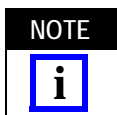


1. INTRODUCTION

The Heavy Duty Industrial (HD-I) Fine Adjust Assembly 879103-[] is used in conjunction with the side-feed and end-feed HD-I applicators described in 408-8322 and 408-8323 to provide a greater number of crimp height options without the necessity of changing parts.



Refer to 408-8322, Heavy Duty Industrial (HD-I) Side-Feed Applicators; and 408-8323, Heavy Duty Industrial (HD-I) End-Feed Applicators.



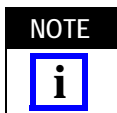
Dimensions in this document are in metric units [with U.S. customary units in brackets].

2. DESCRIPTION

HD-I Fine Adjust Assembly 879103-[] consists of a ram post, a wire crimp height adjustment disc, and an insulation crimp height adjustment disc (see Figure 1), which replace the ram post, wave washer, wire disc, insulation crimp disc, and shim on the applicators shown in 408-8322 and 408-8323. In addition, Fine Adjust Assembly 879103-[] uses a spacer that replaces the normal production spacer.

2.1. Wire Crimp Height Adjustment Disc

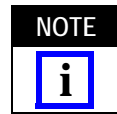
The wire crimp height adjustment disc in this assembly is an adjustable plate with fifty-four increment notches, as opposed to the four pin settings available on the standard HD-I applicator wire crimp height adjustment disc. Each increment represents a change in crimp height of 0.015 [.0006]. Turning the crimp height adjustment disc clockwise decreases the crimp height; turning the disc counterclockwise increases the crimp height.



Every tenth increment is denoted by a letter ("A" to "F") with the increments between each letter represented numerically ("1" to "9"). Wire sizes and their relevant crimp heights will be listed on the log sheet with the corresponding reference setting, such as "A6," "C4," and so forth.

2.2. Insulation Crimp Height Adjustment Disc

The insulation crimp height adjustment disc in this assembly is a plate with twelve variable pad heights, as opposed to the eight-pad insulation crimp disc in the standard HD-I applicator. Each pad represents a change in insulation crimp height of 0.15 [.006]. Turning the lower disc clockwise decreases the insulation crimp height; turning the disc counterclockwise increases the insulation crimp height.



Insulation crimp height is normally a non-measured dimension and varies according to the diameter of insulation being used.

3. REMOVAL AND RE-ASSEMBLY

The HD-I Fine Adjust Assembly 879103-[] is factory installed and should require no further adjustment. If the assembly must be removed from the ram (Item 44 in 408-8322 and 408-8323), be sure to loosen ram post locking set screw (Item 63 in 408-8322 and 408-8323). The ram post can then be removed. Upon re-assembly, be sure that the two ball detents on the fine adjust assembly are aligned with the centerline of the insulation crimper and oriented relative to the front of the tooling (as shown in Figure 1). Ensure that the correct spacer (as per the appropriate applicator log) is re-assembled. Be sure that the ram post and ram post locking set screw are tight before re-installing the applicator into the appropriate terminating unit.

4. REVISION SUMMARY

Since the previous version of this document, the following changes were made:

- Updated document to corporate requirements.

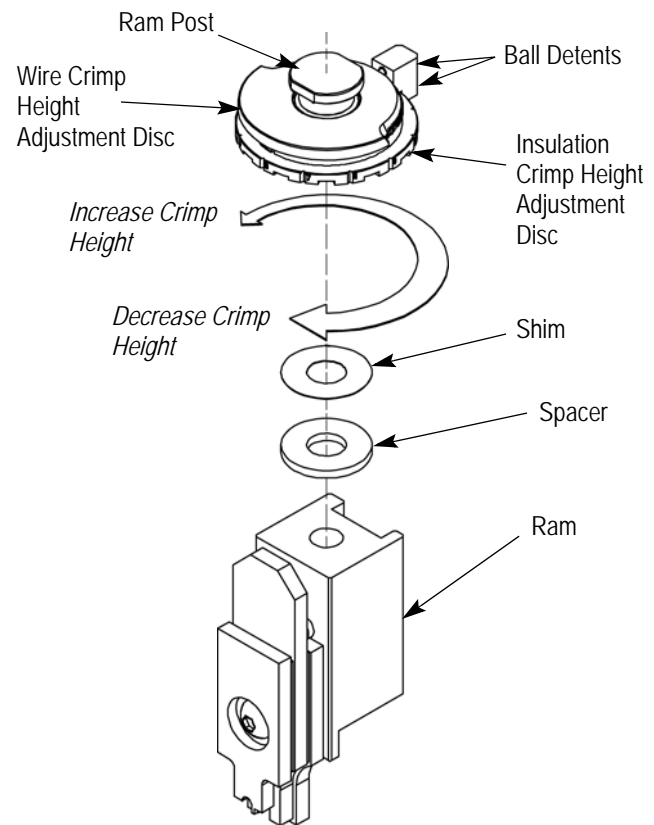


Figure 1