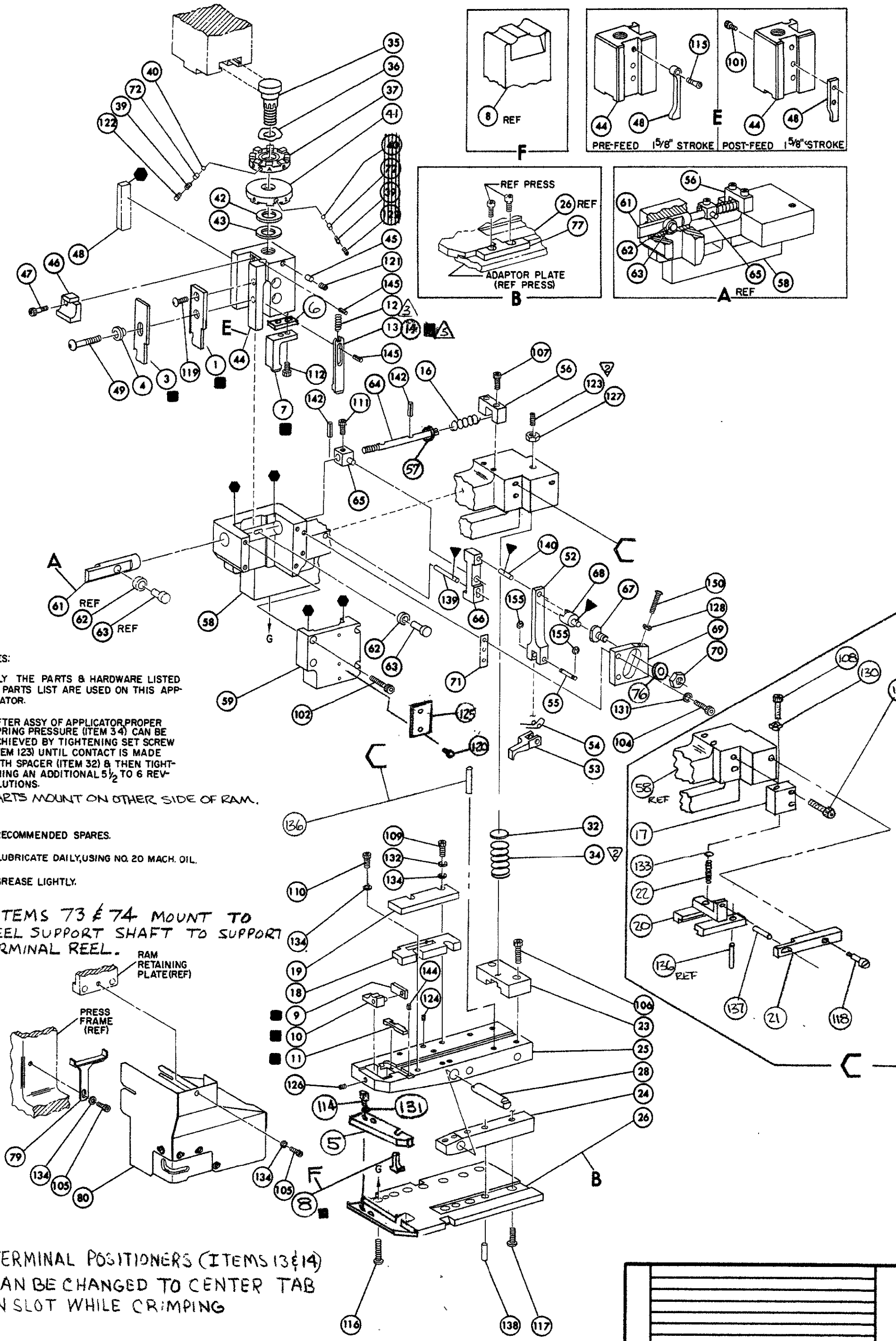


THIS IS A CONTROLLED DOCUMENT.



- NOTES:**
- 1. ONLY THE PARTS & HARDWARE LISTED 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 1/2 TO 6 REVOLUTIONS.
 - 3. PARTS MOUNT ON OTHER SIDE OF RAM. KEY:
 - 4. -RECOMMENDED SPARES.
 - 5. -LUBRICATE DAILY, USING NO. 20 MACH. OIL.
 - 6. -GREASE LIGHTLY.
 - 7. ITEMS 73 & 74 MOUNT TO REEL SUPPORT SHAFT TO SUPPORT TERMINAL REEL.
 - 8. RAM RETAINING PLATE (REF)
 - 9. PRESS FRAME (REF)
 - 10. TERMINAL POSITIONERS (ITEMS 13 & 14) CAN BE CHANGED TO CENTER TAB IN SLOT WHILE CRIMPING

REQ.	PART NO.	DESCRIPTION	NO.	REQ.	PART NO.	DESCRIPTION	NO.
	162		1	690517-1	SPACER	71	
	161		1	22594-8	NUT, HEX	70	
	160		1	240628-1	PLATE, ADJUSTMENT	69	
	159		1	240626-1	SHAFT, PIVOT	68	
	158		1	240633-1	BUSHING	67	
	157		1	240630-1	LEVER, INTERMEDIATE	66	
	156		1	240629-1	BLOCK, PIVOT	65	
2	21045-3	RING RET "C" (3/16 DIA) FEED PIN	1	240632-2	SCREW, ADJUSTMENT	64	
				240659-3	PIN, CAM ROLLER	63	
				240658-1	ROLLER, CAM	62	
				240631-1	ROD, FEED	61	
				455164-1	CAP, HOUSING	60	
				458984-1	HOUSING	59	
				21899-4	WASHER, ADJ. SCREW	58	
				458361-1	GUIDE, FEED ROD	57	
				240624-1	PIN, FEED FINGER	56	
2	4. 21028-9	PIN SLOTTED SPRING (1/8 DIA X .38) RAM	1	691499-1	SPRING, FEED FINGER	55	
1	3. 21028-2	PIN, SLOTTED SPRING (3/32 DIA X .25) REAR SHEAR PLATE	1	690584-5	FINGER, FEED	54	
				240634-1	LEVER, TERMINAL	53	
2	5. 21028-1	PIN, SLOTTED SPRING (1/8 DIA X .50) SCREW ADJ. ROD	1			52	
						51	
						50	
1	1. 21030-2	PIN, DOWEL (3/16 DIA X .62) LEVER	1	3-21002-5	BOLT, CRIMPER	49	
1	1. 21030-6	PIN, DOWEL (3/16 DIA X 1.25) HOUSING	1	238015-1	CAM POST FEED 1/8" STROKE	48	
1	21029-5	PIN, SLOT (3/16 DIA X .75) BASE PLATE	1	22353-8	SCREW, SHOULDER	47	
1	21029-3	PIN, SLT. SPRING (.187 X .62 LG.) DRAG	1			46	
2	1-21030-6	PIN, DOWEL (.187 X 1.25 LG.) DRAG	1	690191-1	PLUG, NYLON	45	
				135	691533-1	RAM	44
				21899-3	WASHER, FLAT 1/4 GUARD	43	
1	21899-1	WASHER, FLAT (#6) DRAG STUD	1	690125-1	WASHER, LAMINATED	42	
				690124-4	WASHER, RAM	41	
4	21024-5	WASHER, LOCK (#10) FEED ADJ. PLATE & RET PLATE	1	690223-1	DISC, SPACER	40	
1	21018-7	NUT, HEX (#10) DRAG	1	23241-6	BALL, STEEL	39	
				690170-1	SPRING, DISC.	38	
1	21068-5	NUT, HEX MACH (6-32) FEED ADJ.	1	8-690141-1	DISC., WIRE	37	
1	1. 22202-7	NUT HEX MACH (5/16-24) SPRING HOUSING	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
1	461264-1	PLATE, I.D.	125	1	3. 23846-5	SPRING, HINGE BAR	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. (NYLON) (6-32 X .25) C.P. DISC.	122				31
1	21009-2	SCREW SKT. SET (1/4-20 X .25) C.P. RAM	121				30
2	21017-2	SCREW, DRIVE (#2 X .19) I.D. PLATE	120				29
1	2. 21002-1	SCREW BTN HD. SKT. CAP (8-32 X .38) CRIMPER	119	1	690582-1	PIN, HINGE	28
1	22353-9	SCR. SHLD. SLT. HD. (.250 X .250) DRAG	118				27
3	3. 21002-4	SCREW BTN HD. SKT. CAP (1/4-20 X .75) BLOCK, STABILIZER	117	1	463873-1	PLATE, BASE	26
4	2-22733-8	SCREW BTN HD. SKT. CAP (1/4-20 X .62) HOUSING	116	1	691535-2	BAR, HINGE	25
				690571-1	BLOCK, STABILIZER	24	
2	7-21000-6	SCREW SKT. CAR (10-32 X 3) ANVIL MTG. PL.	114	1	81422-2	BLOCK, PRESSURE	23
2	2. 21000-8	SCREW SKT. HD CAP (8-32 X .62) DRAG MOUNT	113	1	7-22282-5	SPRING, DRAG	22
2	23030-3	SCREW SKT. HD CAP (6-32 X .50) SL. BLADE	112	1	458968-1	LEVER, DRAG	21
1	3. 21000-4	SCREW SKT. HD CAP (10-32 X .38) PIVOT BLOCK	111	1	458960-2	DRAG, STOCK	20
2	2. 21002-2	SCREW, BUT HD CAP (8-32 X .50) FR STRIP GUIDE	110	1	691520-1	GUIDE, STRIP, REAR	19
2	2. 21002-2	SCREW, BUT HD CAP (8-32 X .50) REAR STRIP GUIDE	109	1	691529-1	GUIDE, STRIP, FRONT	18
1	3-21000-9	SCR. SKT. HD. CAP (10-32 X 1.00) DRAG	108	1	458978-1	BLOCK, SPRING	17
1	3-21000-0	SCREW SKT. HD CAP (8-32 X .88) FEED ROD GUIDE	107	1	4-22284-9	SPRING, FEED RETURN	16
2	2. 21000-9	SCREW SKT. HD CAP (8-32 X .75) PRESS BLOCK	106				15
				105	692134-8	POSITIONER, TERMINAL	14
2	21001-1	SCREW SKT. HD CAP (1/4-20 X .38) GUARD	104	1	692134-5	POSITIONER, TERMINAL	13
2	3. 21000-6	SCREW SKT. HD CAP (10-32 X .62) FEED PLATE	103	1	3. 22280-5	SPRING, TERM. POSITIONER	12
2	2-21000-7	SCR. SKT. HD. CAP (8-32 X .50) DRAG	102	1	691525-1	PLATE, REAR SHEAR	11
4	3. 21000-8	SCREW SKT. HD CAP (10-32 X .88) HSG. CAP	101	1	691524-2	INSERT, ANVIL	10
2	3. 21000-9	SCREW SKT. HD. CAP (10-32 X 1.00) CAM	100	1	690569-4	PLATE, FRONT SHEAR	9
				79	691523-1	ANVIL	8
				78	691522-1	BLADE, SLUG	7
				77	455608-1	SPACER SHEAR BLADE	6
1	458109-1	WASHER, FLAT, PRECISION	76	1	463814-1	PLATE, ANVIL MOUNTING	5
				75		SPACER TUBULAR, INSUL CRIMPER	4
2	21001-6	SCR. SOC. HD. CAP 1/4-20 X 1.00	74			CRIMPER, INSULATION	3
2	682131-1	WASHER, BEVELED	73				2
1	690603-1	SPRING, ASSHT	72	1	691531-1	CRIMPER, WIRE	1

TERM APPL SPEC 114-2078

CRIMPING DATA				THIS APPLICATOR WILL APPLY
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	STRIP LENGTH	6117-3
A	.072	12		6199-1
B	.062	14		
C	.056	16		
D	.052	18		
CRIMP	SIZE	TYPE	FEED	
WIRE	.160	T.L.		
INSULATION	-#	-#	.620	
INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION # 8031		
	18-12			
REMARKS ARTOS CS9-AT DONOT EXCEED 80C.P.M WITH THIS APPLICATOR EJECT SIDE ONLY				
SET UP GAGE	LAYOUT NO.	AMP INCORPORATED HARRISBURG, PENNA.		
DRAWN 5973	APPROVED 05-10-73	LOC A	C	686961-9
CHECKED 5-10-73	REL.	APPLICATOR, MINIATURE QUICK CHANGE HINGE BAR, E.F. (TAB LOK (LEFT HAND))		

REV	DATE	DESCRIPTION	BY	CHK
N	0150-7147-96			
M	0150-6927-96			
L	ECN 0150-5217-94			
K	ECN A-304991			
J	ECN AIG2985			
I	REV PER ECN A-5616			
H	REV PER ECN			
G	ADD ITEMS 73 & 74			
F	REV PER ECN			
E	REV PER ECN			
D	REV PER ECN ITEM 114			
C	REV PER ECN			
B	REV PER ECN			
A	REV PER ECN			
N	ECN 0150-1207-04			