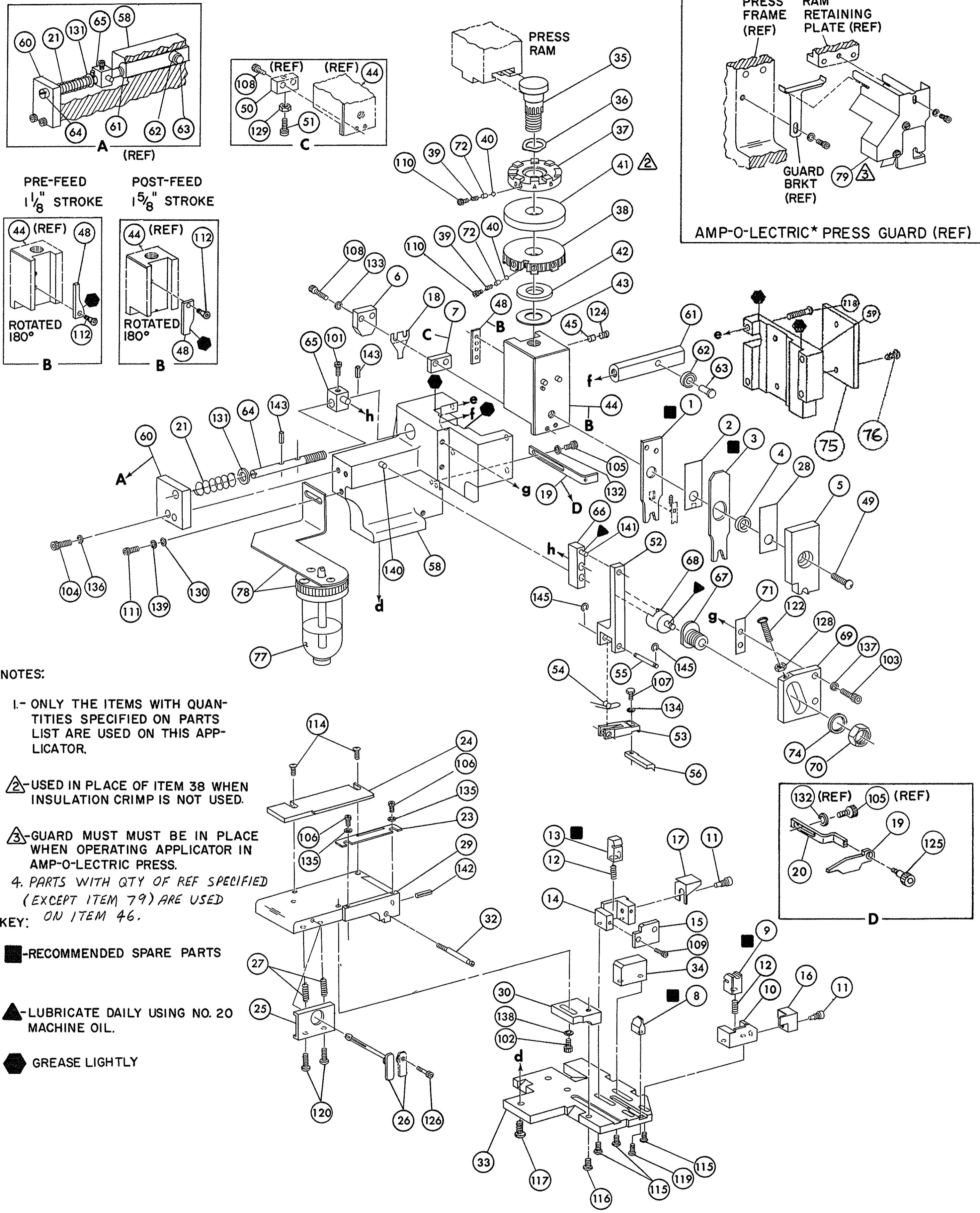


THIS IS A CONTROLLED DOCUMENT



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. PARTS WITH QTY OF REF SPECIFIED (EXCEPT ITEM 79) ARE USED ON ITEM 46.

KEY:

-RECOMMENDED SPARE PARTS

-LUBRICATE DAILY USING NO. 20 MACHINE OIL.

GREASE LIGHTLY

| | | | | | | | |
|-----|------------|--|-----|-----|------------|-------------------------------|----|
| 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 | 458537-2 | PAWL, FEED | 56 |
| REF | 1-21030-6 | PIN, DOWEL (.187 DIA X 1.25) HOUSING | 141 | REF | 240624-1 | PIN, FEED FINGER | 55 |
| 1 | 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) ADJ PLATE | 138 | REF | 455679-1 | LEVER, TERMINAL FEED ARM | 52 |
| REF | 21024-5 | WASHER, LOCK (NO 10) FEED GUIDE ROD | 137 | | | BUMPER, HOLDDOWN | 51 |
| 2 | 21024-2 | WASHER, LOCK (NO 4) FRONT STRIP GUIDE | 136 | | | SPACER, TONKER | 50 |
| 1 | 21024-4 | WASHER, LOCK (NO 8) FEED FINGER | 135 | 1 | 7-21002-9 | BOLT, CRIMPER | 49 |
| 1 | 21024-4 | WASHER, LOCK (NO 8) DEPRESSOR | 134 | 1 | 690602-5 | CAM PRE FEED | 48 |
| REF | 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 |
| 1 | 21899-2 | WASHER, FLAT (NO 10) LUB ASSY | 131 | 1 | 690191-1 | PLUG, NYLON | 45 |
| 1 | 21018-5 | NUT, HEX MACH (6-32) HOLDDOWN | 130 | 1 | 455673-1 | RAM | 44 |
| REF | 21018-5 | NUT, HEX MACH (6-32) FEED ADJ | 129 | 1 | 690125-1 | WASHER, LAMINATED | 43 |
| REF | 22353-8 | SCR, SHLD. (.187 DIA X .250 LG) DRAG LEVER | 128 | 1 | 690124-1 | WASHER, RAM | 42 |
| 1 | 456567-1 | SCR, SHLD. (.188 DIA X .125 LG) STRIPPER | 127 | 1 | 690223-1 | DISC, SPACER | 41 |
| 1 | 21009-2 | SCR, SKT SET (1/4-20 X .25) (LOC-WEL) RAM | 126 | 1 | 23241-6 | BALL, STEEL | 40 |
| | | | 125 | 1 | 690170-1 | SPRING, COMPRESSION | 39 |
| REF | 6-23715-5 | SCR, PANHD MACH (6-32 X 1.50) FEED ADJ | 124 | | | DISC, INSULATION | 38 |
| | | | 123 | 1 | 4-692155-7 | DISC, WIRE | 37 |
| 2 | 5-21008-6 | SCR, SKT SET (10-32 X .75) DRAG | 122 | 1 | 22480-5 | WASHER, SPRING | 36 |
| 1 | 22733-8 | SCR, BUT HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL | 121 | 1 | 690212-1 | POST, RAM | 35 |
| REF | 2-21002-9 | SCR, BUT HD SKT CAP (10-32 X .75) CAP | 120 | | | SUPPORT, TERMINAL | 34 |
| REF | 17177-1 | SCR, BUT HD SKT CAP (1/4-20 X .62) HOUSING | 119 | REF | 455675-1 | PLATE, BASE | 33 |
| REF | 2-21002-7 | SCR, BUT HD SKT CAP (10-32 X .50) SG ADJ BLOCK | 118 | 1 | 690432-3 | SCREW, ADJUSTMENT | 32 |
| 2 | 2-21002-2 | SCR, BUT HD SKT CAP (8-32 X .50) SHEAR | 117 | | | | 31 |
| 2 | 2-21002-1 | SCR, BUT HD SKT CAP (8-32 X .38) R STRIP GUIDE | 116 | REF | 455689-1 | BLOCK, STRIP GUIDE ADJ | 30 |
| | | | 115 | 1 | 2-458144-4 | PLATE, STRIP GUIDE | 29 |
| | | | 114 | 1 | 455888-8 | 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 | 356835-1 | LEVER, DRAG RELEASE | 26 |
| 1 | 3-21000-4 | SCR, SKT HD CAP (10-32 X .38) LUBRICATOR ASSY | 111 | 1 | 240792-1 | DRAG, STOCK | 25 |
| 1 | 23030-1 | SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC | 110 | 1 | 6-690504-4 | GUIDE STRIP (REAR) | 24 |
| | | | 109 | 1 | 690438-1 | GUIDE, STRIP (FRONT) | 23 |
| | | | 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 |
| 2 | 1-21000-3 | SCR, SKT HD CAP (4-40 X .25) F STRIP GUIDE | 106 | 1 | 458950-1 | ARM, STRIPPER | 20 |
| 1 | 2-21000-7 | SCR, SKT HD CAP (8-32 X .50) STRIPPER | 105 | 1 | 458949-1 | STRIPPER | 19 |
| REF | 3-21000-7 | SCR, SKT HD CAP (10-32 X .75) FEED ROD GUIDE | 104 | | | HOLDER, TERMINAL | 18 |
| REF | 3-21000-6 | SCR, SKT HD CAP (10-32 X .62) FEED ADJ BLOCK | 103 | | | GUARD, CHIP (REAR) | 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 | | | PLATE, SHEAR (REAR) | 15 |
| REF | 455749-1 | GUARD (WINDOW) | 79 | | | HOLDER, SHEAR (REAR) | 14 |
| 1 | 1-465184-0 | LUBRICATOR ASSY | 78 | | | SHEAR, FLOAT (REAR) | 13 |
| | | | 77 | | | SPRING, SHEAR | 12 |
| 2 | 21017-2 | SCR, DRIVE (#2 X .19) I. D. PLATE | 76 | 1 | 3-22280-3 | STOP, SHEAR | 11 |
| 1 | 461264-1 | PLATE, I. D. | 75 | 1 | 690461-1 | HOLDER, SHEAR (FRONT) | 10 |
| REF | 458109-1 | WASHER, SPECIAL | 74 | 1 | 690459-1 | SHEAR, FLOAT (FRONT) | 9 |
| | | | 73 | 1 | 454276-1 | ANVIL | 8 |
| | | | 72 | | | SPACER, DEPRESSOR (REAR) | 7 |
| | | | 71 | | | DEPRESSOR, SHEAR (REAR) | 6 |
| | | | 70 | 1 | 455889-9 | DEPRESSOR, SHEAR (FRONT) | 5 |
| | | | 69 | | | SPACER, TUBULAR, INS CRIMPER | 4 |
| | | | 68 | | | CRIMPER, INSULATION | 3 |
| | | | 67 | | | SPACER, CRIMPER | 2 |
| | | | 66 | 1 | 3-456406-3 | CRIMPER, WIRE | 1 |

| QTY | PART NO | DESCRIPTION | ITEM NO |
|-----|----------|----------------------------|---------|
| | | PLATE, STRIP GUIDE COVER | 73 |
| | | SPRING, ASSIST | 72 |
| | | SPACER | 71 |
| | | NUT, HEX | 70 |
| | | PLATE, ADJUSTMENT | 69 |
| | | SHAFT, PIVOT | 68 |
| | | BUSHING | 67 |
| | | LEVER, INTERMEDIATE | 66 |
| | | BLOCK, PIVOT | 65 |
| | | SCREW, ADJUSTMENT FEED ROD | 64 |
| | | PIN, CAM ROLLER | 63 |
| | | ROLLER, CAM | 62 |
| | | ROD, FEED | 61 |
| REF | 454178-1 | GUIDE, FEED ROD | 60 |

| CRIMPING DATA | | | | APPLICATOR WILL APPLY |
|--------------------------------------|--------------|------------------|-------------------|-----------------------|
| PAD LTR | CRIMP HEIGHT | WIRE SIZE | WIRE STRIP LENGTH | |
| A | .057 | 18 | | 63364 |
| B | .053 | 20 | | |
| C | .051 | 22 | | |
| D | NOT USED | | | |
| CRIMP | SIZE | TYPE | FEED | APPL INST |
| WIRE | .090 | F | .360 | A1 8040 |
| INSUL | | | | |
| WIRE RANGE 22-18 | | INSULATION RANGE | | PRESS NO 565435-5 |
| REMARKS AMP-O-LECTRIC PRE-FEED | | | | |

| | | |
|---|----------------|----------------|
| 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 |
| SET UP GAGE 10-1 458637-1 1253 DR 5-11-84 APR 84 C. E. ... CHK 5-15-84 REL 5/12/84 UEG | | |
| AMP INCORPORATED Harrisburg, Pa | | |
| NAME MINIATURE QUICK CHANGE APPLICATOR SIDE FEED (MAG MATE POKE-IN TAB) | | |
| LOC A | D | NO 567165-2 |
| REV B | | |