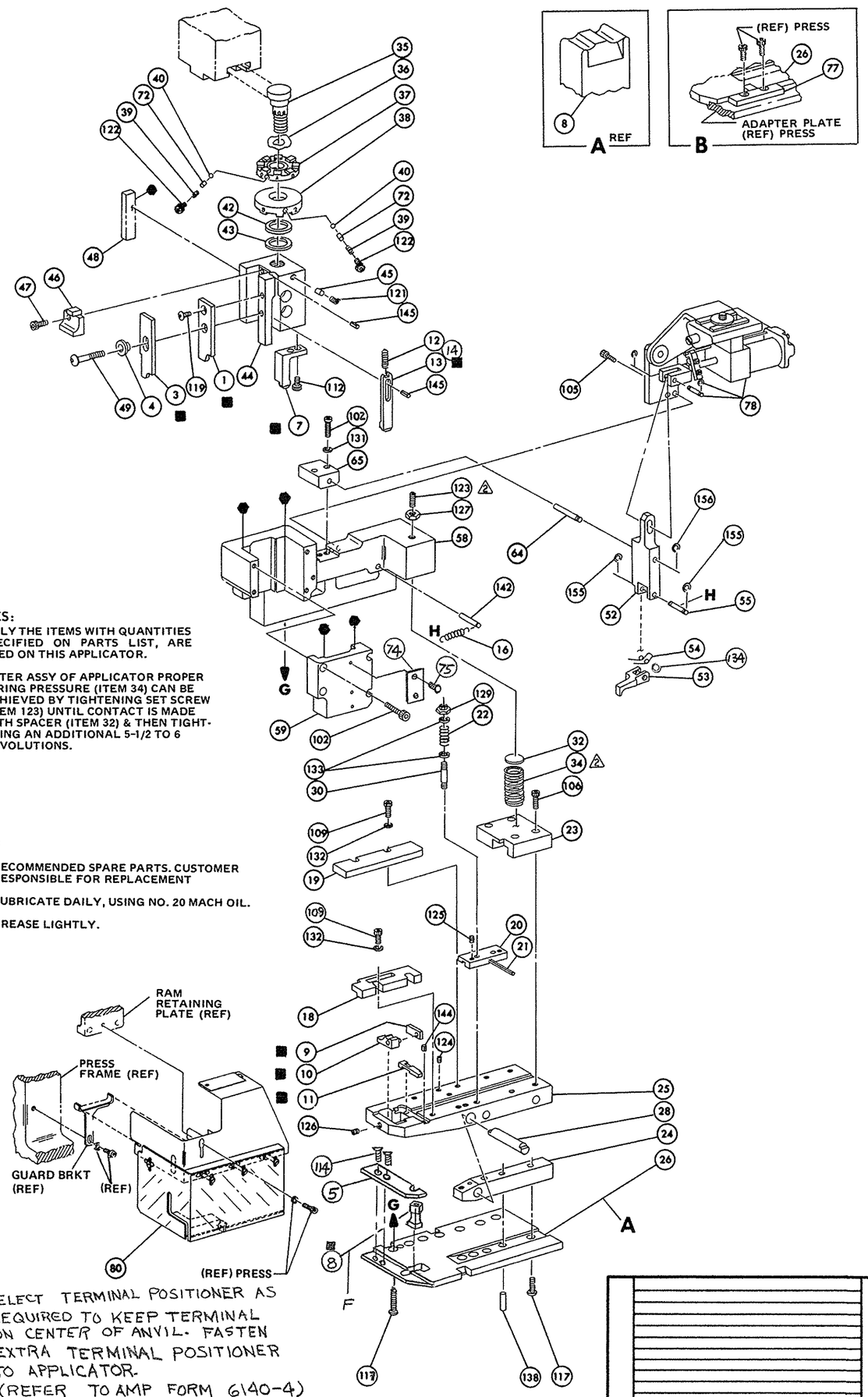
THIS IS A CONTROLLED DOCUMENT



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. CUSTOMER RESPONSIBLE FOR REPLACEMENT

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

⬢ — GREASE LIGHTLY.

3 SELECT TERMINAL POSITIONER AS REQUIRED TO KEEP TERMINAL ON CENTER OF ANVIL. FASTEN EXTRA TERMINAL POSITIONER TO APPLICATOR.
(REFER TO AMP FORM 6140-4)

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				52
			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	454568-1	FINGER, FEED	53
			143	1	457057-1	ARM, PIVOT	52
1	3- 22183-9	PIN, GROVE (.187 DIAX1.125) FD RETURN SPG	142				51
			141				50
			140	1	3-21002-5	BOLT, CRIMPER	49
			139				48
1	21029-5	PIN, SLOTTED (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	134	1	690125-1	WASHER, LAMINATED	43
4	1- 21899-3	WASHER, FLAT (NO. 8) DRAG STUD & STR GDS	133	1	690124-4	WASHER, RAM	42
4	21024-4	WASHER, LOCK (No. 8) STRIP GUIDE	132				41
2	21024-5	WASHER, LOCK (No. 10) PIVOT BLOCK	131	1	23241-6	BALL, STEEL	40
			130	1	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	1-354870-6	DISC., WIRE, ASSY.	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	3-21008-0	SCREW, SKT SET (6-32 X .38) DRAG NYLOK	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
1	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
			118				27
7	2-22733-7	SCREW, BTN HD SKT NYLOK (1/4-20 X .62) BLK STAB	117	1	6849905-1	PLATE, BASE	26
~~4~~	~~17177-1~~	~~SCREW, BTN HD SKT CAP (1/4-20 X .75) HOUSING~~	116	1	454579-2	BAR, HINGE	25
			115	1	690571-1	BLOCK, STABILIZER	24
2	7-21000-6	SCREW, SOC HD SKT CAP (10-32 X .31) 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	457093-1	DRAG, STOCK	20
			110	1	454573-1	GUIDE, STRIP, REAR	19
4	2-22603-3	SCREW, HEX HD CAP (8-32 X .62) REAR STRIP GD	109	1	457090-2	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				15
2	21001-3	SCREW, SKT HD CAP (1/4-20 X .62) AIR FD ASSY	105	1	692134-2	POSITIONER, TERMINAL	14
			104	1	692134-7	POSITIONER, TERMINAL △3 ■	13
			103	1	5- 22280-5	SPRING, TERM. POSITIONER	12
6	3- 21000-8	SCREW, SKT HD CAP (10-32 X .88) HSG CAP	102	1	454712-4	PLATE, REAR SHEAR ■	11
			101	1	454578-1	INSERT, ANVIL ■	10
1	457244-1	GUARD ASSEMBLY	80	1	690569-3	PLATE, FRONT SHEAR ■	9
			79	1	690718-1	ANVIL ■	8
1	457098-1	AIR FEED ASSEMBLY	78	1	454575-3	BLADE, SLUG ■	7
1	694427-1	PLATE, APPLICATOR, MOUNTING	77				6
			76	1	6849906-1	PLATE, ANVIL MOUNTING	5
2	21017-2	SCR, DRIVE # 2x.19	75	1	690574-1	SPACER TUBULAR, INSUL CRIMPER	4
1	461264-1	PLATE, IDENTIFICATION	74	1	690715-1	CRIMPER, INSULATION ■	3
			73				2
1	690603-1	SPRING, ASSIST	72	1	690716-3	CRIMPER, WIRE ■	1

TERM APPL SPEC 114-2078

CRIMPING DATA

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.065	14	
B	.061	16	
C	.058	18	
D	.056	20	

CRIMP	SIZE	TYPE	FEED	PRESS (REF)
WIRE	.140	TAB LOK	.650	565435-5
INSULATION	.140	O		

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION
.110-.170	20-14	AI 8037

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

THIS APPLICATOR WILL APPLY

42234
42459
60195
60643
62354
63635
1742595-1

LTR	REVISION RECORD	ECN	DR	CK	DATE
L1	ECR-19-001120		GB		1-19

LTR	REVISION RECORD	ECN	DR	CK	DATE
L	ECR-08-008793		TM		4-08
K2	ECN 0150-1159-04				9-04
K1	ECN 0150-0569-04				3-04
K	ECN 0150-0531 03				5-03
J	EC 0150-5439-94		JB		6/94
H1	EC A-361892				4-8-92
H	ECN A-304791				5-91
G	REACTIVATED. REV, R-6642				2/86
F	INACTIVE PER ECN R-1117				2-14-75
E1	ADDED TERM 62354 PER R-926				2-24-75
E	REV PER ECN R-924				1-27-75
D1	DELET'D TERM 61475 L-1261				5-20-74
D	REDRAWN WITH CHANGES L-1066				4-10-73

SET - AGE | LAYOUT NO.

DRAWN I. KLUNK 4/16/73 | APPROVED 4/24/73

CHECKED M. WOODRUFF 4/24/73

TE Connectivity, Harrisburg, PA 17105-3608

LOC A C | NO. 687391-4 | REV. L1

SCALE NONE

NAME **APPLICATOR, MINIATURE QUICK CHANGE HINGE BAR, E.F. (.250 FLAG FASTON)**

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

687391-4

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