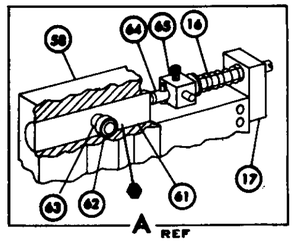

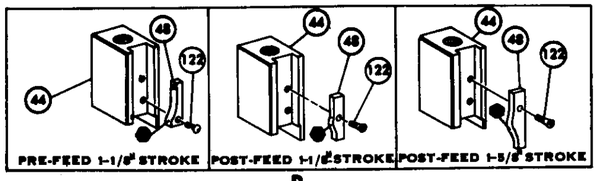

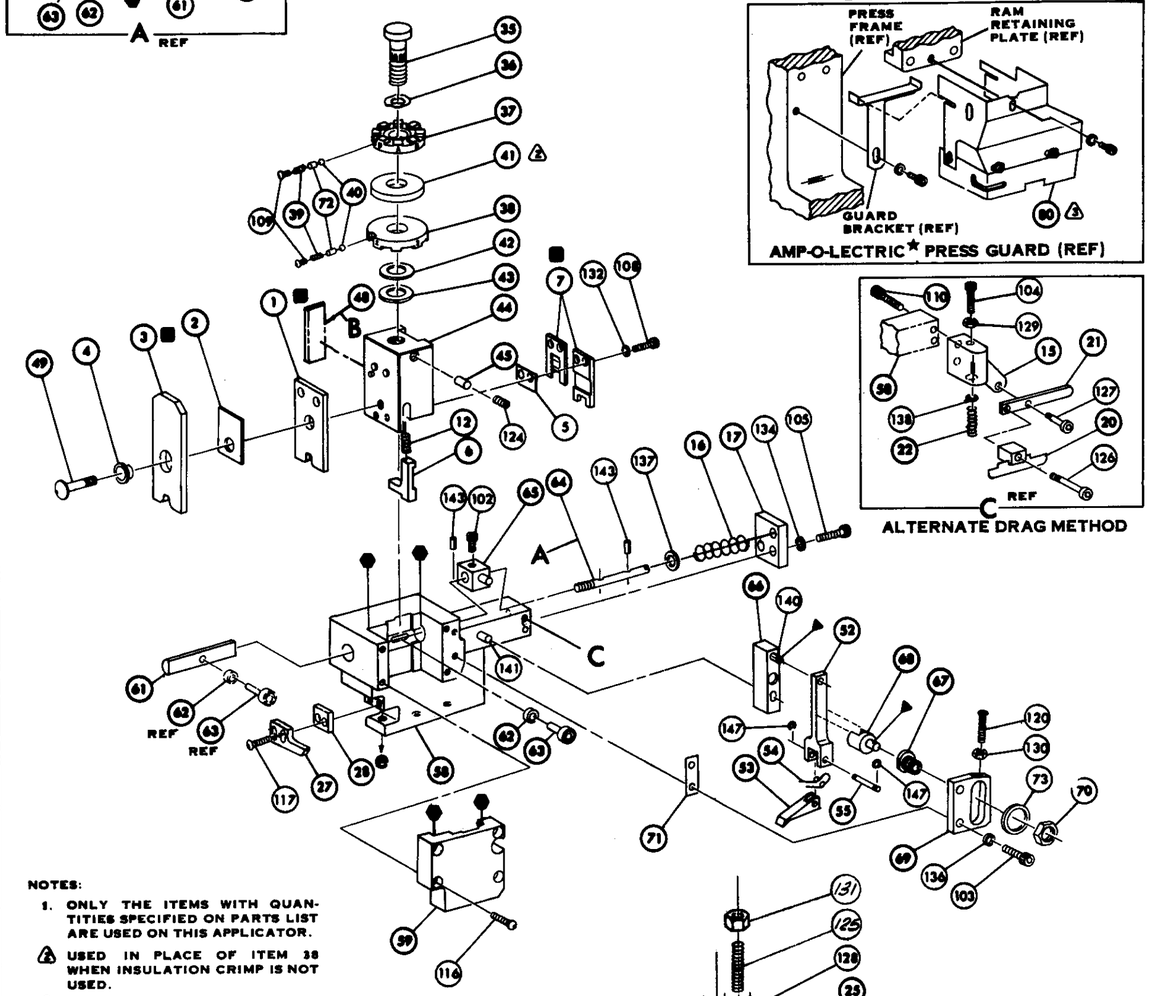

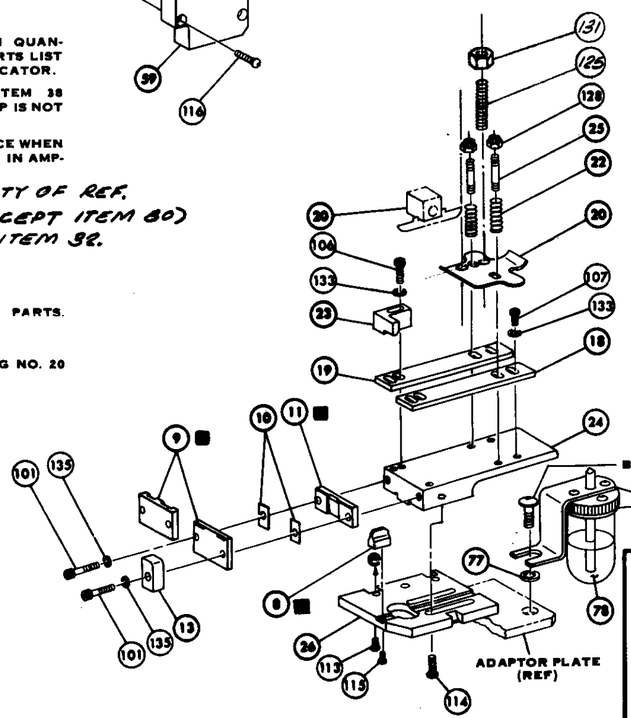

NOTES:

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 38.

KEY:

■ RECOMMENDED SPARE PARTS.

▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.

⬢ GREASE LIGHTLY.

REQ.	PART NO.	DESCRIPTION	NO.
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	147
REF	1- 21030-7	PIN, DOWEL (.187 DIA x 1.50) HOUSING	146
REF	1- 21030-1	PIN, DOWEL (.187 DIA x .50) LEVER	145
			144
REF	5- 21028-1	PIN, SLOT SPG (.12 DIA x .50) FEED ADJ ROD	143
			142
REF	1- 21030-7	PIN, DOWEL (.187 DIA x 1.50) HOUSING	141
REF	1- 21030-1	PIN, DOWEL (.187 DIA x .50) LEVER	140
			139
—	22260-5	WASH, FLAT (NO. 6) DRAG SPRING	138
REF	21899-4	WASH, FLAT (NO. 5/16 DIA) SCR ADJ	137
REF	21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE	136
2	21024-5	WASH, LOCK (NO. 10) SHEAR PLATES	135
REF	21024-5	WASH, LOCK (NO. 10) FEED ROD GUIDE	134
5	21024-4	WASH, LOCK (NO. 8) STRIP GUIDE	133
2	21024-4	WASH, LOCK (NO. 8) SHEAR BLADE	132
2	21018-4	NUT, HEX MACH (8-40) DRAG	131
REF	21068-5	NUT, HEX MACH (6-32) FEED ADJ PLATE	130
—	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	129
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUDS	128
—	5- 21004-7	SCR, SKT HD SHLD (.250 DIA x .25) DRAG ARM	127
—	21004-5	SCR, SKT HD SHLD (.250 DIA x 1.00) DRAG	126
2	4-21018-8	SCR, SKT SET OVAL PT. (4-40 x .75) DRAG	125
1	21009-2	SCR, SKT SET (1/4-20 x 25) NYLOK RAM	124
			123
1	2- 21003-0	SCR, FLAT HD SOC CAP (6-32 x .50) CAM	122
			121
REF	3- 21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ	120
			119
			118
3	2-21002-2	SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER	117
REF	2- 21002-9	SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP	116
1	22733-8	SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL	115
4	3- 21002-3	SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL	114
REF	1-84073-9	SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE	113
			112
			111
—	2- 21000-4	SCR, SKT HD CAP (6-32 x 1.00) DRAG ADAPTOR	110
2	2-31030-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC	109
2	2-21000-4	SCR, SKT HD CAP (8-32 x .31) SHEAR BLADE	108
3	2-21000-9	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE	107
2	2-21000-8	SCR, SKT HD CAP (8-32 x .62) STRIP GUIDE	106
REF	3- 21000-7	SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE	105
—	3- 21000-9	SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING	104
REF	3- 21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE	103
REF	3- 21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK	102
2	3- 21000-8	SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES	101
REF	455745-1	GUIDE, WINDOW ⚠3	80
—	465184-9	LUBRICATOR ASSY	79
—	22014-1	OIL SYNTHETIC	78
—	454406-1	SPACER, LUBRICATOR BRACKET	77
			76
			75
			74
REF	458109-1	WASHER, FLAT (SPECIAL)	73
2	690603-1	SPRING, ASSIST	72

REQ.	PART NO.	DESCRIPTION	NO.
REF	690517-1	SPACER	71
	22594-8	HEX. NUT	70
	240628-1	PLATE, ADJ	69
	240626-1	SHAFT, PIVOT	68
	240633-1	BUSHING	67
1	455680-1	LEVER, INTERMEDIATE	66
1	240629-1	BLOCK, PIVOT	65
1	240632-2	SCREW, ADJ	64
1	240659-3	PIN, CAM ROLLER	63
1	240658-1	CAM, ROLLER	62
REF	454398-1	ROD, FEED	61
			60
REF	454220-1	CAP, RAM	59
REF	453736-1	HOUSING	58
			57
			56
REF	240624-1	PIN, FEED FINGER	55
REF	691499-1	SPRING, FEED FINGER	54
REF	240635-1	FINGER, FEED	53
REF	240634-1	LEVER, TERMINAL	52
			51
			50
1	7-21002-9	BOLT, CRIMPER	49
1	690602-5	CAM, PRE FEED 1- 1/8 STROKE	48
			47
			46
1	690191-1	PLUG, NYLON	45
1	455679-1	RAM	44
1	690125-1	WASHER, LAMINATED	43
1	690124-1	WASHER, RAM	42
		SPACER, DISC	41
2	23241-6	BALL, STEEL	40
2	690170-1	SPRING, COMPRESSION	39
1	690142-1	DISC, INSULATION	38
1	5-690692-6	DISC, WIRE	37
1	22480-5	WASHER, SPRING	36
1	690212-1	POST, RAM	35
			34
1	458990-1	APPLICATOR, BASIC (SUB ASSY)	33
			32
			31
			30
1	3-690451-2	SPACER, STRIPPER	29
1	240689-1	STRIPPER	28
REF	455676-1	PLATE, BASE	27
2	22354-8	DRAG, STUD	26
1	455678-1	PLATE, STRIP GUIDE	25
1	240825-9	PLATE, STRIP HOLD	24
2	4-22281-1	SPRING, DRAG	23
—	240636-1	LEVER, DRAG	22
1	454177-1	DRAG, STOCK	21
1	454204-6	GUIDE, STRIP REAR	20
1	454204-6	GUIDE, STRIP FRONT	19
REF	454178-1	GUIDE, FEED ROD	18
REF	4-22284-9	SPRING, FEED RETURN	17
—	454665-1	ADAPTOR, DRAG	16
			15
			14
1	690481-3	SPACER, HOLD DOWN	13
1	23896-1	SPRING, HOLD DOWN	12
1	240644-1	PLATE, REAR SHEAR	11
		SPACER, SHEAR PLATE	10
1	690496-1	PLATE, FRONT SHEAR	9
1	2-340693-9	ANVIL	8
1	690494-6	BLADE, SLUG	7
1	1-455892-9	HOLD DOWN	6
		SPACER, SHEAR BLADE	5
1	238009-1	SPACER, TUBULAR, INS CRIMPER	4
1	1-456135-4	CRIMPER, INSULATION	3
1	455888-3	SPACER, INSULATION	2
1	456404-5	CRIMPER, WIRE	1

CRIMPING DATA

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.036	#20	
B	.033	#22	
C	NOT	USED	
D	NOT	USED	

	SIZE	TYPE	FEED	PRESS REF.
CRIMP WIRE	.070	F	.542	5654355
INSULATION	.090	O		

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION
.075 MAX.	22-20	A 8039

REMARKS

AMP-O-LECTRIC
PRE FEED

THIS APPLICATOR WILL APPLY

42863
42864
42869
42587
42588
42615
42616
60518
151308

LTR	REVISION RECORD	ECN	DR	CK	DATE
D1	ECN A-31679				6-91
C2	ECN A160488				11-88
B3	ECN A-31679 REV 2-EXPL				2-84
A4	REV ITEM 31 PER R2105				3-79
A5	REV. PER ECN R-1697				11-77

SET UP SHEET 455638-1 | LAYOUT NO. 80 | DRAWN 11/18/73 | APPROVED 11-16-73 | CHECKED 11-17-73 | REL. 11-16-73

AMP INCORPORATED HARRISBURG, PENNA.

LOC A C | NO. 687955-3 | REV. D1

SCALE NONE | NAME MINIATURE QUICK CHANGE APPLICATOR END-FEED (EDGE CONNECTOR)

NO. 687955-3

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