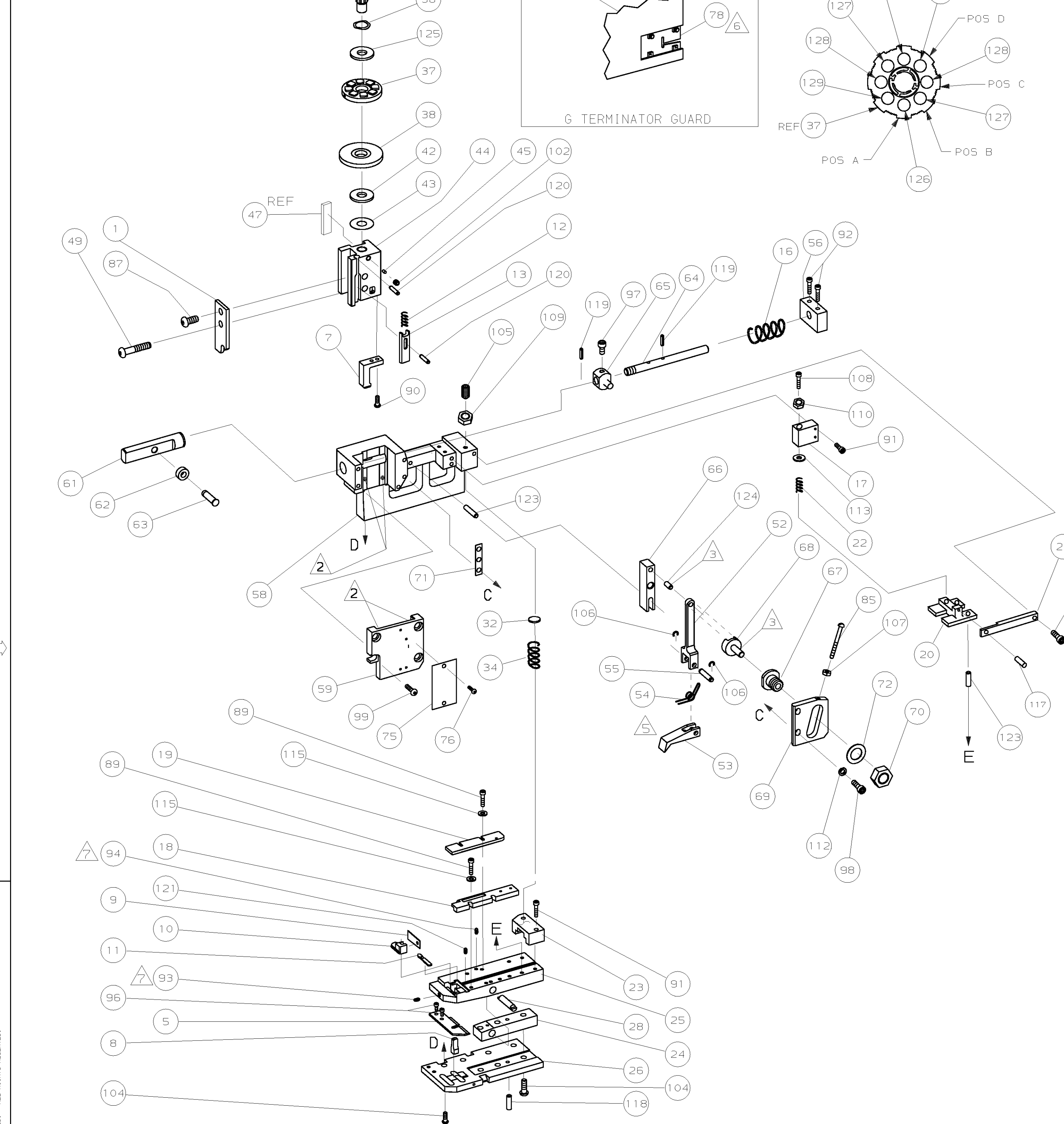
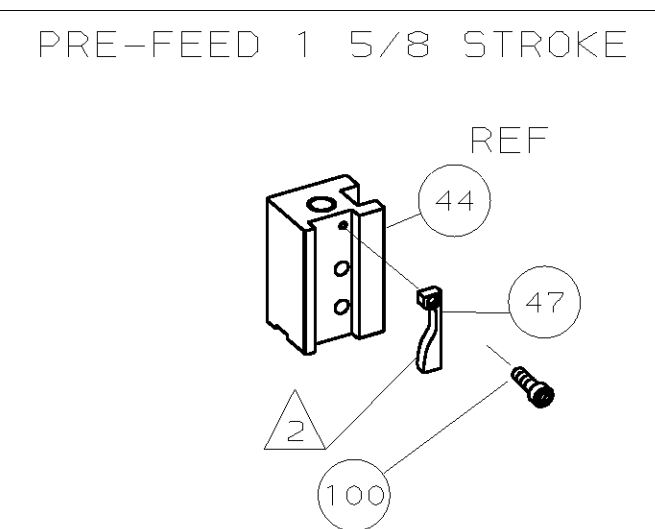


PART NUMBER	REV	FIRST USED
1-686961-2	C	354500-1



- 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.



TERMINAL NAME:		CRIMPING DATA	
TAB LOK (RIGHT HAND)		PAD LTR	CRIMP HEIGHT
61177		A	.072±.002
		B	.062±.002
		C	.056±.002
		D	.052±.002
		CRIMP	SIZE
		WIRE	.160
		INSUL	-
		FEED	.620
		APPL INST	AI 8031
		SET UP GAGE	-
		LAYOUT	-
TERM APPL SPEC 114-2078		WIRE STRIP LENGTH .363-.393	

QTY	REV	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	-	A 4-21006-0 SCREW, SKT SET (8-32X.25)	94
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	REV	DESCRIPTION	ITEM NO
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	-	C 692134-5 POSITIONER, TERMINAL	13
1	-	A 5-22280-5 SPRING, TERM. POSITIONER	12
1	-	B 691525-1 PLATE, REAR SHEAR	11
1	-	C 691524-1 ANVIL INSERT	10
1	-	B 690569-4 PLATE, FRONT SHEAR	9
1	-	D 691523-1 ANVIL	8
1	-	B 691532-1 BLADE, SLUG	7
-	-	-	6
1	-	B 463874-1 PLATE, ANVIL RETAINING	5
-	-	-	4
-	-	-	3
-	-	-	2
1	-	C 691531-1 CRIMPER, WIRE	1

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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

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

NAME: END FEED HINGE BAR APPLICATOR MACHINE REF: MINI APPL

SCALE: - DWG NO: 1-686961-2 SHEET: 1 OF 1 REV: C1

CUSTOMER AND ASSEMBLY DRAWING