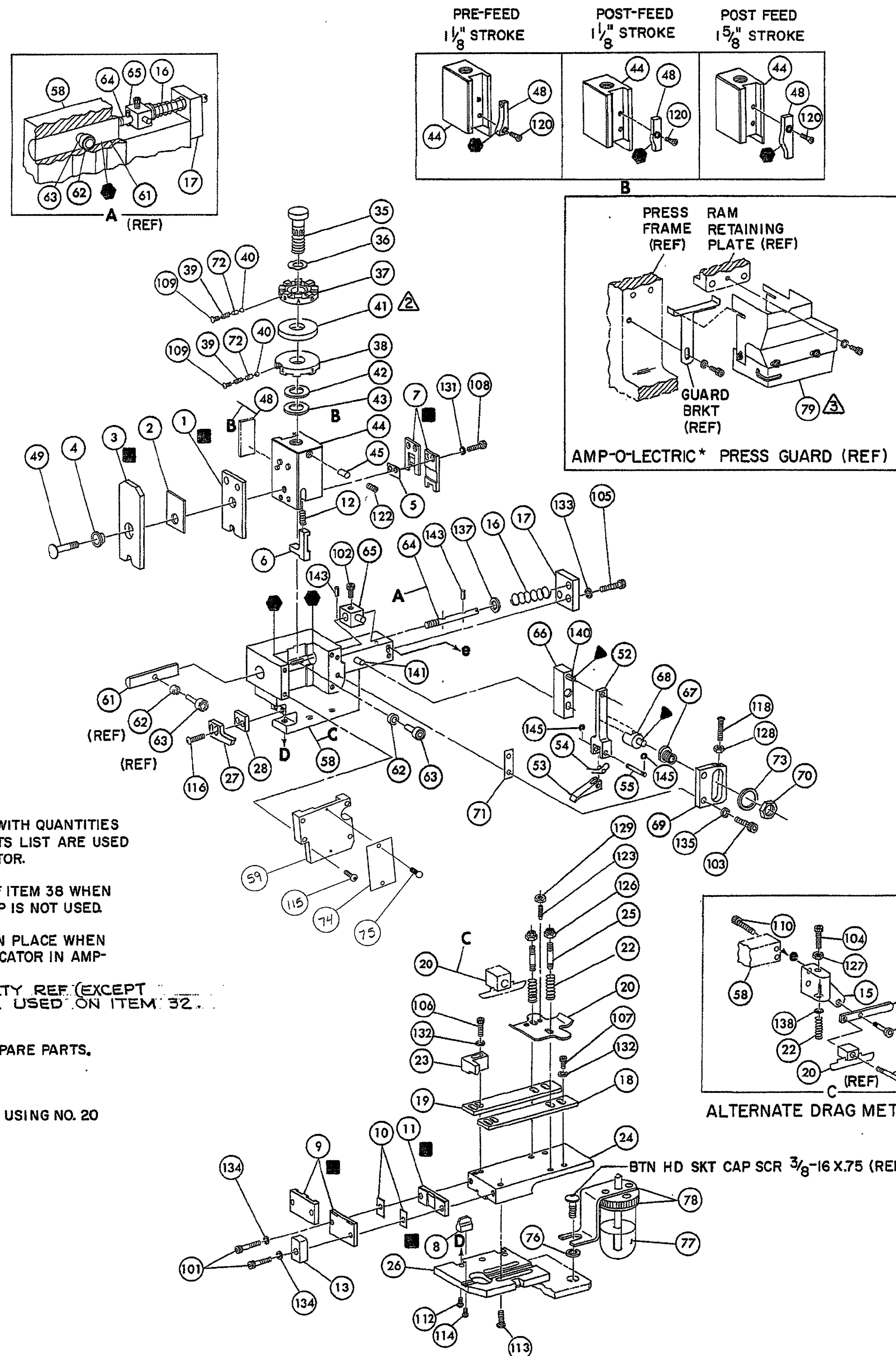


THIS DRAWING IS A CONTROLLED DOCUMENT.



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 REF (EXCEPT ITEM 79) ARE USED ON ITEM 32.

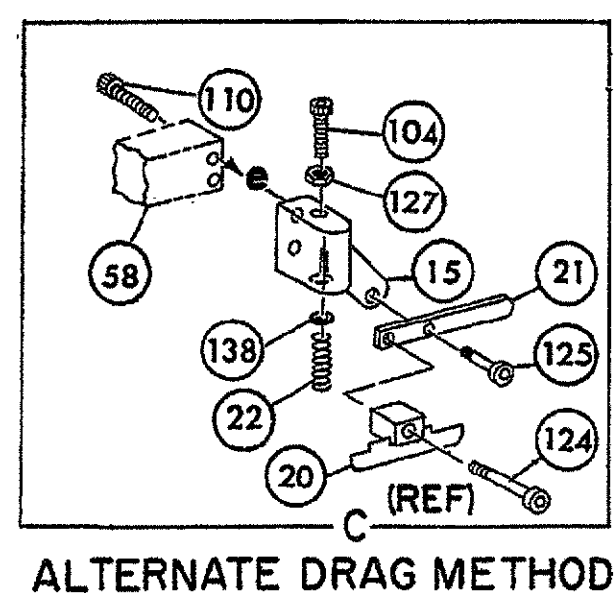
KEY:

■ RECOMMENDED SPARE PARTS.

▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.

● GREASE LIGHTLY.

REF	QTY	PART NO	DESCRIPTION	ITEM NO	
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	145	REF 454220-1 CAP, RAM	59
REF	5-21028-1	PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD	143	REF 453736-1 HOUSING	58
REF	1-21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	141	REF 240624-1 PIN, FEED FINGER	55
REF	1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	140	REF 691499-1 SPRING, FEED FINGER	54
REF	22260-5	WASHER, FLAT (NO 6) DRAG SPRING	138	REF 240635-1 FINGER, FEED	53
REF	21899-4	WASHER, FLAT (5/16 DIA) SCR ADJ	137	REF 240634-3 LEVER, TERMINAL	52
REF	21024-5	WASHER, LOCK (NO 10) FEED ADJ PLATE	135	1 7-21002-9 BOLT, CRIMPER	49
REF	21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	134	1 690501-4 CAM, POST FEED 1 5/8 STROKE	48
REF	21024-4	WASHER, LOCK (NO 8) STRIP GUIDE	132		46
REF	21024-4	WASHER, LOCK (NO 8) SHEAR BLADE	131	1 690191-1 PLUG, NYLON	45
REF	21018-4	NUT, HEX MACH (4-40) DRAG	129	1 455674-2 RAM	44
REF	21068-5	NUT, HEX MACH (6-32) FD ADJ PLATE	128	1 690125-1 WASHER, LAMINATED	43
REF	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	127	1 690124-1 WASHER, RAM	42
REF	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	126	2 23241-6 BALL, STEEL	40
REF	5-21004-7	SCR, SKT HD SHLD (250 DIA X .25) DRAG ARM	125	2 690170-1 SPRING, COMPRESSION	39
REF	21004-5	SCR, SKT HD SHLD (250 DIA X 1.00) DRAG	124	1 690142-1 DISC, INSULATION	38
REF	4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	123	1 690692-7 DISC, WIRE	37
REF	21009-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	122	1 22480-5 WASHER, SPRING	36
REF	1-21002-7	SCR, BTN HD SKT CAP (6-32 X .38) CAM	121	1 690212-1 POST, RAM	35
REF	3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	118	1 458980-2 APPLICATOR, BASIC (SUB ASSY)	32
REF	2-21002-2	SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	116		30
REF	2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	115		29
REF	22733-8	SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	114		28
REF	3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	113	1 690455-3 STRIPPER	27
REF	2-22733-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	112	REF 455676-1 PLATE, BASE	26
REF	2-21000-4	SCR, SKT HD CAP (6-32 X 1.00) DRAG ADAPTOR	111	2 22354-8 DRAG, STUD	25
REF	3-23657-8	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	109	1 455678-8 PLATE, STRIP GUIDE	24
REF	2-21000-6	SCR, SKT HD CAP (8-32 X .38) SHEAR BLADE	108	2 4-22281-1 SPRING, DRAG	22
REF	7-21000-4	SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	107	240636-1 LEVER, DRAG	21
REF	7-21000-4	SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	106	1 454177-1 DRAG, STOCK	20
REF	3-21000-7	SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE	105	1 458030-3 GUIDE, STRIP (REAR)	19
REF	3-21000-9	SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING	104	1 458031-3 GUIDE, STRIP (FRONT)	18
REF	3-21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	103	REF 454178-1 GUIDE, FEED ROD	17
REF	3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	102	REF 4-22284-9 SPRING, FEED RETURN	16
REF	3-21000-8	SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE	101		15
REF	455745-1	GUARD, WINDOW	79		14
REF	465184-9	LUBRICATOR ASSY	78		13
REF	455985-1	OIL, LUBRICATING	77		12
REF	454406-1	SPACER, LUB BRACKET	76	1 691901-5 PLATE, REAR SHEAR	11
REF	21017-2	SCR, DRIVE (#2 X .19) ID PLATE	75	2 1-240645-3 SPACER, SHEAR PLATE	10
REF	461264-1	PLATE, ID	74	1 690783-1 PLATE, FRONT RETAINER	9
REF	458109-1	WASHER, FLAT (SPECIAL)	73	1 461295-6 ANVIL	8
REF	690603-1	SPRING, ASSIST	72	1 1-691157-4 BLADE, SLUG	7
REF	690517-1	SPACER	71		6
REF	22594-8	NUT, HEX	70	1 240641-2 SPACER, SHEAR BLADE	5
REF	240628-1	PLATE, ADJ	69	1 238009-1 SPACER, TUBULAR	4
REF	240626-1	SHAFT, PIVOT	68	1 4-456134-6 CRIMPER, INSULATION	3
REF	240633-1	BUSHING	67	1 1-455888-3 SPACER, INSULATION	2
REF	455680-1	LEVER, INTERMEDIATE	66	1 456407-1 CRIMPER, WIRE	1
REF	240629-1	BLOCK, PIVOT	65		
REF	240632-2	SCREW, ADJ	64		
REF	240659-3	PIN, CAM ROLLER	63		
REF	240658-1	CAM, ROLLER	62		
REF	454398-1	ROD, FEED	61		



ALTERNATE DRAG METHOD

CRIMPING DATA				APPLICATOR WILL APPLY	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE LENGTH	485003	
A	.062	18			
B	.058	20			
C	.056	22			
D	NOT USED				
CRIMP	SIZE	TYPE	FEED	APPL INST	
WIRE	.100	"E"	.657	A1 8039	
INSUL	.180	"E"			
WIRE RANGE	INSULATION RANGE	PRESS NO	REMARKS		
22-18	.090-.150		AMPOMATOR POST FEED		

REMARKS	NO	REV
	TO APPLY TERMINAL	
	SPEC 114-2084	
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

D	ECN 0150-0910-04	M/REV	7-04	SET UP PAGE 10-1
C3	ECN 0150-0631-03	M/REV	6-03	458638-1841
C2	ECN 0150-9606-99	M/REV	4-99	DR THE APPL
C1	0150-8510-78	M/REV	5/98	18-000-11111111
C	0150-6779-76	M/REV	4-76	CHRY, 247, RELT 2175
B	REV PER ECU 2-5603	M/REV	10-04	11/11/04
A	REV PER ECU R2310	M/REV	1-79	



AMP INCORPORATED
Harrisburg, Pa.

LOC A D NO 466446-1 REV D

MINIATURE QUICK CHANGE APPLICATOR

END FEED RING

CUSTOMER AND ASSEMBLY DRAWING!