



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 REF (EXCEPT ITEM 79) ARE USED ON ITEM 32.
- CUT TO LENGTH AT ASS'Y.

KEY:

- RECOMMENDED SPARE PARTS.
- LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- GREASE LIGHTLY.

REF	QTY	PART NO	DESCRIPTION	ITEM NO	REF	QTY	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	144	REF	453736-1	HOUSING	58	
REF		1-21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	143				57	
REF		1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	142				56	
		22260-5	WASHER, FLAT (NO 6) DRAG SPRING	141	REF	240624-1	PIN, FEED FINGER	55	
REF		21899-4	WASHER, FLAT (5/16 DIA) SCR ADJ	140	REF	691499-1	SPRING, FEED FINGER	54	
		21024-5	WASHER, LOCK (NO 10) FEED ADJ PLATE	139	REF	240635-1	FINGER, FEED	53	
REF		21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	138	REF	240634-3	LEVER, TERMINAL	52	
REF		21024-5	WASHER, LOCK (NO 10) FEED ROD GUIDE	137				51	
REF		21024-4	WASHER, LOCK (NO 8) STRIP GUIDE	136				50	
REF		21024-4	WASHER, LOCK (NO 8) SHEAR BLADE	135	1	7-21002-9	BOLT, CRIMPER	49	
		21018-4	NUT, HEX MACH (4-40) DRAG	134	1	690602-5	CAM, PRE FEED 1 1/8 STROKE	48	
REF		21068-5	NUT, HEX MACH (6-32) FD ADJ PLATE	133				47	
		21018-7	NUT, HEX MACH (10-32) DRAG SPRING	132				46	
		21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	131	1	690191-1	PLUG, NYLON	45	
		5-21004-7	SCR, SKT HD SHLD (250 DIA X .25) DRAG ARM	130	1	455674-1	RAM	44	
		21004-5	SCR, SKT HD SHLD (250 DIA X 1.00) DRAG	129	1	690125-1	WASHER, LAMINATED	43	
		4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	128	1	690124-1	WASHER, RAM	42	
		21009-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	127			SPACER, DISC	41	
		1-21002-7	SCR, BTN HD SKT CAP (6-32 X .38) CAM	126	2	23241-6	BALL, STEEL	40	
REF		3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	125	2	690170-1	SPRING, COMPRESSION	39	
		2-21002-2	SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	124	1	690142-1	DISC, INSULATION	38	
REF		2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	123	1	1-690141-6	DISC, WIRE	37	
		22733-8	SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	122	1	22480-5	WASHER, SPRING	36	
		3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	121	1	690212-1	POST, RAM	35	
REF		2-22733-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	120				34	
		2-21000-4	SCR, SKT HD CAP (6-32 X 1.00) DRAG ADAPTOR	119				33	
		23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	118	1	458980-2	APPLICATOR, BASIC (SUB ASSY)	32	
		2-21000-7	SCR, SKT HD CAP (8-32 X .44) SHEAR BLADE	117				31	
		7-21000-4	SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	116				30	
		2-21000-8	SCR, SKT HD CAP (8-32 X .62) STRIP GUIDE	115				29	
REF		3-21000-7	SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE	114	1	3-690451-2	SPACER, STRIPPER	28	
		3-21000-9	SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING	113	1	240639-1	STRIPPER	27	
REF		3-21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	112	REF	455676-1	PLATE, BASE	26	
REF		3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	111	2	22354-8	DRAG, STUD	25	
		3-21000-8	SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE	110	1	455678-6	PLATE, STRIP GUIDE	24	
REF		455745-1	GUARD	109	1	240825-4	PLATE, STRIP HOLD	23	
		465184-9	LUBRICATOR ASSY	108	2	4-22281-1	SPRING, DRAG	22	
		455985-1	OIL, LUBRICATING	107		240636-1	LEVER, DRAG	21	
		454406-1	SPACER, LUB BRACKET	106	1	454177-1	DRAG, STOCK	20	
		458109-1	WASHER, FLAT (SPECIAL)	105	1	454204-3	GUIDE, STRIP (REAR)	19	
REF		690603-1	SPRING, ASSIST	104	1	454204-3	GUIDE, STRIP (FRONT)	18	
REF		690517-1	SPACER	103	REF	454178-1	GUIDE, FEED ROD	17	
		22594-8	NUT, HEX	102	REF	4-22284-9	SPRING, FEED RETURN	16	
		240628-1	PLATE, ADJ	101			ADAPTER, DRAG	15	
		240626-1	SHAFT, PIVOT	79				14	
		240633-1	BUSHING	78				13	
		455680-1	LEVER, INTERMEDIATE	77				12	
		240629-1	BLOCK, PIVOT	76	1	691901-2	SPACER, HOLD DOWN	11	
		240632-2	SCREW, ADJ	75	2	1-240645-6	SPRING, HOLD DOWN	10	
		240659-3	PIN, CAM ROLLER	74	1	690783-1	PLATE, REAR SHEAR	9	
		240658-1	CAM, ROLLER	73	1	2-240655-2	SPACER, SHEAR PLATE	8	
REF		454398-1	ROD, FEED	72	1	1-691157-0	PLATE, FRONT SHEAR	7	
				71			ANVIL	6	
				70	1	3-240641-6	BLADE, SLUG	5	
				69	1	238009-1	HOLD DOWN, TERMINAL	4	
				68	1	1-456134-4	SPACER, SHEAR BLADE	3	
				67	1	455888-4	SPACER, TUBULAR	2	
				66	1	456408-2	CRIMPER, INSULATION	1	
				65			CRIMPER, WIRE		

CRIMPING DATA				APPLICATOR WILL APPLY	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	OBS.	ITEM
A	.060	18		40893	
B	.056	20		40894	
C	NOT USED			42481	
D	NOT USED				

CRIMP	SIZE	TYPE	FEED	APPL INST
WIRE	.110	F	.682	A1 8039
INSUL	.140	F		
WIRE RANGE	20-18		.075-.110	565435-5

REMARKS
AMP-O-LECTRIC PRE-FEED

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

PIF LTR	REVISION RECORD	APP DATE	PIF LTR	REVISION RECORD	APP DATE	PIF LTR	REVISION RECORD	APP DATE

THIS INFORMATION IS UNCLASSIFIED AND IS AVAILABLE TO YOU ON CONDITION THAT YOU AGREE TO HOLD IT UNCLASSIFIED AND NOT TO DISCLOSE IT TO OTHER THAN AMP PERSONNEL WITHOUT WRITTEN AUTHORIZATION FROM AMP INCORPORATED, HARRISBURG, PA.