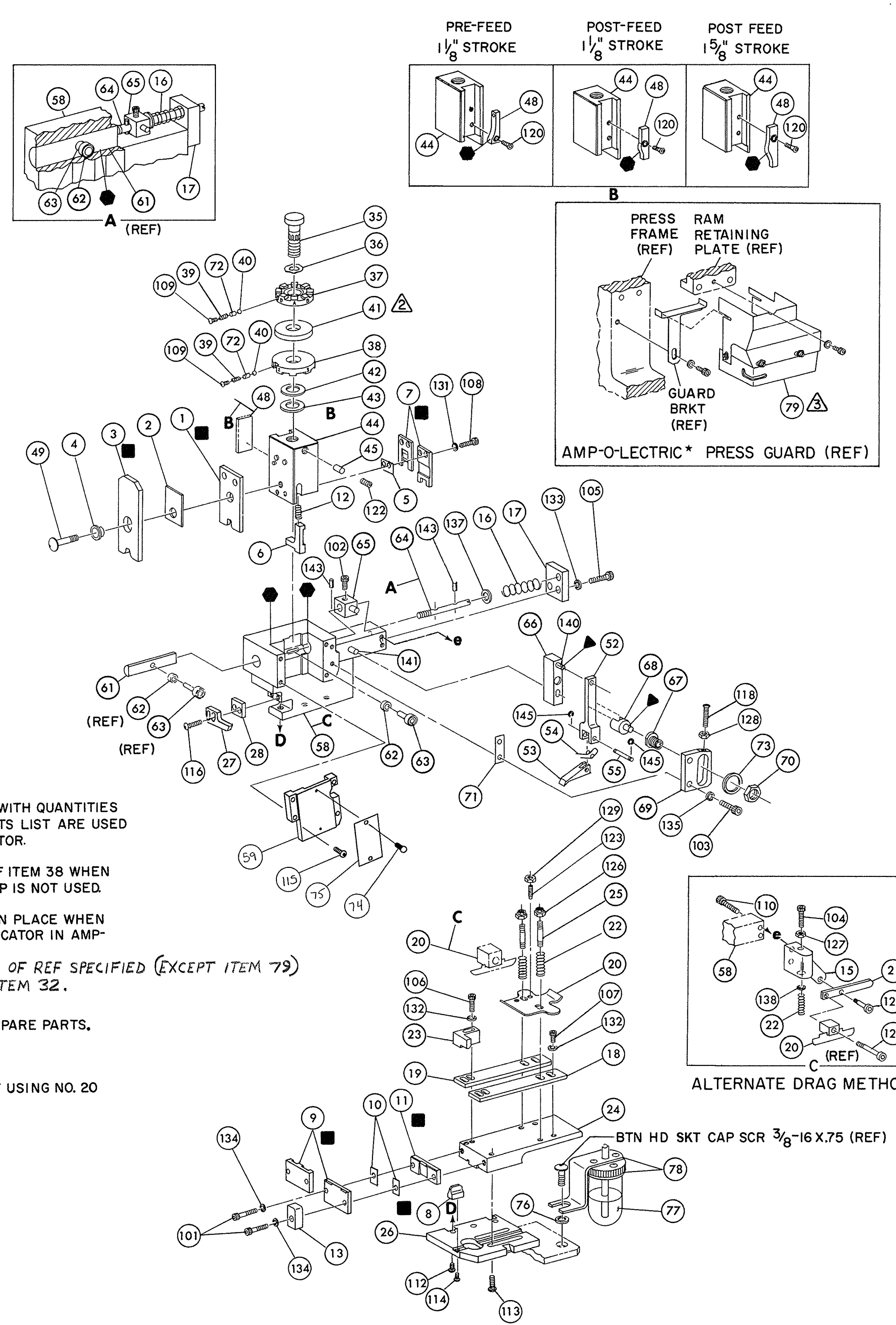


THIS IS A CONTROLLED DOCUMENT.



- NOTES:**
- 1. ONLY THE ITEMS WITH QUANTITIES SPECIFIED ON PARTS LIST ARE USED ON THIS APPLICATOR.
 - ⚠ USED IN PLACE OF ITEM 38 WHEN INSULATION CRIMP IS NOT USED.
 - ⚠ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-O-LECTRIC PRESS.
 - 4. PARTS WITH QTY. OF REF SPECIFIED (EXCEPT ITEM 79) ARE USED ON ITEM 32.
- KEY:**
- RECOMMENDED SPARE PARTS.
 - ▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.
 - GREASE LIGHTLY.

ALTERNATE DRAG METHOD

REF	QTY	PART NO	DESCRIPTION	ITEM NO	REF	QTY	PART NO	DESCRIPTION	ITEM NO
REF		21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	145	REF		454220-1	CAP, RAM	59
REF		5-21028-1	PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD	143	REF		453736-1	HOUSING	58
REF		1-21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	141	REF		240624-1	PIN, FEED FINGER	55
REF		1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	140	REF		691499-1	SPRING, FEED FINGER	54
REF		22260-5	WASHER, FLAT (NO 6) DRAG SPRING	138	REF		240635-1	FINGER, FEED	53
REF		21899-4	WASHER, FLAT (5/16 DIA) SCR ADJ	137	REF		240634-1	LEVER, TERMINAL	52
REF		21024-5	WASHER, LOCK (NO 10) FEED ADJ PLATE	135	1		7-21002-9	BOLT, CRIMPER	49
2		21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	134	1		690501-4	CAM, POST - FEED 1 5/8 STROKE	48
REF		21024-5	WASHER, LOCK (NO 10) FEED ROD GUIDE	133					47
4		21024-4	WASHER, LOCK (NO 8) STRIP GUIDE	132					46
2		21024-4	WASHER, LOCK (NO 8) SHEAR BLADE	131	1		690191-1	PLUG, NYLON	45
2		21018-4	NUT, HEX MACH (4-40) DRAG	130	1		455674-1	RAM	44
REF		21068-5	NUT, HEX MACH (6-32) FD ADJ PLATE	128	1		690125-1	WASHER, LAMINATED	43
REF		21018-7	NUT, HEX MACH (10-32) DRAG SPRING	127	1		690124-1	WASHER, RAM	42
2		21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	126	2		23241-6	SPACER, DISC	41
REF		5-21004-7	SCR, SKT HD SHLD (250 DIA X .25) DRAG ARM	125	2		690170-1	BALL, STEEL	40
REF		21004-5	SCR, SKT HD SHLD (250 DIA X 1.00) DRAG	124	1		690142-1	SPRING, COMPRESSION	39
2		4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	123	1		3-690141-9	DISC, INSULATION	38
1		21009-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	122	1		22480-5	DISC, WIRE	37
1		1-21002-7	SCR, BTN HD SKT CAP (6-32 X .38) CAM	120	1		690212-1	WASHER, SPRING	36
REF		3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	118	1			POST, RAM	35
2		2-21002-2	SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	116				APPLICATOR, BASIC (SUB ASSY)	32
REF		2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	115					31
1		22733-8	SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	114	1		3-690451-2	SPACER, STRIPPER	30
4		3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	113	1		240639-1	STRIPPER	29
REF		1-24073-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	112	REF		455676-1	PLATE, BASE	28
REF		2-21000-4	SCR, SKT HD CAP (6-32 X 1.00) DRAG ADAPTOR	110	2		22354-8	DRAG, STUD	27
2		23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	109	2		455678-1	PLATE, STRIP GUIDE	26
3		7-21000-7	SCR, SKT HD CAP (8-32 X .50) SHEAR BLADE	108	2		4-22281-1	PLATE, STRIP HOLD	25
3		7-21000-4	SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	107	2		240636-1	SPRING, DRAG	24
1		7-21000-4	SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	106	1		454177-1	LEVER, DRAG	23
REF		3-21000-7	SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE	105	1		458030-1	DRAG, STOCK	22
REF		3-21000-9	SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING	104	1		458031-1	GUIDE, STRIP (REAR)	21
REF		3-21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	103	REF		454178-1	GUIDE, STRIP (FRONT)	20
REF		3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	102	REF		4-22284-9	GUIDE, FEED ROD	19
2		3-21000-8	SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE	101	REF			SPRING, FEED RETURN	18
REF		455745-1	GUARD, WINDOW	79				ADAPTER, DRAG	17
REF		465184-9	LUBRICATOR ASSY	78					16
REF		852931-2	OIL, LUBRICATING	77					15
REF		454406-1	SPACER, LUB BRACKET	76					14
1		461264-1	PLATE, ID	75					13
2		21017-2	SCR, DRIVE (#2 X .19) ID PLATE	74					12
REF		458109-1	WASHER, FLAT (SPECIAL)	73	1		240644-1	SPACER, HOLD DOWN	11
2		690603-1	SPRING, ASSIST	72	1		690482-4	SPRING, HOLD DOWN	10
REF		690517-1	SPACER	71	1		2-461295-0	PLATE, REAR SHEAR	9
REF		22594-8	NUT, HEX	70	1		690474-4	SPACER, SHEAR PLATE	8
REF		240628-1	PLATE, ADJ	69	1		2-240641-9	PLATE, FRONT SHEAR	7
REF		240626-1	SHAFT, PIVOT	68	1		238009-1	ANVIL	6
REF		240633-1	BUSHING	67	1		6-456134-2	BLADE, SLUG	5
REF		455680-1	LEVER, INTERMEDIATE	66	1		455888-4	HOLD DOWN, TERMINAL	4
REF		240629-1	BLOCK, PIVOT	65	1		456423-2	SPACER, SHEAR BLADE	3
REF		240632-2	SCREW, ADJ	64	1			SPACER, TUBULAR	2
REF		240659-3	PIN, CAM ROLLER	63	1			SPACER, INSULATION	1
REF		240658-1	CAM, ROLLER	62	1			CRIMPER, INSULATION	
REF		454398-1	ROD, FEED	60	1			CRIMPER, WIRE	

CRIMPING DATA				APPLICATOR WILL APPLY	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	350199	
A	.082	14			
B	.078	(2) 18			
C	.075	16			
D	.070	18			
CRIMP	SIZE	TYPE	FEED	APPL INST	
WIRE	.120	F			
INSUL	.220	F	.855	A1 8039	
WIRE RANGE	18-14	INSULATION RANGE	.120-.175	PRESS NO	
REMARKS AMPOMATOR POST - FEED					
I.D. PLATE (REF): 461264-1					

REMARKS	NO	REV
APPL USED ON MACHINE PART NO	MACH SERIAL NO	TO APPLY TERMINAL SPEC 114-2084
CUSTOMER NAME	APPL SERIAL NO	DISTRIBUTION
ADDRESS	PURCHASE ORDER	ORIGINAL
CITY	ENG APP	CUSTOMER COPY
		FIELD ENG COPY

REV	DATE	DESCRIPTION	APP'D	CHK'D	REL	LOC	NO	REV
D	ECN 0150-0243-04	11/18/82						
C	PER ECN 272190	10/10/80						
B	ECN A161988	11/28/78						
A	REV PER ECN R-5303	12/11/78						