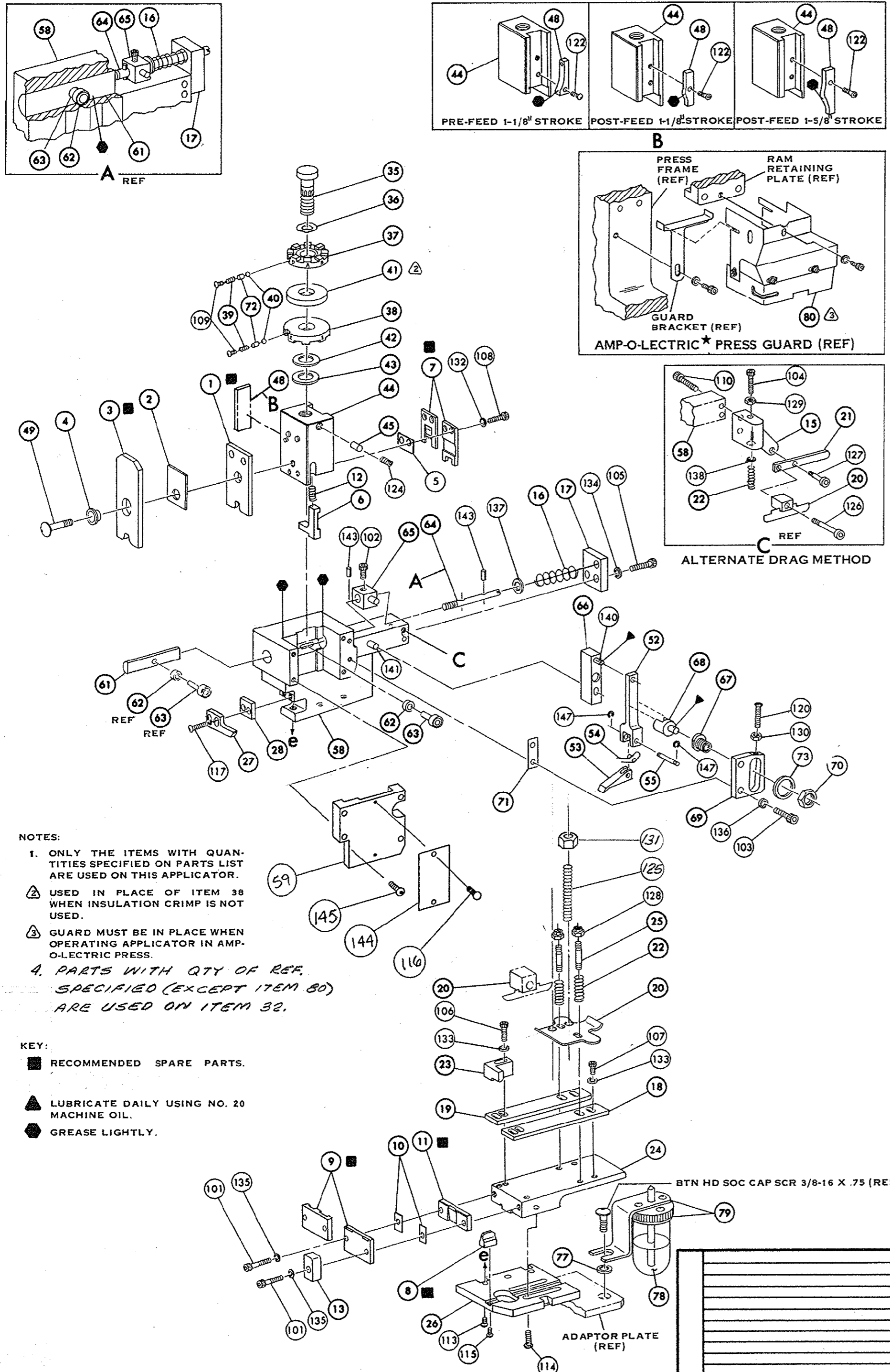


THIS IS A CONTROLLED DOCUMENT.



**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 80) ARE USED ON ITEM 32.

**KEY:**

- RECOMMENDED SPARE PARTS.
- LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- GREASE LIGHTLY.

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3076-1

REF	PART NO.	DESCRIPTION	NO.	REQ.	PART NO.	DESCRIPTION	NO.
	162	REF	690517-1		SPACER	71	
	161		22594-8		HEX, NUT	70	
	160		240628-1		PLATE, ADJ	69	
	159		240626-1		SHAFT, PIVOT	68	
	158		240633-1		BUSHING	67	
	157		455680-1		LEVER, INTERMEDIATE	66	
	156		240629-1		BLOCK, PIVOT	65	
	155		240632-2		SCREW, ADJ	64	
	154		240659-3		PIN, CAM ROLLER	63	
	153		240658-1		CAM, ROLLER	62	
	152	REF	454398-1		ROD, FEED	61	
	151					60	
	150	REF	454220-1		CAP, RAM	59	
	149	REF	453736-1		HOUSING	58	
	148					57	
	147					56	
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN				55	
	146	REF	240624-1		PIN, FEED FINGER	54	
2	21017-2	SCR, DRIVE (#2 x .19)			SPRING, FEED FINGER	53	
1	461264-1	PLATE, ID			FINGER, FEED	52	
REF	5-21028-1	PIN, SLOT SPG (.12 DIA x .50) FEED ADJ ROD			LEVER, TERMINAL	51	
	142					50	
REF	1-21030-7	PIN, DOWEL (.187 DIA x 1.50) HOUSING				49	
REF	1-21030-1	PIN, DOWEL (.187 DIA x .50) LEVER			BOLT, CRIMPER	48	
	140		7-21002-9			47	
	139		690602-5		CAM, PRE FEED 1-1/8 STROKE	46	
	138					45	
	137					44	
REF	22260-5	WASH, FLAT (NO. 6) DRAG SPRING				43	
REF	21899-4	WASH, FLAT (NO. 5/16 DIA) SCR ADJ				42	
REF	21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE			690191-1	PLUG, NYLON	41
2	21024-5	WASH, LOCK (NO. 10) SHEAR PLATES			455674-1	RAM	40
REF	21024-5	WASH, LOCK (NO. 10) FEED ROD GUIDE			690125-1	WASHER, LAMINATED	39
5	21024-4	WASH, LOCK (NO. 8) STRIP GUIDE			690124-1	WASHER, RAM	38
2	21024-4	WASH, LOCK (NO. 8) SHEAR BLADE				SPACER, DISC	37
REF	21018-4	NUT, HEX MACH (4-40) DRAG			23241-6	BALL, STEEL	36
REF	21068-5	NUT, HEX MACH (6-32) FEED ADJ PLATE			690170-1	SPRING, COMPRESSION	35
	21018-7	NUT, HEX MACH (10-32) DRAG SPRING			690142-1	DISC, INSULATION	34
	21022-2	NUT, SELF-LKG (8-32) DRAG STUDS			7-690692-9	DISC, WIRE	33
	5-21004-7	SCR, SKT HD SHLD (.250 DIA x .25) DRAG ARM			22480-5	WASHER, SPRING	32
	127						31
	126						30
	125						29
2	4-21078-8	SCR, SKT SET DUAL PT (4-40 x .75) DRAG			690212-1	POST, RAM	28
1	21009-2	SCR, SKT SET (1/4-20 x .25) NYLOK RAM					27
	124						26
	123				458980-1	APPLICATOR, BASIC (SUB ASSY)	25
1	1-21002-7	SCR, BTN HD SOC CAP (6-32 x .38) CAM					24
	122						23
	121						22
REF	3-21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ					21
	119				3-690451-2	SPACER, STRIPPER	20
	118				240639-1	STRIPPER	19
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER			455676-1	PLATE, BASE	18
REF	2-21002-9	SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP			22354-8	DRAG, STUD	17
1	22733-8	SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL			455678-1	PLATE, STRIP GUIDE	16
4	3-21002-3	SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL			240825-2	PLATE, STRIP HOLD	15
REF	1-24073-9	SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE			4-22281-1	SPRING, DRAG	14
	112				240636-1	LEVER, DRAG	13
	111				454177-1	DRAG, STOCK	12
	110				454204-1	GUIDE, STRIP REAR	11
2	23030-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC			454204-1	GUIDE, STRIP FRONT	10
2	2-21000-6	SCR, SKT HD CAP (8-32 x .38) SHEAR BLADE			454178-1	GUIDE, FEED ROD	9
3	7-21000-4	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE			4-22284-9	SPRING, FEED RETURN	8
2	2-21000-8	SCR, SKT HD CAP (8-32 x .62) STRIP GUIDE			454665-1	ADAPTOR, DRAG	7
REF	3-21000-7	SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE					6
REF	3-21000-9	SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING			690481-3	SPACER, HOLD DOWN	5
REF	3-21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE			23846-1	SPRING, HOLD DOWN	4
REF	3-21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK			240644-1	PLATE, REAR SHEAR	3
2	3-21000-8	SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES				SPACER, SHEAR PLATE	2
REF	455745-1	GUARD, WINDOW			690496-1	PLATE, FRONT SHEAR	1
	80				2-240655-4	ANVIL	
	465184-9	LUBRICATOR ASSY			690474-6	BLADE, SLUG	
	22014-1	OIL SYNTHETIC			1-455892-9	HOLD DOWN	
	454406-1	SPACER, LUBRICATOR BRACKET			3-240641-9	SPACER, SHEAR BLADE	
	79				238009-1	SPACER, TUBULAR, INS CRIMPER	
	78				1-456134-2	CRIMPER, INSULATION	
	77				455888-7	SPACER, INSULATION	
	76				1-456403-5	CRIMPER, WIRE	
	75						
	74						
	73						
	72						
REF	458109-1	WASHER, FLAT (SPECIAL)					
2	690603-1	SPRING, ASSIST					

CRIMPING DATA				THIS APPLICATOR WILL APPLY
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	42294
A	.049	#18		60291
B	.043	#20		60532
C	.040	#22		60636
D	NOT USED			60729
CRIMP SIZE	TYPE	FEED	PRESS REF.	61030
WIRE	.062	F		61158
INSULATION	.155	F	.705	61639
INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION		61923
.120-.140	22-18	#8039		62712
REMARKS				62930
AMP-O-LECTRIC PRE FEED				63246
TERM APPL SPEC 114-2036				63568

F ECR-06-00242	11/11/06	SET UP GAGE	458638-1	LAYOUT NO.	106	AMP INCORPORATED HARRISBURG, PENNA.
E 0150-7552-97	12/27/07	DRAWN	12/15/73	APPROVED	12-523	
D 0150-6433-97	11/12/07	CHECKED	12/15/73	REL.	12/15/73	LOC A C NO. 687967-3 REV. F
C1 ECN A-316791	11/12/07	SCALE	1:1	NAME		MINIATURE QUICK CHANGE APPLICATOR
C2 ECN A160428	11/12/07	DATE	12/27/07			END-FEED (.110 FASTON)
B REV PER ECN R-5326	11/12/07					CUSTOMER AND ASSEMBLY DRAWING
A1 REV PER ECN	11/12/07					
A REV PER ECN	11/12/07					

NO. 687967-3