Accessory Full Cycle/Pressure Electrical Control Box	**molex**	**Application Tooling Specification Sheet**	
			Order No. 64001-4000
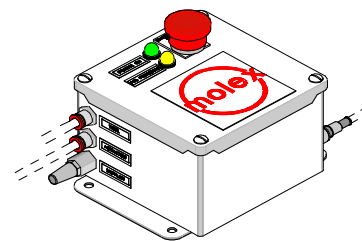
Features

- The 64001-4000 Full Cycle Electrical Control Box is an option for use on Air Power Crimp Tool (AT200) Order No.19279-0001 equipped with Bench Adapter Order No.19078-0307.
- This control box will assure that the air tool completes a full crimp cycle. Applying the air pressure for a long enough cycle to assure a successfully completed crimp.
- Prevents actuation if sufficient pneumatic pressure is not available to produce good crimps.
- Eliminates the operators' judgment and low line pressure as sources of variability for critical applications.

OPERATION

1. To install the control box remove the pneumatic foot switch and all of the tubing.
2. Replace with the components, fittings and the tubing. See Figures 1 and 3.
3. Make sure they are correctly connected in the right positions, which are clearly marked on the each side of the Cycle Box in Figure 1.
4. The power is on if the "*Green*" indicator light is on.
5. If the "*Yellow*" indicator light turns on, the air pressure is low (90 PSI – Min.). Check the pressure gauge and reset if necessary.
6. To change the cycle time, the timer has to be readjusted. This is done by removing the (4) screws on the top cover. Place the cover aside and locate the timer. See Figure 2. Using a Phillips screwdriver insert it in the slot on top of the timer. Turn the timer clockwise (CW) to increase time or counterclockwise (CCW) to decrease time. The dial can be turned by hand if a screwdriver is not available. Place the cover back and re-install the (4) screws.
7. Push the foot switch to start the crimp cycle.
8. When the crimp cycle is complete the circuit will release and the jaws of the air tool will open.
9. To stop the cycle before complete, push the emergency stop button. To reset, rotate the button clockwise (CW) as indicated by the arrows on the button.
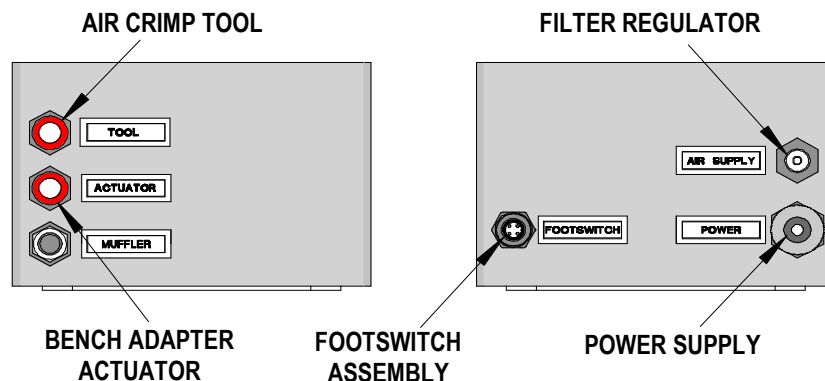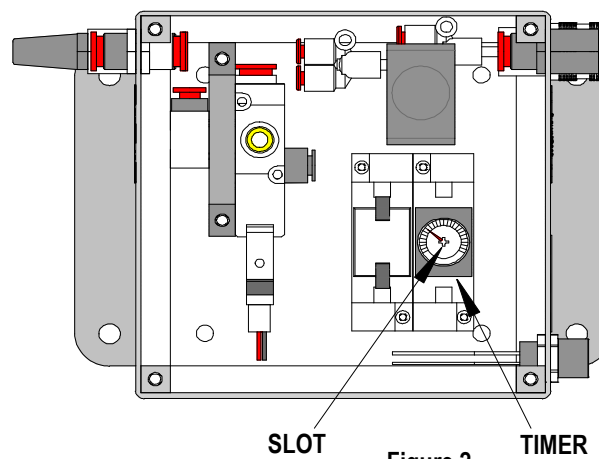

Figure 1

AIR CRIMP TOOL · FILTER REGULATOR · BENCH ADAPTER ACTUATOR · FOOTSWITCH ASSEMBLY · POWER SUPPLY

Figure 2

SLOT · TIMER

Parts List

Item	Order No.	Description	Qty
**64001-4000-Electrical Controls (Timed Cycle)**			
1	64001-4000	Control Box	Figure 3
2	62500-1265	Power Supply	1
3	63800-8394	Footswitch Assembly	1
4	69018-6237	Power Cord	1
5	N/A	1/4" OD Tubing	**
6	N/A	1/8 NPT by 1/4 Tube Fitting	**
7	19078-0307	Bench Adapter	REF
8	19279-0001	Air Power Crimp Tool	REF

** Available from an industrial supply company such as MSC (1-800-645-7270).

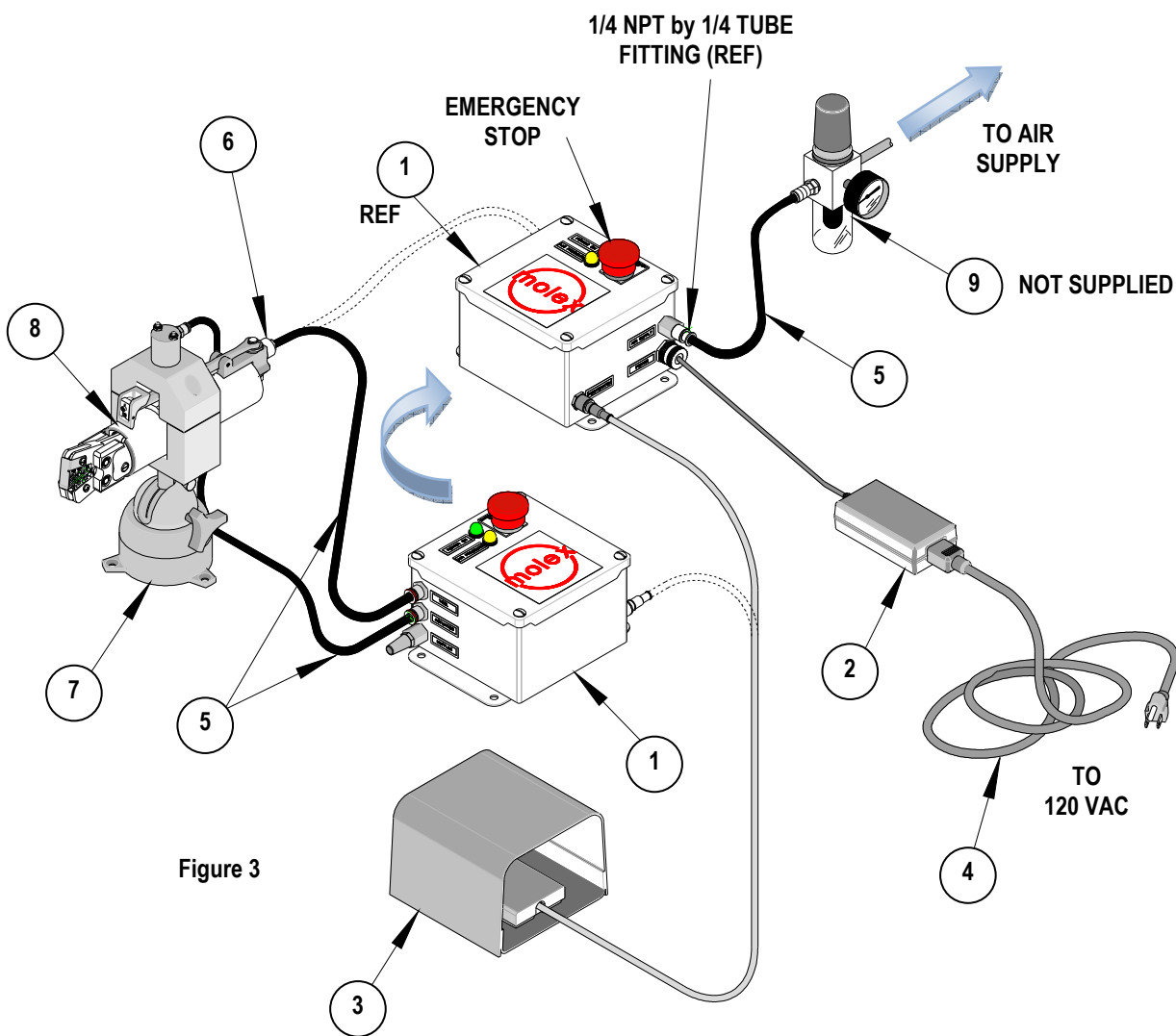**1/4 NPT by 1/4 TUBE FITTING (REF)**

EMERGENCY STOP

TO AIR SUPPLY

NOT SUPPLIED

TO 120 VAC

Figure 3

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