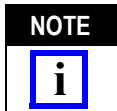


Figure 1

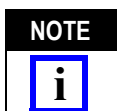
1. INTRODUCTION

90-Degree Cable Clamp Assembly 1424030-1 is designed to be used in CHAMPOMATOR* 2.5 Bench Terminating Machines 762734-[]. The machine must be equipped with a clamp solenoid valve and a controller having software at Rev 3.03.05 or later. To use the machine without these requirements, use 90-Degree Cable Clamp Assembly 768802-1 and follow the instructions packaged with that cable clamp.



Other cable clamps not supplied with the CHAMPOMATOR 2.5 bench terminating machine are required to terminate other product lines on the machine. For information on these cable clamps, call PRODUCT INFORMATION at the bottom of this page.

The cable clamp enables the machine to apply discrete wire jacketed cable to CHAMP* connectors. The cable clamp is designed to hold the cable in the correct position when terminating connectors with a 90-degree cable breakout.



Make sure to retain all material in the bench terminating machine documentation package for reference. For information on the operation of the machine, refer to Customer Manual 409-5839 supplied with the machine.

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

2. DESCRIPTION (See Figure 1)

The cable clamp features an air-activated cylinder, jaw, spring plunger, wire holder, and a position-adjustment track which permits the cable clamp to accommodate different connector sizes.

During the machine operation, the operator places the cable into the open cable clamp, actuates the spring plunger, 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 spring plunger to unclamp the cable and removes the completed cable assembly from the machine.

3. INSTALLATION



It will be necessary to open or remove machine covers to perform the following procedure. Be sure to reinstall ALL covers BEFORE operating the machine. Turn off the machine air supply by disengaging the air supply at the back of the machine.

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



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.

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

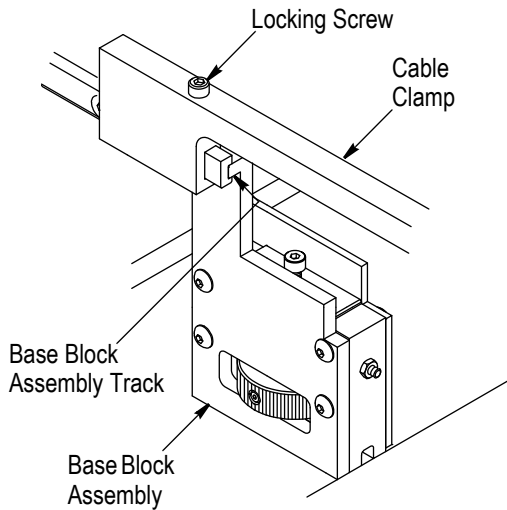


Figure 2

4. On the machine, plug the air hose from the clamp solenoid valve (see Figure 3) onto the fitting of the cable clamp (refer to Figure 1).
5. Turn on the air to the machine, and inspect the cable clamp for air leaks.

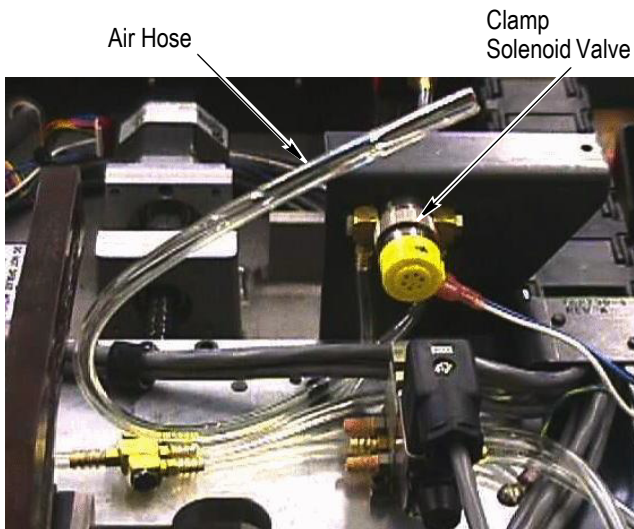


Figure 3

6. Load a properly prepared cable into the cable clamp.
7. The cable outer jacket must be removed prior to placing the cable in the cable clamp.
8. Adjust the position of the cable clamp and cable so that the cable breakout is located behind the first pair of connector contacts.
9. Tighten the locking screw with a $\frac{5}{32}$ -in. hex wrench.
10. Replace the main cover of the machine, and turn on the machine electrical power.

4. MAINTENANCE

Lubricate the position adjustment track with a good, quality, light machine oil to ensure optimum service. Wipe off any excess oil.

5. REPLACEMENT PARTS

Figure 4 lists recommended customer-replaceable parts. These parts should be inspected regularly. Customer-replaceable parts should be stocked to prevent machine or assembly downtime in the event that they require replacement. For location of the parts, refer to Figure 1. For location of the air hose and clamp solenoid valve, refer to Figure 3.

PART NUMBER	DESCRIPTION	QTY PER ASSEMBLY
763596-1	Wire Holder	1
980311-3	Air-Activated Cylinder	1
980451-1	Spring Plunger	1
980338-1	Air Hose	Ref
994916-1	Clamp Solenoid Valve	1

Figure 4

Order replacement parts through your representative, or call 1-800-526-5142, or send a facsimile of your purchase order to 1-717-986-7605, or write to:

CUSTOMER SERVICE (038-035)
 TYCO ELECTRONICS CORPORATION
 PO BOX 3608
 HARRISBURG PA 17105-3608

6. REVISION SUMMARY

Revisions to this instruction sheet include:

- Updated instruction sheet to corporate requirements