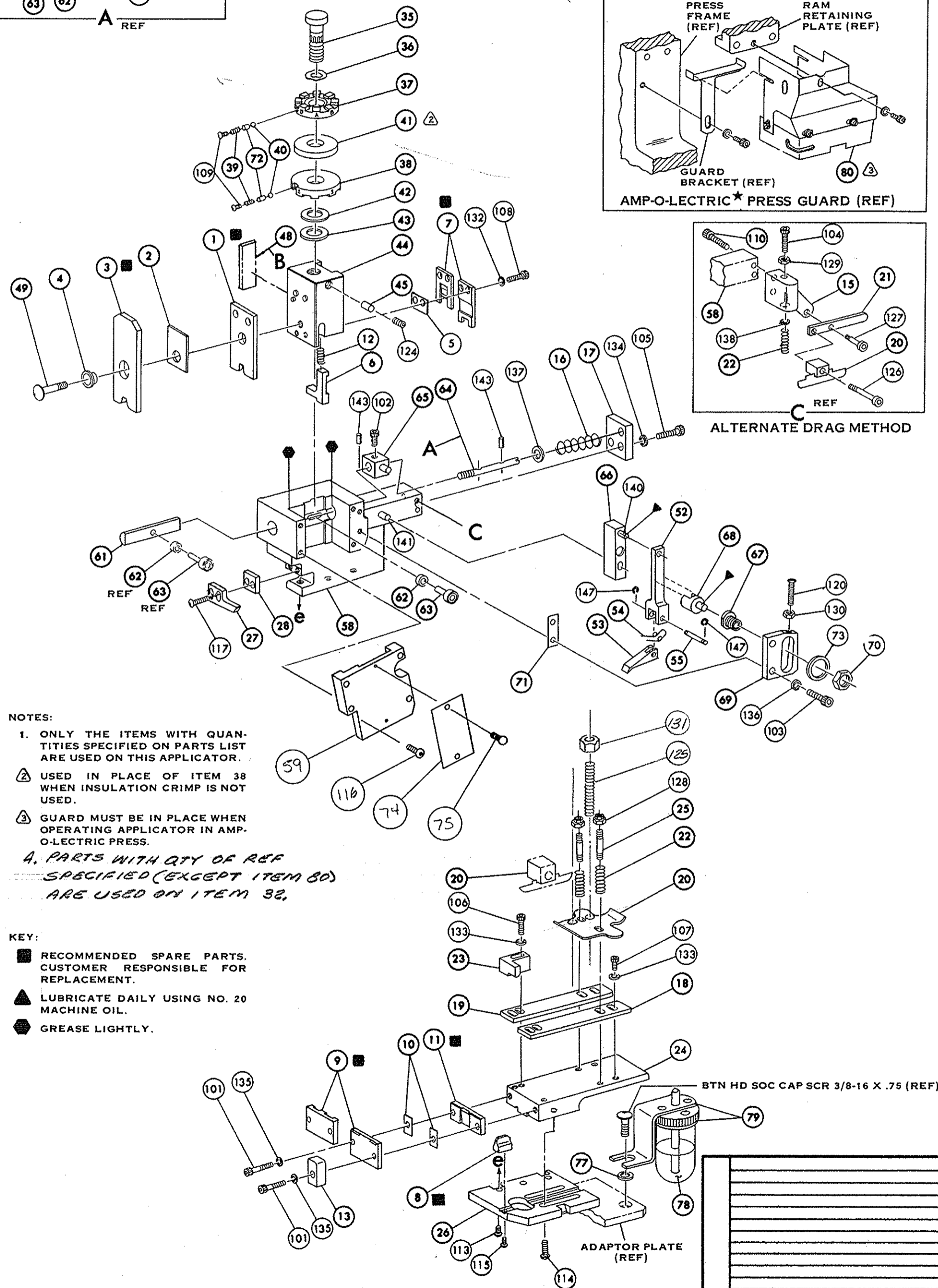
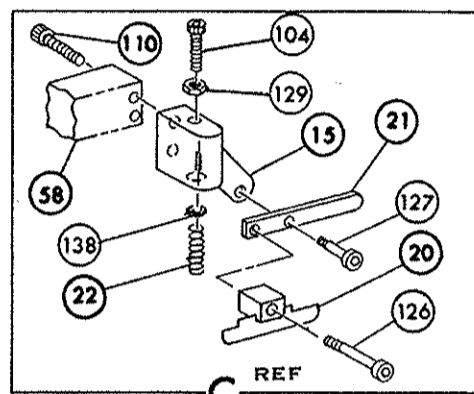
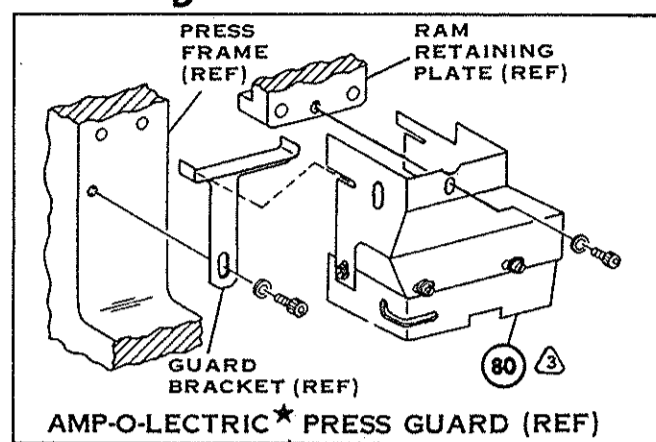
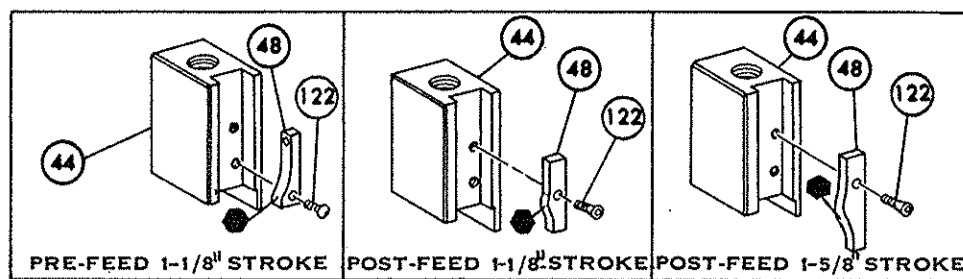
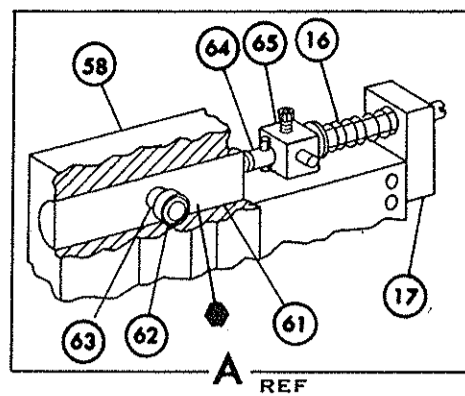


THIS DRAWING IS A CONTROLLED DOCUMENT.



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.
 A. PARTS WITH QTY OF REF SPECIFIED (EXCEPT ITEM 80) ARE USED ON ITEM 32.

KEY:
 ■ RECOMMENDED SPARE PARTS. CUSTOMER RESPONSIBLE FOR REPLACEMENT.
 ▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.
 ● GREASE LIGHTLY.

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	240634-1	LEVER, TERMINAL	52
142				51
141				50
140	1	7-21002-9	BOLT, CRIMPER	49
139	1	690501-4	CAM, POST FEED 1-5/8 STROKE	48
138				47
137				46
136	1	690191-1	PLUG, NYLON	45
135	1	455674-1	RAM	44
134	1	690125-1	WASHER, LAMINATED	43
133	1	690124-1	WASHER, RAM	42
132				41
131	2	23241-6	BALL, STEEL	40
130	2	690170-1	SPRING, COMPRESSION	39
129	1	690142-1	DISC, INSULATION	38
128	1	6-692155-5	DISC, WIRE	37
127	1	22480-5	WASHER, SPRING	36
126	1	690212-1	POST, RAM	35
125				34
124				33
123	1	452980-1	APPLICATOR, BASIC (SUB ASSY)	32
122				31
121				30
120				29
119	1	3-690451-2	SPACER, STRIPPER	28
118	1	240639-1	STRIPPER	27
117	REF	455676-1	PLATE, BASE	26
116	2	22554-B	DRAG, STUD	25
115	1	455678-1	PLATE, STRIP GUIDE	24
114				23
113	2	A-22281-1	SPRING, DRAG	22
112	-	240636-1	LEVER, DRAG	21
111	1	454177-1	DRAG, STOCK	20
110	1	458030-9	GUIDE, STRIP REAR	19
109	1	458031-9	GUIDE, STRIP FRONT	18
108	REF	454178-1	GUIDE, FEED ROD	17
107	REF	4-22284-9	SPRING, FEED RETURN	16
106	-	454665-1	ADAPTOR, DRAG	15
105				14
104				13
103				12
102	1	240644-1	PLATE, REAR SHEAR	11
101	2	240645-8	SPACER, SHEAR PLATE	10
80	1	240642-1	PLATE, FRONT SHEAR	9
79	1	2-240693-8	ANVIL	8
78	1	1-240651-2	BLADE, SLUG	7
77				6
76	1	4-240691-0	SPACER, SHEAR BLADE	5
75	1	238009-1	SPACER, TUBULAR, INS CRIMPER	4
74	1	1-456135-4	CRIMPER, INSULATION	3
73	1	455650-4	SPACER, INSULATION	2
72	1	1-456102-5	CRIMPER, WIRE	1

TERM APPL SPEC 114-2084

NO.	PART NO.	DESCRIPTION	NO.	REQ.	PART NO.	DESCRIPTION	NO.
2	21017-2	SCR, DRIVE (#2 x .19) ID PLATE	75				
1	461264-1	PLATE, ID	74				
REF	458109-1	WASHER, FLAT (SPECIAL)	73				
2	690603-1	SPRING, ASSIST	72				

CRIMPING DATA				THIS APPLICATOR WILL APPLY	
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	RINGS	SPADES
A	.046	20		60553	60542 065.
B	.043	22		60554	60445
C	.041	24		60555	60500
D	NOT USED			62684	60501

CRIMP	SIZE	TYPE	FEED	PRESS REF.
WIRE	.062	F		
INSULATION	.090	0	.676	
INSULATION RANGE	.048-.078	WIRE RANGE	24-20	APPLICATOR INSTRUCTION # 8039
REMARKS AMPOMATOR				

ECN 0150-0684-04	DATE 11/18/80	WIRE 504	SETUP GAGE 458638-1	LAYOUT NO. 73	AMP INCORPORATED HARRISBURG, PENNA.
ECN 0150-0203-00	DATE 11/18/80	WIRE 3100			
REV PER ECN A-153588		WIRE 1180			
C REV PER ECN		WIRE 240			
B REV PER ECN R-3078		WIRE 6677			
A REV PER ECN R2690		WIRE 1978			
A REV PER ECN		WIRE 1877			
ADD TERM 62684		WIRE 877			

SCALE NONE

MINIATURE QUICK CHANGE APPLICATOR END-FEED (RINGS & SPADES)

CUSTOMER AND ASSEMBLY DRAWING

NO. 466019-1