

PART NUMBER	REV	FIRST USED
819528-1	M	-

CRIMPING DATA				
PAD LTR	CRIMP HEIGHT	WIRE SIZE		
A	.071	14		
B	.063	16		
C	.057	18		
D	NOT USED			
CRIMP SIZE	TYPE	FEED	APPL INST	
WIRE .120	F	.755±.005	A1 8091	
INSUL .180	Q			
WIRE RANGE	INSULATION RANGE	MACHINE NO		
18-14	.150 MAX	467000-4		
REMARKS				
STRIPPING CAPABILITY LIMITED TO CERTAIN INSULATION TYPES.				
SET-UP GAGE	10:1 83			
APPLICATOR WILL APPLY				
63317	-	-		
63316	-	-		
63315	-	-		
63314	-	-		
63512	-	-		
63582	-	-		
-	-	-		
-	-	-		

QTY	REF	DESCRIPTION	ITEM NO
1	A	852421-1 PIN, MODIFIED DOWEL	198
1	A	844445-1 SPACER	197
1	C	844490-1 MOUNT, JAW SLIDE	196
1	C	854104-1 PLATE, SIDE MOUNT	195
1	C	844492-1 MOUNT, CYLINDER	194
1	C	844493-1 LEVER, DRIVE	193
1	A	843137-1 ROLLER	192
1	B	844487-1 BACK UP, SPRING	191
1	B	844486-1 GUIDE, SPRING	190
			189
			188
			187
1	A	354218-1 COVER, SCRAP	186
			185
			184
			183
3	A	2-21000-6 SCREW, SHC (8-32 x .38)	182
2	A	2-21002-3 SCREW, BHSC (8-32 x .62)	181
			180
			179
			178
			177
1	B	844446-1 CAM	176
1	B	820631-1 SLIDE, BOTTOM	175
1	B	820626-1 BLOCK, SCREW MOUNTING	174
1	B	820630-1 CAM, STRIP BLADE	173
			172
1	A	820628-1 CAP, RIGHT RAM	171
			170
1	A	820625-1 PIN, ECCENTRIC	169
			168
1	A	820623-1 LINK, CAM	167
1	B	820622-1 BLOCK, LINK PIVOT	166
			165
1	C	820499-1 SLIDE, BOTTOM STRIP BLADE	164
1	B	820574-1 BLOCK, CAM	163
1	B	820575-1 SCREW, ADJUSTMENT	162
1	B	820576-1 SLIDE, TOP STRIP BLADE	161
			160
1	A	819397-1 SPACER, SHEAR PLATE, REAR	159
1	B	820191-1 PLATE, HOLD DOWN	158
2	A	21017-2 SCREW, RH DRIVE (#2 x .19)	157
1	B	461264-1 PLATE, IDENTIFICATION	156
1	A	454671-1 INSULATION, ACOUSTICAL	155
1	A	820190-1 PLATE, SWITCH, MOUNT	154
1	A	24333-1 SWITCH, PRESSURE SENSITIVE	153
REF	A	820001-1 SPACER	152
1	A	5-21028-4 PIN, SLT SPR (.125 DIA x .69)	151
REF	A	24042-2 VALVE, SLEEVE, 3-WAY	150
			149
REF	A	22311-2 NIPPLE, CLOSE	148
			147
2	A	22304-5 NIPPLE, HEX, PIPE FITTING	146
46.00	IN	A 27319-1 TUBING, POLY-FLO	145
REF	A	23238-1 INSERT, COUPLING	144
REF	A	26108-1 BODY, COUPLING, QUICK-CONNECT	143
REF	A	22306-1 ELBOW, STREET, 90	142
REF	A	22295-8 FITTING, PLASTIC TUBING, MALE	141

QTY	REF	DESCRIPTION	ITEM NO
-1	U/M	REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)	
		PARTS LIST	

QTY	REF	DESCRIPTION	ITEM NO
REF	A	23791-1 TEE, PIPE FITTING, FEMALE BRANCH	140
REF	A	26524-1 MUFFLER, EXHAUST	139
1	A	23238-1 INSERT, COUPLING	138
REF	A	22295-7 FITTING, PLASTIC TUBING, MALE	137
2	A	22294-6 ELBOW, PLASTIC TUBING, MALE	136
REF	A	2-21002-2 SCREW, BHCS (8-32 x .50)	135
REF	A	25435-1 VALVE, SINGLE SOLENOID, 4 WAY	134
1	A	23054-1 VALVE, FLOW CONTROL	133
			132
1	A	22374-1 VALVE, QUICK EXHAUST	131
REF	A	28582-1 LUBRICATOR, AIR LINE, MINIATURE	130
REF	A	28581-2 REGULATOR, PRESSURE, MINIATURE	129
REF	A	28580-3 FILTER, AIR LINE, MINIATURE	128
REF	A	23739-1 VALVE, CONTROL, LIMIT	127
1	D	820012-1 GUARD, REAR	126
REF	C	820011-1 BRACKET, REGULATOR	125
REF	B	819999-1 PLATE, SWITCH	124
REF	B	820000-1 CAM, ACTUATOR	123
1	D	820010-1 GUARD, FRONT, UPPER	122
1	D	820009-1 GUARD, FRONT, LOWER	121
5	A	1-21002-7 SCREW, BHSC (6-32 x .38)	120
1	A	1-25482-3 CAM FOLLOWER (SEALED)	119
			118
1	A	1-21029-7 PIN, SLTD SPR (.188 x 2.00)	117
			116
3	A	3-21000-5 SCREW, SHC (10-32 x .50)	115
1	A	9-22279-4 SPRING, COMPRESSION	114
			113
1	B	820005-1 HOLD-DOWN, TERMINAL	112
4	A	2-21002-8 SCREW, BHSC (10-32 x .62)	111
4	A	1-21000-5 SCREW, SHC (4-40 x .50)	110
2	A	1-21000-3 SCREW, SHC (4-40 x .25)	109
1	A	7-22282-5 SPRING, COMPRESSION	108
1	A	374999 TENSION ADJUSTING PLATE	107
2	A	21018-6 NUT, HEX (8-32)	106
2	A	21078-8 SCREW, SET (8-32 x .50)	105
4	A	1-21000-9 SCREW, SHC (6-32 x .38)	104
1	A	690517-1 SPACER, ADJ PLT	103
1	B	820496-3 BLADE, TOP (14 AWG)	102
1	B	820496-2 BLADE, TOP (16 AWG)	101
1	B	820496-1 BLADE, TOP (18 AWG)	100
1	B	820497-3 BLADE, BOTTOM (14 AWG)	99
1	B	820497-2 BLADE, BOTTOM (16 AWG)	98
1	B	820497-1 BLADE, BOTTOM (18 AWG)	97
1	A	690191-4 PLUG, NYLON (.187 DIA x .19)	96
2	A	3-21000-8 SCREW, SHC (10-32 x .88)	95
1	C	844297-1 CAP, RAM, LEFT	94
1	A	844489-1 CYLINDER, AIR, MODIFIED	93
1	A	21009-6 SCREW, SET, SELF-LOCKING	92
9	A	2-21000-7 SCREW, SHC (8-32 x .50)	91
1	A	7-21028-2 PIN, SLTD SPR (.156 DIA x .75)	90
1	C	819398-1 BLADE, SLUG	89
2	A	21018-5 NUT, HEX #6	88
1	B	819413-1 JAW, UPPER	87
2	A	21055-5 WASHER, FLAT #6	86
			85
1	A	853818-1 PLATE, EJECTOR FRONT	84
2	A	458778-3 SPACER	83
2	A	2-21000-1 SCREW SHC 6-32X.62	82
1	A	21007-1 SCREW, SET (1/4-20 x .18)	81
			80
1	C	844488-1 SLIDE, MODIFIED	79
1	A	21009-2 SCREW, SET, SELF-LOCKING	78
1	A	690191-1 PLUG, NYLON (.125 DIA x .19)	77
1	A	819420-1 SPACER, MOUNT	76
1	B	819421-1 FINGER, FEED	75
2	A	3-21002-4 SCREW, BHSC (1/4-20 x .62)	74
3	A	2-21000-9 SCREW, SHC (8-32 x .75)	73
2	A	1-21028-1 PIN, SLTD SPR (.062 DIA x .812)	72
2	A	4-21000-0 SCREW, SHC (10-32 x 1.25)	71

QTY	REF	DESCRIPTION	ITEM NO
-1	U/M	REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)	
		PARTS LIST	

QTY	REF	DESCRIPTION	ITEM NO
1	D	844494-1 JAW, LOWER	70
			69
1	A	21055-8 WASHER, FLAT (1/4)	68
			67
			66
6	A	2-21000-0 SCREW, SHC (6-32 x .50)	65
2	A	819391-1 GUIDE, FEED PAWL	64
2	B	819393-1 GUIDE, STRIP, FRONT	63
3	A	2-21000-5 SCREW, SHC (8-32 x .25)	62
			61
1	A	5-21006-1 SCREW, SET (10-32 x .38)	60
1	A	1-21030-9 PIN, DOWEL (.188 DIA x 2.00)	59
			58
1	A	21020-1 NUT, HEX, JAM (1/4-20)	57
1	A	1-21007-4 SCR SOC SET (1/4-20 X 2.00)	56
1	A	1-21989-5 SCR, SHLD, (.188 X 1.25)	55
1	A	22733-7 SCREW, BHSC, SELF-LOCKING	54
1	B	819404-1 ANVIL	53
2	A	1-21002-9 SCREW, BHC (6-32 x .62)	52
1	B	819396-1 PLATE, SHEAR, REAR	51
1	A	819395-1 SPACER SHEAR PLATE, FRONT	50
1	A	819403-1 PLATE, FRONT SHEAR	49
1	C	819392-1 PLATE, STRIP GUIDE	48
1	D	854099-1 PLATE, BASE	47
1	D	819390-1 RAM	46
2	A	21022-3 NUT, HEX, SELF LOCKING (10-32)	45
2	A	2-22281-5 SPRING, COMPRESSION	44
1	A	21055-6 WASHER, FLAT (#8)	43
2	A	4-21000-0 SCREW, SHC (10-32 X 1.25)	42
1	B	819389-1 DRAG	41
1	B	819419-1 MOUNT, FEED BRACKET	40
2	A	21024-5 WASHER, SPRING LOCK (#10)	39
4	A	21055-7 WASHER, FLAT (#10)	38
2	A	4-21000-1 SCREW, SHC (10-32 x 1.50)	37
1	A	3-21001-4 SCREW, SHC (3/8-16 x .88)	36
1	A	21001-1 SCREW, SHC (1/4-20 x .38)	35
2	A	1-21001-0 SCR, SHC (1/4-20 X 2.00 LG)	34
1	C	819444-1 HOUSING, APPLICATOR	33
3	A	2-22733-8 SCREW, BHSC (1/4-20 x .75)	32
2	A	3-21001-5 SCREW, SHC (3/8-16 x 1.00)	31
1	C	819374-1 CRIMPER, WIRE .120 "F"	30
1	C	819373-1 SPACER, INSULATION	29
1	A	6-21002-6 SCREW, BHSC (10-24 x .88)	28
1	A	819422-1 SPACER, CRIMPER SCREW	27
1	B	819372-1 CRIMPER, INSULATION "0"	26
2	A	3-21000-0 SCREW, SHC (8-32 x .88)	25
1	A	22292-2 COLLAR, SHAFT (.18 ID)	24
2	A	21045-6 RING, RETAINING, EXT CRESCENT	23
1	A	2-23620-9 PIN, STRAIGHT, GROOVE (.250 DIA)	22
2	A	1-22170-8 PIN, COTTER	21
1	A	22202-4 NUT, HEX, JAM (5/16-24)	20
2	A	23241-6 BALL, STEEL	19
2	A	690603-1 SPRING ASSIST	18
2	A	690170-1 SPRING, COMPRESSION	17
2	A	23030-1 SCREW, SHC, SELF-LOCKING	16
1	A	22480-5 WASHER, WAVE SPRING	15
1	C	690142-3 DISC, INSULATION CRIMP ADJUSTMENT	14
1	B	690212-1 POST, RAM	13
1	C	6-690141-8 DISC, WIRE CRIMP ADJUSTMENT	12
1	A	690125-1 SHIM STOCK	11
1	A	690124-1 WASHER, RAM	10
1	C	468528-1 CYLINDER, AIR	9
1	A	388639-2 GUIDE ROD	8
1	B	461686-2 CLEVIS, FEED	7
1	C	459609-1 BRACKET, FEED ADJUSTMENT	6
1	B	376170 PISTON POSITIONER	5
1	A	376169 FEED ADJUSTING SCREW	4
1	A	376166 FEED ADJUSTMENT BLOCK	3
1	A	376165 CLAMP WASHER	2
1	A	374112 SPRING, FEED FINGER	1

QTY	REF	DESCRIPTION	ITEM NO
-1	U/M	REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)	
		PARTS LIST	

1. RECOMMENDED SPARE PARTS
2. QUANTITIES IN INCHES
3. OPTIONAL EQUIPMENT
4. ADD .002 TO .004 SHIM IF REQUIRED.
5. GREASE LIGHTLY.
6. USE ANTI SEIZE WHEN INSTALLING ITEM 93 INTO ITEM 194.

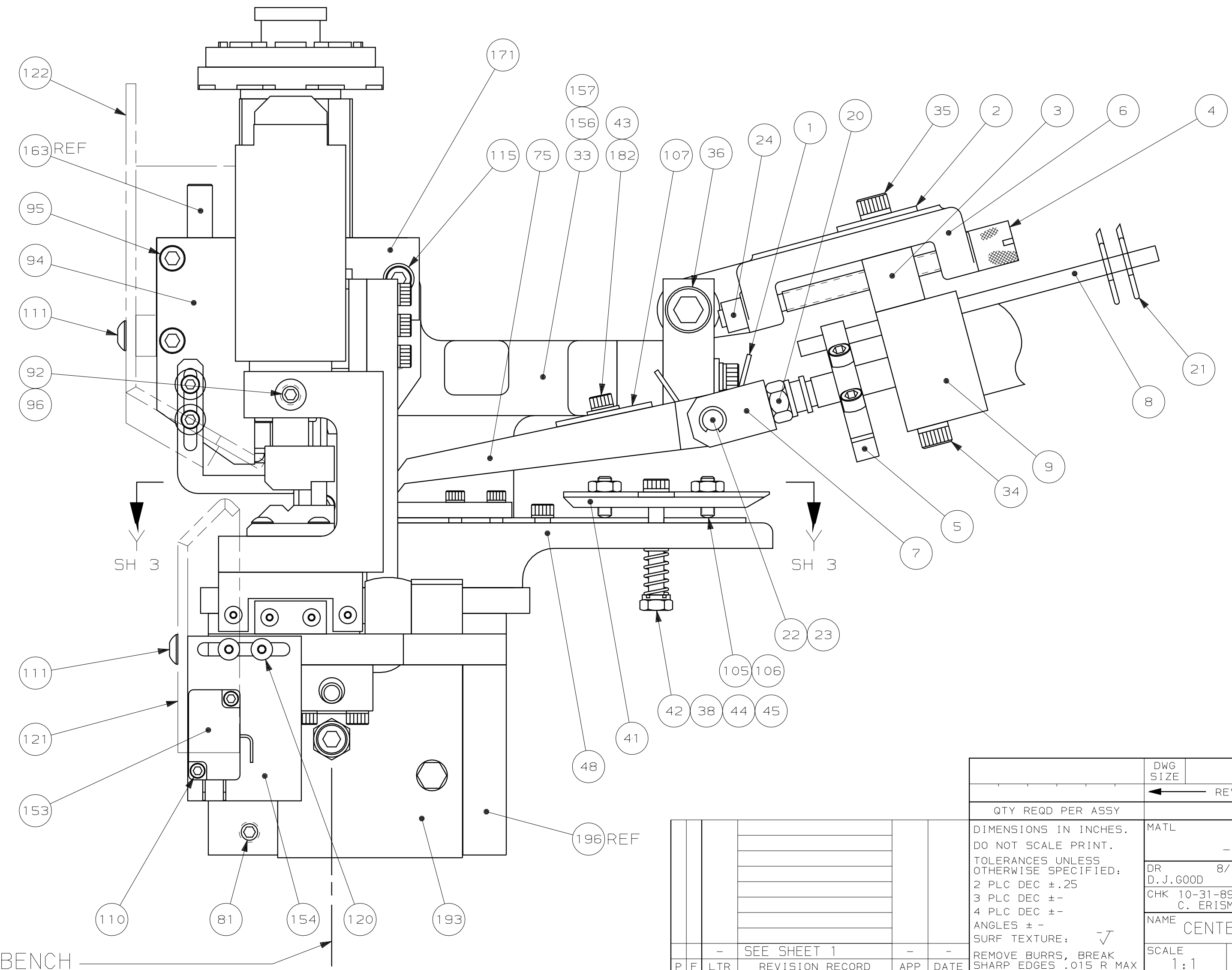
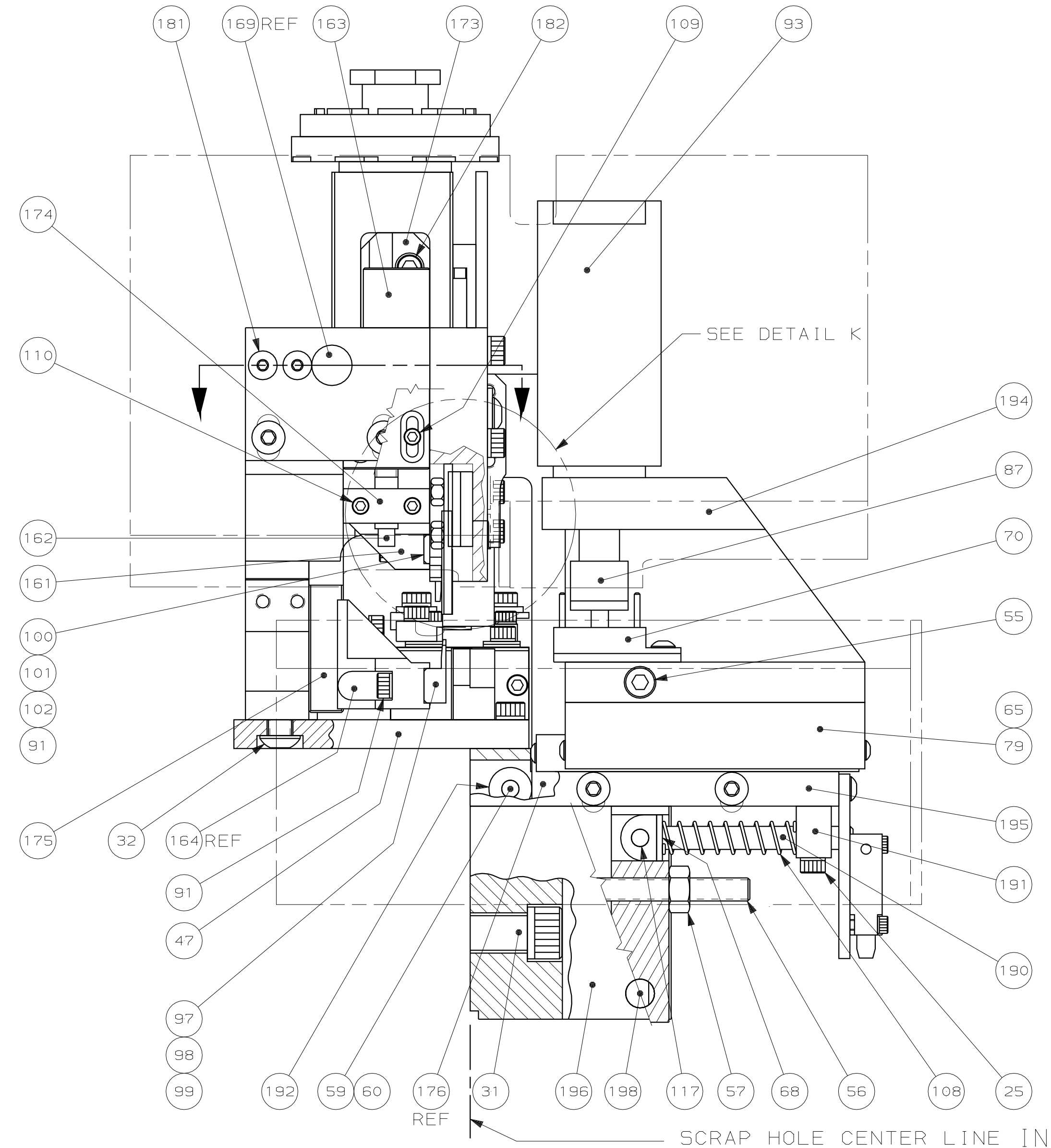
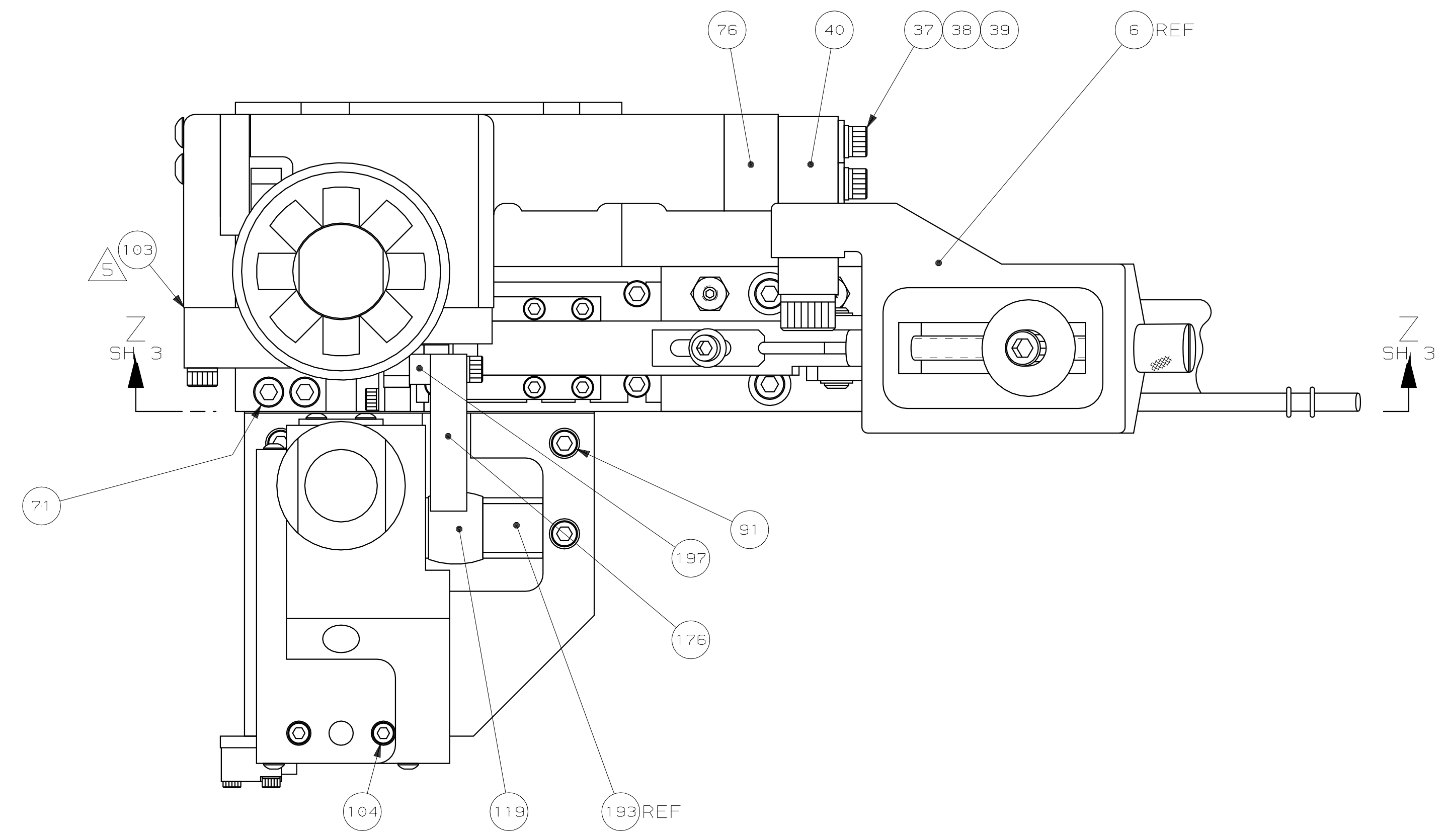
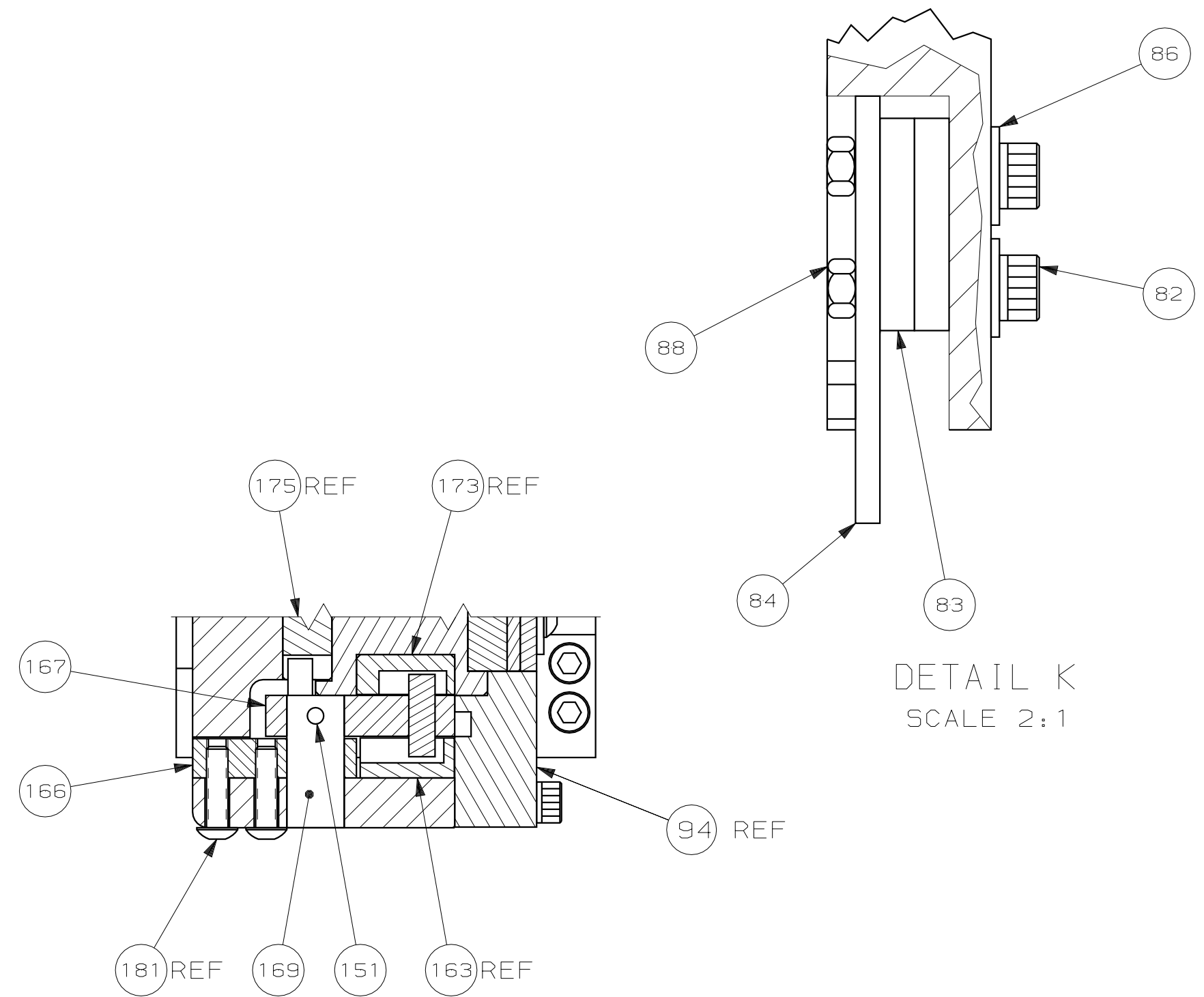
NOTE TO CUSTOMER: FOR PROPER SCRAP REMOVAL A 1" HOLE MUST BE DRILLED IN YOUR BENCH. SEE SHEET 2 FOR LOCATION.

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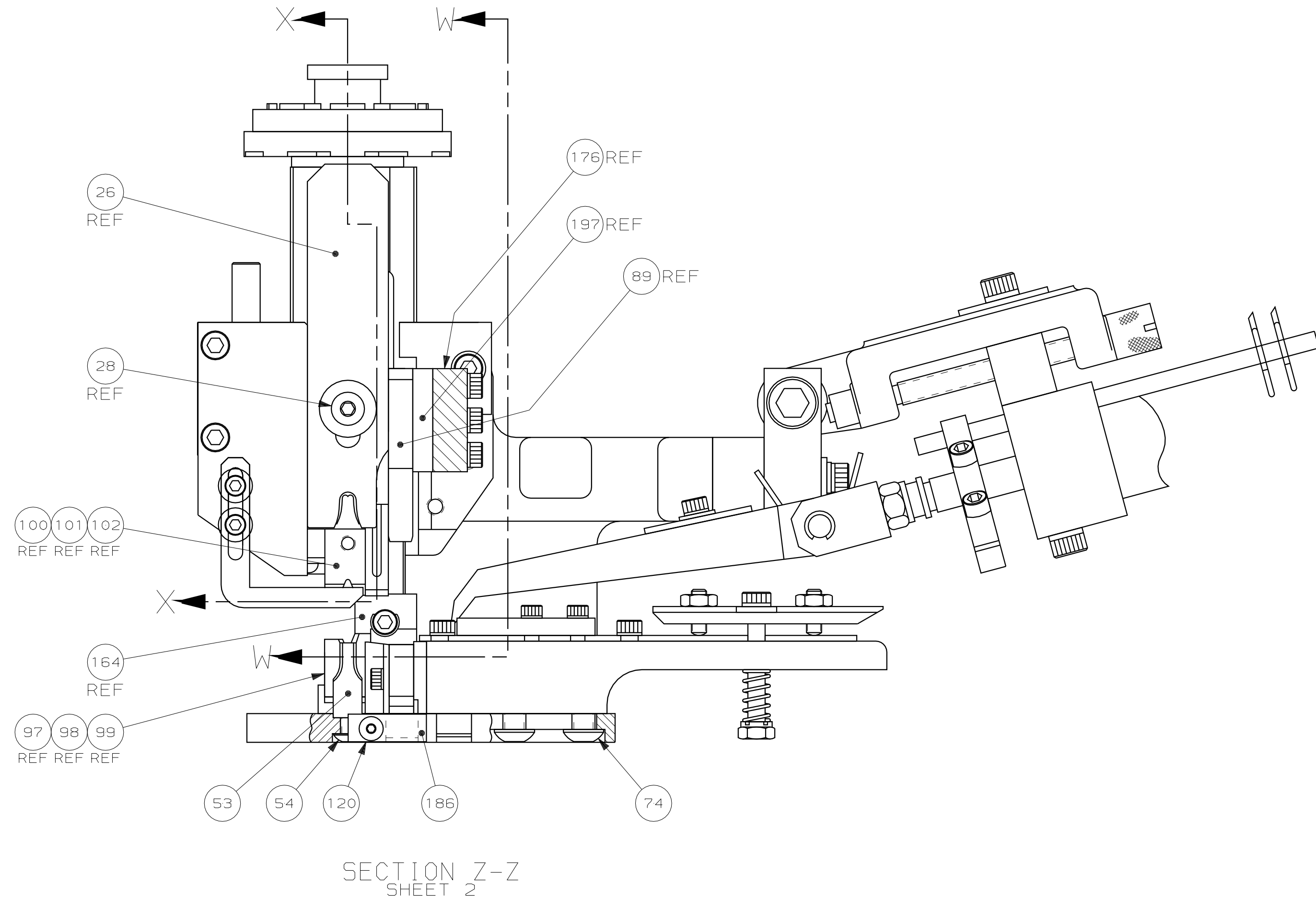
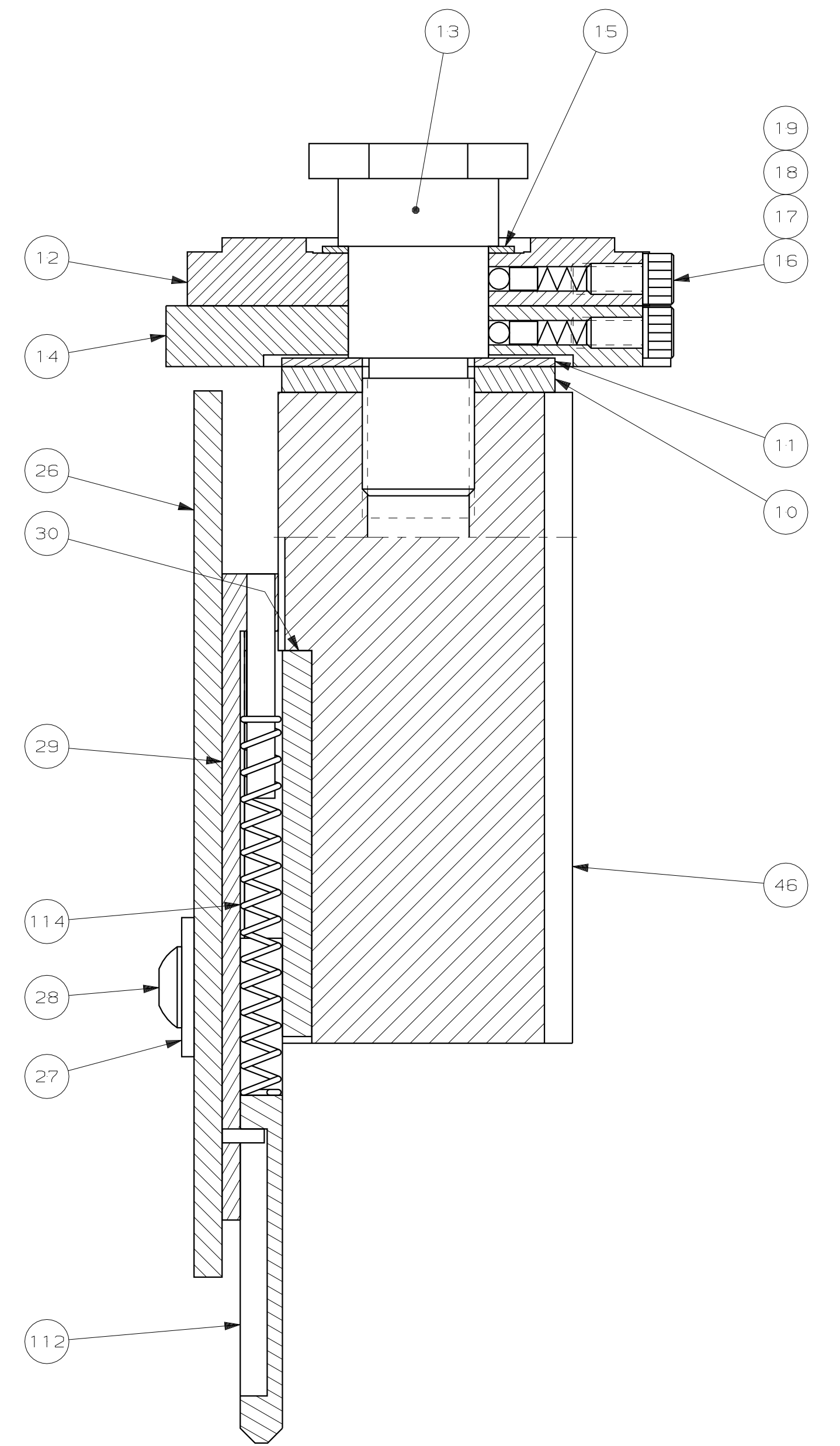
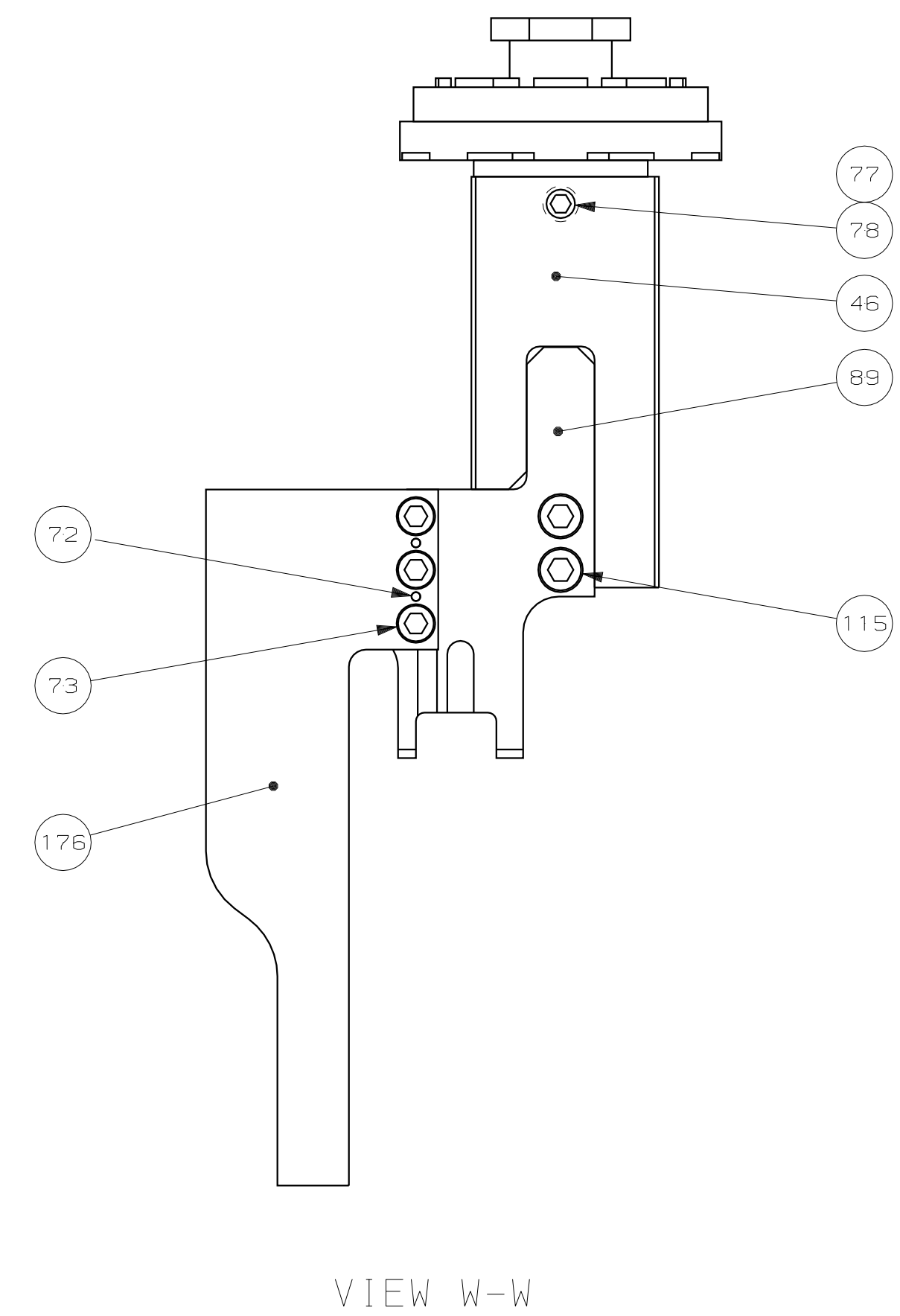
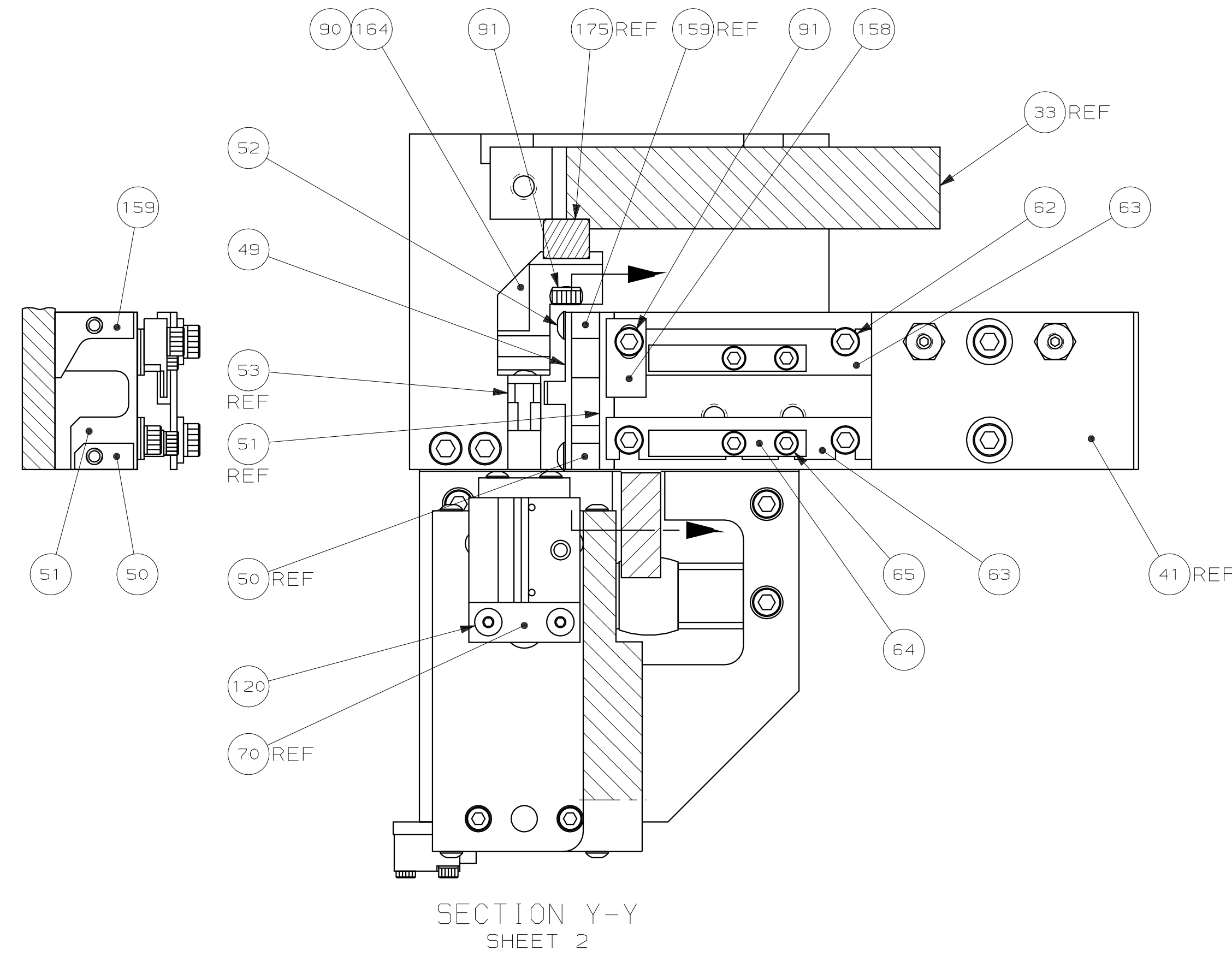
LOC A
DIST 66

DWG SIZE	PART NO	DESCRIPTION	ITEM NO		
		REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)			
QTY REQD PER ASSY		PARTS LIST			
MATL	HT TR	FIN			
DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED:		AMP INCORPORATED Harrisburg, Pa. 17105			
DR	8/11/89			APP	-
CHK	10-31-89			REL	1-25-90
3	PLC DEC ±			C. ERISMAN	B. MCPHERSON
NAME		MACHINE REF			
CENTER STRIP APPLICATOR ASSEMBLY		CENTER STRIP MACHINE			
SCALE	DWG NO	SHEET	REV		
1:1	819528-1	2 OF 4	M		

REV	DESCRIPTION	DATE
-	SEE SHEET 1	-
P/F	LTR	REVISION RECORD
	APP	DATE

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VIEW W-W

SECTION X-X
SCALE 2:1

LOC A
DIST 66

REV	DESCRIPTION	APP	DATE
1	SEE SHEET 1		

DWG SIZE	PART NO	DESCRIPTION	ITEM NO
		REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)	
QTY REQD PER ASSY		PARTS LIST	
MATL	HT TR	FIN	
DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED:			
2	PLC DEC ± .25		
3	PLC DEC ±		
4	PLC DEC ±		
ANGLES ±			
SURF TEXTURE: ✓			
REMOVE BURRS, BREAK SHARP EDGES .015 R MAX			
SCALE 1:1	DWG NO 819528-1	MACHINE REF CENTER STRIP MACHINE	ITEM NO
		SHEET 3 OF 4	REV M

SECTION Z-Z
SHEET 2

1-825618
D
C
B
A

