

PART NUMBER	REV	FIRST USED
567858-1	B	854040-4

318368		VISIBLE	CRIMPING DATA		
PAD	LTR		CRIMP HEIGHT	WIRE SIZE	
A			.047 ±.002 [1.19 ±0.05mm]	18	
B			NOT	USED	
C			NOT	USED	
D			NOT	USED	
		CRIMP	SIZE	TYPE	RANGE
		WIRE	.076 [1.93mm]	F	18
		INSUL	.115 (2.92mm)	0	φ.090 MAX
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.217-.236	NONE	.575	SEE CUSTOMER MANUAL	NONE	L1668

STANDARD FORCE CRIMP QUALITY MONITOR APPLICATOR
SIM TO HDM 680191

QTY	REV	DESCRIPTION	ITEM NO		
1	-	A	2-21010-7	SCR, SET (6-32x.12) LIFT ARM	67
1	-	B	1-21002-6	SCR, BHC (6-32x.25) LEVER	66
1	-	B	856044-1	LEVER, SLIDE LOCK	65
1	-	A	2-21000-0	SCR, SHC (6-32x.50) LIFT ARM	64
1	-	B	856043-1	ARM, LIFT	63
1	-	A	2-21000-6	SCR, SHC (8-32x.38) EXT ARM	62
1	-	B	856042-1	ARM, EXTENSION	61
					60
					59
					58
1	-	A	7-21013-3	SCR, SET (5/16x.38) CR BOLT	57
REF	-	B	694433-8	PAWL, FEED	56
					55
					54
					53
					52
1	-	A	811242-2	BUMPER, HOLDDOWN	51
1	-	A	690753-1	SPACER, TONKER	50
					49
1	-	A	690602-6	CAM, PRE-FEED 1.62 STROKE	48
					47
					46
1	-	A	690191-1	PLUG, NYLON	45
1	-	C	853493-4	SIDE FEED RAM ASSY	44
1	-	A	690125-1	WASHER, LAMINATED	43
1	-	A	690124-1	WASHER, RAM	42
1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)	41
1	-	A	23241-6	BALL, STEEL	40
1	-	A	690170-1	SPRING, COMPRESSION	39
1	-	C	690142-1	DISC, INSULATION	38
1	-	D	354777-1	WIRE DISC, PLASTIC	37
1	-	A	22480-5	WASHER, SPRING	36
1	-	B	856041-1	POST, RAM	35
1	-	B	690786-1	SUPPORT, TERMINAL	34
1	-	C	462544-1	PLATE, BASE SPECIAL	33
1	-	A	690432-3	SCREW, ADJUSTMENT	32
1	-	B	462543-1	BLOCK, SCREW SPECIAL	31
1	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	-	C	455671-1	PLATE, STRIP GUIDE	29
1	-	C	455888-4	SPACER, FRONT SHEAR DEP	28
2	-	A	1-22284-0	SPRING, DRAG	27
1	-	B	690546-1	LEVER, DRAG RELEASE	26
1	-	B	240792-1	DRAG, TERMINAL	25
1	-	D	9-690504-2	GUIDE, STRIP (REAR)	24
1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
					22
1	-	A	463756-1	GUIDE, SCRAP	21
1	-	A	904275-1	SUPPORT, SPRING	20
REF	-	C	462615-1	STRIPPER	19
					18
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1	-	A	6-22279-4	SPRING, SHEAR	12
1	-	B	690461-2	STOP, SHEAR (FRONT)	11
1	-	B	462548-3	HOLDER, SHEAR (FRONT) SP	10
1	-	B	462547-3	SHEAR, FLOAT (FRONT) SP	9
1	-	C	662520-8	ANVIL	8
					7
					6
1	-	A	462838-3	DEPRESSOR, SHEAR (FRONT) SP	5
1	-	B	238011-6	SPACER, BLOCK CRIMPER	4
1	-	C	904741-1	CRIMPER, INSULATION	3
1	-	C	455888-9	SPACER, CRIMPER	2
1	-	C	3-568176-0	CRIMPER, WIRE	1

QTY	REV	DESCRIPTION	ITEM NO		
2	-	C	5-354779-0	PIN, WIRE DISC (.3240)C	129
					128
					127
					126
1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	-	A	217238-4	DOCUMENTATION PACKAGE	124
					123
					122
1	-	A	4-21028-0	PIN, SLT SPR (φ.093x.75) ST GDE PL	121
1	-	B	690701-2	PLATE, SERIAL NO.	120
2	-	A	21899-2	WASHER, FLAT (#10) S G ADJ BLK	119
					118
2	-	A	21024-5	WASHER, LOCK (#10) ADJ BLOCK	117
					116
					115
2	-	A	21024-2	WASHER, LOCK (#4) FRONT STP GUIDE	114
REF	-	A	21024-4	WASHER, LOCK (#8) FEED FINGER	113
2	-	A	21024-4	WASHER, LOCK (#8) DEP-HOLD	112
REF	-	A	21024-4	WASHER, LOCK (#8) STRIPPER	111
					110
					109
1	-	A	21018-5	NUT, HEX (#6) HOLD DOWN	108
					107
					106
					105
					104
1	-	A	21009-2	SCR, SKT SET (1/4-20x.25 LW) RAM	103
					102
4	-	A	21017-2	SCR, DRIVE (#2x.19) ID PLATE	101
1	-	B	819347-1	PLATE, IDENTIFICATION	100
2	-	A	3-21002-0	SCR, BHC (10-32x.88) DRAG	99
1	-	A	22733-8	SCR, BHC (8-32x.38 LW) ANVIL	98
					97
1	-	A	3-21000-8	SCR, SHC (10-32x.88) MOUNTING	96
1	-	A	2-21002-7	SCR, BHC (10-32x.50) S G ADJ BLK	95
6	-	A	2-21002-2	SCR, BHC (8-32x.50) SHEAR-TERM SUP	94
					93
					92
1	-	A	1-21002-7	SCR, SHC (6-32x.50) CAM	91
2	-	A	2-21000-7	SCR, SHC (8-32x.50) SCR BLK	90
					89
					88
2	-	A	2-21000-7	SCR, SHC (8-32x.48) HLD DWN	87
REF	-	A	2-22603-0	SCR, HEX HD (8-32x.31) FEED FINGER	86
2	-	A	1-21000-3	SCR, SHC (4-40x.25) F ST GUIDE	85
REF	-	A	22733-9	SCR, BHC (8-32x.50 SL) STRIPPER	84
					83
					82
1	-	A	3-22603-1	SCR, HEX (10-32x.38) S G ADJ BL	81
					80
					79
					78
2	-	B	463310-4	BLADE, STRIPPING (#18)	77
-	-	D	354440-3	FFC LOOP ASSY	76
					75
1	-	A	690603-1	SPRING, ASSIST	74
1	-	A	23030-1	SCR, SKT CAP (6-32x.25) CP DSC	73
					72
2	-	B	853495-1	GASKET	71
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- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 ITEM NOT SHOWN
- 4 TORQUE ITEM 41 TO 60 INCH POUNDS
- 5 CUT TO LENGTH AT ASSEMBLY.
- 6 ATTACH ITEM 20 TO ITEM 33 USING ADHESIVE PART NUMBER 28998-6.

QTY	REV	DESCRIPTION	ITEM NO
-1	U/M	DWG SIZE	PART NO
			DESCRIPTION
			ITEM NO

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-1	U/M	DWG SIZE	PART NO
			DESCRIPTION
			ITEM NO

MATL - HT TR - FIN -

DR 20FEB97 APP 21FEB97
R.O. WILSON J.J. HIRNEISEN
CHK 21FEB97 REL -
C. ERISMAN

AMP AMP Incorporated
Harrisburg, PA 17105-3608

NAME: CQM STRIPPER CRIMPER APPLICATOR MACHINE REF STRIPPER CRIMPER

SCALE: D DWG NO: 567858 SHEET 1 OF 1 REV B