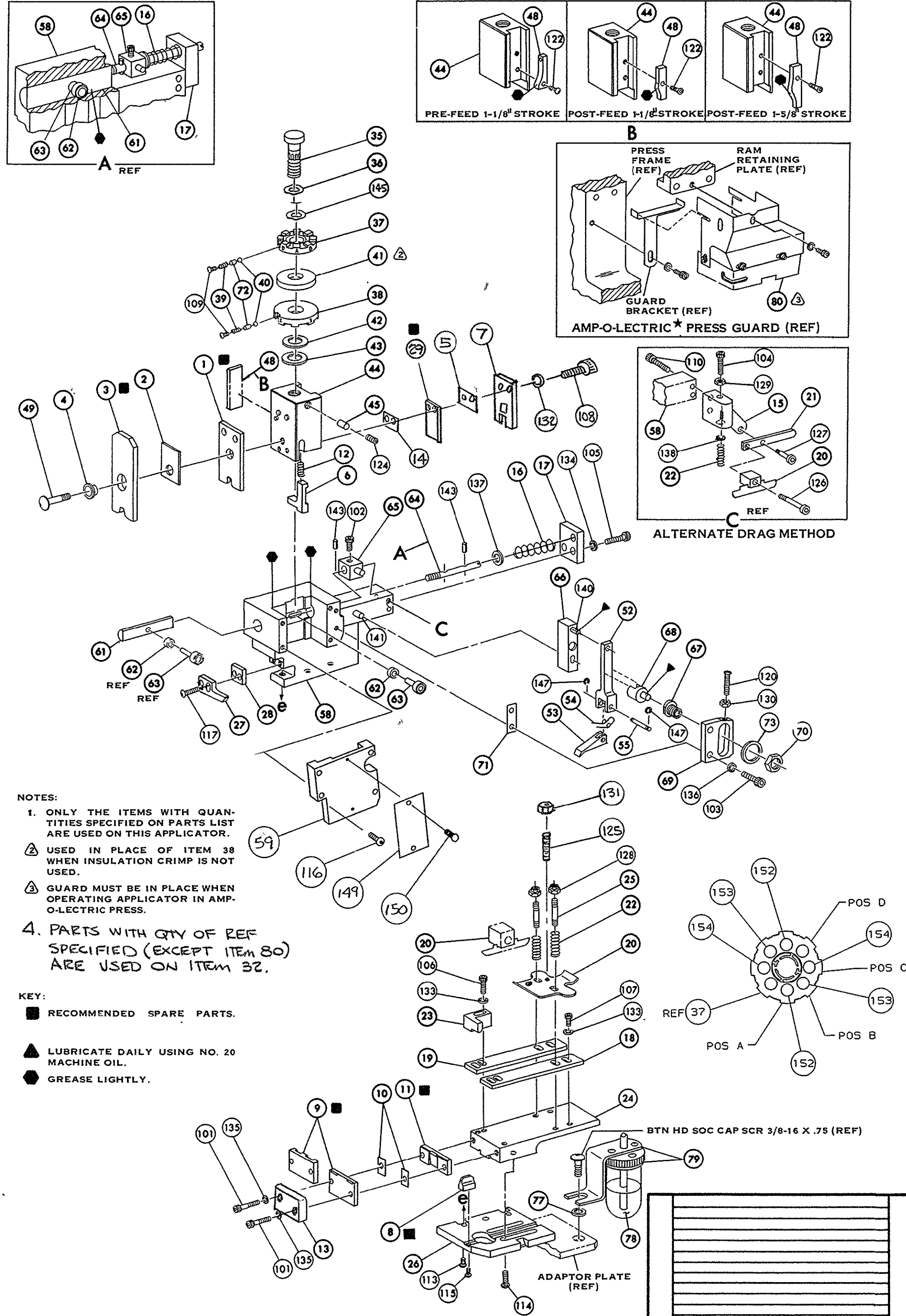


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- NOTES:**
1. ONLY THE ITEMS WITH QUANTITIES SPECIFIED ON PARTS LIST ARE USED ON THIS APPLICATOR.
  2. USED IN PLACE OF ITEM 38 WHEN INSULATION CRIMP IS NOT USED.
  3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-O-LECTRIC PRESS.
  4. PARTS 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		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	240634-3	LEVER, TERMINAL	52
			142				51
			141				50
			140				49
			139	1	7-21002-9	BOLT, CRIMPER	48
			138	1	690501-3	CAM, POSTFEED 1-1/8 STROKE	47
			137				46
			136	1	690191-1	PLUG, NYLON	45
			135	1	455674-2	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	354777-1	DISC, WIRE	37
			127	1	22480-5	WASHER, SPRING	36
			126	1	690212-1	POST, RAM	35
			125				34
			124				33
			123	1	458980-2	APPLICATOR, BASIC (SUB ASSY)	32
			122				31
			121				30
			120	1	690759-1	TOOL, FLANGING	29
			119	1	2-690451-2	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	455678-6	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	1	2-240641-8	SPACER, HOLD DOWN FLANGE	14
			104	1	690783-1	PLATE, RETAINING	13
			103			SPRING, HOLD DOWN	12
			102	1	1-240833-0	PLATE, REAR SHEAR	11
			101	2	240645-7	SPACER, SHEAR PLATE	10
			80	1	690784-2	PLATE, FRONT SHEAR	9
			79	1	2-240654-3	ANVIL	8
			78	1	1-240651-5	BLADE, SLUG	7
			77			HOLD DOWN	6
			76	1	4-240641-8	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
A	.089	14		40705- -A
B	.082	16		40819- -A
C	.078	18		41473- -A
D	NOT USED			350435- -A
CRIMP SIZE	TYPE	FEED	PRESS REF.	
.140	F			
WIRE		.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	LAYOUT NO.	AMP INCORPORATED HARRISBURG, PENNA.		
458638-1	237-A	REV. 5-6-80		
ECN 0150-0532-03	APPROVED	LOC A C NO. 687810-8		
REV PER ECU 72-5309	DATE 5-12-80	SCALE NONE		
REV PER ECU	DATE 2/18/76	NAME		
REV PER ECU	DATE 2/28/76	MINIATURE QUICK CHANGE APPLICATOR		
		END-FEED (FLANGED SPADE)		