

1. INTRODUCTION

Adapter Kits 854468-[] are used to adjust Ribbon Cable Notcher 854449-[] for use in the power units listed in Figure 1. These instructions cover the installation of the adapter kit onto the ribbon cable notcher. Refer to instruction sheet 408-9515 for setup and operation of the notcher.



Dimensions on this instruction sheet are in millimeters [with inches in brackets]. Figures are not drawn to scale.

ADAPTER KIT	POWER UNIT (Customer Manual)
854468-1	AMP-O-LECTRIC* Model "K" Terminating Machine 2-565435-2 or 565435-5 [†] (409-5128)
854468-2	2700-lb Pneumatic Power Unit 312522-1 (409-5590)

[†]Machine 565435-5 is no longer available for new applications, but can still be used for existing applications.

Figure 1

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

2. DESCRIPTION

Adapter Kit 854468-1 consists of an adapter plate, upper adjuster, lower adjuster, shoulder bolt, spring, socket head cap screws, movable rear stop, guard and two tubing connectors.

Adapter Kit 854468-2 consists of a ram adapter and socket head cap screws.

3. INSTALLATION

3.1. Adapter Kit 854468-1 (For Model "K" Machine)

1. DISCONNECT THE POWER from the terminating machine.
2. Attach the adapter plate to the underside of the ribbon cable notcher using the four 8-32 socket head cap screws. Refer to Figure 2.
3. Attach the lower adjuster to the upper die plate of the notcher using the two 10-32 socket head cap screws. Refer to Figure 2.
4. Install the shoulder bolt and spring into the upper adjuster. Place the upper adjuster onto the lower adjuster. Tighten the bolt. For proper clearance, the upper adapter must be oriented for end notching (seated in the bottom groove in the lower adjuster) during installation. Adjust for feed-through notching

(seated in the upper groove in the lower adjuster) after installation as described in Step 9. See Figure 3, Detail A.

Installing Adapter Kit 854468-1

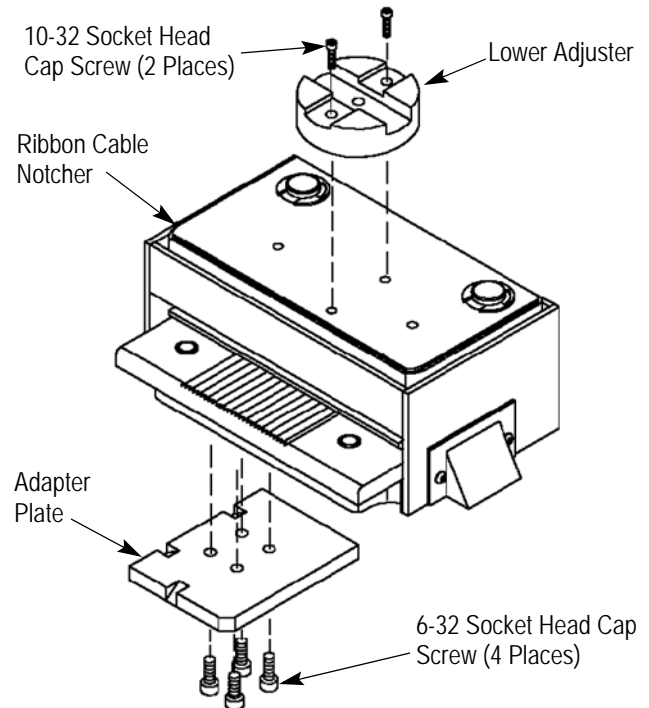
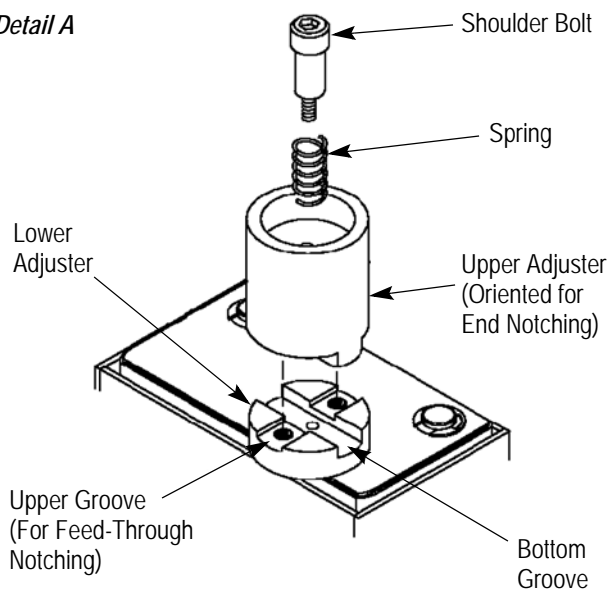


Figure 2

5. Slide the notcher onto the base of the terminating machine. Make sure to orient the notcher according to the type of notching being used (refer to the instructions packaged with the notcher). Align the slots in the adapter plate with the fixed rear stops on the terminating machine. See Figure 3, Detail B.
6. Install the movable rear stop (included with adapter kit), locking the notcher into place.
7. Install the adapter kit guard onto the terminating machine. Make sure that the notcher guard is installed onto the notcher.
8. Connect the notcher air hose to the air supply (use the appropriate tubing connector included with the adapter kit).
9. For end notching, make sure that the notcher cable stop plate is located against the dowel posts. For feed-through notching, remove the cable stop plate from the notcher. Lift and rotate the upper adjuster 90°. Make sure that it is fully seated in the lower adjuster (refer to Figure 3, Detail A).

Installing Adapter Kit 854468-1

Detail A



Detail B

For Clarity, Notcher and Terminating Machine Not Shown

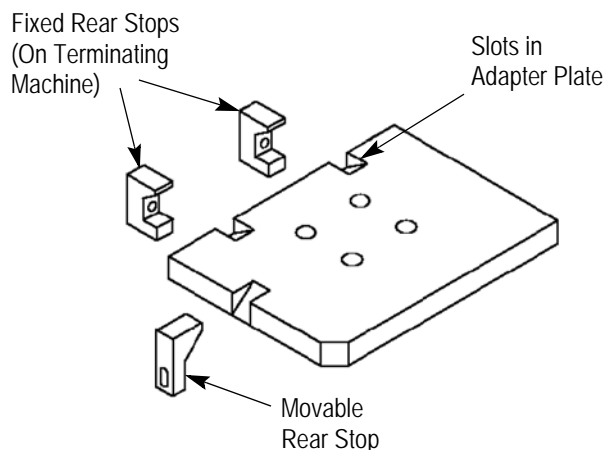


Figure 3

3.2. Adapter Kit 854468-2 (For Pneumatic Power Unit)

1. Adjust the stroke of the pneumatic power unit (as described in the instructions included with the unit) according to the type of notching being used: end notching requires a 6.35 [.25] stroke, and feed-through notching requires a 10.41 [.41] stroke.

2. DISCONNECT THE POWER from the pneumatic power unit.

3. Attach the adapter kit ram adapter to the ram using the four 6-32 socket head cap screws. See Figure 4.

4. Slide the notcher onto the base of the power unit. Make sure to orient the notcher according to the type of notching being used. Refer to Figure 5.

5. For end notching, make sure that the notcher cable stop plate is located against the dowel posts. For feed-through notching, remove the cable stop plate from the notcher.

Installing Adapter Kit 854468-2

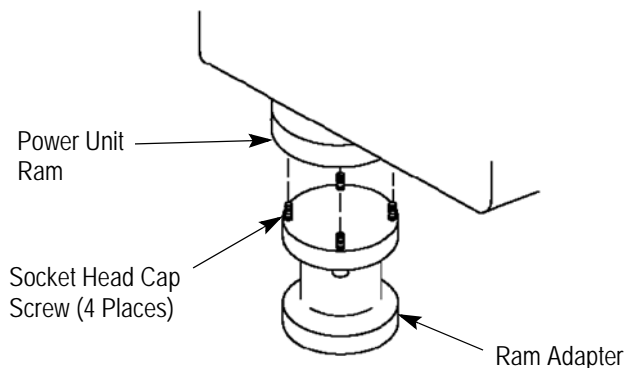


Figure 4

Orientation of Ribbon Cable Notcher

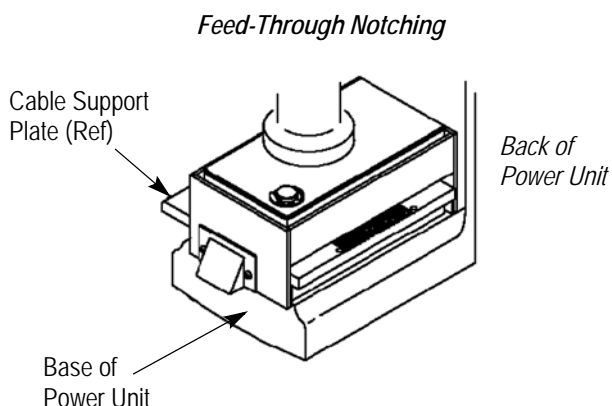
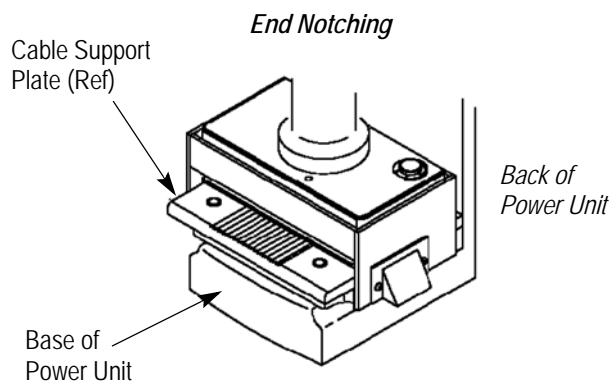


Figure 5

4. MAINTENANCE AND INSPECTION

4.1. Daily Maintenance

It is recommended that each operator be responsible for the following four steps of daily maintenance:

Remove dust, moisture, and contaminants with a clean, soft brush or a soft, lint-free cloth; or clean the tooling with compressed air.



Compressed air used for cleaning must be reduced to less than 206.8 kPa [30 psi]. ALWAYS use effective chip guarding and personal protective equipment (including eye protection).



Do NOT use objects that could damage any tooling.

6. Make sure that the tooling is in place and secure.
7. When not in use, store the adapter kit in a clean, dry area.

4.2. Periodic Inspection

Regular inspection should be performed by quality-control personnel. A record of scheduled inspections should remain with the adapter kit or be supplied to personnel responsible for tooling. Though recommendations call for at least one inspection a month, the frequency should be based on amount of use, working conditions, operator training and skill, and established company policies.

4.3. Visual Inspection

1. Make certain all components are in place.
2. Check all surfaces for wear. Replace worn parts.

5. REPLACEMENT AND REPAIR

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

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

For customer repair service, call 1-800-526-5136.

6. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Corrected typographical errors throughout.
- Updated document to corporate requirements.