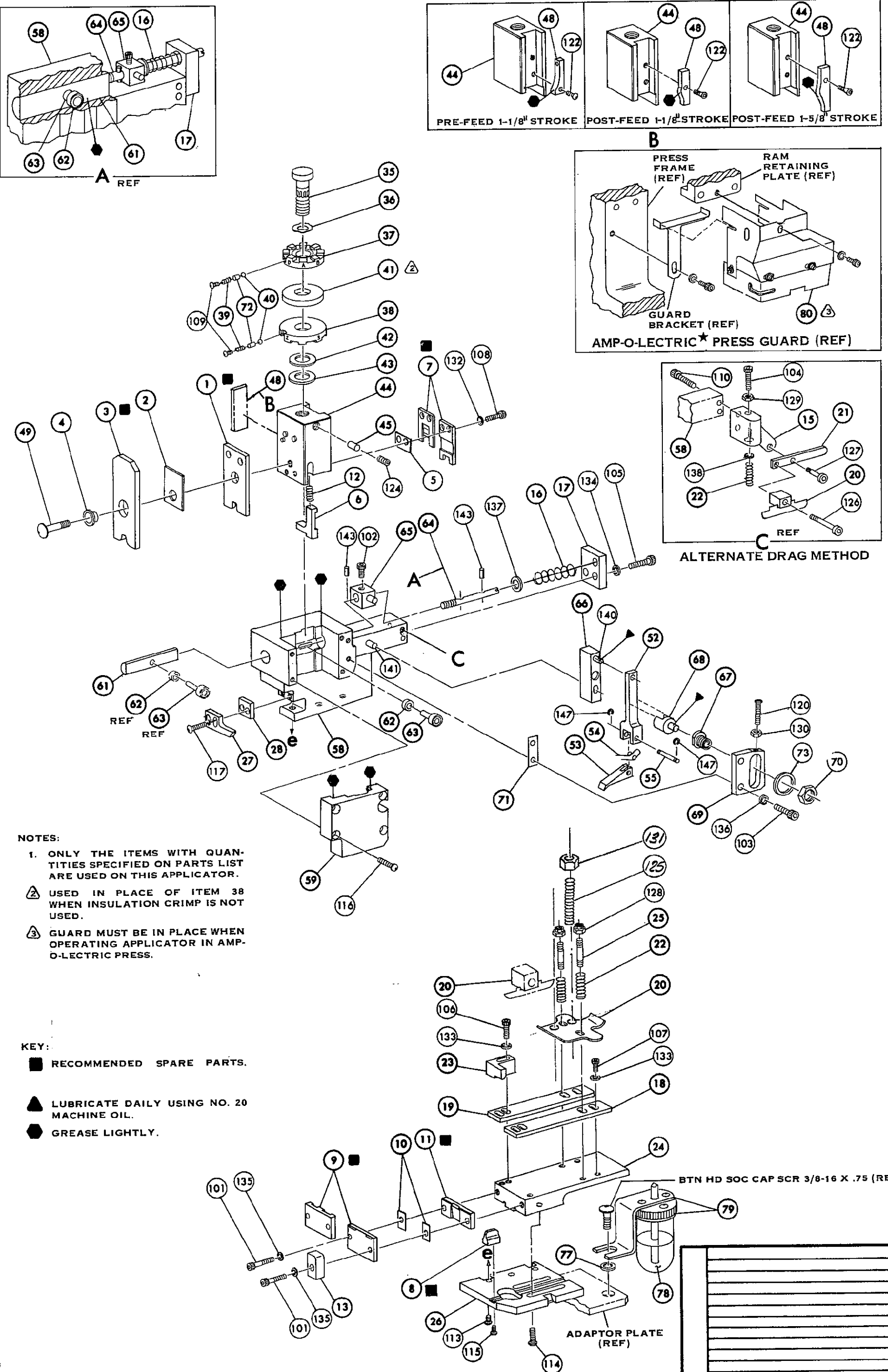


THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INC. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.



- 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.

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

THIS INFORMATION IS CONFIDENTIAL AND IS DISCLOSED TO YOU ON CONDITION THAT NO FURTHER DISCLOSURE IS MADE BY YOU TO OTHER THAN AMP PERSONNEL WITHOUT WRITTEN AUTHORIZATION FROM AMP INCORPORATED, HARRISBURG, PA. DIMENSIONS IN INCHES DO NOT SCALE PRINT.

REQ.	PART NO.	DESCRIPTION	NO.	REQ.	PART NO.	DESCRIPTION	NO.
			162	1	690517-1	SPACER	71
			161	1	22594-8	HEX. NUT	70
			160	1	240628-1	PLATE, ADJ	69
			159	1	240626-1	SHAFT, PIVOT	68
			158	1	240633-1	BUSHING	67
			157	1	455680-1	LEVER, INTERMEDIATE	66
			156	1	240629-1	BLOCK, PIVOT	65
			155	1	240632-2	SCREW, ADJ	64
			154	1	240659-3	PIN, CAM ROLLER	63
			153	1	240658-1	CAM, ROLLER	62
			152	1	454398-1	ROD, FEED	61
			151				60
			150	1	454220-1	CAP, RAM	59
			149	1	453736-1	HOUSING	58
			148				57
			147				56
2	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	146	1	240624-1	PIN, FEED FINGER	55
			145	1	690499-1	SPRING, FEED FINGER	54
			144	1	240635-1	FINGER, FEED	53
2	5- 21028-1	PIN, SLOT SPG (.12 DIA x .50) FEED ADJ ROD	143	1	240634-1	LEVER, TERMINAL	52
			142				51
			141				50
1	1- 21030-7	PIN, DOWEL (.187 DIA x 1.50) HOUSING	140	1	7-21002-9	BOLT, CRIMPER	49
1	1- 21030-1	PIN, DOWEL (.187 DIA x .50) LEVER	139	1	690501-3	CAM, POST FEED 1- 1/8 STROKE	48
			138				47
			137				46
1	21899-4	WASH, FLAT (NO. 6) DRAG SPRING	136	1	690191-1	PLUG, NYLON	45
2	21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE	135	1	455674-1	RAM	44
2	21024-5	WASH, LOCK (NO. 10) SHEAR PLATES	134	1	690125-1	WASHER, LAMINATED	43
2	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			SPACER, DISC	41
2	21024-4	WASH, LOCK (NO. 8) SHEAR BLADE	131	2	23241-6	BALL, STEEL	40
2	21018-4	NUT, HEX MACH (4-90) DRAG	130	2	690170-1	SPRING, COMPRESSION	39
1	21068-5	NUT, HEX MACH (6-32) FEED ADJ PLATE	129	1	690142-1	DISC, INSULATION	38
			128	1	7-690141-8	DISC, WIRE	37
			127	1	22480-5	WASHER, SPRING	36
			126	1	690212-1	POST, RAM	35
			125				34
2	4-21078-8	SCR, SKT SET OVAL PT (4-90 x .75) DRAG	124				33
1	21009-2	SCR, SKT SET (1/4-20 x .25) NYLOK RAM	123				32
			122				31
1	2- 21003-0	SCR, FLAT HD SOC CAP (6-32 x .50) CAM	121				30
			120				29
1	3- 21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ	119	1	3-690451-2	SPACER, STRIPPER	28
			118	1	240639-1	STRIPPER	27
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER	117	1	455676-1	PLATE, BASE	26
4	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	1	240825-4	PLATE, STRIP HOLD	23
3	2-22733-8	SCR, BTN HD SKT CAP (1/4-20 x .62) BASE PLATE	113	2	4-22221-1	SPRING, DRAG	22
			112			LEVER, DRAG	21
			111	1	454177-1	DRAG, STOCK	20
			110	1	454204-3	GUIDE, STRIP REAR	19
2	23030-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC	109	1	454204-3	GUIDE, STRIP FRONT	18
2	2-21000-8	SCR, SKT HD CAP (8-32 x .62) SHEAR BLADE	108	1	454178-1	GUIDE, FEED ROD	17
3	2-21000-6	SCR, SKT HD CAP (8-32 x .38) STRIP GUIDE	107	1	4-22284-9	SPRING, FEED RETURN	16
3	2-21000-9	SCR, SKT HD CAP (8-32 x .75) STRIP GUIDE	106		454665-1	ADAPTOR, DRAG	15
2	3- 21000-7	SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE	105				14
2	3- 21000-9	SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING	104	1	1-690481-0	SPACER, HOLD DOWN	13
2	3- 21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE	103	1	23846-1	SPRING, HOLD DOWN	12
1	3- 21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK	102	1	240694-1	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	80	1	690496-9	PLATE, FRONT SHEAR	9
			79	1	2240693-6	ANVIL	8
			78	1	690474-6	BLADE, SLUG	7
			77	1	1-455882-7	HOLD DOWN	6
			76	1	4-240691-7	SPACER, SHEAR BLADE	5
			75	1	238009-1	SPACER, TUBULAR, INS CRIMPER	4
			74	1	456134-6	CRIMPER, INSULATION	3
			73	1	1-455888-1	SPACER, INSULATION	2
			72	1	1-454045-3	CRIMPER, WIRE	1

CRIMPING DATA				THIS APPLICATOR WILL APPLY	
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	60939	
A	.068	16			
B	.060	18			
C	.056	20			
D	NOT USED				
CRIMP	SIZE	TYPE	FEED	PRESS REF.	
WIRE	.080	F			
INSULATION	.180	F	1.025	565435-5	
INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION # 8039			
.090-.130	20-16	152367			
REMARKS AMP-O-LECTRIC POST FEED  I. D. PLATE (REF): 461264-1					
SET UP GAGE 458638-1		LAYOUT NO.		AMP HARRISBURG, PENNA.	
DRAWN G 0150-6575-06		CHECKED R 2385167-9 3-78		SCALE NONE	
ECN F ECN A16308B		REV ITEM 37 PER ECN R 1847154-1 10/76		NAME MINIATURE QUICK CHANGE APPLICATOR	
REV PER 200 R-3326		REV PER ECN R 1270-24 10/81		END-FEED (FASTIN TAB)	
REV ITEM 27		REV PER ECN			
REV PER ECN		REV PER ECN			
REV PER ECN		REV PER ECN			

NO. 687995-2

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