

# Air feed / Split cycle setup

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**Note: This procedure should be followed when utilizing airfeed applicators. The setup will be done in the OMI. The air feed valve is located on the lower right side of the press. If the air hose size on your air feed kit does not match up with the air fitting on your applicator you may need an air line reducer, part number 034409. Contact your Komax Corporation service technician for more details.**

## In the OMI Select

- Setup press, enter
- Peripherals, enter
- Airfeed, enter

## Highlight feeder , press enter

- Select POS. (position) or TIM (timer), most applications work fine with POS.
- Select either feed on the up stroke or down stroke, generally you will choose up
  - Set your start position to a value less than your stroke.  
i.e. 40mm stroke, choose 35mm start position

- › **Activation time can usually be left at the default value of 100ms. You can adjust it if you are having feed problems.**
- › **Press ESC to get back to main menu**

# Split cycle setup

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› **Note: You will utilize splitcycle during closed barrel applications so that the terminal will not move during insertion. Having the proper height is key. You can make these settings in Topwin or on the OMI with PC or LCD models**

## In the OMI: (for LCD models)

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### › Select the following

- Setup press
- Split cycle

### › Highlight split cycle and press enter

- Use the wheel to turn split cycle on or off. Press enter

### › Set split height

- You can start with the default of 5mm or you can take a measurement of the outer diameter of the terminal where it is being crimped. Press ESC to get back to main menu.
  - If height is correct you have little or no play side to side or up and down and your terminals should not be deformed.

# Setup for Topwin: (For PC models)

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## › Selecting the press

- In the setup screen click on the press that you are using closed barrel.
  - Note: the terminal must in closed barrel in the terminal type.
- Select the process tab
- Enable Split cycle
- Click the box next to split cycle. If it is checked it is on if there is no check it is off.

## › Set split height

- The split height is also set in the process tab of the terminal.

- The default value is 5mm or .20"
  - You may choose to start with the default value or you can make a measurement of the outer diameter of the terminal where it is to be crimped

### › Check split height

- When the terminal is captured there should be no play side to side or up and down. The terminal should not be deformed. If any of these symptoms are present you need to adjust your split height accordingly.