

CONNECTOR TYPES	CONNECTOR-SPECIFIC KITS
AMPLIMITE* .050 Series	679235-1 (408-9892)
AMP-LATCH* Paddleboard	679176-1 (408-9928)

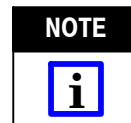
Figure 1

## 1. INTRODUCTION

These instructions cover installation, setup, and termination procedures for Base Assembly Universal Arbor Tool 768338-2. The universal arbor tool is used with connector-specific kits (listed in Figure 1) to terminate connectors onto .64 mm [.025 in.] centerline ribbon cable. The tooling assemblies are used in conjunction with Manual Arbor Frame Assembly 91085-2 (see Figure 1) or Pneumatic Auto-Cycle Unit 91112-3.

For information regarding the setup and operation of the arbor frame assembly, refer to instruction sheet 408-7777 and 408-6732 for the auto-cycle unit. Installation and setup procedures for the connector-specific kits are available in 408-9928 (for 679176-1) and 408-9892 (for 679235-1).

Read these instructions (and other referenced documents) thoroughly before terminating any connectors.



*Dimensions are in millimeters [followed by inches in brackets].*

## 2. DESCRIPTION (Figure 1)

The universal arbor tool consists of an upper tool mount and a lower tooling assembly. The lower tooling consists of a machined base, a fluted plate, two cable guides, a cable clamp, a cable stop, and a front guard. The machined base allows the tooling to be moved into and out of the crimping area of the arbor frame assembly. The fluted plate is designed to provide proper seating of the ribbon cable. The cable guides aid in positioning the ribbon cable with the connector assembly, and the cable clamp holds the

ribbon cable in position. The cable stop provides proper positioning of the ribbon cable for flush terminations.

### 3. INSTALLATION OF BASE ASSEMBLY UNIVERSAL ARBOR TOOL (Figure 1)

**NOTE**  
 The procedures in this section are typical for both the Manual Arbor Frame Assembly and the Pneumatic Auto-Cycle Unit.

**DANGER**  
 Before installing the universal arbor tool in the Pneumatic Auto-Cycle Unit, DISCONNECT air from main air valve.

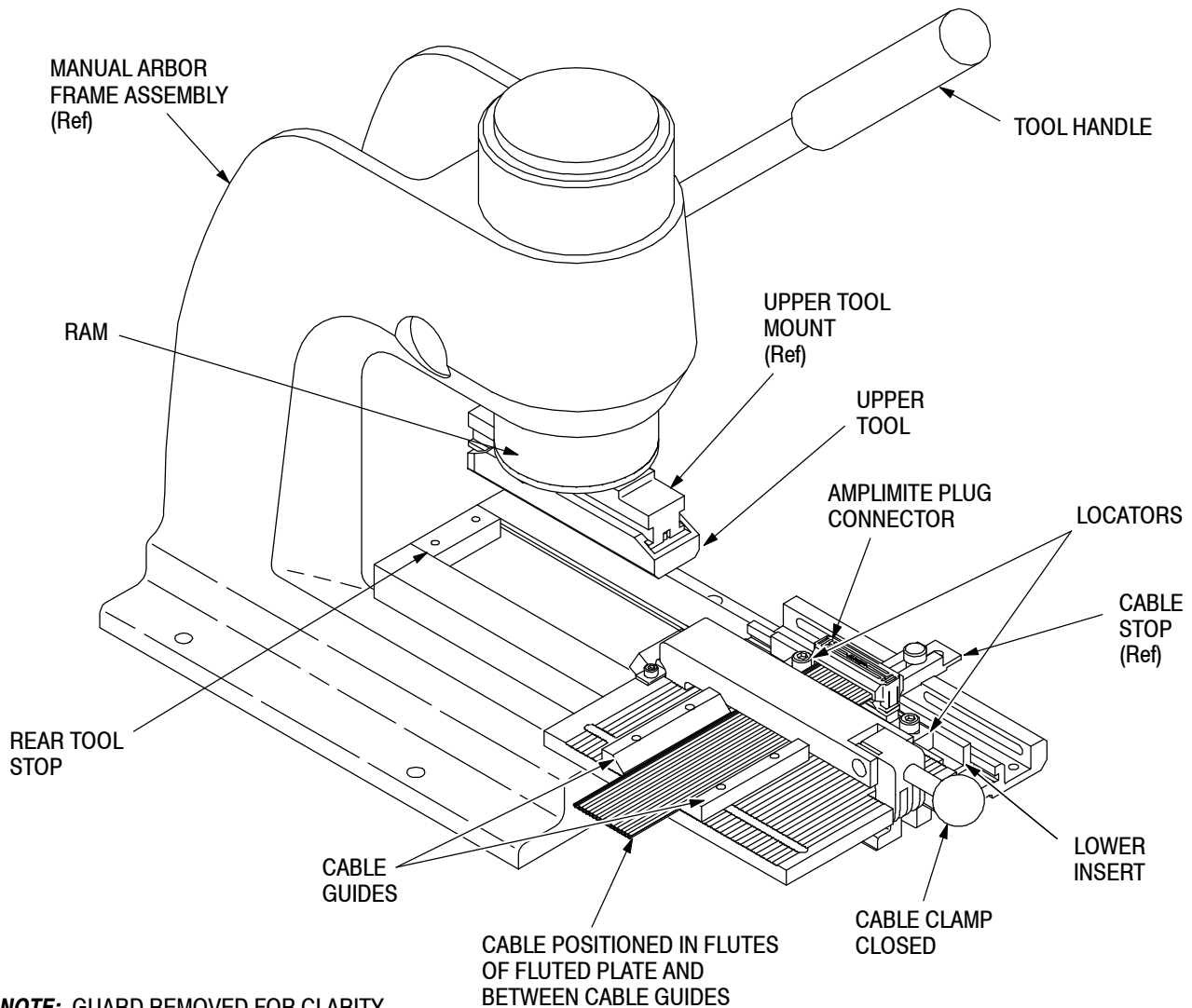
1. Secure upper tool mount to ram with the two socket head cap screws.

**NOTE**  
 The slot on the upper tool mount must face toward the FRONT of the frame assembly, as shown in Figure 1.

2. Remove tool stop from the front of the slide base.
3. Position lower tooling assembly onto slide base of frame assembly and slide into position.
4. Replace tool stop and tighten it to secure the lower tooling assembly onto the slide base.

### 4. TERMINATION PROCEDURE

1. Install the connector-specific kit onto the universal arbor tool; then set up the tooling components for termination. Refer to the instruction sheet supplied with the connector-specific kit. See Figure 2.



**NOTE:** GUARD REMOVED FOR CLARITY

Figure 2

**DANGER**

To avoid personal injury, make sure all guards are installed on the arbor frame assembly or the auto-cycle unit before terminating the connector.

2. Place cable into the flutes of the fluted plate, as shown in Figure 2.

**NOTE**

Cable conductors must stay in the same flutes for the entire length of the fluted plate.

3. Insert connector into the lower insert using the instructions supplied with the connector-specific kit.

4. Slide cable through the connector so that the end of the cable is against the cable stop. The cable must be positioned between the cable guides. When cable is properly positioned, close the cable clamp. See Figure 2.

5. To actuate the ram for the arbor frame assembly, slide lower tooling assembly toward rear of base plate until it is positioned against the rear tool stop. Pull down on the frame assembly handle to terminate the cable to the connector.

**NOTE**

To actuate the ram for the auto-cycle unit, slide lower tooling assembly toward the rear of the base plate until the sensing port closes. The frame assembly will automatically cycle and terminate the cable to the connector.

6. To retract the ram for the arbor frame assembly, raise the tool handle. Slide tooling assembly out from under the ram and remove the terminated connector.

**NOTE**

The ram will automatically retract when the auto-cycle unit has completed the crimp cycle. Slide the lower tooling out from under the ram to remove the terminated connector.

7. Measure the termination height of the connector. The dimension should conform to the termination height dimensions provided in Application

Specification 114-40049. If the termination height is incorrect, an adjustment to the ram height is required. Refer to the instruction sheet supplied with the appropriate frame assembly for ram height adjustment procedures.

## 5. MAINTENANCE AND INSPECTION

### 5.1. Maintenance

Base Assembly Universal Arbor Tool 768338-2 requires little maintenance other than to keep it clean. Remove debris and contaminants from the tooling with a clean, soft, lint-free cloth or a clean, soft brush. Do not use objects that could damage the tooling and do not use any solvents that could harm paint or plastic material. When not in use, store the tooling in a clean, dry area.

### 5.2. Inspection

The tooling should be inspected immediately upon arrival at your facility and at regularly-scheduled intervals thereafter to ensure that it has not been damaged. Examine the tooling for any signs of damage or excessive wear during inspections. If replacement of parts is necessary, refer to Figure 3 for the list of customer-replaceable parts.

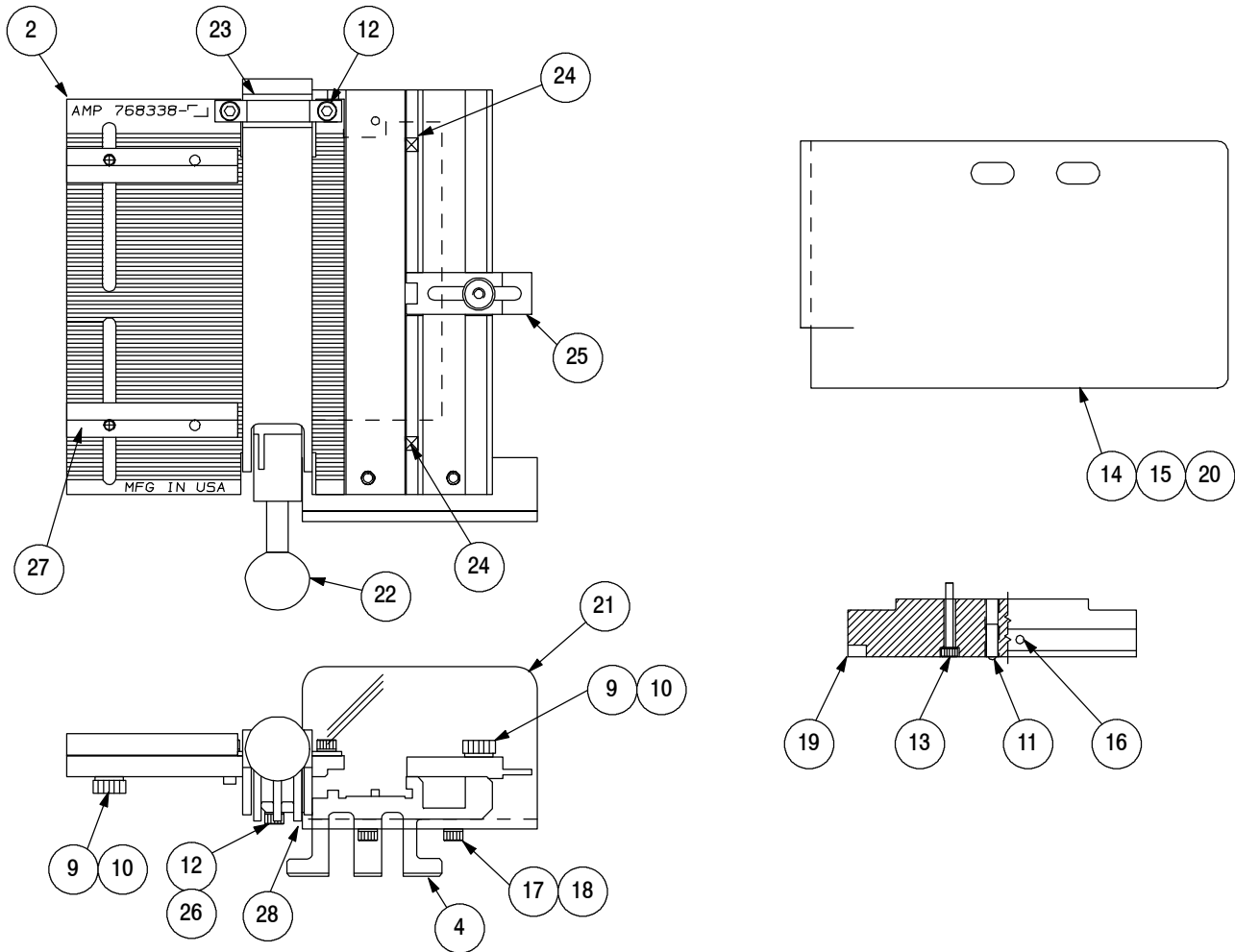
## 6. REPLACEMENT AND REPAIR

Figure 3 provides a list of customer-replaceable parts for the Base Assembly Universal Arbor Tool 768338-2. Replacement parts can be ordered through your local TE Connectivity representative. Parts replacement and tooling repair may also be secured by calling the Product Information or the Tooling Assistance Center at the numbers shown on the bottom of the first page of this document.

## 7. REVISION HISTORY

Since the previous version of this document, the following has been changed:

- Updated document to corporate requirements.



**BASE ASSEMBLY UNIVERSAL ARBOR TOOL 768338-2**

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
2	768724-1	PLATE, Fluted	1
4	768599-1	BASE, Machined	1
9	27708-2	KNOB, Thumbscrew, No. 6	3
10	2-21000-0	SCREW, SHC, 6-32 x .50 LG	3
11	23057-4	PLUNGER, Ball, SST	1
12	1-21000-9	SCREW, SHC, 6-32 x .38 LG	2
13	1-21000-7	SCREW, SHC, 4-4- x .75 LG	2
14	21055-7	WASHER, Flat, No. 10	3
15	2-21002-5	SCREW, BHC, 10-32 x .25 LG	3
16	3-21028-4	PIN, Roll, .093 x .38 LG	1
17	1-21000-8	SCREW, SHC, 6-32 x .25 LG	2
18	21055-5	WASHER, No. 6	2
19	314823-1	UPPER TOOL MOUNT	1
20	768602-1	GUARD, Frame	1
21	768707-1	GUARD, Front	1
22	768915-1	CABLE CLAMP ASSEMBLY	1
23	768603-1	PIN, Pivot	1
24	2-21006-7	SCREW, SET, 6-32 x .12 LG	2
25	679069-1	STOP, CABLE	1
26	2-21000-3	SCREW, SET, 6-32 x .88 LG	2
27	679068-1	GUIDE, Cable	2
28	679070-1	SPACER (Not Shown)	1

Figure 3