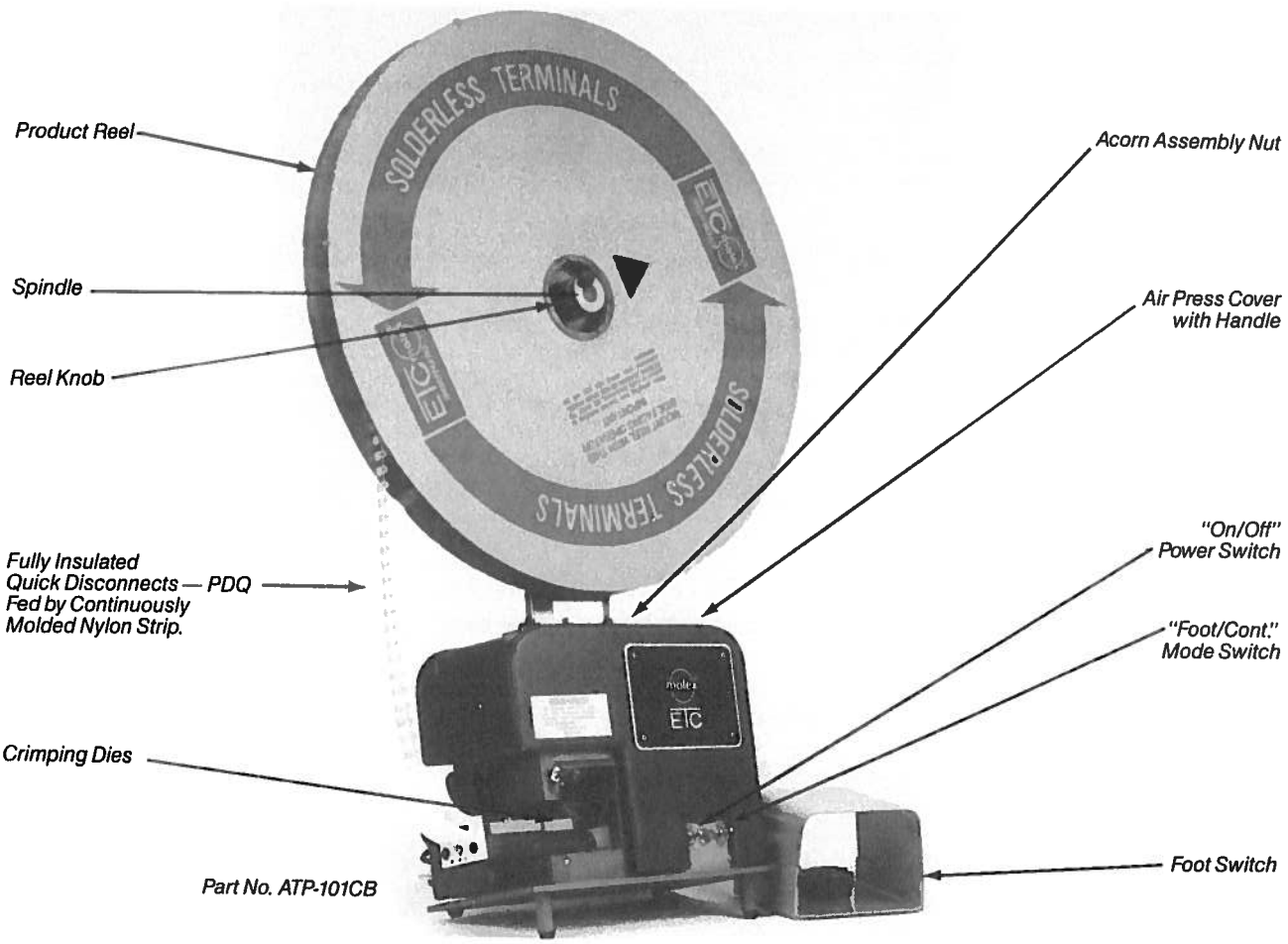
OPERATING INSTRUCTIONS AND PARTS IDENTIFICATION LIST FOR

ATP-101CB

CONTINUOUS MOLDED NYLON STRIP

Air Crimping Press



Familiarizing yourself with the Air Crimping Press and its many parts will better enable you to make repairs when problems occur. The Parts Identification List will be of significant help in communicating these problems to Molex-ETC or our Sales Representative.

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19288-0434

molex

ETC

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ATP-101CB
CONTINUOUS MOLDED NYLON STRIP AIR CRIMPING PRESS

The Molex-ETC pneumatic press accommodates the usage of continuously molded fully insulated quick disconnects—PDQ. The press is capable of cycling once every second or 3,600 crimps per hour. With actuation of the foot pedal a full cycle of the crimping dies is completed. The total applied costs of crimping fully insulated quick disconnects —PDQ is lowered dramatically with the usage of the Molex-ETC pneumatic press.

- Compact in size as well as light in weight makes this unit the most portable in the industry.
- Fully insulated quick disconnect reels are top mounted to give space.
- Being easy to operate, the ATP-101CB provides a fast, straightforward and low cost method of crimping.
- Can crimp a full range of fully insulated quick disconnects & female coupler parts from 26 AWG. through 14 AWG.
- A reel of continuously molded fully insulated quick disconnects can be supplied in reels of up to 2,500 parts each.
- An operator controlled device through the use of a foot pedal frees operator's hands for maximum production capabilities.
- Design features meet OSHA requirements.
- Changeover from one FIQD to another or from a FIQD to a female coupler takes but a few minutes.
- Overall dimensions (excluding reel of terminals) is 12″ high x 13″ wide x 7½″ deep.
- Weight of the unit is approximately 28 pounds.

As operators of Molex-ETC's Air Crimping Press, you will want your Press to operate exactly as it was designed to do — to crimp continuously molded fully insulated quick disconnects and female couplers quickly, efficiently and reliably. These Operating Instructions will help you achieve these results with instructions that are easy to read and understand. Read them through carefully before installing and operating your Molex-ETC Air Crimping Press.

1. REEL HOLDER BRACKET INSTALLATION

A. Remove hex acorn nut which retains the press cover (nut is located under cover handle).
B. Hold bracket to the rear of machine in a vertical position, with spindle up and facing front of machine.
C. Lower the reel bracket's horizontal flange (with clearance hole) over the 3/8" threaded stud (located under cover handle) and replace acorn nut securely.
D. Be sure that reel bracket's foot, with rubber heel, sits squarely against work surface.

2. FIQD REEL INSTALLATION

A. Remove reel knob from spindle.
B. To be certain that fully insulated quick disconnects unwind properly, place reel over spindle with the *ETC label facing front of Press.*
C. Replace knob by sliding it over end of spindle.
D. Check to see that reel is fully seated and turns freely.

NOTE: The reel bracket is equipped with a plate that has three (3) leaf springs. When the reel is fully seated, these springs press against the back surface of the reel, causing tension. This tension can be controlled by pushing the reel knob against (more tension) or pulling reel knob away from (less tension) reel.

3. OPERATION OF WORK LIGHTS

A. Uncoil line cord and connect to 110 volt A.C. source. ATP-101CB Electrical Controls on front of press, below ETC logo.
B. Place on/off toggle switch in "ON" position for work lights. **WARNING! Doing this also allows air press to be cycled by pressing the foot pedal if air line is connected.**
C. IMPORTANT: BE SURE THE MODE SELECTOR TOGGLE SWITCH IS IN THE "FOOT" POSITION.
D. Air Crimping Press is now ready to cycle by using foot pedal if air line is connected.

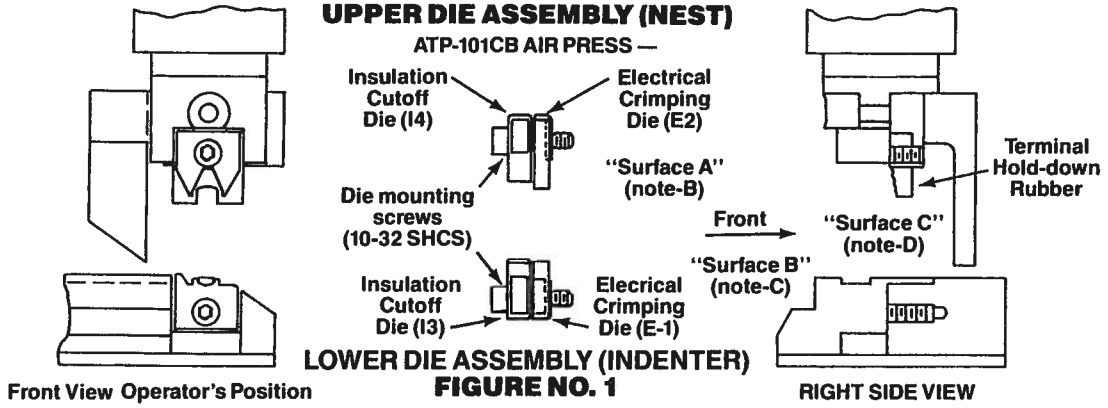


FIGURE NO. 1

4. CRIMPING DIES INSTALLATION

A. It is recommended to shut power off when changing dies.
B. Be sure that UPPER DIE ASSEMBLY (electrical & insulation dies both) are seated squarely (perpendicular) to "surface A" by holding them up (with finger) against "surface A" while fastening down die mounting screw.
C. Be sure that LOWER DIE ASSEMBLY (electrical & insulation dies both) are seated squarely (perpendicular) to "surface B" by holding them down (with finger) against "surface B" while fastening down die mounting screw.
D. Be sure UPPER DIE ASSEMBLY & LOWER DIE ASSEMBLY are both seated squarely (perpendicular) against "surface C."
E. Also be sure no small particles get between UPPER or LOWER DIE ASSEMBLIES and/or "SURFACE A, B, or C."

SHARPENING CUTOFF DIE:

A. Insulation cutoff die (I4) is the only die to sharpen.
B. Sharpen the bottom surface on a surface grinder with an 80 grit wheel or finer.
C. Grind ~.002" to sharpen.

5. UNIVERSAL COVER PLATE ADJUSTMENTS

A. Adjustments should be made with UNIVERSAL COVER PLATE removed from ATP-101CB Air Press.
B. The UNIVERSAL COVER PLATE has four (4) possible positions. Each position guides a specific Molex-ETC style & size fully insulated quick disconnect- PDQ thru it.
C. Each position is made by having the FRONT SLIDE and the REAR SLIDE in the correct setting combination.
D. See Chart No. 1 for explanation of each position.

IMPORTANT: AFTER FASTENING SLIDES INTO POSITION, DOUBLE CHECK TO BE SURE THE ENTIRE LENGTH OF THE SLIDE BUTTS UP AGAINST ITS RESPECTIVE COVER PLATE STOP.

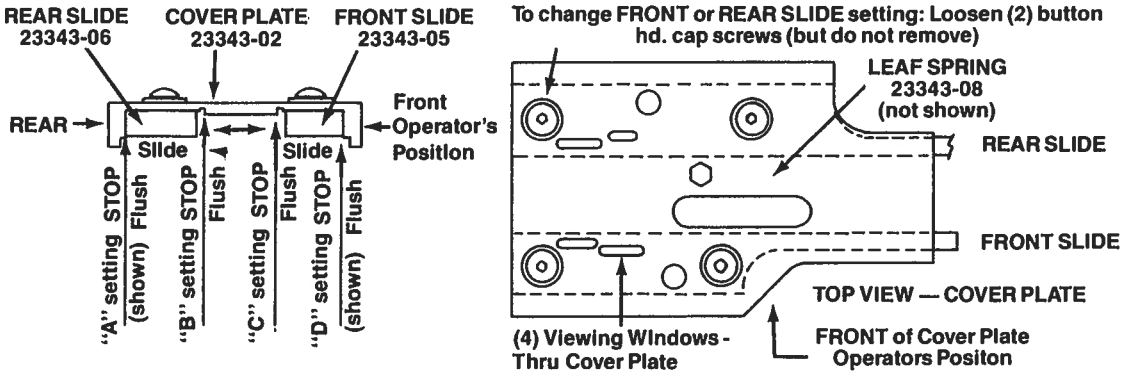


FIGURE NO. 2

CHART NO. 1 (USE WITH FIGURE NO. 2)

4 POSITIONS	FRONT SLIDE SETTINGS	REAR SLIDE SETTINGS	APPEARS IN WINDOW	
			FRT. SLIDE	REAR SLIDE
POSITION 1	"C" setting Standard (non expanded) insulation barrel	"B" setting .110 or .187 tab size	STAND.	.110/.187
POSITION 2	"C" setting Standard (non expanded) insulation barrel	"A" setting .250 tab size	STAND.	.250
POSITION 3	"D" setting expanded insulation barrel	"B" setting .110 or .187 tab size	EXPAND.	.110/.187
POSITION 4	"D" setting expanded insulation barrel	"A" setting .250 tab size	EXPAND.	.250

5a. COUPLER COVER PLATE ADJUSTMENTS (Female Coupler Only)

A. Adjustments should be made with COUPLER COVER PLATE removed from ATP-101CB Air Press.

B. The COUPLER COVER PLATE has one (1) required position. This position guides the female coupler (fully insulated quick disconnect) thru it.

C. This position is made by having the *COUPLER FRONT SLIDE & the REAR SLIDE in the correct setting combination.

D. See Chart No. 2 for explanation of this position.

*The "Coupler Cover Plate" and "Universal Cover Plate" are identical except for the (coupler) FRONT SLIDE, and the (universal) FRONT SLIDE which are different items but are interchangeable.

IMPORTANT: AFTER FASTENING SLIDES INTO POSITION, DOUBLE CHECK TO BE SURE THE ENTIRE LENGTH OF THE SLIDE BUTTS UP AGAINST ITS RESPECTIVE COVER PLATE STOP.

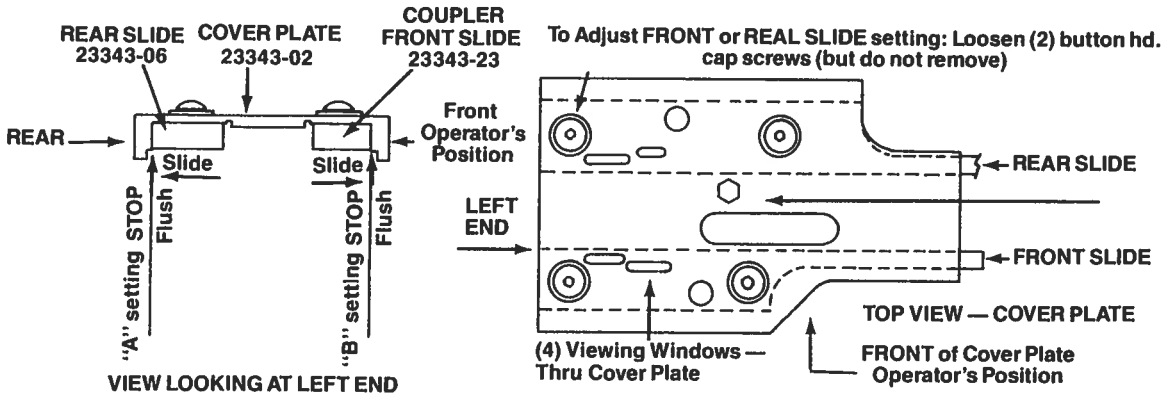


FIGURE NO. 2a.

CHART NO. 2 (USE WITH FIGURE NO. 2a.)				
POSITIONS	FRONT SLIDE SETTINGS	REAR SLIDE SETTINGS	APPEARS IN WINDOW	
			FRT. SLIDE	REAR SLIDE
POSITION 1	"A" setting Standard insulation barrel	"B" setting .250 tab size Female Coupler only	COUPLER	.250

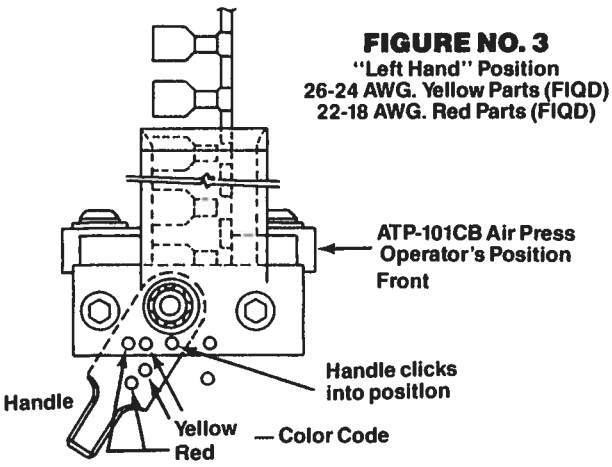


FIGURE NO. 3
"Left Hand" Position
26-24 AWG. Yellow Parts (FIQD)
22-18 AWG. Red Parts (FIQD)

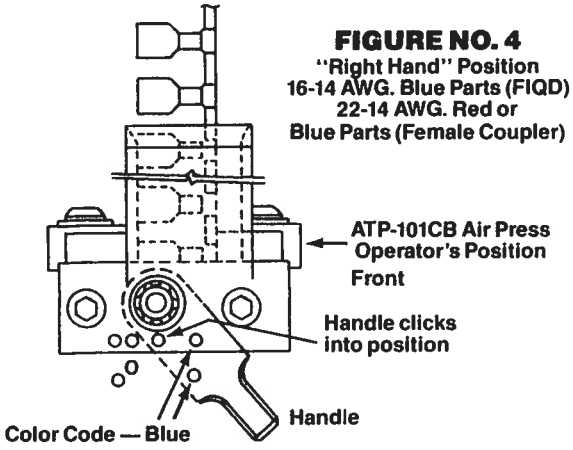


FIGURE NO. 4
"Right Hand" Position
16-14 AWG. Blue Parts (FIQD)
22-14 AWG. Red or
Blue Parts (Female Coupler)

6. FEED PAWL ADJUSTMENT (Handle)

A. Figures No. 3 & 4 show the Feed Pawl Adjustment (Handle) in both required positions.

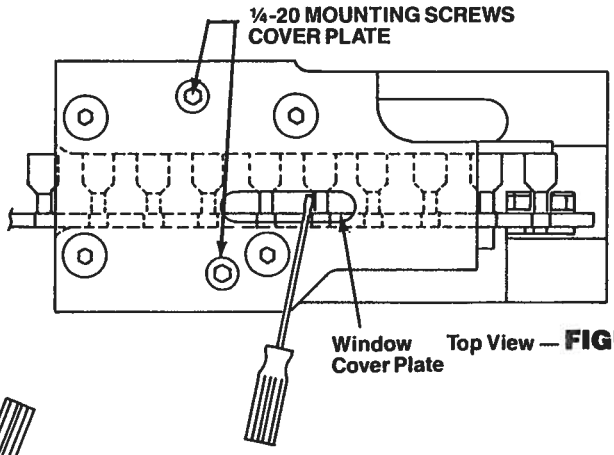
B. The Handle should always be in one of the two following positions according to parts being used:

1. "Left Hand Position" (Fig. No. 3)
   26-24 AWG.: Yellow Parts
   22-18 AWG.: Red Parts
   Fully Insulated Quick Disconnects — PDQ

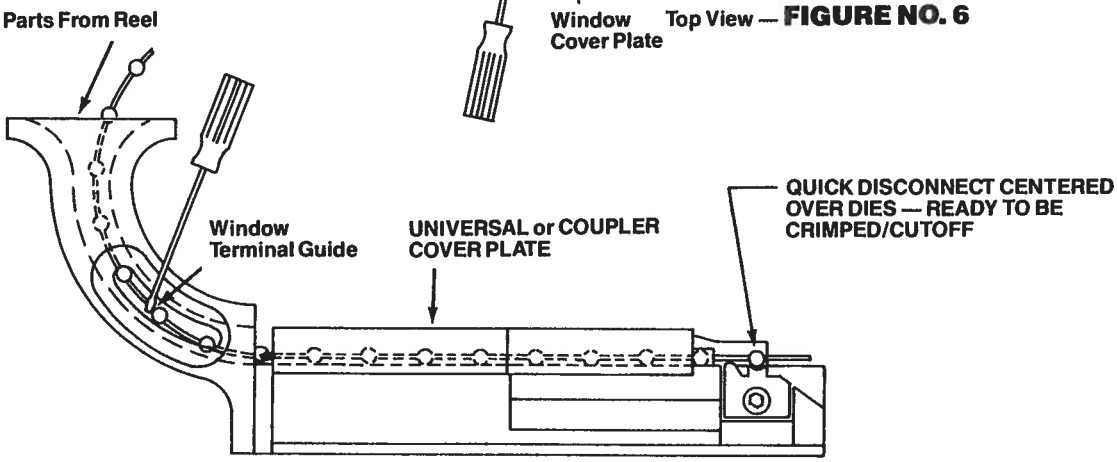
2. "Right Hand Position" (Fig. No. 4)
   16-14 AWG.: Blue Parts
   Fully Insulated Quick Disconnects — PDQ

   "Right Hand Position" (Fig. No. 4)
   22-18 AWG.: Red Parts
   16-14 AWG.: Blue Parts
   Female Coupler
   Fully Insulated Quick Disconnects

C. Handle "Clicks" into left or right hand positions.



Top View — **FIGURE NO. 6**



Front View ATP-101CB (Mechanical feed shown)
FIGURE NO. 5

7. LOADING FULLY INSULATED QUICK DISCONNECTS (PDQ or Female Coupler) INTO ATP-101CB MECHANICAL FEED.

IMPORTANT: It is recommended to shut power "OFF" while loading parts. Before loading parts into ATP-101CB Mechanical Feed, make sure the following settings are adjusted.

A. FEED PAWL ADJUSTMENT: (see instruction #6)

B. UNIVERSAL COVER PLATE ADJUSTMENT (see instruction #5)
COUPLER COVER PLATE ADJUSTMENT (see instruction #5A)

These must be in proper adjustment according to parts being used.

C. Take parts from reel which should be mounted to Reel Holder (see instructions #1 & 2). Start feeding parts down thru Terminal Guide into Mechanical Feed.

D. Feeding can be assisted by using a small screw driver (thru the terminal guide window — see Fig. 5) and advancing parts into mechanical feed as far as they will go.

E. At this time the parts should be visible thru the window on top of the cover plate (Fig. 6). Continue to advance the parts (by using a small screw driver thru cover plate window, Fig. 6) until first part is centered over the lower crimping dies. (Illustrated Fig. 5 & 6).

NOTE: PROPER ADJUSTMENTS & CENTERING OF QUICK DISCONNECTS BETWEEN UPPER & LOWER DIES IS CRITICAL TO THE CRIMPING OF THE CONDUCTOR BARREL & CUTOFF OF THE CONTINUOUSLY MOLDED STRIP.

IMPORTANT: MAKE SURE THE UNIVERSAL COVER PLATE IS PROPERLY SEATED & SECURELY MOUNTED TO MECHANICAL FEED; IF NOT, DAMAGE MAY OCCUR TO COVER PLATE WHEN PRESS IS CYCLED. (COVER PLATE MOUNTING SCREWS. SHOWN FIG. 6)

8. CONNECTING TO AIR LINE

A). The on/off toggle switch (front of ATP-101CB) should be in the "OFF" position.

B). Connect ¼" N.P.T. air hose to ¼" female hex in-line filter at rear of press. Then connect other end of air hose to 95 PSI - 110 PSI air source.

IMPORTANT: AIR TAPE PRESSES MUST BE USED WITH A FILTER-LUBRICATOR-AIR REGULATOR to ASSURE PROPER PERFORMANCE and PREVENT INTERNAL DAMAGE. If your air supply is not already equipped with Filter-Lubricator-Regulators and none are available locally, consult Molex-ETC factory for catalog number FLR.

9. CRIMPING/CUTOFF: Fully Insulated Quick Disconnects (PDQ & Female Coupler) (Foot Switch Operation)

A). ATP-101CB must be hooked up to air supply (instruction #8).

B). Flip on/off toggle switch (Front of ATP-101 CB) to the "ON" position.

C). Flip mode selector toggle switch to the "FOOT" position.

D). Make sure parts to be crimped/cut-off are properly loaded & Cover Plate is properly mounted (see instruction #7).

E). Insert properly stripped wire* into Quick Disconnect Barrel until wire "stops" against Q.D. wire stop, now depress Foot Switch. Q.D. will be crimped/cut-off and next part will be fed into the proper position to repeat the cycle.

*Recommended wire stripping lengths shown on page #13-14.

10. LAST PART ON THE STRIP (REEL) REMOVAL.

A). The next to last Q.D. on the strip will be the last to be crimped/cut-off.

B). The last Q.D. will remain inside of the mechanical feed, and will have to be removed, so that it will not interfere with the next loading of parts.

11. MAINTENANCE PROCEDURES

1. Supply air line must be equipped with a filter-lubricator unit at all times.
2. Drop-type lubricators should be filled with SAE 20 W non detergent oil. Lubricator should be adjusted to allow one drop of oil per 10 to 15 cycles of Press.
3. For mist-type lubricator, follow appropriate instructions.
4. Use a small brush to keep crimping area and transfer mechanism free of all foreign particles.
5. To oil the Press, it is necessary to remove the Press Housing. To do this, remove the Acorn Assembly Nut in the center of carrying handle mounting plate. Lift Housing straight up and off from Press.
6. Oil the following areas with Teflon All Purpose Lubricant every 5,000 crimps or once every month.
   - Top Cam Back-Up Roller (use oil hole) — No. 36 on Parts List.
   - Cam Follower Roller (roller in top of Ram) — No. 34 on Parts List.
   - Ram Guide Bushing (fill oil chamber at top of bushing) — No. 31 on Parts List.
   - Bearing Block Roller at Cam — No. 7 and No. 3 on Parts List.
   - Cam Follower and Feed Slide — No. 11 and No. 2 on Parts List.
7. Replacement work light bulbs: 2 bulbs required per Press.
   - Bulb No. 47 (6.3 Volts) available at most hardware or electrical-electronics supply stores.

IMPORTANT: USE OF A FILTER-LUBRICATOR-AIR REGULATOR (FLR) IS ESSENTIAL TO ASSURE PROPER PERFORMANCE OF THE AIR TAPE PRESS.

ALL MOLEX-ETC AIR PRESSES MUST BE USED WITH AN FLR UNIT TO PREVENT DETERIORATION OF O-RINGS AND SEALS, AND TO PREVENT INTERNAL DAMAGE TO CYLINDERS AND VALVES.

IF YOUR AIR SUPPLY IS NOT ALREADY EQUIPPED WITH FILTER-LUBRICATOR-AIR REGULATORS AND NONE ARE AVAILABLE LOCALLY, CONSULT MOLEX-ETC FOR CATALOG NUMBER FLR.

12. ADJUSTMENTS

The only customer adjustments recommended are:

A. Universal Cover Plate (instruction No. 5) Coupler Cover Plate (instruction No. 5a).

B. Feed Pawl Adjustment (instruction No. 6).

C. Feed Advancement: This is preset at factory and should not require readjustment. If found that adjustment is needed, 7/16" hex nut (Item 17 page 12) can be turned counter-clockwise to advance terminal farther to the right, or turn hex nut clockwise to shorten length of feed.

13. CRIMP/CUT OFF DIE SETS FOR ATP-101CB AIR PRESS

Part No./Die Set No. Cross Reference

Fully Insulated Quick Disconnects—PDQ

PART NUMBER	WIRE RANGE AWG.	ACCEPTS MALE TAB SIZE	DIE SET NUMBERS
M-2210C	26-24	.187x.020	ACP-M-595
M-2211C	"	.187x.032	"
M-2212C	"	.250x.032	"
AA-2201C	22-18	.250x.032	ACP-AA-595
AA-2202C	"	.187x.020	"
AA-2203C	"	.187x.032	"
AA-2204C	"	.110x.020	"
AA-2205C	"	.110x.032	"
AA-2201X C	"	.25x.032	ACP-AA-595X
AA-2202X C	"	.187x.020	"
AA-2203X C	"	.187x.032	"
AA-2204X C	"	.110x.020	"
AA-2205X C	"	.110x.032	"
BB-2206C	16-14	.250x.032	ACP-BB-595
BB-2207C	"	.187x.020	"
BB-2208C	"	.187x.032	"
BB-2206X C	"	.250x.032	ACP-BB-595X
BB-2207X C	"	.187x.020	"
BB-2208X C	"	.187x.032	"

NYLON INSULATION

"AWG" COLOR CODES: M (26-24 AWG) = YELLOW,
AA (22-18 AWG) = RED,
BB (16-14 AWG) = BLUE

"C" DENOTES: CONTINUOUSLY MOLDED CARRIER (NYLON) STRIP

"X" DENOTES: EXPANDED WIRE INSULATION (HOUSING)
NO "X" DENOTES STANDARD WIRE INSULATION (HOUSING)

Part No./Die Cross Reference

Coupler—Fully Insulated Quick Disconnects

PART NUMBER	WIRE RANGE AWG.	ACCEPTS MALE TAB SIZE	DIE SET NUMBERS
AA-2261C	22-18	.250x.032	ACP-AB-295
BB-2263C	16-14	.250x.032	"

14. RECOMMENDED WIRE STRIPPING LENGTHS (GENERAL GUIDE)

Fully Insulated Quick Disconnect—PDQ

WIRE RANGE AWG.	NOMINAL WIRE INSULATION O.D.		WIRE STRIPPING LENGTH
26-24	.030 or smaller		1/4
	.040		17/64
	.050		9/32
	.060		5/16
	.070		11/32
	.080		3/8
	.090		13/32
	.100		27/64
22-18	.060	FIQD'S	15/64
	.080	with STD.	1/4
	.100	Wire Insul.	17/64
	.120	Barrel	9/32
	.140	*	19/64
	.160	FIQD'S	5/16
	.180	with Exp.	21/64
	.200	Wire Insul.	11/32
	.220	Barrel	23/64
	.240	**	3/8

*.14 NOM. = MWID THAT CAN BE INSERTED INTO STANDARD STYLE FIQD'S

**.24 NOM. = MWID THAT CAN BE INSERTED INTO EXPANDED STYLE FIQD'S

MWID = MAX. WIRE INSUL. DIA.

Fully Insulated Quick Discconnect—PDQ

WIRE RANGE AWG.	NOMINAL WIRE INSULATION O.D.	WIRE STRIPPING LENGTH	
16-14	~~.70~~ .070	1/4	STANDARD FLARE
	~~.90~~ .090	17/64	
	.110	17/64	
	.130	9/32	
	▲.150	19/64	
	▲.165	5/16	
	.170	5/16	EXPANDED FLARE
	.190	21/64	
	.210	11/32	
	.230	23/64	
	.250	3/8	
	▲▲.265	25/64	

▲ .150 NOM. = MWID THAT CAN BE INSERTED INTO STANDARD FLARE FIQD'S. (.250x.032 TAB PARTS)

▲ .165 NOM. = MWID FOR (.187x.020 & .187x.032 TAB PARTS)

▲▲ .265 NOM. = MWID THAT CAN BE INSERTED INTO EXPANDED FLARE FIQD'S.

14A. RECOMMENDED WIRE STRIPPING LENGTH

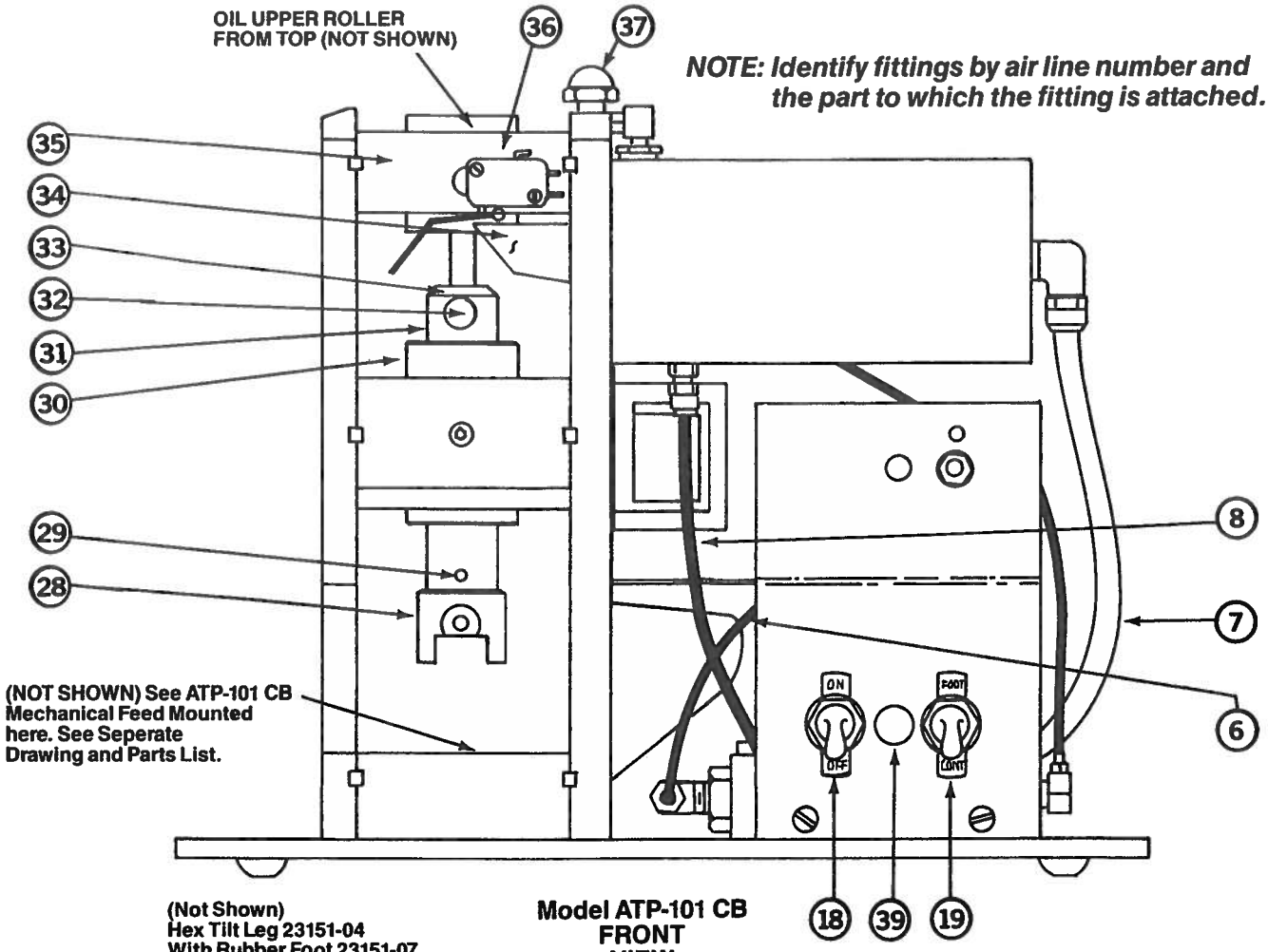
Female Coupler — Fully Insulated Quick Disconnect

Wire Strip length = 5/16

MWID = .170

MWID = MAX. WIRE INSULATION DIA.

IMPORTANT: USE OF A FILTER-LUBRICATOR-AIR REGULATOR (FLR) IS ESSENTIAL TO ASSURE PROPER PERFORMANCE OF THE AIR TAPE PRESS.
ALL MOLEX-ETC AIR PRESSES MUST BE USED WITH AN FLR UNIT TO PREVENT DETERIORATION OF O-RINGS AND SEALS, AND TO PREVENT INTERNAL DAMAGE TO CYLINDERS AND VALVES.
IF YOUR AIR SUPPLY IS NOT ALREADY EQUIPPED WITH FILTER-LUBRICATOR-AIR REGULATORS AND NONE ARE AVAILABLE LOCALLY, CONSULT MOLEX-ETC FACTORY FOR CATALOG NUMBER FLR.



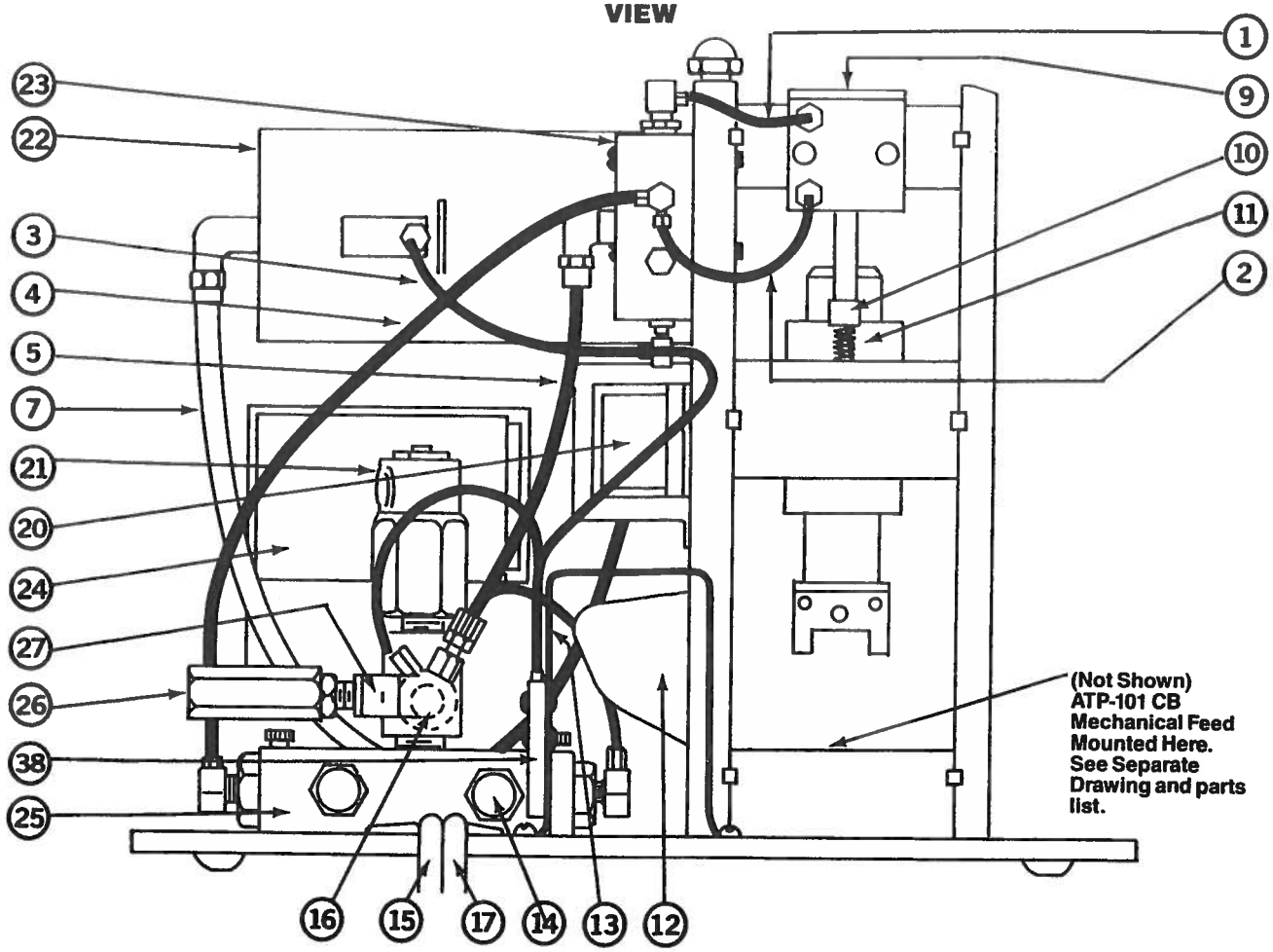
(Not Shown)
Hex Tilt Leg 23151-04
With Rubber Foot 23151-07

Model ATP-101 CB FRONT VIEW

ITEM	REQD	DESCRIPTION	Molex-ETC PART NO.
1	1	⅛ OD Tube-Top Lift Cylinder to Top Secondary Air Valve	
2	1	⅛ OD Tube-Secondary Air Valve to Bottom Lift Cylinder	
3	1	⅛ OD Tube-Secondary Air Valve to Main Air Cylinder	
4	1	⅛ OD Tube-Secondary Air Valve to Primary Air Valve	
5	1	¼ OD Tube-Secondary Air Valve to Air Manifold	
6	1	⅛ OD Tube-Solenoid Valve to Primary Air Valve	
7	1	⅜ OD Tube-Main Air Cylinder to Primary Air Valve	
8	1	¼ OD Tube-Main Air Cylinder to Primary Air Valve	
9	1	Ram Lift Cylinder	23194-01
10	1	(See ATP-101 CB Mechanical Feed Parts List)	
11	1	(See ATP-101 CB Mechanical Feed Parts List)	
12	1	Tape Funnel	23155-25
13	1	Tape Exhaust Guide	23155-26
14	2	Exhaust Muffler	23197-10
15	1	Power Cord (3-Conductor)	26700-80
16	1	⅛ NPT Hex Manifold	23198-16

Model ATP-101 Electrical Controls (Item 28 Power Toggle Switch with Red "Power ON" Indicator Light and Item 29 Mode Selector Toggle Switch) are located on Front of Press. See Lower-Right Front View on Opposite Page.

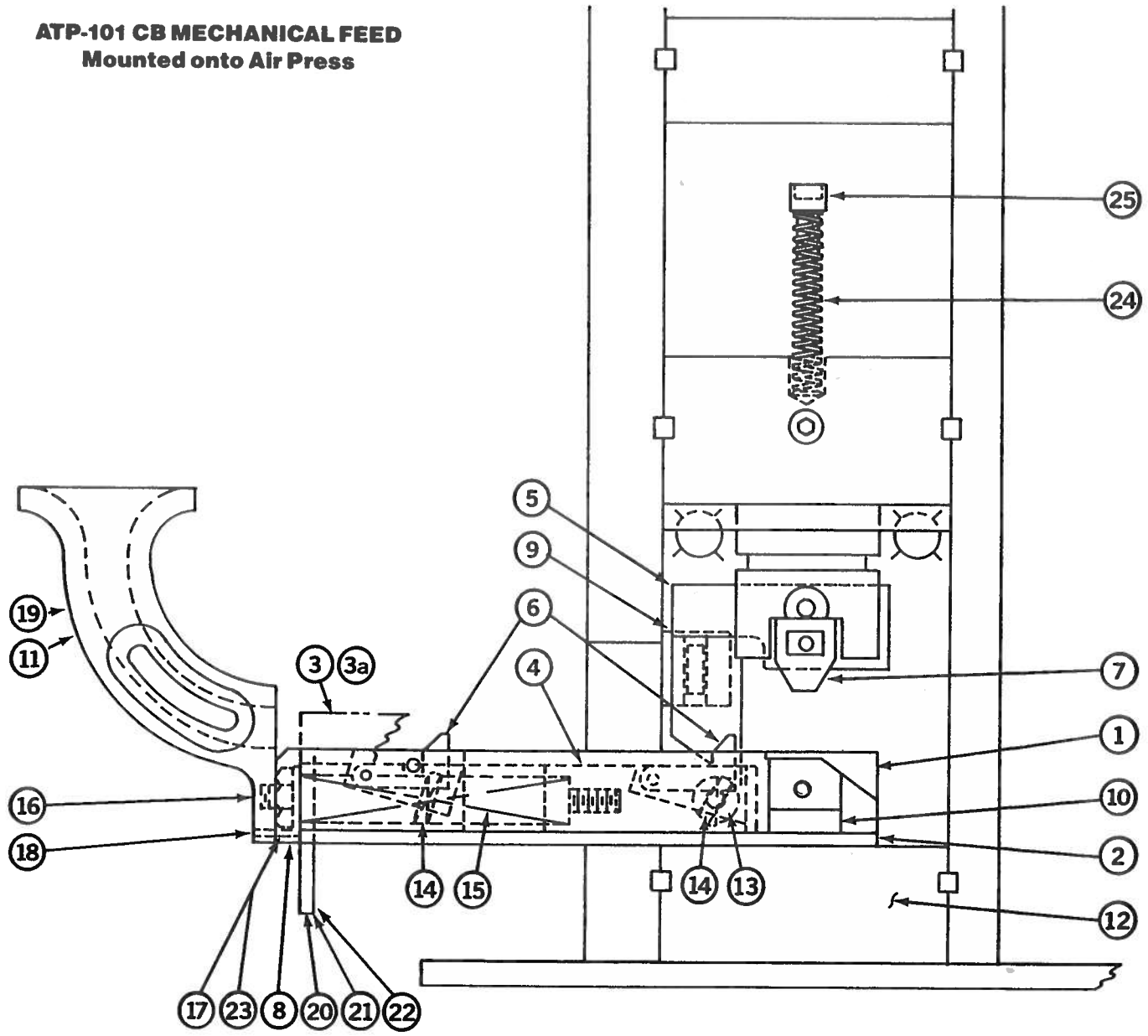
Model ATP-101 CB
REAR
VIEW



ITEM	REQ'D	DESCRIPTION	Molex-ETC PART NO.
17	1	Foot Switch & Cord	23334-02
18	1	Power Switch (Toggle)	23335-02
19	1	Selector Switch (Toggle)	23335-02
20	1	Transformer (110V/6.3V)	23334-10
21	1	Solenoid Valve	23334-13
22	1	Main Air Cylinder	23192-00
23	1	Secondary Air Valve	23192-09
24	1	Control Box	23251-02
25	1	Primary Air Valve Assembly	23189-00
26	1	In Line Air Filter	23172-08
27	1	Brass Fitting Elbow	26800-75
28	1	Upper Die Holder	23157-05
29	1	Upper Die Holder Retainer Screw (¼-20 x ¼)	26130-47

ITEM	REQ'D	DESCRIPTION	Molex-ETC PART NO.
30	1	Ram Bushing	23154-06
31	1	Ram	23155-01
32	1	Ram Lift Pin	23155-03
33	1	Lower Roller	23155-02
34	1	Power Cam	23155-16
35	1	Upper Roller	23155-05
36	1	Timing Control Switch (With Arm)	23334-27
37	1	Acorn Nut (⅜ - 16)	26210-58
38	1	Air Override Control Valve	23197-06
39	1	"Power On" Indicator Light	23335-04
40	1	Air Press Cover with Handle **(SHOWN ON FRONT COVER ONLY)**	23155-34

ATP-101 CB MECHANICAL FEED
Mounted onto Air Press



ITEM	REQ'D	DESCRIPTION	Molex-ETC PART NO.
1	1	Base Block	23343-01
2	1	Back Up Plate—Base Block	23341-02
3	1	Universal Cover Plate Ass'y.	23343-13
3A	1	Coupler Cover Plate Ass'y.	23343-24
4	1	Feed Slide	23343-04
5	1	Cam	23343-03
6	2	Stop & Feed Pawls	23343-07
7	1	Terminal Hold-Down Rubber	23343-17
8	1	End Cover	23343-14
9	1	Bearing Block Ass'y	23341-18
10	1	Die Spacer	23343-09
11	1	Terminal Guide	23343-21
12	1	ATP-101 CB Base Block	23341-13
13	1	Cam Follower	23341-15
14	2	Comp Spring (Feed & Stop Pawls)	23341-16
15	1	Comp Spring (Feed Slide)	23341-17
16	1	¼ - 28 Rod x 4" Lg.	26220-89
17	1	¼ - 28 Self Locking Hex Nut	26210-84
18	1	Spring Plunger	23343-15
19	2	¼ - 20 x ¾" But. HD Hex Soc. Cap Screw	26120-24
20	1	Adjuster Pad-Handle	23343-11
21	1	Adjuster Pad-Inner	23343-10
22	2	4 - 40x⅜" Flat HD Hex Soc. Cap Screw	26110-27
23	1	Flat Washer (Modified)	23343-16
24	1	Comp. Spring-Ram Lift Cylinder	23341-24
25	1	Spring Adapter-Ram Lift Cylinder	23341-27

INSTRUCTIONS FOR CHANGING FEED POSITIONS ON ATP-10ICBC CRIMPING PRESS

ED ADJUSTER SLIDE HAS THREE STEPS FOR POSITIONING FEED FINGER FOR ALL WIRE RANGES OF LLY INSULATED QUICK DISCONNECT PRODUCT LINE. STEP CHANGES ARE EASILY MADE BY PUSHING OR LLING BLACK KNOB FRONT TO REAR.

EP *1 YELLOW 26-24 / RED 22-18 DOUBLE LINES (RED/YELLOW). SLIDE SHOULD BE IN REAR POSITION AGAINST POSITIVE STOP SO THE YELLOW LINE IS IN LINE WITH REAR EDGE OF MECHANICAL FEED COVER.

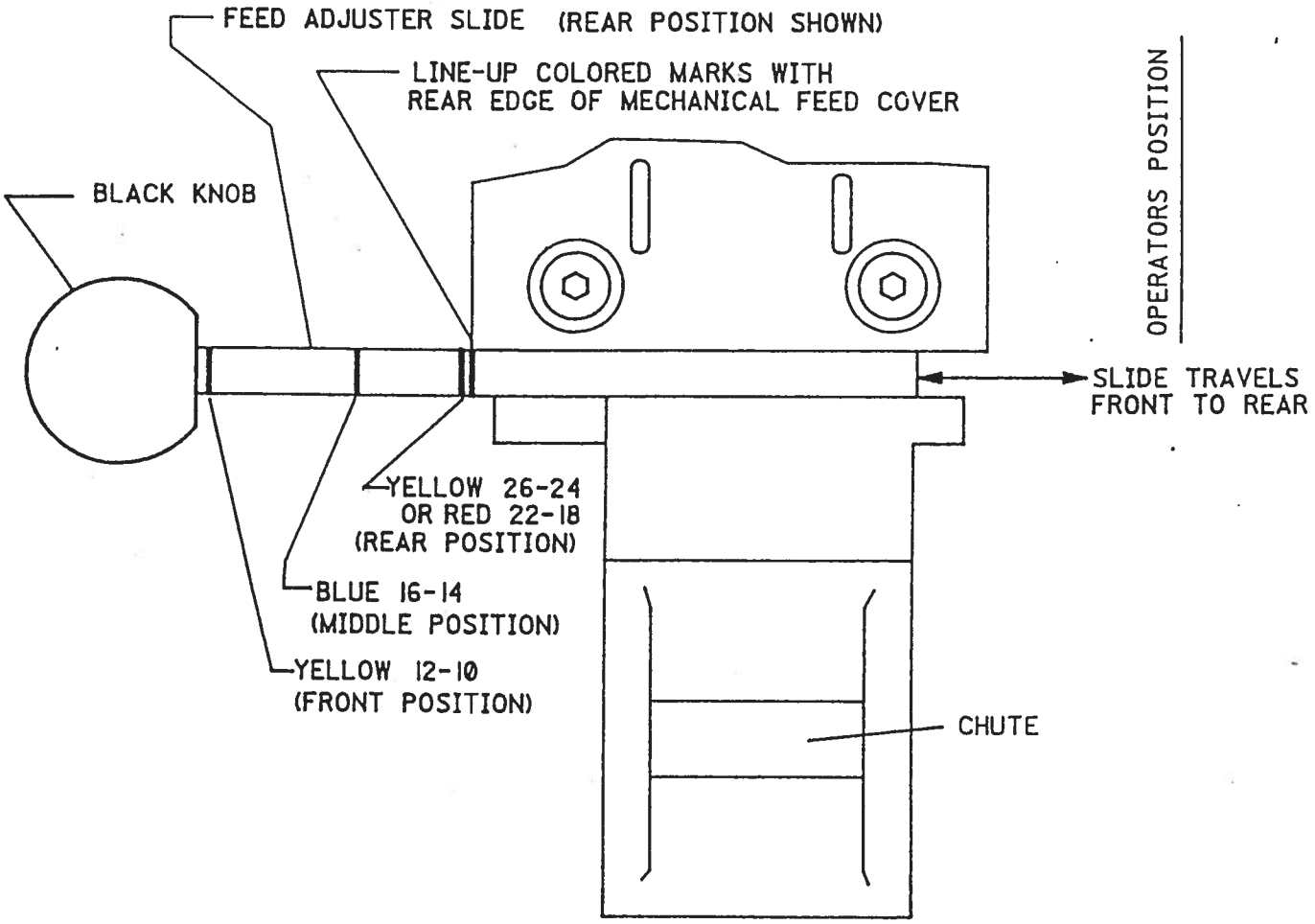
EP *2 BLUE 16-14 (BLUE LINE). SLIDE SHOULD BE IN MID RANGE POSITION SO BLUE LINE IS IN LINE WITH REAR EDGE OF MECHANICAL FEED COVER. (NO POSITIVE STOP FOR MIDDLE POSITION)

EP *3 YELLOW 12-10 (SINGLE YELLOW LINE). SLIDE SHOULD BE IN FRONT POSITION AGAINST POSITIVE STOP SO THE SINGLE YELLOW LINE IS IN LINE WITH THE REAR EDGE OF MECHANICAL FEED COVER.

NGE OF MECHANICAL FEED COVERS IS REQUIRED WHEN CONVERTING FROM 26-14 WIRE RANGES TO 12-10 E RANGE. THE 12-10 COVER IS DEDICATED TO 12-10 FULLY INSULATED QUICK DISCONNECT.

-24,22-18 & 16-14 WIRE RANGES REQUIRE A SEPERATE ADDITIONAL COVER.
S COVER HAS ADJUSTMENTS WHICH ARE OUTLINED IN THE ATP-10ICB INSTRUCTION MANUAL.

TE: ATP-10ICB WILL HANDLE 26-24 , 22-18 OR 16-14 AWG ONLY.
ATP-10ICBC WILL HANDLE 26-24 , 22-18 , 16-14 OR 12-10 AWG.



ATP-10ICBC
PARTIAL TOP VIEW

E NAME: 2334330 12/22/89

DWG. NO 23343-30

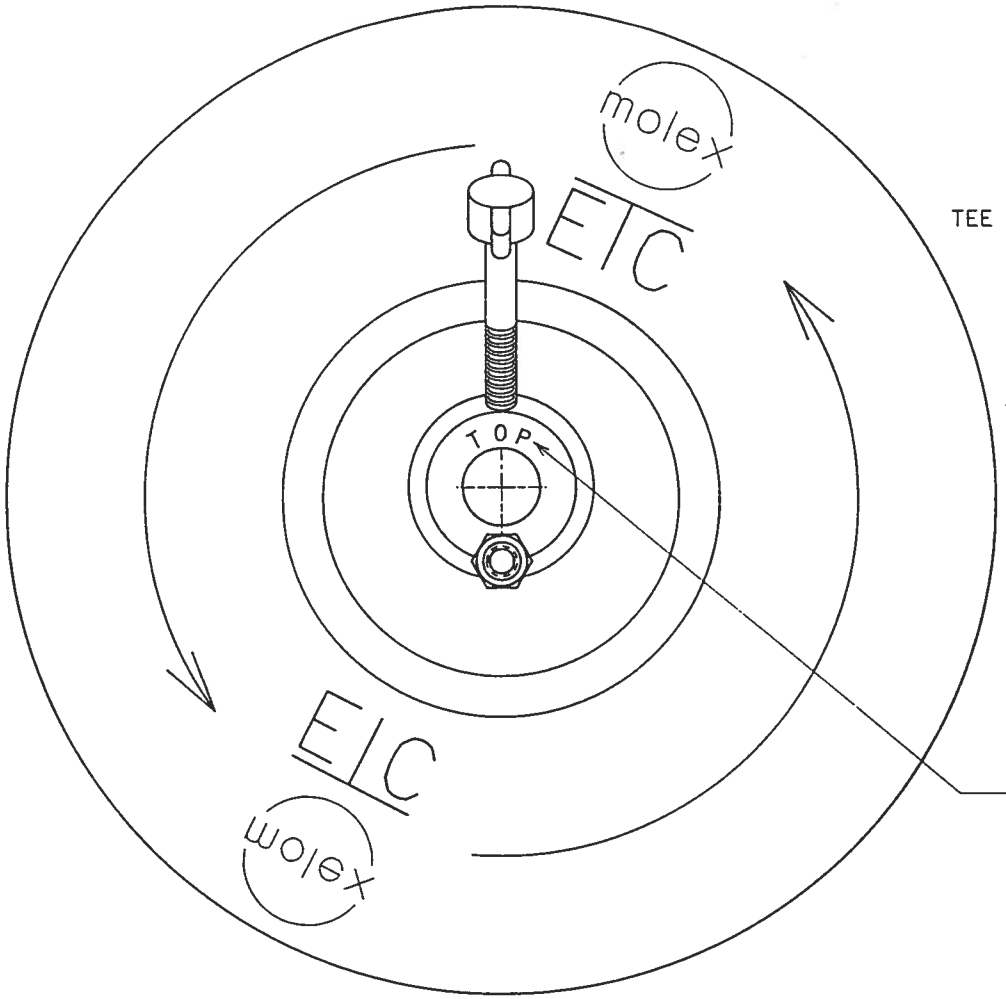


FIG - 1
OPERATORS VIEW

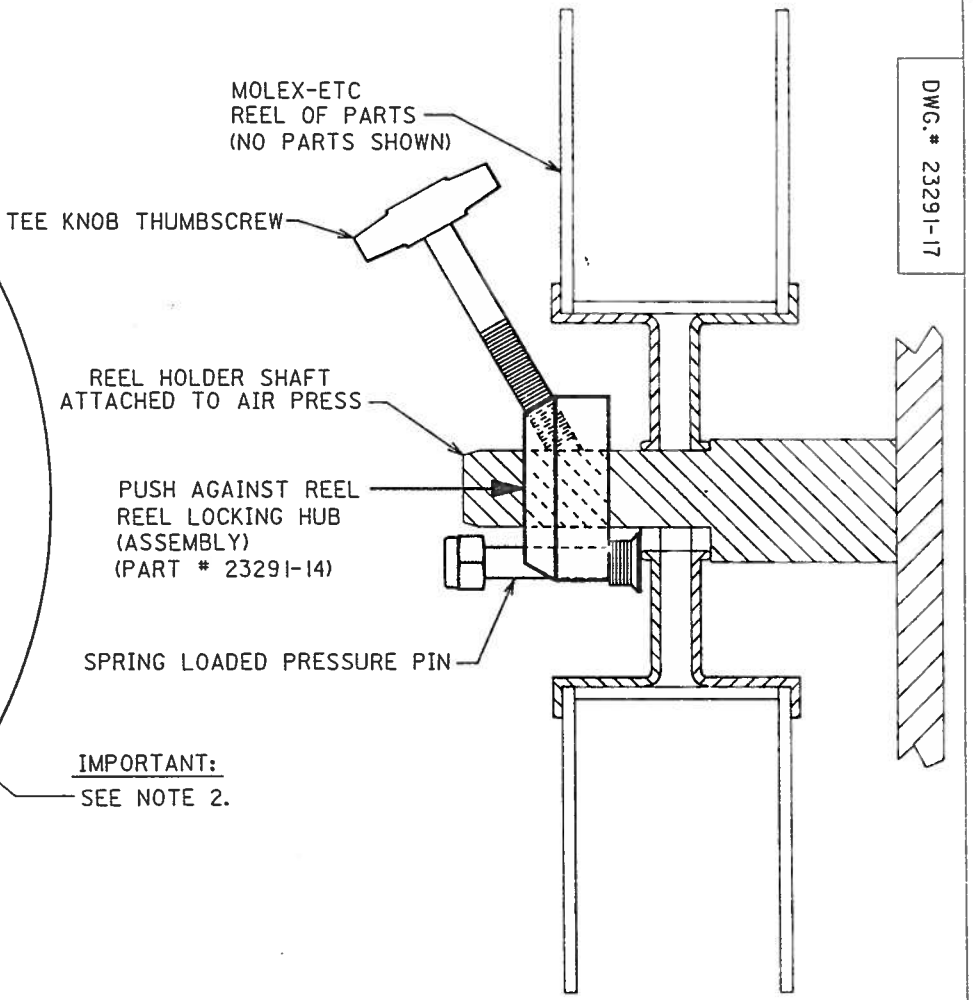


FIG - 2
SIDE VIEW
CROSS SECTION

DWG.# 23291-17

1. SLIDE REEL OF MOLEX-ETC PARTS ONTO THE REEL HOLDER SHAFT OF THE AIR PRESS (FIG-2).
2. SLIDE THE REEL LOCKING HUB ØNTO THE REEL HOLDER SHAFT. IMPORTANT: THE PORTION OF THE HUB WITH "TOP" STAMPED ON IT MUST BE POSITIONED UP AS SHOWN IN (FIG-1).

AFTER THE "TOP" OF THE REEL LOCKING HUB IS POSITIONED PROPERLY:

A.) USE A SLOW STEADY PRESSURE AND PUSH THE HUB AGAINST THE REEL. THIS COLLAPSES A PRESSURE PIN AGAINST THE REEL (FIG-2).

B.) WHILE HOLDING THE REEL LOCKING HUB AGAINST THE REEL, TURN THE TEE KNOB THUMBSCREW CLOCKWISE UNTIL IT IS FIRMLY TIGHT (FIG-2).

INSTRUCTIONS FOR AIR PRESS REEL LOCKING HUB
DWG.# 23291-17
CAD FILE 2329117
03/30/94 EMF

ACP-101
PART LOADING INSTRUCTIONS

Top View of Cover Plate

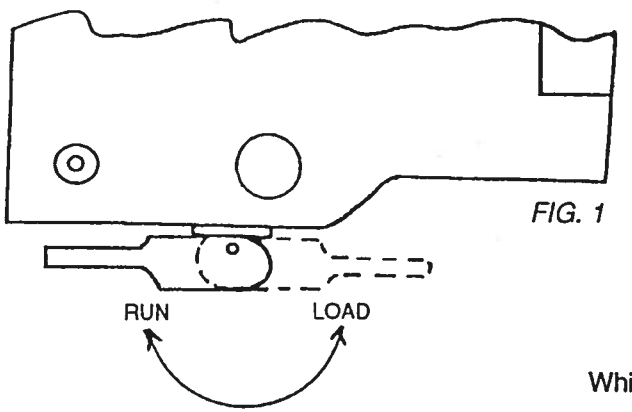


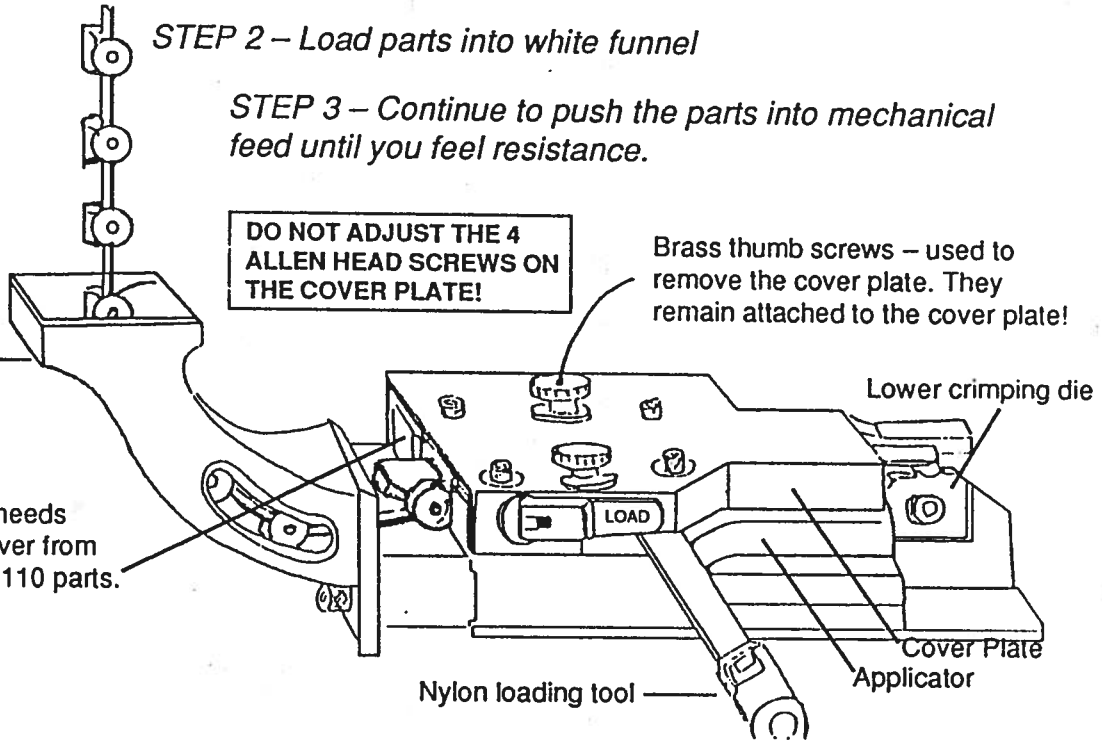
FIG. 1

STEP 1 – Swing toggle to load position

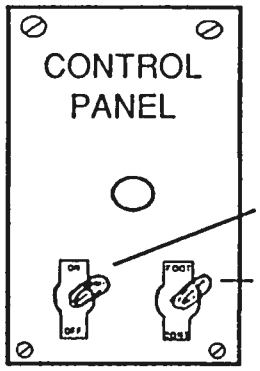
STEP 2 – Load parts into white funnel

STEP 3 – Continue to push the parts into mechanical feed until you feel resistance.

DO NOT ADJUST THE 4 ALLEN HEAD SCREWS ON THE COVER PLATE!



STEP 4 – Looking into the slot between the cover plate and the applicator, take the nylon loading tool, push the first terminal until it's located over the lower crimping die.



STEP 5 – Switch the toggle to "run" position (see Fig. 1), then with machine on, depress foot pedal. Crimp 2 or 3 parts to check for proper alignment and crimp.

AIR =	85 to 105 PSIG
POWER =	115 Volt 60 Cycles 1/4 Amp