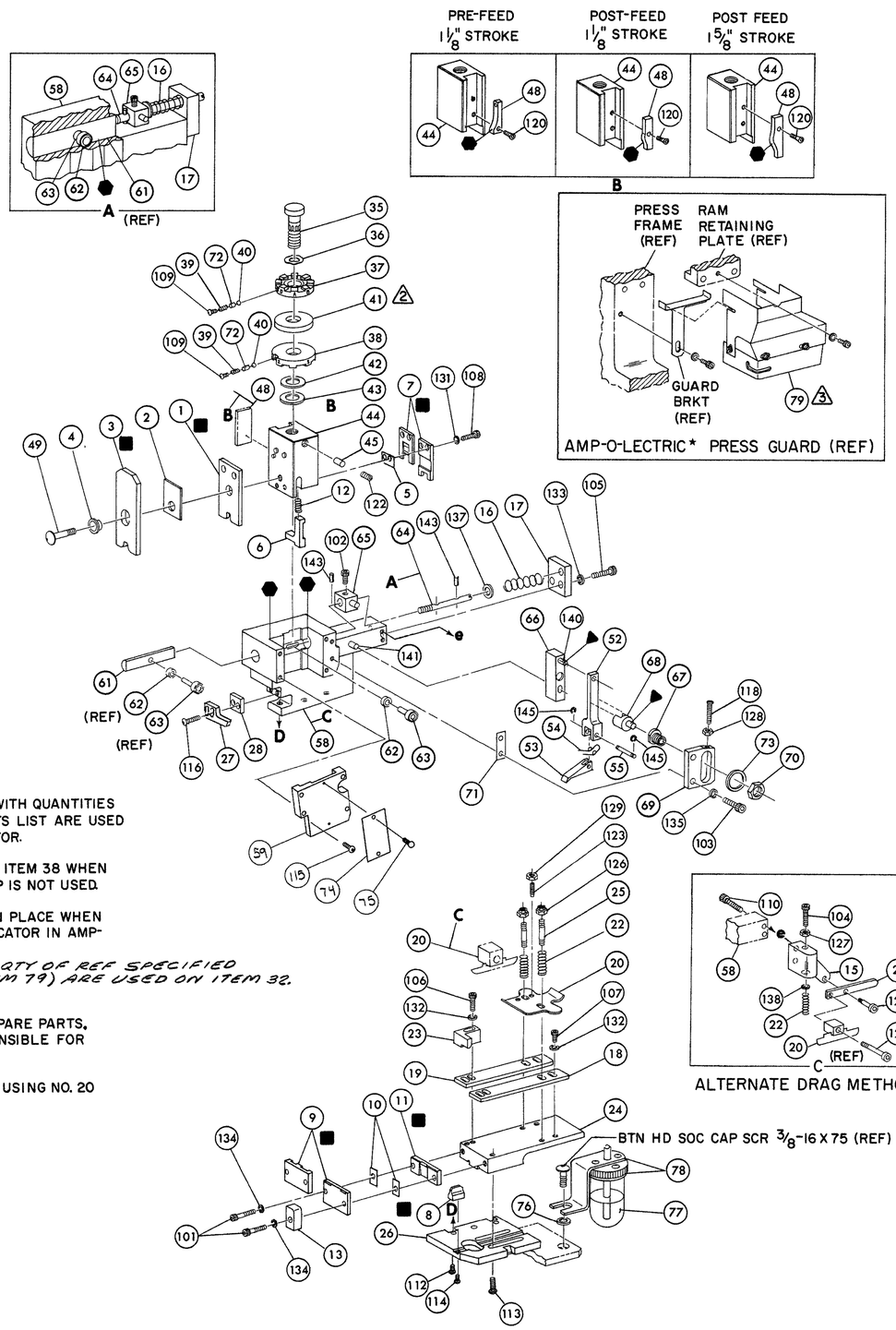

NOTES:

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 79) ARE USED ON ITEM 32.

KEY:

■ RECOMMENDED SPARE PARTS. CUSTOMER RESPONSIBLE FOR REPLACEMENT.

▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.

⬢ GREASE LIGHTLY.

QTY	PART NO	DESCRIPTION	ITEM NO
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	145
			144
REF	5-21028-1	PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD	143
			142
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
			139
—	22260-5	WASHER, FLAT (NO 6) DRAG SPRING	138
REF	21899-4	WASHER, FLAT (5/16 DIA) SCR ADJ	137
			136
REF	21024-5	WASHER, LOCK (NO 10) FEED ADJ PLATE	135
2	21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	134
REF	21024-5	WASHER, LOCK (NO 10) FEED ROD GUIDE	133
5	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
REF	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	21009-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	122
			121
1	1-21002-7	SCR, BUT HD SKT CAP (6-32 X . .) CAM	120
			119
REF	3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	118
			117
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	116
REF	2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	115
1	22733-8	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
REF	1-24073-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	112
			111
–	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) (LOC-WEL) CP DISC	109
2	2-21000-6	SCR, SKT HD CAP (8-32 X .38) SHEAR BLADE	108
3	7-21000-4	SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	107
2	2-21000-8	SCR, SKT HD CAP (8-32 X .62) 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	3-21002-0	SCR, BUT HD CAP (10-32 X .88) SHEAR PLATE	101
REF	455745-1	GUARD, WINDOW △3	79
—	465184-9	LUBRICATOR ASSY	78
—	455985-1	OIL, LUBRICATING	77
—	454406-1	SPACER, LUB BRACKET	76
2	21017-2	SCR, DRIVE (#2 X .19) ID PLATE	75
1	461264-1	PLATE, ID	74
REF	458109-1	WASHER, FLAT (SPECIAL)	73
2	690603-1	SPRING, ASSIST	72
REF	690517-1	SPACER	71
	22594-8	NUT, HEX	70
	240628-1	PLATE, ADJ	69
	240626-1	SHAFT, PIVOT	68
	240633-1	BUSHING	67
	455680-1	LEVER, INTERMEDIATE	66
	240629-1	BLOCK, PIVOT	65
	240632-2	SCREW, ADJ	64
	240659-3	PIN, CAM ROLLER	63
	240658-1	CAM, ROLLER	62
REF	454398-1	ROD, FEED	61
			60

QTY	PART NO	DESCRIPTION	ITEM NO
REF	454220-1	CAP, RAM	59
REF	453736-1	HOUSING	58
			57
			56
REF	240624-1	PIN, FEED FINGER	55
REF	691499-1	SPRING, FEED FINGER	54
REF	240635-1	FINGER, FEED	53
REF	240634-1	LEVER, TERMINAL	52
			51
			50
1	7-21002-9	BOLT, CRIMPER	49
1	690602-5	CAM, PRE FEED 1 1/8 STROKE	48
			47
			46
1	690191-1	PLUG, NYLON	45
1	455674-1	RAM	44
1	690125-1	WASHER, LAMINATED	43
1	690124-1	WASHER, RAM	42
		SPACER, DISC △2	41
2	23241-6	BALL, STEEL	40
2	690170-1	SPRING, COMPRESSION	39
1	690142-1	DISC, INSULATION	38
1	8-690692-6	DISC, WIRE	37
1	22480-5	WASHER, SPRING	36
1	690212-1	POST, RAM	35
			34
			33
1	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
			31
			30
			29
1	3-690451-2	SPACER, STRIPPER	28
1	240639-1	STRIPPER	27
REF	455676-1	PLATE, BASE	26
2	22354-8	DRAG, STUD	25
1	455678-1	PLATE, STRIP GUIDE	24
1	240825-9	PLATE, STRIP HOLD	23
2	4-22281-1	SPRING, DRAG	22
—	240636-1	LEVER, DRAG	21
1	454177-1	DRAG, STOCK	20
1	454204-6	GUIDE, STRIP (REAR)	19
1	454204-6	GUIDE, STRIP (FRONT)	18
REF	454178-1	GUIDE, FEED ROD	17
REF	4-22284-9	SPRING, FEED RETURN	16
		ADAPTER, DRAG	15
			14
1	690481-2	SPACER, HOLD DOWN	13
1	23846-1	SPRING, HOLD DOWN	12
1	240644-1	PLATE, REAR SHEAR ■	11
		SPACER, SHEAR PLATE	10
1	690495-3	PLATE, FRONT SHEAR ■	9
1	6-240693-4	ANVIL ■	8
1	690474-5	BLADE, SLUG ■	7
1	3-455892-0	HOLD DOWN, TERMINAL	6
1	3-240641-7	SPACER, SHEAR BLADE	5
1	238009-1	SPACER, TUBULAR	4
1	1-456139-6	CRIMPER, INSULATION ■	3
1	455888-7	SPACER, INSULATION	2
1	1-456407-6	CRIMPER, WIRE ■	1

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.038	22	
B	.035	24	
C	.033	26	
D	NOT	USED	

CRIMP	SIZE	TYPE	FEED	APPL INST
WIRE	.055	F	.689	A18039
INSUL	.080	F		

WIRE RANGE 26-22 | INSULATION RANGE .050-.070 | PRESS NO 565435-5

REMARKS: AMP-O-LECTRIC PRE FEED

APPLICATOR WILL APPLY

60674
1742754

REMARKS	NO	REV
	TO APPLY TERMINAL SPEC 114-2036	
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
		E1	ECR-10-005177	KW/GB	3-10
		E	ECN 0150-1438-04	RV/TB	11-04
		D1	0150-9337-99	RM	5-99
		D	0150-6325-95	LTB	11-95
		C	ECN A15768D	AB	11-88
		B	REV FER ON R-5470		
		A	REV. ITEM 37 PER E3946		3-80

P	F	LTR	REVISION RECORD	APP	DATE

SET UP GAGE 458638-1 10-1
DR 5-2-74 APP 5-3-74
CHK 6-3-74 REL 7-9-74

AMP INCORPORATED Harrisburg, Pa

LOC A | D | NO 466091-3 | REV E1

NAME MINIATURE QUICK CHANGE APPLICATOR END FEED (.250 FASTON RECEPT)

CUSTOMER AND ASSEMBLY DRAWING

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TE Connectivity:

466091-3