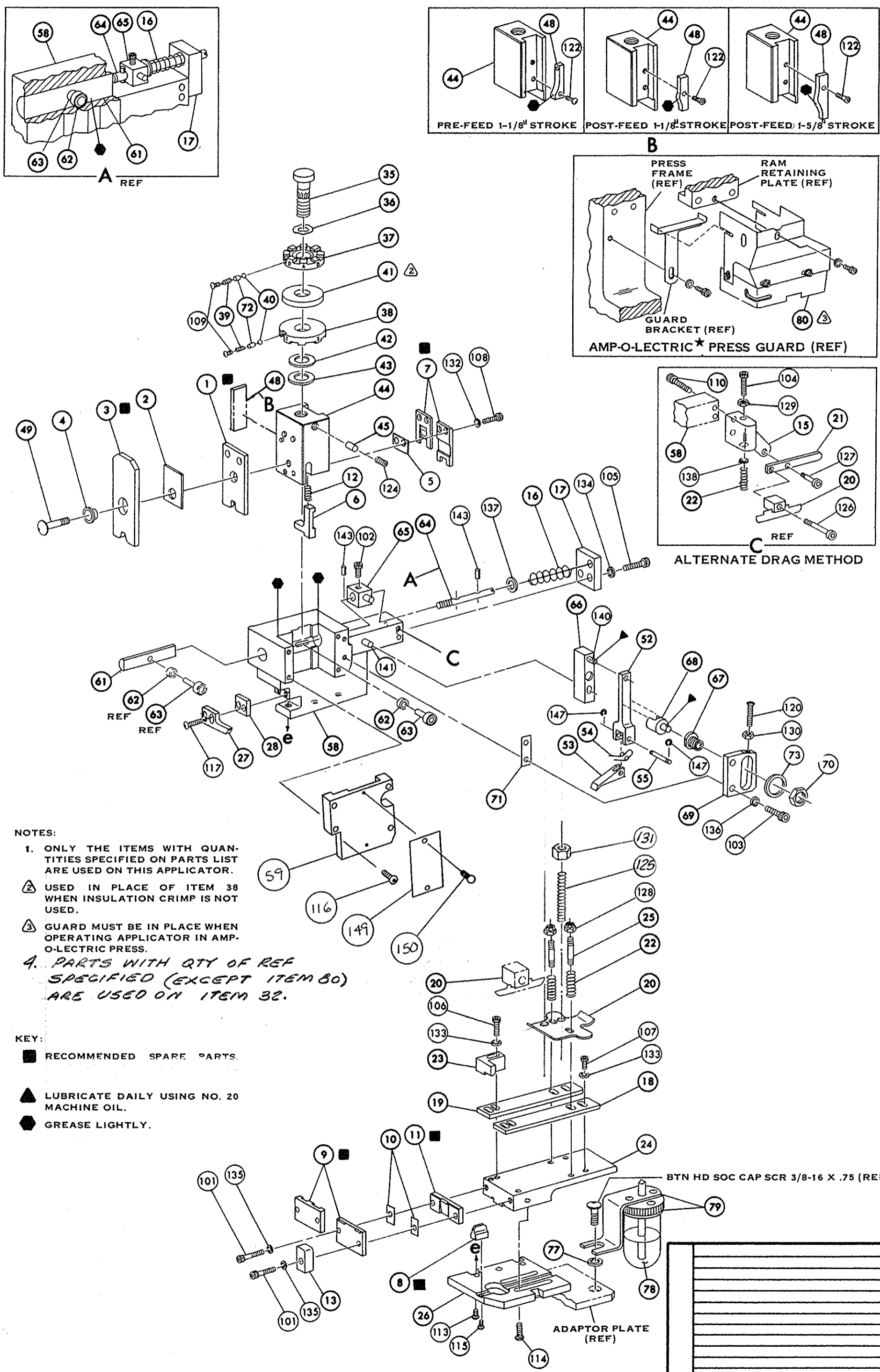


THIS IS A CONTROLLED DOCUMENT.



- 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 |
| 2 | 21017-2 | SCR, DRIVE (#2 x .19) ID PLATE | 150 | REF | 454220-1 | CAP, RAM | 59 |
| 1 | 461264-1 | PLATE, ID | 149 | REF | 453736-1 | HOUSING | 58 |
| | | | 148 | | | | 57 |
| REF | 21045-3 | RING, RETAINING 'C' (.187 DIA) FEED PIN | 147 | | | | 56 |
| | | | 146 | REF | 240624-1 | PIN, FEED FINGER | 55 |
| | | | 145 | REF | 691999-1 | 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 | 690501-3 | CAM, POST 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 | 455679-1 | 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 | | | | 41 |
| 2 | 21024-4 | WASH, LOCK (NO. 8) SHEAR BLADE | 131 | 2 | 23241-6 | BALL, STEEL | 40 |
| 2 | 21018-4 | NUT, HEX MACH (6-32) DRAG SPRING | 130 | 2 | 690170-1 | SPRING, COMPRESSION | 39 |
| REF | 21068-5 | NUT, HEX MACH (6-32) FEED ADJ PLATE | 129 | 1 | 690192-1 | DISC, INSULATION | 38 |
| | | | 128 | 1 | 690141-5 | DISC, WIRE | 37 |
| 2 | 21022-2 | NUT, HEX SELF-LKG (8-32) DRAG STUDS | 127 | 1 | 22480-5 | WASHER, SPRING | 36 |
| | | | 126 | | | | 35 |
| | | | 125 | | | | 34 |
| 2 | 21009-2 | SCR, SKT SET (1/4-20 x 25) NYLOK RAM | 124 | | | | 33 |
| 1 | 21009-2 | SCR, SKT SET (1/4-20 x 25) NYLOK RAM | 123 | 1 | 458980-1 | APPLICATOR, BASIC (SUB ASSY) | 32 |
| | | | 122 | | | | 31 |
| 1 | 2- 21003-0 | SCR, FLAT HD SOC CAP (6-32 x .50) CAM | 121 | | | | 30 |
| | | | 120 | | | | 29 |
| REF | 3- 21064-2 | SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ | 119 | | | | 28 |
| | | | 118 | 1 | 3-690451-2 | SPACER, STRIPPER | 27 |
| | | | 117 | REF | 240639-1 | STRIPPER | 26 |
| 2 | 2-21002-2 | SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER | 116 | 2 | 455676-1 | PLATE, BASE | 25 |
| REF | 2- 21002-9 | SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP | 115 | 2 | 22354-8 | DRAG, STUD | 24 |
| 1 | 22733-8 | SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL | 114 | 1 | 458803-2 | PLATE, STRIP GUIDE | 23 |
| 4 | 3- 21002-3 | SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL | 113 | 1 | 240325-3 | PLATE, STRIP HOLD | 22 |
| REF | 1-24073-9 | SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE | 112 | 2 | 4-22281-1 | SPRING, DRAG | 21 |
| | | | 111 | | 240636-1 | LEVER, DRAG | 20 |
| | | | 110 | 1 | 454177-1 | DRAG, STOCK | 19 |
| | | | 109 | 1 | 454209-1 | GUIDE, STRIP REAR | 18 |
| 2 | 23030-1 | SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC | 108 | REF | 454178-1 | GUIDE, STRIP FRONT | 17 |
| 2 | 2-21000-7 | SCR, SKT HD CAP (8-32 x .50) SHEAR BLADE | 107 | REF | 454178-1 | GUIDE, FEED ROD | 16 |
| 3 | 7-21000-4 | SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE | 106 | REF | 4-22284-9 | SPRING, FEED RETURN | 15 |
| REF | 2-21000-8 | SCR, SKT HD CAP (8-32 x .62) STRIP GUIDE | 105 | | 454665-1 | ADAPTOR, DRAG | 14 |
| REF | 3- 21000-7 | SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE | 104 | | | | 13 |
| | | | 103 | 1 | 690481-7 | SPACER, HOLD DOWN | 12 |
| REF | 3- 21000-6 | SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE | 102 | 1 | 23346-1 | SPRING, HOLD DOWN | 11 |
| REF | 3- 21000-4 | SCR, SKT HD CAP (10-32 x .38) PIVOT BLK | 101 | 1 | 240633-2 | PLATE, REAR SHEAR | 10 |
| 2 | 3- 21000-8 | SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES | 80 | 1 | 690482-3 | SPACER, SHEAR PLATE | 9 |
| REF | 455745-1 | GUARD, WINDOW | 79 | 1 | 6-240693-2 | PLATE, FRONT SHEAR | 8 |
| | | | 78 | 1 | 690479-3 | ANVIL | 7 |
| | | | 77 | 1 | 2455892-1 | BLADE, SLUG | 6 |
| | | | 76 | 1 | 2455892-1 | HOLD DOWN | 5 |
| | | | 75 | 1 | 2240641-0 | SPACER, SHEAR BLADE | 4 |
| | | | 74 | 1 | 238009-1 | SPACER, TUBULAR, INS CRIMPER | 3 |
| | | | 73 | 1 | 3-456135-8 | CRIMPER, INSULATION | 2 |
| REF | 458109-1 | WASHER, FLAT (SPECIAL) | 72 | 1 | 455888-9 | SPACER, INSULATION | 1 |
| 2 | 690603-1 | SPRING, ASSIST | | 1 | 4-456406-5 | CRIMPER, WIRE | |

| CRIMPING DATA | | | | THIS APPLICATOR WILL APPLY | |
|-------------------------|--------------|------------|-------------------|----------------------------|-------|
| PAD LETTER | CRIMP HEIGHT | WIRE SIZE | WIRE STRIP LENGTH | | |
| A | NOT | USED | | 60295 | |
| B | .048 | 18 | | 61091 | |
| C | .044 | 20 | | 61169 | |
| D | .042 | 22 | | | |
| CRIMP | SIZE | TYPE | FEED | PRESS REF. | |
| | .090 | F | | 565935-5 | |
| INSULATION | .140 | 0 | .890 | NO LANCE | |
| INSULATION RANGE | .085-.125 | WIRE RANGE | 22-18 | APPLICATOR INSTRUCTION | #8039 |
| REMARKS | | | | | |
| AMP-O-LECTRIC POST FEED | | | | | |
| FOREIGN 280095 | | | | | |

TERM APPL SPEC 114-2025

| | | | |
|---|--------------------|------|---------|
| J | ECN 0150-0533-03 | DATE | 5-03 |
| H | 0150-7793-97 | DATE | 6-97 |
| G | 0150-6987-96 | DATE | 7-96 |
| F | ECN A-3987-92 | DATE | 10-92 |
| E | ECN A160488 | DATE | 11-88 |
| D | REV PER ECN K-5526 | DATE | 2-84 |
| C | REV PER ECN | DATE | 7-79 |
| B | REV PER | DATE | 5-79 |
| A | ADDED TERM 280095 | DATE | 9/1/78 |
| A | REV PER | DATE | 6-19-78 |

| | | | |
|-------------------------------------|----------|------------|----------|
| SET UP PAGE | 458638-1 | LAYOUT NO. | 253 |
| APPROVED | 1/1/74 | REL. | 1/15-74 |
| CHECKED | 1-11-74 | SCALE | NONE |
| LOC | A | NO. | 687981-2 |
| AMP INCORPORATED HARRISBURG, PENNA. | | | |

MINIATURE QUICK CHANGE APPLICATOR END-FEED (.250 FASTON RECEPT.)

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NO. 687981-2