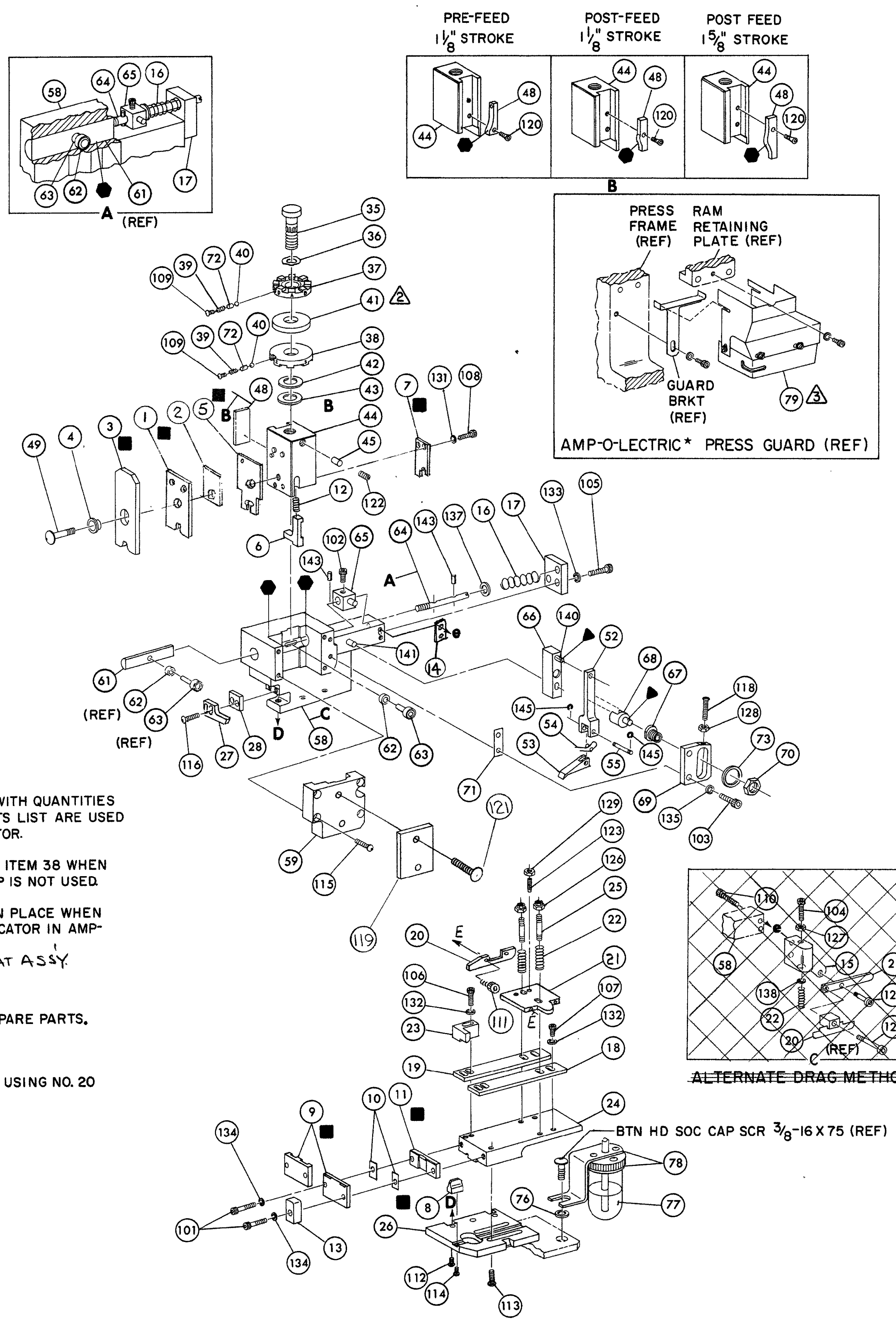


THIS DRAWING IS A CONTROLLED DOCUMENT.



**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.

4. CUT TO LENGTH AT ASSY.

**KEY:**

■ RECOMMENDED SPARE PARTS.

▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.

● GREASE LIGHTLY.

| QTY | PART NO   | DESCRIPTION                                      | ITEM NO | PART NO    | DESCRIPTION                    | ITEM NO |
|-----|-----------|--|---------|------------|--------------------------------|---------|
| 2   | 21045-3   | RING, RETAINING 'C' (.187 DIA) FEED PIN          | 145     | 454220-1   | CAP, RAM                       | 59      |
|     |           |  | 144     | 453736-1   | HOUSING                        | 58      |
| 2   | 5-21028-1 | PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD         | 143     |            |                                | 57      |
|     |           |  | 142     |            |                                | 56      |
| 1   | 1-21030-7 | PIN, DOWEL (.187 DIA X 1.50) HOUSING             | 141     | 240624-1   | PIN, FEED FINGER               | 55      |
| 1   | 1-21030-1 | PIN, DOWEL (.187 DIA X .50) LEVER                | 140     | 691499-1   | SPRING, FEED FINGER            | 54      |
|     |           |  | 139     | 694921-8   | FINGER, FEED                   | 53      |
| -   | 22260-5   | WASHER, FLAT (NO 6) DRAG SPRING                  | 138     | 240634-1   | LEVER, TERMINAL                | 52      |
| 1   | 21899-4   | WASHER, FLAT (5/16 DIA) SCR ADJ                  | 137     |            |                                | 51      |
|     |           |  | 136     |            |                                | 50      |
| 2   | 21024-5   | WASHER, LOCK (NO 10) FEED ADJ PLATE              | 135     | 690686-1   | BOLT, CRIMPER                  | 49      |
| 2   | 21024-5   | WASHER, LOCK (NO 10) SHEAR PLATES                | 134     | 690501-4   | CAM, POST FEED 1/8 STROKE      | 48      |
| 2   | 21024-5   | WASHER, LOCK (NO 10) FEED ROD GUIDE              | 133     |            |                                | 47      |
| 4   | 21024-4   | WASHER, LOCK (NO 8) STRIP GUIDE                  | 132     |            |                                | 46      |
| 2   | 21024-4   | WASHER, LOCK (NO 8) SHEAR BLADE                  | 131     | 690191-1   | PLUG, NYLON                    | 45      |
|     |           |  | 130     | 455674-5   | RAM                            | 44      |
| 2   | 21018-4   | NUT, HEX MACH (4-40) DRAG                        | 129     | 690125-1   | WASHER, LAMINATED              | 43      |
| 1   | 21018-5   | NUT, HEX MACH (6-32) FD ADJ PLATE                | 128     | 690124-1   | WASHER, RAM                    | 42      |
| -   | 21018-7   | NUT, HEX MACH (10-32) DRAG SPRING                | 127     |            |                                | 41      |
| 2   | 21022-2   | NUT, HEX SELF-LKG (8-32) DRAG STUD               | 126     | 23241-6    | BALL, STEEL                    | 40      |
| -   | 5-21004-7 | SCR, SKT HD SHLD (250 DIA X .25) DRAG ARM        | 125     | 690170-1   | SPRING, COMPRESSION            | 39      |
| -   | 21004-5   | SCR, SKT HD SHLD (250 DIA X 1.00) DRAG           | 124     | 690142-1   | DISC, INSULATION               | 38      |
| 2   | 4-21078-8 | SCR, SKT SET OVAL POINT (4-40 X .75) DRAG        | 123     | 5-692155-1 | DISC, WIRE                     | 37      |
| 1   | 21009-2   | SCR, SKT SET (1/4-20 X .25) (LOC-WEL) RAM        | 122     | 22480-5    | WASHER, SPRING                 | 36      |
| 2   | 21017-2   | SCR, DRIVE (#2 X .19)                            | 121     | 690212-1   | POST, RAM                      | 35      |
| 1   | 1-21002-7 | SCR, BUT HD SKT CAP (6-32 X .38) CAM             | 120     |            |                                | 34      |
| 1   | 461264-1  | PLATE, IDENTIFICATION                            | 119     |            |                                | 33      |
| 1   | 6-23715-5 | SCR, PAN HD MACH (6-32 X 1.50) FEED ADJ          | 118     | 458980-    | APPLICATOR, BASIC (SUB ASSY)   | 32      |
|     |           |  | 117     |            |                                | 31      |
| 2   | 2-21002-3 | SCR, BTN HD SKT CAP (8-32 X .62) STRIPPER        | 116     |            |                                | 30      |
| 4   | 2-21002-9 | SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP        | 115     |            |                                | 29      |
| 1   | 22733-8   | SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL | 114     | 3-690451-0 | SPACER, STRIPPER               | 28      |
| 4   | 3-21002-3 | SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL    | 113     | 240639-2   | STRIPPER                       | 27      |
| 3   | 17177-1   | SCR, BTN HD SKT CAP (1/4-20 X .62) BASE PL       | 112     | 455676-1   | PLATE, BASE                    | 26      |
| 2   | 1-21000-3 | SCR, SKT HD CAP (4-40 X .25) DRAG                | 111     | 22354-8    | DRAG, STUD                     | 25      |
| -   | 7-21000-3 | SCR, SKT HD CAP (6-32 X 1.12) DRAG ADAPTOR       | 110     | 455678-1   | PLATE, STRIP GUIDE             | 24      |
| 2   | 23030-1   | SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC   | 109     |            |                                | 23      |
| 2   | 2-21000-6 | SCR, SKT HD CAP (8-32 X .38) SHEAR BLADE         | 108     | 23470-5    | SPRING, DRAG                   | 22      |
| 3   | 2-21000-6 | SCR, SKT HD CAP (8-32 X .38) STRIP GUIDE         | 107     | 464451-4   | ARM, STOCK DRAG                | 21      |
| 1   | 2-21000-6 | SCR, SKT HD CAP (8-32 X .38) STRIP GUIDE         | 106     | 464452-2   | DRAG, STOCK                    | 20      |
| 2   | 3-21000-7 | SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE       | 105     | 3-458030-9 | GUIDE, STRIP (REAR)            | 19      |
| -   | 3-21000-9 | SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING       | 104     | 3-458031-9 | GUIDE, STRIP (FRONT)           | 18      |
| 2   | 3-21000-6 | SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE       | 103     | 454178-1   | GUIDE, FEED ROD                | 17      |
| 1   | 3-21000-4 | SCR, SKT HD CAP (10-32 X .38) PIVOT BLK          | 102     | 4-22284-9  | SPRING, FEED RETURN            | 16      |
| 2   | 3-21000-8 | SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE        | 101     | 454665-4   | ADAPTER, DRAG                  | 15      |
| REF | 455745-1  | GUARD, WINDOW                                    | 79      | 464524-1   | SPACER, ADAPTER                | 14      |
| -   | 465184-9  | LUBRICATOR ASSY                                  | 78      |            |                                | 13      |
| -   | 455985-1  | OIL, LUBRICATING                                 | 77      |            |                                | 12      |
| -   | 454406-1  | SPACER, LUB BRACKET                              | 76      | 453654-1   | PLATE, REAR SHEAR              | 11      |
|     |           |  | 75      | 2-240645-0 | SPACER, SHEAR PLATE            | 10      |
|     |           |  | 74      | 453653-1   | PLATE, FRONT SHEAR RETAINER    | 9       |
| 1   | 458109-1  | WASHER, FLAT (SPECIAL)                           | 73      | 453670-5   | ANVIL                          | 8       |
| 2   | 690603-1  | SPRING, ASSIST                                   | 72      | 453656-1   | BLADE, SLUG REAR               | 7       |
| 1   | 690517-1  | SPACER   | 71      |            |                                | 6       |
| 1   | 22594-8   | NUT, HEX   | 70      | 684917-2   | SPACER, SHEAR BLADE FRONT      | 5       |
| 1   | 240628-1  | PLATE, ADJ                                       | 69      | 238009-1   | SPACER, TUBULAR                | 4       |
| 1   | 240626-1  | SHAFT, PIVOT                                     | 68      | 2-456135-8 | CRIMPER, INSULATION            | 3       |
| 1   | 240633-1  | BUSHING  | 67      | 1-455888-2 | SPACER, MINIATURE WIRE CRIMPER | 2       |
| 1   | 455680-1  | LEVER, INTERMEDIATE                              | 66      | 2-456402-6 | CRIMPER, WIRE                  | 1       |
| 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      |            |                                |         |

| CRIMPING DATA      |              |                  |                   | APPLICATOR WILL APPLY |        |
|--------------------|--------------|------------------|-------------------|-----------------------|--------|
| PAD LTR            | CRIMP HEIGHT | WIRE SIZE        | WIRE STRIP LENGTH |                       |        |
| A                  | .041         | 20               |                   |                       | 61119  |
| B                  | .037         | 22               |                   |                       | 61451  |
| C                  | .034         | 24               |                   |                       | 61586  |
| D                  | NOT USED     |                  |                   |                       | 641549 |
| CRIMP              | SIZE         | TYPE             | FEED              | APPL INST             |        |
| WIRE               | .055         | F                |                   |                       |        |
| INSUL              | .080         | O                | .535              | A18039                |        |
| WIRE RANGE         | 24-20        | INSULATION RANGE | INSUL RANGE       | PRESS NO              |        |
|                    |              |                  | .045-.070         |                       |        |
| REMARKS: AMPOMATOR |              |                  |                   |                       |        |

|                              |                |                |
|------------------------------|----------------|----------------|
| 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 |

HI ECN 0150-1142-01 11/16 9-01  
 H 0150-4376-93 11/16 9-01  
 G REV PER ECN R-5886 11/16 9-01

F REV PER R-5037 06/14 4-83  
 E REV PER ECN R-3624 06/14 4-83  
 DI REV PER ECN R-3460 06/14 4-83  
 D REV PER ECN R-3085 06/14 4-83  
 C REV PER ECN R-2629 06/14 4-83  
 B REV PER ECN R-1945 06/14 4-83  
 A REV PER ECN R-1806 06/14 4-83

SET UP GAGE 10-1  
 458638-1 405  
 DR 9/16/14  
 WIRE RANGE 24-20  
 INSULATION RANGE .045-.070  
 PRESS NO  
 AMPOMATOR

AMP INCORPORATED  
 Harrisburg, Pa.

NAME: MINIATURE QUICK CHANGE APPLICATOR  
 END FEED (RIGHT ANGLE PIN RECOG.)  
 CUSTOMER AND ASSEMBLY DRAWING