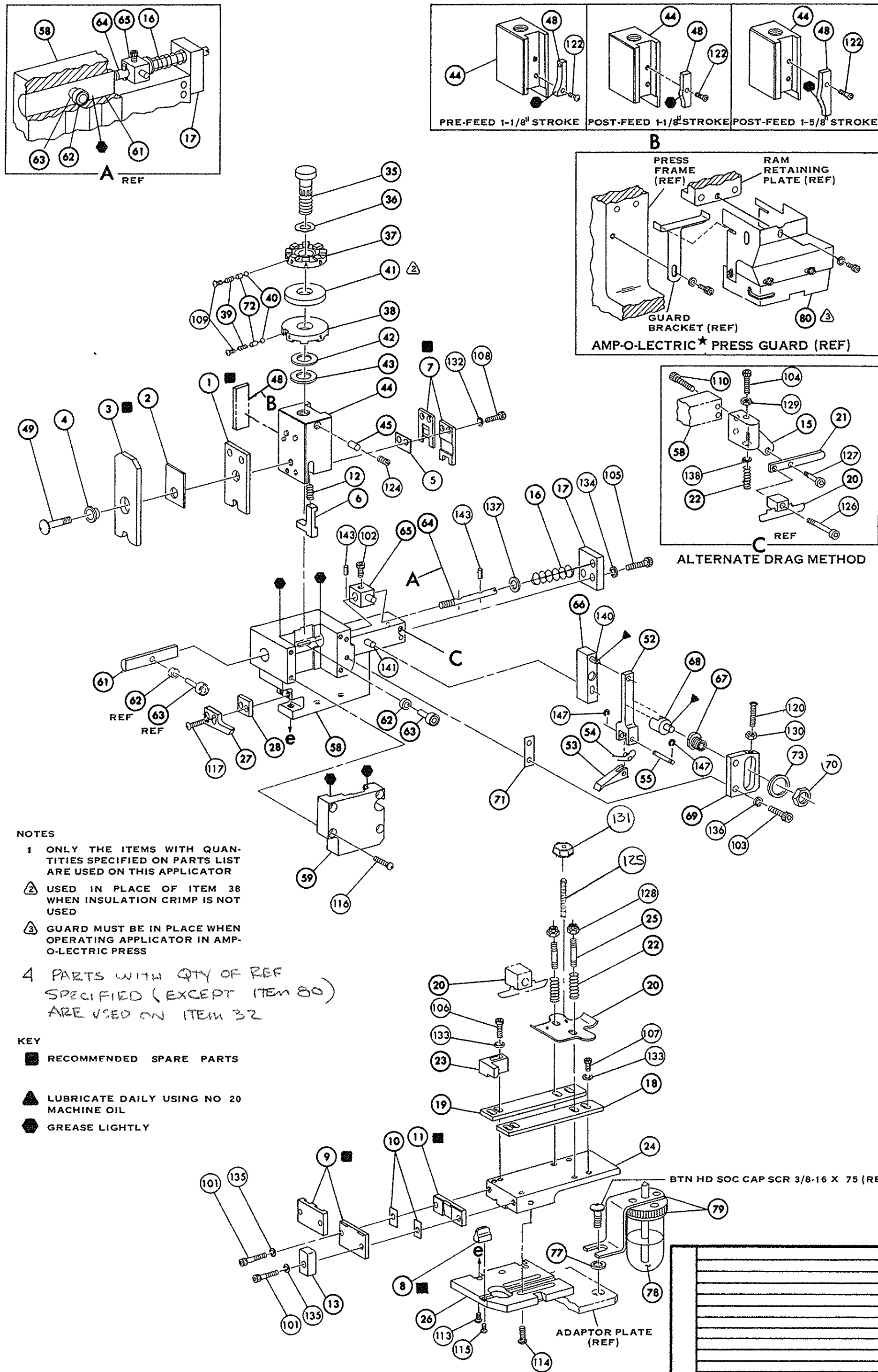


THIS IS A CONTROLLED DOCUMENT

NO. 687817-2



**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-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

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REF	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	REF 21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN		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 240634-1	LEVER, TERMINAL		52		
	142				51		
	141	REF 5- 21028-1	PIN, SLOT SPG (.12 DIA x .50) FEED ADJ ROD		50		
	140	REF 1- 21030-7	PIN, DOWEL (.187 DIA x 1.50) HOUSING		49		
	139	REF 1- 21030-1	PIN, DOWEL (.187 DIA x .50) LEVER		48		
	138	22260-5	WASH, FLAT (NO. 6) DRAG SPRING		47		
	137	REF 21899-4	WASH, FLAT (NO. 5/16 DIA) SCR ADJ		46		
	136	REF 21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE		45		
	135	2	21024-5	WASH, LOCK (NO. 10) SHEAR PLATES	44		
	134	REF 21024-5	WASH, LOCK (NO. 10) FEED ROD GUIDE		43		
	133	4	21024-4	WASH, LOCK (NO. 8) STRIP GUIDE	42		
	132	2	21024-4	WASH, LOCK (NO. 8) SHEAR BLADE	41		
	131	REF 21018-4	NUT, HEX MACH (4-40) DRAG		40		
	130	REF 21068-5	NUT, HEX MACH (6-32) FEED ADJ PLATE		39		
	129	2	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	38		
	128	REF 21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUDS		37		
	127	5- 21004-7	SCR, SKT HD SHLD (.250 DIA x .25) DRAG ARM		36		
	126	21004-5	SCR, SKT HD SHLD (.250 DIA x 1.00) DRAG		35		
	125	REF 4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG		34		
	124	1	21009-2	SCR, SKT SET (1/4-20 X 25) NYLOK RAM	33		
	123	1	REF 7- 21002-7	SCR, BUTTWN HD SOC CAP (6-32 x .50) CAM	32		
	122				31		
	121				30		
	120	REF 3- 21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ		29		
	119	1	REF 3-690451-2	SPACER, STRIPPER	28		
	118	2	21002-2	SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER	27		
	117	REF 2- 21002-9	SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP		26		
	116	2	22733-8	SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL	25		
	115	1	REF 4- 21002-3	SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL	24		
	114	4	REF 1-24073-9	SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE	23		
	113	2	4-22281-1	SPRING, DRAG	22		
	112	2	240636-1	LEVER, DRAG	21		
	111	1	454177-1	DRAG, STOCK	20		
	110	1	REF 2- 21000-4	SCR, SKT HD CAP (6-32 x 1.00) DRAG ADAPTOR	19		
	109	1	23030-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC	18		
	108	2	2-21000-5	SCR, SKT HD CAP (8-32 x .25) SHEAR BLADE	17		
	107	REF 3- 21000-7	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE		16		
	106	1	7-21000-4	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE	15		
	105	REF 3- 21000-7	SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE		14		
	104	3- 21000-9	SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING		13		
	103	REF 3- 21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE		12		
	102	REF 3- 21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK		11		
	101	2	3- 21000-8	SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES	10		
	80	REF 455745-1	GUARD, WINDOW		9		
	79	465184-9	LUBRICATOR ASSY		8		
	78	22014-1	OIL SYNTHETIC		7		
	77	454406-1	SPACER, LUBRICATOR BRACKET		6		
	76				5		
	75				4		
	74				3		
	73	REF 458109-1	WASHER, FLAT (SPECIAL)		2		
	72	690603-1	SPRING, ASSIST		1		

**CRIMPING DATA**

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	THIS APPLICATOR WILL APPLY
A	077	14		41006
B	068	16		41499
C	063	18		
D	NOT USED			
CRIMP	SIZE	TYPE	FEED	PRESS REF.
WIRE	.120	F	.375	565435-5
INSULATION	+	---		
INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION		
	18-14	A18039		

REMARKS: AMP-O-LECTRIC PRE FEED

I.D. PLATE (REF): 461264-1

SET UP GAGE: 458638-1 LAYOUT NO: 369

APPROVED: [Signature] DATE: 6-5-78

CHECKED: [Signature] DATE: 6-5-78

SCALE: NONE

**MINIATURE QUICK CHANGE APPLICATOR**  
END-FEED (RING)

AMP INCORPORATED HARRISBURG, PENNA. LOC A NO. 687817-2 REV. E

REV	DATE	DESCRIPTION	BY	CHK