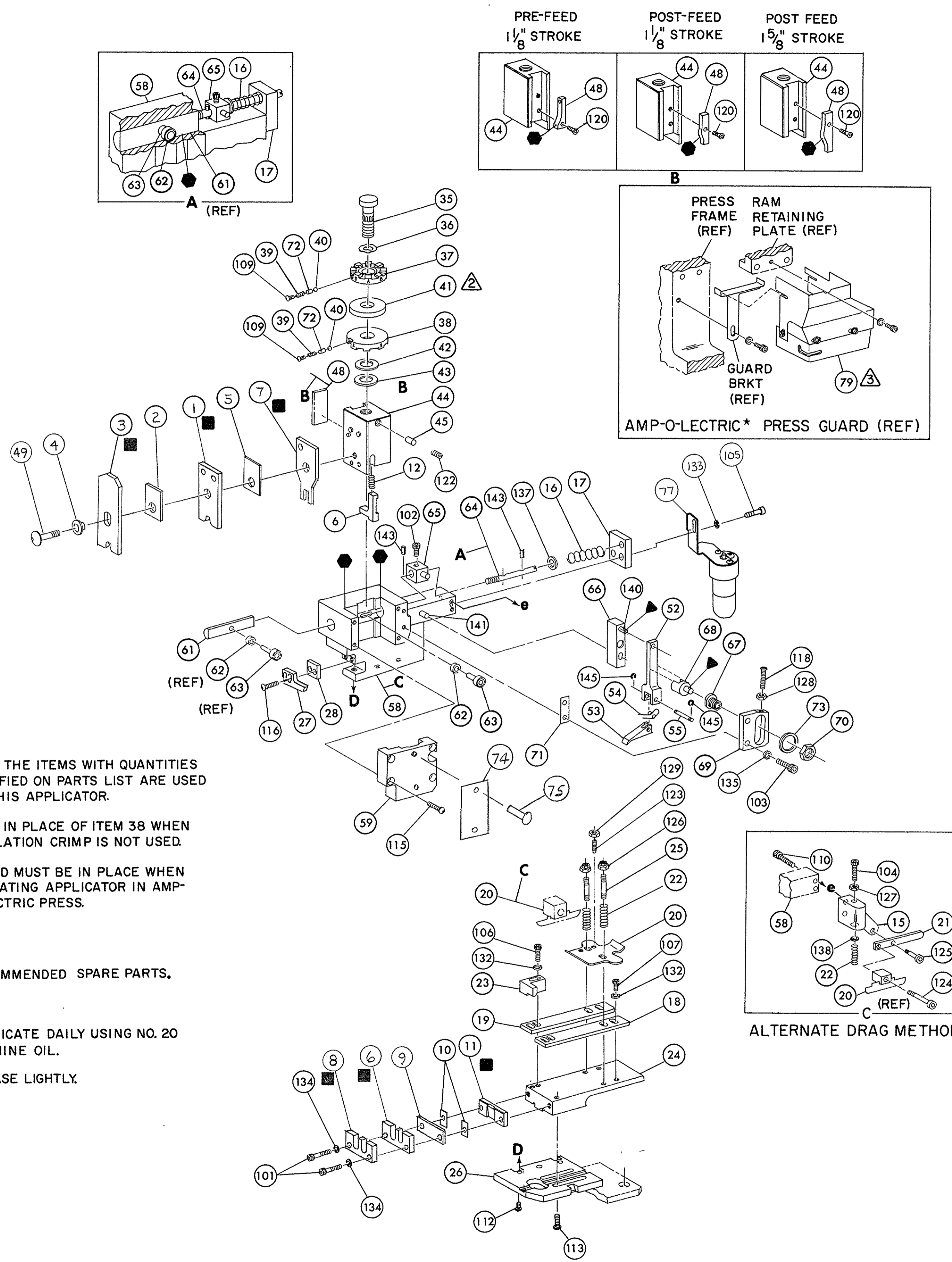


THIS DRAWING IS A CONTROLLED DOCUMENT  
 © AMP INCORPORATED 1988



**NOTES:**

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

2. USED IN PLACE OF ITEM 38 WHEN INSULATION CRIMP IS NOT USED.

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

**KEY:**

■ RECOMMENDED SPARE PARTS.

▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.

● GREASE LIGHTLY.

ALTERNATE DRAG METHOD

QTY	PART NO	DESCRIPTION	ITEM NO	QTY	PART NO	DESCRIPTION	ITEM NO
2	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	145	1	454220-1	CAP, RAM	59
			144	1	453736-1	HOUSING	58
2	5-21028-1	PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD	143				57
			142				56
1	1-21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	141	1	240624-1	PIN, FEED FINGER	55
1	1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	140	1	691499-1	SPRING, FEED FINGER	54
			139	1	240635-1	FINGER, FEED	53
	22260-5	WASHER, FLAT (NO 6) DRAG SPRING	138	1	240634-3	LEVER, TERMINAL	52
1	21899-4	WASHER, FLAT (5/16 DIA) SCR ADJ	137				51
			136				50
2	21024-5	WASHER, LOCK (NO 10) FEED ADJ PLATE	135	1	690686-1	BOLT, CRIMPER	49
2	21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	134	1	690602-5	CAM, PRE-FEED 1 1/8 STROKE	48
2	21024-5	WASHER, LOCK (NO 10) FEED ROD GUIDE	133				47
5	21024-4	WASHER, LOCK (NO 8) STRIP GUIDE	132				46
	21024-4	WASHER, LOCK (NO 8) SHEAR BLADE	131	1	690191-1	PLUG, NYLON	45
			130	1	455674-8	RAM	44
2	21018-4	NUT, HEX MACH (4-40) DRAG	129	1	690125-1	WASHER, LAMINATED	43
1	21068-5	NUT, HEX MACH (6-32) FD ADJ PLATE	128	1	690124-4	WASHER, RAM	42
	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	127				41
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	126	2	23241-6	BALL, STEEL	40
	5-21004-7	SCR, SKT HD SHLD (250 DIA X .25) DRAG ARM	125	2	690170-1	SPRING, COMPRESSION	39
	21004-5	SCR, SKT HD SHLD (250 DIA X 1.00) DRAG	124	1	690142-1	DISC, INSULATION	38
2	4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	123	1	690141-6	DISC, WIRE	37
1	21009-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	122	1	22480-5	WASHER, SPRING	36
			121	1	690212-1	POST, RAM	35
1	2-21003-0	SCR, FLAT HD SKT CAP (6-32 X .50) CAM	120				34
			119				33
1	3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	118		458980-	APPLICATOR, BASIC (SUB ASSY)	32
			117				31
2	2-21002-4	SCR, BTN HD SKT CAP (8-32 X .75) STRIPPER	116				30
4	2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	115				29
1	2-2733-8	SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	114	1	3-690451-0	SPACER, STRIPPER	28
4	3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	113	1	240639-4	STRIPPER	27
3	2-2733-8	SCR, BTN HD SKT CAP (1/4-20 X .62) BASE PL	112	1	459717-1	PLATE, BASE	26
			111	2	22354-8	DRAG, STUD	25
	2-21000-4	SCR, SKT HD CAP (6-32 X 1.00) DRAG ADAPTOR	110	1	455678-6	PLATE, STRIP GUIDE	24
2	23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	109	1	240825-2	PLATE, STRIP HOLD	23
			108	2	4-22281-1	SPRING, DRAG	22
3	7-21000-4	SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	107		240636-1	LEVER, DRAG	21
2	2-21000-8	SCR, SKT HD CAP (8-32 X .62) STRIP GUIDE	106	1	454177-1	DRAG, STOCK	20
2	3-21000-7	SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE	105	1	454204-1	GUIDE, STRIP (REAR)	19
	3-21000-9	SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING	104	1	454204-1	GUIDE, STRIP (FRONT)	18
2	3-21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	103	1	454178-1	GUIDE, FEED ROD	17
1	3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	102	1	4-22284-9	SPRING, FEED RETURN	16
2	3-21000-8	SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE	101			ADAPTER, DRAG	15
REF	455745-1	GUARD, WINDOW	79				14
1	465184-9	LUBRICATOR ASSY	78				13
REF	852931-2	OIL, LUBRICATING	77				12
	454406-1	SPACER, LUB-BRACKET	76	1	691901-2	PLATE, REAR SHEAR	11
2	21017-2	SCREW, DRIVE	75	2	1-240645-6	SPACER, SHEAR PLATE	10
1	461264-1	PLATE, I.D.	74	1	690783-7	PLATE, SPACER	9
1	458109-1	WASHER, FLAT (SPECIAL)	73	1	2-690702-2	ANVIL, INSULATION	8
2	690603-1	SPRING, ASSIST	72	1	460507-2	BLADE, SLUG	7
1	690517-1	SPACER	71	1	2-690702-1	ANVIL, WIRE	6
1	22594-8	NUT, HEX	70	1	1-455888-9	SPACER, CRIMPER	5
1	240628-1	PLATE, ADJ	69	1	238009-8	SPACER, TUBULAR	4
1	240626-1	SHAFT, PIVOT	68	1	3-456134-2	CRIMPER, INSULATION	3
1	240633-1	BUSHING	67	1	455888-3	SPACER, INSULATION	2
1	455680-1	LEVER, INTERMEDIATE	66	1	1-459736-2	CRIMPER, WIRE	1
1	240629-1	BLOCK, PIVOT	65				
1	240632-2	SCREW, ADJ	64				
1	240659-3	PIN, CAM ROLLER	63				
1	240658-1	CAM, ROLLER	62				
1	454398-1	ROD, FEED	61				
			60				

CRIMPING DATA				APPLICATOR WILL APPLY	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH		
A	.066	#16			40990
B	.061	#18			60581
C	.057	#20			62873
D	NOT USED				1217510

CRIMP	SIZE	TYPE	FEED	APPL INST
WIRE	.110	F	.385	A1 8039
INSUL	.140	F		

WIRE RANGE	INSULATION RANGE	PRESS NO
#20 - #16	.090 - .130	565435-5

REMARKS	DISTRIBUTION
AMP-O-LECTRIC PRE-FEED	ORIGINAL
	CUSTOMER COPY
	FIELD ENG COPY

REMARKS	NO	REV
TO APPLY TERMINAL SPEC 114-2093		
APPL USED ON MACHINE PART NO	MACH SERIAL NO	DISTRIBUTION
CUSTOMER NAME	APPL SERIAL NO	ORIGINAL
ADDRESS	PURCHASE ORDER	CUSTOMER COPY
CITY	ENG APP	FIELD ENG COPY

ECN A-157588	11-11-88	SET UP PAGE 10-1
REV PER ECU R25475	11/30/88	458638-1 756
ADD TERM 22872 R2986	12/27/88	DR 6-7-74 APP
REV PER ECU R18555	11/20/88	B. Bomber
REV PER ECU R15555	11/20/88	CHK 2-10-88 REL 4/88
REV PER ECU R-1049	11/20/88	LOG A
REV PER ECU R776	11/20/88	D NO 466160-2

AMP INCORPORATED Harrisburg, Pa.

MINIATURE QUICK CHANGE APPLICATOR END FEED ( WELDED TAB)

CUSTOMER AND ASSEMBLY DRAWING