



- 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.
 - △- ITEMS WITH QTY. OF REF SPECIFIED (EXCEPT ITEM 79) ARE USED ON ITEM 46.
 - RECOMMENDED SPARE PARTS CUSTOMER RESPONSIBLE FOR REPLACEMENT.
 - ▲- LUBRICATE DAILY USING NO. 20 MACHINE OIL.

REF	QTY	PART NO	DESCRIPTION	ITEM NO	REF	QTY	PART NO	DESCRIPTION	ITEM NO
REF		21045-3	RING, RETAINING 'C' (.187 DIA) FEED FINGER PIN	145	REF		454220-1	CAP, HOUSING	59
REF		5-21028-1	PIN, SLOT SPR (.125 DIA X .50) ADJ ROD	144	REF		454485-1	HOUSING	58
1		4-21028-0	PIN, SLOT SPR (.093 DIA X .75) STR G PLATE	143					57
REF		1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	142	1		690542-2	PAWL, FEED	56
REF		1-21030-6	PIN, DOWEL (.187 DIA X 1.25) HOUSING	141	REF		240624-1	PIN, FEED FINGER	55
REF		21024-5	WASHER, LOCK (NO 10) LUB ASSY	140	REF		691499-1	SPRING, FEED FINGER	54
1		21024-5	WASHER, LOCK (NO 10) STRIP GUIDE ADJ BLOCK	139	REF		690541-1	FINGER, FEED	53
REF		21024-5	WASHER, LOCK (NO 10) FEED GUIDE ROD	138	REF		455679-1	LEVER, TERMINAL FEED ARM	52
REF		21024-5	WASHER, LOCK (NO 10) ADJ PLATE	137	1		811242-2	BUMPER, HOLDDOWN	51
REF		21024-5	WASHER, LOCK (NO 10) FRONT STRIP GUIDE	136	1		690753-1	SPACER, TONKER	50
3		21057-2	WASHER, LOCK (NO 4) FEED FINGER	135	1		7-21022-9	BOLT, CRIMPER	49
1		21024-4	WASHER, LOCK (NO 8) DEPRESSOR	134	1		690501-4	CAM POST FEED	48
2		21024-4	WASHER, LOCK (NO 8) STRIPPER	133					47
REF		21899-4	WASHER, FLAT (5/16 DIA) SCREW ADJ	132	1		459456-1	APPLICATOR, BASIC (SUB ASSY)	46
REF		21899-2	WASHER, FLAT (NO 10) LUB ASSY	131	1		690191-1	PLUG, NYLON	45
REF		21068-5	NUT, HEX MACH (6-32) HOLDDOWN	130	1		455673-1	RAM	44
REF		21068-5	NUT, HEX MACH (6-32) FEED ADJ	129	1		690125-1	WASHER, LAMINATED	43
				128	1		690124-1	WASHER, RAM	42
				127					41
				126	2		23241-6	BALL, STEEL	40
				125	2		690170-1	SPRING, COMPRESSION	39
1		21009-2	SCR, SKT SET (1/4-20 X .25) (LOC-WEL) RAM	124	1		690142-3	DISC, INSULATION	38
2		21017-2	SCR, DRIVE (#2 X .19) I.D. PLATE	123	1		4-692155-2	DISC, WIRE	37
REF		3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	122	1		22480-5	WASHER, SPRING	36
REF		4-61264-1	PLATE, IDENTIFICATION	121	1		690212-1	POST, RAM	35
2		3-21002-0	SCR, BUT HD SKT CAP (10-32 X .88) DRAG	120					34
1		22733-8	SCR, BUT HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	119	REF		455675-1	PLATE, BASE	33
REF		2-21002-9	SCR, BUT HD SKT CAP (10-32 X .75) CAP	118	1		690432-3	SCREW, ADJUSTMENT	32
REF		1-24073-9	SCR, BUT HD SKT CAP (1/4-20 X .75) HOUSING	117					31
REF		2-21002-7	SCR, BUT HD SKT CAP (10-32 X .50) SG ADJ BLOCK	116	REF		455689-1	BLOCK, STRIP GUIDE ADJ	30
2		2-21002-2	SCR, BUT HD SKT CAP (8-32 X .50) SHEAR	115	1		455671-3	PLATE, STRIP GUIDE	29
2		2-21002-2	SCR, BUT HD SKT CAP (8-32 X .50) R STRIP GUIDE	114	1		1-455888-0	SPACER, FRONT SHEAR DEPRESSOR	28
				113	2		1-22284-0	SPRING, DRAG	27
1		1-21002-7	SCR, BUT HD SKT CAP (6-32 X .38) CAM	112	1		690542-1	LEVER, DRAG RELEASE	26
				111	1		240792-5	DRAG, STOCK	25
2		23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	110	1		690440-2	GUIDE STRIP (REAR)	24
				109	1		690438-1	GUIDE STRIP (FRONT)	23
2		2-21000-7	SCR, SKT HD CAP (8-32 X .50) DEPRESSOR	108					22
1		2-22603-0	SCR, HEX HD MACH (8-32 X .31) FEED FINGER	107	REF		4-22284-9	SPRING, FEED RETURN	21
3		1-21000-3	SCR, SKT HD CAP (4-40 X .25) F STRIP GUIDE	106					20
1		2-21000-7	SCR, SKT HD CAP (8-32 X .50) STRIPPER	105	1		690472-1	STRIPPER	19
REF		3-21000-7	SCR, SKT HD CAP (10-32 X .75) FEED ROD GUIDE	104					18
REF		3-21000-6	SCR, SKT HD CAP (10-32 X .62) FEED ADJ BLOCK	103					17
1		3-21000-4	SCR, SKT HD CAP (10-32 X .38) SG ADJ BLOCK	102	1		691667-1	GUARD, CHIP (FRONT)	16
REF		3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLOCK	101					15
REF		455749-1	GUARD, WINDOW	79					14
				78					13
				77					12
				76	1		5-22280-0	SPRING, SHEAR	11
				75	1		690461-1	STOP, SHEAR	10
				74	1		690459-1	HOLDER, SHEAR (FRONT)	9
REF		458109-1	WASHER, SPECIAL	74	1		454276-1	SHEAR, FLOAT (FRONT)	8
1		454877-3	PLATE, STRIP GUIDE COVER	73	1		690720-3	ANVIL	7
2		690603-1	SPRING, ASSIST	72					6
REF		690517-1	SPACER	71					5
REF		22594-8	NUT, HEX	70	1		455889-9	DEPRESSOR, SHEAR (REAR)	4
REF		240628-1	PLATE, ADJUSTMENT	69	1		2-238011-2	DEPRESSOR, SHEAR (FRONT)	3
REF		240626-1	SHAFT, PIVOT	68	1		1-456135-1	SPACER, TUBULAR, INS CRIMPER	2
REF		240633-1	BUSHING	67	1		455888-5	CRIMPER, INSULATION	1
REF		455680-1	LEVER, INTERMEDIATE	66	1		4-456406-7	SPACER, CRIMPER	1
REF		240629-1	BLOCK, PIVOT	65					1
REF		240632-2	SCREW, ADJUSTMENT FEED ROD	64					1
REF		240659-3	PIN, CAM ROLLER	63					1
REF		240658-1	ROLLER, CAM	62					1
REF		454398-2	ROD, FEED	61					1
REF		454178-1	GUIDE, FEED ROD	60					1

REMARKS	NO	REV
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

TO APPLY TERMINAL SPEC 114-9002

CRIMPING DATA				APPLICATOR WILL APPLY	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH		
A	.062	18 or 16			530501
B	NOT USED				530503
C	NOT USED				530505
D	NOT USED				530507

CRIMP	SIZE	TYPE	FEED	APPL INST
WIRE	.090	F		
INSUL *	.140	O	.560	A1 B040

WIRE RANGE 18-16 INSULATION RANGE .090-.130 PRESS NO

REMARKS
AMPOMATOR
* INSULATION CRIMP HEIGHT TO BE .118 ± .003

PIF	LTR	REVISION RECORD	APP DATE	PIF	LTR	REVISION RECORD	APP DATE

F2 ECN 0150-1142-04 NY/RE 9-04
F1 0150-8511-98 US/SAE

SET UP GAGE 10-1 458632-1 103-2
DR APB 15-24
CHK 15-25 REL 15-24
LOC A D NO 466913-1 REV F2

MINIATURE QUICK CHANGE APPLICATOR
SIDE FEED (DUG TYNE FLAG)

AMP INCORPORATED Harrisburg, Pa.

CUSTOMER AND ASSEMBLY DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT.