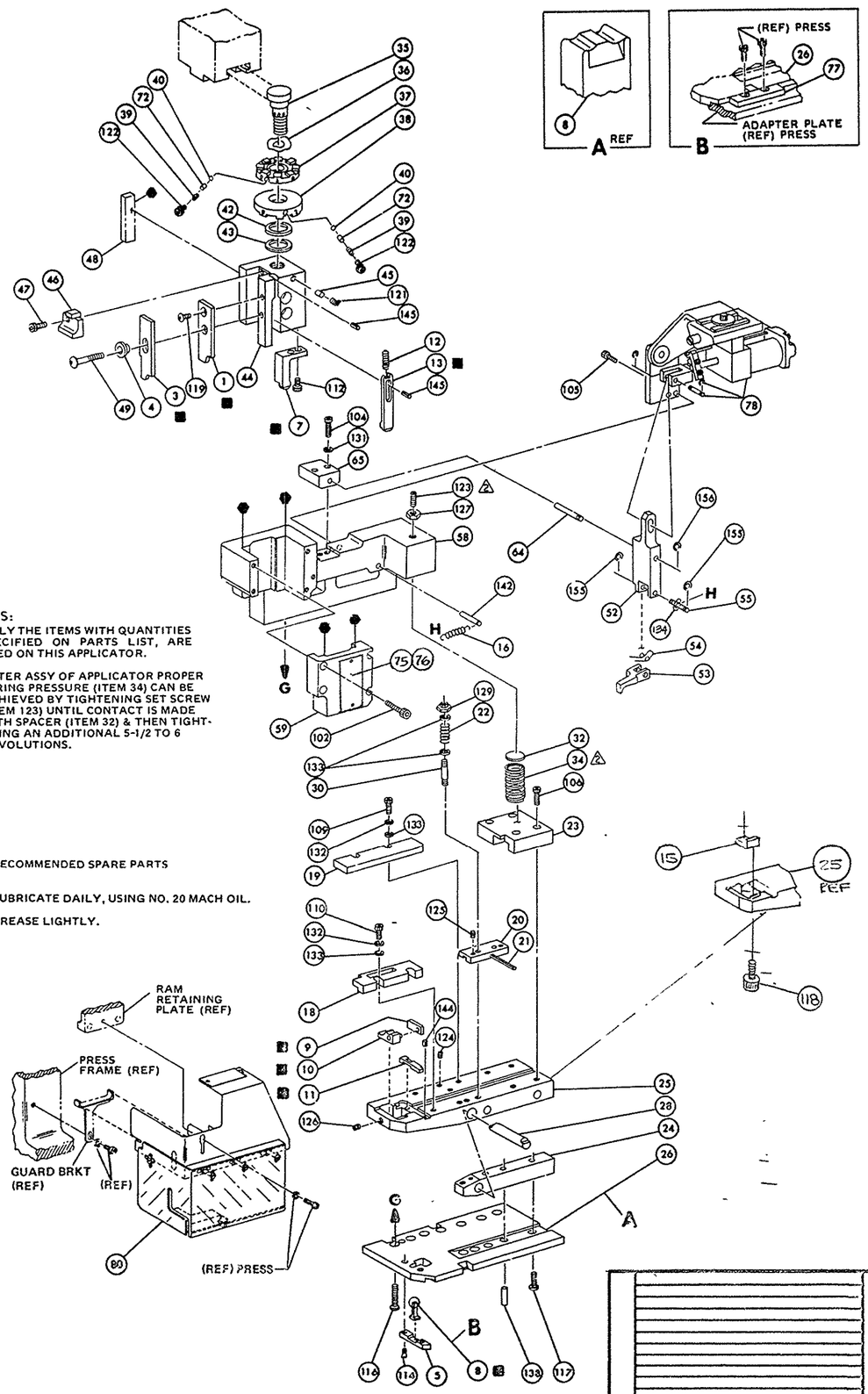
THIS IS A CONTROLLED DOCUMENT.



NOTES:

1. ONLY THE ITEMS WITH QUANTITIES SPECIFIED 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 5-1/2 TO 6 REVOLUTIONS.

KEY:

■ — RECOMMENDED SPARE PARTS

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

⬢ — GREASE LIGHTLY.

REQ.	PART NO.	DESCRIPTION	NO.	REQ.	PART NO.	DESCRIPTION	NO.
			162				71
			161				70
			160				69
			159				68
			158				67
			157				66
1	1- 21986-2	RING RET "E" (3/16 DIA) PIVOT ARM	156	1	456987-1	BLOCK, PIVOT	65
2	21045-3	RING RET "C" (3/16 DIA) FEED PIN	155	1	457058-1	PIN, PIVOT	64
			154				63
			153				62
			152				61
			151				60
			150	1	455164-1	CAP, HOUSING	59
			149	1	457079-1	HOUSING	58
			148				57
			147				56
			146	1	240624-1	PIN, FEED FINGER	55
2	4- 21028-9	PIN SLOT SPG (1/8 DIA X .38) RAM	145	1	691499-1	SPRING, FEED FINGER	54
1	3- 21028-2	PIN, SLOT SPG (3/32 DIA X .25) REAR SHEAR PL	144	1	454568-3	FINGER, FEED	53
			143	1	457057-1	ARM, PIVOT	52
1	3- 22183-7	PIN, GROVE (.187 DIA X .88) FD RETURN SPG	142				51
			141				50
			140	1	3-21002-5	BOLT, CRIMPER	49
			139				48
1	1- 21030-3	PIN, DOWEL (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
			135	1	454574-1	RAM	44
1	25745-1	RING, SPLIT (FEED FINGER)	134	1	690125-1	WASHER, LAMINATED	43
8	1- 21899-3	WASHER, FLAT (NO. 8) DRAG STUD & STR GDS	133	1	1-690124-1	WASHER, RAM	42
4	21024-4	WASHER, LOCK (No. 8) STRIP GUIDE	132				41
2	21024-5	WASHER, LOCK (No. 10) PIVOT BLOCK	131	2	23241-6	BALL, STEEL	40
			130	2	690170-1	SPRING, DISC.	39
2	21022-2	NUT, HEX (SLF LKG) (8-32) DRAG STUD	129	1	690142-1	DISC., INSULATION	38
			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
2	3- 21012-1	SCREW, SKT SET (6-32 X .38) DRAG	125	1	3- 23846-5	SPRING, HINGE BAR △2	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				31
1	21009-2	SCREW,SKT SET (1/4-20 X .25) C.P. RAM	121	2	22354-8	STUD, DRAG	30
			120				29
1	2- 21002-1	SCREW,BTN HD SKT CAP (8-32 X .38) CRIMPER	119	1	690582-1	PIN, HINGE	28
1	1-21000-5	SCREW, SKT. HD. CAP (4-40 x .50) INSERT	118				27
3	3- 21002-4	SCREW,BTN HD SKT CAP (1/4-20 X .62) BLK STAB	117	1	684905-1	PLATE, BASE	26
4	1-24073-9	SCREW,BTN HD SKT CAP (1/4-20 X .75) HOUSING	116	1	354679-1	BAR, HINGE	25
			115	1	690571-1	BLOCK, STABILIZER	24
2	2-24607-7	SCREW,FL HD SKT CAP (6-32 X .25) ANVIL MTG. PL.	114	1	690585-1	BLOCK, PRESSURE	23
			113	2	23470-8	SPRING, DRAG	22
2	1-23030-1	SCREW,SKT HD CAP (8-32 x .62) NYLOK, SL BLADE	112	1	21029-9	LEVER, DRAG	21
			111	1	457093-4	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 GD	109	1	457090-5	GUIDE, STRIP, FRONT	18
			108				17
			107	1	2- 22287-6	SPRING, FEED RETURN	16
4	2- 21000-9	SCREW,SKT HD CAP (8-32 X .75) PRESS BLOCK	106	1	354678-1	INSERT, TERMINAL POSITIONER	15
2	21001-3	SCREW,SKT HD CAP (1/4-20 X .62) AIR FD ASSY	105				14
2	3- 21000-8	SCREW,SKT HD CAP (10-32 X .88) PIVOT BLOCK	104	1	455279-3	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	454712-2	PLATE, REAR SHEAR ■	11
			101	1	454709-1	INSERT, ANVIL ■	10
1	457244-2	GUARD ASSEMBLY	80	1	690569-1	PLATE, FRONT SHEAR ■	9
			79	1	690575-1	ANVIL ■	8
1	457098-1	AIR FEED ASSEMBLY	78	1	454572-1	BLADE, SLUG ■	7
1	694427-1	PLATE, APPLICATOR, MOUNTING	77				6
2	21017-2	SCR, DRIVE (#2 X .19)	76	1	684906-1	PLATE, ANVIL MOUNTING	5
1	461264-1	PLATE, ID	75	1	690574-1	SPACER TUBULAR, INSUL CRIMPER	4
			74	1	690588-1	CRIMPER, INSULATION ■	3
			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	THIS APPLICATOR WILL APPLY SPADE	RING
A	.072	12		41887	41892
B	.062	14		41888	41893
C	.056	16		41889	41894
D	.052	18		42187	42189
				42188	42190
				42226	42191
				60976	42851
				61902	42923
				63053	63262

CRIMP	SIZE	TYPE	FEED	PRESS (REF)
WIRE	160	TAB	.480	565435-5
INSULATION	.180	O		

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION
110-.210	18-12	8037

REMARKS: AMP-O-LECTRIC® PRESS (AIR FEED)

LTR	REVISION RECORD	ECN	DR	CK	DATE
N	ECR-06-002569		MJ	GB	2-06
M	0150-7103-96		DR	GB	8-96
L	0150-6674-95		DR	GB	3-95
K	ECN 0150-4232-93	—	MJ	GB	1-93
J	ECN A-376092		DR	GB	7-10-92
H	ECN A-366682	✓	MJ	TB	6-92
G	ECN A-33392	—	MJ	GB	1-10-92
F4	REACTIVATE A-345991		MJ	CK	12-91
F3	ECN A-273490		LD	TB	10-90
F2	REV. PER ECN R-5094		DR	GB	5-14-73
F1	REV. PER ECN	R 5209	DR	GB	9-18-80
F	REV. PER ECN	R 1254	TB		5-75
E	INACTIVE PER ECN	R 1117	DR		5-14-75
D	REDRAWN WITH CHANGES	L 9424	JM		4-26-7

LTR	REVISION RECORD	ECN	DR	CK	DATE

DRAWN 4-18-73 T. BUNK
CHECKED 4-23-73 T. EMILLER
APPROVED 4-27-73
LAYOUT NO.
SCALE NONE

AMP INCORPORATED HARRISBURG, PENNA.

CAGE CODE 00779 | LOC A C | NO. 687393-5 | REV N

NAME: APPLICATOR, MINIATURE QUICK CHANGE HINGE BAR, E.F. (FLAG RINGS & SPADES)

CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

687392-5

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