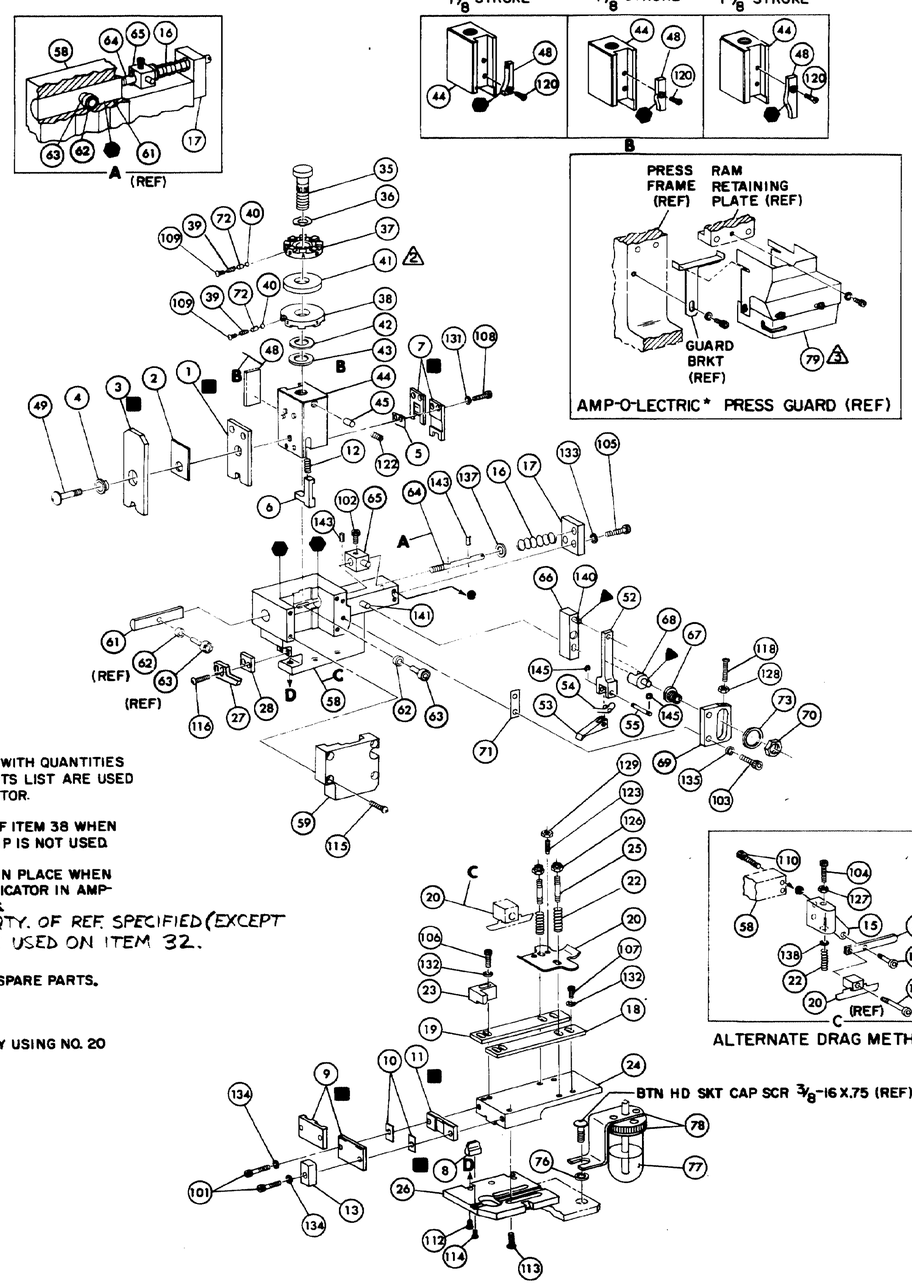


NOTES:

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 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 |
| | | | 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 |
| | | | 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 |
| | | | 121 |
| 1 | 1-21002-7 | SCR, BTN HD SKT CAP (6-32 X .38) CAM | 120 |
| | | | 119 |
| REF. | 3-21064-2 | SCR, RD HD MACH (6-32 X 1.50) FEED ADJ | 118 |
| | | | 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 |
| | | | 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 | 2-21000-6 | SCR, SKT HD CAP (8-32 X .38) SHEAR BLADE | 108 |
| 3 | 2-21000-6 | SCR, SKT HD CAP (8-32 X .38) STRIP GUIDE | 107 |
| 2 | 2-21000-8 | SCR, SKT HD CAP (8-32 X .62) 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. | 691499-1 | SPRING, FEED FINGER | 54 |
| REF. | 240635-1 | FINGER, FEED | 53 |
| REF. | 240634-1 | LEVER, TERMINAL | 52 |
| | | | 51 |
| | | | 50 |
| 1 | 7-21002-9 | BOLT, CRIMPER | 49 |
| 1 | 690602-5 | CAM, PRE-FEED 1 1/8 STROKE | 48 |
| | | | 47 |
| | | | 46 |
| 1 | 690191-1 | PLUG, NYLON | 45 |
| 1 | 455674-1 | RAM | 44 |
| 1 | 690125-1 | WASHER, LAMINATED | 43 |
| 1 | 690124-1 | WASHER, RAM | 42 |
| 1 | 690223-1 | SPACER, DISC △4 | 41 |
| 1 | 23241-6 | BALL, STEEL | 40 |
| 1 | 690170-1 | SPRING, COMPRESSION | 39 |
| | | DISC, INSULATION | 38 |
| 1 | 2-455829-2 | DISC, WIRE | 37 |
| 1 | 22480-5 | WASHER, SPRING | 36 |
| 1 | 690212-1 | POST, RAM | 35 |
| | | | 34 |
| | | | 33 |
| 1 | 458980-1 | 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 | 455678-5 | PLATE, STRIP GUIDE | 24 |
| 1 | 240825-9 | PLATE, STRIP HOLD | 23 |
| 2 | 4-22281-1 | SPRING, DRAG | 22 |
| — | 240636-1 | LEVER, DRAG | 21 |
| 1 | 454177-1 | DRAG, STOCK | 20 |
| 1 | 454204-2 | GUIDE, STRIP (REAR) | 19 |
| 1 | 454204-2 | GUIDE, STRIP (FRONT) | 18 |
| REF. | 454178-1 | GUIDE, FEED ROD | 17 |
| REF. | 4-22284-9 | SPRING, FEED RETURN | 16 |
| | | ADAPTER, DRAG | 15 |
| | | | 14 |
| 1 | 690481-7 | SPACER, HOLD DOWN | 13 |
| 1 | 23846-1 | SPRING, HOLD DOWN | 12 |
| 1 | 240644-8 | PLATE, REAR SHEAR ■ | 11 |
| | | SPACER, SHEAR PLATE | 10 |
| 1 | 1-690482-9 | PLATE, FRONT SHEAR ■ | 9 |
| 1 | 2-240654-6 | ANVIL ■ | 8 |
| 1 | 2-690474-3 | BLADE, SLUG ■ | 7 |
| 1 | 455892-9 | HOLD DOWN, TERMINAL | 6 |
| 1 | 4-240641-0 | SPACER, SHEAR BLADE | 5 |
| | | SPACER, TUBULAR | 4 |
| | | CRIMPER, INSULATION ■ | 3 |
| | | SPACER, INSULATION | 2 |
| 1 | 456410-5 | CRIMPER, WIRE ■ | 1 |

**CRIMPING DATA**

| PAD LTR | CRIMP HEIGHT | WIRE SIZE | WIRE STRIP LENGTH |
|---|---|---|---|
| A | CRIMP | | |
| B | UNTIL | | |
| C | TIGHT | | |
| D | | | |

| CRIMP | SIZE | TYPE | FEED | APPL INST |
|---|---|---|---|---|
| WIRE | — | — | .655 | A1 8039 |
| INSUL | 130 | F | | |

| WIRE RANGE | INSULATION RANGE | PRESS NO |
|---|---|---|
| — | .075-.100 | 565435-5 |

REMARKS
PRE-FEED AMP-O-LECTRIC
INS CRIMP ONLY. WIRE INSERTED IN PIN & SOLDERED

**APPLICATOR WILL APPLY**

60420

| REMARKS | NO | REV |
|---|---|---|
| | TO APPLY TERMINAL | |
| 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 |
|---|---|---|---|---|
| B | | REV PER ECN A-153583 | | 11-1-88 |
| A | | REV PER ECN 2-5-97 | | |

SET UP GAGE 10-1 458638-1 6928
DR 2-10-77 APP
CHK 3/4/77 REL

AMP INCORPORATED Harrisburg, Pa

LOC A D NO 466640-1 REV B

NAME MINIATURE QUICK CHANGE APPLICATOR
END FEED (INS. PER ... BE DIA. PIN)

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