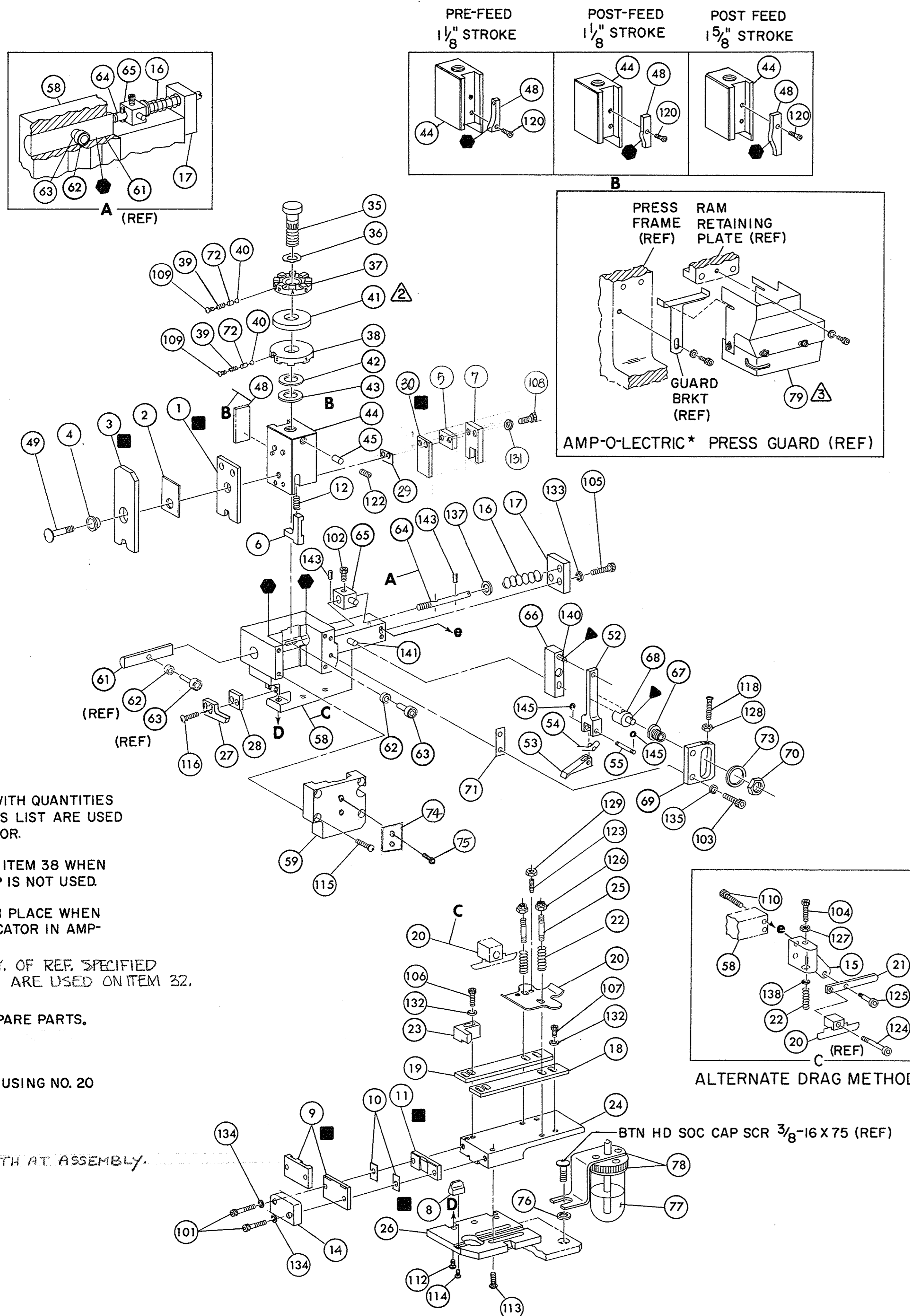


THIS DRAWING IS A CONTROLLED DOCUMENT.



- 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. ITEMS WITH QTY. OF REF. SPECIFIED (EXCEPT ITEM 78) ARE USED ON ITEM 32.
- KEY:**
- RECOMMENDED SPARE PARTS.
  - ▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.
  - GREASE LIGHTLY.
  - △ CUT TO LENGTH AT ASSEMBLY.

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
#	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	50
2	21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	134	1	690602-5	CAM, PRE FEED	48
REF.	21024-5	WASHER, LOCK (NO 10) FEED ROD GUIDE	133				47
4	21024-4	WASHER, LOCK (NO 8) STRIP GUIDE	132				46
2	21024-4	WASHER, LOCK (NO 8) SHEAR BLADE	131	1	690191-1	PLUG, NYLON	45
2	21018-4	NUT, HEX MACH (4-40) DRAG	130	1	455674-2	RAM	44
REF.	21068-5	NUT, HEX MACH (6-32) FD ADJ PLATE	128	1	690125-1	WASHER, LAMINATED	43
#	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	127	#	690124-1	WASHER, RAM	42
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	126	2	23241-6	SPACER, DISC	41
#	5-21004-7	SCR, SKT HD SHLD (250 DIA X .25) DRAG ARM	125	2	690170-1	BALL, STEEL	40
#	21004-5	SCR, SKT HD SHLD (250 DIA X 1.00) DRAG	124	1	690142-1	SPRING, COMPRESSION	39
2	4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	123	1	690141-8	DISC, INSULATION	38
1	21009-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	122	1	22480-5	DISC, WIRE	37
1	2-21003-0	SCR, FLAT HD SKT CAP (6-32 X .50) CAM	120	1	690212-1	WASHER, SPRING	36
REF.	3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	118	1	458980-2	POST, RAM	35
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	116	1	690759-3	APPLICATOR, BASIC (SUB ASSY)	32
REF.	2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	115	1	1-240641-3	TOOL FLANGING	30
4	3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	113	1	3-690451-2	SPACER, FLANGING TOOL	29
REF.	1-24073-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	112	REF.	455676-1	SPACER, STRIPPER	28
#	2-21000-4	SCR, SKT HD CAP (6-32 X 1.00) DRAG ADAPTOR	110	2	22354-8	STRIPPER	27
2	23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	109	1	455678-8	PLATE, BASE	26
3	2-21000-8	SCR, SKT HD CAP (8-32 X .62) SHEAR BLADE	108	2	4-22281-1	DRAG, STUD	25
1	2-21000-6	SCR, SKT HD CAP (8-32 X .38) STRIP GUIDE	107	#	240636-1	PLATE, STRIP GUIDE	24
REF.	3-21000-7	SCR, SKT HD CAP (8-32 X .50) STRIP GUIDE	106	1	454177-1	PLATE, STRIP HOLD	23
#	3-21000-9	SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE	105	1	458030-5	SPRING, DRAG	22
REF.	3-21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	104	1	458031-5	LEVER, DRAG	21
REF.	3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	103	REF.	454178-1	DRAG, STOCK	20
2	3-21000-8	SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE	101	REF.	4-22284-9	GUIDE, STRIP (REAR)	19
REF.	455745-1	GUARD, WINDOW	79	#	690783-1	GUIDE, STRIP (FRONT)	18
#	465184-9	LUBRICATOR ASSY	78	#	454178-1	GUIDE, FEED ROD	17
#	455985-1	OIL, LUBRICATING	77	#	4-22284-9	SPRING, FEED RETURN	16
#	454406-1	SPACER, LUB BRACKET	76	1	240644-7	ADAPTER, DRAG	15
2	21017-2	SCR, DRIVE (2 X .19) I.D. PLATE	75	2	1-240645-0	SPACER, PLATE RETAINING	14
1	461264-1	PLATE, IDENTIFICATION	74	1	690784-2	SPACER, HOLD DOWN	13
REF.	458109-1	WASHER, FLAT (SPECIAL)	73	1	5-238005-3	SPRING, HOLD DOWN	12
2	690603-1	SPRING, ASSIST	72	1	2-240651-3	PLATE, REAR SHEAR	11
REF.	690517-1	SPACER	71	#	4-240641-8	SPACER, SHEAR PLATE	10
	22594-8	NUT, HEX	70	1	238009-3	PLATE, FRONT SHEAR	9
	240628-1	PLATE, ADJ	69	1	2-456135-6	ANVIL	8
	240626-1	SHAFT, PIVOT	68	1	455888-3	BLADE, SLUG	7
	240633-1	BUSHING	67	1	456408-5	HOLD DOWN, TERMINAL	6
	455680-1	LEVER, INTERMEDIATE	66	1	4-240641-8	SPACER, SHEAR BLADE	5
	240629-1	BLOCK, PIVOT	65	1	238009-3	SPACER, TUBULAR	4
	240632-2	SCREW, ADJ	64	1	2-456135-6	CRIMPER, INSULATION	3
	240659-3	PIN, CAM ROLLER	63	1	455888-3	SPACER, INSULATION	2
	240658-1	CAM, ROLLER	62		456408-5	CRIMPER, WIRE	1
REF.	454398-1	ROD, FEED	61				

**CRIMPING DATA**

PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE LENGTH
A	.069	# 16	
B	.063	# 18	
C	.059	# 20	
D	NOT USED		

**APPLICATOR WILL APPLY**

CRIMP	SIZE	TYPE	FEED	APPL INST
WIRE	.110	"F"	.860	A1 8039
INSUL	.135	"O"		

WIRE RANGE 20-16 INSULATION RANGE 100-140 PRESS NO 265435-5

REMARKS: AMP-O-LECTRIC PRE-FEED

REMARKS	NO	REV
APPL USED ON MACHINE PART NO	MACH SERIAL NO	
CUSTOMER NAME	APPL SERIAL NO	
ADDRESS	PURCHASE ORDER	
CITY	ENG APP	

NO TO APPLY TERMINAL SPEC 114-2084

DISTRIBUTION ORIGINAL CUSTOMER COPY FIELD ENG COPY

ECN 0150-1249-03  
 DR 0150-7420-96  
 ECN A157688  
 Rev Per Len P-S173  
 Rev Per Len 28813  
 Rev Per Len R2692

SETUPPAGE 10-1  
 458638-1  
 7104  
 11-03  
 11-88  
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 11-88

AMP INCORPORATED Harrisburg, Pa.

MINIATURE QUICK CHANGE APPLICATOR END FEED ( FLANGED SPADE)