



Fig. 1

## 1. INTRODUCTION

These instructions cover applicators that were designed to terminate (in a single cycle of operation) 4 and 6 position telephone plugs with flat cable having the same number of conductors. Termination is accomplished by the insulation piercing technique when the contacts in the plug are inserted into the cable conductors.

The modular plugs are supplied in reel-form and retained in a plastic carrier strip which is sheared as the cable conductors are being terminated. Refer to the Applicator Parts List and Exploded View Drawing (Applicator Log) for the product (plug) number, and the required crimp height.

These applicators are used in a Modified AMP-O-LECTRIC \* Model "K" Terminating Machine which must be equipped with an air feed valve assembly for supplying pressure to the applicator feed cylinder in sequence with the machine cycling.

This instruction sheet, the parts list and exploded view drawing, and the customer manual (CM 5128) provide all information necessary to operate and maintain the applicator, and machine.

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## 2. DESCRIPTION

Major components of the applicator are identified in Figures 1 through 3. The strip enters the applicator from the left, passing under the carrier retainer and stock drag, and between the strip retainer and strip guide. The lead modular plug is always positioned in the "target area," and centered over the housing support, at the beginning of each machine cycle. This requires air pressure to be supplied to the extension port of the feed air cylinder.

On the downward stroke of the ram, air pressure to the cylinder is stopped to allow the cylinder to be retracted by internal spring pressure to pick up the next feed point, and to exhaust air pressure within.

As the applicator ram bottoms, and with a cable end inserted into the modular plug, the carrier strip is sheared from the lead plug as the contacts are pushed downward to terminate the cable conductors. Also, the primary and secondary strain relief are pushed down to secure the cable in the plug.

On the return (upward) stroke, the terminated plug is released by the tooling for removal. This is followed by the feed cylinder being pressurized again to advance the strip one increment to position the next plug in the "target area." This completes a cycle of operation.