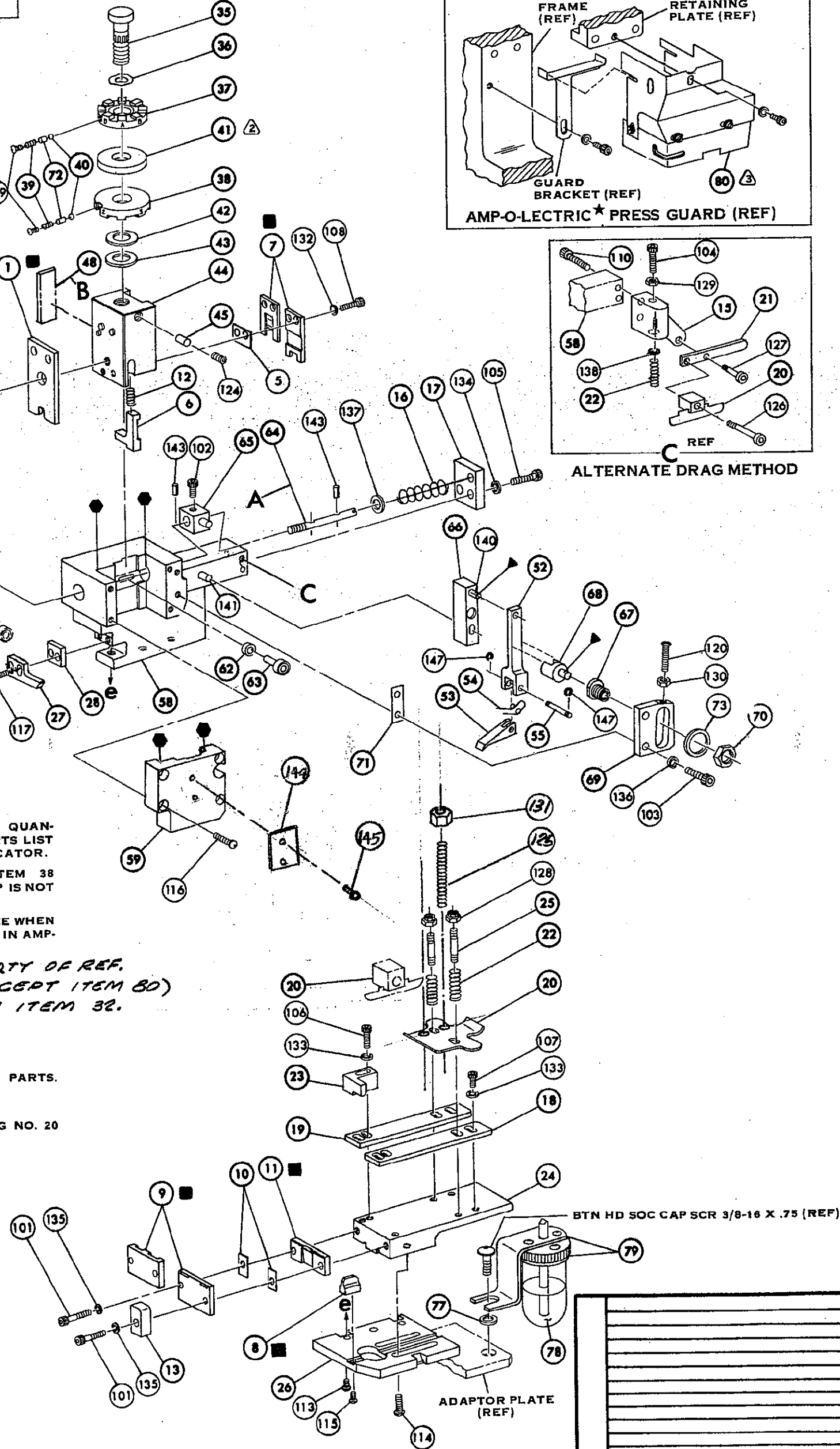


NOTES:

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-ELECTRIC PRESS.
- A. 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	
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	146	REF	240624-1	PIN, FEED FINGER	55	
2	21017-2	SCR, DRIVE (#2 X .19) I.D. PLATE	145	REF	691499-1	SPRING, FEED FINGER	54	
1	461264-1	PLATE, IDENTIFICATION	144	REF	240635-1	FINGER, FEED	53	
REF	5- 21028-1	PIN, SLOT SPG (.12 DIA X .50) FEED ADJ ROD	143	REF	240634-1	LEVER, TERMINAL	52	
			142				51	
REF	1- 21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	141				50	
REF	1- 21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	140	1	7-21002-9	BOLT, CRIMPER	49	
			139	1	690501-9	CAM, POST FEED 1- 5/8 STROKE	48	
			138				47	
			137				46	
REF	22260-5	WASH, FLAT (NO. 6) DRAG SPRING	136	1	690191-1	PLUG, NYLON	45	
REF	21899-4	WASH, FLAT (NO. 5/16 DIA) SCR ADJ	135	1	455674-1	RAM	44	
REF	21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE	134	1	690125-1	WASHER, LAMINATED	43	
REF	21024-5	WASH, LOCK (NO. 10) SHEAR PLATES	133	1	690124-1	WASHER, RAM	42	
REF	21024-5	WASH, LOCK (NO. 8) STRIP GUIDE	132	1	690223-1	SPACER, DISC	41	
REF	21024-4	WASH, LOCK (NO. 8) SHEAR BLADE	131	1	23241-6	BALL, STEEL	40	
REF	21018-7	NUT, HEX MACH (6-32) FEED ADJ PLATE	130	1	690170-1	SPRING, COMPRESSION	39	
REF	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	129			DISC, INSULATION	38	
REF	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUDS	128	1	3-692155-2	DISC, WIRE	37	
REF	5- 21004-7	SCR, SKT HD SHLD (.250 DIA X .25) DRAG ARM	127	1	22480-5	WASHER, SPRING	36	
			126	1	690212-1	POST, RAM	35	
REF	21004-5	SCR, SKT HD SHLD (.250 DIA X 1.00) DRAG	125				34	
REF	4- 21028-8	SCR, SKT SET QVAL PT (4-40 X .75) DRAG	124				33	
REF	1	21009-2	SCR, SKT SET (1/4-20 X .25) NYLOK RAM	123	1	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
REF	1	1-21007-7	SCR, BUT HD SOC CAP (6-32 X .38) CAM	122			31	
			121				30	
REF	3- 21064-2	SCR, RDH HD MACH (6-32 X 1.50) FEED ADJ	120				29	
			119	1	3-690451-2	SPACER, STRIPPER	28	
			118	1	240639-1	STRIPPER	27	
REF	2- 21002-2	SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	117	REF	455676-1	PLATE, BASE	26	
REF	2- 21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	116	2	22359-8	DRAG, STUD	25	
REF	1	22733-8	SCR, BTN HD SKT CAP (8-32 X .38) NYLOK ANVIL	115	1	455678-1	PLATE, STRIP GUIDE	24
REF	4	3- 21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	114	1	240625-7	PLATE, STRIP HOLD	23
REF	1-24073-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PLATE	113	2	4-22281-7	SPRING, DRAG	22	
			112	-	240636-1	LEVER, DRAG	21	
			111	1	454177-1	DRAG, STOCK	20	
			110	1	454204-2	GUIDE, STRIP REAR	19	
REF	2- 21000-4	SCR, SKT HD CAP (6-32 X 1.00) DRAG ADAPTOR	109	1	454204-2	GUIDE, STRIP FRONT	18	
REF	1	3- 23657-8	SCR, SKT HD CAP (6-32 X .25) NYLOK C. P. DISC	108	REF	454178-1	GUIDE, FEED ROD	17
REF	2	21000-7	SCR, SKT HD CAP (8-32 X .50) SHEAR BLADE	107	REF	4-22284-9	SPRING, FEED RETURN	16
REF	3	7-21000-4	SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	106	-	454665-1	ADAPTOR, DRAG	15
REF	2	21000-8	SCR, SKT HD CAP (8-32 X .62) STRIP GUIDE	105			14	
REF	3- 21000-7	SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE	104	1	690481-3	SPACER, HOLD DOWN	13	
REF	3- 21000-9	SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING	103	1	23596-1	SPRING, HOLD DOWN	12	
REF	3- 21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	102	1	240644-1	PLATE, REAR SHEAR	11	
REF	3- 21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	101			SPACER, SHEAR PLATE	10	
REF	2	3- 21000-8	SCR, SKT HD CAP (10-32 X .88) SHEAR PLATES	80	1	690657-1	PLATE, FRONT SHEAR	9
REF	455745-1	GUARD, WINDOW	79	1	1-240654-2	ANVIL	8	
			78	1	690474-5	BLADE, SLUG	7	
			77	1	1-455898-8	HOLD DOWN	6	
			76	1	1-240641-2	SPACER, SHEAR BLADE	5	
			75			SPACER, TUBULAR, INS CRIMPER	4	
			74			CRIMPER, INSULATION	3	
REF	458109-1	WASHER, FLAT (SPECIAL)	73			SPACER, INSULATION	2	
REF	690603-1	SPRING, ASSIST	72	1	1-454426-1	CRIMPER, WIRE	1	

CRIMPING DATA				THIS APPLICATOR WILL APPLY	
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	60733	
A	.074	#16			
B	.067	#18			
C	.062	#20			
D	NOT USED				
CRIMP WIRE	SIZE	TYPE	FEED	PRESS REF.	
	.090	F			
INSULATION			.730		
INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION			
	20-16	#8031			
REMARKS AMPOMATOR					

SET UP GAGE 458633-1 LAYOUT NO. 412
 DR. MAN. 12/28/73 APPROVED 11/9/79
 CHECKED 11-8-74
 SCALE NONE NAME NONE
AMP AMP INCORPORATED HARRISBURG, PENNA.
 LOC. NO. A C 687973-1 REV. F
MINIATURE QUICK CHANGE APPLICATOR
END-FEED (PIN RECEPT)
 Customer & Assembly Drawing

REV.	DESCRIPTION	DATE	BY
F	0150-8328-98		
E	0150-8254-95 REACT		
D	0150-6723-96 GBE		
C	0150-6320-95		
B	REV. PER ECN R-5326		
A	REV PER ECN R-2789		

687973-1