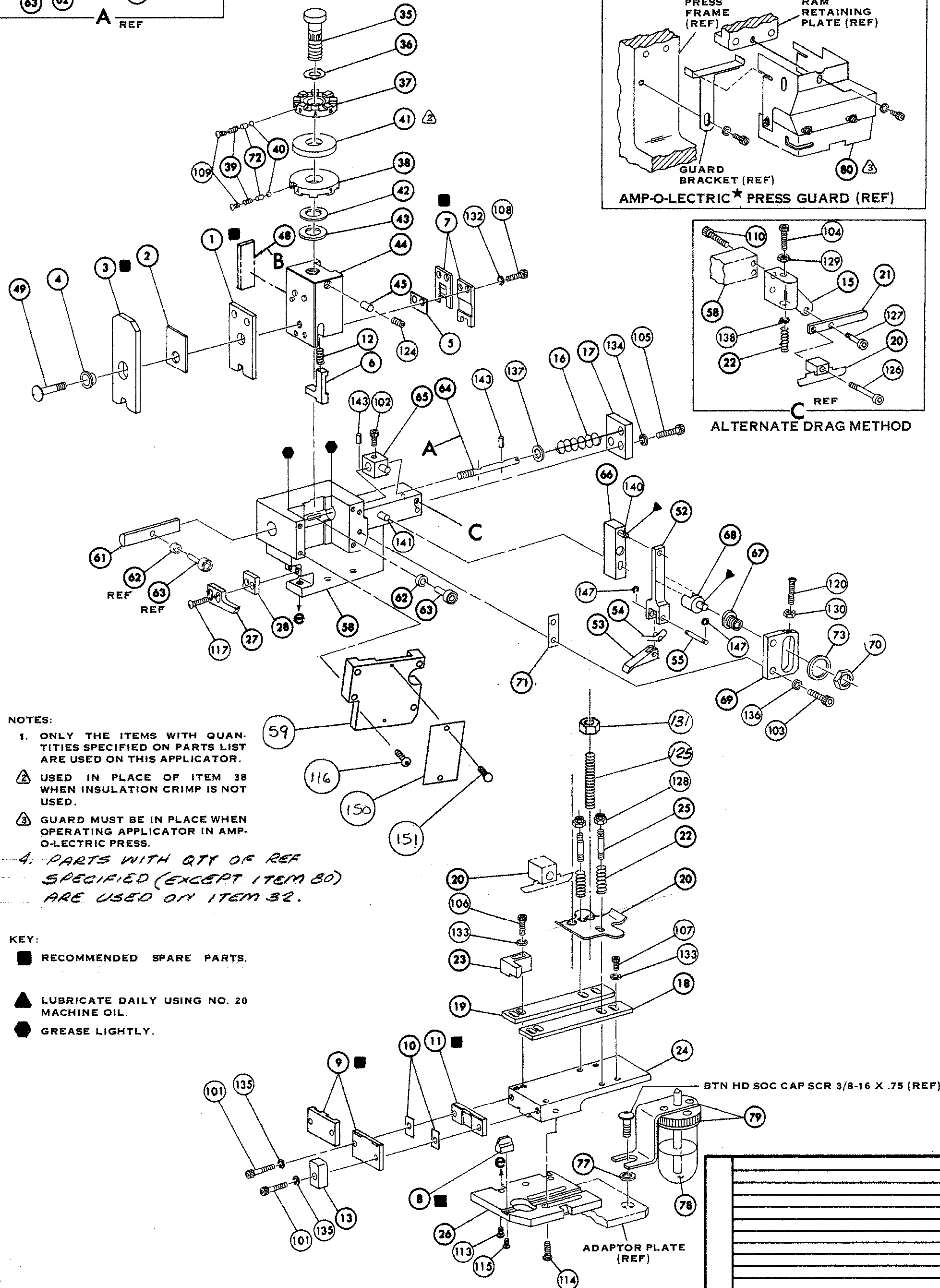
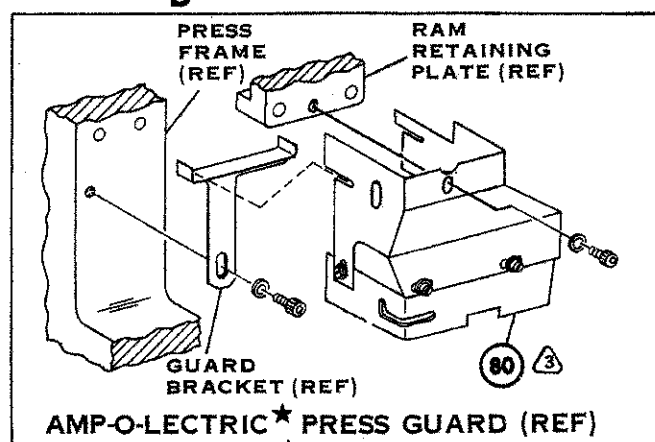
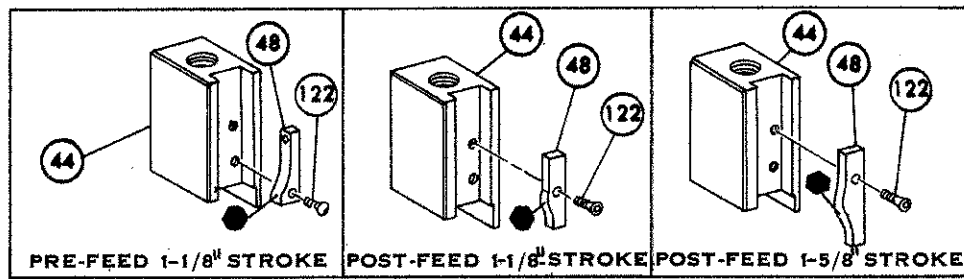
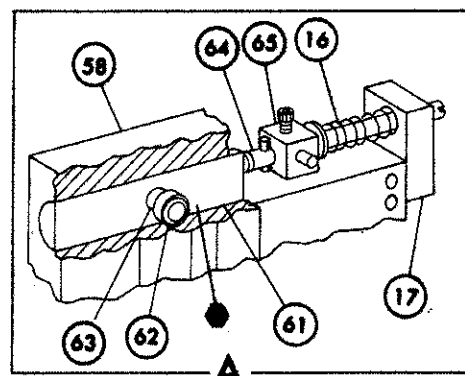


THIS IS A CONTROLLED DOCUMENT.



- 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
1	461264-1	PLATE, ID		149	REF	453736-1	HOUSING
				148			57
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN		147			56
				146	REF	240624-1	PIN, FEED FINGER
				145	REF	691999-1	SPRING, FEED FINGER
				144	REF	840635-1	FINGER, FEED
REF	5- 21028-1	PIN, SLOT SPG (.12 DIA x .50) FEED ADJ ROD		143	REF	240634-1	LEVER, TERMINAL
				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	721002-9	BOLT, CRIMPER
				139	1	690602-5	CAM, PRE FEED 1- 1/8 STROKE
				138			47
				137			46
REF	21899-4	WASH, FLAT (NO. 6) DRAG SPRING		136	1	690191-1	PLUG, NYLON
REF	21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE		135	1	455274-1	RAM
2	21024-5	WASH, LOCK (NO. 10) SHEAR PLATES		134	1	690125-1	WASHER, LAMINATED
REF	21024-5	WASH, LOCK (NO. 10) FEED ROD GUIDE		133	1	690124-1	WASHER, RAM
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
REF	21018-4	NUT, HEX MACH (4-40) DRAG		130	2	690170-1	SPRING, COMPRESSION
REF	21068-5	NUT, HEX MACH (6-32) FEED ADJ PLATE		129	1	690142-1	DISC, INSULATION
				128	1	3692155-2	DISC, WIRE
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUDS		127	1	22480-5	WASHER, SPRING
				126	1	690212-1	POST, RAM
				125			34
2	4-21078-8	SCR, SKT SET OVAL PT. (4-40 x .75) DRAG		124			33
1	21009-2	SCR, SKT SET (1/4-20 x 25) NYLOK RAM		123	1	458980-1	APPLICATOR, BASIC (SUB ASST)
				122			31
1	2- 21003-0	SCR, FLAT HD SOC CAP (6-32 x .50) CAM		121			30
REF	3- 21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ		120			29
				119	1	3-690451-2	SPACER, STRIPPER
				118	1	240639-1	STRIPPER
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER		117	REF	455676-1	PLATE, BASE
REF	2- 21002-9	SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP		116	2	22354-8	DRAG, STUD
1	22733-8	SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL		115	1	455678-1	PLATE, STRIP GUIDE
4	3- 21002-3	SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL		114	1	240825-4	PLATE, STRIP HOLD
REF	1-24075-9	SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE		113	2	4-22281-1	SPRING, DRAG
				112		240636-1	LEVER, DRAG
				111	1	454177-1	DRAG, STOCK
				110	1	454204-1	GUIDE, STRIP REAR
2	23030-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC		109	1	454204-1	GUIDE, STRIP FRONT
2	2-21000-6	SCR, SKT HD CAP (8-32 x .38) SHEAR BLADE		108	REF	454178-1	GUIDE, FEED ROD
3	7-21000-4	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE		107	REF	4-22284-9	SPRING, FEED RETURN
2	7-21000-4	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE		106		454665-1	ADAPTOR, DRAG
REF	3- 21000-7	SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE		105			14
				104	1	690451-3	SPACER, HOLD DOWN
				103	1	23846-1	SPRING, HOLD DOWN
REF	3- 21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE		102	1	240644-1	PLATE, REAR SHEAR
REF	3- 21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK		101			11
2	3- 21000-8	SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES		100			10
REF	455745-1	GUARD, WINDOW		80	1	690458-6	PLATE, FRONT SHEAR
				79	1	4240655-2	ANVIL
				78	1	690774-6	BLADE, SLUG
				77	1	3-455892-6	HOLD DOWN
				76	1	5-240641-8	SPACER, SHEAR BLADE
				75	1	238007-1	SPACER, TUBULAR, INS CRIMPER
				74	1	456135-6	CRIMPER, INSULATION
REF	458109-1	WASHER, FLAT (SPECIAL)		73	1	455888-4	SPACER, INSULATION
2	690603-1	SPRING, ASSIST		72	1	1-456405-5	CRIMPER, WIRE

TERM APPL SPEC 114-2080

CRIMPING DATA

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	THIS APPLICATOR WILL APPLY
A	.068	#16		42101
B	.060	#18		
C	NOT USED			
D	NOT USED			

CRIMP SIZE	TYPE	FEED	PRESS REF.
WIRE .080	F		
INSULATION .140	O	.625	565435-5

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION
.090-.120	18-16	#8039

REMARKS
AMP-O-LECTRIC
PRE FEED

FILED 0150-0042-05	DATE 1-05	BY 11/19/73	SCALE NONE
FILED 0150-0636-03	DATE 11/19/73	BY 11/19/73	SCALE NONE
E 0150-6987-96	DATE 11/23/73	BY 11/23/73	SCALE NONE
D 0150-6703-96	DATE 11/23/73	BY 11/23/73	SCALE NONE
C ECN A160488	DATE 11/23/73	BY 11/23/73	SCALE NONE
B REV PER RD 2-5525	DATE 11/23/73	BY 11/23/73	SCALE NONE
A REV PER ECN	DATE 11/23/73	BY 11/23/73	SCALE NONE

SET UP GAGE 458638-1	LAYOUT NO. 459	AMP INCORPORATED HARRISBURG, PENNA.
DRY 11/19/73	APPROVED 11-27-73	LOC A C NO. 687963-2
CHECKED 11/23/73	REL. 11/27/73	REV. F1

MINIATURE QUICK CHANGE APPLICATOR
END-FEED (PIN RECEPTACLE)

687963-2