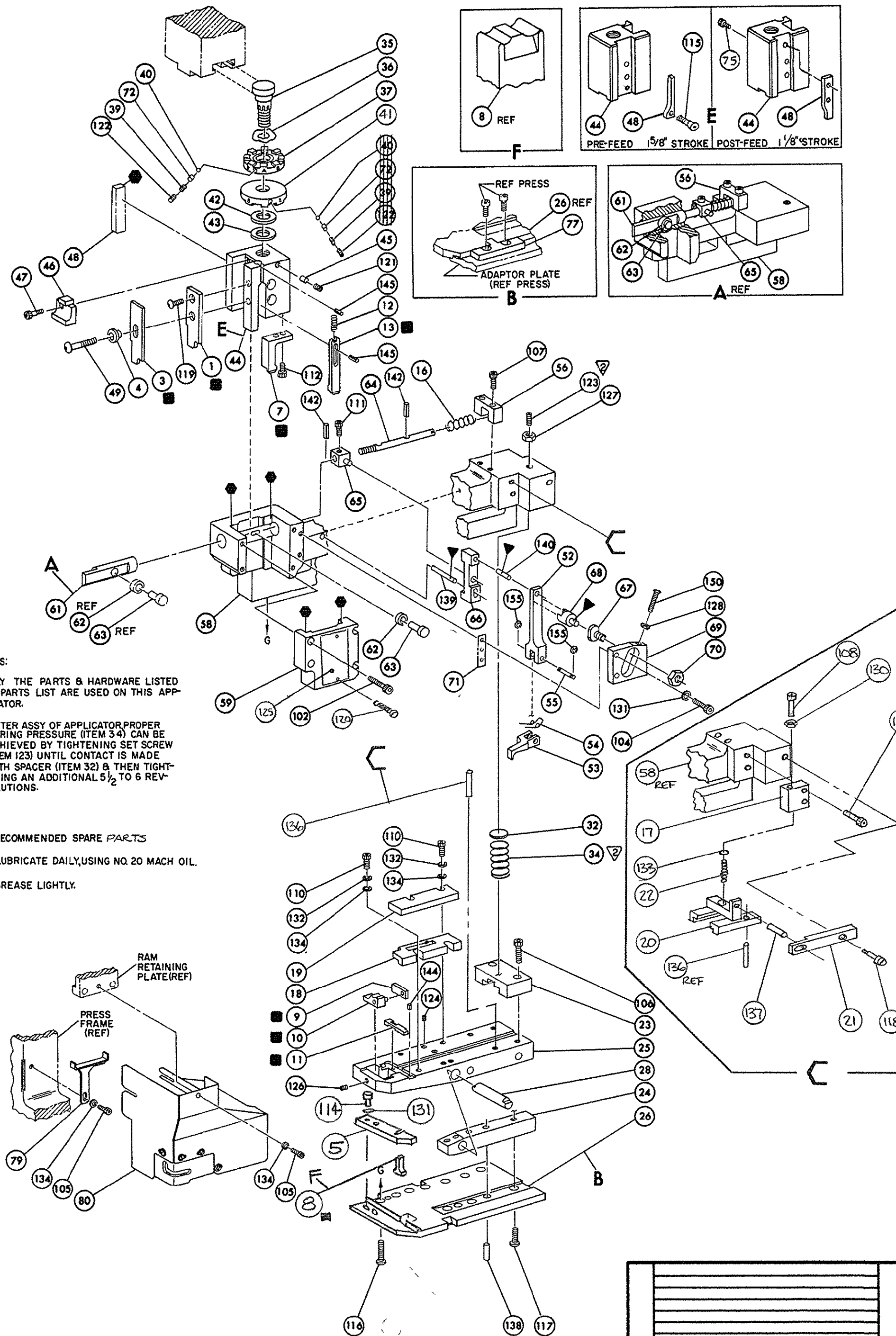


THIS IS A CONTROLLED DOCUMENT.



NOTES:
 1. ONLY THE PARTS & HARDWARE LISTED ON PARTS LIST ARE USED ON THIS APPLICATOR.

2. AFTER ASSY OF APPLICATOR PROPER SPRING PRESSURE (ITEM 3 & 4) CAN BE ACHIEVED BY TIGHTENING SET SCREW (ITEM 123) UNTIL CONTACT IS MADE WITH SPACER (ITEM 32) & THEN TIGHTENING AN ADDITIONAL 5/2 TO 6 REVOLUTIONS.

KEY:
 ■ - RECOMMENDED SPARE PARTS
 ▼ - LUBRICATE DAILY, USING NO. 20 MACH OIL.
 ● - GREASE LIGHTLY.

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REQ.	PART NO.	DESCRIPTION	NO.	REQ.	PART NO.	DESCRIPTION	NO.
			162	1	690517-1	SPACER	71
			161	1	22594-8	NUT, HEX	70
			160	1	240628-1	PLATE, ADJUSTMENT	69
			159	1	240626-1	SHAFT, PIVOT	68
			158	1	240633-1	BUSHING	67
			157	1	240630-1	LEVER, INTERMEDIATE	66
			156	1	240629-1	BLOCK, PIVOT	65
2	21045-3	RING RET "C" (3/16 DIA) FEED PIN	155	1	240632-2	SCREW, ADJUSTMENT	64
			154	1	240659-3	PIN, CAM ROLLER	63
			153	1	240658-1	ROLLER, CAM	62
			152	1	240631-1	ROD, FEED	61
			151				60
1	3-21064-1	SCREW RD. HD. MACH. (6-32 X 1.25) FEED ADJ.	150	1	455164-1	CAP, HOUSING	59
			149	1	458984-1	HOUSING	58
			148				57
			147	1	458961-1	GUIDE, FEED ROD	56
			146	1	240624-1	PIN, FEED FINGER	55
2	4-21028-9	PIN SLOTTED SPRING (1/8 DIA X .38) RAM	145	1	691499-1	SPRING, FEED FINGER	54
1	3-21028-2	PIN, SLOTTED SPRING (3/32 DIA X .25) REAR SHEAR PLATE	144	1	690584-5	FINGER, FEED	53
			143	1	240634-1	LEVER, TERMINAL	52
2	5-21028-1	PIN, SLOTTED SPRING (1/8 DIA X .50) SCREW ADJ. ROD	142				51
			141				50
1	1-21030-2	PIN, DOWEL (3/16 DIA X .62) LEVER	140	1	3-21002-5	BOLT, CRIMPER	49
1	1-21030-6	PIN, DOWEL (3/16 DIA X 1.25) HOUSING	139	1	690696-1	CAM FEED 1/8 STROKE	48
1	21029-5	PIN, SLOTTED (3/16 DIA X .75) BASE PLATE	138				47
1	21029-3	PIN, SLOTTED SPRING (.187 X .62 LG) DRAG	137				46
2	1-21030-6	PIN, DOWEL (.187 X 1.25 DIA) DRAG	136	1	690191-1	PLUG, NYLON	45
			135	1	691533-1	RAM	44
			134	1	690125-1	WASHER, LAMINATED	43
1	21899-3	WASHER, FLAT 1/4 GUARD	133	1	690124-4	WASHER, RAM	42
4	21024-4	WASHER, LOCK (#8) STRIP GUIDE	132	1	690223-1	DISC, SPACER	41
4	21024-5	WASHER, LOCK (#10) FEED ADJ. PLATE & RET PLATE	131	1	23241-6	BALL, STEEL	40
1	21018-7	NUT, HEX (#10) DRAG	130	1	690170-1	SPRING, DISC.	39
1	21022-3	NUT, HEX (SELF LOCKING) (#10-32) DRAG STUD	129				38
1	21018-5	NUT, HEX MACH (6-32) FEED ADJ.	128	1	3-690141-1	DISC., WIRE	37
1	1-22202-7	NUT HEX MACH (5/16-24) SPRING HOUSING	127	1	22480-5	WASHER, SPRING	36
			126	1	690212-1	POST, RAM	35
1	21061-9	SCREW SKT. SET (8-32 X .25) ANVIL INSERT	125	1	3-23846-5	SPRING, HINGE BAR	34
1	461264-1	PLATE, ID	124				33
2	4-21006-0	SCREW SKT. SET (8-32 X .25) HINGE PIN	123	1	690573-1	SPACER, SPRING	32
1	8-21007-5	SCREW SKT. SET (5/16-24 X .75) SPRING HOUSING	122	1	458582-1	MOUNT, DRAG	31
1	2-23030-1	SCREW, SKT. HD. CAP. (NYLOK) (6-32 X 25) C. P. DISC.	121	1	3-23354-8	STUD, DRAG	30
1	21009-2	SCREW SKT. SET (1/4-20 X .25) C. P. RAM	120	1	21030-7	MOUNT, PIN, DRAG	29
2	21017-2	SCR, DRIVE (#2 X .19) ID PLATE	119	1	690582-1	PIN, HINGE	28
1	2-21002-3	SCREW BTN HD. SKT. CAP (8-32 X .62) CRIMPER	118				27
1	1-22853-9	SCR SHLD. SLT. HD. (250 X 250) DRAG	117	1	463873-1	PLATE, BASE	26
3	2-22733-8	SCREW BTN HD. SKT. CAP (1/4-20 X .62) BLOCK, STABILIZER	116	1	691535-2	BAR, HINGE	25
4	2-22733-8	SCREW BTN HD. SKT. CAP (1/4-20 X .62) HOUSING	115	1	690571-1	BLOCK, STABILIZER	24
1	3-21000-4	SCREW FL HD. SKT. CAP (6-32 X .38) CAM	114	1	814222-2	BLOCK, PRESSURE	23
2	7-21000-6	SCREW SKT. HD. CAP (10-32 X 31) ANVIL MTG. PL.	113	1	7-22282-5	SPRING, DRAG	22
2	2-21000-8	SCREW SKT. HD CAP (8-32 X .62) DRAG MOUNT	112	1	458968-1	LEVER, DRAG	21
2	23030-4	SCREW SKT. HD CAP (6-32 X .50) NYLOK, SL BLADE	111	1	458960-2	DRAG, STOCK	20
1	3-21000-4	SCREW SKT. HD CAP (10-32 X .38) PIVOT BLOCK	110	1	691530-1	GUIDE, STRIP, REAR	19
4	2-22603-3	SCREW HEX HD CAP (8-32 X .62) FR STRIP GUIDE	109	1	691529-1	GUIDE, STRIP, FRONT	18
2	2-21000-8	SCREW SKT. HD CAP (8-32 X .62) REAR STRIP GUIDE	108	1	458978-1	BLOCK, SPRING	17
1	3-21000-9	SCREW SKT. HD CAP (10-32 X 1.00) DRAG	107	1	4-22284-9	SPRING, FEED RETURN	16
1	3-21000-0	SCREW SKT. HD CAP (8-32 X .37) FEED ROD GUIDE	106				15
2	2-21000-9	SCREW SKT. HD CAP (8-32 X .75) PRESS BLOCK	105				14
			104	1	692134-5	POSITIONER, TERMINAL	13
2	2-21000-9	SCREW SKT. HD CAP (8-32 X .75) DRAG	103	1	5-22280-5	SPRING, TERM, POSITIONER	12
4	3-21000-8	SCREW SKT. HD CAP (10-32 X .88) HSG. CAP	102	1	691525-1	PLATE, REAR SHEAR	11
3	2-21000-9	SCREW SKT. HD. CAP (10-32 X 1.00) CAM	101	1	691524-1	INSERT, ANVIL	10
1	457244-2	GUARD ASSEMBLY	80	1	690569-4	PLATE, FRONT SHEAR	9
		BRACKET, GUARD	79	1	691523-1	ANVIL	8
		AIR FEED ASSEMBLY	78	1	691522-1	BLADE, SLUG	7
1	694427-1	PLATE, APPLICATOR, MOUNTING	77	1	458608-1	SPACER, SLUG BLADE	6
			76	1	463874-1	PLATE, ANVIL MOUNTING	5
1	1-21002-7	SCR, BAC, 6-32 X .38	75				4
			74				3
			73				2
1	690603-1	SPRING, ASSIST	72	1	691531-1	CRIMPER, WIRE	1

TERM APPL SPEC 114-2078

CRIMPING DATA				THIS APPLICATOR WILL APPLY
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	61177-1
A	.072	12		61177-2
B	.062	14		
C	.056	16		
D	.052	18		
CRIMP	SIZE	TYPE	FEED	PRESS REF.
WIRE	.160	T.L.	.620	56S435-5
INSULATION	++	++		
INSULATION RANGE		WIRE RANGE	APPLICATOR INSTRUCTION	M
		18-12		
REMARKS AMP-O-LECTRIC PRE-FEED				

REV	DATE	DESCRIPTION	BY	CHK
M1	3/7/19	ECR-19-003701		
M	5-06	ECR-26-61177		
L	9-04	ECN 0150-1267-04		
K	7-92	ECN A-377392		
J	5-91	ECN A-304991		
H	11-76	REV PER ECN A-5616		
G	11-76	REV PER ECN		
F	2-8-77	REV PER ECN		
E	7-74	REV PER ECN		
D	8-73	REV PER ECN		
C	10-74	REV PER ECN		
B	2-73	REV PER ECN		
A	2-73	REV PER ECN		

SET UP GAGE LAYOUT NO.

DRAWN 5-9-73 APPROVED [Signature]

CHECKED 5-10-73 [Signature]

SCALE NONE NAME

AMP AMP INCORPORATED HARRISBURG, PENNA.

LOC A C NO. 1-686961-1

APPLICATOR, MINIATURE QUICK CHANGE HINGE BAR, E.F. (TAB LOK (RIGHT HAND))