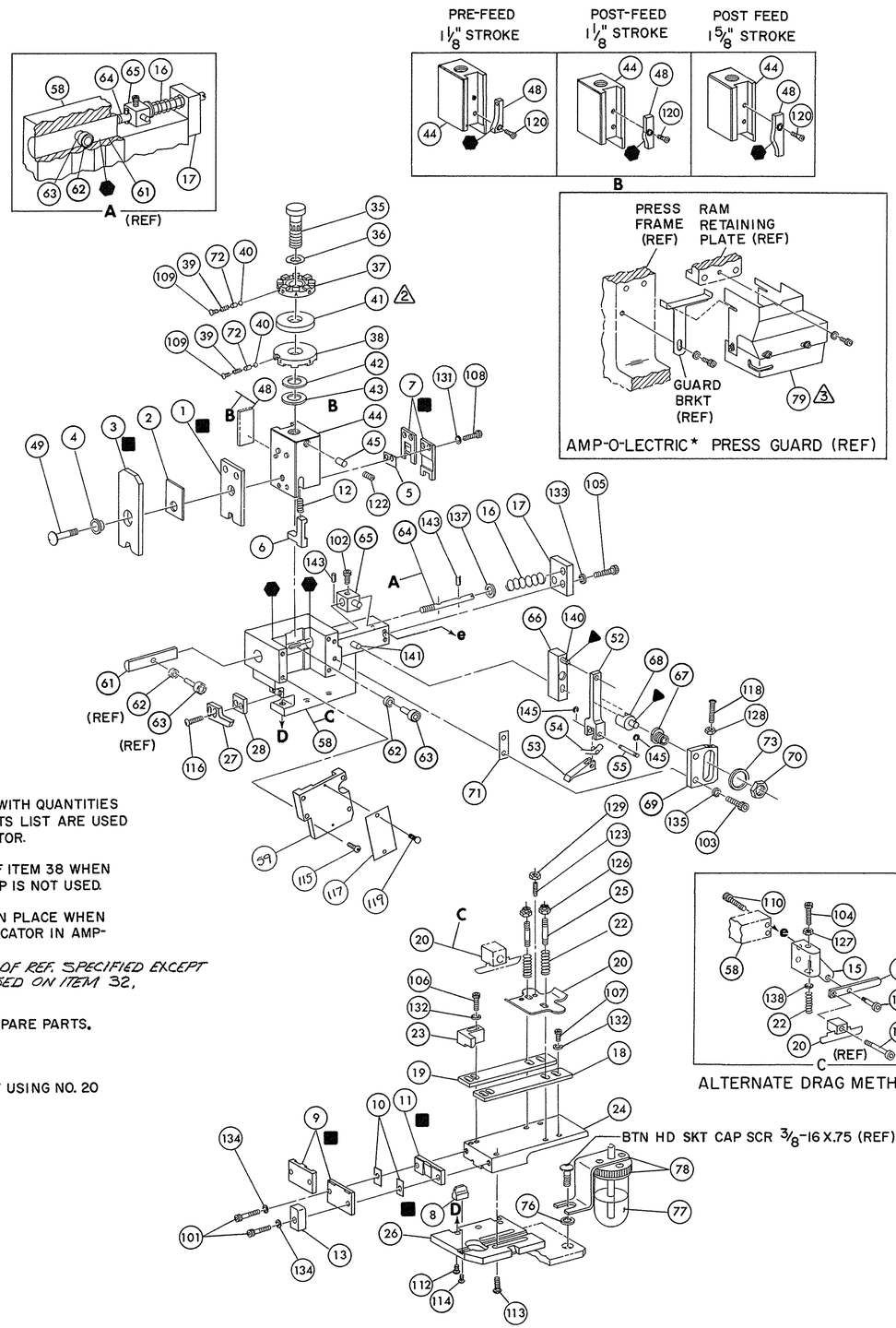
THIS IS A CONTROLLED DOCUMENT.



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.

4.- ITEMS WITH QTY. OF REF. SPECIFIED EXCEPT ITEM 79 ARE USED ON ITEM 32.

KEY:

■ RECOMMENDED SPARE PARTS.

▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.

⬢ GREASE LIGHTLY.

QTY	PART NO	DESCRIPTION	ITEM NO
REF.	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	145
			144
REF.	5-21028-1	PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD	143
			142
REF.	1-21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	141
REF.	1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	140
			139
—	22260-5	WASHER, FLAT (NO 6) DRAG SPRING	138
REF.	21899-4	WASHER, FLAT (5/16 DIA) SCR ADJ	137
2	1-354779-1	PIN, WIRE DISC (.3045)	136
REF.	21024-5	WASHER, LOCK (NO 10) FEED ADJ PLATE	135
2	21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	134
REF.	21024-5	WASHER, LOCK (NO 10) FEED ROD GUIDE	133
4	21024-4	WASHER, LOCK (NO 8) STRIP GUIDE	132
2	21024-4	WASHER, LOCK (NO 8) SHEAR BLADE	131
2	9-354778-6	PIN, WIRE DISC (.2975)	130
2	21018-4	NUT, HEX MACH (4-40) DRAG	129
REF.	21068-5	NUT, HEX MACH (6-32) FD ADJ PLATE	128
—	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	127
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	126
—	5-21004-7	SCR, SKT HD SHLD (.250 DIA X .25) DRAG ARM	125
—	21004-5	SCR, SKT HD SHLD (.250 DIA X 1.00) DRAG	124
2	4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	123
1	21009-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	122
2	8-354778-5	PIN, WIRE DISC (.2920)	121
1	1-21002-7	SCR, BTN HD SKT CAP (6-32 X .38) CAM	120
2	21017-2	SCR, DRIVE (2 x .19) ID PLATE	119
REF.	3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	118
1	461264-1	PLATE, ID	117
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	116
REF.	2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	115
1	22733-8	SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	114
4	3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	113
REF.	2-22733-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	112
2	7-354778-1	PIN, WIRE DISC (.2850)	111
—	2-21000-4	SCR, SKT HD CAP (6-32 X 1.00) DRAG ADAPTOR	110
1	23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	109
2	2-21000-7	SCR, SKT HD CAP (8-32 X .50) SHEAR BLADE	108
3	7-21000-4	SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	107
1	7-21000-4	SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	106
REF.	3-21000-7	SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE	105
–	3-21000-9	SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING	104
REF.	3-21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	103
REF.	3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	102
2	3-21000-8	SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE	101
REF	455745-1	GUARD, WINDOW △3	79
—	465184-9	LUBRICATOR ASSY	78
—	455985-1	OIL, LUBRICATING	77
—	454406-1	SPACER, LUB BRACKET	76
			75
			74
REF.	458109-1	WASHER, FLAT (SPECIAL)	73
1	690603-1	SPRING, ASSIST	72
REF.	690517-1	SPACER	71
	22594-8	NUT, HEX	70
	240628-1	PLATE, ADJ	69
	240626-1	SHAFT, PIVOT	68
	240633-1	BUSHING	67
	455680-1	LEVER, INTERMEDIATE	66
	240629-1	BLOCK, PIVOT	65
	240632-2	SCREW, ADJ	64
	240659-3	PIN, CAM ROLLER	63
	240658-1	CAM, ROLLER	62
REF.	454398-1	ROD, FEED	61
			60

QTY	PART NO	DESCRIPTION	ITEM NO
REF.	454220-1	CAP, RAM	59
REF.	453736-1	HOUSING	58
			57
			56
REF.	240624-1	PIN, FEED FINGER	55
REF	61499-1	SPRING, FEED FINGER	54
REF.	240635-1	FINGER, FEED	53
REF.	240634-3	LEVER, TERMINAL	52
			51
			50
1	7-21002-9	BOLT, CRIMPER	49
1	690602-5	CAM, PRE-FEED 1 1/8 STROKE	48
			47
1	986950-1	WASHER, PRECISION	46
1	690191-1	PLUG, NYLON	45
1	455674-1	RAM	44
1	690125-1	WASHER, LAMINATED	43
1	690124-1	WASHER, RAM	42
		SPACER, DISC △2	41
1	23241-6	BALL, STEEL	40
1	690170-1	SPRING, COMPRESSION	39
1	690142-1	DISC, INSULATION	38
1	354777-1	DISC, WIRE	37
1	22480-5	WASHER, SPRING	36
1	690212-1	POST, RAM	35
			34
			33
1	458980-2	APPLICATOR, BASIC (SUB ASSY)	32
			31
			30
			29
1	3-690451-2	SPACER, STRIPPER	28
1	240639-1	STRIPPER	27
REF.	455676-1	PLATE, BASE	26
2	22354-8	DRAG, STUD	25
1	455678-1	PLATE, STRIP GUIDE	24
		PLATE, STRIP HOLD	23
2	4-22281-1	SPRING, DRAG	22
—	240636-1	LEVER, DRAG	21
1	454177-1	DRAG, STOCK	20
1	458030-2	GUIDE, STRIP (REAR)	19
1	458031-2	GUIDE, STRIP (FRONT)	18
REF.	454178-1	GUIDE, FEED ROD	17
REF.	4-22284-9	SPRING, FEED RETURN	16
		ADAPTER, DRAG	15
			14
		SPACER, HOLD DOWN	13
		SPRING, HOLD DOWN	12
1	240644-1	PLATE, REAR SHEAR ■	11
		SPACER, SHEAR PLATE	10
1	690482-8	PLATE, FRONT SHEAR ■	9
1	461295-8	ANVIL ■	8
1	1-690474-0	BLADE, SLUG ■	7
		HOLD DOWN, TERMINAL	6
1	240641-3	SPACER, SHEAR BLADE	5
1	238009-1	SPACER, TUBULAR	4
1	8-456134-1	CRIMPER, INSULATION ■	3
1	455888-4	SPACER, INSULATION	2
1	456425-1	CRIMPER, WIRE ■	1

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.084	12	
B	.078	(2) 16	
C	.073	14	
D	.067	(1) 16 OR (2) 18	

CRIMP	SIZE	TYPE	FEED	APPL INST
WIRE	.140	F	.855	A1 8039
INSUL	.280	F		

WIRE RANGE (2) 16, 16-12, (2) 18 | INSULATION RANGE .150-.205 OR (2) .125 | PRESS NO 565435-5

REMARKS PRE-FEED AMP-O-LECTRIC

APPLICATOR WILL APPLY

640253

REMARKS	NO	REV
	TO APPLY TERMINAL SPEC 114-2084	
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

P	F	LTR	REVISION RECORD	APP	DATE
E			ECR-08-027767	TM	11-08
D			ECR 05-009434	MG	8-05
C			REV. PER ECN A-261990	JE	8-1-90
B			ECN A-153588	WB	11-1-88
A			REV. PER ECN R-5492		2-1-84

SET UPGAGE 10-1 455638-1 871
DR 2-17-75 APP 12/23/87
CHK 12/1/75 REL 12-23-87
LOC A | D | NO 466536-2 | REV E

AMP INCORPORATED Harrisburg Pa

NAME MINIATURE QUICK CHANGE APPLICATOR
END FEED (RING)

CUSTOMER AND ASSEMBLY DRAWING

DIST 66

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AMP 3076-2 REV 8-74

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