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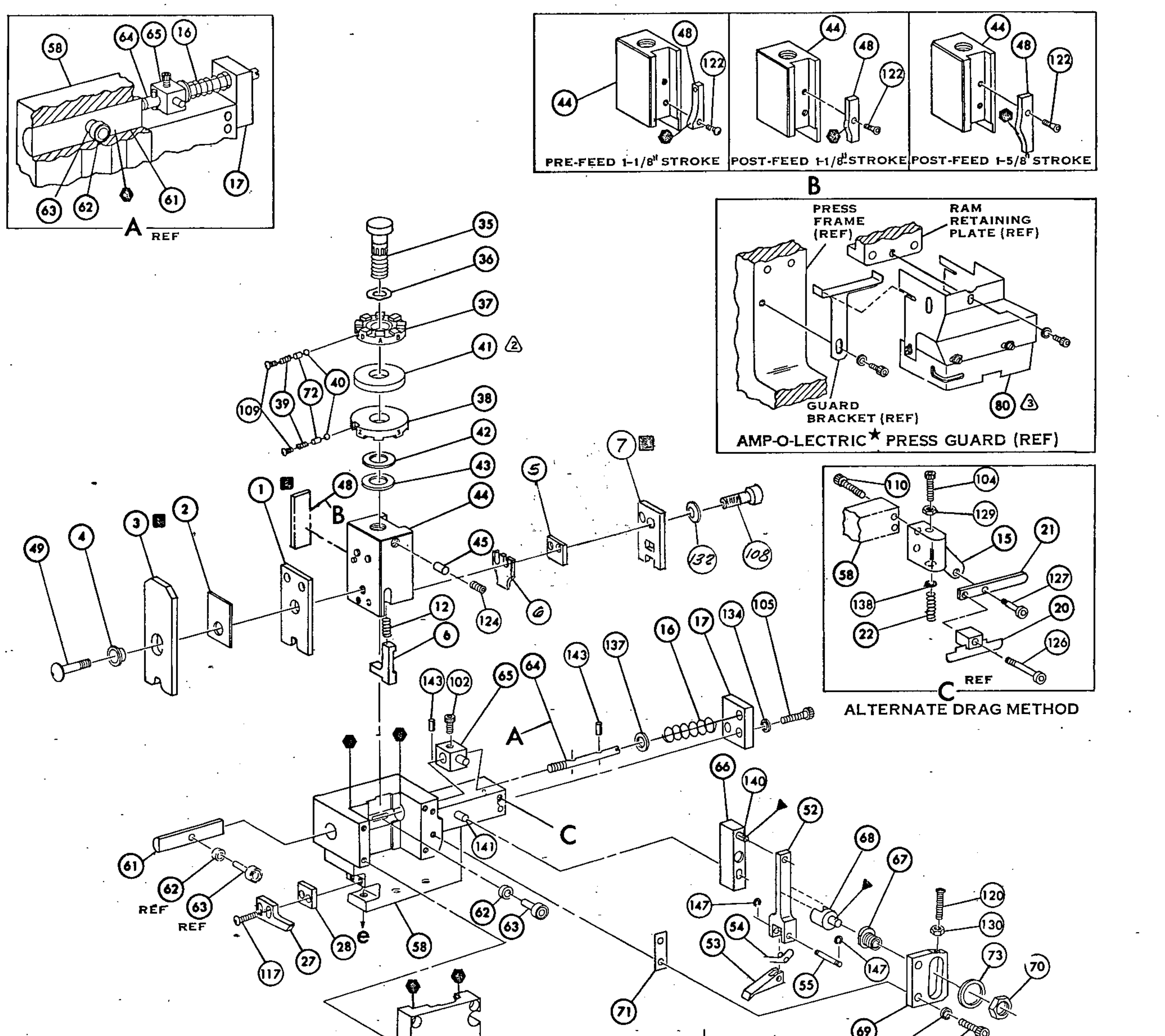

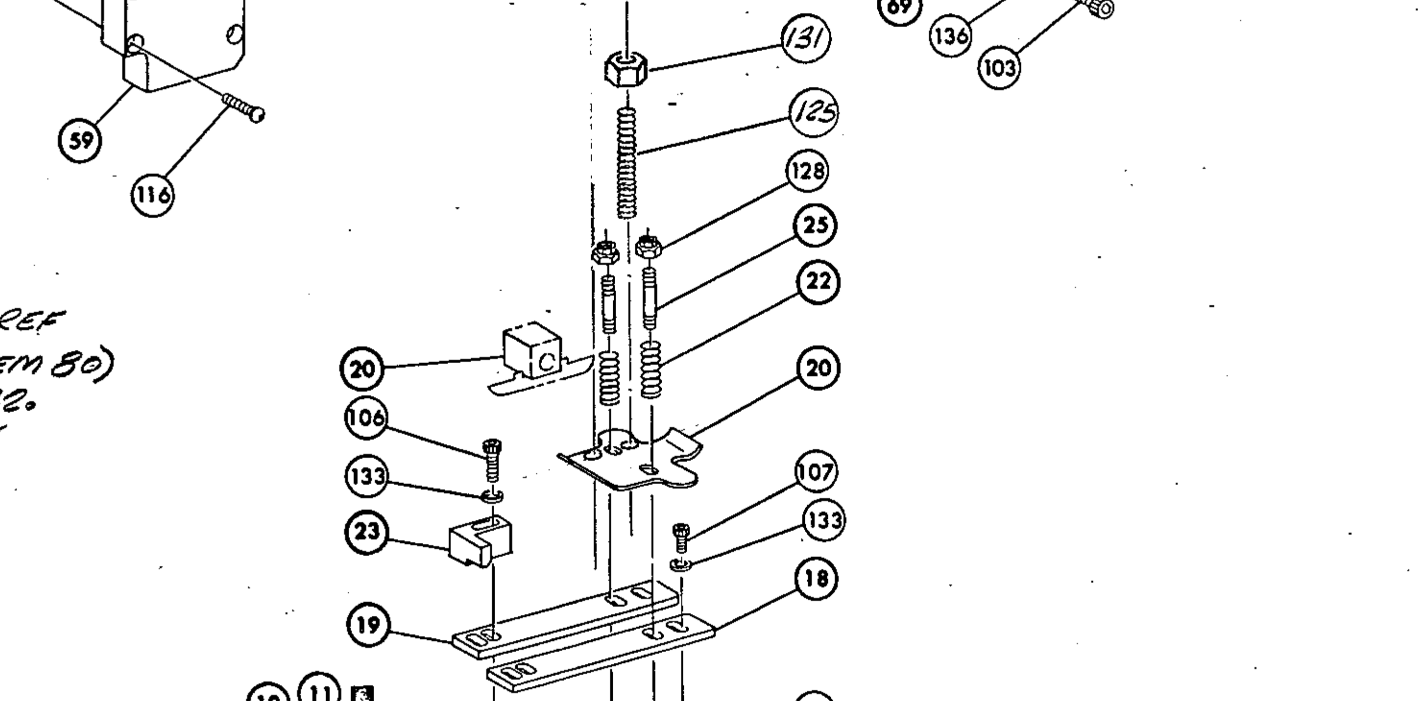

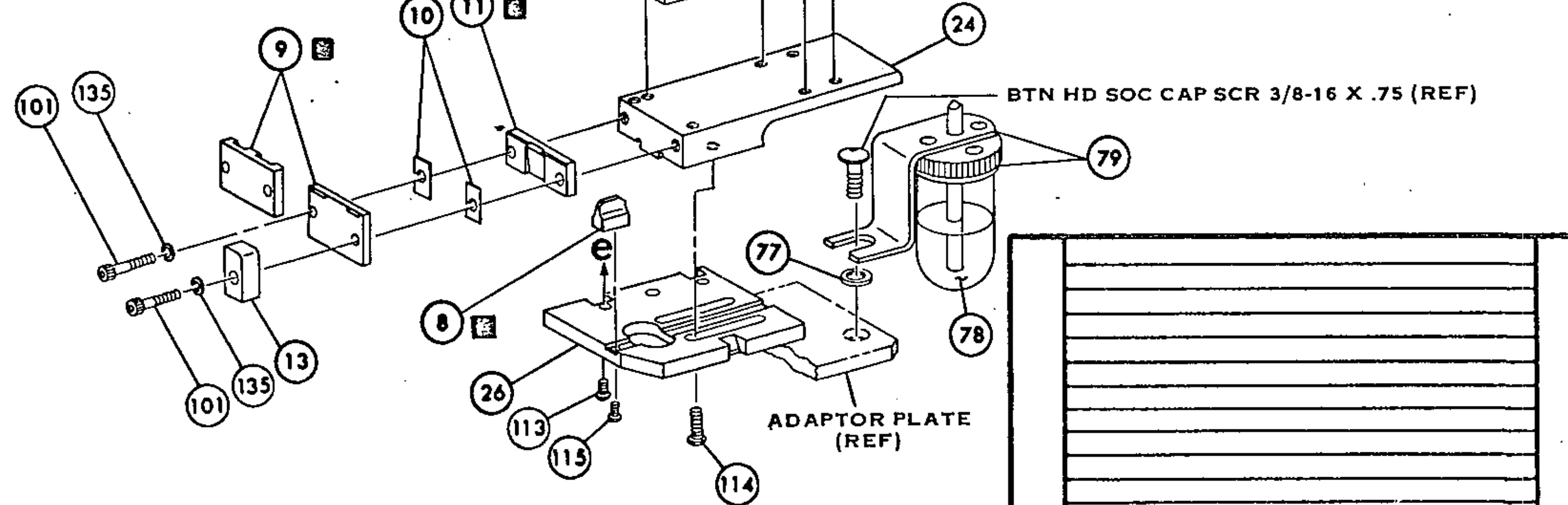

NOTES:

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.

△5 CUT TO LGTH AT ASSY

KEY:

▣ RECOMMENDED SPARE PARTS. CUSTOMER RESPONSIBLE FOR REPLACEMENT.

△ LUBRICATE DAILY USING NO. 20 MACHINE OIL.

⬡ GREASE LIGHTLY.

*TRADEMARK OF AMP INCORPORATED

REQ.	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
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	147				56
			146	REF	240624-1	PIN, FEED FINGER	55
			145	REF	691499-1	SPRING, FEED FINGER	54
			144	REF.	240635-1	FINGER, FEED	53
REF	5- 21028-1	PIN, SLOT SPG (.12 DIA x .50) FEED ADJ ROD	143	REF	240634-1	LEVER, TERMINAL	52
			142				51
REF	1- 21030-7	PIN, DOWEL (.187 DIA x 1.50) HOUSING	141				50
REF	1- 21030-1	PIN, DOWEL (.187 DIA x .50) LEVER	140	1	7-21002-9	BOLT, CRIMPER	49
			139	1	690602-5	CAM, PRE FEED 1- 1/8 STROKE	48
—	22260-5	WASH, FLAT (NO. 6) DRAG SPRING	138				47
REF	21899-4	WASH, FLAT (NO. 5/16 DIA) SCR ADJ	137				46
REF	21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE	136	1	690191-1	PLUG, NYLON	45
2	21024-5	WASH, LOCK (NO. 10) SHEAR PLATES	135	1	455674-2	RAM	44
REF	21024-5	WASH, LOCK (NO. 10) FEED ROD GUIDE	134	1	690125-1	WASHER, LAMINATED	43
5	21024-4	WASH, LOCK (NO. 8) STRIP GUIDE	133	1	690124-1	WASHER, RAM	42
2	21024-4	WASH, LOCK (NO. 8) SHEAR BLADE	132			SPACER, DISC	41
2	21018-4	NUT, HEX, MACH (4-40) DRAG	131	2	23241-6	BALL, STEEL	40
REF	21068-5	NUT, HEX MACH (6-32) FEED ADJ PLATE	130	2	690170-1	SPRING, COMPRESSION	39
—	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	129	1	690142-1	DISC, INSULATION	38
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUDS	128	1	5-690692-6	DISC, WIRE	37
—	5- 21004-7	SCR, SKT HD SHLD (.250 DIA x .25) DRAG ARM	127	1	22480-5	WASHER, SPRING	36
—	21004-5	SCR, SKT HD SHLD (.250 DIA x 1.00) DRAG	126	1	690212-1	POST, RAM	35
2	4-21078-8	SCR, SKT SET OVAL PT (4-40 x .75) DRAG	125				34
1	21009-2	SCR, SKT SET (1/4-20 x 25) NYLOK RAM	124				33
			123	1	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
1	2- 21003-0	SCR, FLAT HD SOC CAP (6-32 x .50) CAM	122				31
			121				30
REF	3- 21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ	120				29
			119	1	3-690451-2	SPACER, STRIPPER	28
			118	1	240639-1	STRIPPER	27
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER	117	REF	455676-1	PLATE, BASE	26
REF	2- 21002-9	SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP	116	2	22354-8	DRAG, STUD	25
1	22733-8	SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL	115	1	455678-5	PLATE, STRIP GUIDE	24
4	3- 21002-3	SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL	114	1	240825-9	PLATE, STRIP HOLD	23
REF	1-24073-9	SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE	113	2	4-22281-1	SPRING, DRAG	22
			112	—	240636-1	LEVER, DRAG	21
			111	1	454177-1	DRAG, STOCK	20
—	2- 21000-4	SCR, SKT HD CAP (6-32 x 1.00) DRAG ADAPTOR	110	1	454204-7	GUIDE, STRIP REAR	19
2	23030-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC	109	1	454204-7	GUIDE, STRIP FRONT	18
2	2-21000-7	SCR, SKT HD CAP (8-32 x .44) SHEAR BLADE △5	108	REF	454178-1	GUIDE, FEED ROD	17
3	7-21000-4	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE	107	REF	4-22284-9	SPRING, FEED RETURN	16
2	2-21000-8	SCR, SKT HD CAP (8-32 x .62) STRIP GUIDE	106	—	454665-1	ADAPTOR, DRAG	15
REF	3- 21000-7	SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE	105				14
—	3- 21000-9	SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING	104			SPACER, HOLD DOWN	13
REF	3- 21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE	103			SPRING, HOLD DOWN	12
REF	3- 21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK	102	1	240644-8	PLATE, REAR SHEAR	11
2	3- 21000-8	SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES	101	2	2-240645-3	SPACER, SHEAR PLATE	10
REF	455745-1	GUARD, WINDOW △3	80	1	1-240648-0	PLATE, FRONT SHEAR	9
—	465184-9	LUBRICATOR ASSY	79	1	6-240655-7	ANVIL	8
—	22014-1	OIL SYNTHETIC	78	1	3-240651-5	BLADE, SLUG	7
—	454406-1	SPACER, LUBRICATOR BRACKET	77	1	690518-7	HOLD DOWN	6
			76	1	4-240641-3	SPACER, SHEAR BLADE	5
			75	1	238009-1	SPACER, TUBULAR, INS CRIMPER	4
			74	1	1-456134-6	CRIMPER, INSULATION	3
REF	458109-1	WASHER, FLAT (SPECIAL)	73	1	455883-7	SPACER, INSULATION	2
2	690603-1	SPRING, ASSIST	72	1	1-456403-5	CRIMPER, WIRE	1

CRIMPING DATA

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.032	22	
B	.030	24	
C	NOT	USED	
D	NOT	USED	

CRIMP	SIZE	TYPE	FEED	PRESS REF.
WIRE	.062	F	.705	565435-5
INSULATION	.080	F		

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION
.040-.060	24-22	AI 8039

REMARKS: AMP-O-LECTRIC PRE FEED

THIS APPLICATOR WILL APPLY: 60089

LTR	REVISION RECORD	ECN	DR/CK	DATE
H	0150-6459-95			8/95
G	REV PER ECN A-153588	—	NG/CE	11-88
F	REV PER ECN R-5470	—		1-24-84
E	REV ITEM 37 PER R2905		RAJG	3-79
D	REV PER ECN	R865	lm	11/74
C	REV PER ECN	R821	lm	10/74
B	REV PER ECN	R818	lm	10/25/74
A	REV. PER ECN	R760		9/11/74

SET UP GAGE: 453633-1
LAYOUT NO.: 407
DRAWN: Fogarty 2/8/74
APPROVED: 2-26-74
CHECKED: 2-26-74 H C Miller
REL.: 2-26-74

AMP INCORPORATED
HARRISBURG, PENNA.

LOC: A C
NO. 466020-2
REV. H
SCALE: NONE

NAME: MINIATURE QUICK CHANGE APPLICATOR
END-FEED (.110 FASTON RECEPT)

NO. 466020-2

PRINT 6

3076-1