

Specifications and Ordering Information

WIRE RANGE

Stranded

26 - 10 AWG [0.12 - 6 mm²]

Solid

26 - 16 AWG [0.12 - 1.4 mm²]

INSULATION

Outside Diameter

.040 - .250 [1.02 - 6.35]

Types

Polyvinyl chloride (PVC),
Cross-linked polyethylene,
VULKENE, TFFLON and TEFZEL.
(Contact AMP for other insulation
types.)

WIRE TENSILE STRENGTH

10 lb [44 N] min.
(Wires with a lower tensile strength
should be evaluated by AMP
Engineering.)

STRIP LENGTHS

Standard Setup, Both Ends (Full or Partial Strip)

0 - .35 [0 - 8.9]

Special Setup, Both Ends (No Additional Tooling Required)

.725 [1" 8.4"] max.

With Long Strip Kit

Up to 1.5 [38] (Leading end only)

LEAD LENGTHS

Standard Machine

3 - 90 [76.2 - 2 285]

With Long-Lead Conveyor(s)

90 - 1 000 [2 285 - 25 400]
(Leads over 240 [6 095] may not stack
properly.)

With Short Lead Kit

Down to 1.62 [41.2]

Lead Length Variation

± .1% or ± .06 [1.52], whichever is
greater

MACHINE DIMENSIONS

See drawings, page 4.

Weight

2 000 lb [907 kg]

AIR REQUIREMENTS

Pressure

90 psi [6.21 bar] min. at 15 scfm
[0.0071 m³/s] sustained. Lower air
supplies will reduce production rates.

Air Drop Supply Line

.75 [19] min. dia.

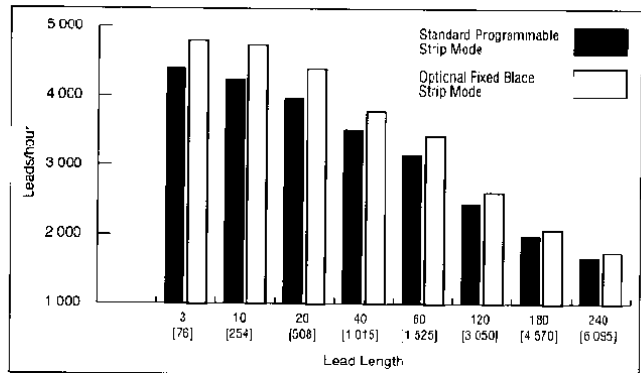
ELECTRICAL REQUIREMENTS

220 (±10%) VAC, 50/60 Hz, single
phase, 25 A with neutral and ground.

Production Rates

Notes:

- Air supply must be maintained at 90 psi [6.21 bar] and 15 scfm [0.0071 m³/s] to achieve maximum production rates.
- Rates apply to wire with average stiffness and characteristics.
- AMP recommends using barreled wire with the CLS IV+. Lower rates may be experienced with some wire sizes and types, or when using a dereeler or prefeeder.
- Rates for leads over 120 [3 048] may be reduced if long-lead conveyors are used.
- QCM may reduce rates by 200/hr.
- Closed barrel product may affect rates by 600/hr.



Base Machine Part Numbers

Tooling kits are **not** supplied with the base machine and must be purchased separately. One cutting blade kit is included with the base machine.

Description	Part No.
AMPOMATOR CLS IV+ Machine (with Manual Precision-Adjust Terminating Units)	356500-1 or 1213400-1*
AMPOMATOR CLS IV+ Machine (with QCM G-Adapter and Auto Precision-Adjust Terminating Units)	356500-2 or 1213400-2*

*CE Version

Tooling Kits

A minimum of one kit is **required** per machine. Each kit contains front and rear wire guides.

Wire Outside Diameter			Wire Outside Diameter		
inch	mm	Part No.	inch	mm	Part No.
.040 - .050	1.02 - 1.27	217943-1	.110 - .155	2.79 - 3.94	217943-4
.045 - .075	1.14 - 1.91	217943-2	.150 - .200	3.81 - 5.08	217943-5
.070 - .115	1.78 - 2.92	217943-3	.190 - .250	4.83 - 6.35	217943-6
.090 - .125	2.28 - 3.18	217943-7			

Components for Standard Programmable Strip Mode

One cutting blade kit, 854764-3, is included with each machine.

Description	Part No.
Cutting Blade Kit (includes long shear blades, universal strip blades, blade holders and spacers)	854764-3
Long Shear Blade (2 required per machine)	844764-5
Universal Strip Blade Kit, 26-10 AWG (includes 2 long and 2 short universal strip blades)	856695-9

Wire size-specific strip blade kits (below) can be ordered for improved stripping for difficult wire insulation.

Components for Optional Fixed Blade Strip Mode

Running in this mode allows the machine to run faster but requires a setup change every time strip length is changed. Minimum requirement is: 1 strip blade holder kit, 1 eject blade kit, and 1 strip blade kit.

Description	Part No.
Strip Blade Holder Kit (includes 2 blade holders, 2 shear blades, 1 bag of spacers)	814039-2
Shear Blade, .062 [1.58] Thick (order 2 blades per setup)	844764-1
Miscellaneous spacers	20576-1
Eject Blade Kit (4 eject blades, mounting hardware)	356505-1

Strip Blade Kits (includes 2 long and 2 short blades)

Wire Size			Wire Size		
AWG	mm ²	Part No.	AWG	mm ²	Part No.
10	5 - 6	856695-1	18	0.8 - 1	856695-5
12	3	856695-2	20	0.5 - 0.6	856695-6
14	2	856695-3	24-22	0.2 - 0.4	856695-7
16	1.2 - 1.4	856695-4	26	0.12 - 0.15	856695-8

Special blade kits for short strip and other specials available. Consult AMP.