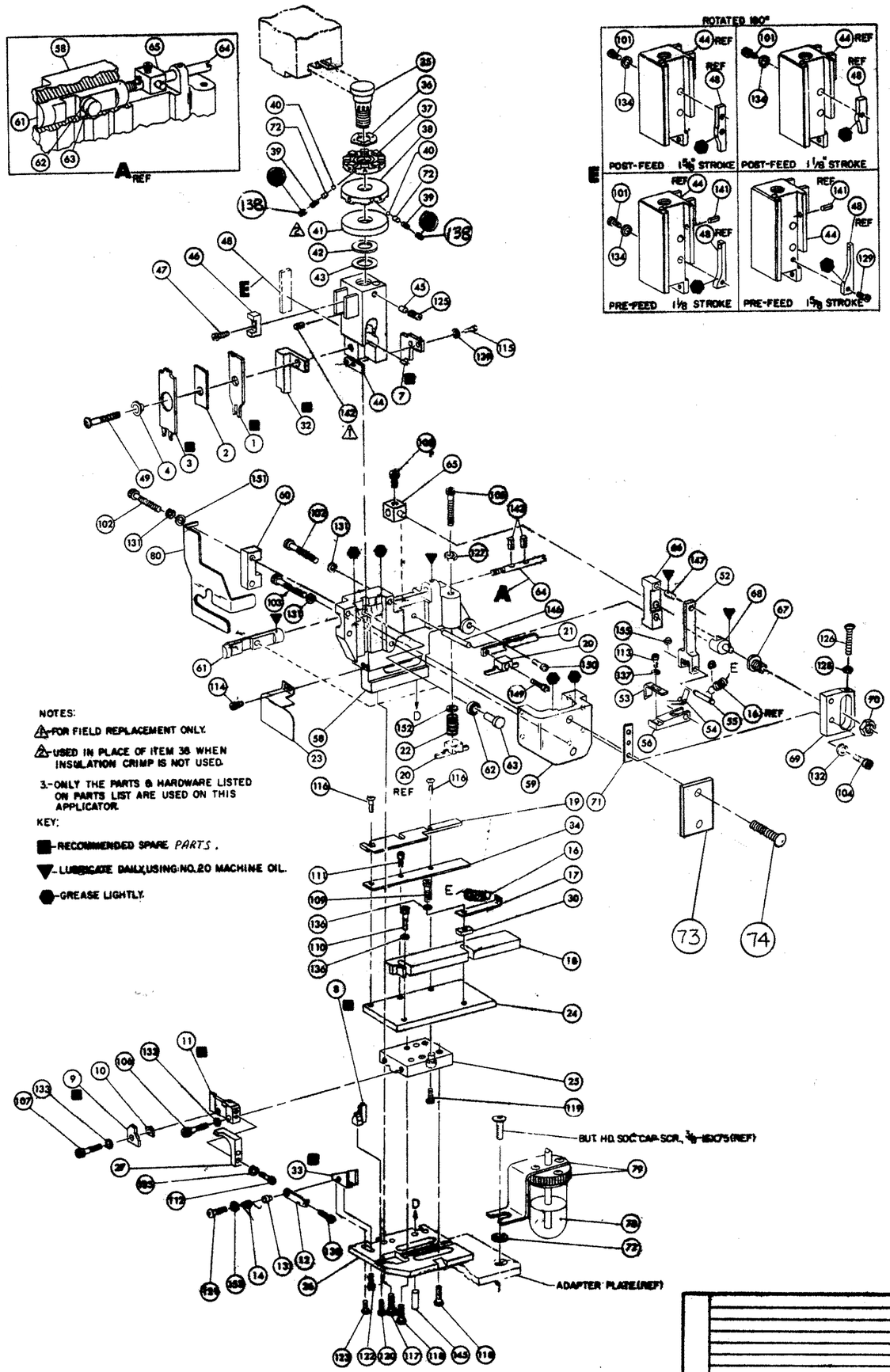
THIS IS A CONTROLLED DOCUMENT.



NOTES:

1. FOR FIELD REPLACEMENT ONLY.
2. USED IN PLACE OF ITEM 38 WHEN INSULATION CRIMP IS NOT USED.
3. ONLY THE PARTS & HARDWARE LISTED ON PARTS LIST ARE USED ON THIS APPLICATOR.

KEY:

■ RECOMMENDED SPARE PARTS.

▼ LUBRICATE DAILY, USING NO. 20 MACHINE OIL.

⬢ GREASE LIGHTLY.

REQ.	PART NO.	DESCRIPTION	NO.	REQ.	PART NO.	DESCRIPTION	NO.
			162	1	690517-1	SPACER	71
			161	1	22594-8	NUT, HEX	70
			160	1	240628-1	PLATE, ADJUSTMENT	69
			159	1	240626-1	SHAFT, PIVOT	68
			158	1	240633-1	BUSHING	67
			157	1	240630-1	LEVER, INTERMEDIATE	66
			156	1	240629-1	BLOCK, PIVOT	65
2		23045-3 RING, RETAINING "C" .187 DIA.	155	1	240632-1	SCREW, ADJ.	64
			154	1	240639-1	PIN, CAM ROLLER	63
←		21055-6 WASHER, FLAT (#8) LIFTER SPRING	153	1	240638-1	ROLLER, CAM	62
1		21055-5 WASHER, FLAT (#6) DRAG SPRING	152	1	690649-1	ROD, FEED	61
2		21055-7 WASHER, FLAT (#10) GUARD	151	1	690648-1	PLATE, WEAR	60
1		5- 21004-7 SCREW SKT. HD. SHLDR (.250 DIA X .25) DRAG ARM	150	1	240621-1	CAP, RAM	59
1		21004-2 SCREW SKT. HD. SHLDR (.250 DIA X .50) DRAG	149	1	690553-1	HOUSING	58
			148				57
1		1- 21030-1 PIN, DOWEL (.187 DIA X .90) LEVER	147	1	690529-1	ARM, FEED	56
1		1- 21030-7 PIN, DOWEL (.187 DIA X 1.50) HOUSING	146	1	240624-1	PIN, FEED FINGER	55
—		2- 21030-2 PIN, DOWEL (.250 DIA X .75) BASE PLATE	145	1	691499-1	SPRING, FEED FINGER	54
			144	1	690532-1	FINGER, FEED	53
2		5- 21028-1 PIN, SLOTTED SPRING (.12 DIA X .50) FEED ADJ ROD	143	1	240634-1	LEVER, TERMINAL	52
REF.		21028-2 PIN, SLOTTED SPRING (.06 DIA X .25) RAM ⚠1	142				51
—		9- 21028-8 PIN, SLOTTED SPRING (.12 DIA X .25) CAM	141				50
2		21024-3 WASHER, LOCK (#6) REAR STRIP GUIDE	140	1	7-21002-9	BOLT, CRIMPER	49
2		21024-4 WASHER, LOCK (#8) SHEAR BLADE	139	1	690602-2	CAM PRE FEED 1⅛ STROKE	48
2		23030-1 SCR SOC HD CAP (6-32 X .25) C.P. DISC	138	1	22253-8	SCREW SHOULDER (.187 DIA X .250)	47
1		21024-4 WASHER, LOCK (#8) FEED FINGER	137	1	690402-1	BLOCK, INSULATION ADJUSTMENT	46
2		21024-4 WASHER, LOCK (#8) FRONT STRIP GUIDE	136	1	690191-1	PLUG, NYLON	45
2		21024-4 WASHER, LOCK (#8) STRIPPER	135	1	690598-1	RAM	44
2		21024-5 WASHER, LOCK (#10) CAM	134	1	690128-1	WASHER, LAMINATED	43
2		21024-5 WASHER, LOCK (#10) SHEAR PLATE	133	1	690126-1	WASHER, RAM	42
2		21024-5 WASHER, LOCK (#10) FEED ADJ. PLATE	132			SPACER, DISC. ⚠2	41
4		21024-5 WASHER, LOCK (#10) HOUSING CAP	131	2	23241-6	BALL, STEEL	40
1		1- 21002-3 SCREW BTN. HD. SKT. CAP (4-40 X .12) TERMINAL LIFT	130	2	690178-1	SPRING, COMPRESSION	39
—		1- 21003-9 SCREW FLAT HD. SKT. CAP (6-32 X .38) CAM	129	1	690142-1	DISC, INSULATION	38
1		21018-5 NUT, HEX MACHINE (6-32) FEED ADJ.	128	1	1-690622-2	DISC, WIRE	37
1		21018-7 NUT, HEX MACHINE (10-32) DRAG SPRING	127	1	22480-5	WASHER, SPRING	36
1		6-23715-5 SCREW RD. HD. MACHINE (6-32 X 1.25) FEED ADJ.	126	1	690212-1	POST, RAM	35
1		21009-2 SCREW SKT. SET (NYLOK) (¼-20 X .25) C.P. RAM	125	1	690610-1	SPACER, STRIP GUIDE	34
—		2- 21006-7 SCREW SKT. SET (6-32 X .12) C.P. DISC.	124	1	690551-1	PLATE SHEAR, SIDE ■	33
1		2- 21002-0 SCREW BTN. HD. SKT. CAP (8-32 X .25) SHEAR BLOCK	123	1	690549-9	BLADE, SHEAR, SIDE	32
1		2- 21002-1 SCREW, BTN. HD. SOC. CAP (8-32 X .38) SHEAR BLOCK	122				31
←		2- 21002-2 SCREW BTN. HD. SKT. CAP (8-32 X .50) TERM. LIFTER	121	1	690453-1	ANCHOR, SPACER	30
1		22733-8 SCREW, BTN. HD. SOC. CAP (NYLOK) (8-32 X .38) ANVIL	120				29
3		3-21000-4 SCREW SKT. HD. [illegible] CAP (10-32 X .38) S.G. PLATE	119				28
4		3- 21002-3 SCREW BTN. HD. SKT. CAP (¼-20 X .50) BASE PLATE	118	1	690634-1	STRIPPER	27
2		3- 21002-5 SCREW BTN. HD. SKT. CAP (¼-20 X .75) HOUSING	117	1	690554-1	PLATE, BASE	26
2		1-21002-7 SCREW, BTN. HD. SOC. CAP (6-32 X .38) REAR STRIP GUIDE	116	1	690555-1	BLOCK, BASE	25
2		7-21000-4 SCREW, SOC. HD. CAP (8-32 X .31) REAR SHEAR BLADE	115	1	690528-1	PLATE, STRIP GUIDE	24
2		1- 21000-8 SCREW SKT. HD. CAP (6-32 X .25) CHIP GUARD	114	1	469487-1	GUARD, CHIP	23
1		2- 21000-5 SCREW SKT. HD. CAP (8-32 X .25) FEED FINGER	113	1	7- 22288-5	SPRING, DRAG	22
2		2- 21000-8 SCREW SKT. HD. CAP (8-32 X .62) STRIPPER	112	1	240636-1	LEVER, DRAG	21
1		1- 21000-8 SCREW SKT. SOC HD. CAP (6-32 X .25) STRIP GUIDE SPA	111	1	240634-2	DRAG, STOCK	20
1		2-21000-7 SCREW SKT. HD. CAP (8-32 X .50) FRONT STRIP GUIDE	110	1	690530-1	GUIDE, STRIP, REAR	19
1		3-21000-1 SCREW SKT. HD. CAP (8-32 X 1.00) FRONT STRIP GUIDE	109	1	690531-1	GUIDE, STRIP, FRONT	18
1		3- 21000-4 SCREW SKT. HD. CAP (10-32 X .38) PIVOT BLOCK	108	1	238008-1	SPRING, ANCHOR	17
1		3- 21000-8 SCREW SKT. HD. CAP (10-32 X .88) SHEAR PLATE	107	1	3- 22288-0	SPRING, FEED RETURN	16
1		3- 21000-8 SCREW SKT. HD. CAP (10-32 X .88) SHEAR PLATE	106				15
1		3- 21000-9 SCREW SKT. HD. CAP (10-32 X 1.00) DRAG SPRING	105			SPRING, TERM. LIFTER	14
2		3- 21000-6 SCREW SKT. HD. CAP (10-32 X .62) FEED ADJ. PLATE	104			BUSHING, TERM. LIFTER	13
1		4- 21000-1 SCREW SKT. HD. CAP (10-32 X 1.88) CAP	103			LIFTER, TERMINAL	12
3		4- 21000-0 SCREW SKT. HD. CAP (10-32 X 1.25) CAP	102	1	690631-1	PLATE, REAR SHEAR ■	11
2		3- 21000-5 SCREW SKT. HD. CAP (10-32 X 1.62) CAM	101	1	469488-1	SPACER, SHEAR PLATE	10
1		455750-5 GUARD ASSY	80	1	690588-1	PLATE, FRONT SHEAR ■	9
—		463184-9 LUBRICATOR ASSY.	79	1	1-240694-0	ANVIL ■	8
—		22014-1 OIL, SYNTHETIC	78	1	690612-1	BLADE, SHEAR ■	7
—		454406-1 SPACER, LUBRICATOR BRACKET	77				6
			76				5
			75	1	238009-1	SPACER, TUBULAR, INS. CRIMPER	4
2		21017-2 SCREW, DRIVE #2 X .19	74	1	690406-5	CRIMPER, INSULATION ■	3
1		461264-1 PLATE, IDENTIFICATION	73	1	2-690407-1	SPACER, INSULATION CRIMPER	2
2		690603-1 SPRING, ASSIST	72	1	453838-4	CRIMPER, WIRE ■	1

TERM APPL SPEC 114-2079

CRIMPING DATA

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.050	18	
B	.045	20	
C	.042	22	
D	NOT	USED	

	SIZE	TYPE	FEED	
CRIMP				PRESS REF
WIRE	070	F	.525	565435-5
INSULATION	110	E		

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION
.060-.070	22-18	408024

REMARKS: AMP-O-LECTRIC PRE FEED

THIS APPLICATOR WILL APPLY

	62085
	62333

REV.	REVISION RECORD	ECN	DR	DATE
D1	ECN 0158-1457-04		JM/JE	12-04
D	ECN R-6240		JM/MS	8-5
C1	REDRAWN W/O CHANGE R-5039		CE/JG	4-83

SET UP GAGE 679108-1 | LAYOUT NO. 648 | AMP INCORPORATED HARRISBURG, PENNA.

DRAWN C Swanson 4.8.83 | APPROVED TR McClure | CHECKED JRG | REL E Swanson 4-15-83

LOC A C | NO. 687801-3 | REV. D1

SCALE NONE | NAME MINIATURE QUICK CHANGE APPLICATOR .FLAG FASTON E.E (.187 FLAG FASTON.)

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

687801-3

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