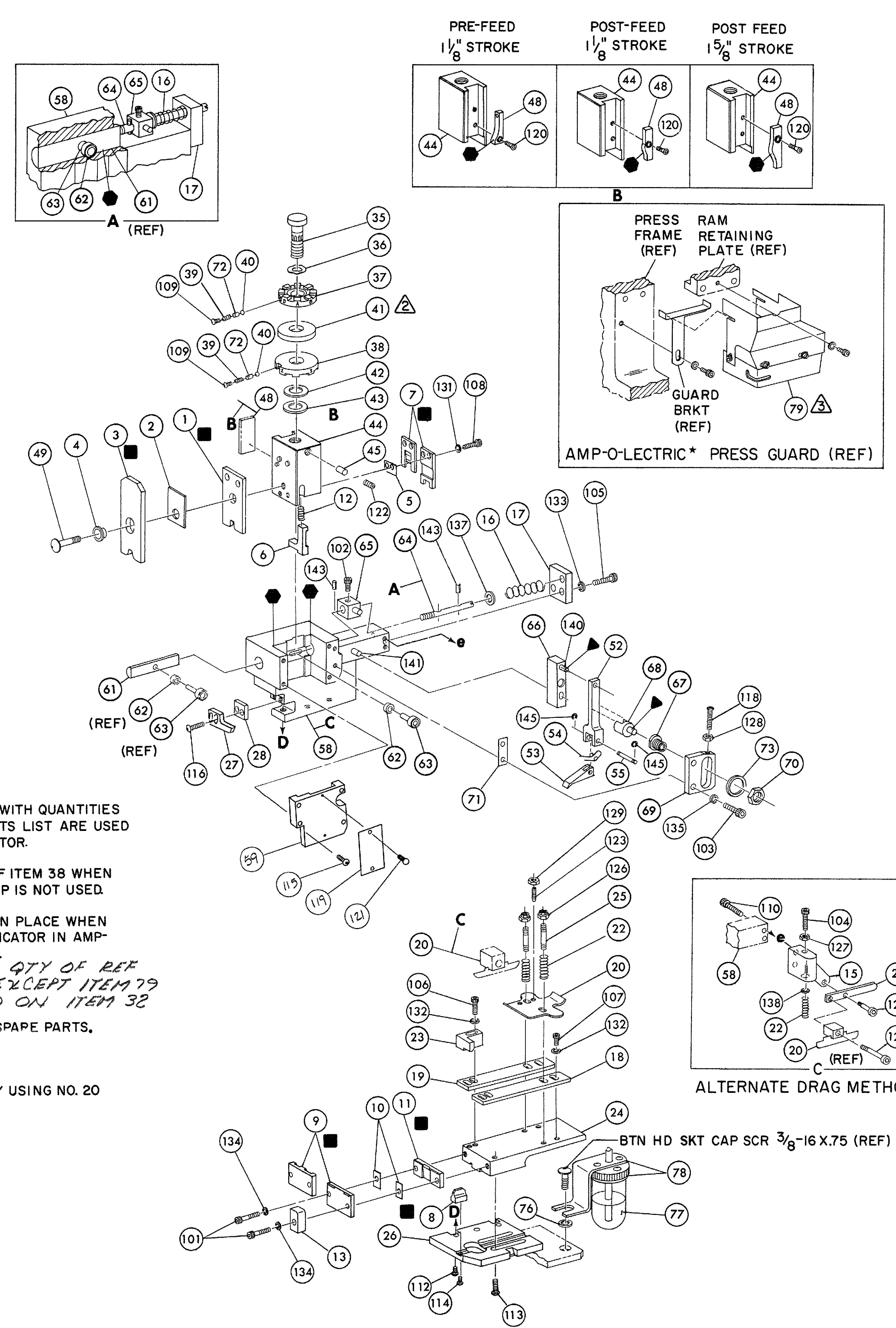


THIS DRAWING IS A CONTROLLED DOCUMENT.



NOTES:

- I 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.
- A PARTS WITH QTY OF REF SPECIFIED EXCEPT ITEM 79 KEY: ARE USED ON ITEM 32
- RECOMMENDED SPAPE PARTS.
- ▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- GREASE LIGHTLY.

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	144	REF	453736-1	HOUSING	58
REF	1-21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	142				57
REF	1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	141	REF	240624-1	PIN, FEED FINGER	55
			140	REF	691999-1	SPRING, FEED FINGER	54
			139	REF	240635-1	FINGER, FEED	53
			138	REF	240634-1	LEVER, TERMINAL	52
			137				51
			136				50
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	690501-3	CAM, POST FEED 1/8 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
			130	1	455674-2	RAM	44
2	21018-4	NUT, HEX MACH (4-40) DRAG	129	1	690125-1	WASHER, LAMINATED	43
REF	21068-5	NUT, HEX MACH (6-32) FD ADJ PLATE	128	1	690124-1	WASHER, RAM	42
			127				41
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	126	2	23241-6	BALL, STEEL	40
			125	2	690170-1	SPRING, COMPRESSION	39
			124	1	690142-1	DISC, INSULATION	38
2	4-21078-8	SCR, SKT HD SHLD (250 DIA X 1.00) DRAG	123	1	7-690141-7	DISC, WIRE	37
1	21009-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	122	1	22480-5	WASHER, SPRING	36
2	21017-2	SCR, DRIVE (#2 X .19) ID PLATE	121	1	690212-1	POST, RAM	35
1	1-21002-7	SCR, BTN HD SKT CAP (6-32 X .38) CAM	120				34
1	461264-1	PLATE, ID	119				33
REF	3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	118	1	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
			117				31
			116				30
1	7-21002-2	SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	115				29
REF	2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	114	1	3-690451-2	SPACER, STRIPPER	28
1	22733-8	SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	114	1	240639-1	STRIPPER	27
4	3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	113	1	455676-1	PLATE, BASE	26
REF	2-22733-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	112	REF	22354-8	DRAG, STUD	25
			111	2	455678-1	PLATE, STRIP GUIDE	24
			110	1		PLATE, STRIP HOLD	23
2	23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	109				22
2	7-21000-4	SCR, SKT HD CAP (8-32 X .31) SHEAR BLADE	108	2	4-22281-1	SPRING, DRAG	21
3	7-21000-4	SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	107		240636-1	LEVER, DRAG	20
1	7-21000-4	SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	106	1	459177-1	DRAG, STOCK	19
REF	3-21000-7	SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE	105	1	1-458030-2	GUIDE, STRIP (REAR)	18
			104	1	1-458031-2	GUIDE, STRIP (FRONT)	17
REF	3-21000-9	SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING	104	REF	454178-1	GUIDE, FEED ROD	16
REF	3-21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	103	REF	4-22284-9	SPRING, FEED RETURN	15
REF	3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	102	REF		ADAPTER, DRAG	14
2	3-21000-8	SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE	101				13
REF	455745-1	GUARD, WINDOW	79				12
			78				11
			77				10
			76	1	240644-1	SPACER, HOLD DOWN	9
			75				8
			74	1	690482-1	SPRING, HOLD DOWN	7
REF	458109-1	WASHER, FLAT (SPECIAL)	73	1	461295-3	PLATE, REAR SHEAR	6
2	690603-1	SPRING, ASSIST	72	1	690474-2	SPACER, SHEAR PLATE	5
REF	690517-1	SPACER	71				4
			70	1	3-240641-9	HOLD DOWN, TERMINAL	3
			69	1	238009-1	SPACER, SHEAR BLADE	2
			68	1	6-456134-1	SPACER, TUBULAR	1
			67	1	455888-1	CRIMPER, INSULATION	
			66	1	456409-2	SPACER, INSULATION	
			65			CRIMPER, WIRE	
			64				
			63				
			62				
			61				
			60				
REF	454398-1	CAM, ROLLER	60				

CRIMPING DATA				APPLICATOR WILL APPLY	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH		
A	.072	16			60735
B	.066	18			61386
C	.063	20			61764
D	NOT USED				63013
CRIMP	SIZE	TYPE	FEED	APPL INST	
WIRE	120	"F"	.505	A1 8039	
INSUL	180	"F"			
WIRE RANGE	16-20	INSULATION RANGE	.090-135	PRESS NO	565435-5

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

REV	DESCRIPTION	DATE	BY	APP'D
F	0150-9079-99	1/99	U/AY	SET UP GAGE 10-1
E	0150-8905-36	10/98	LAC	458638-1 B11
D	ECN A-393592	9-92	JH/IB	DR
C	ECN A-153588	11-88	MD/AC	APP-21-X
B	REV PER ECN R-3491	10/88	MD/AC	1/1/88
A	REV PER ECN R-3468	3-88	MD/AC	CHK 4/76
	REV ITEM 37 PER R-2391	1/78	MD/AC	2/88