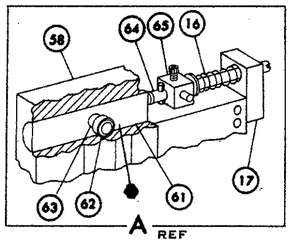
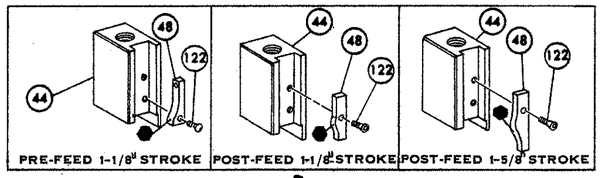
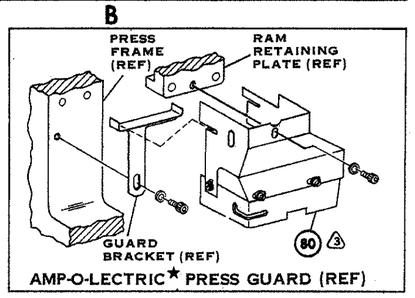
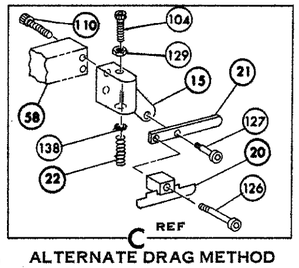
THIS IS A CONTROLLED DOCUMENT.



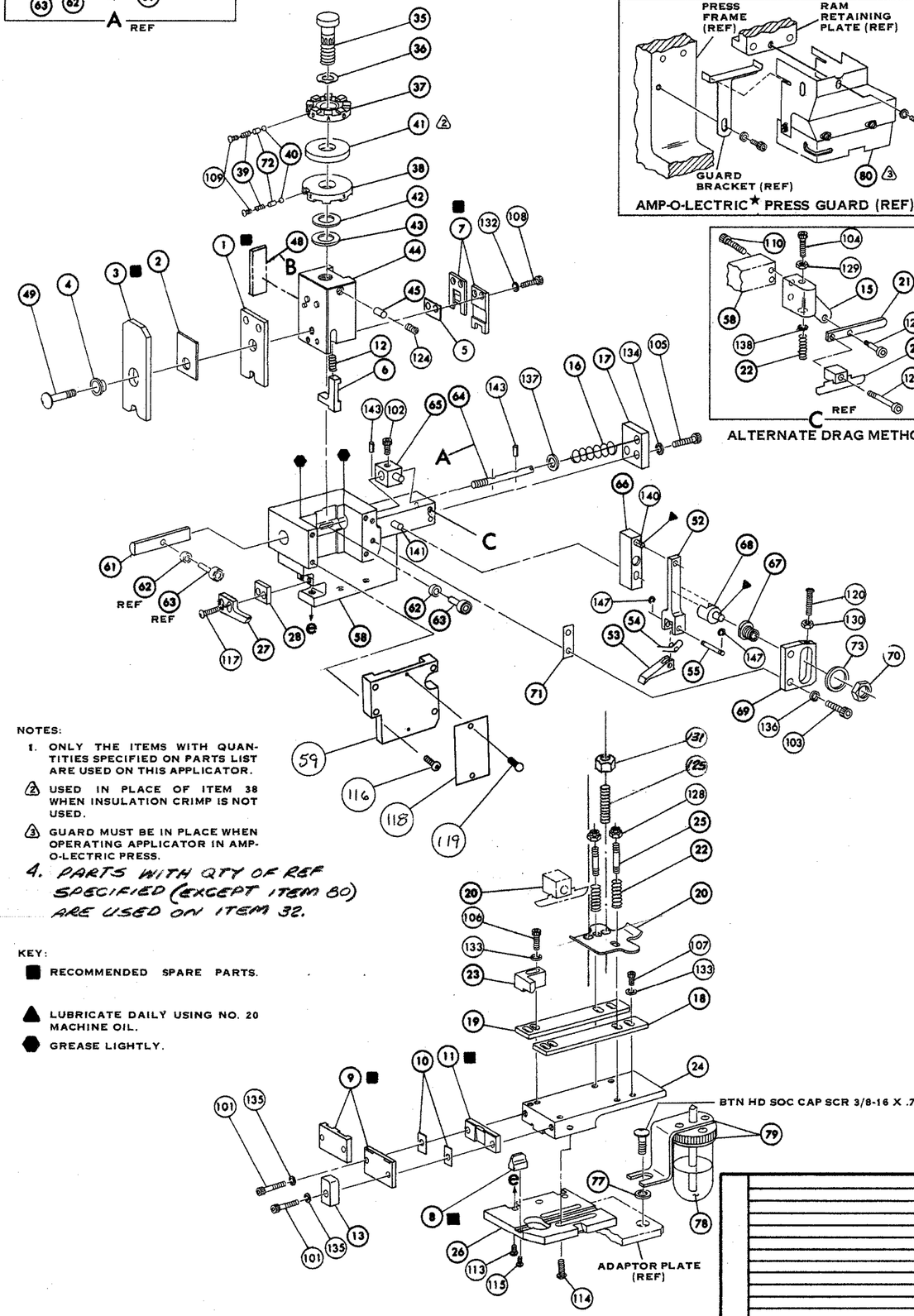


B





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.

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	240635-1	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	1	690223-1	SPACER, DISC	41
2	21018-4	NUT, HEX MACH (4-40) DRAG	131	1	23241-6	BALL, STEEL	40
REF	21068-5	NUT, HEX MACH (6-32) FEED ADJ PLATE	130	1	690170-1	SPRING, COMPRESSION	39
—	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	129			DISC, INSULATION	38
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUDS	128	1	8-690141-1	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	1- 21002-7	SCR, BTN HD SOC CAP (6-32 x .38) CAM	122				31
			121				30
REF	3- 21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ	120				29
2	21017-2	DRIVE SCREW (#2 x .19)	119	1	3-690451-2	SPACER, STRIPPER	28
1	461264-1	PLATE, IDENTIFICATION	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	455678-1	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	1-24078-9	SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE	113	2	4-22281-1	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	454204-3	GUIDE, STRIP REAR	19
1	23030-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC	109	1	454204-3	GUIDE, STRIP FRONT	18
2	2-21000-7	SCR, SKT HD CAP (8-32 x .50) SHEAR BLADE	108	REF	454178-1	GUIDE, FEED ROD	17
3	2-21000-6	SCR, SKT HD CAP (8-32 x .38) STRIP GUIDE	107	REF	4-22284-9	SPRING, FEED RETURN	16
2	2-21000-9	SCR, SKT HD CAP (8-32 x .75) 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	690481-5	SPACER, HOLD DOWN	13
REF	3- 21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE	103	1	23846-1	SPRING, HOLD DOWN	12
REF	3- 21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK	102	1	240644-1	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	1-690482-2	PLATE, FRONT SHEAR ■	9
—	465184-9	LUBRICATOR ASSY	79	1	240654-8	ANVIL ■	8
—	22014-1	OIL SYNTHETIC	78	1	690474-5	BLADE, SLUG ■	7
—	454406-1	SPACER, LUBRICATOR BRACKET	77	1	455892-6	HOLD DOWN	6
			76	1	4-240641-1	SPACER, SHEAR BLADE	5
			75			SPACER, TUBULAR, INS CRIMPER	4
			74			CRIMPER, INSULATION ■	3
REF	458109-1	WASHER, FLAT (SPECIAL)	73			SPACER, INSULATION	2
1	690603-1	SPRING, ASSIST	72	1	456408-6	CRIMPER, WIRE ■	1

TERM APPL SPEC 114-2036

CRIMPING DATA

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.070	#14	.237-.267
B	.060	#16	.237-.267
C	.054	#18	.237-.267
D	NOT	USED	

CRIMP	SIZE	TYPE	FEED	PRESS REF.
WIRE	.110	F	.665	565435-5
INSULATION	—	—		

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION AI
—	18-14	8039

THIS APPLICATOR WILL APPLY: 42845, 60021

REMARKS: AMP-O-LECTRIC POST FEED

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

LTR	REVISION RECORD	ECN	DR	CK	DATE
E	ECN 0150-1378-04		MM	TF	11-04
D	ECN 0154-0342-03		MM	TF	4-03
C	ECN A1G0688				11-88
B	REV PER ECN R-5525				2/84
A	REV ITEM 37	R2382			2-78

SET UP GAGE 458638-1 | LAYOUT NO. 51 | DRAWN Frantz 10/9/73 | CHECKED | APPROVED Ben Hawk 10-11-73 | REL. 10.11.73

AMP INCORPORATED HARRISBURG, PENNA.

LOC A C | NO. 687942-2 | REV. E

SCALE NONE | NAME MINIATURE QUICK CHANGE APPLICATOR END-FEED (.250 FASTIN FASTON)

CUSTOMER AND ASSEMBLY DRAWING

687942-2

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3076-1