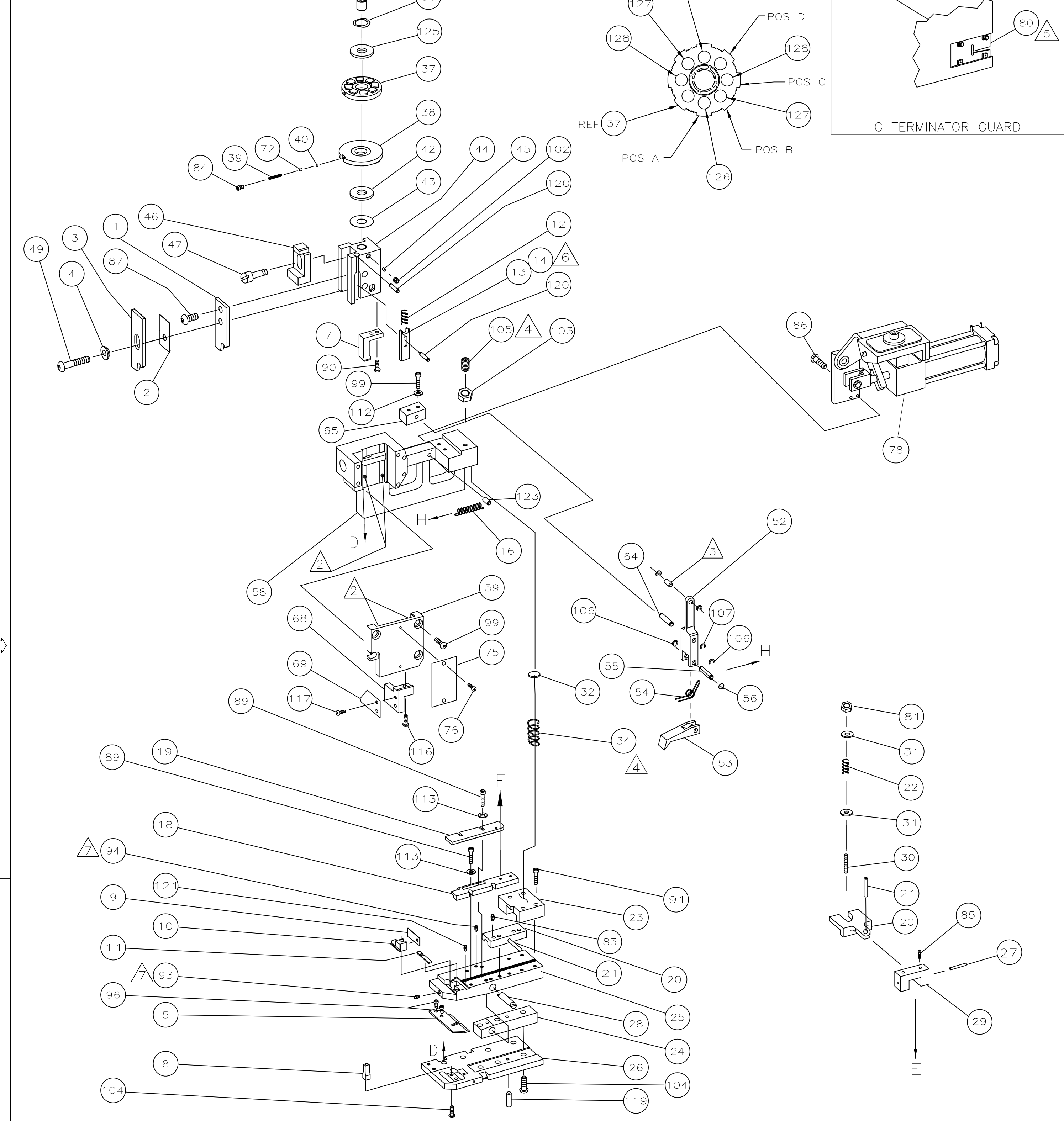


PART NUMBER	REV	FIRST USED
687394-8	G	354500-1



- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 4 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.
- 5 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 6 TO DETERMINE PROPER TERMINAL POSITIONER REFER TO AMP FORM 6140-4
- 7 USE SEALANT PN 1-23419-5 AS SHOWN

TERMINAL NAME: RECEPTACLE, FASTON™.187 SERIES FLAG			
PAD LTR	CRIMP HEIGHT		WIRE SIZE
	A	.040 ±.002 [1.02 ±.05mm]	16
B	.037 ±.002 [0.94 ±.05mm]	18	
C	.035 ±.002 [0.89 ±.05mm]	20	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.140 [3.56mm]	TAB-LOCK	20 - 16
INSUL	.140 [3.56mm]	0	.110 - .170

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.148-.168	114-2078	.510	408-8037	-	L1815

QTY	REV	DESCRIPTION	ITEM NO
2	-	C 4-354779-8 PIN, WIRE DISC (.3230)C	129
2	-	C 4-354779-7 PIN, WIRE DISC (.3225)B	127
2	-	C 4-354779-2 PIN, WIRE DISC (.3200)A	126
1	-	A 986950-1 WASHER, FLAT PRECISION	125
1	-	A 4-22183-2 PIN, GROOVE (Ø.187X2.00)	123
1	-	A 3-21028-2 PIN, SLOTTED SPRING (Ø.094X.25)	121
2	-	A 4-21028-9 PIN, SLOTTED SPRING (Ø.125X.38)	120
1	-	A 21029-5 PIN,SLOTTED SPRING (Ø.188X.75)	119
1	-	A 1-21002-6 SCREW, SBHC (6-32 x .25) STOP	117
1	-	A 2-22603-1 SCREW, HEX HD(8-32X.38) MTG	116
1	-	A 21024-4 WASHER, LOCK (#8)	113
2	-	A 21024-5 WASHER, LOCK (#10)	112
4	-	A 21024-4 WASHER, LOCK (#8)	113
2	-	A 21024-5 WASHER, LOCK (#10)	112
1	-	A 1-21986-2 RING,RET "E" Ø3/16	107
2	-	A 21045-3 RING,RET "C" Ø3/16	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
1	-	A 1-22202-7 NUT, HEX (5/16-24)	103
1	-	A 21009-2 SCREW,SKT SET(1/4-20X.25)	102
6	-	A 3-21000-8 SCREW, SHC (10-32X.88)	99
2	-	A 7-21000-6 SCREW, SHC (10-32X.38)	96
1	-	A 4-21006-5 SCREW, SKT SET (8-32X.62)	94
1	-	A 21061-9 SCREW, SKT SET (8-32X.25)	93
4	-	A 2-21000-9 SCREW, SHC (8-32X.75)	91
2	-	A 1-23030-1 SCREW, SHC (NYLOK)(8-32X.62)	90
4	-	A 2-22603-3 SCREW, HEX HC (8-32X.62)	89
1	-	A 2-21002-1 SCREW, BHC (8-32X.38)	87
2	-	A 21001-3 SCREW,SHC (1/4-20X.62)	86
2	-	A 2-21000-8 SCREW, SHC (8-32X.62)	85
1	-	A 23030-1 SCREW, SHC(NYLOK)(6-32X.25)	84
1	-	A 21022-3 NUT, HEX SELF LOCK (10-32)	81
REF	-	A 679532-1 PLATE, APPL MNT	80
1	-	D 462622-2 AIR FEED ASSEMBLY	78
2	-	A 21017-2 SCR,DRIVE(#2X.19)ID	76
1	-	B 461264-1 PLATE, IDENTIFICATION	75
1	-	A 690603-1 SPRING, ASSIST	72

QTY	REV	DESCRIPTION	ITEM NO
1	-	C 318528-1 CAP, RAM	59
1	-	D 457079-1 HOUSING	58
1	-	B 25745-1 RING, SPLIT	56
1	-	B 240624-1 PIN, FEED FINGER	55
1	-	B 691499-1 SPRING, FEED FINGER	54
1	-	B 454568-1 FINGER, FEED	53
1	-	B 457057-1 ARM, PIVOT	52
1	-	A 3-21002-5 BOLT, CRIMPER	49
1	-	A 22353-8 SCREW, SHOULDER	47
1	-	A 690578-1 BLOCK, INSULATION ADJUST	46
1	-	A 690191-1 PLUG, NYLON	45
1	-	C 454574-1 RAM	44
1	-	A 690125-1 WASHER, LAMINATED	43
1	-	A 1-690124-1 WASHER, RAM	42
1	-	A 23241-6 BALL, STEEL	41
1	-	A 690170-1 SPRING, COMPRESSION	39
1	-	C 690142-1 DISC, INSULATION	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
1	-	A 690573-1 SPACER, SPRING	32
2	-	A 1-21899-3 WASHER, FLAT	31
1	-	A 1-22354-8 STUD, DRAG	30
1	1	A 454569-1 DRAG MOUNT	29
1	-	B 1633530-1 PIN, HINGE	28
1	-	A 21030-2 DRAG SPRING MOUNT	27
1	-	C 684905-1 PLATE, BASE	26
1	-	B 454579-2 HINGE BAR	25
1	-	B 690571-1 BLOCK, STABILIZER	24
1	-	C 690585-1 BLOCK, PRESSURE	23
1	-	A 8-22282-6 SPRING, DRAG	22
1	-	A 21030-6 LEVER, DRAG	21
1	-	A 454570-1 DRAG, STOCK	20
1	-	C 454573-1 GUIDE, STRIP (REAR)	19
1	-	C 318739-6 GUIDE, STRIP (FRONT)	18
1	-	A 2-22287-6 SPRING, EXTENSION	16
1	-	B 1-692134-1 POSITIONER,TERMINAL	14
1	-	B 692134-7 POSITIONER,TERMINAL	13
1	-	A 5-22280-5 SPRING,TERM. POSITIONER	12
1	-	B 454712-3 PLATE, REAR SHEAR	11
1	-	B 454578-1 ANVIL INSERT	10
1	-	C 690569-2 PLATE, FRONT SHEAR	9
1	-	A 690718-1 ANVIL	8
1	-	B 454575-1 BLADE, SLUG	7
1	-	B 684906-1 PLATE,ANVIL RETAINING	5
1	-	B 690574-1 SPACER,TUBULAR INSUL CRIMPER	4
1	-	C 690715-1 CRIMPER, INSULATION	3
1	-	C 690716-3 CRIMPER, WIRE	1

LOC A
DIST 66

QTY	REV	DESCRIPTION	ITEM NO
1	-	A 690603-1 SPRING, ASSIST	72

QTY	REV	DESCRIPTION	ITEM NO
1	-	C 690716-3 CRIMPER, WIRE	1

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JAN 4, 1999

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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 Jc Baker	11/6/96	APP J.DODDS
CHK C ERISMAN	11/6/96	REL

NAME: END FEED HINGE BAR APPLICATOR MACHINE REF: MINI APPL
 SCALE: D DWG NO: 687394-8 SHEET 1 OF 1 REV G