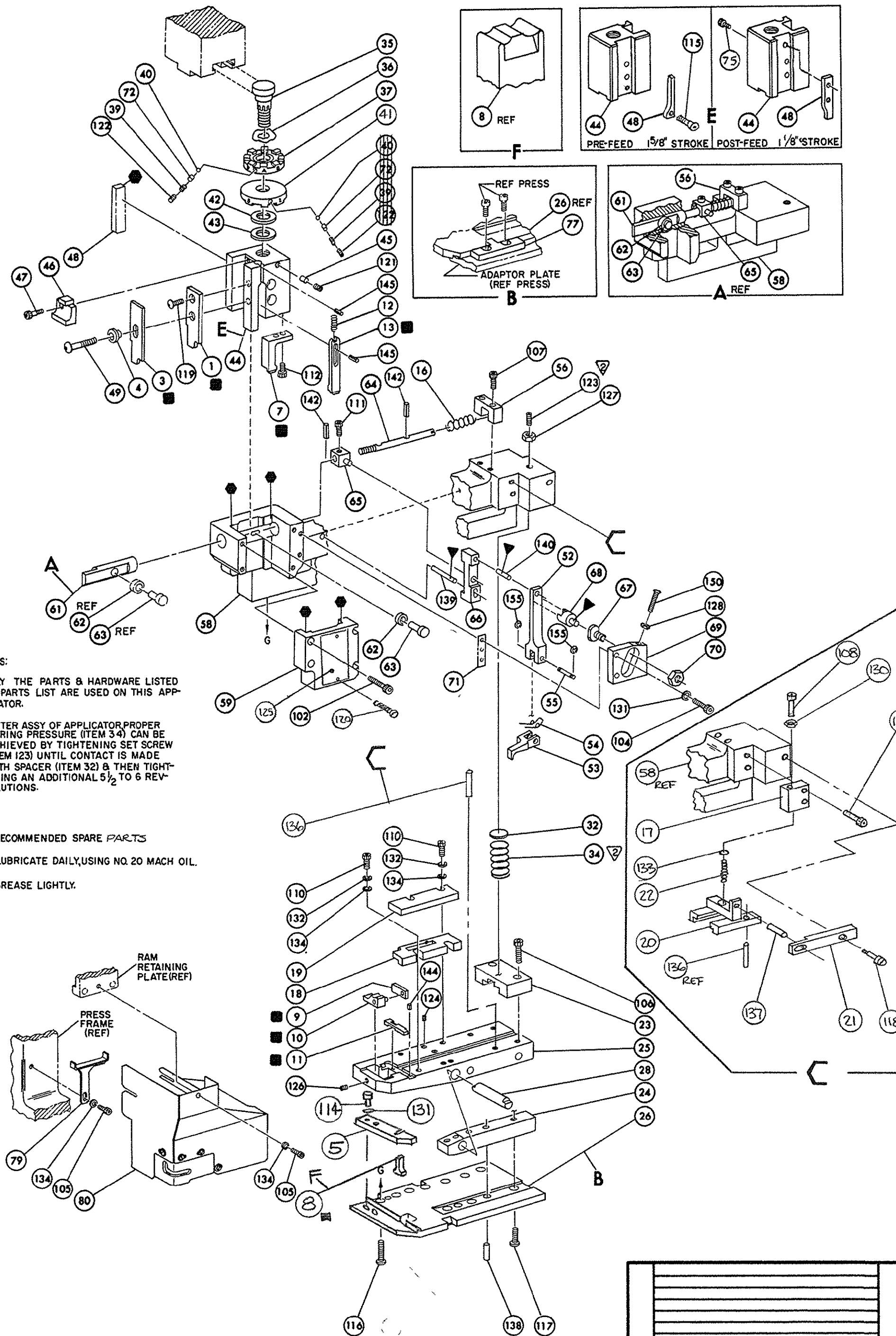


THIS IS A CONTROLLED DOCUMENT.



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.

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	1	240632-2	SCREW, ADJUSTMENT	64	
	155		1	240659-3	PIN, CAM ROLLER	63	
	154		1	240658-1	ROLLER, CAM	62	
	153		1	240631-1	ROD, FEED	61	
	152		1			60	
	151		1			59	
1	3-21064-1	SCREW RD. HD. MACH. (6-32 X 1.25) FEED ADJ.	1	455164-1	CAP, HOUSING	58	
	149		1	458984-1	HOUSING	57	
	148		1			56	
	147		1	458961-1	GUIDE, FEED ROD	55	
	146		1	240624-1	PIN, FEED FINGER	54	
2	4-21028-9	PIN SLOTTED SPRING (1/8 DIA X .38) RAM	1	691499-1	SPRING, FEED FINGER	53	
1	3-21028-2	PIN, SLOTTED SPRING (3/32 DIA X .25) REAR SHEAR PLATE	1	690584-5	FINGER, FEED	52	
	145		1	240634-1	LEVER, TERMINAL	51	
2	5-21028-1	PIN, SLOTTED SPRING (1/8 DIA X .50) SCREW ADJ. ROD	1			50	
	144		1			49	
	143		1			48	
1	1-21030-2	PIN, DOWEL (3/16 DIA X .62) LEVER	1	3-21002-5	BOLT, CRIMPER	47	
1	1-21030-6	PIN, DOWEL (3/16 DIA X 1.25) HOUSING	1	690696-1	CAM FEED 1/8 STROKE	46	
1	21029-5	PIN, SLOTTED (3/16 DIA X .75) BASE PLATE	1	22353-8	SCREW, SHOULDER	45	
1	21029-3	PIN, SLOTTED SPRING (.187 X .62 LG) DRAG	1			44	
2	1-21030-6	PIN, DOWEL (.187 X 1.25 DIA) DRAG	1	690191-1	RAM	43	
	142		1	691533-1	RAM	42	
	141		1	690125-1	WASHER, LAMINATED	41	
1	21899-3	WASHER, FLAT 1/4 GUARD	1	690124-4	WASHER, RAM	40	
1	21899-1	WASHER, FLAT (#6) DRAG STUD	1	690223-1	DISC, SPACER	39	
4	21024-4	WASHER, LOCK (#8) STRIP GUIDE	1	23241-6	BALL, STEEL	38	
4	21024-5	WASHER, LOCK (#10) FEED ADJ. PLATE & RET PLATE	1	690170-1	SPRING, DISC.	37	
1	21018-7	NUT, HEX (#10) DRAG	1	22480-5	WASHER, SPRING	36	
1	21022-3	NUT, HEX (SELF LOCKING) (#10-32) DRAG STUD	1			35	
1	21018-5	NUT, HEX MACH (6-32) FEED ADJ.	1			34	
1	1-22202-7	NUT HEX MACH (5/16-24) SPRING HOUSING	1	690212-1	POST, RAM	33	
	127		1	3-23846-5	SPRING, HINGE BAR	32	
1	21061-9	SCREW SKT. SET (8-32 X .25) ANVIL INSERT	1	690573-1	SPACER, SPRING	31	
1	461264-1	PLATE, ID	1	454589-1	MOUNT, DRAG	30	
2	4-21006-0	SCREW SKT. SET (8-32 X .25) HINGE PIN	1	3-22354-8	STUD, DRAG	29	
1	8-21007-5	SCREW SKT. SET (5/16-24 X .75) SPRING HOUSING	1	21030-7	MOUNT, PIN, DRAG	28	
1	2-23030-1	SCREW, SKT. HD. CAP. (NYLOK) (6-32 X 25) C. P. DISC.	1	117	463873-1	PLATE, BASE	27
1	21009-2	SCREW SKT. SET (1/4-20 X .25) C. P. RAM	1	116	691535-2	BAR, HINGE	26
2	21017-2	SCR, DRIVE (#2 X .19) ID PLATE	1	115	690571-1	BLOCK, STABILIZER	25
1	2-21002-3	SCREW BTN HD. SKT. CAP (8-32 X .62) CRIMPER	1	114	814222-2	BLOCK, PRESSURE	24
1	1-22853-9	SCR SHLD. SLT. HD. (250 X .250) DRAG	1	113	7-22282-5	SPRING, DRAG	23
3	2-22733-8	SCREW BTN HD. SKT. CAP (1/4-20 X .62) BLOCK, STABILIZER	1	112	458968-1	LEVER, DRAG	22
4	2-22733-8	SCREW BTN HD. SKT. CAP (1/4-20 X .62) HOUSING	1	111	458960-2	DRAG, STOCK	21
1	3-21000-4	SCREW FL HD. SKT. CAP (6-32 X .38) CAM	1	110	691530-1	GUIDE, STRIP, REAR	20
2	7-21000-6	SCREW SKT. CAP (10-32 X 31) ANVIL MTG. PL.	1	109	691529-1	GUIDE, STRIP, FRONT	19
2	2-21000-8	SCREW SKT. HD CAP (8-32 X .62) DRAG MOUNT	1	108	458978-1	BLOCK, SPRING	18
2	23030-4	SCREW SKT. HD CAP (6-32 X .50) NYLOK, SL BLADE	1	107	4-22284-9	SPRING, FEED RETURN	17
1	3-21000-4	SCREW SKT. HD CAP (10-32 X .38) PIVOT BLOCK	1	106			16
4	2-22603-3	SCREW HEX HD CAP (8-32 X .62) FR STRIP GUIDE	1	105			15
2	2-21000-8	SCREW SKT. HD CAP (8-32 X .62) REAR STRIP GUIDE	1	104	692134-5	POSITIONER, TERMINAL	14
1	3-21000-9	SCREW SKT. HD CAP (10-32 X 1.00) DRAG	1	103	5-22280-5	SPRING, TERM, POSITIONER	13
1	3-21000-0	SCREW SKT. HD CAP (8-32 X .37) FEED ROD GUIDE	1	102	691525-1	PLATE, REAR SHEAR	12
2	2-21000-9	SCREW SKT. HD CAP (8-32 X .75) PRESS BLOCK	1	101	691524-1	INSERT, ANVIL	11
1	21001-1	SCREW SKT. HD CAP (1/4-20 X .38) GUARD	1	80	690569-4	PLATE, FRONT SHEAR	10
2	3-21000-6	SCREW SKT. HD CAP (10-32 X .62) FEED PLATE	1	79	691523-1	ANVIL	9
2	221000-9	SCR SKT. HD. CAP (8-32 X .75) DRAG	1	78	691522-1	BLADE, SLUG	8
4	3-21000-8	SCREW SKT. HD CAP (10-32 X .88) HSG. CAP	1	77	455608-1	SPACER, SLUG BLADE	7
1	3-21000-9	SCREW SKT. HD CAP (10-32 X 1.00) CAM	1	76	463874-1	PLATE, ANVIL MOUNTING	6
1	457244-2	GUARD ASSEMBLY	1	75		SPACER TUBULAR, INSUL CRIMPER	5
		BRACKET, GUARD	1	74		CRIMPER, INSULATION	4
		AIR FEED ASSEMBLY	1	73			3
1	694427-1	PLATE, APPLICATOR, MOUNTING	1	72	691531-1	CRIMPER, WIRE	2
			1				1
1	1-21002-7	SCR, BAC, 6-32 X .38	1				
1	690603-1	SPRING, ASSIST	1				

TERM APPL SPEC 114-2078

CRIMPING DATA				THIS APPLICATOR WILL APPLY	
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH		
A	.072	12		61177-1	
B	.062	14		61177-2	
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					
— INACTIVE — FOR REPLACEMENT ONLY					
SET UP GAGE	LAYOUT NO.	AMP INCORPORATED HARRISBURG, PENNA.			
DRAWN 5-9-73	APPROVED	Loc A C No. 1-686961-1 M			
CHECKED S-10-73	REL.				
SCALE NONE	NAME	APPLICATOR, MINIATURE QUICK CHANGE HINGE BAR, E.F. (TAB LOK (RIGHT HAND))			

REV	DATE	DESCRIPTION	BY	CHK
A	5-06			
L	9-04			
K	7-92			
J	5-91			
H	11-76			
G	11-76			
F	2-77			
E	7-74			
D	8-73			
C	10-74			
B	8-73			
A	8-73			

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