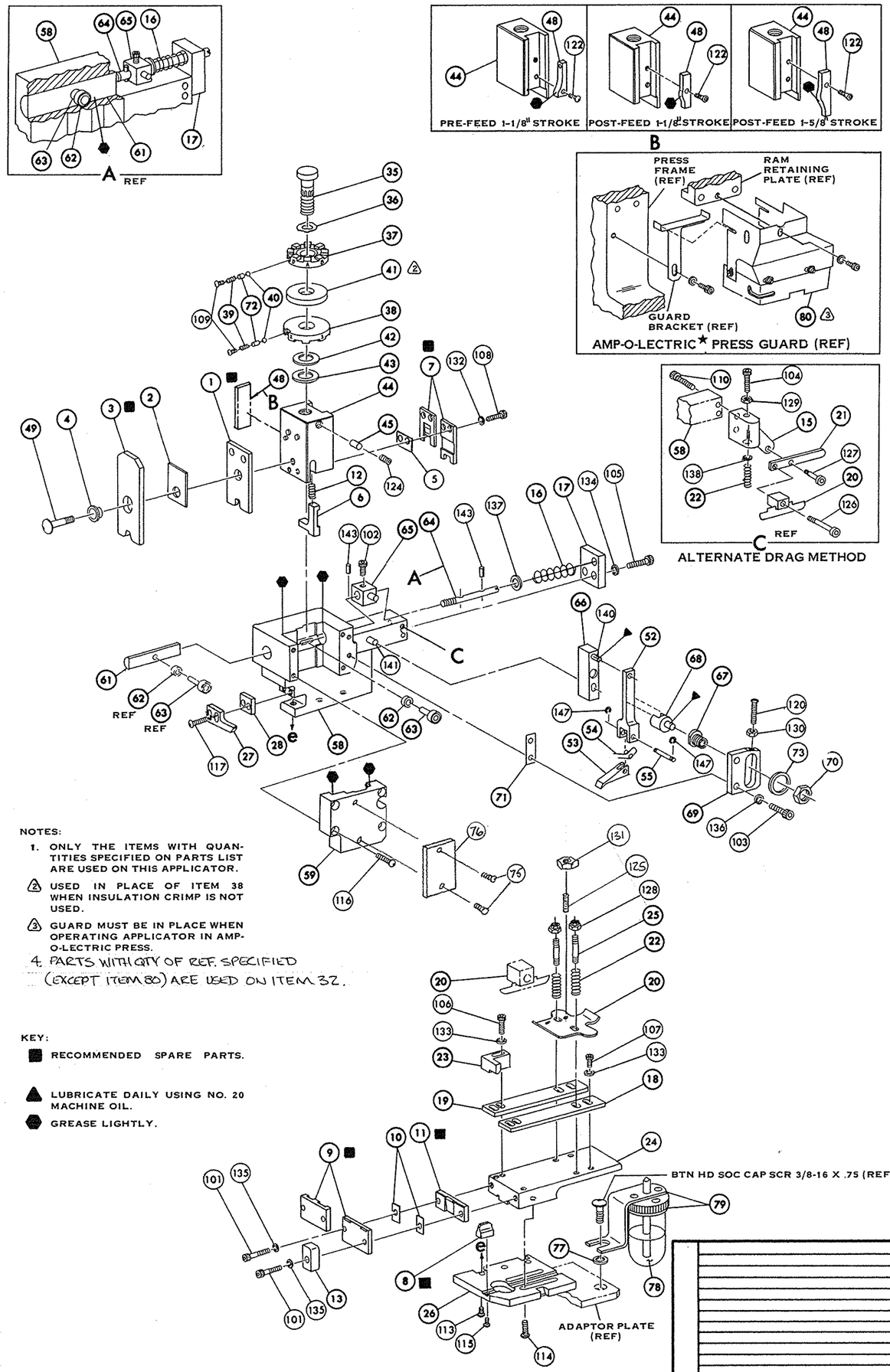

NOTES:

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.

★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				52
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	690561-3	CAM, POSTFEED 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	455674-2	RAM	44
REF	21024-5	WASH, LOCK (NO. 10) FEED ROD GUIDE	134	1	690125-1	WASHER, LAMINATED	43
4	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	7690141-6	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	APPL, BASIC (SUB ASSY)	32
1	2- 21003-0	SCR, FLAT HD SOC CAP (6-32 x .50) CAM	122				31
			121				30
REF	3- 21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ	120				29
			119	1	3690451-2	SPACER, STRIPPER	28
			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			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
—	2- 21000-4	SCR, SKT HD CAP (6-32 x 1.00) DRAG ADAPTOR	110	1	458020-3	GUIDE, STRIP REAR	19
1	23030-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC	109	1	458031-3	GUIDE, STRIP FRONT	18
2	2-21000-6	SCR, SKT HD CAP (8-32 x .38) 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
1	7-21000-4	SCR, SKT HD CAP (8-32 x .31) 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			SPACER, HOLD DOWN	13
REF	3- 21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE	103			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	690482-5	PLATE, FRONT SHEAR ■	9
—	465184-9	LUBRICATOR ASSY	79	1	1-240654-4	ANVIL ■	8
—	22014-1	OIL SYNTHETIC	78	1	690474-5	BLADE, SLUG ■	7
—	454406-1	SPACER, LUBRICATOR BRACKET	77			HOLD DOWN	6
1	461264-1	PLATE IDENTIFICATION	76	1	1-240641-3	SPACER, SHEAR BLADE	5
2	21017-2	SCR, DRIVE (2 x .19) ID PLATE	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	1-456489-5	CRIMPER, WIRE ■	1

CRIMPING DATA

THIS APPLICATOR WILL APPLY: 42054

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.091	14	
B	.082	16	
C	.078	18	
D	NOT	USED	

	SIZE	TYPE	FEED	PRESS REF.
CRIMP				
WIRE	.120	F	.520	565435-5
INSULATION	—	—		

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

REMARKS: AMP-O-LECTRIC POST-FEED

APPL SPEC 114-2084

LTR	REVISION RECORD	ECN	DR	CK	DATE
E1	ECR-06-002275				1-06
E	0150-0762-02				6-02
D	0150-0518-01				5-01
C	ECN A160688				11-88
B	REV. PER ECN R-3510				2-15-84
A	REV PER ECN	R 870			12-20-73
01	REV PER ECN	L 9623			7-12-73

SET UP GAGE 458638-1 | LAYOUT NO. 56 | DRAWN BA WOLFE 5-22-73 | APPROVED 5-23-73 | CHECKED 5-23-73 | REL. 5-24-73

AMP INCORPORATED HARRISBURG, PENNA.

LOC A | C | NO. 687820-2 | REV. E1

SCALE NONE

NAME: MINIATURE QUICK CHANGE APPLICATOR END-FEED (RING)

CUSTOMER AND ASSEMBLY DRAWING

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