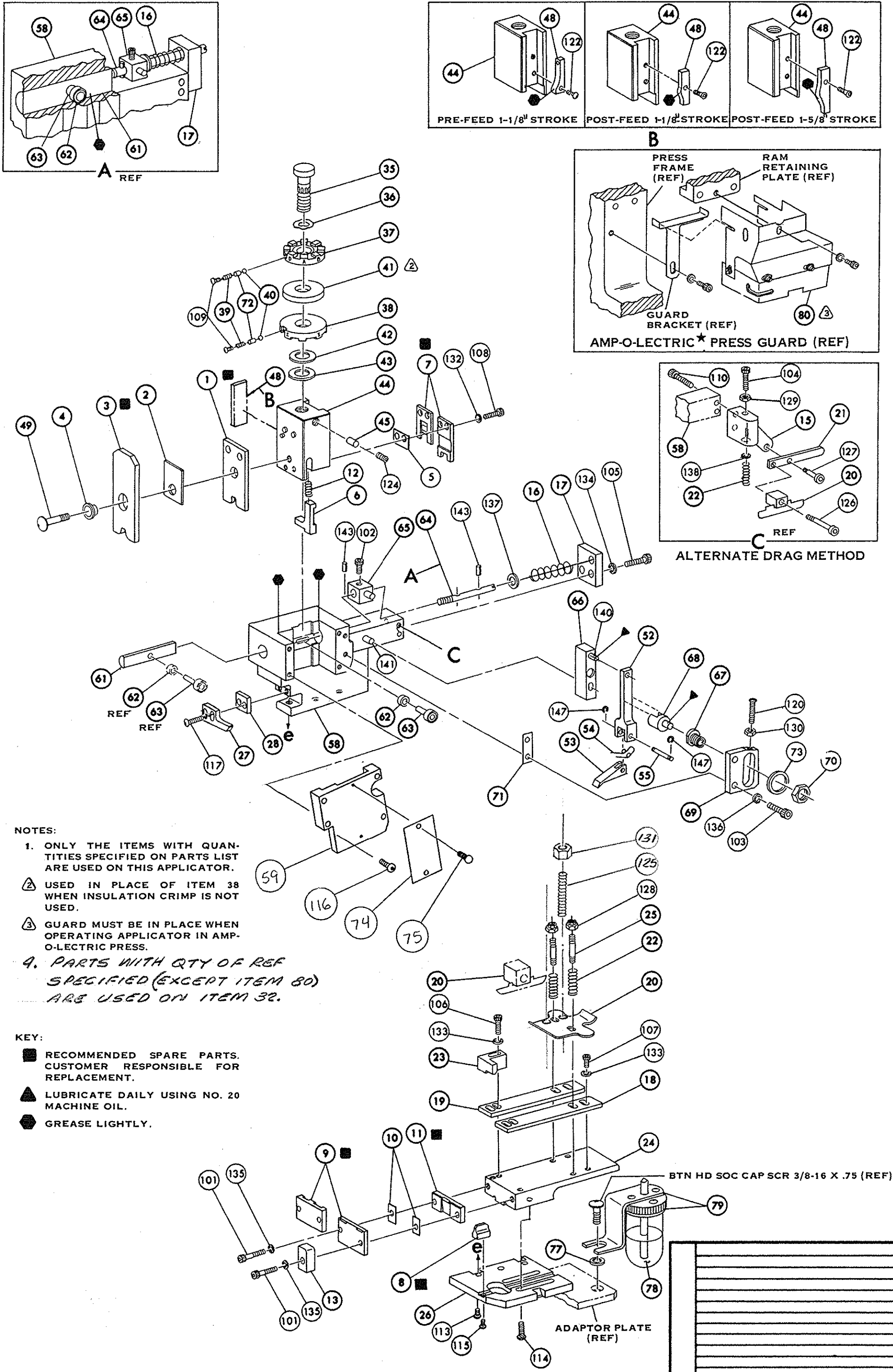


THIS DRAWING IS A CONTROLLED DOCUMENT.



**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 OF REF SPECIFIED (EXCEPT ITEM 80) ARE USED ON ITEM 32.

**KEY:**

- RECOMMENDED SPARE PARTS. CUSTOMER RESPONSIBLE FOR REPLACEMENT.
- LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- GREASE LIGHTLY.

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REVISION RECORD		REVISION RECORD	
LTR	DATE	ECN	DATE
F	0150-0684-01		
E	0150-7376-96		
D	REV PER ECN	A-153588	
C	REV PER ECN	R-5470	
B	REV PER ECN	R-3078	
A	REV PER ECN	R22690	
A	PER ECN	R 2118	
Q1	ADD TERM	R2162	

REQ.	PART NO.	DESCRIPTION	NO.	REQ.	PART NO.	DESCRIPTION	NO.
	162	REF 690517-1	SPACER		71		
	161	22594-8	HEX, NUT		70		
	160	240628-1	PLATE, ADJ		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, ADJ		64		
	154	240659-3	PIN, CAM ROLLER		63		
	153	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		
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN		147			
				146	REF 240624-1	PIN, FEED FINGER	55
				145	REF 691499-1	SPRING, FEED FINGER	54
				144	REF 240635-1	FINGER, FEED	53
REF	5- 21028-1	PIN, SLOT SPG (.12 DIA x .50) FEED ADJ ROD		143	REF 240634-1	LEVER, TERMINAL	52
				142			51
REF	1- 21030-7	PIN, DOWEL (.187 DIA x 1.50) HOUSING		141			50
REF	1- 21030-1	PIN, DOWEL (.187 DIA x .50) LEVER		140	1 7-21002-9	BOLT, CRIMPER	49
				139	1 690602-5	CAM, PRE FEED 1- 1/8 STROKE	48
	22260-5	WASH, FLAT (NO. 6) DRAG SPRING		138			47
REF	21899-4	WASH, FLAT (NO. 5/16 DIA) SCR ADJ		137			46
REF	21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE		136	1 690191-1	PLUG, NYLON	45
2	21024-5	WASH, LOCK (NO. 10) SHEAR PLATES		135	1 455679-1	RAM	44
REF	21024-5	WASH, LOCK (NO. 10) FEED ROD GUIDE		134	1 690125-1	WASHER, LAMINATED	43
4	21024-4	WASH, LOCK (NO. 8) STRIP GUIDE		133	1 690124-1	WASHER, RAM	42
2	21024-4	WASH, LOCK (NO. 8) SHEAR BLADE		132			41
2	21018-4	NUT, HEX MACH (4-90) DRAG		131	2 23241-6	BALL, STEEL	40
REF	21068-5	NUT, HEX MACH (6-32) FEED ADJ PLATE		130	2 690170-1	SPRING, COMPRESSION	39
	21018-7	NUT, HEX MACH (10-32) DRAG SPRING		129	1 690142-1	DISC, INSULATION	38
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUDS		128	1 6-692155-5	DISC, WIRE	37
	5- 21004-7	SCR, SKT HD SHLD (.250 DIA x .25) DRAG ARM		127	1 22480-5	WASHER, SPRING	36
	21004-5	SCR, SKT HD SHLD (.250 DIA x 1.00) DRAG		126	1 690212-1	POST, RAM	35
2	4-21018-8	SCR, SKT SET OVAL PT (4-40 x .75) DRAG		125			34
1	21009-2	SCR, SKT SET (1/4-20 x .25) NYLOK RAM		124			33
				123	1 458980-1	APPLICATOR, BASIC (SUB ASSY)	32
1	2- 21003-0	SCR, FLAT HD SOC CAP (6-32 x .50) CAM		122			31
				121			30
REF	3- 21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ		120			29
				119	1 3-690451-2	SPACER, STRIPPER	28
				118	1 240639-1	STRIPPER	27
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER		117	REF 455676-1	PLATE, BASE	26
REF	2- 21002-9	SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP		116	2 22359-8	DRAG, STUD	25
1	22733-8	SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL		115	1 455678-1	PLATE, STRIP GUIDE	24
4	3- 21002-3	SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL		114			23
REF	1-24073-9	SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE		113	2 4-22261-1	SPRING, DRAG	22
				112	240636-1	LEVER, DRAG	21
				111	1 454177-1	DRAG, STOCK	20
	2- 21000-4	SCR, SKT HD CAP (6-32 x 1.00) DRAG ADAPTOR		110	1 458030-9	GUIDE, STRIP REAR	19
2	23030-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC		109	1 458031-9	GUIDE, STRIP FRONT	18
2	2-21000-6	SCR, SKT HD CAP (8-32 x .38) SHEAR BLADE		108	REF 454178-1	GUIDE, FEED ROD	17
3	7-21000-4	SCR, SKT HD CAP (8-32 x .51) STRIP GUIDE		107	REF 4-22284-9	SPRING, FEED RETURN	16
1	7-21000-4	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE		106	454665-1	ADAPTOR, DRAG	15
REF	3- 21000-7	SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE		105			14
	3- 21000-9	SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING		104			13
REF	3- 21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE		103			12
REF	3- 21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK		102	1 240644-1	PLATE, REAR SHEAR	11
2	3- 21000-8	SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES		101	2 240645-8	SPACER, SHEAR PLATE	10
REF	455745-1	GUARD, WINDOW		80	1 240642-1	PLATE, FRONT SHEAR	9
	465184-9	LUBRICATOR ASSY		79	1 2240693-8	ANVIL	8
	22014-1	OIL SYNTHETIC		78	1 1-240651-2	BLADE, SLUG	7
	454406-1	SPACER, LUBRICATOR BRACKET		77			6
				76	1 3-240641-7	SPACER, SHEAR BLADE	5
2	21017-2	SCR, DRIVE (#2 x .19) ID PLATE		75	1 238009-1	SPACER, TUBULAR, INS CRIMPER	4
1	461264-1	PLATE, ID		74	1 1-456135-4	CRIMPER, INSULATION	3
REF	458109-1	WASHER, FLAT (SPECIAL)		73	1 455888-4	SPACER, INSULATION	2
2	690603-1	SPRING, ASSIST		72	1 1-456403-0	CRIMPER, WIRE	1

TERM APPL SPEC 114-2084

CRIMPING DATA				THIS APPLICATOR WILL APPLY	
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	RINGS	SPADES
A	.046	20		60553	60344-085
B	.043	22		60554	60445
C	.041	24		60555	60500
D	NOT USED			62684	60501

CRIMP	SIZE	TYPE	FEED	PRESS REF.
WIRE	.062	F		565435-5
INSULATION	.090	0	.676	

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION
.048-.078	24-20	8039

REMARKS  
AMP-O-LECTRIC PRE FEED

SET UP GAGE	458638-1	LAYOUT NO.	73
DRAWN	1/31/74	APPROVED	2-1-74
CHECKED	2-1-74	REL	2-1-74
A PER ECN	R22690	R 2118	R 2118
Q1 ADD TERM	62684	R 2162	R 2162

SCALE NONE

LOC	A	C	NO.	466019-2	REV.	F
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**MINIATURE QUICK CHANGE APPLICATOR**  
END-FEED (RINGS & SPADES)

CASE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO

466019-2