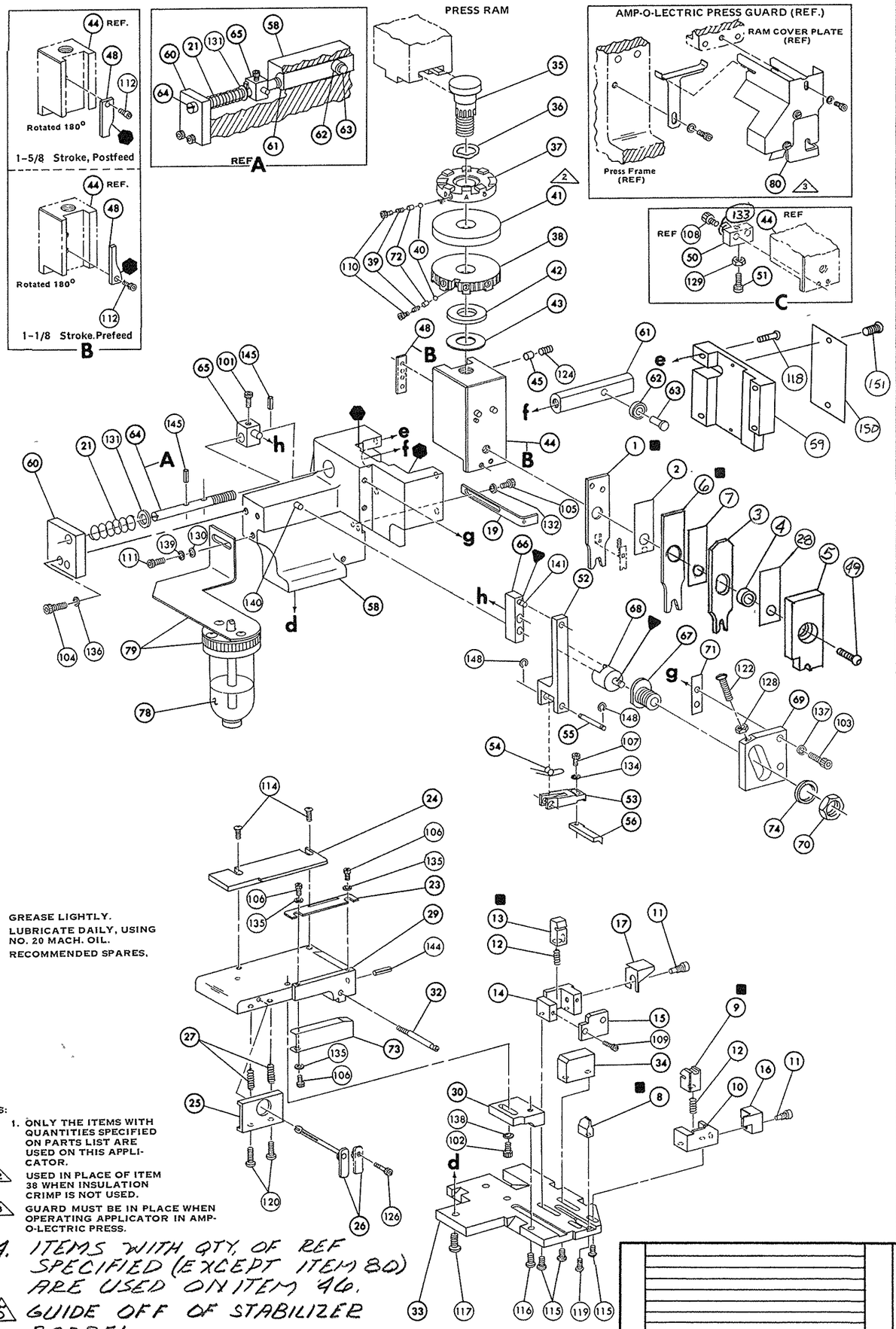

KEY:

- GREASE LIGHTLY.
- LUBRICATE DAILY, USING NO. 20 MACH. OIL.
- RECOMMENDED SPARES.

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. ITEMS WITH QTY. OF REF SPECIFIED (EXCEPT ITEM 80) ARE USED ON ITEM 46.
5. GUIDE OFF OF STABILIZER BARREL
6. CUT TO LENGTH AT ASSY.

REQ.	PART NO.	DESCRIPTION	NO.	REQ.	PART NO.	DESCRIPTION	NO.
			162	REF	690517-1	SPACER	71
			161	1	22594-8	NUT, HEX	70
			160	1	240628-1	PLATE, ADJUSTMENT	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, ADJUSTMENT, FEED ROD	64
			154		240659-3	PIN, CAM ROLLER	63
			153		240658-1	ROLLER, CAM	62
			152		454398-2	ROD, FEED	61
2	21017-2	SCR, DRIVE (2 x .19) ID PLATE	151	1	454178-1	GUIDE, FEED ROD	60
1	461264-1	PLATE, ID	150	1	454220-1	CAP, HOUSING	59
			149	REF	454485-1	HOUSING	58
REF	21045-3	RING, RETNG "C" (.187 DIA) FEED FINGER PIN	148				57
			147	1	690542-2	PAWL, FEED	56
			146	REF	240624-1	PIN, FEED FINGER	55
REF	5- 21028-1	PIN, SLTD SPRING (.125 DIA x .50) ADJ ROD	145	REF	691499-1	SPRING, FEED FINGER	54
1	4- 21028-0	PIN, SLTD SPRING (.093 DIA x .75) S. G. PL	144	REF	690541-1	FINGER, FEED	53
			143	REF	455679-1	LEVER, TERMINAL FEED ARM	52
			142	1	811242-2	BUMPER, HOLDDOWN	51
REF	1- 21030-1	PIN, DOWEL (.187 DIA x .50) LEVER	141	1	690753-1	SPACER, TONKER	50
REF	1- 21030-6	PIN, DOWEL (.187 DIA x1.25) HOUSING	140	1	7-21002-9	BOLT, CRIMPER	49
—	21024-5	WASHER, LOCK (NO. 10) LUB ASSY	139	1	690602-5	CAM PREFEED 1 1/8 STROKE	48
1	21024-5	WASHER, LOCK (NO. 10) STRIP GUIDE ADJ BLK	138				47
REF	21024-5	WASHER, LOCK (NO. 10) ADJ PLATE	137	1	459456-1	APPL BASIC (SUB ASSY)	46
REF	21024-5	WASHER, LOCK (NO. 10) FEED GUIDE ROD	136	1	690191-1	PLUG, NYLON	45
3	21057-2	WASHER, LOCK (NO. 4) FRONT STRIP GUIDE	135	1	455673-1	RAM	44
1	21024-4	WASHER, LOCK (NO. 8) FEED FINGER	134	1	690125-1	WASHER, LAMINATED	43
2	21024-4	WASHER, LOCK (NO. 8) DEPRESSOR	133	1	690124-1	WASHER, RAM	42
1	21024-4	WASHER, LOCK (NO. 8) STRIPPER	132			DISC, SPACER △2	41
REF	21899-4	WASHER, FLAT (5/16 DIA) SCREW ADJ	131	2	23241-6	BALL, STEEL	40
—	21899-2	WASHER, FLAT (NO. 10) LUB ASSY	130	2	690170-1	SPRING, COMPRESSION	39
1	21068-5	NUT, HEX MACH (6-32) HOLDDOWN	129	1	690142-1	DISC, INSULATION	38
REF	21068-5	NUT, HEX MACH (6-32) FEED ADJ	128	1	1-690682-2	DISC, WIRE	37
			127	1	22480-5	WASHER, SPRING	36
—	22353-8	SCREW, SHLDR (.187 DIA x .250 LG) DRAG LEVER	126	1	690212-1	POST, RAM	35
			125	1	460712-1	SUPPORT, TERMINAL	34
1	21009-2	SCREW, SKT SET (1/4-20 x .25) (NYLOK) RAM	124	REF	455675-1	PLATE, BASE	33
			123	1	690432-3	SCREW, ADJUSTMENT	32
REF	3- 21064-2	SCREW, RD HD MACH (6-32 x 1.50) FEED ADJ	122				31
			121	REF	455689-1	BLOCK, STRIP GUIDE ADJ	30
2	2- 21002-9	SCREW, BTN HD SKT CAP (10-32 x .75) DRAG	120	1	455671-5	PLATE, STRIP GUIDE	29
1	22733-8	SCREW, BTN HD SKT CAP (8-32 x .38) ANVIL	119	1	455888-8	SPACER, F. SHEAR DEPRESSOR	28
REF	2- 21002-9	SCREW, BTN HD SKT CAP (10-32 x .75) CAP	118	2	122284-0	SPRING, DRAG	27
REF	1- 24073-9	SCREW, BTN HD SKT CAP (NYLOK) 1/4-20 x .75 HSG	117	1	690546-1	LEVER, DRAG RELEASE	26
REF	2- 21002-7	SCREW, BTN HD SKT CAP (10-32 x .50) S.G. ADJ BLK	116	1	240792-1	DRAG, STOCK	25
4	2- 21002-2	SCREW, BTN HD SKT CAP (8-32 x .50) SHEAR	115	1	1-690504-3	GUIDE, STRIP REAR △5	24
2	2-21002-2	SCREW, BTN HD SKT CAP (8-32 x .50) R. S. G.	114	1	690438-1	GUIDE, STRIP FRONT	23
			113				22
1	1- 21002-7	SCREW, BTN HD SKT CAP (6-32 x .38) CAM	112	REF	4- 22284-9	SPRING, FEED RETURN	21
—	3- 21000-4	SCREW, SKT HD CAP (10-32 x .38) LUB ASSY	111				20
2	23030-1	SCREW, SKT HD CAP (6-32 x .25) (NYLOK) C.P. DISC	110	1	691353-1	STRIPPER	19
		SCREW, SKT HD CAP (6-32 x) R. SHEAR PLATE	109			HOLDER, TERMINAL	18
2	2-21000-7	SCREW, SKT HD CAP (8-32 x .46) DEPRESSOR △6	108			GUARD, CHIP REAR	17
1	2-226603-0	SCREW, SKT HD CAP (8-32 x .31) FEED FINGER	107	1	691667-1	GUARD, CHIP FRONT	16
3	1- 21000-3	SCREW, SKT HD CAP (4-40 x .25) F. STRIP GUIDE	106			PLATE, SHEAR REAR ■	15
1	2- 21000-7	SCREW, SKT HD CAP (8-32 x .50) STRIPPER	105			HOLDER, SHEAR REAR	14
REF	3- 21000-7	SCREW, SKT HD CAP (10-32 x .75) FEED ROD G.	104			SHEAR, FLOAT REAR ■	13
REF	3- 21000-6	SCREW, SKT HD CAP (10-32 x .62) FEED ADJ BLK	103	1	5- 22280-0	SPRING, SHEAR	12
1	3- 21000-4	SCREW, SKT HD CAP (10-32 x .38) S.G. ADJ BLK	102	1	690461-1	STOP, SHEAR	11
REF	3- 21000-4	SCREW, SKT HD CAP (10-32 x .38) PIVOT BLOCK	101	1	690459-1	HOLDER, SHEAR FRONT	10
REF	455749-1	GUARD (WINDOW) △3	80	1	454216-1	SHEAR, FLOAT FRONT ■	9
—	1-465184-0	LUBRICATOR ASSY	79	1	1-458834-3	ANVIL ■	8
		OIL SYNTHETIC	78	1	455888-2	SPACER, SIZING TOOL	7
			77	1	460130-1	TOOL, SIZING	6
			76	1	1-455889-3	DEPRESSOR, SHEAR FRONT	5
			75	1	238011-2	SPACER, TUBULAR, INS CRIMPER	4
REF	458109-1	WASHER, FLAT, SPECIAL	74	1	2-456135-0	CRIMPER, INSULATION ■	3
1	454877-3	PLATE, STRIP GUIDE COVER	73	1	455888-1	SPACER, CRIMPER	2
2	690603-1	SPRING, ASSIST	72	1	1-456404-0	CRIMPER, WIRE ■	1

TERM APPL SPEC 114-25008

CRIMPING DATA

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.048	18	
B	.043	20	
C	.040	22	
D	NOT	USED	

CRIMP	SIZE	TYPE	FEED	USED ON
WIRE	.070	"F"	.420	MACH NO. 565435-5
INSULATION	.110	"O"		

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION
.050-.100 DIA	18-22	8040

REMARKS: AMP-O-LECTRIC PRE FEED

THIS APPLICATOR WILL APPLY: 87269

LTR	REVISION RECORD	ECN	DR/CK	DATE
E	ECR 05-009434		MY/KC	8-03
D	ECN A-15358A	A 535	NCK	11-1-88
C1	DARKENED		JH/KR	3-9-88
C	REV. ITEM 37	A 343		3-5-80
B1	REV PER ECN	R 1756		7-26-76
B	REV. PER ECN	R 418		4-15-74
A	REV PER ECN	R 416		3-29-74

SET UP GAGE 458637-1 | LAYOUT NO. 681 | DRAWN 11-20-73 | APPROVED 12-30-73 | CHECKED 11-28-73 | REL. 11-30-73 | SCALE NONE | NAME

AMP INCORPORATED HARRISBURG, PENNA.

LOC A C | NO. 466007-2 | REV E

APPLICATOR MINIATURE QUICK CHANGE SIDE-FEED (CONTACT)

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

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