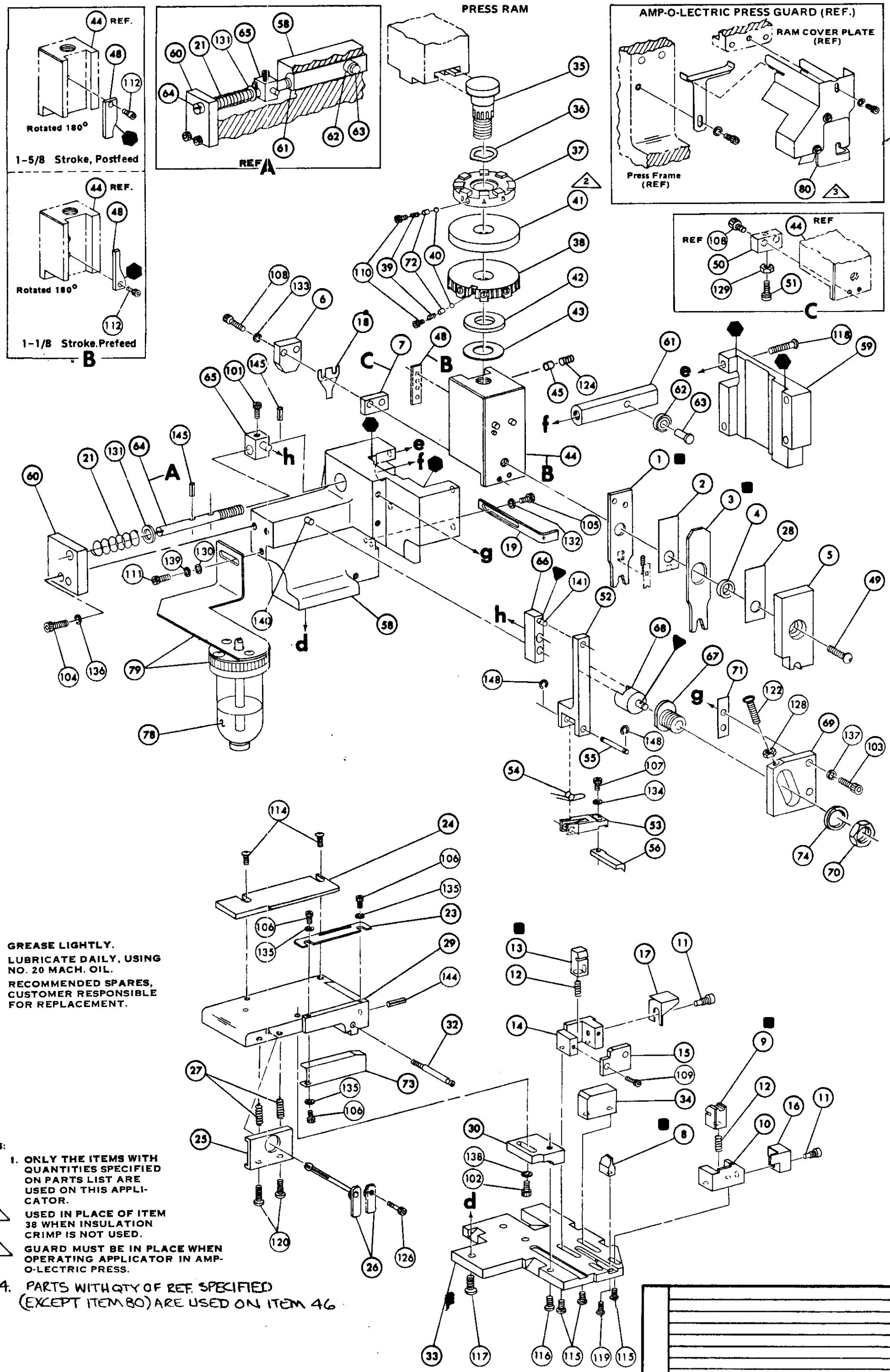


THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INC. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.



KEY:
 ● GREASE LIGHTLY.
 ● LUBRICATE DAILY, USING NO. 20 MACH. OIL.
 ■ RECOMMENDED SPARES, CUSTOMER RESPONSIBLE FOR REPLACEMENT.

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 46.

REF	PART NO.	DESCRIPTION	NO.	REF	PART NO.	DESCRIPTION	NO.
	162			REF	690517-1	SPACER	71
	161				22594-8	NUT, HEX	70
	160				240628-1	PLATE, ADJUSTMENT	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, ADJUSTMENT, FEED ROD	64
	154				240659-3	PIN, CAM ROLLER	63
	153				240658-1	ROLLER, CAM	62
	152				454398-2	ROD, FEED	61
	151				454178-1	GUIDE, FEED ROD	60
	150				454220-1	CAP, HOUSING	59
	149			REF	454485-1	HOUSING	58
REF	21045-3	RING, RETNG "C" (.187 DIA) FEED FINGER PIN	148				57
	147			1	690542-2	PAWL, FEED	56
	146			REF	240624-1	PIN, FEED FINGER	55
REF	5- 21028-1	PIN, SLTD SPRING (.125 DIA x .50) ADJ ROD	145	REF	691499-1	SPRING, FEED FINGER	54
1	4- 21028-0	PIN, SLTD SPRING (.093 DIA x .75) S. G. PL	144	REF	690541-1	FINGER, FEED	53
	143			REF	455679-1	LEVER, TERMINAL FEED ARM	52
	142			1	811242-2	BUMPER, HOLLOW	51
REF	1- 21030-1	PIN, DOWEL (.187 DIA x .50) LEVER	141	1	690753-1	SPACER, TONKOR	50
REF	1- 21030-6	PIN, DOWEL (.187 DIA x 1.25) HOUSING	140	1	7-21002-2	BOLT, CRIMPER	49
1	21024-5	WASHER, LOCK (NO. 10) LUB ASSY	139	1	690602-5	CAMP RE-FEED 1/8 STROKE	48
1	21024-5	WASHER, LOCK (NO. 10) STRIP GUIDE ADJ BLK	138				47
REF	21024-5	WASHER, LOCK (NO. 10) ADJ PLATE	137	1	459456-1	APPL BASIC SUB ASSY	46
REF	21024-5	WASHER, LOCK (NO. 10) FEED GUIDE ROD	136	1	690191-1	PLUG, NYLON	45
3	21057-2	WASHER, LOCK (NO. 4) FRONT STRIP GUIDE	135	1	455673-1	RAM	44
1	21024-4	WASHER, LOCK (NO. 8) FEED FINGER	134	1	690125-1	WASHER, LAMINATED	43
Z	21024-4	WASHER, LOCK (NO. 8) DEPRESSOR	133	1	690124-1	WASHER, RAM	42
1	21024-4	WASHER, LOCK (NO. 8) STRIPPER	132				41
REF	21899-4	WASHER, FLAT (5/16 DIA) SCREW ADJ	131	Z	23241-6	BALL, STEEL	40
1	21899-2	WASHER, FLAT (NO. 10) LUB ASSY	130	Z	690170-1	SPRING, COMPRESSION	39
1	21068-5	NUT, HEX MACH (6-32) HOLLOWDOWN	129	1	690147-1	DISC, INSULATION	38
REF	21068-5	NUT, HEX MACH (6-32) FEED ADJ	128	1	6-670692-3	DISC, WIRE	37
	127			1	22480-5	WASHER, SPRING	36
	126			1	690212-1	POST, RAM	35
	125			1	690786-6	SUPPORT, TERMINAL	34
1	21009-2	SCREW, SKT SET (1/4-20 x .25) (NYLOK) RAM	124	REF	455675-1	PLATE, BASE	33
	123			1	690432-3	SCREW, ADJUSTMENT	32
REF	3- 21064-2	SCREW, RD HD MACH (6-32 x 1.50) FEED ADJ	122				31
	121			REF	455689-1	BLOCK, STRIP GUIDE ADJ	30
2	2- 21002-9	SCREW, BTN HD SKT CAP (10-32 x .75) DRAG	120	1	455661-1	PLATE, STRIP GUIDE	29
1	22733-8	SCREW, BTN HD SKT CAP (8-32 x .38) ANVIL	119	1	1-455888-0	SPACER, F. SHEAR DEPRESSOR	28
REF	2- 21002-9	SCREW, BTN HD SKT CAP (10-32 x .75) CAP	118	2	1-22284-0	SPRING, DRAG	27
REF	1- 24073-9	SCREW, BTN HD SKT CAP (NYLOK) 1/4-20 x .75 HSG	117	1	690546-1	LEVER, DRAG RELEASE	26
REF	2- 21002-7	SCREW, BTN HD SKT CAP (10-32 x .50) S.G. ADJ BLK	116	1	240192-1	DRAG, STOCK	25
4	2- 21002-2	SCREW, BTN HD SKT CAP (8-32 x .50) SHEAR	115	1	690504-1	GUIDE, STRIP REAR	24
2	2- 21002-2	SCREW, BTN HD SKT CAP (8-32 x .50) R. S. G.	114	1	690438-1	GUIDE, STRIP FRONT	23
	113						22
1	2- 21003-0	SCREW, FLAT HD SKT CAP (6-32 x .50) CAM	112	REF	4- 22284-9	SPRING, FEED RETURN	21
1	3- 21000-4	SCREW, SKT HD CAP (10-32 x .38) LUB ASSY	111				20
2	23030-1	SCREW, SKT HD CAP (6-32 x .25) (NYLOK) C.P. DISC	110	1	690472-1	STRIPPER	19
	109						18
2	2- 21000-8	SCREW, SKT HD CAP (8-32 x .62) DEPRESSOR	108				17
1	2- 21000-8	SCREW, HEX HD CAP (8-32 x .31) FEED FINGER	107	1	691667-1	GUARD, CHIP REAR	16
3	1- 21000-3	SCREW, SKT HD CAP (4-40 x .25) F. STRIP GUIDE	106				15
1	2- 21000-7	SCREW, SKT HD CAP (8-32 x .50) STRIPPER	105				14
REF	3- 21000-7	SCREW, SKT HD CAP (10-32 x .75) FEED ROD G.	104				13
REF	3- 21000-6	SCREW, SKT HD CAP (10-32 x .62) FEED ADJ BLK	103	1	5- 22280-0	SPRING, SHEAR	12
1	3- 21000-4	SCREW, SKT HD CAP (10-32 x .38) S.G. ADJ BLK	102	1	690461-1	STOP, SHEAR	11
REF	3- 21000-4	SCREW, SKT HD CAP (10-32 x .38) PIVOT BLOCK	101	1	690459-1	HOLDER, SHEAR FRONT	10
REF	455749-1	GUARD ASSY (WINDOW)	80	1	454276-1	SHEAR, FLOAT FRONT	9
1	1-465184-0	LUBRICATOR ASSY	79	1	1-458834-0	ANVIL	8
REF	8529312	OIL SYNTHETIC	78	1	240641-5	SPACER, DEPRESSOR REAR	7
	77						6
	76			1	1-455689-4	DEPRESSOR, SHEAR REAR	5
	75			1	238011-4	SPACER, TUBULAR, INS CRIMPER	4
REF	458109-1	WASHER, FLAT, SPECIAL	74	1	1-456135-7	CRIMPER, INSULATION	3
1	454877-3	PLATE, STRIP GUIDE COVER	73	1	455888-3	SPACER, CRIMPER	2
2	690603-1	SPRING, ASSIST	72	1	4-456406-3	CRIMPER, WIRE	1

CRIMPING DATA				THIS APPLICATOR WILL APPLY	
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	SCC	PIN
A	.068	# 14		66578	66577
B	.059	# 16		66651	66650
C	.052	# 18			
D	NOT USED				

CRIMP	SIZE	TYPE	FEED	USED ON
WIRE	.090	F		MACH NO.
INSULATION	.120	0	.500	565435-5

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION
.080-.105	18-14	8c40

REMARKS: AMP-O-LECTRIC PRE-FEED

H	0150-6987-96	REV 1	7-96
G	EQ-A-272390	REV 1	10-96
F	K-N-160588	REV 1	11-86
E3	REV PER ECN	R 3111	11-79
E2	ADD BY 461752-2	R 2201	7-79
E1	ADD BY 66680, 66651	R 2411	8-78
D	REV ITEM 37	R 1234	11-78
C	REV PER ECN	R 1525	10-76
B	REV PER ECN	R 1423	11-75
A	REV PER ECN	R 1270	11-75
01	ADDED ITEM 66551 PER ECN	R 1691	11-74

I. D. PLATE (REF): 461264-1

SET UP PAGE	LAYOUT NO.	AMP INCORPORATED
458637-1	679	HARRISBURG, PENNA.
DRAWN	APPROVED	LOC
BAW/EE	Ken	A
CHECKED	REL	NO.
10-31-77	11-77	C
		687997-2
		H

SCALE NONE

APPLICATOR MINIATURE QUICK CHANGE SIDE-FEED (TYPE II .062 DIA. PIN & SCC.)

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