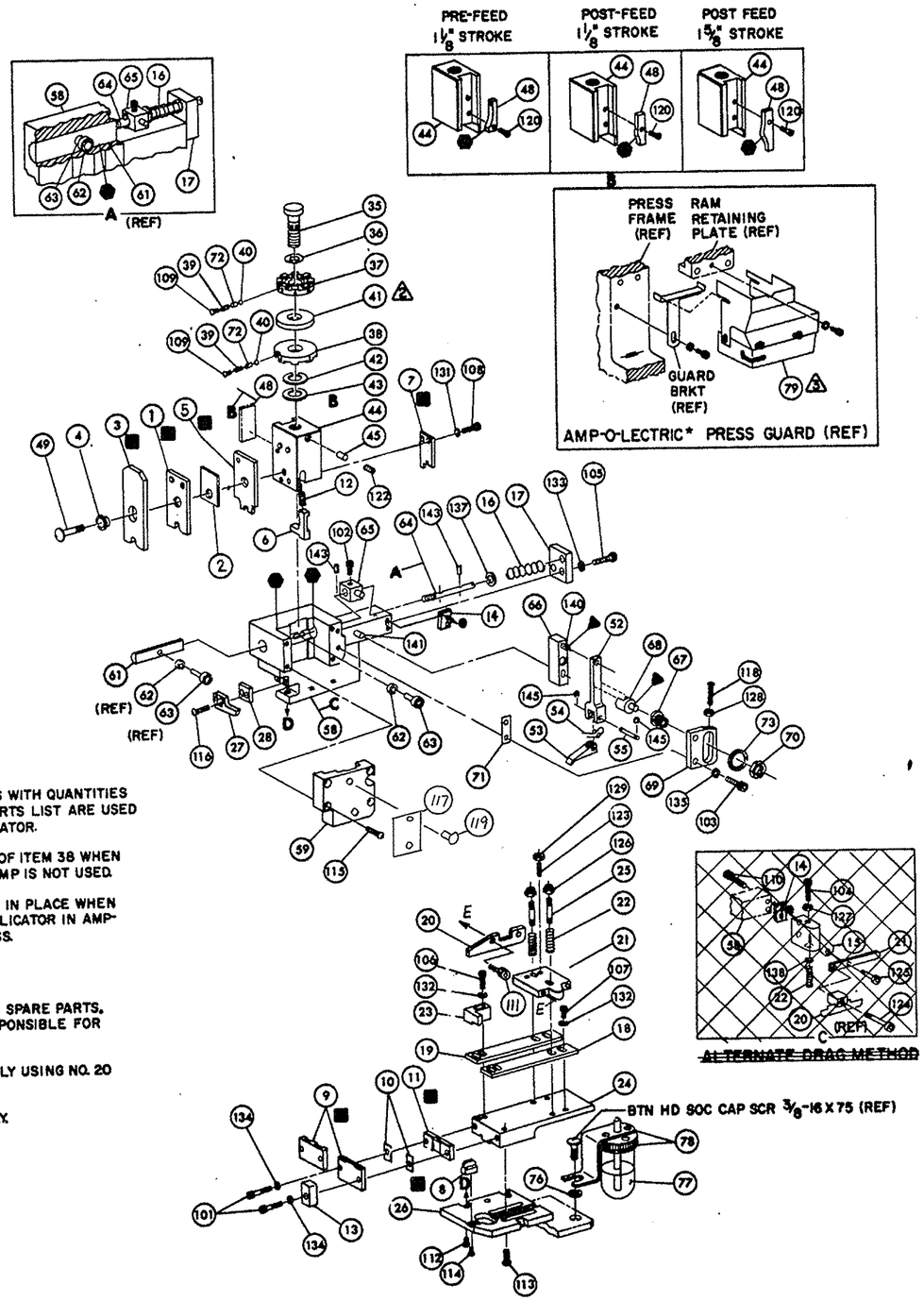
THIS IS A CONTROLLED DOCUMENT.



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. CUSTOMER RESPONSIBLE FOR REPLACEMENT.

▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.

⬢ GREASE LIGHTLY.

QTY	PART NO	DESCRIPTION	ITEM NO
2	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	145
			144
2	5-21023-1	PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD	143
			142
1	1-21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	141
1	1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	140
			139
—	22260-5	WASHER, FLAT (NO 6) DRAG SPRING	138
1	21899-4	WASHER, FLAT (5/16 DIA) SCR ADJ	137
			136
2	21024-5	WASHER, LOCK (NO 10) FEED ADJ PLATE	135
2	21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	134
2	21024-5	WASHER, LOCK (NO 10) FEED ROD GUIDE	133
4	21024-4	WASHER, LOCK (NO 8) STRIP GUIDE	132
2	21024-4	WASHER, LOCK (NO 8) SHEAR BLADE	131
			130
2	21018-4	NUT, HEX MACH (4-40) DRAG	129
1	21068-5	NUT, HEX MACH (6-32) FD ADJ PLATE	128
—	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	127
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	126
—	5-21004-7	SCR, SKT HD SHLD (.250 DIA X .25) DRAG ARM	125
—	21004-5	SCR, SKT HD SHLD (.250 DIA X 1.00) DRAG	124
2	4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	123
1	22651-9	SCR, SKT SET (1/4-20 X .25) (LOC-WEL) RAM	122
			121
1	2-21003-0	SCR, FLAT HD SKT CAP (6-32 X .50) CAM	120
2	21017-2	SCR, DR (#2 X .19) ID PLATE	119
1	3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	118
1	461264-1	PLATE, ID	117
2	2-21002-3	SCR, BTN HD SKT CAP (8-32 X .62) STRIPPER	116
4	2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	115
1	24073-2	SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	114
4	3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	113
3	1-24073-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	112
2	1-21000-3	SCR, SKT HD CAP (4-40 X .25) DRAG	111
—	2-21000-4	SCR, SKT HD CAP (6-32 X 1.00) DRAG ADAPTOR	110
2	3-23657-8	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	109
2	2-21000-6	SCR, SKT HD CAP (8-32 X .38) SHEAR BLADE	108
3	2-21000-6	SCR, SKT HD CAP (8-32 X .38) STRIP GUIDE	107
1	2-21000-6	SCR, SKT HD CAP (8-32 X .38) STRIP GUIDE	106
2	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
2	3-21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	103
1	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 PLATE	101
REF	455745-1	GUARD, WINDOW	79
—	465184-9	LUBRICATOR ASSY	78
—	455985-1	OIL, LUBRICATING	77
—	454406-1	SPACER, LUB BRACKET	76
			75
			74
1	458109-1	WASHER, FLAT (SPECIAL)	73
2	690603-1	SPRING, ASSIST	72
1	690517-1	SPACER	71
1	22594-8	NUT, HEX	70
1	240628-1	PLATE, ADJ	69
1	240626-1	SHAFT, PIVOT	68
1	240633-1	BUSHING	67
1	455680-1	LEVER, INTERMEDIATE	66
1	240629-1	BLOCK, PIVOT	65
1	240632-2	SCREW, ADJ	64
1	240659-3	PIN, CAM ROLLER	63
1	240658-1	CAM, ROLLER	62
1	454398-1	ROD, FEED	61
			60

QTY	PART NO	DESCRIPTION	ITEM NO
1	454220-1	CAP, RAM	59
1	453736-2	HOUSING	58
			57
			56
			55
1	240624-1	PIN, FEED FINGER	54
1	691499-1	SPRING, FEED FINGER	53
1	694921-8	FINGER, FEED	52
1	240634-1	LEVER, TERMINAL	51
			50
			49
1	690686-1	BOLT, CRIMPER	48
1	690501-4	CAM, POST FEED 1 5/8 STROKE	47
			46
			45
1	690191-1	PLUG, NYLON	44
1	455674-5	RAM	43
1	690125-1	WASHER, LAMINATED	42
1	690124-1	WASHER, RAM	41
		SPACER, DISC	40
2	23241-6	BALL, STEEL	39
2	690170-1	SPRING, COMPRESSION	38
1	690142-1	DISC, INSULATION	37
1	5-692155-1	DISC, WIRE	36
1	22480-5	WASHER, SPRING	35
1	690212-1	POST, RAM	34
			33
			32
—	458980-	APPLICATOR, BASIC (SUB ASSY)	31
			30
			29
1	3-690451-0	SPACER, STRIPPER	28
1	240639-2	STRIPPER	27
1	455676-1	PLATE, BASE	26
2	22354-8	DRAG, STUD	25
1	455678-1	PLATE, STRIP GUIDE	24
		PLATE, STRIP HOLD	23
2	23470-5	SPRING, DRAG	22
1	464451-4	ARM, STOCK DRAG	21
1	464452-2	DRAG, STOCK	20
1	3-458030-9	GUIDE, STRIP (REAR)	19
1	3-458031-9	GUIDE, STRIP (FRONT)	18
1	454178-1	GUIDE, FEED ROD	17
1	4-22284-9	SPRING, FEED RETURN	16
—	454665-4	ADAPTER, DRAG	15
—	464524-1	SPACER, DRAG ADAPTER	14
		SPACER, HOLD DOWN	13
		SPRING, HOLD DOWN	12
1	453654-1	PLATE, REAR SHEAR ■	11
2	2-240645-0	SPACER, SHEAR PLATE	10
1	453653-1	PLATE, FRONT SHEAR ■	9
1	453670-4	ANVIL ■	8
1	453656-1	BLADE, SLUG, REAR ■	7
		HOLD DOWN, TERMINAL	6
1	684917-2	, SHEAR BLADE, FRONT ■	5
1	238009-1	SPACER, TUBULAR	4
1	3-456135-1	CRIMPER, INSULATION ■	3
1	1-455888-2	SPACER, INSULATION	2
1	2-456402-6	CRIMPER, WIRE ■	1

CRIMPING DATA				APPLICATOR WILL APPLY
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	61323
A	.041	20		
B	.038	(1)22 OR (2)24		
C	.034	24		
D	NOT	USED		

CRIMP	SIZE	TYPE	FEED	APPL INST
WIRE	.055	F	.535	A18039
INSUL	.110	O		

WIRE RANGE 24 - 20 | INSULATION RANGE .040 - .100 | PRESS NO

REMARKS: AMPOMATOR, LEADMAKER, BENCH G

REMARKS	NO	REV
	TO APPLY TERMINAL	
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

P F	LTR	REVISION RECORD	APP	DATE
F	0150-0062-03		CE	1-03
E	0150-1530-02	ACTIVATE	OCTO	12-02
D	DAS PER R-291631			2-91
C	REV PER R-5037			4-83
B	REV. PER ECN R4265			
A	REV. PER ECN R-3624			2-77
	REV. PER ECN R2029			
	REV PER ECN R1806			

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AMP INCORPORATED Harrisburg, Pa.

LOC A | NO 466295-1 | REV F

NAME MINIATURE QUICK CHANGE APPLICATOR END FEED (RIGHT ANGLE PIN RECPT.)

CUSTOMER AND ASSEMBLY DRAWING

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