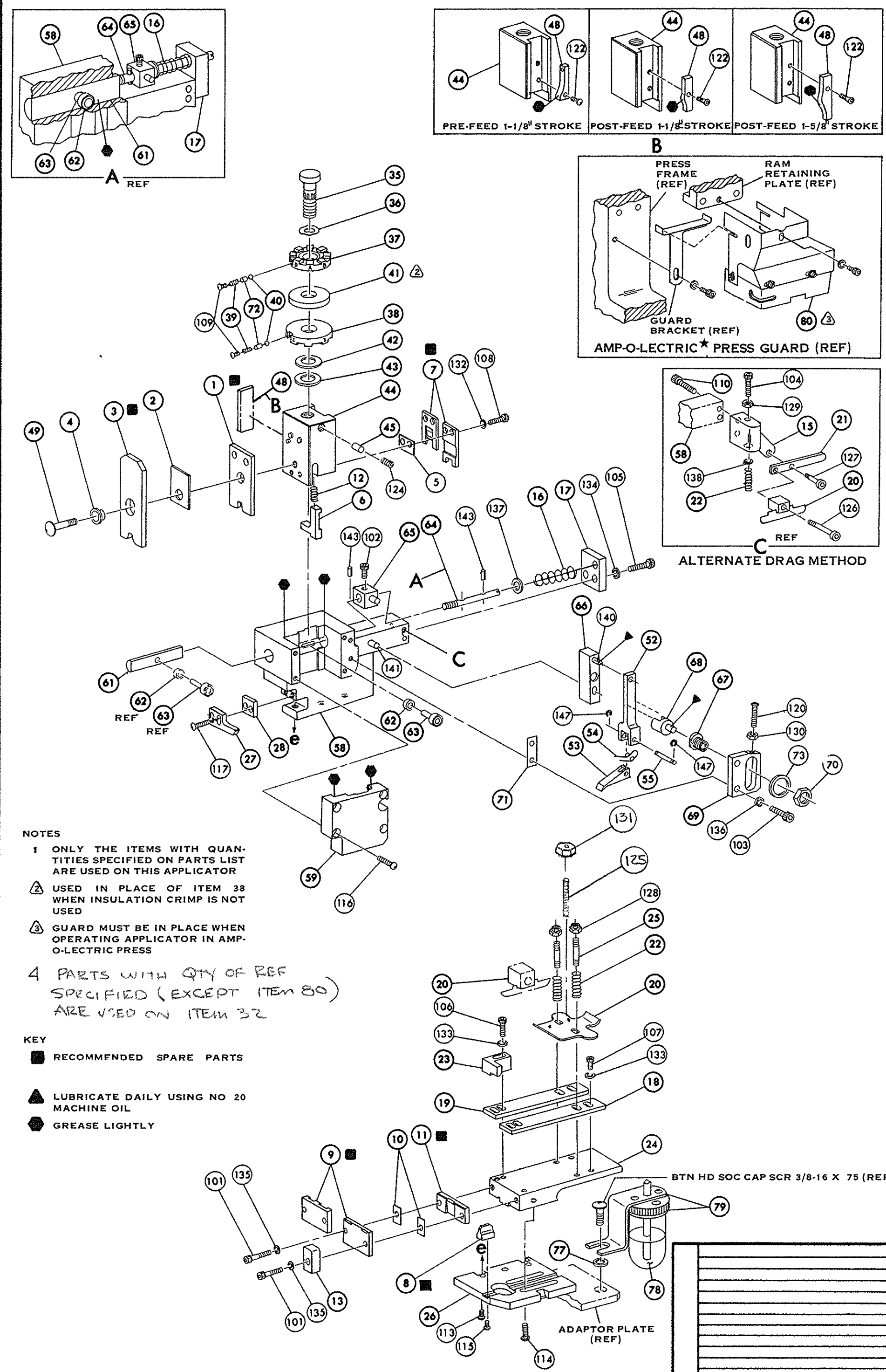


THIS IS A CONTROLLED DOCUMENT



NOTES

1 ONLY THE ITEMS WITH QUANTITIES SPECIFIED ON PARTS LIST ARE USED ON THIS APPLICATOR

⚠ USED IN PLACE OF ITEM 38 WHEN INSULATION CRIMP IS NOT USED

⚠ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-O-LECTRIC PRESS

4 PARTS WITH QTY OF REF SPECIFIED (EXCEPT ITEM 80) ARE USED ON ITEM 32

KEY

■ RECOMMENDED SPARE PARTS

▲ LUBRICATE DAILY USING NO 20 MACHINE OIL

● GREASE LIGHTLY

DIMENSIONS IN INCHES DO NOT SCALE PRINT

DIBT

TRADEMARK OF AMP INCORPORATED

REF	PART NO	DESCRIPTION	NO	REQ	PART NO	DESCRIPTION	NO
	162	REF 690517-1	SPACER		71		
	161	22594-8	HEX, NUT		70		
	160	240628-1	PLATE, ADJ		69		
	159	240626-1	SHAFT, PIVOT		68		
	158	240633-1	BUSHING		67		
	157	455680-1	LEVER, INTERMEDIATE		66		
	156	240629-1	BLOCK, PIVOT		65		
	155	240632-2	SCREW, ADJ		64		
	154	240659-3	PIN, CAM ROLLER		63		
	153	240658-1	CAM, ROLLER		62		
	152	REF 454398-1	ROD, FEED		61		
	151				60		
	150	REF 454220-1	CAP, RAM		59		
	149	REF 453736-1	HOUSING		58		
	148				57		
	147	REF 21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN		56		
	146	REF 240624-1	PIN, FEED FINGER		55		
	145	REF 691499-1	SPRING, FEED FINGER		54		
	144	REF 240635-1	FINGER, FEED		53		
	143	REF 240634-1	LEVER, TERMINAL		52		
	142				51		
	141	REF 5- 21028-1	PIN, SLOT SPG (.12 DIA x .50) FEED ADJ ROD		50		
	140	REF 1- 21030-7	PIN, DOWEL (.187 DIA x 1.50) HOUSING		49		
	139	REF 1- 21030-1	PIN, DOWEL (.187 DIA x .50) LEVER		48		
	138	22260-5	WASH, FLAT (NO. 6) DRAG SPRING		47		
	137	REF 21899-4	WASH, FLAT (NO. 5/16 DIA) SCR ADJ		46		
	136	REF 21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE		45		
	135	2	21024-5 WASH, LOCK (NO. 10) SHEAR PLATES		44		
	134	REF 21024-5	WASH, LOCK (NO. 10) FEED ROD GUIDE		43		
	133	4	21024-4 WASH, LOCK (NO. 8) STRIP GUIDE		42		
	132	2	21024-4 WASH, LOCK (NO. 8) SHEAR BLADE		41		
	131	REF 21018-4	NUT, HEX MACH (4-40) DRAG		40		
	130	REF 21068-5	NUT, HEX MACH (6-32) FEED ADJ PLATE		39		
	129	2	21018-7 NUT, HEX MACH (10-32) DRAG SPRING		38		
	128	REF 21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUDS		37		
	127	REF 5- 21004-7	SCR, SKT HD SHLD (.250 DIA x .25) DRAG ARM		36		
	126	REF 21004-5	SCR, SKT HD SHLD (.250 DIA x 1.00) DRAG		35		
	125	REF 4- 21078-8	SCR SKT SET OVAL POINT (4-40 X .75) DRAG		34		
	124	1	21009-2 SCR, SKT SET (1/4-20 x 25) NYLOK RAM		33		
	123	REF 1- 21002-7	SCR, BUTTON HD SOC CAP (6-32 x .50) CAM		32		
	122				31		
	121				30		
	120	REF 3- 21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ		29		
	119				28		
	118	REF 2- 21002-2	SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER		27		
	117	REF 2- 21002-9	SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP		26		
	116	1	22733-8 SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL		25		
	115	4	3- 21002-3 SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL		24		
	114	REF 1- 24073-9	SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE		23		
	113				22		
	112				21		
	111				20		
	110	REF 2- 21000-4	SCR, SKT HD CAP (6-32 x 1.00) DRAG ADAPTOR		19		
	109	1	23030-1 SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC		18		
	108	2	2- 21000-5 SCR, SKT HD CAP (8-32 x .25) SHEAR BLADE		17		
	107	REF 3- 21000-4	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE		16		
	106	1	7- 21000-4 SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE		15		
	105	REF 3- 21000-7	SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE		14		
	104	REF 3- 21000-9	SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING		13		
	103	REF 3- 21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE		12		
	102	REF 3- 21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK		11		
	101	2	3- 21000-8 SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES		10		
	80	REF 455745-1	GUARD, WINDOW		9		
	79	REF 465184-9	LUBRICATOR ASSY		8		
	78	REF 22014-1	OIL SYNTHETIC		7		
	77	REF 454406-1	SPACER, LUBRICATOR BRACKET		6		
	76				5		
	75				4		
	74				3		
	73	REF 458109-1	WASHER, FLAT (SPECIAL)		2		
	72	REF 690603-1	SPRING, ASSIST		1		

CRIMPING DATA				THIS APPLICATOR WILL APPLY	
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH		
A	.077	14		41006	
B	.068	16		41499	
C	.063	18			
D	NOT USED				
CRIMP SIZE	TYPE	FEED	PRESS REF.		
WIRE	.120	F			
INSULATION	+	.375	565435-5		
INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION			
+	18-14	A18039			
REMARKS: AMP-O-LECTRIC PRE FEED					
I. D. PLATE (REF): 461264-1					
SET UP GAGE	LAYOUT NO.				
458638-1	369				
E ECR-08-010318		TM 4-08		AMP INCORPORATED HARRISBURG, PENNA.	
D1 0150-0655-03		CE 6-03		LOC A C NO. 687817-2 E	
D ECA 0150-0636-02		PLT 5-02		REV.	
C ECN A160686		NCR 11-89			
B REV PER ECN R-5309		S/NR 1484			
A REV ITEM 37 PER ECN		R246 3-78			
O1 REV PER ECN		L 2-88			
SCALE NONE					
MINIATURE QUICK CHANGE APPLICATOR END-FEED (RING)					

LTR	REVISION RECORD	ECN	DATE	LTR	REVISION RECORD	ECN	DATE

NO. 687817-2