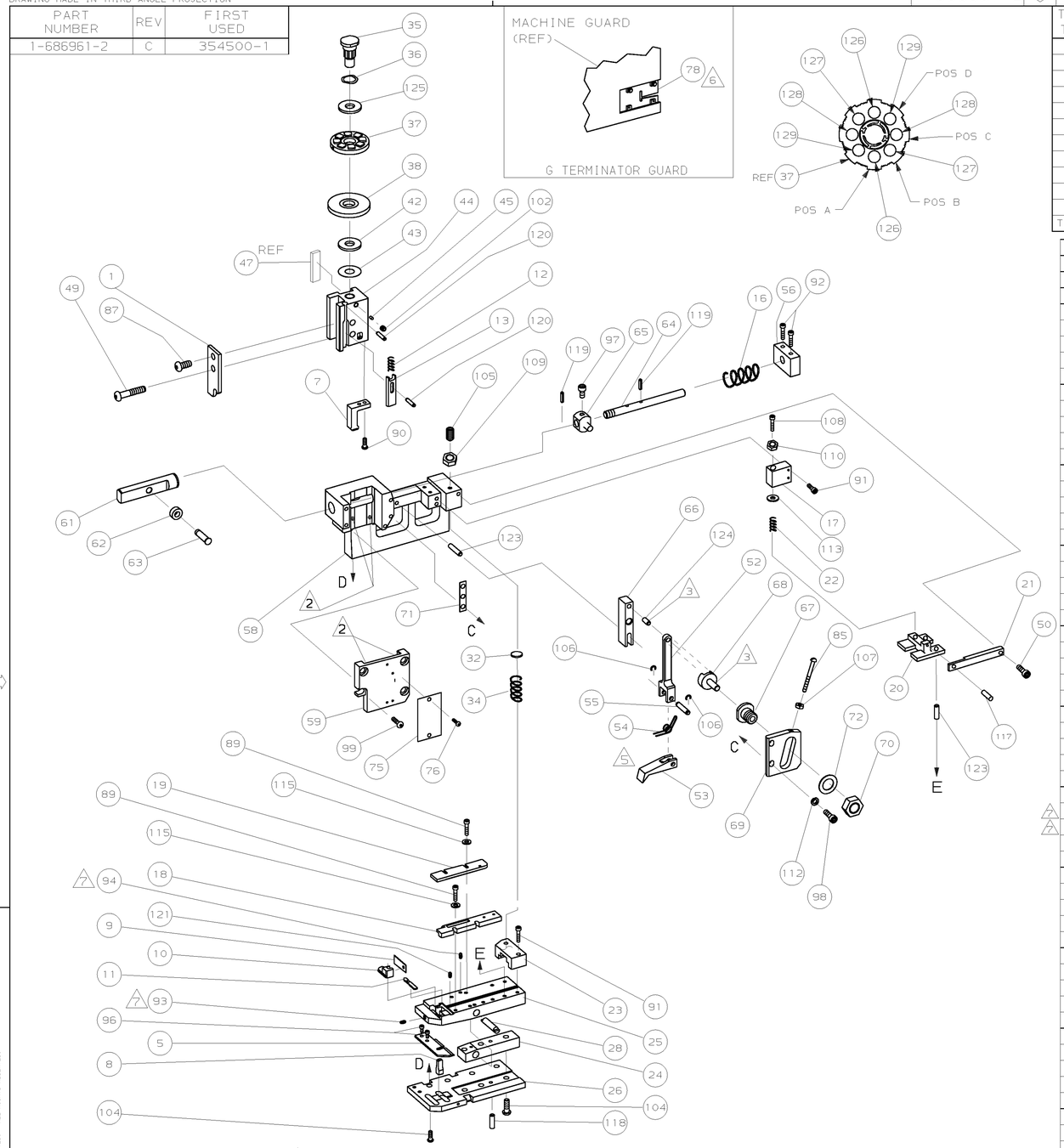
DRAWING MADE IN THIRD ANGLE PROJECTION

1-686961-2 ⇔ 1-686961-2

/home/us016926/DMTECmod

PART NUMBER	REV	FIRST USED
1-686961-2	C	354500-1



TERMINAL NAME: TAB LOK (RIGHT HAND)	
	61177
TERM APPL SPEC	114-2078

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.072±.002	12
B	.062±.002	14
C	.056±.002	16
D	.052±.002	18

CRIMP	SIZE	TYPE	RANGE
WIRE	.160	TAB LOCK	18-12
INSUL	–	–	–

FEED	APPL INST	SET UP GAGE	LAYOUT
.620	AI 8031	–	–

WIRE STRIP LENGTH .363-.393

	-12	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
	2	–	C	2-354779-8	PIN, WIRE DISC (.3130)D	129
	2	–	C	2-354779-2	PIN, WIRE DISC (.3100)C	128
	2	–	C	1-354779-5	PIN, WIRE DISC (.3065)B	127
	2	–	C	9-354778-6	PIN, WIRE DISC (.2975)A	126
	1	–	A	986950-1	WASHER, FLAT PRECISION	125
	1	–	A	1-21030-2	PIN, DOWEL (ø.187X.62)	124
	3	–	A	1-21030-6	PIN, DOWEL (ø.187X1.25)	123
						122
	2	–	A	3-21028-2	PIN, SLOTTED SPRING (ø.094X.25)	121
	2	–	A	4-21028-9	PIN, SLOTTED SPRING (ø.125X.38)	120
	2	–	A	5-21028-1	PIN, SLOTTED SPRING (ø.125X.50)	119
	1	–	A	21029-5	PIN, SLOTTED SPRING (ø.188X.75)	118
	1	–	A	21029-3	PIN, SLOTTED SPRING (ø.188X.62)	117
						116
	4	–	A	21024-4	WASHER, LOCK (#8)	115
	2	–	A	21055-6	WASHER, FLAT (#8)	114
	1	–	A	21899-1	WASHER, FLAT (#6)	113
	2	–	A	21024-5	WASHER, LOCK (#10)	112
						111
	1	–	A	21018-7	NUT, HEX (10-32)	110
	1	–	A	1-22202-7	NUT, HEX (5/16-24)	109
	1	–	A	3-21000-9	SCREW,SHC (10-32 X 1.00)DRAG	108
	1	–	A	21018-5	NUT, HEX (6-32)	107
	2	–	A	21045-3	RING,RET"C"(ø.187)FD PIN	106
	1	–	A	8-21007-5	SCREW,SKT SET(5/16-24x.75)	105
	7	–	A	2-22733-8	SCREW, BHC (1/4-20X.63)	104
						103
	1	–	A	21009-2	SCREW,SKT SET(1/4-20x.25)	102
						101
	2	–	A	1-21003-9	SCREW, FL (6-32X.38)	100
	4	–	A	3-21000-8	SCREW, SHC (10-32X.88)	99
	2	–	A	3-21000-6	SCREW, SHC (10-32X.62)	98
	1	–	A	3-21000-4	SCREW, SHC (10-32X.38)	97
	2	–	A	7-21000-6	SCREW, SHC (10-32X.38)	96
						95
2	2	–	A	4-21006-0	SCREW, SKT SET (8-32X.25)	94
2	1	–	A	21061-9	SCREW, SKT SET (8-32X.25)	93
	2	–	A	3-21000-0	SCREW, SHC (8-32X.88)	92
	2	–	A	2-21000-9	SCREW, SHC (8-32X.75)	91
	2	–	A	23030-4	SCREW, SHC (NYLOK)(6-32X.62)	90
	4	–	A	2-22603-3	SCREW, HEX (8-32X.62)	89
						88
	1	–	A	2-21002-2	SCREW, BHC (8-32X.50)	87
						86
	1	–	A	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	85
	1	–	A	23030-1	SCREW, SHC(NYLOK)(6-32X.25)	84
						83
						82
						81
						80
						79
	REF	–	B	679532-1	INSERT, GUARD	78
						77
	2	–	A	21017-2	SCR,DRIVE(#2X.19)ID	76
	1	–	B	461264-1	PLATE, IDENTIFICATION	75
	1	–	A	690603-1	SPRING, ASSIST	74
						73
	1	–	A	458109-1	WASHER, SPECIAL	72
	1	–	A	690517-1	SPACER	71

QTY REQD PER ASSY — REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION) — PARTS LIST

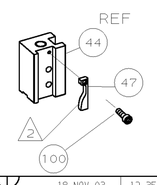
-12 BENCH MODEL G MECH PRE FEED

	-12	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
	1	–	A	22594-8	NUT, HEX	70
	1	–	B	240628-1	PLATE, ADJ	69
	1	–	B	240626-1	SHAFT, PIVOT	68
	1	–	B	240633-1	BUSHING	67
	1	–	A	240630-1	LEVER, INTERMEDIATE	66
	1	–	B	240629-1	BLOCK, PIVOT	65
	1	–	A	240632-2	SCR, ADJ	64
	1	–	B	240659-3	PIN, CAM ROLLER	63
	1	–	B	240658-1	ROLER, CAM	62
	1	–	B	240631-1	ROD, FEED	61
						60
	1	–	C	455164-1	CAP ASSEMBLY	59
	1	–	D	458984-1	HOUSING	58
						57
	1	–	B	458361-1	GUIDE,FEED ROD	56
	1	–	B	240624-1	PIN, FEED FINGER	55
	1	–	B	691499-1	SPRING, FEED FINGER	54
	1	–	B	690584-5	FINGER, FEED	53
	1	–	B	240634-1	LEVER, TERMINAL	52
						51
	1	–	A	1-22353-9	SCREW, SHOULDER	50
	1	–	A	3-21002-5	BOLT, CRIMPER	49
						48
	1	–	B	453991-1	CAM, PRE-FEED 1 5/8 ST	47
						46
	1	–	A	690191-1	PLUG, NYLON	45
	1	–	C	691533-1	RAM	44
	1	–	A	690125-1	WASHER, LAMINATED	43
	1	–	A	1-690124-1	WASHER, RAM	42
						41
	–	–	–	–	–	40
	–	–	–	–	–	39
	1	–	C	690223-1	DISC, SPACER	38
	1	–	D	354777-1	WIRE DISC, PLASTIC	37
	1	–	B	22480-5	WASHER, SPRING	36
	1	–	B	690212-1	POST, RAM	35
	1	–	A	3-23846-5	SPRING, HINGE BAR	34
						33
	1	–	A	690573-1	SPACER, SPRING	32
	–	–	–	–	–	31
	–	–	–	–	–	30
	–	–	–	–	–	29
	1	–	B	690582-1	PIN, HINGE	28
						27
	1	–	C	463873-1	PLATE, BASE	26
	1	–	B	691535-2	HINGE BAR	25
	1	–	B	690571-1	BLOCK, STABILIZER	24
	1	–	C	814222-2	BLOCK, PRESSURE	23
	1	–	A	7-22282-5	SPRING, DRAG	22
	1	–	A	458968-1	LEVER, DRAG	21
	1	–	A	458960-2	DRAG, STOCK	20
	1	–	C	691530-1	GUIDE, STRIP (REAR)	19
	1	–	C	691529-1	GUIDE, STRIP (FRONT)	18
	1	–	B	458978-1	BLOCK, SPRING	17
	1	–	A	4-22284-9	SPRING, FEED RETURN	16
						15
						14
1	1	–	C	692134-5	POSITIONER,TERMINAL	13
	1	–	A	5-22280-5	SPRING,TERM. POSITIONER	12
1	1	–	B	691525-1	PLATE, REAR SHEAR	11
1	1	–	C	691524-1	ANVIL INSERT	10
1	1	–	B	690569-4	PLATE, FRONT SHEAR	9
1	1	–	D	691523-1	ANVIL	8
1	1	–	B	691532-1	BLADE, SLUG	7
	–	–	–	–	–	6
	1	–	B	463874-1	PLATE,ANVIL RETAINING	5
	–	–	–	–	–	4
	–	–	–	–	–	3
	–	–	–	–	–	2
1	1	–	C	691531-1	CRIMPER, WIRE	1

QTY REQD PER ASSY — REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION) — PARTS LIST

1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. LUBRICATE DAILY USING NO. 20 MACHINE OIL.
4. DO NOT EXCEED 80 C.P.M. WITH THIS APPLICATOR.
5. AFTER ASSEMBLY OF APPLICATOR, PROPER SPRING PRESSURE (ITEM 34) CAN BE OBTAINED BY TIGHTENING SET SCREW (ITEM 105) UNTIL CONTACT IS MADE WITH SPACER (ITEM 32) THEN TIGHTEN AN ADDITIONAL 5 1/2 - 6 REVOLUTIONS.
6. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
7. APPLY SEALANT PN 1-23419-5.

PRE-FEED 1 5/8 STROKE



P	F	LTR	REVISION RECORD	APP	DATE
		C1	ECN 0150-1227-03	TE	11-03
		C	ECN 0150-0969-03	TE	9-03
		B	ECN 0150-0511-03	TE	5-03
		A	REVISED	CE	12-94

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±- 3 PLC DEC ±- 4 PLC DEC ±- ANGLES ± - SURF TEXTURE, √ REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL	HT TR	FIN
–	–	–
–	–	–

DR 10-10-94 M. O'BRINE — APP 10-10-94 J. SLUSSER — CHK 10-10-94 C.ERISMAN — REL 12/20/94 B. MORGAN

AMP Incorporated Harrisburg, PA 17105-3608

NAME END FEED HINGE BAR APPLICATOR — MACHINE REF MINI APPL

SCALE – — D — DWG NO 1-686961-2 — SHEET 1 OF 1 — REV C1

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LOC A — DIST 66

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