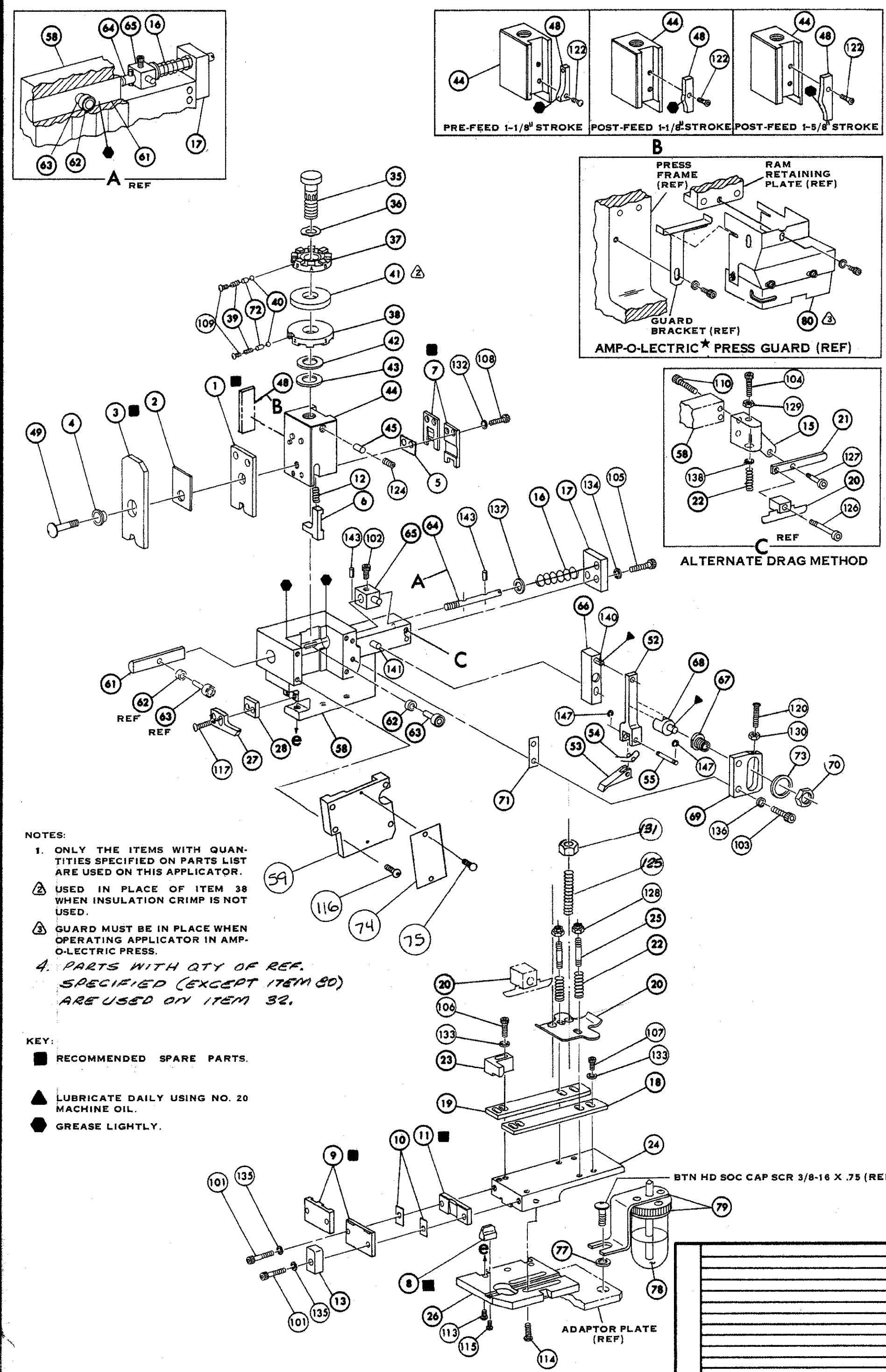


THIS IS A CONTROLLED DOCUMENT.



- 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.
 - LUBRICATE DAILY USING NO. 20 MACHINE OIL.
 - GREASE LIGHTLY.

| REF | QTY | PART NO. | DESCRIPTION | NO. | REF | QTY | 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 |
| | | 147 | | | | | | | 56 |
| | | 146 | REF | 240624-1 | | | | PIN, FEED FINGER | 55 |
| | | 145 | REF | 691999-1 | | | | SPRING, FEED FINGER | 54 |
| | | 144 | REF | 240635-1 | | | | FINGER, FEED | 53 |
| | | 143 | REF | 240634-1 | | | | LEVER, TERMINAL | 52 |
| | | 142 | | | | | | | 51 |
| | | 141 | | | | | | | 50 |
| | | 140 | 1 | 7-21002-9 | | | | BOLT, CRIMPER | 49 |
| | | 139 | 1 | 690501-3 | | | | CAM, POST FEED 1-1/8 STROKE | 48 |
| | | 138 | | | | | | | 47 |
| | | 137 | | | | | | | 46 |
| | | 136 | 1 | 690191-1 | | | | PLUG, NYLON | 45 |
| | | 135 | 1 | 455674-1 | | | | RAM | 44 |
| | | 134 | 1 | 690125-1 | | | | WASHER, LAMINATED | 43 |
| | | 133 | 1 | 690124-1 | | | | WASHER, RAM | 42 |
| | | 132 | 1 | 690223-1 | | | | SPACER, DISC | 41 |
| | | 131 | 1 | 23241-6 | | | | BALL, STEEL | 40 |
| | | 130 | 1 | 690170-1 | | | | SPRING, COMPRESSION | 39 |
| | | 129 | | | | | | DISC, INSULATION | 38 |
| | | 128 | 1 | 669014-8 | | | | DISC, WIRE | 37 |
| | | 127 | 1 | 22480-5 | | | | WASHER, SPRING | 36 |
| | | 126 | 1 | 690212-1 | | | | POST, RAM | 35 |
| | | 125 | | | | | | | 34 |
| | | 124 | | | | | | | 33 |
| | | 123 | 1 | 458980-1 | | | | APPLICATOR, BASIC (SUB ASSY) | 32 |
| | | 122 | | | | | | | 31 |
| | | 121 | | | | | | | 30 |
| | | 120 | | | | | | | 29 |
| | | 119 | 1 | 3-690451-2 | | | | SPACER, STRIPPER | 28 |
| | | 118 | | 240639-1 | | | | STRIPPER | 27 |
| | | 117 | REF | 455676-1 | | | | PLATE, BASE | 26 |
| | | 116 | 2 | 22354-3 | | | | DRAG, STUD | 25 |
| | | 115 | 1 | 455673-1 | | | | PLATE, STRIP GUIDE | 24 |
| | | 114 | 1 | 240825-6 | | | | PLATE, STRIP HOLD | 23 |
| | | 113 | 2 | 4-22281-1 | | | | SPRING, DRAG | 22 |
| | | 112 | | 240636-1 | | | | LEVER, DRAG | 21 |
| | | 111 | 1 | 454177-1 | | | | DRAG, STOCK | 20 |
| | | 110 | 1 | 454204-3 | | | | GUIDE, STRIP REAR | 19 |
| | | 109 | 1 | 454204-3 | | | | GUIDE, STRIP FRONT | 18 |
| | | 108 | REF | 454178-1 | | | | GUIDE, FEED ROD | 17 |
| | | 107 | REF | 4-22284-9 | | | | SPRING, FEED RETURN | 16 |
| | | 106 | | 454665-1 | | | | ADAPTOR, DRAG | 15 |
| | | 105 | | | | | | | 14 |
| | | 104 | 1 | 690481-2 | | | | SPACER, HOLD DOWN | 13 |
| | | 103 | 1 | 23846-1 | | | | SPRING, HOLD DOWN | 12 |
| | | 102 | 1 | 240644-1 | | | | PLATE, REAR SHEAR | 11 |
| | | 101 | | | | | | SPACER, SHEAR PLATE | 10 |
| | | 80 | 1 | 690482-3 | | | | PLATE, FRONT SHEAR | 9 |
| | | 79 | 1 | 1-240654-7 | | | | ANVIL | 8 |
| | | 78 | 1 | 690474-3 | | | | BLADE, SLUG | 7 |
| | | 77 | 1 | 2-455892-1 | | | | HOLD DOWN | 6 |
| | | 76 | 1 | 1-240641-2 | | | | SPACER, SHEAR BLADE | 5 |
| | | 75 | | | | | | SPACER, TUBULAR, INS CRIMPER | 4 |
| | | 74 | | | | | | CRIMPER, INSULATION | 3 |
| | | 73 | | | | | | SPACER, INSULATION | 2 |
| | | 72 | 1 | 456408-9 | | | | CRIMPER, WIRE | 1 |

TERM APPL SPEC 114-2036

| CRIMPING DATA | | | | THIS APPLICATOR WILL APPLY |
|------------------|--------------|------------------------|-------------------|----------------------------|
| PAD LETTER | CRIMP HEIGHT | WIRE SIZE | WIRE STRIP LENGTH | 42643 |
| A | .072 | #14 | | 60938 |
| B | .063 | #16 | | |
| C | .057 | #18 | | |
| D | NOT USED | | | |
| CRIMP SIZE | TYPE | FEED | PRESS REF. | |
| WIRE | .110 | F | 565435-5 | |
| INSULATION | | .745 | | |
| INSULATION RANGE | WIRE RANGE | APPLICATOR INSTRUCTION | | |
| | 18-14 | #3039 | | |

AMP-O-LECTRIC POST FEED

| | | | |
|----------------|-------------------|-------|--------------------|
| SET UP GAGE | LAYOUT NO. | AMP | AMP INCORPORATED |
| 458633-1 | 149 | | HARRISBURG, PENNA. |
| DRAWN 10-11-73 | APPROVED 10-11-73 | LOC A | C NO. 687943-2 |
| REVIEWED | REL 10-12-73 | | REV. D |

MINIATURE QUICK CHANGE APPLICATOR
END-FEED (.250 FASTON)

| REVISION RECORD | ECN | DATE | REVISION RECORD | ECN | DATE |
|-----------------|--------------------|------|-----------------|-----|------|
| D | ECN 0150-1438-04 | | | | |
| C | ECN A160688 | | | | |
| B | REV PER REV 2-5322 | | | | |
| A | PER ECN | | | | |