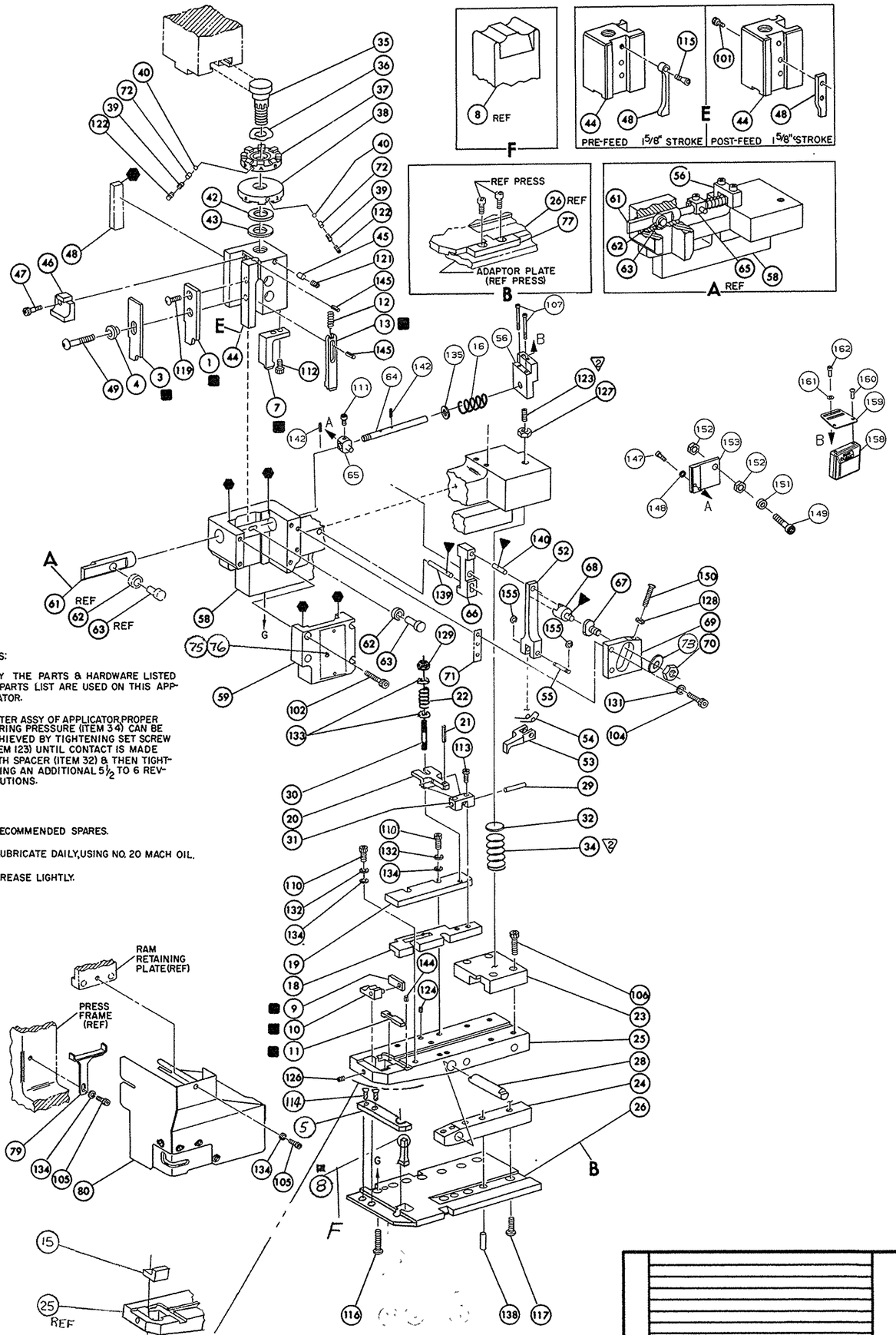

NOTES:

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.

QTY	PART NO.	DESCRIPTION	ITEM NO.
2	2-21000-6	SCR, SHC (8-32 x .38)	162
2	18028-2	WASHER, FLAT (M4)	161
2	994991-5	SCR, OVAL HD (M4 x 12)	160
1	1864303-1	BRACKET, COUNTER MT6	159
1	1804300-1	APPLICATOR COUNTER ASSY	158
			157
			156
2	21045-3	RING RET "C" (3/16 DIA) FEED PIN	155
			154
1	1804318-1	BRACKET, MAGNET HOLDER	153
2	22593-1	NUT, HEX JAM (1/4-20)	152
1	1804310-1	MAGNET, RING	151
1	3-21064-1	SCREW RD. HD. MACH. (6-32 X 1.25) FEED ADJ.	150
1	3-21081-2	SCR, SHC (1/4-20 X 1.00)	149
2	21024-3	WASHER, LOCK (#6)	148
2	2-21000-0	SCR, SHC (6-32 X .50)	147
			146
2	4-21028-9	PIN SLOTTED SPRING (1/8 DIA X .38) RAM	145
1	3-21028-2	PIN, SLOTTED SPRING (3/32 DIA X .25) REAR SHEAR PLATE	144
			143
2	5-21028-1	PIN, SLOTTED SPRING (1/8 DIA X .50) SCREW ADJ. ROD	142
			141
1	1-21030-2	PIN, DOWEL (3/16 DIA X .62) LEVER	140
1	1-21030-6	PIN, DOWEL (3/16 DIA X 1.25) HOUSING	139
1	1-21029-5	PIN, SLOTTED (3/16 DIA X .75) BASE PLATE	138
			137
			136
1	21899-4	WASHER, FLAT (5/16)	135
—	21899-3	WASHER, FLAT 1/4 GUARD	134
2	21899-2	WASHER, FLAT (#10) DRAG STUD	133
4	21024-4	WASHER, LOCK (#8) STRIP GUIDE	132
2	21024-5	WASHER, LOCK (#10) FEED ADJ. PLATE	131
			130
1	21022-3	NUT HEX (SELF LOCKING) (10-32) DRAG STUD	129
1	21068-5	NUT, HEX MACH (6-32) FEED ADJ.	128
1	1-22202-7	NUT HEX MACH (5/16-24) SPRING HOUSING	127
1	21061-9	SCREW SKT. SET (8-32 X .25) ANVIL INSERT	126
			125
2	4-21006-0	SCREW SKT. SET (8-32 X .25) HINGE PIN	124
1	8-21007-5	SCREW SKT. SET (5/16-24 X .75) SPRING HOUSING	123
2	23030-1	SCREW, SKT. HD. CAP. (NYLOK) (6-32 X 25) C. P. DISC.	122
1	21009-2	SCREW SKT. SET (1/4-20 X .25) C. P. RAM	121
			120
1	2-21002-1	SCREW BTN HD. SKT. CAP (8-32 X .38) CRIMPER	119
1	1-21000-5	SCREW, SKT. HD. CAP (4-40 x .50) INSERT	118
3	3-21002-4	SCREW BTN HD. SKT. CAP (1/4-20 X .62) BLOCK, STABILIZER	117
4	2-22733-8	SCREW BTN HD. SKT. CAP (1/4-20 X .62) HOUSING (LOC. WELL)	116
—	1-21003-9	SCREW FL HD. SKT. CAP (6-32 X .38) CAM	115
2	7-21000-6	SCREW FL HD. SKT. CAP (10-32 x .31) ANVIL MTG. PL.	114
2	2-21000-8	SCREW SKT. HD CAP (8.32 X .62) DRAG MOUNT	113
2	1-23030-1	SCREW SKT. HD CAP (8-32 X .62) NYLOK, SL BLADE	112
1	3-21000-4	SCREW SKT. HD CAP (10-32 X .38) PIVOT BLOCK	111
4	2-22663-3	SCREW HEX HD CAP (8-32 X .50) FR STRIP GUIDE	110
~~2~~	~~2-21000-8~~	~~SCREW SKT. HD CAP (8-32 X .62) REAR STRIP GUIDE~~	109
			108
2	9-21000-3	SCREW SKT. HD CAP (8-32 X 2.0) FEED ROD GUIDE	107
4	2-21000-9	SCREW SKT. HD CAP (8-32 X .75) PRESS BLOCK	106
—	21001-1	SCREW SKT. HD CAP (1/4-20 X .38) GUARD	105
2	3-21000-6	SCREW SKT. HD CAP (10-32 X .62) FEED PLATE	104
			103
4	3-21000-8	SCREW SKT. HD CAP (10-32 X .88) HSG. CAP	102
2	3-21000-9	SCREW SKT. HD. CAP (10-32 X 1.00) CAM	101
		GUARD ASSEMBLY	80
		BRACKET, GUARD	79
		AIR FEED ASSEMBLY	78
		PLATE, APPLICATOR, MOUNTING	77
2	21017-2	SCR, DRIVE (#2 X .19)	76
1	461264-1	PLATE, ID	75
			74
1	458109-1	WASHER, SPECIAL	73
2	690603-1	SPRING, ASSIST	72

QTY	PART NO.	DESCRIPTION	ITEM NO.
1	690517-1	SPACER	71
1	22594-8	NUT, HEX	70
1	240628-1	PLATE, ADJUSTMENT	69
1	240626-1	SHAFT, PIVOT	68
1	240633-1	BUSHING	67
1	240630-1	LEVER, INTERMEDIATE	66
1	1804317-1	BLOCK, PIVOT	65
1	1633286-1	SCREW, ADJUSTMENT	64
1	240659-3	PIN, CAM ROLLER	63
1	240658-1	ROLLER, CAM	62
1	240631-1	ROD, FEED	61
			60
1	455164-1	CAP, HOUSING	59
1	455162-1	HOUSING	58
			57
1	1804319-1	GUIDE, FEED ROD	56
1	240624-1	PIN, FEED FINGER	55
1	691499-1	SPRING, FEED FINGER	54
1	454568-3	FINGER, FEED	53
1	240634-1	LEVER, TERMINAL	52
			51
			50
1	3-21002-5	BOLT, CRIMPER	49
1	238015-1	CAM POST FEED 15/8 STROKE	48
1	22353-8	SCREW, SHOULDER	47
1	690578-1	BLOCK, INSUL ADJUSTMENT	46
1	690191-1	PLUG, NYLON	45
1	454574-1	RAM	44
1	690125-1	WASHER, LAMINATED	43
1	690124-4	WASHER, RAM	42
			41
2	23241-6	BALL, STEEL	40
2	690170-1	SPRING, DISC.	39
1	690142-1	DISC., INSULATION	38
1	8-690141-1	DISC., WIRE	37
1	22480-5	WASHER, SPRING	36
1	690212-1	POST, RAM	35
1	3-23846-5	SPRING, HINGE BAR ⚠2	34
			33
1	690573-1	SPACER, SPRING	32
1	454569-1	MOUNT, DRAG	31
1	1-22354-8	STUD, DRAG	30
1	21030-2	MOUNT, PIN, DRAG	29
1	690582-1	PIN, HINGE	28
			27
1	684905-1	PLATE, BASE	26
1	354679-1	BAR, HINGE	25
1	690571-1	BLOCK, STABILIZER	24
1	690585-1	BLOCK, PRESSURE	23
1	8-22282-6	SPRING, DRAG	22
1	21030-6	LEVER, DRAG	21
1	454570-1	DRAG, STOCK	20
1	454573-1	GUIDE, STRIP, REAR	19
1	454571-5	GUIDE, STRIP, FRONT	18
			17
1	4-222849	SPRING, FEED RETURN	16
1	354678-1	INSERT, TERMINAL POSITIONER	15
1	455279-3	POSITIONER, TERMINAL ■	13
1	5-22280-5	SPRING, TERM, POSITIONER	12
1	454712-2	PLATE, REAR SHEAR ■	11
1	454709-1	INSERT, ANVIL ■	10
1	690569-1	PLATE, FRONT SHEAR ■	9
1	690575-1	ANVIL ■	8
1	454572-1	BLADE, SLUG ■	7
			6
1	684906-1	PLATE, ANVIL MOUNTING	5
1	690574-1	SPACER TUBULAR, INSUL CRIMPER	4
1	690588-1	CRIMPER, INSULATION ■	3
			2
1	690587-1	CRIMPER, WIRE ■	1

CRIMPING DATA

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.072	12	
B	.062	14	
C	.056	16	
D	.052	18	

	SIZE	TYPE	FEED	WIRE STRIP LENGTH
CRIMP WIRE	.160	TAB CODE	.480	
INSULATION	.180	0		

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION
.110-.210	18-12	A 80031

REMARKS

AMPOMATOR

DO NOT EXCEED 80 C.P.M. WITH THIS APPLICATOR

THIS APPLICATOR WILL APPLY	
SPADE	RING
41887	41892
41888	41893
41889	41894
42188	42189
42226	42190
42187	42191
60976	42851
61902	42903
63053	62621
	63262

APPL SPEC 114-2078

LTR	REVISION RECORD	ECN	DR	CK	DATE
M	ECN A-36592	—	JW	RC	4-92
L	ECN A-304991	—	MD	TD	5-91
K	ECN A170585	—	NE	CK	12-88
J1	REV PER ECN R-5094		MD	TD	5-87
J	REV PER R-4287		CEM		1-87
H3	REV PER ECN	P	3708	TW	9/8/80
H2	REV PER ECN	P	3174	RB	9-579
H1	ADD ITEM 62621	R	2055	MD	5-577
H	REV PER ECN	R	1254	TB	8-75
G	REV PER ECN ITEM 114	R	1117	BM	5-75
F	REV. PER ECN	L	9720	TW	5-573
E	REV. PER ECN	L	9484	TW	1-30-73
D	SUPERSEDED REDRAWN		4925	TW	12/21/72
	W/ CHANGES				
J	ECR-06-002569	M/E	2-06		
S	ECR 05-014110	M/E	11-05		
R	ECN 0150-1331-02	M/E	10-02		
P	0150-6274-95	M/E	7-95		
N	ECN 0150-4232-93	—	1-93		

LTR	REVISION RECORD	ECN	DR	CK	DATE

SET UP GAGE	LAYOUT NO.	AMP	AMP INCORPORATED HARRISBURG, PENNA.
DRAWN Fogarty 12/21/72	APPROVED Ken Rawe 1-2-73		
CHECKED C. Miller 1/3/73	REL. Marilyn 1.2.73	LOC A C	NO. 687393-1 REV. J
SCALE NONE	NAME APPLICATOR, MINIATURE QUICK CHANGE HINGE BAR, E.F. (FLAG SPADE & RING)		

GAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

687393-1

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