



**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. ITEMS 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.

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REF	QTY	PART NO	DESCRIPTION	ITEM NO	REF	QTY	PART NO	DESCRIPTION	ITEM NO
21045-3			RING, RETAINING 'C' (.187 DIA) FEED PIN	145	454220-1			CAP, RAM	59
5-21028-1			PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD	144	453736-1			HOUSING	58
1-21030-7			PIN, DOWEL (.187 DIA X 1.50) HOUSING	143					57
1-21030-1			PIN, DOWEL (.187 DIA X .50) LEVER	142					56
22260-5			WASHER, FLAT (NO 6) DRAG SPRING	141	240624-1			PIN, FEED FINGER	55
21899-4			WASHER, FLAT (5/16 DIA) SCR ADJ	140	691499-1			SPRING, FEED FINGER	54
21024-5			WASHER, LOCK (NO 10) FEED ADJ PLATE	139	240635-1			FINGER, FEED	53
21024-5			WASHER, LOCK (NO 10) SHEAR PLATES	138	240634-1			LEVER, TERMINAL	52
21024-5			WASHER, LOCK (NO 10) FEED ROD GUIDE	137					51
21024-4			WASHER, LOCK (NO 8) STRIP GUIDE	136					50
21024-4			WASHER, LOCK (NO 8) SHEAR BLADE	135	7-21002-9			BOLT, CRIMPER	49
21018-4			NUT, HEX MACH (4-40) DRAG	134	690602-5			CAM, PRE FEED 1 1/8 STROKE	48
21068-5			NUT, HEX MACH (6-32) FD ADJ PLATE	133					47
21018-7			NUT, HEX MACH (10-32) DRAG SPRING	132					46
21022-2			NUT, HEX SELF-LKG (8-32) DRAG STUD	131	690191-1			PLUG, NYLON	45
5-21004-7			SCR, SKT HD SHLD (250 DIA X .50) DRAG ARM	130	455674-2			RAM	44
21004-5			SCR, SKT HD SHLD (250 DIA X 1.00) DRAG	129	690125-1			WASHER, LAMINATED	43
4-21078-8			SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	128	690124-1			WASHER, RAM	42
22651-9			SCR, SKT SET (1/4-20 X 25) (LOC-WEL) RAM	127				SPACER, DISC	41
2-21003-0			SCR, FLAT HD SKT CAP (6-32 X .50) CAM	126	23241-6			BALL, STEEL	40
3-21064-2			SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	125	690170-1			SPRING, COMPRESSION	39
2-21002-2			SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	124	690142-1			DISC, INSULATION	38
2-21002-9			SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	123	1-690141-0			DISC, WIRE	37
24073-2			SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	122	22480-5			WASHER, SPRING	36
3-21002-3			SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	121	690212-1			POST, RAM	35
1-24073-9			SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	120					34
2-21000-4			SCR, SKT HD CAP (6-32 X 1.00) DRAG ADAPTOR	119					33
3-23657-8			SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	118	458980-1			APPLICATOR, BASIC (SUB ASSY)	32
7-21000-4			SCR, SKT HD CAP (8-32 X .31) SHEAR BLADE	117					31
3-21000-4			SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	116					30
7-21000-4			SCR, SKT HD CAP (8-32 X .31) STRIP GUIDE	115					29
3-21000-7			SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE	114	3-690451-2			SPACER, STRIPPER	28
3-21000-9			SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING	113	240639-1			STRIPPER	27
3-21000-6			SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	112	455676-1			PLATE, BASE	26
3-21000-4			SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	111	22354-8			DRAG, STUD	25
3-21000-8			SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE	110	455678-9			PLATE, STRIP GUIDE	24
455745-1			GUARD, WINDOW	109	4-22281-1			SPRING, DRAG	23
465184-9			LUBRICATOR ASSY	108	240636-1			LEVER, DRAG	22
455985-1			OIL, LUBRICATING	107	454177-1			DRAG, STOCK	20
454406-1			SPACER, LUB BRACKET	106	458030-2			GUIDE, STRIP (REAR)	19
458109-1			WASHER, FLAT (SPECIAL)	105	458031-2			GUIDE, STRIP (FRONT)	18
690603-1			SPRING, ASSIST	104	454178-1			GUIDE, FEED ROD	17
690517-1			SPACER	103	4-22284-9			SPRING, FEED RETURN	16
22594-8			NUT, HEX	102				ADAPTER, DRAG	15
240628-1			PLATE, ADJ	101					14
240626-1			SHAFT, PIVOT	100	691901-1			PLATE, REAR SHEAR	11
240633-1			BUSHING	99	1-240645-6			SPACER, SHEAR PLATE	10
455680-1			LEVER, INTERMEDIATE	98	240642-3			PLATE, FRONT SHEAR	9
240629-1			BLOCK, PIVOT	97	2-240654-2			ANVIL	8
240632-2			SCREW, ADJ	96	691157-4			BLADE, SLUG	7
240659-3			PIN, CAM ROLLER	95	5-240641-9			HOLD DOWN, TERMINAL	6
240658-1			CAM, ROLLER	94	238009-1			SPACER, SHEAR BLADE	5
454398-1			ROD, FEED	93	3-456135-9			SPACER, TUBULAR	4
				92	455888-4			CRIMPER, INSULATION	3
				91	456409-2			SPACER, INSULATION	2
				90				CRIMPER, WIRE	1

REMARKS		NO	REV
APPL USED ON MACHINE PART NO		TO APPLY TERMINAL	
CUSTOMER NAME	MACH SERIAL NO	DISTRIBUTION	
ADDRESS	APPL SERIAL NO	ORIGINAL	
CITY	PURCHASE ORDER	CUSTOMER COPY	
	ENG APP	FIELD ENG COPY	

CRIMPING DATA					APPLICATOR WILL APPLY	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH			
A	.058	16				160018
B	.055	18				
C	NOT USED					
D	NOT USED					
CRIMP	SIZE	TYPE	FEED	APPL INST		
WIRE	.120	F	.504	A18039		
INSUL	.120	O				
WIRE RANGE	18-16	INSULATION RANGE	PRESS NO			
		.070-.090	565435-5			
REMARKS AMP-O-LECTRIC PRE FEED						

SETUP PAGE 10-1	458638-1 207	DR 3-31-79 APP T-3	AMP INCORPORATED Harrisburg, Pa.
DATE 4-16 REL 1984	LOC A D NO 466253-2	REV B	
NAME MINIATURE QUICK CHANGE APPLICATOR			
END FEED RING			