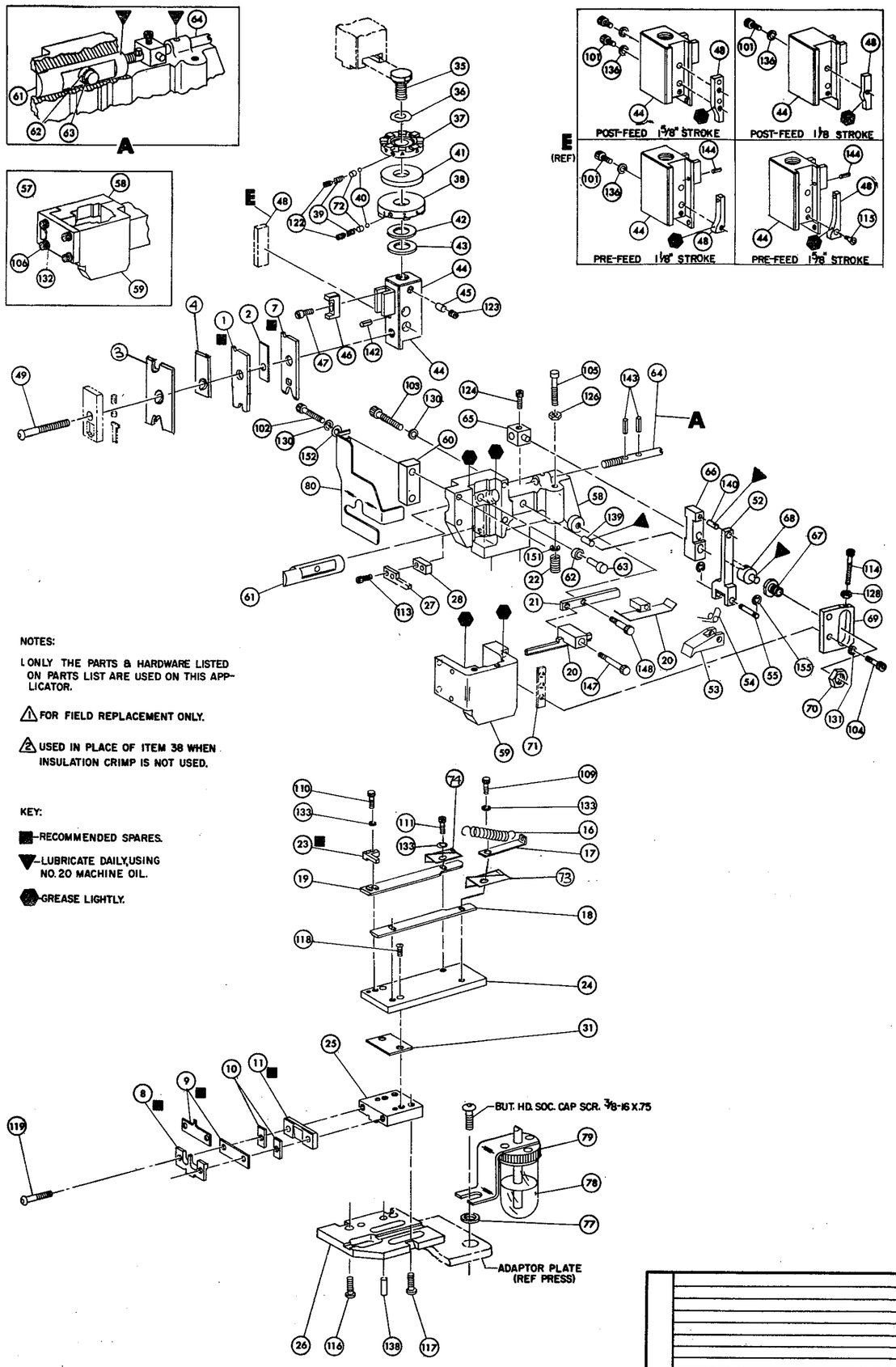
THIS DRAWING IS A CONTROLLED DOCUMENT.



NOTES:

1. ONLY THE PARTS & HARDWARE LISTED ON PARTS LIST ARE USED ON THIS APPLICATOR.

⚠1 FOR FIELD REPLACEMENT ONLY.

⚠2 USED IN PLACE OF ITEM 38 WHEN INSULATION CRIMP IS NOT USED.

KEY:

■ -RECOMMENDED SPARES.

▼ -LUBRICATE DAILY, USING NO. 20 MACHINE OIL.

⬢ -GREASE LIGHTLY.

REQ.	PART NO.	DESCRIPTION	NO.	REQ.	PART NO.	DESCRIPTION	NO.
			162	1	690517-1	SPACER	71
			161	1	22594-8	NUT, HEX	70
			160	1	240628-1	PLATE, ADJUSTMENT	69
			159	1	240626-1	SHAFT, PIVOT	68
			158	1	240633-1	BUSHING	67
			157	1	240630-1	LEVER, INTERMEDIATE	66
			156	1	240629-1	BLOCK, PIVOT	65
2	21045-3	RING, RTNG. "C" (3/16 DIA) FEED PIN	155	1	240632-1	SCREW, ADJUSTMENT	64
			154	1	240659-1	PIN, CAM ROLLER	63
			153	1	240658-1	CAM, ROLLER	62
~~2~~	~~21055-7~~	~~WASHER, FLAT (#10) GUARD~~	152	1	240631-1	ROD, FEED	61
1	22260-5	WASHER, FLAT (#6) DRAG SPRING	151	1	240845-1	PLATE, WEAR	60
			150	1	240621-1	CAP, RAM	59
			149	1	240619-1	HOUSING	58
1	5- 21004-7	SCREW, SKT. HD. SHLDR. (1/4 DIA X .250) DRAG ARM	148				57
1	21004-5	SCREW, SKT. HD. SHLDR. (1/4 DIA X 1.000) DRAG	147				56
			146	1	240624-1	PIN, FEED FINGER	55
			145	1	240638-1	SPRING FEED FINGER	54
—	9- 21028-0	PIN, SLOTTED SPRING (12 DIA X .25) CAM	144	1	240635-1	FINGER, FEED	53
2	5- 21028-1	PIN, SLOTTED SPRING (1/8 DIA X .50) FEED ADJ. ROD	143	1	240634-1	LEVER, TERMINAL	52
—	21028-2	PIN, SLOTTED SPRING (1/16 DIA X .25) RAM ⚠1	142				51
			141				50
1	1- 21030-1	PIN, DOWEL (3/16 DIA X .50) LEVER	140	1	7-21002-9	BOLT, CRIMPER	49
1	1- 21030-7	PIN, DOWEL (3/16 DIA X 1.50) HOUSING	139	1	690602-2	CAM PRE FEED 1 1/8 STROKE	48
—	2- 21030-2	PIN, DOWEL (1/4 DIA X .75) BASE PLATE	138			SCREW, SHOULDER	47
			137			BLOCK, INS, ADJUSTMENT	46
	21024-5	WASHER, LOCK (#10) CAM	136	1	690191-1	PLUG, NYLON	45
			135	1	690476-1	RAM	44
			134	1	690125-1	WASHER, LAMINATED	43
4	21024-4	WASHER, LOCK, (#8) STRIP GUIDE	133	1	690124-1	WASHER, RAM	42
		WASHER, LOCK (#10) HOUSING AND CAP	132	1	690223-1	SPACER, DISC. ⚠2	41
2	21024-5	WASHER, LOCK (#10) FEED ADJ. PLATE	131		23241-6	BALL, STEEL	40
4	21024-5	WASHER, LOCK (#10) HOUSING CAP	130		690170-1	SPRING, COMPRESSION	39
			129			DISC, INSULATION	38
1	21068-5	NUT, HEX MACH. (6-32) FEED ADJ!	128	1	6-692155-3	DISC, WIRE	37
			127	1	22480-5	SPRING, WASHER	36
1	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	126	1	690212-1	POST, RAM	35
			125				34
1	3- 21000-4	SCREW, SKT. HD. CAP (10-32 X .38) PIVOT BLOCK	124				33
1	21009-2	SCREW, SKT. SET (NYLOK) (1/4-20 X .25) C.P. RAM	123				32
	~~2- 21006-7~~	~~SCREW, SKT. SET (6-32 X .13) C.P. DISC~~	122			SPACER, BASE BLOCK	31
1	23030-1	SCREW SOC. HD. CAP (NYLOK) (6-32 X .25) C.P. DISC	121			SPACER, ANCHOR	30
			120				29
2	2-21002-9	SCREW, BTN. HD. SKT. CAP (10-32 X .75) ANVIL	119	1	1-690451-0	SPACER, STRIPPER	28
2	2- 21002-5	SCREW, BTN. HD. SKT. CAP (10-32 X .25) STRIP GUIDE PLATE	118	1	690455-6	STRIPPER	27
4	3- 21002-3	SCREW BTN. HD. SKT. CAP (1/4-20 X .50) BASE BLOCK	117	1	690658-1	PLATE, BASE	26
2	3- 21002-5	SCREW, BTN. HD. SKT. CAP (1/4-20 X .75) HOUSING	116	1	240647-1	BLOCK, BASE	25
—	1- 21003-9	SCREW, FLAT HD. SOC CAP (6-32 X .38) CAM	115	1	691150-1	PLATE, STRIP GUIDE	24
1	3- 21064-2	SCREW, RD HD. MACH (6-32 X 1.50) FEED ADJ.	114			PLATE, STRIP HOLD	23
2	2-21002-4	SCREW, BTN. HD. CAP (8-32 X .75) STRIPPER	113	1	7- 22282-5	SPRING, DRAG	22
			112	1	240636-1	DRAG, LEVER	21
2	2-21000-6	SCREW, SKT. HD. CAP (8-32 X .38) STRIP GUIDE	111	1	1-240696-1	DRAG, STOCK	20
1	2-21000-6	SCREW, SKT. HD. CAP (8-32 X .38) STRIP GUIDE	110	1	691152-1	GUIDE, STRIP, REAR	19
1	2-21000-9	SCREW, SKT. HD. CAP (8-32 X .75) STRIP GUIDE	109	1	691151-1	GUIDE, STRIP, FRONT	18
			108	1	238008-1	ANCHOR, SPRING	17
2	3-21000-9	SCREW, SKT. HD. CAP (10-32 X 1.00) HSG CAP	107	1	3-22287-0	SPRING, FEED RETURN	16
		SCREW, SKT. HD. CAP (10-32 X .62) HOUSING AND CAP	106				15
1	3- 21000-9	SCREW, SKT. HD. CAP (10-32 X 1.00) DRAG SPRING	105				14
2	3- 21000-6	SCREW, SKT. HD. CAP (10-32 X .62) FEED ADJ. PLATE	104				13
1	4- 21000-1	SCREW, SKT. HD. CAP (10-32 X 1.50) HOUSING CAP	103				12
3	4- 21000-0	SCREW, SKT. HD. CAP (10-32 X 1.25) HOUSING CAP	102	1	240644-1	PLATE, REAR SHEAR ■	11
	3- 21000-5	SCREW, SKT. HD. CAP (10-32 X .50) CAM	101	2	240645-3	SPACER, SHEAR PLATE	10
REF	455745-1	GUARD (WINDOW)	80	1	690619-4	PLATE, FRONT SHEAR ■	9
	465184-9	LUBRICATOR ASSY.	79	1	2-690618-7	ANVIL ■	8
	22014-1	OIL, SYNTHETIC	78	1	1-690622-9	BLADE, SLUG ■	7
	454406-1	SPACER, LUBRICATOR BRACKET	77				6
			76				5
			75	1	2-690407-9	SPACER, CRIMPER	4
1	467350-2	GUIDE AUX (LEFT)	74	1	453832-2	CRIMPER, WIRE (FRONT)	3
1	467350-1	GUIDE AUX (RIGHT)	73			SPACER, CRIMPER	2
1	690603-1	ASSIST, SPRING	72	1	453831-3	CRIMPER, WIRE ■	1

CRIMPING DATA

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.071	16	
B	.068	(2) 20	
C	.064	18	
D	NOT	USED	

	SIZE	TYPE	FEED	
CRIMP				PRESS REF
WIRE	.100	F	.505	565935-5
INSULATION	.100	F		

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION
—	18-16	AI 8024

REMARKS: AMP-O-LECTRIC PRE-FEED

THIS APPLICATOR WILL APPLY: 41275, 41329, 41443, 41764, 41984, 42754, 640018

LTR	REVISION RECORD	ECN	DR	CK	DATE
A2	0150- -99	—	JED		4-99
A1	0150-6785-96	—	MY		10-96
A	ECN A161988	—	NS	CE	11-88

SET UP GAGE 619108-1 | LAYOUT NO. 206 | DRAWN Larry Stakem 7-20-78 | APPROVED T Mullen 7/18 | CHECKED BAW 7/78 | REL. E M Vereschagin 7-28-78 | SCALE NONE | LOC A C | NO. 686941-4 | REV. A2

AMP INCORPORATED HARRISBURG, PENNA.

NAME: MINIATURE QUICK CHANGE APPLICATOR END-FEED, SPLICE TYPE.

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

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