

## Specifications and Ordering Information

### WIRE RANGE

#### Stranded

26 - 10 AWG [0.12 - 6 mm<sup>2</sup>]

#### Solid

26 - 16 AWG [0.12 - 1.4 mm<sup>2</sup>]

### 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 m<sup>3</sup>/s] sustained. Lower air  
supplies will reduce production rates.

#### Air Drop Supply Line

.75 [19] min. dia.

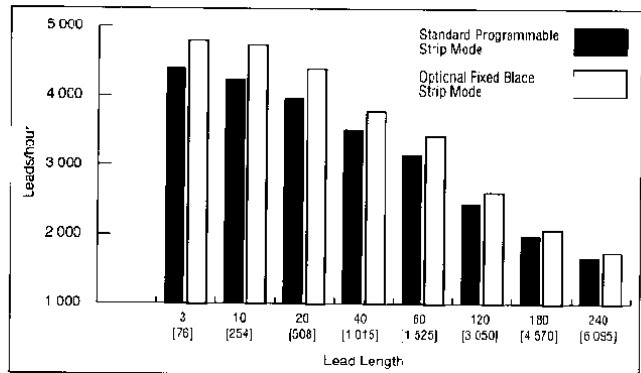
### ELECTRICAL REQUIREMENTS

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 m<sup>3</sup>/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.
- CQM 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 CQM 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 <sup>2</sup>	Part No.	AWG	mm <sup>2</sup>	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.