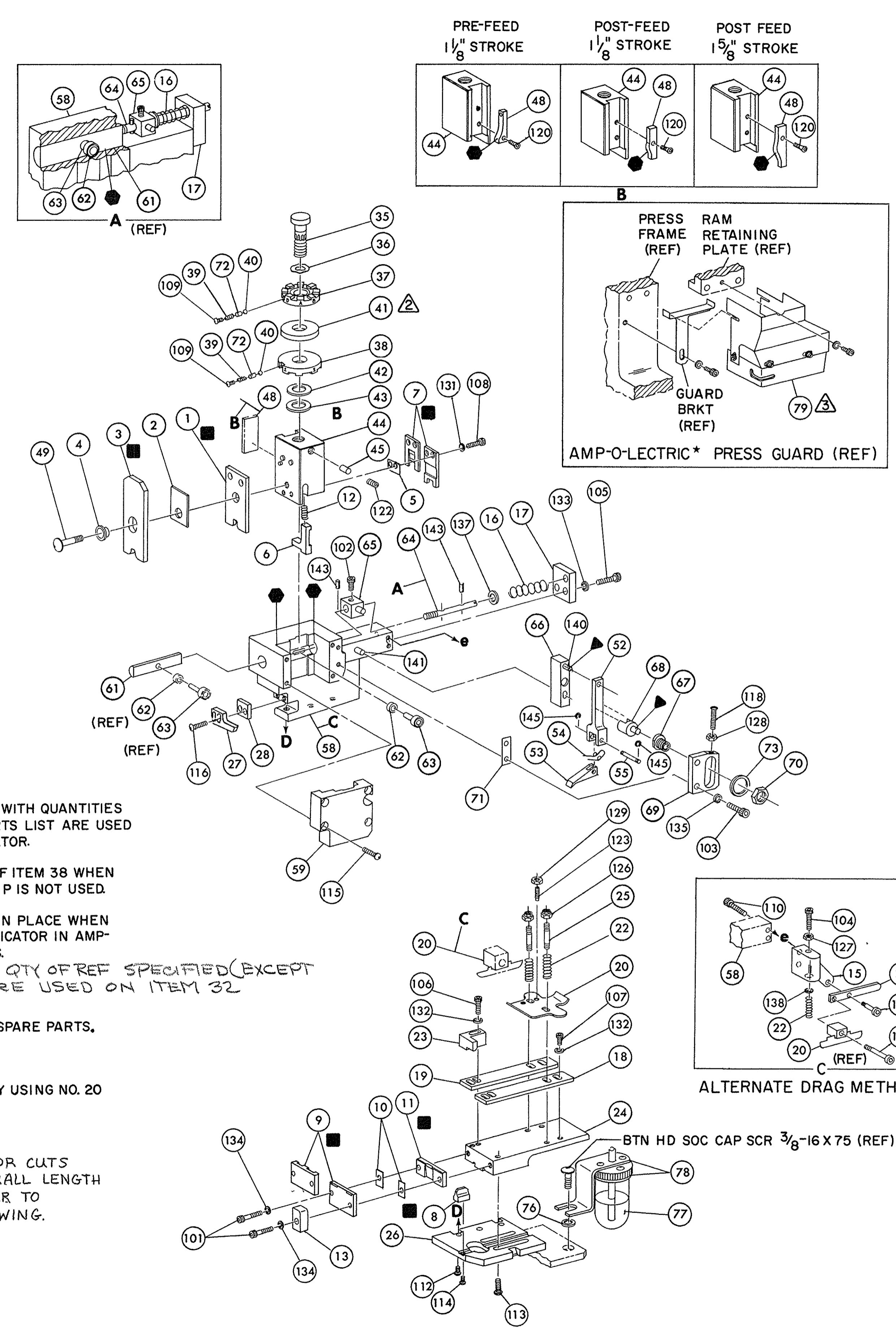


THIS DRAWING IS A CONTROLLED DOCUMENT



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. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEM 72) ARE USED ON ITEM 32.
- KEY:**
- RECOMMENDED SPARE PARTS.
 - ▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.
 - GREASE LIGHTLY.
5. THIS APPLICATOR CUTS TERMINAL OVERALL LENGTH TO .578. REFER TO TERMINAL DRAWING.

ALTERNATE DRAG METHOD

REF	QTY	PART NO	DESCRIPTION	ITEM NO
REF		21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	145
REF		5-21028-1	PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD	143
REF		1-21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	141
REF		1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	140
REF		22260-5	WASHER, FLAT (NO 6) DRAG SPRING	138
REF		21899-4	WASHER, FLAT (5/16 DIA) SCR ADJ	137
REF		21024-5	WASHER, LOCK (NO 10) FEED ADJ PLATE	135
REF		21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	134
REF		21024-5	WASHER, LOCK (NO 10) FEED ROD GUIDE	133
REF		21024-4	WASHER, LOCK (NO 8) STRIP GUIDE	132
REF		21024-4	WASHER, LOCK (NO 8) SHEAR BLADE	131
REF		21018-4	NUT, HEX MACH (4-40) DRAG	129
REF		21068-5	NUT, HEX MACH (6-32) FD ADJ PLATE	128
REF		21018-7	NUT, HEX MACH (10-32) DRAG SPRING	127
REF		21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	126
REF		5-21004-7	SCR, SKT HD SHLD (250 DIA X .25) DRAG ARM	125
REF		21004-5	SCR, SKT HD SHLD (250 DIA X 1.00) DRAG	124
REF		4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	123
REF		21009-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	122
REF		2-21003-0	SCR, FLAT HD SKT CAP (6-32 X .50) CAM	120
REF		3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	118
REF		2-21002-2	SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	116
REF		2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	115
REF		22733-8	SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	114
REF		3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	113
REF		1-24073-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	112
REF		2-21000-4	SCR, SKT HD CAP (6-32 X 1.00) DRAG ADAPTOR	110
REF		23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	109
REF		2-21000-9	SCR, SKT HD CAP (8-32 X .75) SHEAR BLADE	108
REF		7-21000-4	SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	107
REF		2-21000-8	SCR, SKT HD CAP (8-32 X .62) STRIP GUIDE	106
REF		3-21000-7	SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE	105
REF		3-21000-9	SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING	104
REF		3-21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	103
REF		3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	102
REF		3-21000-8	SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE	101
REF		455745-1	GUARD, WINDOW	79
REF		465184-9	LUBRICATOR ASSY	78
REF		455985-1	OIL, LUBRICATING	77
REF		454406-1	SPACER, LUB BRACKET	76
REF		458109-1	WASHER, FLAT (SPECIAL)	73
REF		690603-1	SPRING, ASSIST	72
REF		690517-1	SPACER	71
REF		22594-8	NUT, HEX	70
REF		240628-1	PLATE, ADJ	69
REF		240626-1	SHAFT, PIVOT	68
REF		240633-1	BUSHING	67
REF		455680-1	LEVER, INTERMEDIATE	66
REF		240629-1	BLOCK, PIVOT	65
REF		240632-2	SCREW, ADJ	64
REF		240659-3	PIN, CAM ROLLER	63
REF		240658-1	CAM, ROLLER	62
REF		454398-1	ROD, FEED	61
REF		454220-1	CAP, RAM	59
REF		453736-1	HOUSING	58
REF		240624-1	PIN, FEED FINGER	55
REF		691489-1	SPRING, FEED FINGER	54
REF		240635-1	FINGER, FEED	53
REF		240634-3	LEVER, TERMINAL	52
REF		7-21002-9	BOLT, CRIMPER	49
REF		690602-5	CAM, PRE FEED 1/8 STROKE	48
REF		690191-1	PLUG, NYLON	45
REF		455674-1	RAM	44
REF		690125-1	WASHER, LAMINATED	43
REF		690124-1	WASHER, RAM	42
REF		690223-1	SPACER, DISC	41
REF		23241-6	BALL, STEEL	40
REF		690170-1	SPRING, COMPRESSION	39
REF		22480-5	DISC, INSULATION	38
REF		690212-1	DISC, WIRE	37
REF		22480-5	WASHER, SPRING	36
REF		690212-1	POST, RAM	35
REF		458980-2	APPLICATOR, BASIC (SUB ASSY)	32
REF		3-21002-2	SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	31
REF		2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	29
REF		22733-8	SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	28
REF		3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	27
REF		1-24073-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	26
REF		22354-8	DRAG, STUD	25
REF		455678-5	PLATE, STRIP GUIDE	24
REF		240825-1	PLATE, STRIP HOLD	23
REF		4-22281-1	SPRING, DRAG	22
REF		240636-1	LEVER, DRAG	21
REF		454177-1	DRAG, STOCK	20
REF		454204-1	GUIDE, STRIP (REAR)	19
REF		454204-1	GUIDE, STRIP (FRONT)	18
REF		454178-1	GUIDE, FEED ROD	17
REF		4-22284-9	SPRING, FEED RETURN	16
REF			ADAPTER, DRAG	15
REF			SPACER, HOLD DOWN	14
REF			SPRING, HOLD DOWN	13
REF			PLATE, REAR SHEAR	12
REF			SPACER, SHEAR PLATE	11
REF			PLATE, FRONT SHEAR	10
REF			ANVIL	9
REF			BLADE, SLUG	8
REF			HOLD DOWN, TERMINAL	7
REF			SPACER, SHEAR BLADE	6
REF			SPACER, TUBULAR	5
REF			CRIMPER, INSULATION	4
REF			SPACER, INSULATION	3
REF			CRIMPER, WIRE	2
REF				1

CRIMPING DATA					APPLICATOR WILL APPLY	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH			
A	.095	COMMON				61248-W
B	NOT USED					
C	NOT USED					
D	NOT USED					

CRIMP	SIZE	TYPE	FEED	APPL INST
WIRE	4	4	.950	A18039
INSUL	.110	0		

WIRE RANGE: 20-18 INSULATION RANGE: .065-.080 PRESS NO: 665435-5

REMARKS: AMP-O-LECTRIC PRE FEED

SPL. FOR MOTOROLA (CHK SLUG BLADE & FLAT ANVIL)

REMARKS	NO	REV
APPL USED ON MACHINE PART NO	MACH SERIAL NO	DISTRIBUTION
CUSTOMER NAME	APPL SERIAL NO	ORIGINAL
ADDRESS	PURCHASE ORDER	CUSTOMER COPY
CITY	ENG APP	FIELD ENG COPY

REV	DATE	DESCRIPTION	APP	DATE
1	0150-8514-98	REV PER ECN R-7586		
2	0150-8514-98	REV PER ECN R-3484		
3	0150-8514-98	REV PER ECN R-1790		
4	0150-8514-98	REV PER ECN R-1547		