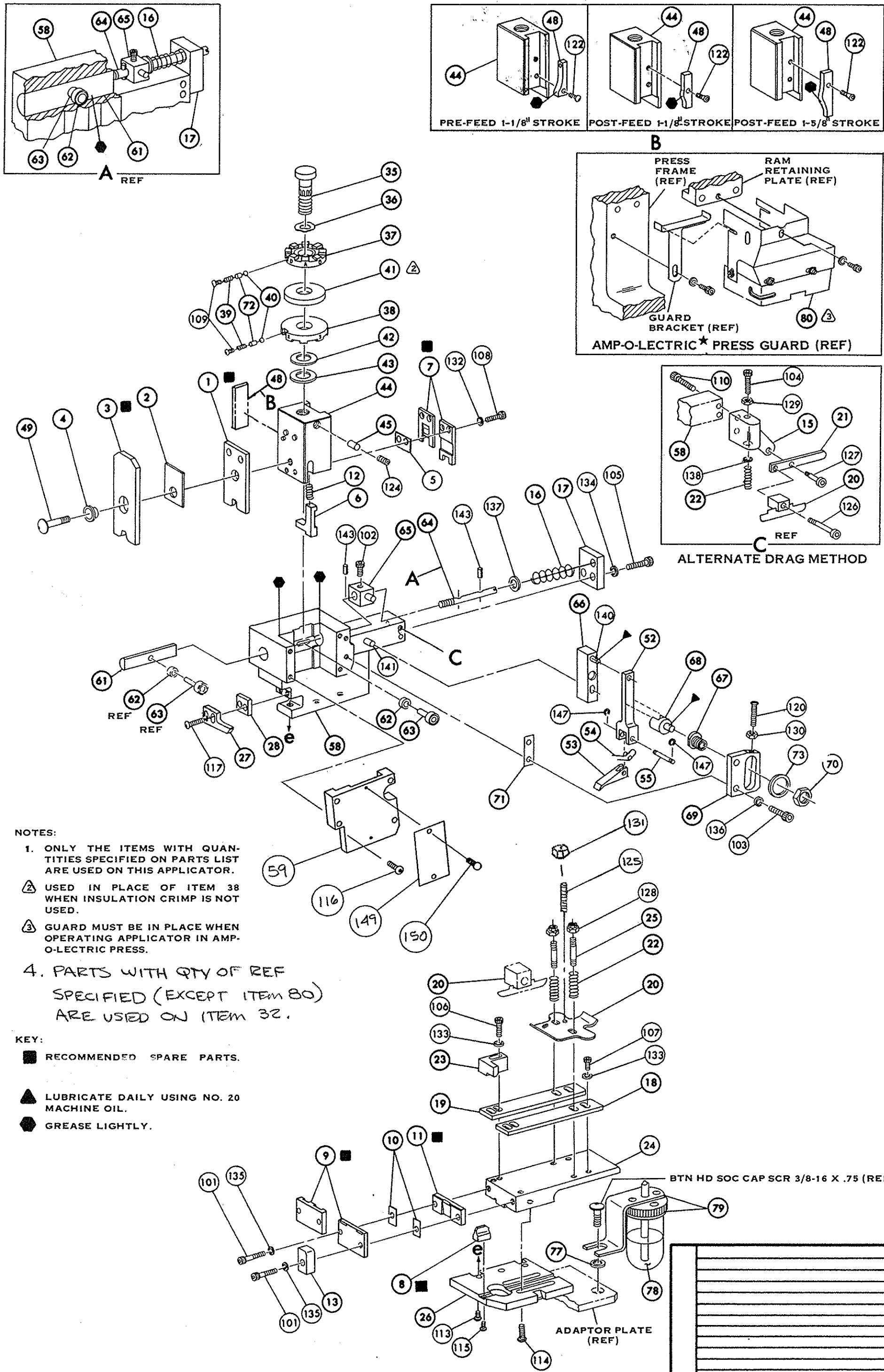


THIS IS A CONTROLLED DOCUMENT.



- 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.

REQ.	PART NO.	DESCRIPTION	NO.	REQ.	PART NO.	DESCRIPTION	NO.
			162	REF	690517-1	SPACER	71
			161	REF	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				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				50
			140	1	7-21002-9	BOLT, CRIMPER	49
			139	1	690501-3	CAM, POSTFEED 1-1/8 STROKE	48
			138				47
			137				46
			136	1	690191-1	PLUG, NYLON	45
			135	1	455674-1	RAM	44
			134	1	690125-1	WASHER, LAMINATED	43
			133	1	690124-1	WASHER, RAM	42
			132	1	690223-1	SPACER, DISC	41
			131	1	23241-6	BALL, STEEL	40
			130	1	690170-1	SPRING, COMPRESSION	39
			129			DISC, INSULATION	38
			128	1	2-690141-9	DISC, WIRE	37
			127	1	22480-5	WASHER, SPRING	36
			126	1	690212-1	POST, RAM	35
			125				34
			124				33
			123	1	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
			122				31
			121				30
			120				29
			119	1	3-690451-2	SPACER, STRIPPER	28
			118	1	240639-1	STRIPPER	27
			117	REF	455676-1	PLATE, BASE	26
			116	2	22354-8	DRAG, STUD	25
			115	1	455678-1	PLATE, STRIP GUIDE	24
			114			PLATE, STRIP HOLD	23
			113	2	4-22281-1	SPRING, DRAG	22
			112		240636-1	LEVER, DRAG	21
			111	1	454177-1	DRAG, STOCK	20
			110	1	458030-3	GUIDE, STRIP REAR	19
			109	1	458031-3	GUIDE, STRIP FRONT	18
			108	REF	454178-1	GUIDE, FEED ROD	17
			107	REF	4-22284-9	SPRING, FEED RETURN	16
			106		454665-1	ADAPTOR, DRAG	15
			105				14
			104			SPACER, HOLD DOWN	13
			103			SPRING, HOLD DOWN	12
			102	1	240644-1	PLATE, REAR SHEAR	11
			101	2	240645-7	SPACER, SHEAR PLATE	10
			80	1	240642-1	PLATE, FRONT SHEAR	9
			79	1	2-240654-3	ANVIL	8
			78	1	1-240651-3	BLADE, SLUG	7
			77			HOLD DOWN	6
			76	1	4-240641-0	SPACER, SHEAR BLADE	5
			75			SPACER, TUBULAR, INS CRIMPER	4
			74			CRIMPER, INSULATION	3
			73			SPACER, INSULATION	2
			72	1	1-456411-4	CRIMPER, WIRE	1

CRIMPING DATA				THIS APPLICATOR WILL APPLY
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	40577
A	.089	14		40705
B	.082	16		40819
C	.078	18		41473
D	NOT USED			350435
CRIMP	SIZE	TYPE	FEED	PRESS REF.
WIRE	.140	F	.562	565435-5
INSULATION	++	++		
INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION	#8039	
---	18-14			
REMARKS AMP-O-LECTRIC POST FEED				
I.D. PLATE (REF): 461264-1				
SET UP GAGE	458638-1	LAYOUT NO.	237	
DRAWN	J.E. BEATTY 5-6-80	APPROVED		
CHECKED	R. KENNEDY 5-32-80	REL.	5/11/80	
SCALE	NONE	NAME		
MINIATURE QUICK CHANGE APPLICATOR				
END-FEED (SPADE)				

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LTR	REVISION RECORD	ECN	DATE	LTR	REVISION RECORD	ECN	DATE

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