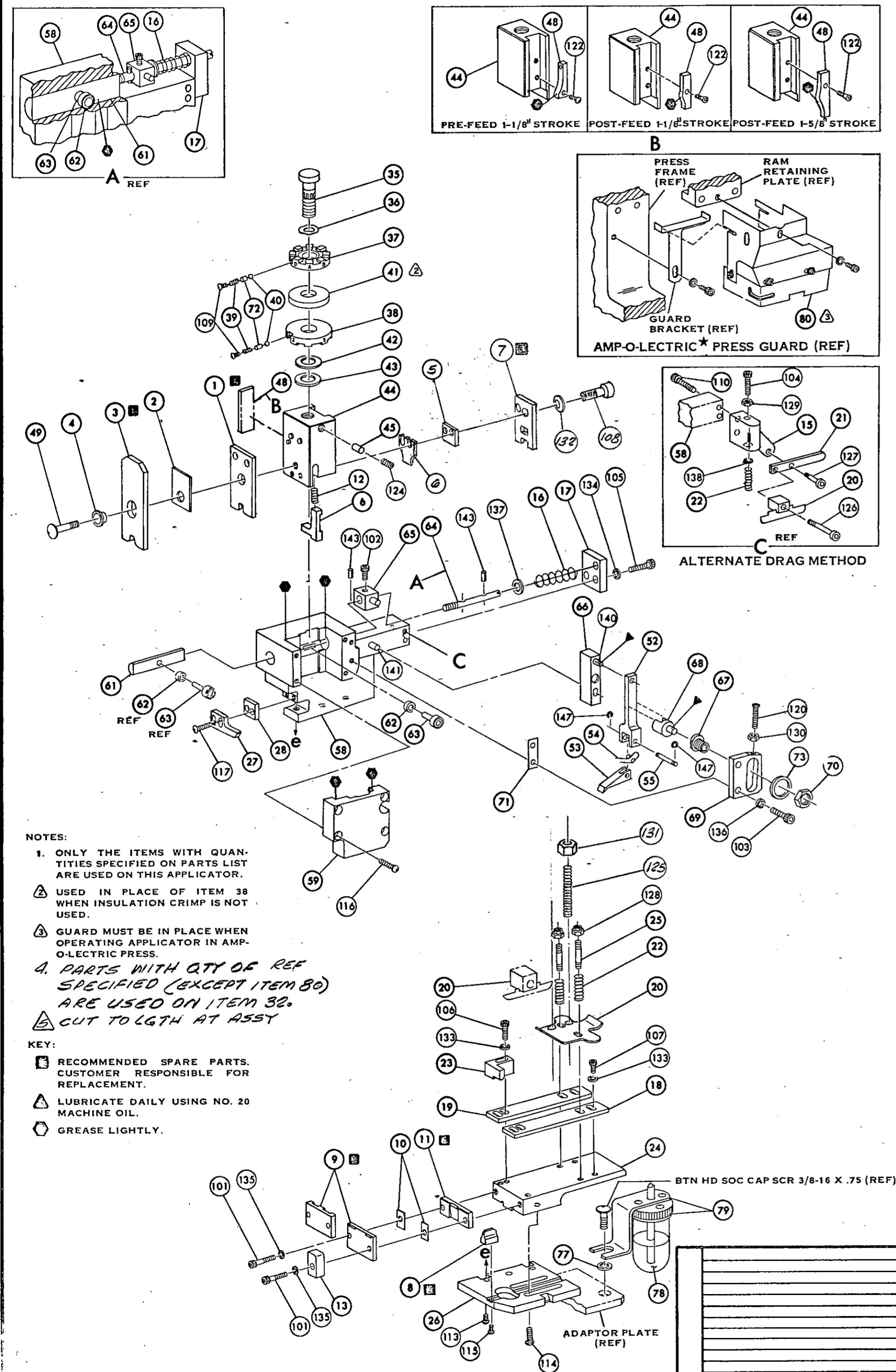


THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INC. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.



- NOTES:**
- 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.
 - PARTS WITH QTY OF REF SPECIFIED (EXCEPT ITEM 80) ARE USED ON ITEM 32.
 - CUT TO LGTH AT ASSY
- KEY:**
- RECOMMENDED SPARE PARTS. CUSTOMER RESPONSIBLE FOR REPLACEMENT.
 - LUBRICATE DAILY USING NO. 20 MACHINE OIL.
 - GREASE LIGHTLY.

THIS INFORMATION IS CONFIDENTIAL AND IS RELEASED TO YOU ON THE UNDERSTANDING THAT NO FURTHER DISCLOSURE WILL BE MADE BY YOU TO OTHERS WITHOUT THE WRITTEN AUTHORIZATION FROM AMP INCORPORATED, HARRISBURG, PENNA.

DIMENSIONS IN INCHES DO NOT SCALE PRINT

*TRADEMARK OF AMP INCORPORATED

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
			147				56
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	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	690602-5	CAM, PRE FEED 1- 1/8 STROKE	48
			138				47
			137				46
REF	21899-4	WASH, FLAT (NO. 6) DRAG SPRING	136	1	690191-1	PLUG, NYLON	45
REF	21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE	135	1	455674-2	RAM	44
2	21024-5	WASH, LOCK (NO. 10) SHEAR PLATES	134	1	690125-1	WASHER, LAMINATED	43
REF	21024-5	WASH, LOCK (NO. 10) FEED ROD GUIDE	133	1	690124-1	WASHER, RAM	42
5	21024-4	WASH, LOCK (NO. 8) STRIP GUIDE	132			SPACER, DISC	41
2	21024-4	WASH, LOCK (NO. 8) SHEAR BLADE	131	2	23241-6	BALL, STEEL	40
REF	21018-4	NUT, HEX, MACH (A-90) DRAG	130	2	690170-1	SPRING, COMPRESSION	39
REF	21068-5	NUT, HEX MACH (6-32) FEED ADJ PLATE	129	1	690142-1	DISC, INSULATION	38
			128	1	5-690692-6	DISC, WIRE	37
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUDS	127	1	22480-5	WASHER, SPRING	36
			126	1			35
2	21004-7	SCR, SKT HD SHLD (.250 DIA x .25) DRAG ARM	125				34
			124				33
			123				32
1	21009-2	SCR, SKT SET (1/4-20 x 25) NYLOK RAM	122	1	458980-1	APPLICATOR, BASIC (SUB ASSY)	31
			121				30
REF	3- 21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ	120				29
			119	1	3-690451-2	SPACER, STRIPPER	28
			118	1	240639-1	STRIPPER	27
2	2-21002-3	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	22954-8	DRAG, STUD	25
1	22733-8	SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL	115	1	455673-5	PLATE, STRIP GUIDE	24
4	3- 21002-3	SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL	114	1	240825-9	PLATE, STRIP HOLD	23
REF	1-24073-9	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
			110	1	454204-7	GUIDE, STRIP REAR	19
2	23030-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC	109	1	454204-7	GUIDE, STRIP FRONT	18
2	2-21000-7	SCR, SKT HD CAP (8-32 x .44) SHEAR BLADE	108	REF	454178-1	GUIDE, FEED ROD	17
3	7-21000-4	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE	107	REF	4-22284-9	SPRING, FEED RETURN	16
2	2-21000-8	SCR, SKT HD CAP (8-32 x .62) 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
			104			SPACER, HOLD DOWN	13
			103			SPRING, HOLD DOWN	12
REF	3- 21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE	102			PLATE, REAR SHEAR	11
REF	3- 21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK	101	2	240644-8	SPACER, SHEAR PLATE	10
2	3- 21000-8	SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES	100	2	2-240645-3	SPACER, SHEAR PLATE	9
REF	455745-1	GUARD, WINDOW	80	1	1-240648-0	PLATE, FRONT SHEAR	8
			79	1	6-240655-7	ANVIL	7
			78	1	3-240661-6	BLADE, SLUG	6
			77	1	690518-7	HOLD DOWN	5
			76	1	4-240641-3	SPACER, SHEAR BLADE	4
			75	1	238069-1	SPACER, TUBULAR, INS CRIMPER	3
			74	1	1-456134-6	CRIMPER, INSULATION	2
REF	458109-1	WASHER, FLAT (SPECIAL)	73	1	455883-7	SPACER, INSULATION	1
2	690603-1	SPRING, ASSIST	72	1	1-456403-5	CRIMPER, WIRE	1

NO. 466020-2

CRIMPING DATA				THIS APPLICATOR WILL APPLY
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	60089
A	.032	22		
B	.030	24		
C	NOT	USED		
D	NOT	USED		
CRIMP WIRE	SIZE	TYPE	FEED	PRESS REF.
	.062	F		565435-5
INSULATION	.080	F	.705	
INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION	A8039	
.040-.060	24-22			
REMARKS: AMP-O-LECTRIC PRE FEED				
SET UP PAGE 459633-1 LAYOUT NO. 407				
AMP INCORPORATED HARRISBURG, PENNA.				
MINIATURE QUICK CHANGE APPLICATOR END-FEED (.110 FASTON RECEPT)				

REV	DATE	DESCRIPTION	BY	CHK
H	01/30/74	REV PER ECN A-153588	WJ	
G	01/30/74	REV PER ECN R-5470	WJ	
F	01/30/74	REV PER ECN R-2905	WJ	
E	01/30/74	REV PER ECN	WJ	
D	01/30/74	REV PER ECN	WJ	
C	01/30/74	REV PER ECN	WJ	
B	01/30/74	REV PER ECN	WJ	
A	01/30/74	REV PER ECN	WJ	