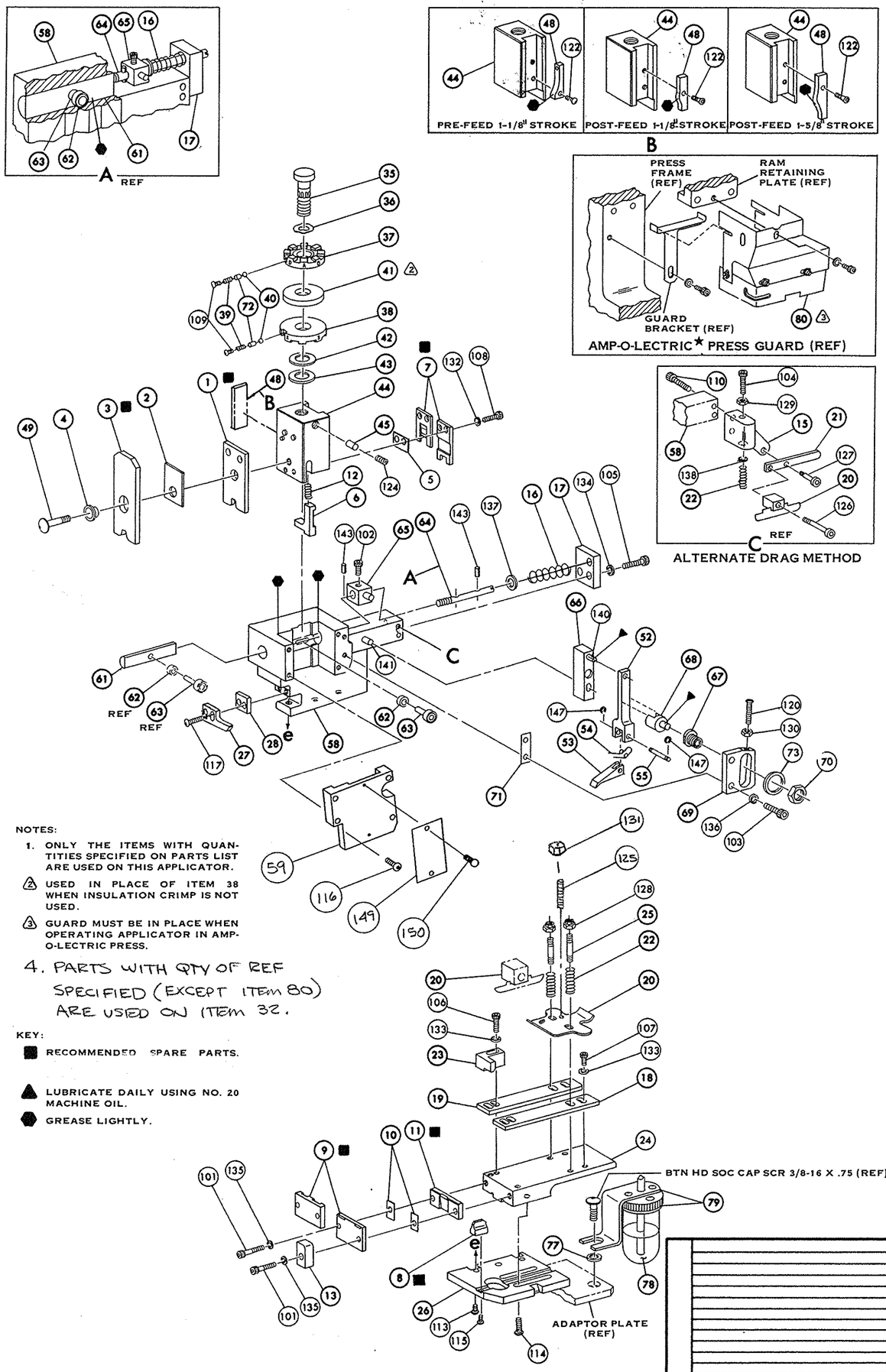

NOTES:

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. 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.

★TRADEMARK OF AMP INCORPORATED

REQ.	PART NO.	DESCRIPTION	NO.
			162
			161
			160
			159
			158
			157
			156
			155
			154
			153
			152
			151
2	21017-2	SCR, DRIVE (#2 x .19) ID PLATE	150
1	461264-1	PLATE, I.D.	149
			148
REF.	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	147
			146
			145
			144
REF.	5- 21028-1	PIN, SLOT SPG (.12 DIA x .50) FEED ADJ ROD	143
			142
REF	1- 21030-7	PIN, DOWEL (.187 DIA x 1.50) HOUSING	141
REF	1- 21030-1	PIN, DOWEL (.187 DIA x .50) LEVER	140
			139
—	22260-5	WASH, FLAT (NO. 6) DRAG SPRING	138
REF	21899-4	WASH, FLAT (NO. 5/16 DIA) SCR ADJ	137
REF	21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE	136
2	21024-5	WASH, LOCK (NO. 10) SHEAR PLATES	135
REF	21024-5	WASH, LOCK (NO. 10) FEED ROD GUIDE	134
4	21024-4	WASH, LOCK (NO. 8) STRIP GUIDE	133
2	21024-4	WASH, LOCK (NO. 8) SHEAR BLADE	132
2	21018-4	NUT, HEX MACH (4-40) DRAG	131
REF	21068-5	NUT, HEX MACH (6-32) FEED ADJ PLATE	130
—	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	129
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUDS	128
—	5- 21004-7	SCR, SKT HD SHLD (.250 DIA x .25) DRAG ARM	127
—	21004-5	SCR, SKT HD SHLD (.250 DIA x 1.00) DRAG	126
2	4-21078-8	SCR, SKT SET OVAL POINT (4-40 X 75) DRAG	125
1	21009-2	SCR, SKT SET (1/4-20 x 25) NYLOK RAM	124
			123
1	2- 21003-0	SCR, FLAT HD SOC CAP (6-32 x .50) CAM	122
			121
REF	3- 21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ	120
			119
			118
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER	117
REF	2- 21002-9	SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP	116
1	22733-8	SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL	115
4	3- 21002-3	SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL	114
REF	1-24073-9	SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE	113
			112
			111
—	2- 21000-4	SCR, SKT HD CAP (6-32 x 1.00) DRAG ADAPTOR	110
1	23030-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC	109
2	2-21000-6	SCR, SKT HD CAP (8-32 x .38) SHEAR BLADE	108
3	7-21000-4	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE	107
1	7-21000-4	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE	106
REF	3- 21000-7	SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE	105
—	3- 21000-9	SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING	104
REF	3- 21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE	103
REF	3- 21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK	102
2	3- 21000-8	SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES	101
REF	455745-1	GUIDE WINDOW (3)	80
—	465184-9	LUBRICATOR ASSY	79
—	22014-1	OIL SYNTHETIC	78
—	454406-1	SPACER, LUBRICATOR BRACKET	77
			76
			75
			74
REF	458109-1	WASHER, FLAT (SPECIAL)	73
1	690603-1	SPRING, ASSIST	72

REQ.	PART NO.	DESCRIPTION	NO.
REF	690517-1	SPACER	71
1	22594-8	HEX. NUT	70
1	240628-1	PLATE, ADJ	69
1	240626-1	SHAFT, PIVOT	68
1	240633-1	BUSHING	67
1	455680-1	LEVER, INTERMEDIATE	66
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
REF	454398-1	ROD, FEED	61
			60
REF	454220-1	CAP, RAM	59
REF	453736-1	HOUSING	58
			57
			56
REF	240624-1	PIN, FEED FINGER	55
REF	691499-1	SPRING, FEED FINGER	54
REF	240635-1	FINGER, FEED	53
REF	240634-1	LEVER, TERMINAL	52
			51
			50
1	7-21002-9	BOLT, CRIMPER	49
1	690501-3	CAM, POSTFEED 1- 1/8 STROKE	48
			47
			46
1	690191-1	PLUG, NYLON	45
1	455674-1	RAM	44
1	690125-1	WASHER, LAMINATED	43
1	690124-1	WASHER, RAM	42
1	690223-1	SPACER, DISC	41
1	23241-6	BALL, STEEL	40
1	690170-1	SPRING, COMPRESSION	39
		DISC, INSULATION	38
1	2-690141-9	DISC, WIRE	37
1	22480-5	WASHER, SPRING	36
1	690212-1	POST, RAM	35
			34
			33
1	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
			31
			30
			29
1	3-690451-2	SPACER, STRIPPER	28
1	240639-1	STRIPPER	27
REF	455676-1	PLATE, BASE	26
2	22354-8	DRAG, STUD	25
1	455678-1	PLATE, STRIP GUIDE	24
		PLATE, STRIP HOLD	23
2	4-222881-1	SPRING, DRAG	22
—	240636-1	LEVER, DRAG	21
1	454177-1	DRAG, STOCK	20
1	458030-3	GUIDE, STRIP REAR	19
1	458031-3	GUIDE, STRIP FRONT	18
REF	454178-1	GUIDE, FEED ROD	17
REF	4-22284-9	SPRING, FEED RETURN	16
—	454665-1	ADAPTOR, DRAG	15
			14
		SPACER, HOLD DOWN	13
		SPRING, HOLD DOWN	12
1	240644-1	PLATE, REAR SHEAR ■	11
2	2406457	SPACER, SHEAR PLATE	10
1	240642-1	PLATE, FRONT SHEAR ■	9
1	2-240654-3	ANVIL ■	8
1	1-240651-3	BLADE, SLUG ■	7
		HOLD DOWN	6
1	4-240641-0	SPACER, SHEAR BLADE	5
		SPACER, TUBULAR, INS CRIMPER	4
		CRIMPER, INSULATION ■	3
		SPACER, INSULATION	2
1	1-456411-4	CRIMPER, WIRE ■	1

TERM APPL SPEC 114-2084

CRIMPING DATA

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.089	14	
B	.082	16	
C	.078	18	
D	NOT	USED	

	SIZE	TYPE	FEED	PRESS REF.
CRIMP WIRE	.140	F	.562	565435-5
INSULATION	—	—		

INSULATION RANGE —

WIRE RANGE 18-14

APPLICATOR INSTRUCTION AI 8039

REMARKS AMP-O-LECTRIC POST FEED

I.D. PLATE (REF): 461264-1

THIS APPLICATOR WILL APPLY

	40577
	40705
	40819
	41473
	350435

LTR	REVISION RECORD	ECN	DR/CK	DATE
C	ECN 0150-05532-03	MY/AE		5-03
B	ECN A160688	NG/GE		11-88
A	REV. PER ECN R-5509	DJ/JH		2.14.84

SET UP SAGE 458638-1 | LAYOUT NO. 237

DRAWN J.E. BEATTY 5-6-80 | APPROVED

CHECKED J.K. 5-12-80 | REL. CMV 5/16/80

AMP INCORPORATED HARRISBURG, PENNA.

LOC A C | NO. 687810-6 | REV. C

SCALE NONE | NAME MINIATURE QUICK CHANGE APPLICATOR END-FEED (SPADE)

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

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AMP 3076-1

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