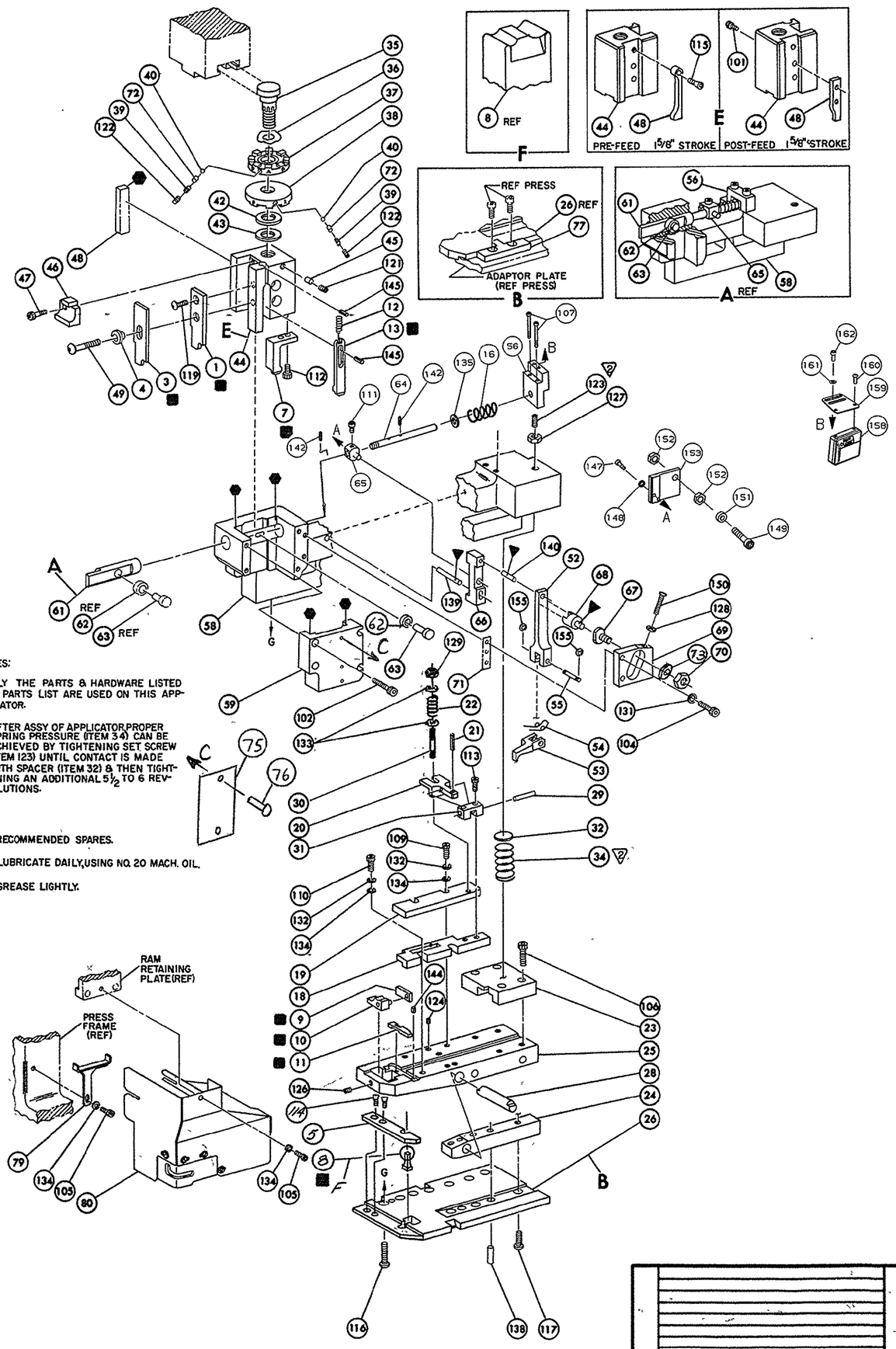

NOTES:

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

2. AFTER ASSY OF APPLICATOR, PROPER SPRING PRESSURE (ITEM 34) CAN BE ACHIEVED BY TIGHTENING SET SCREW (ITEM 123) UNTIL CONTACT IS MADE WITH SPACER (ITEM 32) & THEN TIGHTENING AN ADDITIONAL 5½ TO 6 REVOLUTIONS.

KEY:

■ - RECOMMENDED SPARES.

▼ - LUBRICATE DAILY, USING NO. 20 MACH. OIL.

⬢ - GREASE LIGHTLY.

REQ.	PART NO.	DESCRIPTION	NO.	REQ.	PART NO.	DESCRIPTION	NO.
2	2-21000-6	SCR, SHC (8-32 X .38)	162	1	690517-1	SPACER	71
2	18028-2	WASHER, FLAT (M4)	161	1	22594-8	NUT, HEX	70
2	994991-5	SCR, OVAL HD (M4-12)	160	1	240628-1	PLATE, ADJUSTMENT	69
1	1804303-1	BRACKET, COUNTER MTG	159	1	240626-1	SHAFT, PIVOT	68
1	1804300-1	APPLICATOR, COUNTER, ASSY	158	1	240633-1	BUSHING	67
			157	1	240630-1	LEVER, INTERMEDIATE	66
			156	1	1804317-1	BLOCK, PIVOT	65
2	21045-3	RING RET "C" (3/16 DIA) FEED PIN	155	1	1633286-1	SCREW, ADJUSTMENT	64
			154	1	240659-3	PIN, CAM ROLLER	63
1	1804318-1	BRACKET, MAGNET HOLDER	153	1	240658-1	ROLLER, CAM	62
2	22593-1	NUT, HEX JAM (1/4-20)	152	1	240631-1	ROD, FEED	61
1	1804310-1	MAGNET, RING	151				60
1	3-21064-1	SCREW RD. HD. MACH. (6-32 X 1.25) FEED ADJ.	150	1	455164-1	CAP, HOUSING	59
1	3-21081-2	SCR, SHC (1/4-20 X 1.00)	149	1	455162-1	HOUSING	58
2	21024-3	WASHER, LOCK (#6)	148				57
2	2-21000-0	SCR, SHC (6-32 X .50)	147	1	1804319-1	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	454568-1	FINGER, FEED	53
2	5-21028-1	PIN, SLOTTED SPRING (1/8 DIA X .50) SCREW ADJ. ROD	143	1	240634-1	LEVER, TERMINAL	52
			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	238015-1	CAM POST FEED 1 5/8 STROKE	48
1	21029-5	PIN, SLOTTED (3/16 DIA X .75) BASE PLATE	138	1	22353-8	SCREW, SHOULDER	47
			137	1	690578-1	BLOCK, INSUL ADJUSTMENT	46
			136	1	690191-1	PLUG, NYLON	45
1	21899-4	WASHER, FLAT	135	1	454574-1	RAM	44
—	21899-3	WASHER, FLAT 1/4 GUARD	134	1	690125-1	WASHER, LAMINATED	43
2	21899-2	WASHER, FLAT (#10) DRAG STUD	133	1	690124-4	WASHER, RAM	42
4	21024-4	WASHER, LOCK (#8) STRIP GUIDE	132				41
2	21024-5	WASHER, LOCK (#10) FEED ADJ. PLATE	131	2	23241-6	BALL, STEEL	40
			130	2	690170-1	SPRING, DISC.	39
1	21022-3	NUT HEX (SELF LOCKING) (10-32) DRAG STUD	129	1	690142-1	DISC., INSULATION	38
1	21068-5	NUT, HEX MACH (6-32) FEED ADJ.	128	1	8-690141-1	DISC., WIRE	37
1	1-22202-7	NUT HEX MACH (5/16-24) SPRING HOUSING	127	1	22480-5	WASHER, SPRING	36
1	21061-9	SCREW SKT. SET (8-32 X .25) ANVIL INSERT	126	1	690212-1	POST, RAM	35
			125	1	3-23846-5	SPRING, HINGE BAR	34
2	4-21006-0	SCREW SKT. SET (8-32 X .25) HINGE PIN	124				33
1	8-21007-5	SCREW SKT. SET (5/16-24 X .75) SPRING HOUSING	123	1	690573-1	SPACER, SPRING	32
2	23030-1	SCREW, SKT. HD. CAP. (NYLOK) (6-32 X 25) C.P. DISC.	122	1	454569-1	MOUNT, DRAG	31
1	21009-2	SCREW SKT. SET (1/4-20 X .25) C.P. RAM	121	1	1-22354-8	STUD, DRAG	30
			120	1	21030-2	MOUNT, PIN, DRAG	29
1	2-21002-1	SCREW BTN HD. SKT. CAP (8-32 X .38) CRIMPER	119	1	690582-1	PIN, HINGE	28
			118				27
3	3-21002-4	SCREW BTN HD. SKT. CAP (1/4-20 X .62) BLOCK, STABILIZER	117	1	684905-1	PLATE, BASE	26
4	2-22733-8	SCREW BTN HD. SKT. CAP (1/4-20 X .75) HOUSING	116	1	454579-3	BAR, HINGE	25
—	1-21003-9	SCREW FL HD. SKT. CAP (6-32 X .38) CAM (LOC. WELL)	115	1	690571-1	BLOCK, STABILIZER	24
2	7-21000-6	SCREW SKT. HD. CAP (#8-32 X .31) ANVIL REF. PL.	114	1	690585-1	BLOCK, PRESSURE	23
2	2-21000-8	SCREW SKT. HD CAP (8.32 X .62) DRAG MOUNT	113	1	8-22282-6	SPRING, DRAG	22
2	2-23657-1	SCREW SKT. HD CAP (8-32 X .62) NYLOK, SL BLADE	112	1	21030-6	LEVER, DRAG	21
1	3-21000-4	SCREW SKT. HD CAP (10-32 X .38) PIVOT BLOCK	111	1	454570-1	DRAG, STOCK	20
2	2-21000-7	SCREW SKT HD CAP (8-32 X .50) FR STRIP GUIDE	110	1	454573-1	GUIDE, STRIP, REAR	19
2	2-21000-8	SCREW SKT. HD CAP (8-32 X .62) REAR STRIP GUIDE	109	1	454571-1	GUIDE, STRIP, FRONT	18
			108				17
2	9-21000-3	SCREW SKT. HD CAP (8-32 X 2.0) FEED ROD GUIDE	107	1	4-22284-9	SPRING, FEED RETURN	16
4	2-21000-9	SCREW SKT. HD CAP (8-32 X .75) PRESS BLOCK	106				15
—	21001-1	SCREW SKT. HD CAP (1/4-20 X .38) GUARD	105				14
2	3-21000-6	SCREW SKT. HD CAP (10-32 X .62) FEED PLATE	104	1	692134-1	POSITIONER, TERMINAL ■	13
			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	454711-2	PLATE, REAR SHEAR ■	11
2	3-21000-9	SCREW SKT. HD. CAP (10-32 X 1.00) CAM	101	1	454709-2	INSERT, ANVIL ■	10
		GUARD ASSEMBLY	80	1	1-690569-0	PLATE, FRONT SHEAR ■	9
		BRACKET, GUARD	79	1	690575-1	ANVIL ■	8
		AIR FEED ASSEMBLY	78	1	454575-4	BLADE, SLUG ■	7
		PLATE, APPLICATOR, MOUNTING	77				6
2	21017-2	SCR, DR (#2 X .19) ID	76	1	684906-1	PLATE, ANVIL RETAINING	5
1	461264-1	PLATE, ID	75	1	690574-1	SPACER TUBULAR, INSUL CRIMPER	4
			74	1	690588-1	CRIMPER, INSULATION ■	3
1	458109-1	WASHER, SPECIAL	73				2
2	690603-1	SPRING, ASSIST	72	1	690587-1	CRIMPER, WIRE ■	1

TERM APPL SPEC 114-2078

CRIMPING DATA

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.070	12	
B	.060	14	
C	.054	16	
D	.050	18	

	SIZE	TYPE	FEED
CRIMP			
WIRE	.160	TAB	.770
INSULATION	.180	O	

INSULATION RANGE .110-.210 | WIRE RANGE 18-12 | APPLICATOR INSTRUCTION AI 8031

REMARKS: AMPOMATOR DO NOT EXCEED 80 C.P.M. WITH THIS APPLICATOR

THIS APPLICATOR WILL APPLY: 42284, 1742291

LTR	REVISION RECORD	ECN	DR	CK	DATE
E	ECR-06-011397		CE	GB	5-06
D	ECR 09-014110			MFE	11-05
C	EC A-361892			JEB LK	4-8-92
B	ECN A-331091	—		JH LK	9-91
A	ECN A-304991	—		MMB	5-91

SET UP GAGE: # | LAYOUT NO.: # | DRAWN: J. Harrington 11/16/88 | APPROVED | CHECKED: C. Curran 11/18/88 | REL.

AMP INCORPORATED HARRISBURG, PENNA.

LOC. A C | NO. 567303-1 | REV. E

SCALE NONE | NAME: APPLICATOR, MINIATURE QUICK CHANGE HINGE BAR, E.F. (.250 FLAG FASTON)

CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

CAGE CODE 00779

567303-1

THIS IS A CONTROLLED DOCUMENT.

THIS DRAWING IS UNPUBLISHED. COPYRIGHT 1999 BY AMP INCORPORATED. RELEASED FOR PUBLICATION 11. ALL RIGHTS RESERVED.

PRINT 96

3067 (11/71)