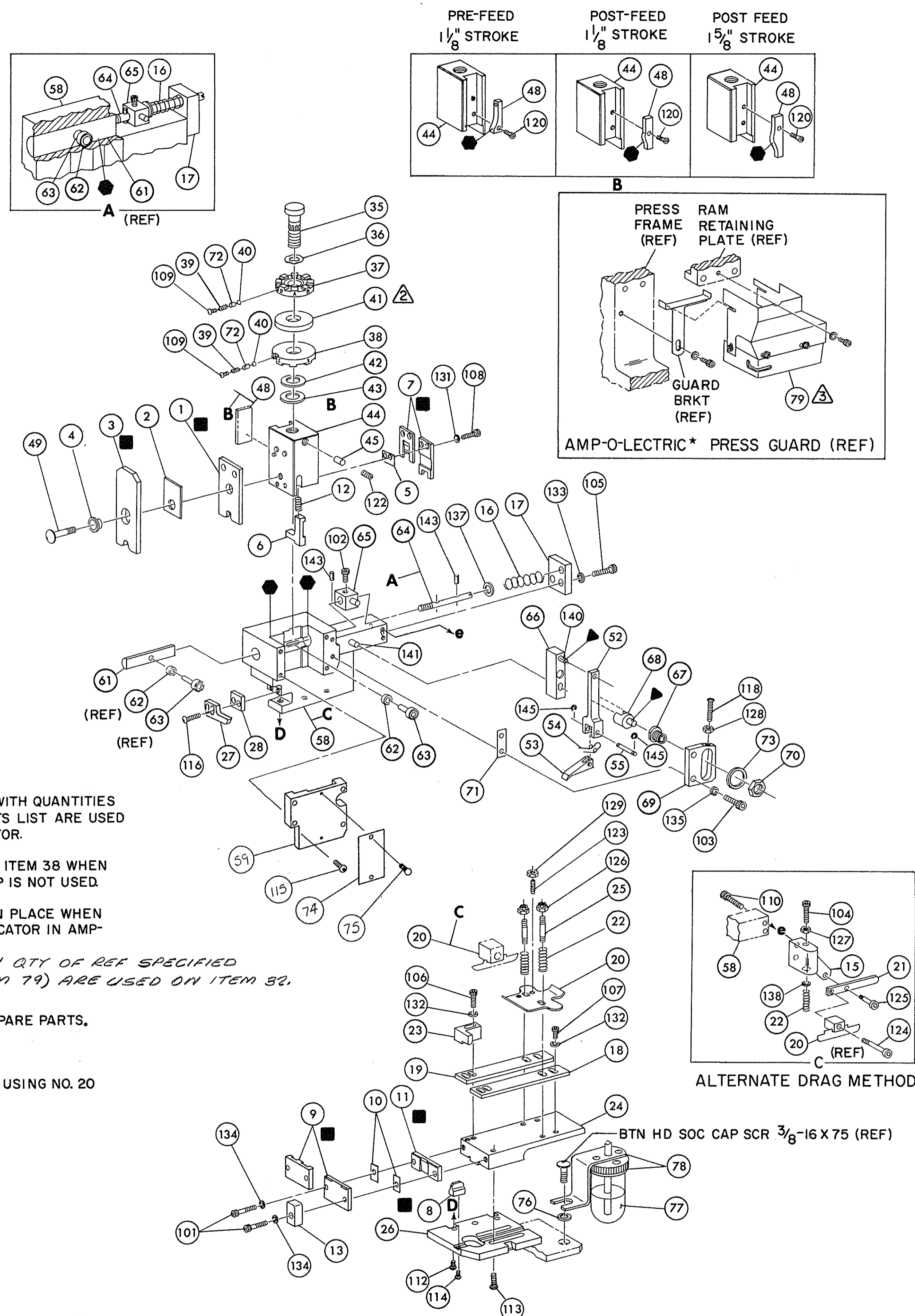


THIS DRAWING IS A CONTROLLED DOCUMENT.



- 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 79) ARE USED ON ITEM 32.
- KEY:**
- RECOMMENDED SPARE PARTS.
  - ▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.
  - GREASE LIGHTLY.

REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	145	REF	454220-1	CAP, RAM	59
				REF	453736-1	HOUSING	58
REF	5-21028-1	PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD	143				57
			142				56
REF	1-21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	141	REF	240624-1	PIN, FEED FINGER	55
REF	1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	140	REF	691499-1	SPRING, FEED FINGER	54
			139	REF	240635-1	FINGER, FEED	53
	22260-5	WASHER, FLAT (NO 6) DRAG SPRING	138	REF	240634-1	LEVER, TERMINAL	52
REF	21899-4	WASHER, FLAT (5/16 DIA) SCR ADJ	137				51
			136				50
REF	21024-5	WASHER, LOCK (NO 10) FEED ADJ PLATE	135	1	7-21002-9	BOLT, CRIMPER	49
2	21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	134	1	690501-4	CAM, POST FEED 15/8 STROKE	48
REF	21024-5	WASHER, LOCK (NO 10) FEED ROD GUIDE	133				47
5	21024-4	WASHER, LOCK (NO 8) STRIP GUIDE	132				46
2	21024-4	WASHER, LOCK (NO 8) SHEAR BLADE	131	1	690191-1	PLUG, NYLON	45
			130	1	455674-1	RAM	44
2	21018-4	NUT, HEX MACH (4-40) DRAG	129	1	690125-1	WASHER, LAMINATED	43
REF	21068-5	NUT, HEX MACH (6-32) FD ADJ PLATE	128	1	690124-1	WASHER, RAM	42
			127				41
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	126	2	23241-6	BALL, STEEL	40
			125	2	690170-1	SPRING, COMPRESSION	39
	5-21004-7	SCR, SKT HD SHLD (250 DIA X .25) DRAG ARM	124	1	690142-1	DISC, INSULATION	38
	21004-5	SCR, SKT HD SHLD (250 DIA X 1.00) DRAG	123	1	8-690692-8	DISC, WIRE	37
2	4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	122	1	22480-5	WASHER, SPRING	36
1	21009-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	121	1	690212-1	POST, RAM	35
			120				34
1	2-21003-0	SCR, FLAT HD SKT CAP (6-32 X .50) CAM	119				33
REF	3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	118	1	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
			117				31
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	116				30
REF	2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	115				29
1	22733-8	SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	114	1	3-690451-2	SPACER, STRIPPER	28
4	3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	113	1	240639-1	STRIPPER	27
REF	1-24073-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	112	REF	455676-1	PLATE, BASE	26
			111	2	22354-8	DRAG, STUD	25
			110	1	458803-8	PLATE, STRIP GUIDE	24
2	23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	109	1	240825-1	PLATE, STRIP HOLD	23
2	2-21000-6	SCR, SKT HD CAP (8-32 X .38) SHEAR BLADE	108	2	4-22281-1	SPRING, DRAG	22
3	7-21000-4	SCR, SKT HD CAP (8-32 X 3/1) 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
REF	3-21000-7	SCR, SKT HD CAP (10-32 X 1.00) FD ROD GUIDE	105	1	454204-1	GUIDE, STRIP (REAR)	19
			104	1	454204-1	GUIDE, STRIP (FRONT)	18
REF	3-21000-9	SCR, SKT HD CAP (8-32 X .75) DRAG SPRING	103	REF	454178-1	GUIDE, FEED ROD	17
REF	3-21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	102	REF	4-22284-9	SPRING, FEED RETURN	16
REF	3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	101			ADAPTER, DRAG	15
2	3-21000-8	SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE	79				14
REF	455745-1	GUARD, WINDOW	79				14
			78	1	690481-7	SPACER, HOLD DOWN	13
	465184-9	LUBRICATOR ASSY	77	1	23846-1	SPRING, HOLD DOWN	12
	455985-1	OIL, LUBRICATING	76	1	240833-7	PLATE, REAR SHEAR	11
	454406-1	SPACER, LUB BRACKET	75			SPACER, SHEAR PLATE	10
2	21017-2	SCR, DRIVE (#2 X .19) ID PLATE	74	1	1-690495-2	PLATE, FRONT SHEAR	9
1	461264-1	PLATE, IDENTIFICATION	73	1	238005-7	ANVIL	8
REF	458109-1	WASHER, FLAT (SPECIAL)	72	1	690474-6	BLADE, SLUG	7
2	690603-1	SPRING, ASSIST	71	1	1-455892-2	HOLD DOWN, TERMINAL	6
REF	690517-1	SPACER	70	1	4-240641-8	SPACER, SHEAR BLADE	5
	22594-8	NUT, HEX	69	1	238009-1	SPACER, TUBULAR	4
	240628-1	PLATE, ADJ	68	1	1-456134-8	CRIMPER, INSULATION	3
	240626-1	SHAFT, PIVOT	67	1	455888-8	SPACER, INSULATION	2
	240633-1	BUSHING	66	1	1-456405-5	CRIMPER, WIRE	1
	455680-1	LEVER, INTERMEDIATE	65				
	240629-1	BLOCK, PIVOT	64				
	240632-2	SCREW, ADJ	63				
	240659-3	PIN, CAM ROLLER	62				
	240658-1	CAM, ROLLER	61				
	454398-1	ROD, FEED	60				

CRIMPING DATA				APPLICATOR WILL APPLY	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	170015	
A	.052	16			
B	.044	18			
C	.039	20			
D	NOT USED				
CRIMP	SIZE	TYPE	FEED	APPL INST	
WIRE	.080	F		A18039	
INSUL	.120	F	.665		
WIRE RANGE	20-16	INSULATION RANGE	.080-.120	PRESS NO	
REMARKS					
AMPOMATOR					

REMARKS		NO	REV
TO APPLY TERMINAL		NONE	
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	

<table border="1"> <tr> <th>P/F</th> <th>LTR</th> <th>REVISION RECORD</th> <th>APP DATE</th> <th>P/F</th> <th>LTR</th> <th>REVISION RECORD</th> <th>APP DATE</th> </tr> <tr> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> </tr> </table>	P/F	LTR	REVISION RECORD	APP DATE	P/F	LTR	REVISION RECORD	APP DATE									<table border="1"> <tr> <td>D</td> <td>ECN DISD-1249-03</td> <td>DATE</td> <td>11-03</td> </tr> <tr> <td>T/C</td> <td>DISD-6588-96</td> <td>DATE</td> <td>11-06</td> </tr> <tr> <td>B</td> <td>ECN A19768B</td> <td>DATE</td> <td>11-88</td> </tr> <tr> <td>A</td> <td>REV FOR EOD R-5A78</td> <td>DATE</td> <td>11-88</td> </tr> </table>	D	ECN DISD-1249-03	DATE	11-03	T/C	DISD-6588-96	DATE	11-06	B	ECN A19768B	DATE	11-88	A	REV FOR EOD R-5A78	DATE	11-88	<table border="1"> <tr> <td>SET UP PAGE</td> <td>10-1</td> </tr> <tr> <td>458638-1</td> <td>225</td> </tr> <tr> <td>DB/1/74</td> <td>APP 8/7/74</td> </tr> <tr> <td>FRANK</td> <td>REVISION</td> </tr> <tr> <td>11-88</td> <td>REL 8/17</td> </tr> <tr> <td>11-88</td> <td>REL 8/17</td> </tr> </table>	SET UP PAGE	10-1	458638-1	225	DB/1/74	APP 8/7/74	FRANK	REVISION	11-88	REL 8/17	11-88	REL 8/17	<table border="1"> <tr> <td>LOC</td> <td>A</td> <td>D</td> <td>NO</td> <td>466227-1</td> <td>REV</td> <td>D</td> </tr> </table>	LOC	A	D	NO	466227-1	REV	D
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**MINIATURE QUICK CHANGE APPLICATOR**  
END FEED (.110 FASTIN FASTON)

AMP INCORPORATED  
Harrisburg, Pa.

CUSTOMER AND ASSEMBLY DRAWING