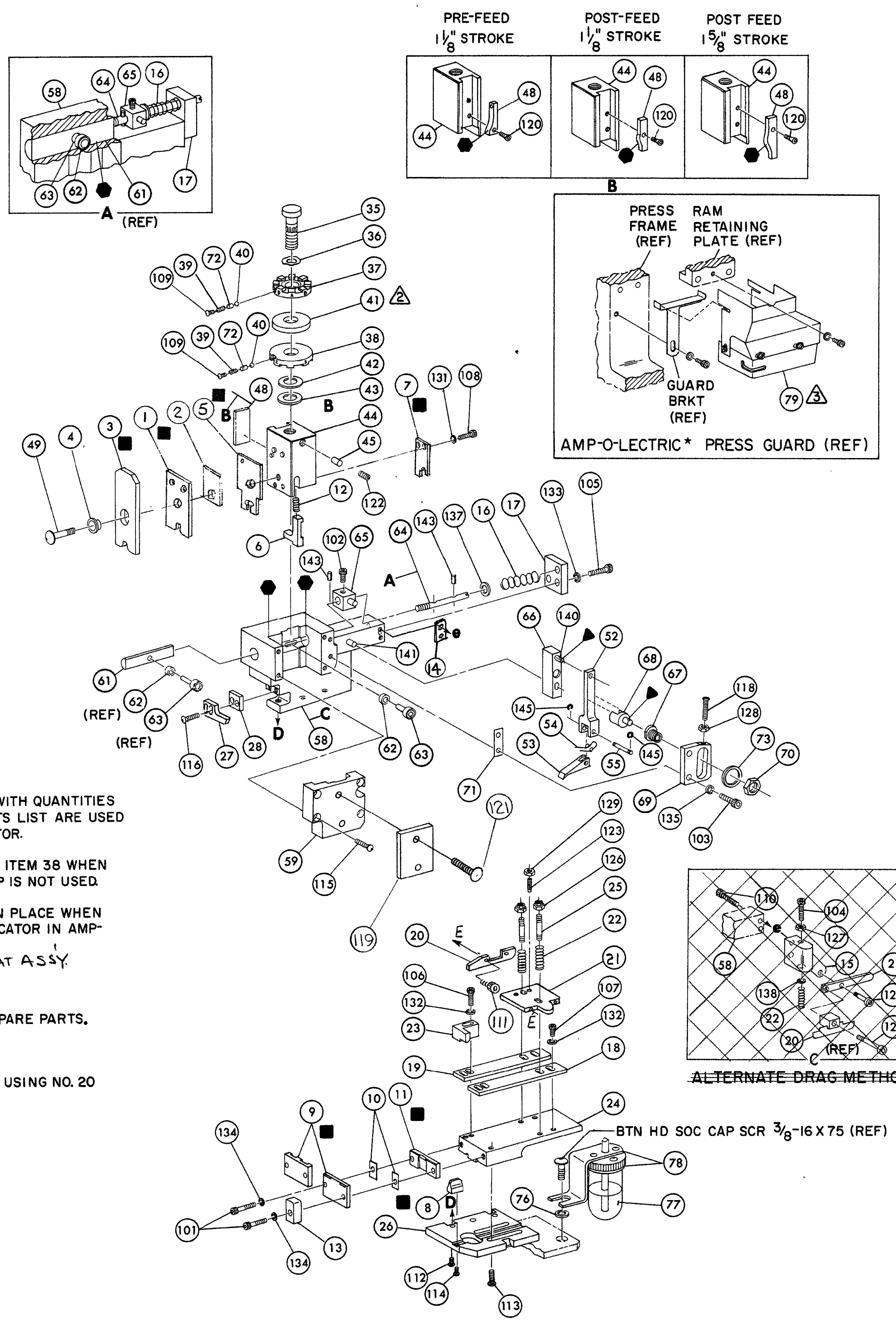


THIS DRAWING IS A CONTROLLED DOCUMENT.



- 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 CUT TO LENGTH AT ASSY.
- KEY:**
- RECOMMENDED SPARE PARTS.
 - ▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.
 - GREASE LIGHTLY.

QTY	PART NO	DESCRIPTION	ITEM NO	PART NO	DESCRIPTION	ITEM NO
2	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	145	454220-1	CAP, RAM	59
			144	453736-1	HOUSING	58
2	5-21028-1	PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD	143			57
			142			56
1	1-21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	141	240624-1	PIN, FEED FINGER	55
1	1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	140	691499-1	SPRING, FEED FINGER	54
			139	694921-8	FINGER, FEED	53
-	22260-5	WASHER, FLAT (NO 6) DRAG SPRING	138	240634-1	LEVER, TERMINAL	52
1	21899-4	WASHER, FLAT (5/16 DIA) SCR ADJ	137			51
			136			50
2	21024-5	WASHER, LOCK (NO 10) FEED ADJ PLATE	135	690686-1	BOLT, CRIMPER	49
2	21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	134	690501-4	CAM, POST FEED 1/8 STROKE	48
2	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	690191-1	PLUG, NYLON	45
			130	455674-5	RAM	44
2	21018-4	NUT, HEX MACH (4-40) DRAG	129	690125-1	WASHER, LAMINATED	43
1	21018-5	NUT, HEX MACH (6-32) FD ADJ PLATE	128	690124-1	WASHER, RAM	42
-	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	127			41
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	126	23241-6	BALL, STEEL	40
-	5-21004-7	SCR, SKT HD SHLD (250 DIA X .25) DRAG ARM	125	690170-1	SPRING, COMPRESSION	39
-	21004-5	SCR, SKT HD SHLD (250 DIA X 1.00) DRAG	124	690142-1	DISC, INSULATION	38
2	4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	123	5-692155-1	DISC, WIRE	37
1	21009-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	122	22480-5	WASHER, SPRING	36
2	21017-2	SCR, DRIVE (#2 X .19)	121	690212-1	POST, RAM	35
1	1-21002-7	SCR, BUT HD SKT CAP (6-32 X .38) CAM	120			34
1	461264-1	PLATE, IDENTIFICATION	119			33
1	6-23715-5	SCR, PAN HD MACH (6-32 X 1.50) FEED ADJ	118	458980-	APPLICATOR, BASIC (SUB ASSY)	32
			117			31
2	2-21002-3	SCR, BTN HD SKT CAP (8-32 X .42) STRIPPER	116			30
4	2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	115			29
1	22733-8	SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	114	3-690451-0	SPACER, STRIPPER	28
4	3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	113	240639-2	STRIPPER	27
3	17177-1	SCR, BTN HD SKT CAP (1/4-20 X .62) BASE PL	112	455676-1	PLATE, BASE	26
2	1-21000-3	SCR, SKT HD CAP (4-40 X .25) DRAG	111	22354-8	DRAG, STUD	25
-	7-21000-3	SCR, SKT HD CAP (6-32 X 1.12) DRAG ADAPTOR	110	455678-1	PLATE, STRIP GUIDE	24
2	23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	109		PLATE, STRIP HOLD	23
2	2-21000-6	SCR, SKT HD CAP (8-32 X .38) SHEAR BLADE	108	23470-5	SPRING, DRAG	22
3	2-21000-6	SCR, SKT HD CAP (8-32 X .38) STRIP GUIDE	107	464451-4	ARM, STOCK DRAG	21
1	2-21000-6	SCR, SKT HD CAP (8-32 X .38) STRIP GUIDE	106	464452-2	DRAG, STOCK	20
2	3-21000-7	SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE	105	3-458030-9	GUIDE, STRIP (REAR)	19
-	3-21000-9	SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING	104	3-458031-9	GUIDE, STRIP (FRONT)	18
2	3-21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	103	454178-1	GUIDE, FEED ROD	17
1	3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	102	4-22284-9	SPRING, FEED RETURN	16
2	3-21000-8	SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE	101	454665-4	ADAPTER, DRAG	15
REF	455745-1	GUARD, WINDOW	79	464524-1	SPACER, ADAPTER	14
-	465184-9	LUBRICATOR ASSY	78		SPACER, HOLD DOWN	13
-	455985-1	OIL, LUBRICATING	77		SPRING, HOLD DOWN	12
-	454406-1	SPACER, LUB BRACKET	76	453654-1	PLATE, REAR SHEAR	11
			75	2-240645-0	SPACER, SHEAR PLATE	10
			74	453653-1	PLATE, FRONT SHEAR RETAINER	9
1	458109-1	WASHER, FLAT (SPECIAL)	73	453670-5	ANVIL	8
2	690603-1	SPRING, ASSIST	72	453656-1	BLADE, SLUG REAR	7
1	690517-1	SPACER	71		HOLD DOWN, TERMINAL	6
1	22594-8	NUT, HEX	70	684917-2	SHEAR BLADE FRONT	5
1	240628-1	PLATE, ADJ	69	238009-1	SPACER, TUBULAR	4
1	240626-1	SHAFT, PIVOT	68	2-456135-8	CRIMPER, INSULATION	3
1	240633-1	BUSHING	67	1-455888-2	SPACER, WIRE CRIMPER	2
1	455680-1	LEVER, INTERMEDIATE	66	2-456402-6	CRIMPER, WIRE	1
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			
1	454398-1	ROD, FEED	61			

CRIMPING DATA				APPLICATOR WILL APPLY	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH		
A	.041	20			61119
B	.037	22			61451
C	.034	24			61586
D	NOT USED				641549
CRIMP	SIZE	TYPE	FEED	APPL INST	
WIRE	.055	F			
INSUL	.080	O	.535	A18039	
WIRE RANGE	24-20	INSULATION RANGE	INSUL RANGE	PRESS NO	
			.045-.070		
REMARKS: AMPOMATOR					

REMARKS	NO	REV
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

F REV PER R-5037
 E REV PER EQU R-3624
 DI REV PER EQU R-3460
 D REV PER EQU R-3085
 C REV PER EQU R-2629
 B REV PER EQU R-1985
 A REV PER EQU R-1806

SET UP GAGE 10-1
 458638-1 405
 DR 9/16/44
 WIRE CRIMPER
 2-2-77
 CHK
 REL 9/16/74
 LOC
 D NO 466294-1 REV HI

NAME: MINIATURE QUICK CHANGE APPLICATOR
 END FEED (RIGHT ANGLE PIN RECOG)
 CUSTOMER AND ASSEMBLY DRAWING