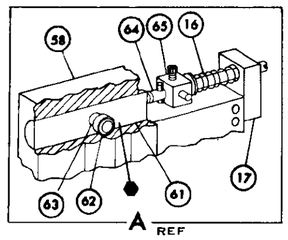
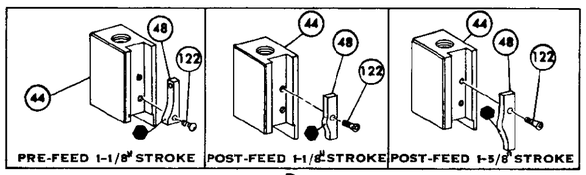
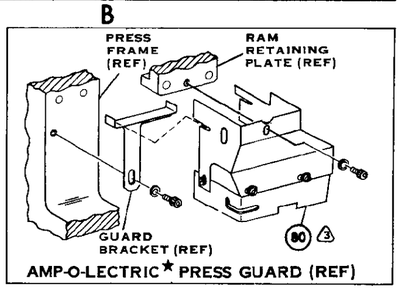
THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INC. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.



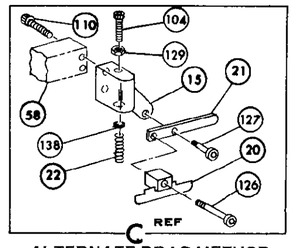

A REF



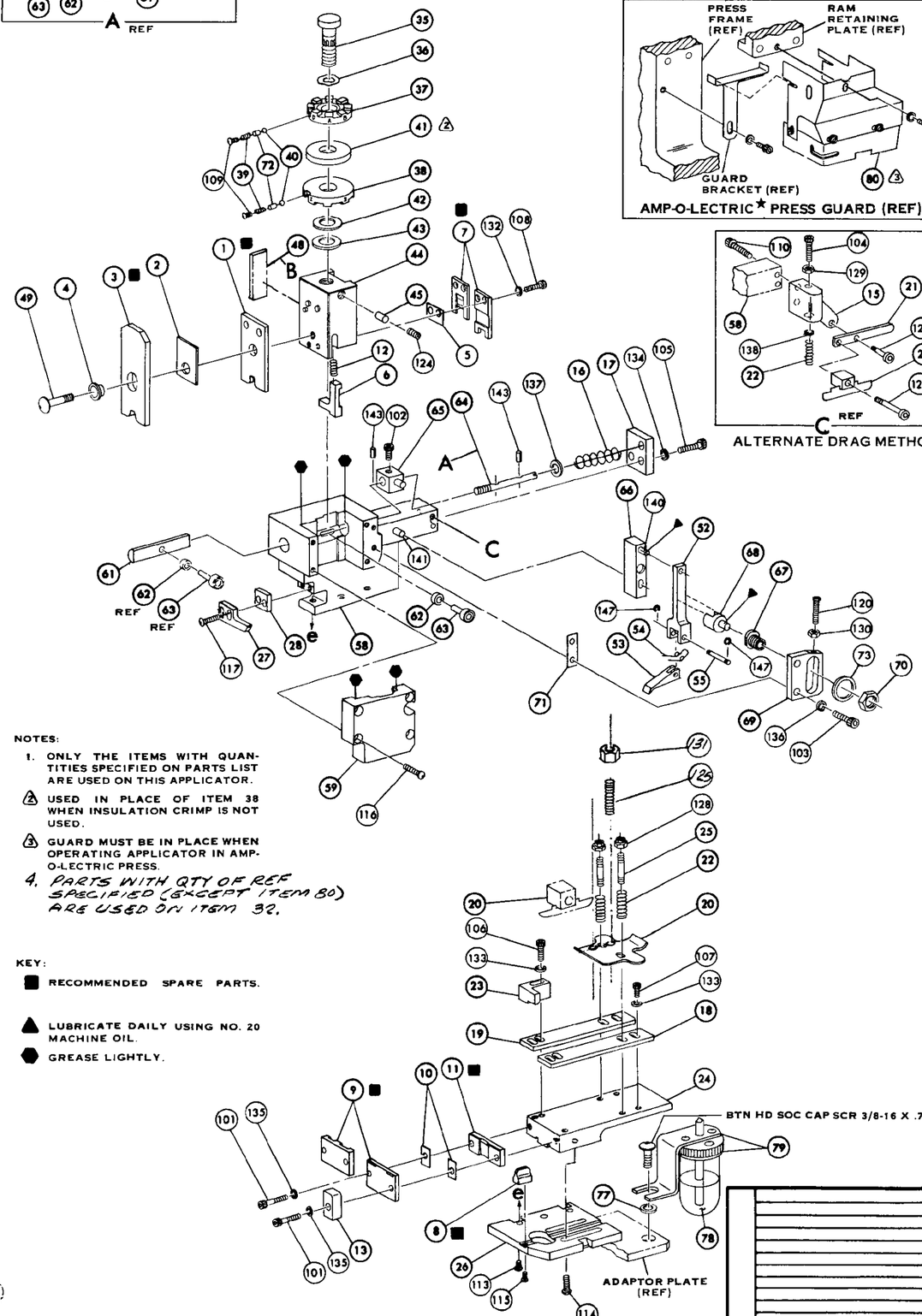

B




AMP-O-LECTRIC★ PRESS GUARD (REF)




C ALTERNATE DRAG METHOD




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.

DIMENSIONS IN INCHES DO NOT SCALE PRINT

THIS INFORMATION IS CONFIDENTIAL AND IS DISCLOSED TO YOU ON CONDITION THAT NO FURTHER DISCLOSURE IS MADE BY YOU TO OTHERS THAN AMP PERSONNEL WITHOUT WRITTEN AUTHORIZATION FROM AMP INCORPORATED, HARRISBURG, PA.

PRINT DATE

★TRADEMARK OF AMP INCORPORATED

| 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 |
| REF | 21045-3 | RING, RETAINING 'C' (.187 DIA) FEED PIN | 147 | | | | 56 |
| | | | 146 | REF | 240624-1 | PIN, FEED FINGER | 55 |
| | | | 145 | REF | 691499-1 | SPRING, FEED FINGER | 54 |
| | | | 144 | REF | 240685-1 | 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 | 690501-3 | CAM, POST FEED 1- 1/8 STROKE | 48 |
| — | 22260-5 | WASH, FLAT (NO. 6) DRAG SPRING | 138 | | | | 47 |
| REF | 21899-4 | WASH, FLAT (NO. 5/16 DIA) SCR ADJ | 137 | | | | 46 |
| REF | 21024-5 | WASH, LOCK (NO. 10) FEED ADJ PLATE | 136 | 1 | 690191-1 | PLUG, NYLON | 45 |
| 2 | 21024-5 | WASH, LOCK (NO. 10) SHEAR PLATES | 135 | 1 | 455674-1 | RAM | 44 |
| REF | 21024-5 | WASH, LOCK (NO. 10) FEED ROD GUIDE | 134 | 1 | 690125-1 | WASHER, LAMINATED | 43 |
| 5 | 21024-4 | WASH, LOCK (NO. 8) STRIP GUIDE | 133 | 1 | 690124-1 | WASHER, RAM | 42 |
| 2 | 21024-4 | WASH, LOCK (NO. 8) SHEAR BLADE | 132 | | | SPACER, DISC | 41 |
| 2 | 21018-4 | NUT, HEX MACH (4-40) DRAG | 131 | 2 | 23241-6 | BALL, STEEL | 40 |
| REF | 21068-5 | NUT, HEX MACH (6-32) FEED ADJ PLATE | 130 | 2 | 690170-1 | SPRING, COMPRESSION | 39 |
| — | 21018-7 | NUT, HEX MACH (10-32) DRAG SPRING | 129 | 1 | 690142-1 | DISC, INSULATION | 38 |
| 2 | 21022-2 | NUT, HEX SELF-LKG (8-32) DRAG STUDS | 128 | 1 | 3-690692-3 | DISC, WIRE | 37 |
| — | 5- 21004-7 | SCR, SKT HD SHLD (.250 DIA x .25) DRAG ARM | 127 | 1 | 22480-5 | WASHER, SPRING | 36 |
| — | 21004-5 | SCR, SKT HD SHLD (.250 DIA x 1.00) DRAG | 126 | 1 | 690212-1 | POST, RAM | 35 |
| 2 | 4-21078-8 | SCR, SKT SET OVAL PT (4-40 x .75) DRAG | 125 | | | | 34 |
| 1 | 21009-2 | SCR, SKT SET (1/4-20 x 25) NYLOK RAM | 124 | | | | 33 |
| | | | 123 | 1 | 458980-1 | APPLICATOR, BASIC (SUB ASSY) | 32 |
| 1 | 2- 21003-0 | SCR, FLAT HD SOC CAP (6-32 x .50) 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 |
| 2 | 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 | 22354-8 | DRAG, STUD | 25 |
| 1 | 22733-8 | SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL | 115 | 1 | 455678-5 | PLATE, STRIP GUIDE | 24 |
| 4 | 3- 21002-3 | SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL | 114 | 1 | 240825-6 | PLATE, STRIP HOLD | 23 |
| REF | 1-24073-9 | SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE | 113 | 2 | 4-222811-1 | SPRING, DRAG | 22 |
| | | | 112 | — | 240636-1 | LEVER, DRAG | 21 |
| | | | 111 | 1 | 454177-1 | DRAG, STOCK | 20 |
| — | 2- 21000-4 | SCR, SKT HD CAP (6-32 x 1.00) DRAG ADAPTOR | 110 | 1 | 454204-1 | GUIDE, STRIP REAR | 19 |
| 2 | 23030-1 | SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC | 109 | 1 | 454204-1 | GUIDE, STRIP FRONT | 18 |
| 2 | 2-21000-6 | SCR, SKT HD CAP (8-32 x .38) SHEAR BLADE | 108 | REF | 454178-1 | GUIDE, FEED ROD | 17 |
| 3 | 7-21000-4 | SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE | 107 | REF | 4-22284-9 | SPRING, FEED RETURN | 16 |
| 2 | 2-21000-8 | SCR, SKT HD CAP (8-32 x .62) STRIP GUIDE | 106 | — | 454665-1 | ADAPTOR, DRAG | 15 |
| REF | 3- 21000-7 | SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE | 105 | | | | 14 |
| — | 3- 21000-9 | SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING | 104 | 1 | 690481-3 | SPACER, HOLD DOWN | 13 |
| REF | 3- 21000-6 | SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE | 103 | 1 | 233846-1 | SPRING, HOLD DOWN | 12 |
| REF | 3- 21000-4 | SCR, SKT HD CAP (10-32 x .38) PIVOT BLK | 102 | 1 | 240644-8 | PLATE, REAR SHEAR ■ | 11 |
| 2 | 3- 21000-8 | SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES | 101 | | | SPACER, SHEAR PLATE | 10 |
| REF | 455745-1 | GUARD WINDOW ③ | 80 | 1 | 1-690482-3 | PLATE, FRONT SHEAR ■ | 9 |
| — | 465184-9 | LUBRICATOR ASSY | 79 | 1 | 5-240625-7 | ANVIL ■ | 8 |
| — | 22014-1 | OIL SYNTHETIC | 78 | 1 | 690674-5 | BLADE, SLUG ■ | 7 |
| — | 454406-1 | SPACER, LUBRICATOR BRACKET | 77 | 1 | 455392-7 | HOLD DOWN | 6 |
| | | | 76 | 1 | 1-240641-9 | SPACER, SHEAR BLADE | 5 |
| | | | 75 | 1 | 238009-1 | SPACER, TUBULAR, INS CRIMPER | 4 |
| | | | 74 | 1 | 1-456134-8 | CRIMPER, INSULATION ■ | 3 |
| REF | 458109-1 | WASHER, FLAT (SPECIAL) | 73 | 1 | 455888-4 | SPACER, INSULATION | 2 |
| 2 | 690603-1 | SPRING, ASSIST | 72 | 1 | 2-456405-7 | CRIMPER, WIRE ■ | 1 |

## CRIMPING DATA

| PAD LETTER | CRIMP HEIGHT | WIRE SIZE | WIRE STRIP LENGTH |
|---|---|---|---|
| A | .060 | #18 | |
| B | .054 | #20 | |
| C | .052 | #22 | |
| D | NOT | USED | |

| | SIZE | TYPE | FEED | PRESS REF. |
|---|---|---|---|---|
| CRIMP | | | | |
| WIRE | .080 | F | .690 | 565435-5 |
| INSULATION | .120 | F | | |

| INSULATION RANGE | WIRE RANGE | APPLICATOR INSTRUCTION |
|---|---|---|
| .080-.100 | 22-18 | 408024 |

REMARKS: AMP-O-LECTRIC POST FEED

THIS APPLICATOR WILL APPLY

| |
|---|
| 41650 |
| 41651 |
| 41652 |

| LTR | REVISION RECORD | ECN | DR | CK | DATE |
|---|---|---|---|---|---|
| D1 | REACTIVATE 0150-6895-96 | | TB | | 5-24 |
| D | OBS 0150-6789-96 | | TB | | 9-26 |
| C | 0150-6776-96 | | TB | | 11-26 |
| B | ECN A166685 | — | WBF | | 11-6 |
| A | RELEASED PER ECN R-3817 | | TB | | 12-17-84 |

SET UP GAGE 458638-1 | LAYOUT NO. 96

DRAWN FORGARTY 7-20-73 | APPROVED 7-23-73

CHECKED 7-23-73 J.H. MILLER | REL 7-25-73 M. WOODRUFF

SCALE NONE

NAME: MINIATURE QUICK CHANGE APPLICATOR END-FEED (TAPER PIN)

AMP INCORPORATED HARRISBURG, PENNA.

LOC A C | NO. 687876-2 | REV. D1

NO. 687876-2