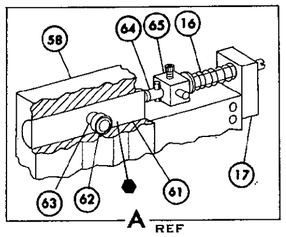
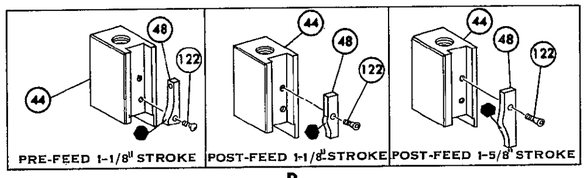
THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INC. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.



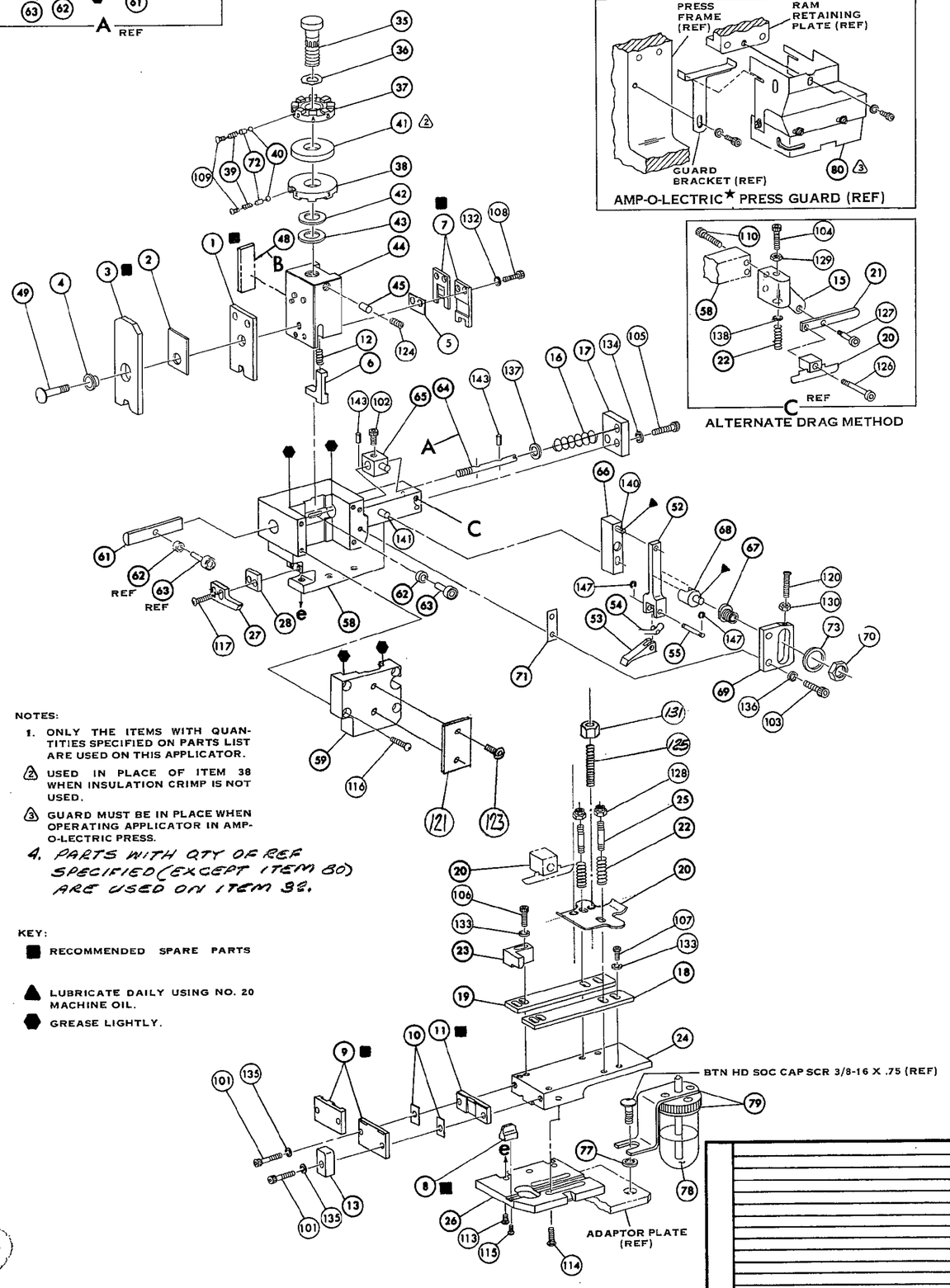
A REF



B

AMP-O-LECTRIC★ PRESS GUARD (REF)

C
ALTERNATE DRAG METHOD



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.
4. PARTS WITH QTY OF REF SPECIFIED (EXCEPT ITEM 80) ARE USED ON ITEM 38.

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

DIMENSIONS IN INCHES DO NOT SCALE PRINT

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.

REQ.	PART NO.	DESCRIPTION	NO.
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	147
REF	5- 21028-1	PIN, SLOT SPG (.12 DIA x .50) FEED ADJ ROD	143
REF	1- 21030-7	PIN, DOWEL (.187 DIA x 1.50) HOUSING	141
REF	1- 21030-1	PIN, DOWEL (.187 DIA x .50) LEVER	140
—	22260-5	WASH, FLAT (NO. 6) DRAG SPRING	138
REF	21899-4	WASH, FLAT (NO. 5/16 DIA) SCR ADJ	137
REF	21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE	136
2	21024-5	WASH, LOCK (NO. 10) SHEAR PLATES	135
REF	21024-5	WASH, LOCK (NO. 10) FEED ROD GUIDE	134
5	21024-4	WASH, LOCK (NO. 8) STRIP GUIDE	133
2	21024-4	WASH, LOCK (NO. 8) SHEAR BLADE	132
2	21018-4	NUT, HEX MACH (4-40) DRAG	131
REF	21018-5	NUT, HEX MACH (6-32) FEED ADJ PLATE	130
—	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	129
8	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUDS	128
—	5- 21004-7	SCR, SKT HD SHLD (.250 DIA x .25) DRAG ARM	127
—	21004-5	SCR, SKT HD SHLD (.250 DIA x 1.00) DRAG	126
2	4-21078-8	SCR, SKT SET OVAL PT. (4-40 x .75) DRAG	125
1	21009-2	SCR, SKT SET (1/4-20 x 25) NYLOK RAM	124
2	21017-2	SCR, DRIVE #2 x .19	123
1	1-21002-7	SCR, BUT HD SOC CAP (6-32 x .38) CAM	122
1	46264-1	PLATE, IDENTIFICATION	121
REF	6-23715-5	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ	120
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER	117
REF	2- 21002-9	SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP	116
1	22733-8	SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL	115
4	3- 21002-3	SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL	114
REF	17177-1	SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE	113
—	2- 21000-4	SCR, SKT HD CAP (6-32 x 1.00) DRAG ADAPTOR	110
2	23030-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC	109
2	2-21000-7	SCR, SKT HD CAP (8-32 x .50) SHEAR BLADE	108
3	2-21000-6	SCR, SKT HD CAP (8-32 x .38) STRIP GUIDE	107
2	2-21000-8	SCR, SKT HD CAP (8-32 x .75) STRIP GUIDE	106
REF	3- 21000-7	SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE	105
—	3- 21000-9	SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING	104
REF	3- 21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE	103
REF	3- 21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK	102
2	3- 21000-8	SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES	101
REF	455745-1	GUARD, WINDOW 3	80
—	465184-9	LUBRICATOR ASSY	79
—	22014-1	OIL SYNTHETIC	78
—	454406-1	SPACER, LUBRICATOR BRACKET	77
REF	458109-1	WASHER, FLAT (SPECIAL)	73
2	690603-1	SPRING, ASSIST	72

NO.	REQ.	PART NO.	DESCRIPTION	NO.
162	REF	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	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	240634-3	LEVER, TERMINAL	52
142				51
141				50
140	1	7-21008-9	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			SPACER, DISC	41
131	2	23241-6	BALL, STEEL	40
130	2	690170-1	SPRING, COMPRESSION	39
129	1	690142-1	DISC, INSULATION	38
128	1	3-690141-2	DISC, WIRE	37
127	1	22480-5	WASHER, SPRING	36
126	1	690212-1	POST, RAM	35
125				34
124				33
123	1	458980-2	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	22359-8	DRAG, STUD	25
115	1	458803-2	PLATE, STRIP GUIDE	24
114	1	240825-4	PLATE, STRIP HOLD	23
113	2	4-22281-1	SPRING, DRAG	22
112	—	240636-1	LEVER, DRAG	21
111	1	454177-1	DRAG, STOCK	20
110	1	454204-3	GUIDE, STRIP REAR	19
109	1	454204-3	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	1	690481-2	SPACER, HOLD DOWN	13
103	1	23846-1	SPRING, HOLD DOWN	12
102	1	240833-2	PLATE, REAR SHEAR	11
101			SPACER, SHEAR PLATE	10
80	1	690482-6	PLATE, FRONT SHEAR	9
79	1	2-690698-6	ANVIL	8
78	1	2-690474-5	BLADE, SLUG	7
77	1	455892-9	HOLD DOWN	6
76	1	5-240641-2	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	1-46405-3	CRIMPER, WIRE	1

CRIMPING DATA

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.060	16	
B	.052	18	
C	.047	20	
D	NOT	USED	

	SIZE	TYPE	FEED	PRESS REF.
CRIMP				
WIRE	.080	F		
INSULATION	.180	F	.810	

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION
.090-.130	20-16	AI 8039

REMARKS: AMPOMATOR

THIS APPLICATOR WILL APPLY: 60435, 640296, 152368

LTR	REVISION RECORD	ECN	DR	CK	DATE
F	DISD - 6575-96		TD		1/96
E	ECN R-6185		MWC		4-94
D	REV PER ECN R-5526		TM		2/84
C	REV ITEM 37 PER ECN	R 2416	LM		3-78
B1	ADDED 640296	R 1885	MP		12-76
B	REVISED C.H.	R 899	LM		12-76
A	REV PER ECN	R 388	LM		3-12-74

SET UP GAGE 458638-1 | LAYOUT NO. 71 | SCALE NONE

DRAWN [illegible] 1/18/74 | CHECKED [illegible] 1-22-74 | APPROVED Ben Hawk 1-22-74 | REL. 1-22-74 M L Woodward

AMP INCORPORATED HARRISBURG, PENNA.

LOC A C | NO. 687993-1 | REV. F

NAME MINIATURE QUICK CHANGE APPLICATOR END-FEED (.187 FASTIN FASTON)

PRINT 10

*TRADE MARK OF AMP INCORPORATED

AMP 3076-1

687993-1