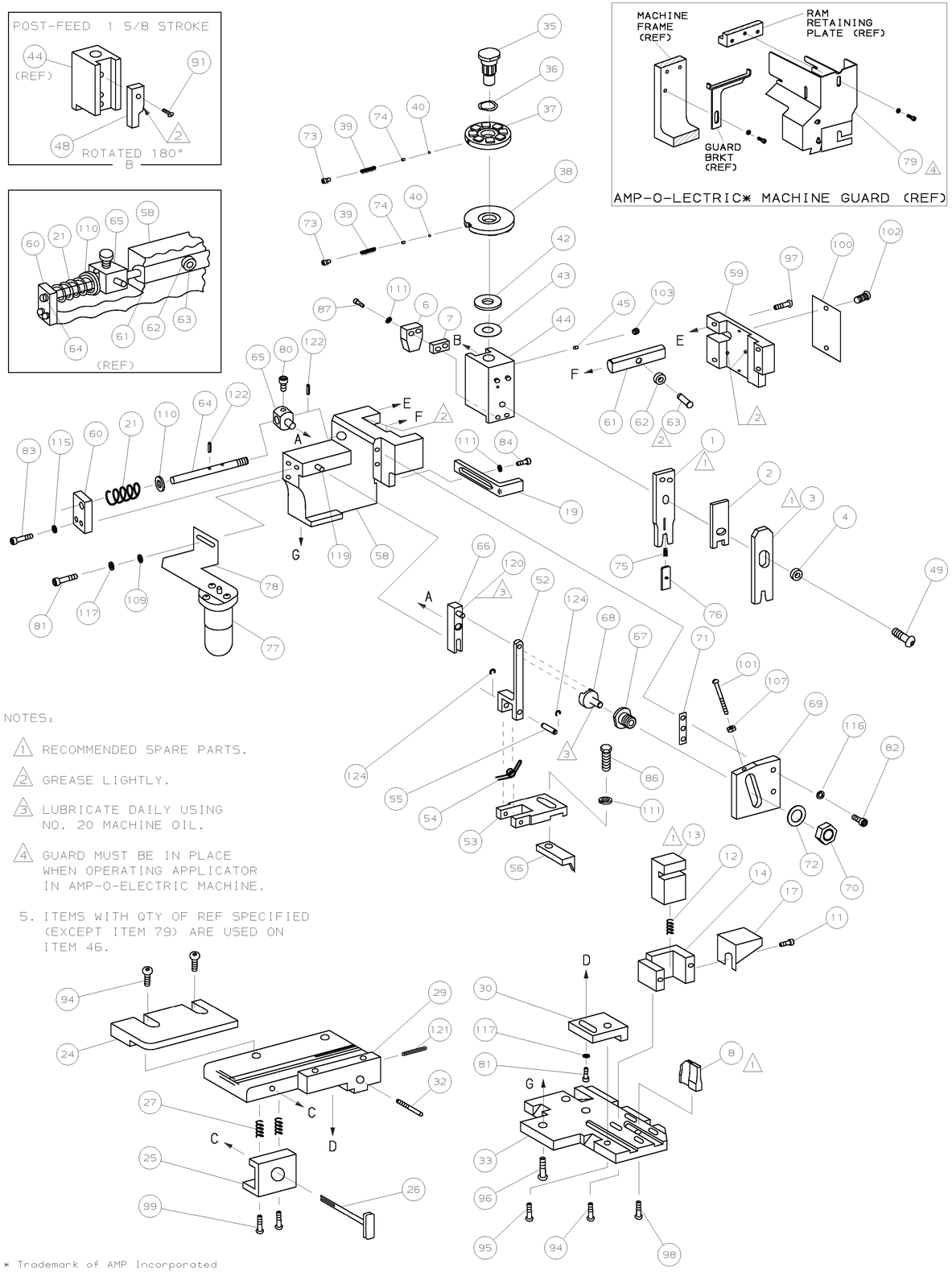


NOTES:

1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. LUBRICATE DAILY USING NO. 20 MACHINE OIL.
4. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-O-ELECTRIC MACHINE.
5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEM 79) ARE USED ON ITEM 46.

| QTY | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|
| REF | 21045-3 | RING,RET "C"(.187ø)FEED FINGER PIN | 124 |
| | | | 123 |
| REF | 5-21028-1 | PIN,SLT SPR(.125ø×.50)ADJ ROD | 122 |
| 1 | 4-21028-0 | PIN,SLT SPR(.093ø×.75)ST GUIDE PL | 121 |
| REF | 1-21030-1 | PIN,DOWEL(.187ø×.50)LEVER | 120 |
| REF | 1-21030-6 | PIN,DOWEL(.187ø×1.25)HOUSING | 119 |
| | | | 118 |
| 2 | 21024-5 | WASHER,LOCK(NO.10)ADJ BLOCK | 117 |
| REF | 21024-5 | WASHER,LOCK(NO.10)ADJ PLATE | 116 |
| REF | 21024-5 | WASHER,LOCK(NO.10)FEED GUIDE ROD | 115 |
| | | | 114 |
| | | | 113 |
| | | | 112 |
| 4 | 21024-4 | WASHER,LOCK(NO.8)STRIPPER | 111 |
| REF | 21899-4 | WASHER,FLAT(5/16 DIA)SCREW ADJ | 110 |
| 1 | 21899-2 | WASHER,FLAT(NO.10)LUB ASSY | 109 |
| | | | 108 |
| REF | 21018-5 | NUT,HEX(6-32)FEED ADJ | 107 |
| | | | 106 |
| | | | 105 |
| | | | 104 |
| 1 | 21009-2 | SCR,SKT SET(1/4-20×.25LOC-WEL)RAM | 103 |
| 2 | 21017-2 | SCR,DRIVE(#2×.19)ID PLATE | 102 |
| REF | 6-23715-5 | SCR,PAN HD(6-32×1.50)FEED ADJ | 101 |
| 1 | 461264-1 | PLATE, IDENTIFICATION | 100 |
| 2 | 2-21002-9 | SCR,BHC(10-32×.75)DRAG | 99 |
| 1 | 22733-8 | SCR,BHC(8-32×.38LOC-WEL)ANVIL | 98 |
| REF | 2-21002-9 | SCR,BHC(10-32×.75)CAP | 97 |
| REF | 2-22733-8 | SCR,BHC(1/4-20×.62)HOUSING | 96 |
| REF | 2-21002-7 | SCR,BHC(10-32×.50)SG ADJ BLOCK | 95 |
| 4 | 2-21002-2 | SCR,BHC(8-32×.50)SHEAR | 94 |
| | | | 93 |
| | | | 92 |
| 1 | 1-21002-7 | SCR,BHC(6-32×.38)CAM | 91 |
| | | | 90 |
| | | | 89 |
| | | | 88 |
| 2 | 2-21000-6 | SCR,SKT CAP(8-32×.38)DEP-HOLD DOWN | 87 |
| 1 | 2-22603-0 | SCR,HEX HEAD(8-32×.31)FEED FINGER | 86 |
| | | | 85 |
| 1 | 2-21000-7 | SCR,SKT CAP(8-32×.50)STRIPPER | 84 |
| REF | 3-21000-7 | SCR,SKT CAP(10-32×.75)FEED ROD GD | 83 |
| REF | 3-21000-6 | SCR,SKT CAP(10-32×.62)FEED ADJ BLK | 82 |
| 2 | 3-21000-4 | SCR,SKT CAP(10-32×.38)SG ADJ BL | 81 |
| REF | 3-21000-4 | SCR,SKT CAP(10-32×.38)PIVOT BLOCK | 80 |
| REF | 455755-1 | GUARD, GUARD (4) | 79 |
| | | | 78 |
| REF | 852931-2 | OIL, LUBRICATING | 77 |
| 1 | 693183-1 | WIRE DEPRESSOR | 76 |
| 1 | 1-23147-2 | SPRING, COMPRESSION | 75 |
| 2 | 690603-1 | SPRING, ASSIST | 74 |
| 2 | 23030-1 | SCR,SKT CAP(6-32×.25)CP DISC | 73 |
| REF | 458109-1 | WASHER, SPECIAL | 72 |
| REF | 690517-1 | SPACER | 71 |
| REF | 22594-8 | NUT, HEX | 70 |
| REF | 240628-1 | PLATE, ADJUSTMENT | 69 |
| REF | 240626-1 | SHAFT, PIVOT | 68 |
| REF | 240633-1 | BUSHING | 67 |
| REF | 455680-1 | LEVER, INTERMEDIATE | 66 |
| REF | 240629-1 | BLOCK, PIVOT | 65 |
| REF | 240632-2 | SCREW, ADJUSTMENT FEED ROD | 64 |
| REF | 240659-3 | PIN, CAM ROLLER | 63 |
| REF | 240658-1 | ROLLER, CAM | 62 |
| REF | 454398-2 | ROD, FEED | 61 |
| REF | 454178-1 | GUIDE, FEED ROD | 60 |

| QTY | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|
| REF | 454220-1 | CAP, HOUSING | 59 |
| REF | 454485-1 | HOUSING | 58 |
| | | | 57 |
| 1 | 1-694433-3 | PAWL, FEED | 56 |
| REF | 240624-1 | PIN, FEED FINGER | 55 |
| REF | 691499-1 | SPRING, FEED FINGER | 54 |
| REF | 690541-1 | FINGER, FEED | 53 |
| REF | 455679-1 | LEVER, TERMINAL FEED ARM | 52 |
| | | | 51 |
| | | | 50 |
| 1 | 7-21002-9 | BOLT, CRIMPER(5/16-24×1.00) | 49 |
| 1 | 690501-4 | CAM, POST-FEED 1 5/8 STROKE | 48 |
| | | | 47 |
| 1 | 459456-1 | APPLICATOR, BASIC (SUBASSY) | 46 |
| 1 | 690191-1 | PLUG, NYLON | 45 |
| 1 | 455673-1 | RAM | 44 |
| 1 | 690125-1 | WASHER, LAMINATED | 43 |
| 1 | 1-690124-3 | WASHER, RAM | 42 |
| | | | 41 |
| 2 | 23241-6 | BALL, STEEL | 40 |
| 2 | 690170-1 | SPRING, COMPRESSION | 39 |
| 1 | 690142-4 | DISC, INSULATION | 38 |
| 1 | 4-692155-0 | DISC, WIRE | 37 |
| 1 | 22480-5 | WASHER, SPRING | 36 |
| 1 | 690212-1 | POST, RAM | 35 |
| | | | 34 |
| REF | 455675-1 | PLATE, BASE | 33 |
| 1 | 690432-3 | SCREW, ADJUSTMENT | 32 |
| | | | 31 |
| REF | 455689-1 | BLOCK, STRIP GUIDE ADJ | 30 |
| 1 | 856172-1 | PLATE, STRIP GUIDE | 29 |
| | | | 28 |
| 2 | 1-22284-0 | SPRING, DRAG | 27 |
| 1 | 690546-1 | LEVER, DRAG RELEASE | 26 |
| 1 | 1-690754-7 | DRAG, STOCK | 25 |
| 1 | 856167-1 | GUIDE, STRIP (REAR) | 24 |
| | | | 23 |
| | | | 22 |
| REF | 4-22284-9 | SPRING, FEED RETURN | 21 |
| | | | 20 |
| 1 | 1-690472-3 | STRIPPER | 19 |
| | | | 18 |
| 1 | 691668-1 | GUARD, CHIP (REAR) | 17 |
| | | | 16 |
| | | | 15 |
| 1 | 690462-1 | HOLDER, SHEAR (REAR) | 14 |
| 1 | 690463-1 | SHEAR, FLOAT (REAR) | 13 |
| 1 | 5-22280-0 | SPRING, SHEAR | 12 |
| 1 | 690461-1 | STOP, SHEAR | 11 |
| | | | 10 |
| | | | 9 |
| 1 | 813339-2 | ANVIL (1) | 8 |
| 1 | 1-240641-9 | SPACER, DEPRESSOR (REAR) | 7 |
| 1 | 690468-2 | DEPRESSOR, SHEAR (REAR) | 6 |
| | | | 5 |
| 1 | 1-238009-6 | SPACER, TUBULAR | 4 |
| 1 | 2-683453-0 | CRIMPER, INSULATION (1) | 3 |
| 1 | 693184-6 | SPACER, CRIMPER | 2 |
| 1 | 817331-9 | CRIMPER, WIRE (1) | 1 |

CRIMPING DATA

| PAD LTR | CRIMP HEIGHT | WIRE SIZE | WIRE STRIP LENGTH |
|---|---|---|---|
| A | .030 | 26 | |
| B | .027 | 28 OR 30 | |
| C | NOT | USED | |
| D | NOT | USED | |

| CRIMP | SIZE | TYPE | FEED | APPL INST |
|---|---|---|---|---|
| WIRE | .042 | F | .295 | AI 8040 |
| INSUL | .070 | F | | |

| WIRE RANGE | INSULATION RANGE | MACHINE NO |
|---|---|---|
| 30-26 | .039-.059 | - |

APPLICATOR WILL APPLY: 170355-1

REMARKS

AMPOMATOR
POST FEED

| P | F | LTR | REVISION RECORD | APP | DATE |
|---|---|---|---|---|---|
| D | | 0150-0545-00 | CE | AUG00 |
| C1 | | 0150-9161-99 | CE | 2-99 |
| C | | 0150-6782-96 | CE | 1-96 |
| B | | 0150-6594-96 | CE | 1-96 |
| A | | ECN A-350492 | - | - |

SET UP GAGE 458637-1 | 10-1 L1419
DR 4-24-91 P.MATHIAS | APP 5-2-91 B. WOLFE
CHK 4-31-91 P. MARTZ | REL 5-3-91 MCPHERSON

AMP — AMP INCORPORATED Harrisburg, Pa.

LOC A | D | NO 567412-1 | REV D

NAME MINIATURE QUICK CHANGE APPLICATOR SIDE FEED (CONTACT LOW PROFILE EI SERIES CONNECTOR)

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

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