

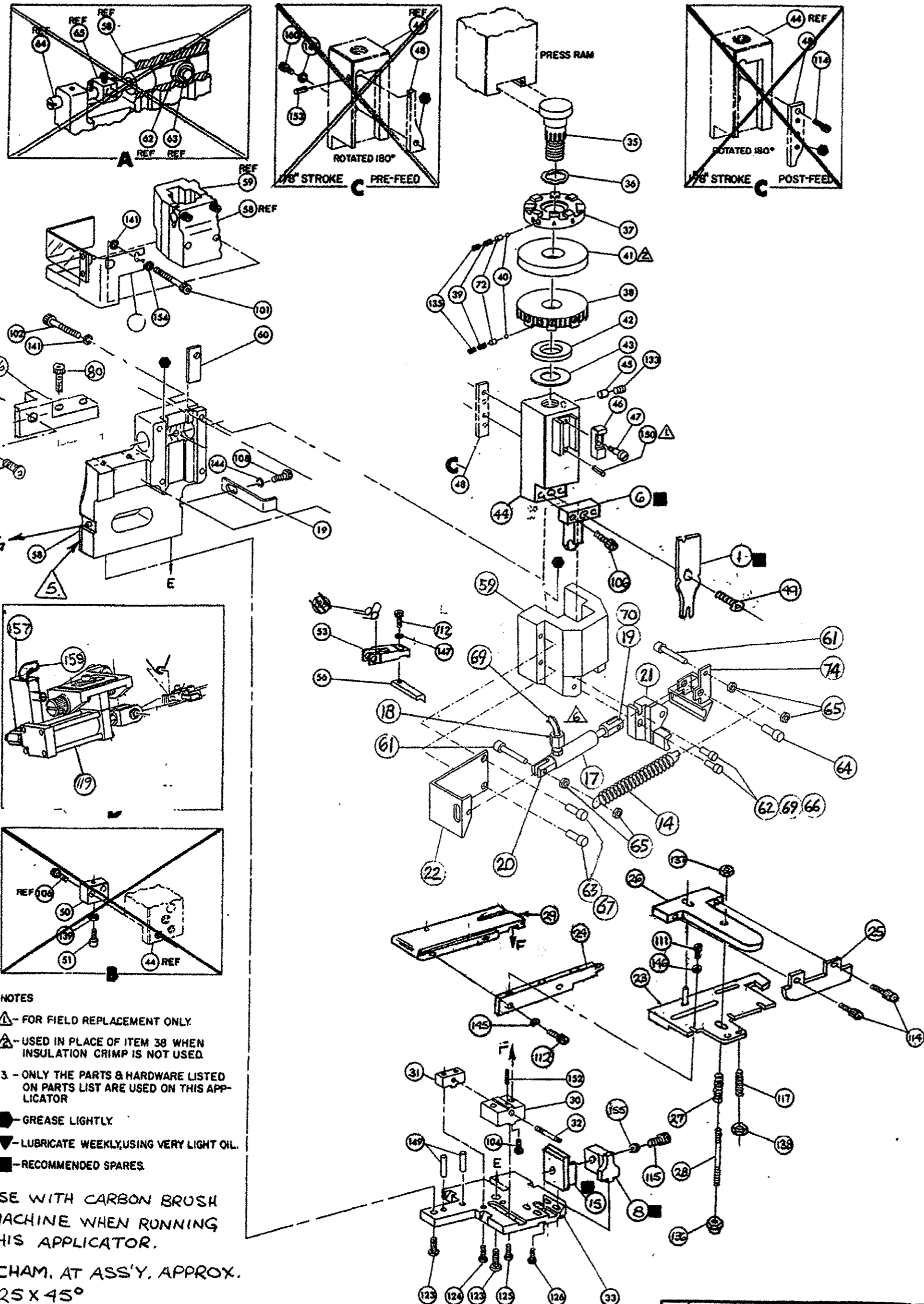
THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE MANUFACTURE OF THIS PRODUCT. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE USER SHOULD BE CONTACTED FOR THE LATEST REVISION.

THIS IS A CONTROLLED DOCUMENT.

RELEASED FOR PUBLICATION 1/1 BY AMP INCORPORATED ALL RIGHTS RESERVED

THIS DRAWING IS UNPUBLISHED AND IS NOT TO BE REPRODUCED OR COPIED WITHOUT THE WRITTEN PERMISSION OF AMP INCORPORATED. COPYRIGHT 1999

PRINT 6/00



- NOTES**
- ▲ FOR FIELD REPLACEMENT ONLY
 - ▲ USED IN PLACE OF ITEM 38 WHEN INSULATION CRIMP IS NOT USED
 - 3 - ONLY THE PARTS & HARDWARE LISTED ON PARTS LIST ARE USED ON THIS APPLICATOR
 - GREASE LIGHTLY
 - ▼ LUBRICATE WEEKLY USING VERY LIGHT OIL
 - RECOMMENDED SPARES

▲ USE WITH CARBON BRUSH MACHINE WHEN RUNNING THIS APPLICATOR.

▲ CHAM. AT ASS'Y. APPROX. .25 X 45°

▲ TUBING FROM FF2 "C" (THRU MANIFOLD "B")

REQ.	PART NO.	DESCRIPTION	NO.	REQ.	PART NO.	DESCRIPTION	NO.
		WASHER, LOCK #10 CAM	162	1	690517-1	SPACER	71
		SCR, SOC HD CAP (10-32 X 1.00) CAM	161	1	21018-8	NUT, HEX #8	70
		22254-6 ELBOW-1/8 NPT X 1/4 O.D. TUBING	160	1	24028-1	TUBING 1/8 O.D.	69
		21045-3 RING, RET "C", 1.56 DIA DRAG RELEASE	159	2	21829-1	WASHER, FLAT #6	68
		23054-1 VALVE, FLOW CONTROL	158	2	21024-5	WASHER, LOCK #10	67
		WASHER, LOCK #8 FEED RETURN SPRING MT.	157	2	21024-3	WASHER, LOCK #6	66
		21024-3 WASHER, LOCK #6 SHEAR PLATE	156	4	21021-1	NUT, SELF LOCKING #4	65
		22260-7 WASHER, FLAT #10 GUARD	155	1	1-21982-1	SCR, SOC SHLDR 8-32 X .50	64
		3-21028-5 PIN, SLOTTED SPR (.125 DIA X .35) CAM	154	2	3-21000-9	SCR, SHC 10-32 X .75	63
		3-21028-5 PIN, SLOTTED SPR (.093 DIA X .43) BASE BLK	153	2	2-21000-7	SCR, SHC 6-32 X .625	62
		3-21028-5 PIN, SLOTTED SPR (.125 DIA X .50) ADJ ROD	152	2	1-21000-7	SCR, SHC 4-40 X .75	61
		21028-2 PIN, SLOTTED SPR (.062 DIA X .25) RAM	151	1	24024-1	PLATE, WEAR	60
		2-21020-3 PIN, DOWEL (.250 DIA X .75) BASE PLATE	150	1	679685-1	CAP, RAM (MACH)	59
		21024-3 PIN, DOWEL (.187 DIA X 1.00) LEVER	149	1	844393-1	HOUSING	58
		21024-4 WASHER, LOCK #8 FEED FINGER	148	1	7-22846-0	PIN, COTTER 5/64 DIA	57
		21024-3 WASHER, LOCK #6 FRONT STRIP GUIDE	147	1	844382-1	PAWL, FEED	56
		21024-3 WASHER, LOCK #8 STRIP GUIDE MOUNT	146	1		PIN, FEED FINGER	55
		21024-4 WASHER, LOCK #8 DEPRESSOR	145	1	461062-1	SPRING, FEED FINGER	54
		21024-3 WASHER, LOCK #10 ADJ PLATE	144	1		FINGER, FEED ASSY	53
		21024-5 WASHER, LOCK #10 RAM	143	1		LEVER, TERMINAL FEED ARM	52
		NUT, HEX (6-32) FEED ADJ.	142	1		BUMPER, HOLDDOWN	51
		21018-6 NUT, HEX (8-32) HOLD DOWN	141	1		SPACER, CRIMPER	50
		21068-5 NUT, HEX (6-32) DRAG ADJ.	140	1	7-21002-9	BOLT, CRIMPER	49
		21018-7 NUT, HEX (10-32) DRAG STUD	139	1		CAM PRE FEED 1/8 STROKE	48
		21022-3 NUT, HEX (10-32 S/L) DRAG STUD	138	1	22353-8	SCREW, SHOULDER (1.87 DIA X .250 LG.)	47
		2-21006-7 SCR, SOC SET (6-32 X .13) C.P. DISC	137	1	690402-	BLOCK, INS ADJ	46
		2-21006-7 SCR, SOC HD CAP (10-32 X .38) PIVOT BLK	136	1	690191-	PLUG, NYLON	45
		21009-2 SCR, SOC SET (NYLON) (1/4-20 X .25) RAM	135	1	6297134-1	RAM	44
		22353-8 SCR, SHED (.187 DIA X .250 LG.) DRAG LEVER	134	1	690125-1	WASHER, LAMINATED	43
		22353-1 SCR, SHLD (.125 DIA X .125 LG.) STRIPPER	133	1	690124-1	WASHER, RAM	42
		274113 SPRING	132	1	690223-1	DISC, SPACER	41
		2-21002-2 SCR, BUT HD SOC CAP (8-32 X .50) SHEAR	131	1	23241-6	BALL, STEEL	40
			130	1	690170-1	SPRING, COMPRESSION	39
			129	1		DISC, INSULATION	38
			128	1	1-690692-9	DISC, WIRE	37
			127	1	22480-5	WASHER, SPRING	36
			126	1	690212-1	POST, RAM	35
			125	1		SUPPORT, TERMINAL	34
			124	1	844390-1	PLATE, BASE	33
			123	1	844386-1	SCREW, ADJUSTMENT	32
			122	1	844387-1	BLOCK, SCREW	31
			121	1	844381-1	BLOCK, BASE	30
			120	1	844392-1	PLATE, STRIP GUIDE	29
			119	1	1-22354-9	SCREW, DRAG	28
			118	1	6-22282-9	SPRING, DRAG	27
			117	1	603952-1	SUPPORT, DRAG STOCK	26
			116	1	603953-1	DRAG, STOCK	25
			115	1	619970-1	MOUNT, STRIP GUIDE	24
			114	1	679742-1	GUIDE, FRONT STRIP	23
			113	1	679750-1	BRACKET, AIR CYLINDER	22
			112	1	679745-1	GUIDE, FIXED	21
			111	1	25660-1	CLEVIS, MALE	20
			110	1	25659-1	CLEVIS, FEMALE	19
			109	1	23901-1	FITTING, 10-32 TO 1/8 TUBING	18
			108	1	24399-1	CYLINDER, AIR, EJECT	17
			107	1	1-22287-6	SPRING, EXTENSION LE-031C-5	16
			106	1	683478-1	PLATE, SHEAR REAR	15
			105	1		HOLDER, SHEAR REAR	14
			104	1		SHEAR, FLOAT REAR	13
			103	1	5-22280-0	SPRING, SHEAR	12
			102	1	690461-1	STOP, SHEAR	11
			101	1		HOLDER, SHEAR FRONT	10
			100	1		SHEAR, FLOAT FRONT	9
			99	1	683477-1	ANVIL	8
			98	1		SPACER, DEPRESSOR REAR	7
			97	1	683475-1	SHEAR, BLADE (SPECIAL)	6
			96	1		DEPRESSOR, SHEAR FRONT	5
			95	1		SPACER, TUBULAR INS CRIMPER	4
			94	1		CRIMPER, INSULATION	3
			93	1		SPACER, CRIMPER	2
			92	1	610573-5	CRIMPER, WIRE	1

CRIMPING DATA					THIS APPLICATOR WILL APPLY	
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	62890		
A	.062	18				
B	.058	20				
C	.055	22				
D	NOT USED					
CRIMP	SIZE	TYPE	FEED			
WIRE	.090	"F"	.480			
INSULATION	#	#				
INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION				
#	22-18	A				
REMARKS						
USE WITH BRUSH MACHINE 459248-7 ONLY						
SET UP GAGE	LAYOUT NO.	APPROVED	LOC	NO.	REV.	
#	1085E1085A		A	567314-1	C2	
BY	DATE	CHECKED	DATE			

REV	DESCRIPTION	DATE	BY	CHKD
02	ECH 0150-1233-04			
01	ECH 0130-1233-02			
00	0130-5398-04			
B	0150-4714-97			
A	REVISED			