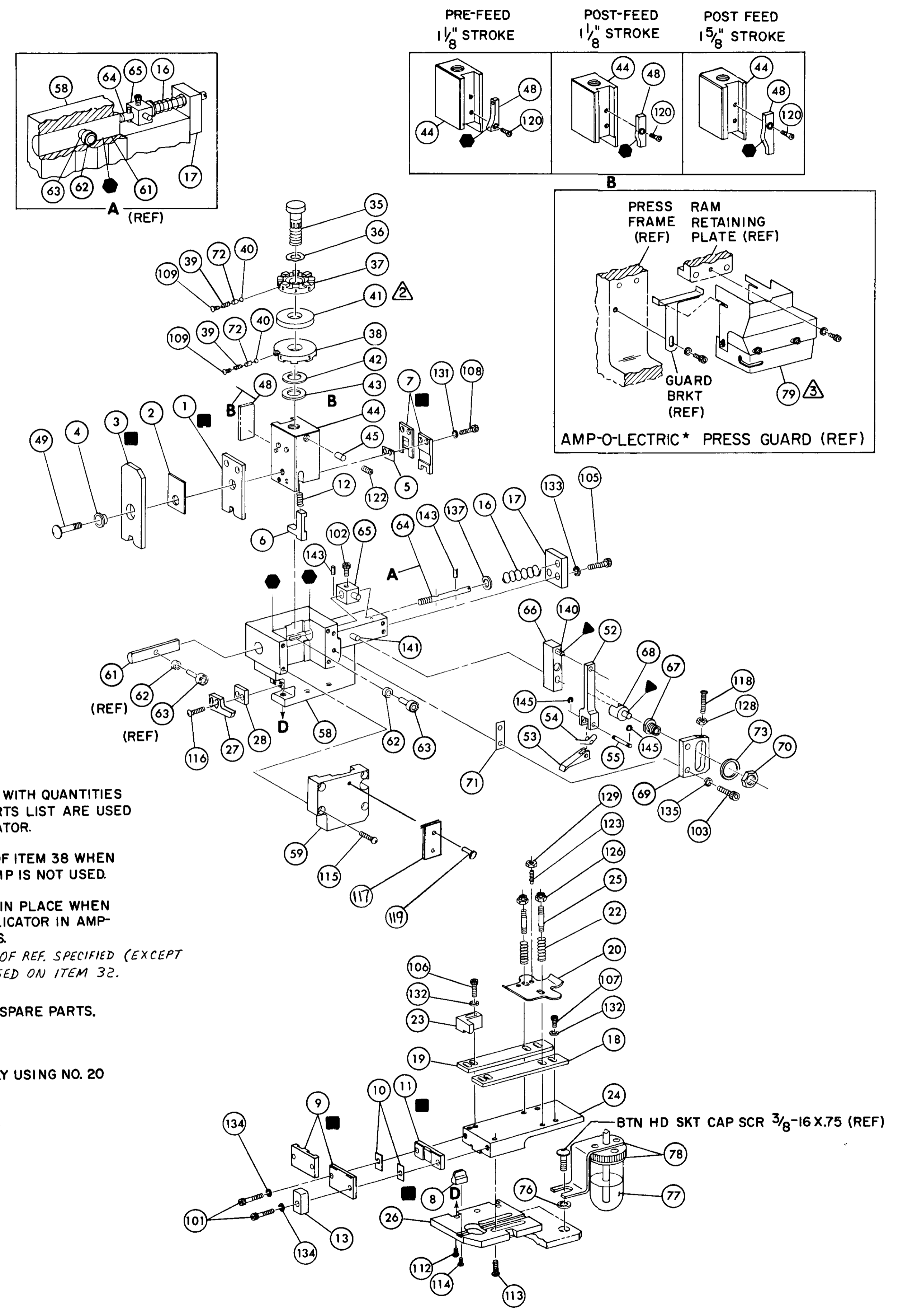


THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INC. IT IS SUBJECT TO CHANGE AND THE USER IS ADVISED TO CHECK FOR THE LATEST REVISION. BE CONTACTED FOR THE LATEST REVISION.



- 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 79) ARE USED ON ITEM 32.
- KEY:**
- RECOMMENDED SPARE PARTS.
 - LUBRICATE DAILY USING NO. 20 MACHINE OIL.
 - GREASE LIGHTLY.

REF	QTY	PART NO	DESCRIPTION	ITEM NO
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	145	REF 454220-1 CAP, RAM 59
REF	5-21028-1	PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD	144	REF 453736-1 HOUSING 58
REF	1-21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	143	
REF	1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	142	
REF	21899-4	WASHER, FLAT (5/16 DIA) SCR ADJ	141	REF 240624-1 PIN, FEED FINGER 55
REF	21024-5	WASHER, LOCK (NO 10) FEED ADJ PLATE	140	REF 691499-1 SPRING, FEED FINGER 54
REF	21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	139	REF 240635-1 FINGER, FEED 53
REF	21024-4	WASHER, LOCK (NO 8) STRIP GUIDE	138	REF 240634-1 LEVER, TERMINAL 52
REF	21024-4	WASHER, LOCK (NO 8) SHEAR BLADE	137	
REF	21018-4	NUT, HEX MACH (4-40) DRAG	136	
REF	21018-5	NUT, HEX MACH (6-32) FD ADJ PLATE	135	1 7-21002-9 BOLT, CRIMPER 49
REF	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	134	1 690501-3 CAM, POST FEED 1 1/2 STROKE 48
REF	4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	133	
REF	21009-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	132	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	131	1 690191-1 PLUG, NYLON 45
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	130	1 455674-1 RAM 44
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	129	1 690125-1 WASHER, LAMINATED 43
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	128	1 690124-1 WASHER, RAM 42
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	127	SPACER, DISC 41
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	126	2 23241-6 BALL, STEEL 40
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	125	2 690170-1 SPRING, COMPRESSION 39
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	124	1 690142-1 DISC, INSULATION 38
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	123	1 8-692155-7 DISC, WIRE 37
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	122	1 22480-5 WASHER, SPRING 36
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	121	1 690212-1 POST, RAM 35
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	120	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	119	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	118	1 458980-1 APPLICATOR, BASIC (SUB ASSY) 32
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	117	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	116	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	115	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	114	1 2-690451-1 SPACER, STRIPPER 28
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	113	1 240639-2 STRIPPER 27
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	112	REF 455676-1 PLATE, BASE 26
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	111	2 22354-8 DRAG, STUD 25
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	110	1 455678-1 PLATE, STRIP GUIDE 24
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	109	1 240825-4 PLATE, STRIP HOLD 23
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	108	2 4-22281-1 SPRING, DRAG 22
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	107	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	106	1 454177-1 DRAG, STOCK 20
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	105	1 454204-4 GUIDE, STRIP (REAR) 19
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	104	1 454204-4 GUIDE, STRIP (FRONT) 18
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	103	REF 454178-1 GUIDE, FEED ROD 17
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	102	REF 4-22284-9 SPRING, FEED RETURN 16
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	101	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	79	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	78	1 690481-5 SPACER, HOLD DOWN 13
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	77	1 23846-1 SPRING, HOLD DOWN 12
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	76	1 240644-1 PLATE, REAR SHEAR 11
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	75	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	74	1 1-690496-1 PLATE, FRONT SHEAR 9
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	73	1 3-683452-5 ANVIL 8
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	72	1 690474-5 BLADE, SLUG 7
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	71	1 4-455892-7 HOLD DOWN, TERMINAL 6
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	70	1 6-240641-8 SPACER, SHEAR BLADE 5
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	69	1 238009-1 SPACER, TUBULAR 4
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	68	1 1-456134-4 CRIMPER, INSULATION 3
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	67	1 455888-4 SPACER, INSULATION 2
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	66	1 3-456406-0 CRIMPER, WIRE 1
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	65	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	64	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	63	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	62	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	61	
REF	21007-2	SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	60	

CRIMPING DATA				APPLICATOR WILL APPLY	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	170177	
A	.070 (1.78)	#14			
B	.059 (1.50)	(2) #20, (1) #16 OR #20 & #18			
C	.053 (1.34)	#18			
D	.051 (1.30)	#20			
CRIMP	SIZE	TYPE	FEED	APPL INST	
WIRE	.090	F	.892	A1 8039	
INSUL	.140	F	(22.7)		
WIRE RANGE 20-14		INSULATION RANGE .087-.122 (2.2-3.0)		PRESS NO 565435-5	
REMARKS AMP-O-LECTRIC POST-FEED					

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