

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.

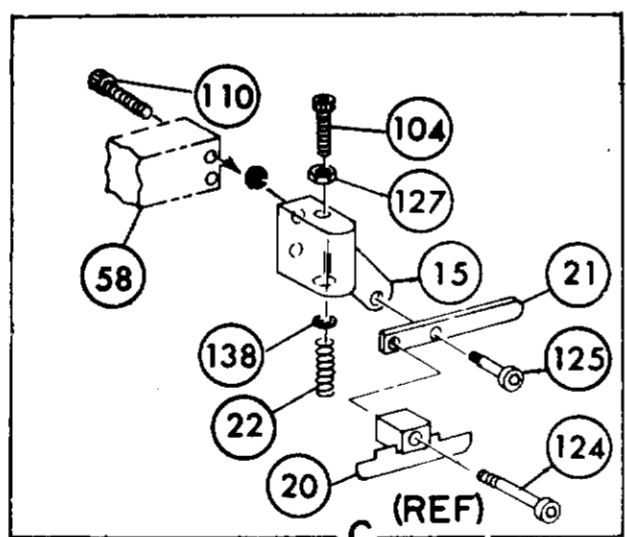
4. PARTS WITH QTY. OF REF. SPECIFIED (EXCEPT ITEM 79) ARE USED ON ITEM 32.

KEY:

■ RECOMMENDED SPARE PARTS.

▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.

● GREASE LIGHTLY.



ALTERNATE DRAG METHOD

BTN HD SKT CAP SCR 3/8-16 X.75 (REF)

| REF | QTY | PART NO | DESCRIPTION | ITEM NO | REF | QTY | PART NO | DESCRIPTION | ITEM NO |
|-----|-----|-----------|--|---------|-----|------------|------------------------------|-------------|---------|
| | | 21045-3 | RING, RETAINING 'C' (.187 DIA) FEED PIN | 145 | REF | 454220-1 | CAP, RAM | 59 | |
| | | | | 144 | REF | 453736-1 | HOUSING | 58 | |
| REF | | 5-21028-1 | PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD | 143 | | | | 57 | |
| | | | | 142 | | | | 56 | |
| 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 | 691497-1 | SPRING, FEED FINGER | 54 | |
| | | | | 139 | REF | 240635-1 | FINGER, FEED | 53 | |
| | | 22260-5 | WASHER, FLAT (NO 6) DRAG SPRING | 138 | REF | 240634-3 | LEVER, TERMINAL | 52 | |
| REF | | 21899-4 | WASHER, FLAT (5/16 DIA) SCR ADJ | 137 | | | | 51 | |
| | | | | 136 | | | | 50 | |
| REF | | 21024-5 | WASHER, LOCK (NO 10) FEED ADJ PLATE | 135 | 1 | 690686-1 | 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 | |
| | | | | 130 | 1 | 455674-1 | 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 | |
| | | 21018-7 | NUT, HEX MACH (10-32) DRAG SPRING | 127 | | | SPACER, DISC | 41 | |
| | | 21022-2 | NUT, HEX SELF-LKG (8-32) DRAG STUD | 126 | 2 | 23241-6 | BALL, STEEL | 40 | |
| | | 5-21004-7 | SCR, SKT HD SHLD (250 DIA X .25) DRAG ARM | 125 | 2 | 690170-1 | SPRING, COMPRESSION | 39 | |
| | | 21004-5 | SCR, SKT HD SHLD (250 DIA X 1.00) DRAG | 124 | 1 | 690142-1 | DISC, INSULATION | 38 | |
| 2 | | 4-21078-8 | SCR, SKT SET OVAL POINT (4-40 X .75) DRAG | 123 | 1 | 3-455829-0 | DISC, WIRE | 37 | |
| 1 | | 21009-2 | SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM | 122 | 1 | 22480-5 | WASHER, SPRING | 36 | |
| | | | | 121 | 1 | 690212-1 | POST, RAM | 35 | |
| | | | | 120 | | | | 34 | |
| 1 | | 1-21002-7 | SCR, BTN HD SKT CAP (6-32 X .38) CAM | 119 | | | | 33 | |
| REF | | 3-21064-2 | SCR, RD HD MACH (6-32 X 1.50) FEED ADJ | 118 | 1 | 458980-2 | APPLICATOR, BASIC (SUB ASSY) | 32 | |
| | | | | 117 | | | | 31 | |
| 2 | | 2-21002-2 | SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER | 116 | | | | 30 | |
| REF | | 2-21002-9 | SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP | 115 | | | | 29 | |
| 1 | | 22733-8 | SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL | 114 | 1 | 1-690451-7 | SPACER, STRIPPER | 28 | |
| 4 | | 3-21002-3 | SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL | 113 | 1 | 690455-3 | STRIPPER | 27 | |
| REF | | 2-22733-9 | SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL | 112 | REF | 455676-1 | PLATE, BASE | 26 | |
| | | | | 111 | 2 | 22354-8 | DRAG, STUD | 25 | |
| | | 2-21000-4 | SCR, SKT HD CAP (6-32 X 1.00) DRAG ADAPTOR | 110 | 1 | 455678-1 | PLATE, STRIP GUIDE | 24 | |
| 2 | | 23030-1 | SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC | 109 | | | PLATE, STRIP HOLD | 23 | |
| 2 | | 221000-9 | SCR, SKT HD CAP (8-32 X .75) SHEAR BLADE | 108 | 2 | 4-22281-1 | SPRING, DRAG | 22 | |
| 3 | | 221000-6 | SCR, SKT HD CAP (8-32 X .38) STRIP GUIDE | 107 | | 240636-1 | LEVER, DRAG | 21 | |
| 1 | | 2-21000-6 | SCR, SKT HD CAP (8-32 X .38) STRIP GUIDE | 106 | 1 | 454177-1 | DRAG, STOCK | 20 | |
| REF | | 3-21000-7 | SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE | 105 | 1 | 458030-6 | GUIDE, STRIP (REAR) | 19 | |
| | | 3-21000-9 | SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING | 104 | 1 | 458031-6 | GUIDE, STRIP (FRONT) | 18 | |
| REF | | 3-21000-6 | SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE | 103 | REF | 454178-1 | GUIDE, FEED ROD | 17 | |
| REF | | 3-21000-4 | SCR, SKT HD CAP (10-32 X .38) PIVOT BLK | 102 | REF | 4-22284-9 | SPRING, FEED RETURN | 16 | |
| 2 | | 3-21000-8 | SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE | 101 | | | ADAPTER, DRAG | 15 | |
| REF | | 455750-3 | GUARD ASSY | 79 | | | | 14 | |
| | | 465184-9 | LUBRICATION ASSY | 78 | | | SPACER, HOLD DOWN | 13 | |
| | | 455985-1 | OIL, LUBRICATING | 77 | | | SPRING, HOLD DOWN | 12 | |
| | | 454406-1 | SPACER, LUB BRACKET | 76 | 1 | 240644-1 | PLATE, REAR SHEAR | 11 | |
| | | | | 75 | | | SPACER, SHEAR PLATE | 10 | |
| | | | | 74 | 1 | 690482-7 | PLATE, FRONT SHEAR | 9 | |
| REF | | 458109-1 | WASHER, FLAT (SPECIAL) | 73 | 1 | 461295-4 | ANVIL | 8 | |
| 2 | | 690603-1 | SPRING, ASSIST | 72 | 1 | 3-690474-1 | BLADE, SLUG | 7 | |
| REF | | 690517-1 | SPACER | 71 | | | HOLD DOWN, TERMINAL | 6 | |
| | | 22594-8 | NUT, HEX | 70 | 1 | 5-230641-7 | SPACER, SHEAR BLADE | 5 | |
| | | 240628-1 | PLATE, ADJ | 69 | 1 | 238009-7 | SPACER, TUBULAR | 4 | |
| | | 240626-1 | SHAFT, PIVOT | 68 | 1 | 5-456134-6 | CRIMPER, INSULATION | 3 | |
| | | 240633-1 | BUSHING | 67 | 1 | 455888-5 | SPACER, INSULATION | 2 | |
| | | 455680-1 | LEVER, INTERMEDIATE | 66 | 1 | 455430-1 | CRIMPER, WIRE | 1 | |
| | | 240629-1 | BLOCK, PIVOT | 65 | | | | | |
| | | 240632-2 | SCREW, ADJ | 64 | | | | | |
| | | 240659-3 | PIN, CAM ROLLER | 63 | | | | | |
| | | 240658-1 | CAM, ROLLER | 62 | | | | | |
| REF | | 454398-1 | ROD, FEED | 61 | | | | | |
| | | | | 60 | | | | | |

| CRIMPING DATA | | | | APPLICATOR WILL APPLY | |
|---------------|--------------|-----------|-------------|-----------------------|-------|
| PAD LTR | CRIMP HEIGHT | WIRE SIZE | WIRE LENGTH | | |
| A | .134 | 10 | | | 60399 |
| B | .120 | 12 | | | 60400 |
| C | .116 | 14 | | | 61844 |
| D | NOT USED | | | | |

| CRIMP | SIZE | TYPE | FEED | APPL INST |
|--------------------|----------|------------------|--------------|-----------|
| WIRE | 10 | F | 1.150 | A1 3039 |
| INSUL | .80 | F | | |
| WIRE RANGE | 12 TO 10 | INSULATION RANGE | .150 TO .210 | PRESS NO |
| REMARKS: AMPOMATOR | | | | |

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

| | | | |
|-----|----------|----|--------------------|
| REV | DATE | BY | DESCRIPTION |
| D | 11-18-88 | | REV PER ENR 2-5491 |
| C | 11-18-88 | | REV PER ENR 2-5491 |
| B | 11-18-88 | | REV PER ENR 2-5491 |
| A | 11-18-88 | | REV PER ENR 2-5491 |

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