

Fig. 1

1. INTRODUCTION

This instruction sheet (IS) covers the use of AMP Auto-Cycle Unit Conversion Kit 543160-1 which allows AMP one-step tooling assemblies to be used with AMP Pneumatic Auto-Cycle Unit 91112-3.

Included in this instruction sheet are recommended procedures for frame setup and tooling assembly installation. Read these instructions carefully before installing the conversion kit.

NOTE

All dimensions on this instruction sheet are in inches.

2. DESCRIPTION (Figure 1)

The auto-cycle conversion kit consists of a clip and an adjustable guard. The clip is installed on the rear of the tooling assembly base, and is used to cycle the unit. AMP Adjustable Guard 126424-1 provides

protection to the operator when the auto-cycle unit is terminating connectors.

3. SETUP PROCEDURE (Figure 2)

Determine which one-step tooling assembly will be installed on the pneumatic auto-cycle unit and proceed as follows:

1. Secure frame to a work bench to ensure stability during operation.
2. Disconnect air supply to the unit. Remove regular auto-cycle guard.
3. Secure appropriate upper tooling to ram with guide pin and lock pin which are included with tooling assembly.
4. Remove cover from auto-cycle unit and remove air hose fitting.
5. Loosen large nut on top of ram to adjust the bottoming stroke of the ram.

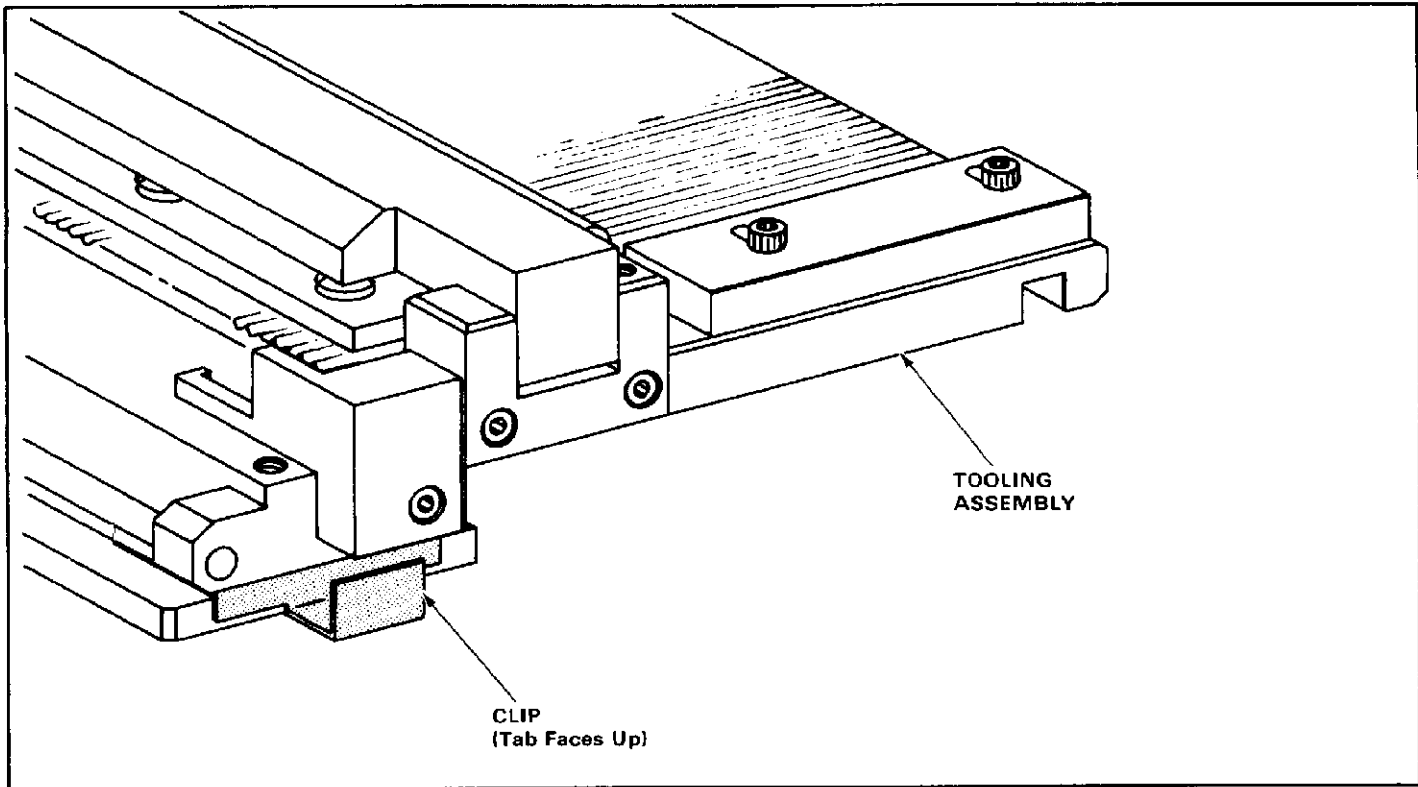


Fig. 2

6. Turn inside ram clockwise until the dimension from bottom of frame surface to the top of the upper tooling surface is $.135 \pm .010$ in. See Figure 3.

7. Tighten the large nut and connect the air

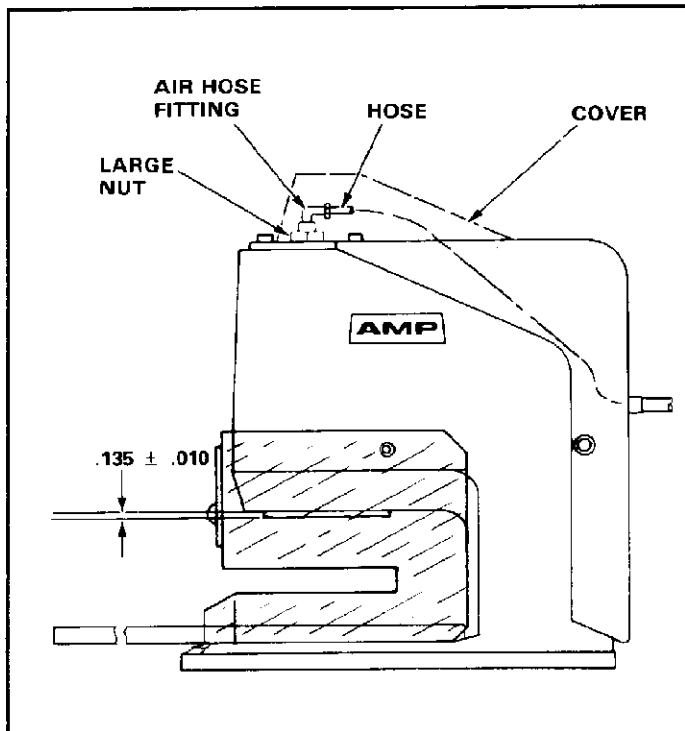


Fig. 3

hose fitting, making sure that the hose fitting faces to the rear of the auto-cycle unit.

8. Replace the cover over the unit, and secure it with appropriate hardware.

9. Install clip on rear of tooling assembly, making sure tab on clip faces up, as shown in Figure 2.

10. Remove tool stop from base plate, slide tooling assembly onto base plate, and re-install tool stop.

11. Position adjustable guard onto auto-cycle unit, making sure front of guard is properly positioned over the capscrews, as shown in Figure 1. Tighten capscrews on guard.

12. Connect unit to an air supply that will provide and maintain pressure of 80 to 90 psi to the unit.

This completes setup procedure.

4. TERMINATING PROCEDURE

1. Install connector and cable into the tooling assembly according to the instructions packaged with the tooling assembly.

2. Slide tooling assembly to rear of pneumatic auto-cycle unit until sensing port closes. The ram will automatically cycle and terminate the cable to the connector.

3. Slide tooling assembly forward and remove terminated connector.