

AM4700-24

April 17, 1997

AM-4700-24 (11-21-0679) Press - Operating Instructions

A. General Maintenance Instructions

1. Lubricate press pinion once a month through grease fitting provided.
2. Lubricate slide once a month with a small quantity of light machine oil on the ways.

B. Assembling 4700 Connectors

1. Slide cable through cable receiving slot in upper housing. (On blind mounting upper housings slide cable firmly against stops molded in upper housing.)
2. Place this assembly into the AM-4700-13A (11-10-1042) fixture plate with the upper housing and cable down against the fixture plate. The fixture plate side rails will square off the cable with the connector.
3. Assemble lower housing (with terminals) to upper housing (with cable) so the polarizing "V" on the lower housing is on the same end as the polarizing stripe on the edge of the cable.
4. Slide fixture plate into press under the platen and press until platen touches fixture plate side rails.
5. Fixture plate is adjustable from 10 to 60 circuits. For 64 circuit connectors a second set of fixture rails must be used, order Part No. AM-4700-37A, 2 required (11-21-0916).

C. Using the AM-6800-1 (11-10-0081) Cable Shear

1. With sliding table in position slide shear under platen slightly depressing the blade holder until base plate snaps in place over the locating screw heads in sliding table.
2. Position cable against rear rail to square cable with blade. Depress handle to cut off.
3. Acrylic cutting surface should be repositioned as required to keep cut off of cable clean and sharp. To reposition cutting surface, loosen 2 #4-40 set screws in side rails and slide acrylic plate to left or right or turn over to expose new surface.
4. Cutting blades AM-6800-2 (11-21-1102) and acrylic cutting surface AM-6800-3 (11-21-1103) should be changed as required to maintain a sharp clean cut on the cable end.

D. Assembling 6874 Connectors

1. Place AM-6874-1 (11-21-0678) fixture plate in press.
2. Place housing into fixture plate.
3. Slide cable into cover slot.
4. Place cover and cable into housing.
5. Slide fixture plate into press.
6. Press.

E. Assembling Universal Adapter Plate Assembly AM-60561
(11-31-2176)

1. Place AM-60561-1 (11-31-2177) fixture plate in press and fasten in place with two (2) #10 - 32 x 5/8" lg. socket head cap screws.
2. Place AM-60561-3 (11-31-2179) side plate on right side of fixture plate and fasten with two (2) #8 - 32 x 3/8 lg. button head cap screws.
3. Place AM-60561-4 (11-31-2180) cable insert in slot on right side of fixture plate. (NOTE: this insert must slide freely in slot.)
4. AM-60561-2 (11-31-2178) cable stop to be placed on housing insert, depending on which change tooling kit is used.

F. Assembling 40312 and 70121 Connectors Using AM-60552
(11-31-2181) Change Part Kit

1. Place AM-60552-2 (11-31-2183) housing insert into large slot in fixture plate.
2. Place AM-60552-1 (11-31-2182) cable stop onto housing insert (locate in dowel holes). **DLH**
Date: 05-03-01 By: DLH
3. Place AM-60552-1 (11-31-2182) fixture rail on fixture plate with slot facing operator. Narrow slot used with 70121 connector; wide slot used with 40312 connector. (NOTE: There are 5 sets of (2) dowel holes. First set closest to operator is for 10 - 14 - 16 ckt. connectors. Second set back is for 20 - 24 - 26 ckt. connectors. Third set back is for 30 - 34 - 36 ckt. connectors. Fourth back is for 40 - 50 ckt. connectors. Fifth back is for 60 - 64 ckt. connectors. Locate this fixture rail according to the circuit size connector you are running.)

4. Slide connector (40312 or 70121) into slot on housing insert, cover side down. Slide connector until it butts up against slot on fixture rail. The polarizing "V" on the lower housing is on the same end as the polarizing stripe on the edge of the cable.
 5. Place cable on approx. centerline of cable insert with outside edge of cable running along side fixture rail and slide cable and insert toward connector. Insert should butt up against connector and cable should then pass through slot in connector and stop against cable stop. The fixture rail will square off the cable with the connector. (NOTE: Cable will not touch fixture rail - there will be a .010 clearance.) (On blind mounting upper housings slide cable firmly against stops molded in upper housing - 70121 only.)
 6. Slide fixture plate into press under the platen and press until platen touches fixture rail.
 7. Fixture plate is adjustable from 10 to 64 circuits.
- G. Assembling 71007 Edge Card Connectors AM-60555 (11-31-2184) Change Part Kit

1. Place AM-60555-2 (11-31-2186) housing insert into large slot in fixture rail.
2. Place AM-60561-2 (11-31-2178) cable stop onto housing insert. Locate in dowel holes.
3. Place AM-60555-1 (11-31-2185) fixture rail on fixture plate with slot facing operator.

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(NOTE: There are 5 sets of (2) dowel holes. First set closest to operator is for 10 - 14 - 16 ckt. connectors. Second set back is for 20 - 24 - 26 ckt. connectors. Third set back is for 30 - 34 - 36 ckt. connectors. Fourth back is for 40 - 50 ckt. connectors. Fifth back is for 60 - 64 ckt. connectors. Locate this fixture rail according to the circuit size connector you are running.)

4. Slide connector (71007) into slot on housing insert, cover side down. Slide connector until it butts up against slot on fixture rail. The polarizing "V" on the lower housing is on the same end as the polarizing stripe on the edge of the cable.

5. Place cable on approx. centerline of cable insert and slide cable and insert toward connector. Insert should butt up against connector and cable should then pass through slot in connector and stop against cable stop. The fixture rail will square off the cable with the connector. (NOTE: Cable will not touch fixture rail - there will be a .010 clearance.)
6. Slide fixture plate into press under the platen and press until platen touches fixture rail.
7. Fixture plate is adjustable from 10 - 50 circuits. Consult Engineering Dept. for 60 - 64 ckt. range.

H. Assembling 5320 Connectors AM-60567 (11-31-2335) Change Part Kit

1. Place AM-60552-2 (11-31-2183) housing insert into large slot in fixture plate.
2. Place AM-60561-2 (11-31-2178) cable stop onto housing insert. Locate in dowel holes.
3. Place AM-60566-1 (11-31-2188) fixture rail on fixture plate with narrow slot facing operator.

(NOTE: There are 5 sets of (2) dowel holes. First set closest to operator is for 10 - 14 - 16 ckt. connectors. Second set back is for 20 - 24 - 26 ckt. connectors. Third set back is for 30 - 34 - 36 ckt. connectors. Fourth set back is for 40 - 50 ckt. connectors. Fifth set back is for 60 ckt. connectors. Locate this fixture rail according to the circuit size connector you are running.)

4. Slide connector (5320) into slot on housing insert, cover side down and into slot on fixture rail. The polarizing "V" on the lower housing is on the same end as the polarizing stripe on the edge of the cable.
5. Place cable on approx. centerline of cable insert and slide cable and insert toward connector. Insert should butt up against connector and cable should then pass through slot in connector and stop against cable stop. The fixture rail will square off the cable with the connector. (NOTE: Cable will not touch fixture rail - there will be a .010 clearance.)
6. Slide fixture plate into press under the platen and press until platen touches fixture rail.
7. Fixture plate is adjustable from 10 - 60 circuits.

J. Assembling 71521 Connectors Using AM-60008 (11-31-5555) Change Parts Kit

- OBSOLETE**
Date: 05-03-01 By: DLH
1. Place AM-60008-1 (11-31-5556) housing insert into large slot in fixture plate.
 2. Place AM-60561-2 (11-31-2178) cable stop on to housing insert (locate in dowel holes).
 3. Place AM-60561-4 (11-31-2180) cable guide in slot perpendicular to housing insert.
 4. Place AM-60007-3 (11-31-5559) fixture rail on fixture plate (in dowel holes) and locate so contoured edge lines up with edge of pocket in housing insert.
 5. Load pre-assembled connector #71521 into housing insert with metallic portion facing up and load with appropriate end towards cable stop.
 6. Place cable on approx. centerline of cable insert with outside edge of cable running along side fixture rail and slide cable and insert toward connector. Insert should butt up against connector and cable should then pass through slot in connector and stop against cable stop. The fixture rail will square off the cable with the connector. (NOTE: Cable will not touch fixture rail - there will be a .010 clearance.)
 7. Slide fixture plate into press under the platen and press until closed and locking tabs are set.

K. Assembling 71522 Connectors Using AM-60007 (11-31-5557) Change Parts Kit

- OBSOLETE**
Date: 05-03-01 By: DLH
1. Place AM-60007-1 (11-31-5558) housing insert into large slot in fixture plate.
 2. Place AM-60561-2 (11-31-2178) cable stop into housing insert (locate in dowel holes).
 3. Place AM-60561-4 (11-31-2180) cable guide in slot perpendicular to housing insert.
 4. Place AM-60007-3 (11-31-5559) fixture rail on fixture plate (in dowel holes) and locate so contoured edge lines up with edge of pocket in housing insert.
 5. Load cover portion of #71522 connector into housing insert.
 6. Load cable over top of cover and butt against cable stop.
 7. Load main portion of connector over cable and on to cover latches.
 8. Slide fixture plate into press under the platen and press until closed and locking tabs are set.

I. Assembling 5300 Series (Qik-Flecs) Connectors AM-60566
(11-31-2187)

1. Remove press platen and install AM-60566-4
(11-31-2191) platen in press.
2. Place AM-60566-2 (11-31-2189) housing insert (5350,
5360 & 5370 connectors) or AM-60566-3 (11-31-2190)
housing insert (5380 connector) into large slot in
fixture plate. Which insert you use depends on what
connector you plan to run.
3. Place AM-60561-2 (11-31-2178) cable stop on to housing
insert. Locate in dowel holes.
4. Place AM-60566-1 (11-31-2188) fixture rail on fixture
plate with slot facing operator. Narrow slot used
with 5350, 5360 & 5370; wide slot used with 5380
connector.

(NOTE: There are 5 sets of (2) dowel holes. First
set closest to operator is for 10 - 14 - 16 ckt.
connectors. Second set back is for 20 - 24 - 26 ckt.
connectors. Third set back is for 30 - 34 - 36 ckt.
connectors. Fourth back is for 40 - 50 ckt. connec-
tors. Fifth back is for 60 - 64 ckt. connectors.
Locate this fixture rail according to the circuit size
connector you are running.)

IT IS RECOMMENDED THAT CUSTOMER ORDER THIS CONNECTOR
AS TWO (2) PIECES -COVER & LOWER HOUSING SEPARATE
INSTEAD OF PRE-ASSEMBLED.

5. Slide cover (5350, 5360, 5370, 5380) into slot on
housing insert, flat side down. Slide cover until it
butts up against slot on fixture rail.
6. Place cable on approx. centerline of cable insert with
outside edge of cable running along side fixture &
slide cable and insert toward cover. cable insert
should butt up against cover and cable should then pass
over cover and stop against cable stop. The fixture
rail will square off the cable with the cover.
(NOTE: Cable will not touch fixture rail - there will
be a .010 clearance.) Now place lower housing in
position over cable and cover and snap into place.
7. Slide fixture plate into press under the platen and
press until platen touches fixture rail.
8. Fixture plate is adjustable from 10 - 64 circuits.

Features

- Portability. Does not require bench mounting to function.
- Drop-in tooling requires only 3/32, 5/32 Allen wrenches to change.
- Sliding fixture plate for ease of loading. Plate slides out for visible loading.
- Fixture plates are compatible with 3M assembly press #3440 and 3445.
- Fixture plates are fully adjustable through entire range of connector circuit sizes.
- Fixture plate rails also serve as cable guides to assure perpendicularity between cable and connector.
- Cable shear for cutting cable ends squarely and cleanly.

Specifications

Weight 18 lbs. (8.16 kg)

| | | |
|-------------|--------|---------------------|
| Table Space | Height | 14 in. (35.56 cm) |
| | Width | 4.75 in. (12.0 cm) |
| | Depth | 10.5 in. (26.67 cm) |

ASSEMBLY PRESS

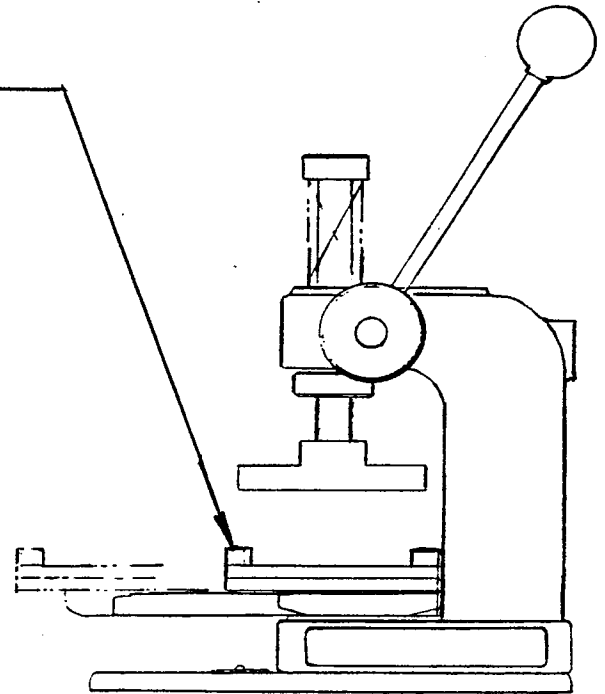
.050 Center Cable Connector

Eng. No. AM-4700-24

E.D.P. No. 11-21-0679

Tooling Options

- AM-60561 (11-31-2176)
Universal Adapter Plate Assembly
for 40312, 70121, 71007, 5320, 5350,
5360, 5370, 5380, 71521, 71522
- AM-60552 (11-31-2181)
Change Part Kit for 40312 & 70121
Connectors 10 - 64 ckt.
- AM-60555 (11-31-2184)
Change Part Kit for 71007 Connec-
tors 10 - 50 ckt.
(Consult Eng. Dept. for 60 - 64 ckt.
connectors)
- AM-60567 (11-31-2335)
Change Part Kit for 5320 Connec-
tors 10 - 60 ckt.
- AM-60566 (11-31-2187)
Change Part Kit for 5350, 5360,
5370 & 5380 Conn. 10 - 64 ckt.
- AM-4700-13A (11-10-1042)
Fixture Plate for all 4700 Connec-
tors thru 60 ckt.
- AM-6874-1 (11-21-0678)
Fixture Plate for all 6874
Connectors
- AM-6800-1 (11-10-0081)
Cable Shear for Cutting All .050
Center Cable thru 64 ckt.
- AM-6800-2 (11-21-1102)
Replacement Blade



- ~~AM-60007 (11-31-5557)
Change Parts for 71522
Connectors~~
- ~~AM-60008 (11-31-5555)
Change Parts for 71521
Connectors~~
- AM-4700-32 (11-10-1055)
Platen for all Circuits
up 64 (Rev. "B")
- AM-4700-37A (11-21-0916)
Change Rail for 4700
Connector, 64 Ckt.
- AM-6800-3 (11-21-1103)
Replacement Cutting Plate