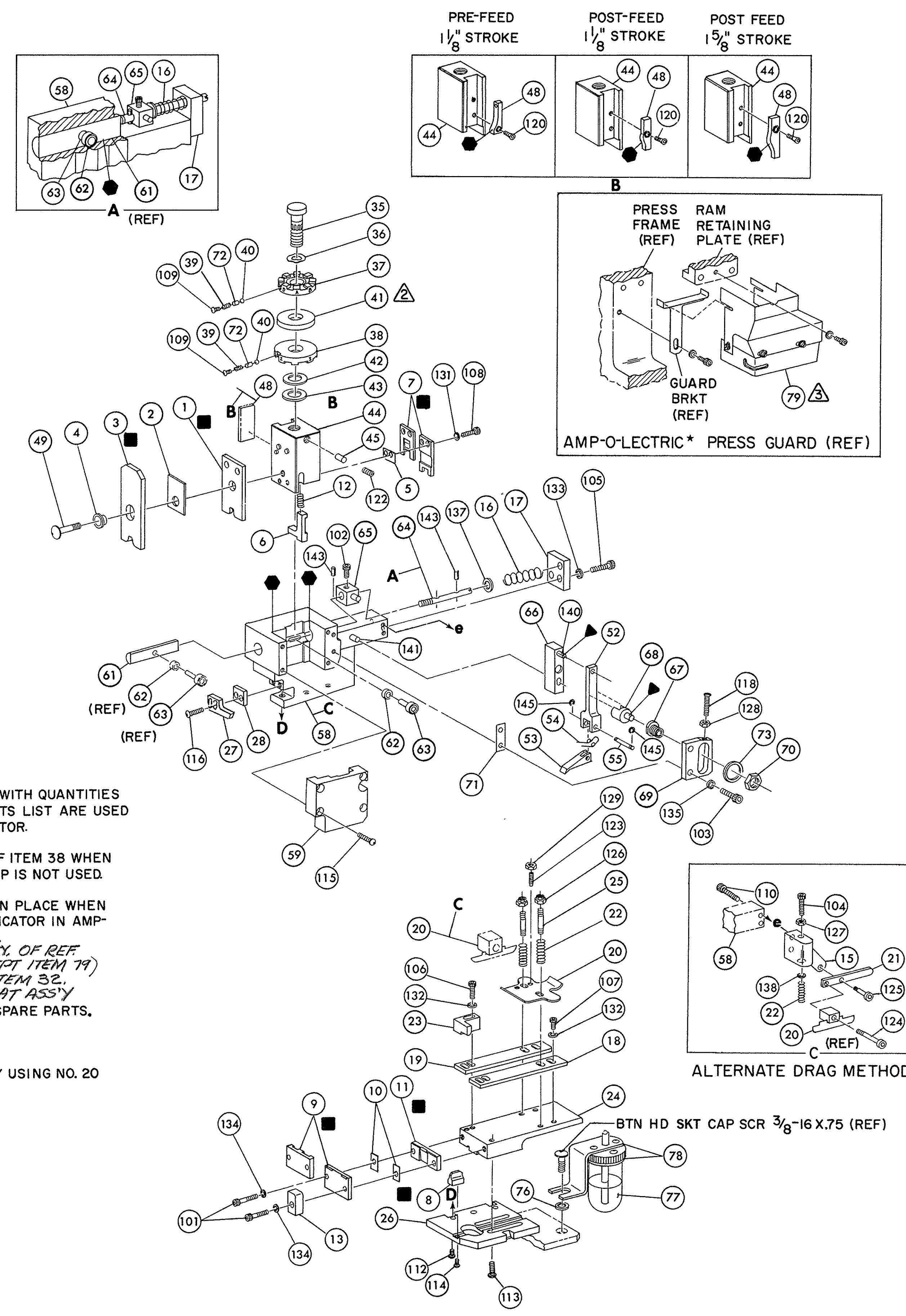


THIS IS A CONTROLLED DOCUMENT.

HAT
FIGURE

REVISION RECORD
DATE
BY
DESCRIPTION

DIST
66



- NOTES:
- 1. 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.
 - 4. ITEMS WITH QTY. OF REF. SPECIFIED (EXCEPT ITEM 79) ARE USED ON ITEM 32. CUT TO LENGTH AT ASSY.
- KEY: ■ RECOMMENDED SPARE PARTS.
- ▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.
 - GREASE LIGHTLY.

ALTERNATE DRAG METHOD

REF.	PART NO	DESCRIPTION	ITEM NO	REF.	PART NO	DESCRIPTION	ITEM NO
REF.	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	145	REF.	454220-1	CAP, RAM	59
REF.	5-21028-1	PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD	143	REF.	453736-1	HOUSING	58
REF.	1-21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	142				57
REF.	1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	141	REF.	240624-1	PIN, FEED FINGER	55
	22260-5	WASHER, FLAT (NO 6) DRAG SPRING	140	REF.	691499-1	SPRING, FEED FINGER	54
REF.	21899-4	WASHER, FLAT (5/16 DIA) SCR ADJ	138	REF.	240635-1	FINGER, FEED	53
			137	REF.	240634-1	LEVER, TERMINAL	52
			136				51
REF.	21024-5	WASHER, LOCK (NO 10) FEED ADJ PLATE	135	1	7-21002-9	BOIT, CRIMPER	50
2	21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	134	1	690602-5	CAM, PRE-FEED 1 1/8 STROKE	48
REF.	21024-5	WASHER, LOCK (NO 10) FEED ROD GUIDE	133				47
4	21024-4	WASHER, LOCK (NO 8) STRIP GUIDE	132				46
2	21024-4	WASHER, LOCK (NO 8) SHEAR BLADE	131	1	690191-1	PLUG, NYLON	45
			130	1	453674-1	RAM	44
2	21018-4	NUT, HEX MACH (4-40) DRAG	129	1	690125-1	WASHER, LAMINATED	43
1	21068-5	NUT, HEX MACH (6-32) FD ADJ PLATE	128	1	690124-1	WASHER, RAM	42
	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	127			SPACER, DISC	41
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	126	2	23241-6	BALL, STEEL	40
	5-21004-7	SCR, SKT HD SHLD (250 DIA X .25) DRAG ARM	125	2	690170-1	SPRING, COMPRESSION	39
	21004-5	SCR, SKT HD SHLD (250 DIA X 1.00) DRAG	124	1	690142-1	DISC, INSULATION	38
2	4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	123	1	9-692155-3	DISC, WIRE	37
1	21009-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	122	1	22480-5	WASHER, SPRING	36
			121	1	690212-1	POST, RAM	35
1	1-21002-7	SCR, BTN HD SKT CAP (6-32 X .38) CAM	120				34
			119				33
REF.	3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	118	/	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
			117				31
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	116				30
REF.	2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	115				29
1	22733-8	SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	114	/	3-690451-2	SPACER, STRIPPER	28
4	3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	113	/	240639-1	STRIPPER	27
REF.	2-22733-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	112	REF.	455676-1	PLATE, BASE	26
			111	2	22354-8	DRAG, STUD	25
	2-21000-4	SCR, SKT HD CAP (6-32 X 1.00) DRAG ADAPTOR	110	1	453678-1	PLATE, STRIP GUIDE	24
2	23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	109			PLATE, STRIP HOLD	23
2	2-21000-8	SCR, SKT HD CAP (8-32 X .56) SHEAR BLADE	108	2	4-22281-1	SPRING, DRAG	22
3	2-21000-6	SCR, SKT HD CAP (8-32 X .38) STRIP GUIDE	107		240636-1	LEVER, DRAG	21
1	2-21000-6	SCR, SKT HD CAP (8-32 X .38) STRIP GUIDE	106	1	454177-1	DRAG, STOCK	20
REF.	3-21000-7	SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE	105	1	1-458030-5	GUIDE, STRIP (REAR)	19
	3-21000-9	SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING	104	1	1-458031-5	GUIDE, STRIP (FRONT)	18
REF.	3-21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	103	REF.	454178-1	GUIDE, FEED ROD	17
REF.	3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	102	REF.	4-22284-9	SPRING, FEED RETURN	16
2	3-21000-8	SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE	101	REF.		ADAPTER, DRAG	15
REF.	455745-1	GUARD, WINDOW	79				14
	465184-9	LUBRICATOR ASSY	78			SPACER, HOLD DOWN	13
	455985-1	OIL, LUBRICATING	77			SPRING, HOLD DOWN	12
	454406-1	SPACER, LUB BRACKET	76	/	240644-1	PLATE, REAR SHEAR	11
			75			SPACER, SHEAR PLATE	10
REF.	458109-1	WASHER, FLAT (SPECIAL)	74	/	690482-8	PLATE, FRONT SHEAR	9
2	690603-1	SPRING, ASSIST	73	1	459866-4	ANVIL	8
REF.	690517-1	SPACER	72	1	2-690474-1	BLADE, SLUG	7
	22594-8	NUT, HEX	71			HOLD DOWN, TERMINAL	6
	240628-1	PLATE, ADJ	70	/	2-240641-9	SPACER, SHEAR BLADE	5
	240626-1	SHAFT, PIVOT	69	/	238009-1	SPACER, TUBULAR	4
	240633-1	BUSHING	68	/	3-456134-6	CRIMPER, INSULATION	3
	455680-1	LEVER, INTERMEDIATE	67	/	1-455888-0	SPACER, INSULATION	2
	240629-1	BLOCK, PIVOT	66	1	456408-9	CRIMPER, WIRE	1
	240632-2	SCREW, ADJ	65				
	240659-3	PIN, CAM ROLLER	64				
	240658-1	CAM, ROLLER	63				
REF.	454398-1	ROD, FEED	62				
			61				
			60				

CRIMPING DATA				APPLICATOR WILL APPLY
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	
A	.076	14 or 14 1/2		60318
B	.073	15		60320
C	.069	16		1217730
D	.065	17 or 18		

CRIMP	SIZE	TYPE	FEED	APPL INST
WIRE	.110	F	.898	A1 8039
INSUL	.155	F		
WIRE RANGE	18-14	INSULATION RANGE	.100-.140	PRESS NO 565435-5
REMARKS	PRE-FEED AMP-O-LECTRIC			
(REF.) I.D. PLATE 461264-1				

REMARKS	NO	REV
APPL USED ON MACHINE PART NO	MACH SERIAL NO	DISTRIBUTION
CUSTOMER NAME	APPL SERIAL NO	ORIGINAL
ADDRESS	PURCHASE ORDER	CUSTOMER COPY
CITY	ENG APP	FIELD ENG COPY

REVISION RECORD	APP DATE	REV	DESCRIPTION

SET UP PAGE 10-1
 458638-1 271
 DR 7-19-77
 ECA 0150-0033-02
 ECA 0150-1100-01
 ECA AIG1988
 REV PER ECA R-5514
 REV ITEM 37 PER RLATZ
 8-02
 1-01
 10-01
 11-80
 12-84
 4-78

AMP INCORPORATED
 Harrisburg, Pa.

NAME: _____
 NO: 466691-2
 REV: D2
 MINIATURE QUICK CHANGE APPLICATOR
 END FEED (AMPLINAR RING)

CUSTOMER AND ASSEMBLY DRAWING