

Figure 1

**1. INTRODUCTION**

This instruction sheet covers the installation and use of AMP\* 90° Cable Clamp Assembly 768802-1, which is used in the CHAMPOMATOR\* 2.5 Bench Terminating Machine. The clamp permits the CHAMPOMATOR 2.5 Machine to apply discrete-wire, jacketed cable to CHAMP\* Connectors.

**NOTE** *These instructions are supplied in the documentation package for the CHAMPOMATOR 2.5 Bench Terminating Machine. Make sure to retain all material in the documentation package for reference. For detailed information on the operation of the CHAMPOMATOR 2.5 Machine, refer to AMP Customer Manual supplied with the machine.*

Reasons for reissue of this instruction sheet are provided in Section 6, REVISION SUMMARY.

**2. DESCRIPTION/OPERATION** (Figure 1)

The cable clamp assembly is designed to hold the cable in the correct position when terminating connectors with a 90° cable breakout. The clamp assembly features an air-activated clamp, a toggle air

valve, a wire holder, and a position-adjustment track, which permits the clamp to accommodate different connector sizes.

**NOTE** *The outer cable jacket must be removed prior to placing the cable in the cable clamp.*

During the machine operation, the operator places the cable into the open cable clamp, actuates the toggle air valve, and places the wires in the wire holder, which holds the cable wires in place during the termination process, helping to keep the loose wires out of the operator's way.

After all terminations have been completed, the operator actuates the cable clamp toggle valve to unclamp the cable, and removes the completed cable assembly from the machine.

**3. INSTALLATION PROCEDURE**

**DANGER** *It is necessary to open or remove machine covers to perform the following procedures. Be sure to replace ALL covers BEFORE operating the machine.*

1. Turn off the machine's air supply by disengaging the air supply at the back of the machine.

2. Turn off the machine's electrical functions by switching the rocker switch on the back of the machine's control module.

**DANGER** To avoid personal injury, disconnect air and electric power before making adjustments to the machine or cable clamp. Do not make adjustments while the machine is operational.

3. Remove the machine's main cover.  
 4. Slide the bottom of the clamp assembly onto the base block assembly track, as shown in Figure 2.

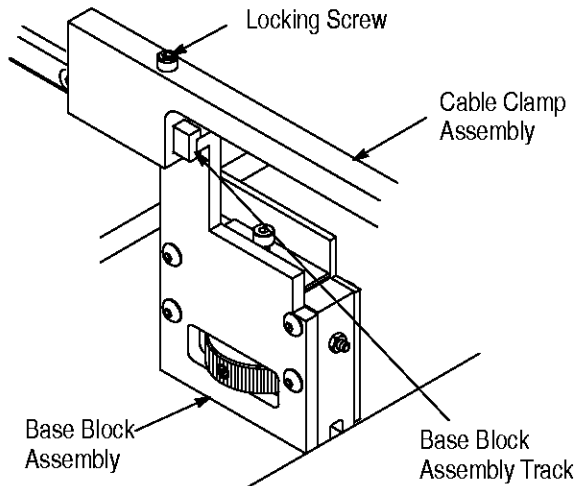


Figure 2

5. Remove the plug from the pneumatic assembly (located at the back of the machine carriage) with a 1/4-in. open-end wrench. Refer to Figure 3. Replace the plug with the fitting attached to the pneumatic tubing, then tighten the fitting with a 1/4-in. open-end wrench.

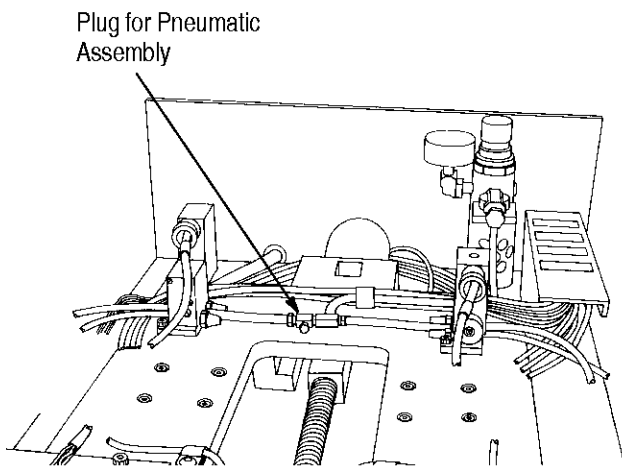


Figure 3

6. Turn on the air to the machine and inspect the clamp assembly for air leaks.

7. Load a properly prepared cable into the clamp assembly.

8. Adjust the position of the clamp assembly and cable so that the cable breakout is located behind the first pair of connector contacts.

9. Tighten the locking screw with a 5/32-in. hex wrench.

10. Replace the machine's main cover and turn on the machine's electrical power.

**4. REPLACEMENTS PARTS**

Figure 4 lists the items that are recommended as customer-replaceable parts. These items should be inspected regularly and replaced, if necessary. Customer-replaceable parts should be stocked to prevent machine downtime in the event that they require replacement.

For detailed information on the location of these items, refer to Figure 1.

PART NUMBER	DESCRIPTION	QTY PER ASSEMBLY
763596-1	Wire Holder	1
17134-1	Toggle Air Valve	1
980338-1	Air Hose	1
980311-3	Air Cylinder	1

Figure 4

**5. OTHER CLAMPS**

Other cable clamps, not supplied with the machine, are required to terminate other product lines on the CHAMPOMATOR 2.5 Bench Terminating Machine. For detailed information on these cable clamps, contact your AMP Representative for assistance.

**6. REVISION SUMMARY**

Since the previous release of this sheet, the following changes were made:

Per EC 0990-0792-98

- Revised Figure 1 illustration
- Changed Toggle Air Valve in Figure 4 from 985112-1 to 17134-1