



- 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.

- KEY:
- RECOMMENDED SPARE PARTS
 - LUBRICATE DAILY USING NO. 20 MACHINE OIL.
 - GREASE LIGHTLY.

| 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 |
| | 146 | REF | 240624-1 | | PIN, FEED FINGER | | 55 |
| | 145 | REF | 691499-1 | | SPRING, FEED FINGER | | 54 |
| | 144 | REF | 240635-1 | | FINGER, FEED | | 53 |
| | 143 | REF | 240634-3 | | LEVER, TERMINAL | | 52 |
| | 142 | | | | | | 51 |
| REF | 5- 21028-1 | PIN, SLOT SPG (.12 DIA x .50) FEED ADJ ROD | | | | | 50 |
| REF | 1- 21030-7 | PIN, DOWEL (.187 DIA x 1.50) HOUSING | | | | | 49 |
| REF | 1- 21030-1 | PIN, DOWEL (.187 DIA x .50) LEVER | | | | | 48 |
| | | | | | | | 47 |
| | 22260-5 | WASH, FLAT (NO. 6) DRAG SPRING | | | | | 46 |
| REF | 21899-4 | WASH, FLAT (NO. 5/16 DIA) SCR ADJ | | | | | 45 |
| REF | 21024-5 | WASH, LOCK (NO. 10) FEED ADJ PLATE | | | | | 44 |
| 2 | 21024-5 | WASH, LOCK (NO. 10) SHEAR PLATES | | | | | 43 |
| REF | 21024-5 | WASH, LOCK (NO. 10) FEED ROD GUIDE | | | | | 42 |
| 5 | 21024-4 | WASH, LOCK (NO. 8) STRIP GUIDE | | | | | 41 |
| 2 | 21024-4 | WASH, LOCK (NO. 8) SHEAR BLADE | | | | | 40 |
| 2 | 21018-4 | NUT, HEX MACH (4-40) DRAG | | | | | 39 |
| REF | 21068-5 | NUT, HEX MACH (6-32) FEED ADJ PLATE | | | | | 38 |
| | 21018-7 | NUT, HEX MACH (10-32) DRAG SPRING | | | | | 37 |
| 2 | 21022-2 | NUT, HEX SELF-LKG (8-32) DRAG STUDS | | | | | 36 |
| | 5- 21004-7 | SCR, SKT HD SHLD (.250 DIA x .25) DRAG ARM | | | | | 35 |
| | | | | | | | 34 |
| | 21004-5 | SCR, SKT HD SHLD (.250 DIA x 1.00) DRAG | | | | | 33 |
| 1 | 1-21078-B | SCR, SKT SET OVAL PT. (4-40 x .75) DRAG | | | | | 32 |
| 2 | 21009-2 | SCR, SKT SET (1/4-20 x 25) NYLOK RAM | | | | | 31 |
| | | | | | | | 30 |
| 1 | 2- 21003-0 | SCR, FLAT HD SOC CAP (6-32 x .50) CAM | | | | | 29 |
| | | | | | | | 28 |
| REF | 3- 21064-2 | SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ | | | | | 27 |
| | | | | | | | 26 |
| | 2- 21002-2 | SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER | | | | | 25 |
| REF | 2- 21002-9 | SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP | | | | | 24 |
| 1 | 22733-8 | SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL | | | | | 23 |
| 4 | 3- 21002-3 | SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL | | | | | 22 |
| REF | 1-24073-9 | SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE | | | | | 21 |
| | | | | | | | 20 |
| | | | | | | | 19 |
| | 2- 21000-4 | SCR, SKT HD CAP (6-32 x 1.00) DRAG ADAPTOR | | | | | 18 |
| | 23030-1 | SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC | | | | | 17 |
| 2 | 2-21000-7 | SCR, SKT HD CAP (8-32 x .50) SHEAR BLADE | | | | | 16 |
| 3 | 2-21000-6 | SCR, SKT HD CAP (8-32 x .38) STRIP GUIDE | | | | | 15 |
| 2 | 2-21000-9 | SCR, SKT HD CAP (8-32 x .75) STRIP GUIDE | | | | | 14 |
| REF | 3- 21000-7 | SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE | | | | | 13 |
| | 3- 21000-9 | SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING | | | | | 12 |
| REF | 3- 21000-6 | SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE | | | | | 11 |
| REF | 3- 21000-4 | SCR, SKT HD CAP (10-32 x .38) PIVOT BLK | | | | | 10 |
| 2 | 3- 21000-8 | SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES | | | | | 9 |
| REF | 455745-1 | GUARD, WINDOW | | | | | 8 |
| | 465184-9 | LUBRICATOR ASSY | | | | | 7 |
| | 22014-1 | OIL SYNTHETIC | | | | | 6 |
| | 454406-1 | SPACER, LUBRICATOR BRACKET | | | | | 5 |
| | | | | | | | 4 |
| 1 | 461264-1 | PLATE, IDENTIFICATION | | | | | 3 |
| 2 | 21017-2 | SCREW, DRIVE | | | | | 2 |
| REF | 458109-1 | WASHER, FLAT (SPECIAL) | | | | | 1 |
| 2 | 690603-1 | SPRING, ASSIST | | | | | |

APPL SPEC 114 - 2065

| CRIMPING DATA | | | | THIS APPLICATOR WILL APPLY |
|----------------------------------|-------------------|------------------------------|-------------------|----------------------------|
| PAD LETTER | CRIMP HEIGHT | WIRE SIZE | WIRE STRIP LENGTH | 42904 |
| A | .086 | #12 | | 61127 |
| B | .072 | #14 | | 62291 |
| C | .064 | #16 | | 62891 |
| D | NOT USED | | | |
| CRIMP SIZE | TYPE | FEED | PRESS REF. | |
| WIRE .120 | F | | | |
| INSULATION .210 | F | .840 | 565435-5 | |
| INSULATION RANGE .150-.190 | WIRE RANGE #16-12 | APPLICATOR INSTRUCTION #8039 | | |
| REMARKS: AMP-O-LECTRIC POST FEED | | | | |

| REV | DATE | DESCRIPTION | REV | DATE | DESCRIPTION |
|-----|------|-------------|-----|------|-------------|
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

SET UP GAGE: 458638-1
 LAYOUT NO.: 294
 DRAWN: 9/5/73
 APPROVED: [Signature]
 CHECKED: [Signature]
 SCALE: NONE
AMP INCORPORATED
 HARRISBURG, PENNA.
 LOC A C NO. 687913-2 REV F
MINIATURE QUICK CHANGE APPLICATOR
 END-FEED (.250 FAST IN FAST OUT)

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 DIMENSIONS IN INCHES DO NOT SCALE PRINT

NO. 687913-2