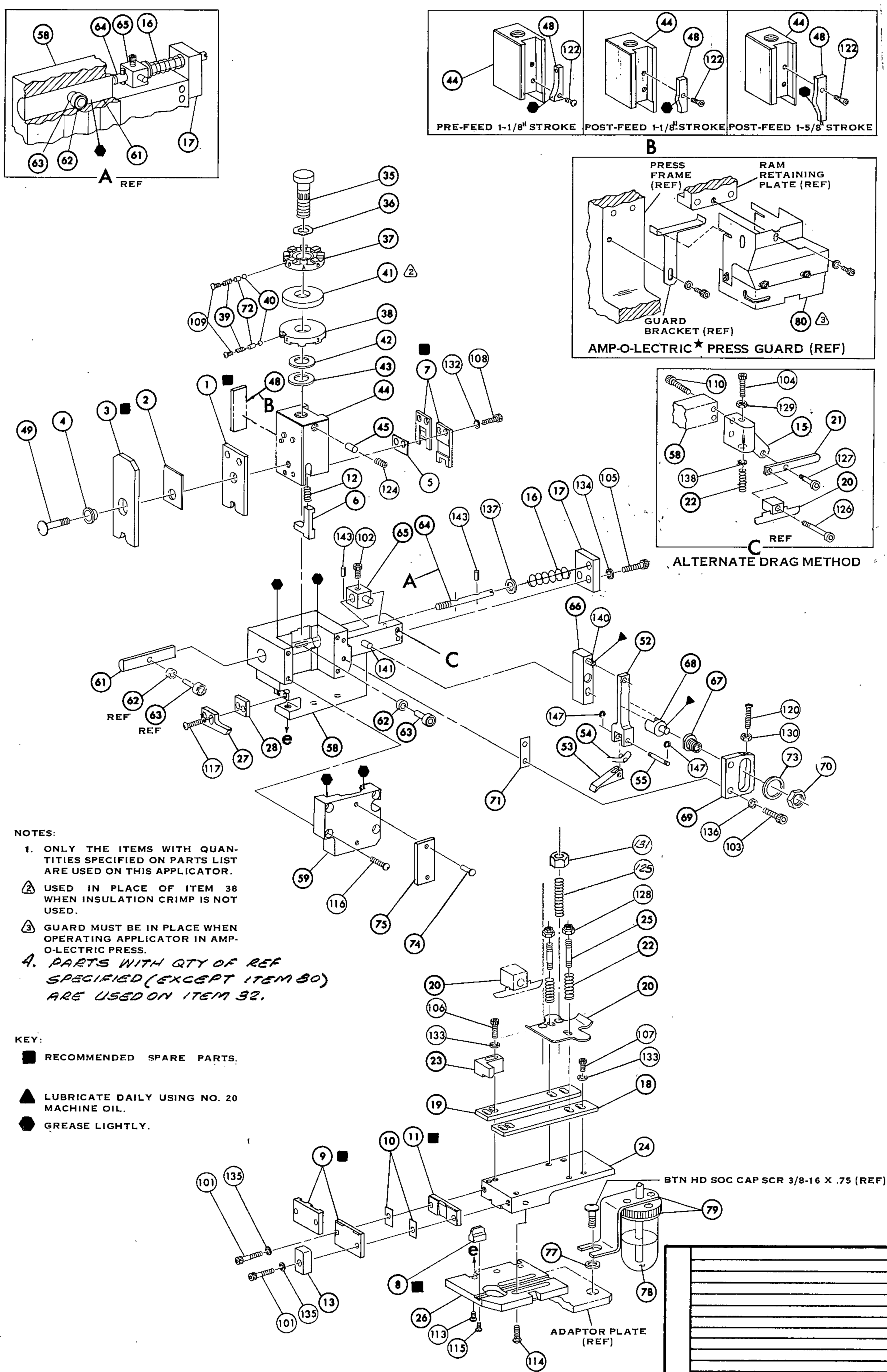


THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INC. IT IS TO CHANGE AND THE CONTROLLING ENGINEERING DEPARTMENT SHOULD BE CONTACTED FOR THE LATEST REVISION.



- NOTES:**
- 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.
 - 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.

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
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	147				56
	146	REF	240624-1			PIN, FEED FINGER	55
	145	REF	691499-1			SPRING, FEED FINGER	54
	144	REF	240635-1			FINGER, FEED	53
REF	5- 21028-1	PIN, SLOT SPG (.12 DIA x .50) FEED ADJ ROD	143	REF	240634-3	LEVER, TERMINAL	52
	142						51
REF	1- 21030-7	PIN, DOWEL (.187 DIA x 1.50) HOUSING	141				50
REF	1- 21030-1	PIN, DOWEL (.187 DIA x .50) LEVER	140	1	7-21002-9	BOLT, CRIMPER	49
	139	1	690501-4			CAM, POST FEED 1- 5/8 STROKE	48
	138						47
REF	22260-5	WASH, FLAT (NO. 6) DRAG SPRING	137				46
REF	21899-4	WASH, FLAT (NO. 5/16 DIA) SCR ADJ	136	1	690191-1	PLUG, NYLON	45
REF	21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE	135	1	455674-1	RAM	44
2	21024-5	WASH, LOCK (NO. 10) SHEAR PLATES	134	1	690125-1	WASHER, LAMINATED	43
REF	21024-5	WASH, LOCK (NO. 10) FEED ROD GUIDE	133	1	690124-1	WASHER, RAM	42
5	21024-4	WASH, LOCK (NO. 8) STRIP GUIDE	132			SPACER, DISC	41
2	21024-4	WASH, LOCK (NO. 8) SHEAR BLADE	131	2	23241-6	BALL, STEEL	40
REF	21018-4	NUT, HEX MACH (4-40) DRAG	130	2	690170-1	SPRING, COMPRESSION	39
REF	21068-5	NUT, HEX MACH (6-32) FEED ADJ PLATE	129	1	690142-1	DISC, INSULATION	38
	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	128	1	690069-4	DISC, WIRE	37
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUDS	127	1	22480-5	WASHER, SPRING	36
	5- 21004-7	SCR, SKT HD SHLD (.250 DIA x .25) DRAG ARM	126	1	690212-1	POST, RAM	35
	21004-5	SCR, SKT HD SHLD (.250 DIA x 1.00) DRAG	125				34
2	4-21018-8	SCR, SKT SET OVAL PT (4-40 x .75) DRAG	124				33
1	21009-2	SCR, SKT SET (1/4-20 x 25) NYLOK RAM	123	1	458980-2	APPLICATOR, BASIC (SUB ASSY)	32
			122				31
REF	3- 21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ	121				30
			120				29
			119	1	3-690451-2	SPACER, STRIPPER	28
			118	1	240639-1	STRIPPER	27
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER	117	REF	455676-1	PLATE, BASE	26
REF	2- 21002-9	SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP	116	2	22354-8	DRAG, STUD	25
1	22733-8	SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL	115	1	458503-2	PLATE, STRIP GUIDE	24
4	3- 21002-3	SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL	114	1	240825-8	PLATE, STRIP HOLD	23
REF	1-24073-9	SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE	113	2	4-22281-1	SPRING, DRAG	22
			112		240636-1	LEVER, DRAG	21
			111	1	459177-1	DRAG, STOCK	20
			110	1	454204-3	GUIDE, STRIP REAR	19
2	2-21000-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC	109	1	454204-3	GUIDE, STRIP FRONT	18
2	2-21000-7	SCR, SKT HD CAP (8-32 x .50) SHEAR BLADE	108	REF	454178-1	GUIDE, FEED ROD	17
3	2-21000-6	SCR, SKT HD CAP (8-32 x .33) STRIP GUIDE	107	REF	4-22284-9	SPRING, FEED RETURN	16
2	2-21000-9	SCR, SKT HD CAP (8-32 x .75) STRIP GUIDE	106		454665-1	ADAPTOR, DRAG	15
REF	3- 21000-7	SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE	105				14
	3- 21000-9	SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING	104	1	690481-7	SPACER, HOLD DOWN	13
REF	3- 21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE	103	1	23346-1	SPRING, HOLD DOWN	12
REF	3- 21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK	102	1	240535-3	PLATE, REAR SHEAR	11
2	3- 21000-8	SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES	101			SPACER, SHEAR PLATE	10
REF	455715-1	GUARD WINDOW	80	1	690482-3	PLATE, FRONT SHEAR	9
	465184-9	LUBRICATOR ASSY	79	1	6-240635-7	ANVIL	8
	22014-1	OIL SYNTHETIC	78	1	690474-3	BLADE, SLUG	7
	454406-1	SPACER, LUBRICATOR BRACKET	77	1	2-455892-4	HOLD DOWN	6
			76	1	2-210171-0	SPACER, SHEAR BLADE	5
1	461264-1	PLATE, IDENTIFICATION	75	1	253009-1	SPACER, TUBULAR, INS CRIMPER	4
2	21017-2	SCREW, DRIVE	74	1	1-456135-1	CRIMPER, INSULATION	3
REF	458109-1	WASHER, FLAT (SPECIAL)	73	1	455888-7	SPACER, INSULATION	2
2	690603-1	SPRING, ASSIST	72	1	456409-7	CRIMPER, WIRE	1

APPL SPEC		CRIMPING DATA			THIS APPLICATOR WILL APPLY
114 - 2065		PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
		A	.086	#12	42904
		B	.072	#14	61127
		C	.064	#16	62291
		D	NOT USED		62891
CRIMP	SIZE	TYPE	FEED	PRESS REF.	
WIRE	.120	F			
INSULATION	.210	F	.340		
INSULATION RANGE	.150-.190	WIRE RANGE	#16-12	APPLICATOR INSTRUCTION	A18039
REMARKS					
AMPOMATOR					
SET UP GAGE		LAYOUT NO.		REV	
453638-1		294		G	
DRAWN FORGARY 9/5/73		APPROVED		AMP INCORPORATED HARRISBURG, PENNA.	
CHECKED 9-10-73		REL. 9/10/73		LOC A C NO. 687913-1	
SCALE NONE		NAME		MINIATURE QUICK CHANGE APPLICATOR	
				END-FEED (.250 FASTIN FASTON)	

LTR	REVISION RECORD	ECN	DATE	LTR	REVISION RECORD	ECN	DATE

NO. 687913-1