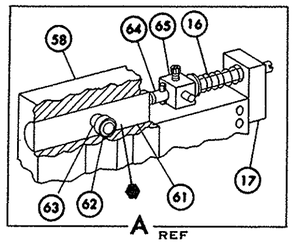
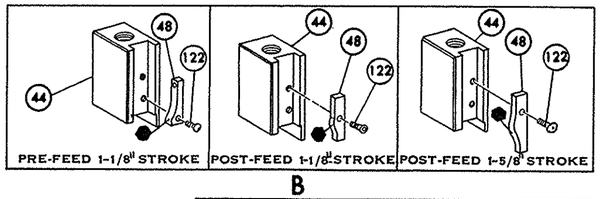


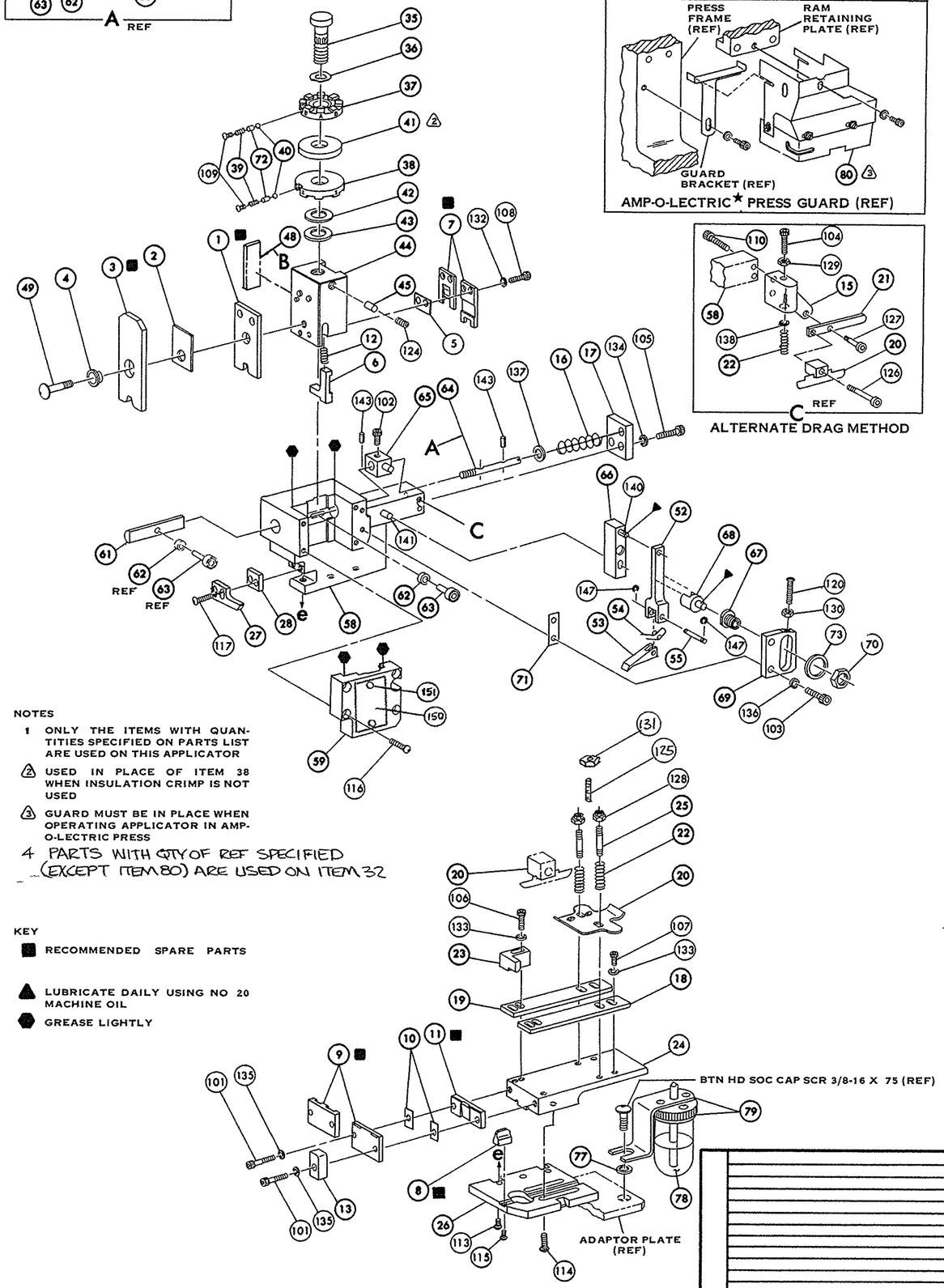




B










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 | 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 |
| 2 | 21017-2 | SCREW, DRIVE (#2 X .19) ID PLATE | 151 | | | | 60 |
| 1 | 461264-1 | PLATE, ID | 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 | 240634-3 | 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 | 690501-4 | CAM, POST FEED 1- 5/8 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 | 455674-1 | RAM | 44 |
| REF | 21024-5 | WASH, LOCK (NO. 10) FEED ROD GUIDE | 134 | 1 | 690125-1 | WASHER, LAMINATED | 43 |
| 4 | 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 | 690141-7 | 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 | 2-21006-6 | SCR, SKT SET CUP PT (4-40 x .62) DRAG | 125 | | | | 34 |
| 1 | 21009-2 | SCR, SKT SET (1/4-20 x 25) NYLOK RAM | 124 | | | | 33 |
| | | | 123 | 1 | 458980-2 | APPL, BASIC (SUB ASSY) | 32 |
| 1 | 1-21002-7 | SCR, BTN HD SOC CAP (6-32 x .38) 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 | 455678-7 | PLATE, STRIP GUIDE | 24 |
| 4 | 3- 21002-3 | SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL | 114 | | | PLATE, STRIP HOLD | 23 |
| REF | 2-22733-8 | SCR, BTN HD SKT CAP (1/4-20 x .62) 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 | 458030-3 | GUIDE, STRIP REAR | 19 |
| 2 | 23030-1 | SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC | 109 | 1 | 458031-3 | GUIDE, STRIP FRONT | 18 |
| 2 | 2-21000-6 | SCR, SKT HD CAP (8-32 x .38) SHEAR BLADE | 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 |
| 1 | 7-21000-4 | SCR, SKT HD CAP (8-32 x .31) 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 | 691901-3 | PLATE, REAR SHEAR ■ | 11 |
| 2 | 3- 21000-8 | SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES | 101 | 2 | 2-240645-1 | SPACER, SHEAR PLATE | 10 |
| REF | 455745-1 | GUARD, WINDOW △3 | 80 | 1 | 690783-1 | PLATE, FRONT SHEAR ■ | 9 |
| — | 465184-9 | LUBRICATOR ASSY | 79 | 1 | 8-240655-8 | ANVIL ■ | 8 |
| — | 22014-1 | OIL SYNTHETIC | 78 | 1 | 691151-8 | BLADE, SLUG ■ | 7 |
| — | 454406-1 | SPACER, LUBRICATOR BRACKET | 77 | | | HOLD DOWN | 6 |
| | | | 76 | 1 | 5-240641-9 | SPACER, SHEAR BLADE | 5 |
| | | | 75 | 1 | 238009-3 | SPACER, TUBULAR, INS CRIMPER | 4 |
| | | | 74 | 1 | 1-456134-7 | CRIMPER, INSULATION ■ | 3 |
| REF | 458109-1 | WASHER, FLAT (SPECIAL) | 73 | 1 | 455888-1 | SPACER, INSULATION | 2 |
| 2 | 690603-1 | SPRING, ASSIST | 72 | 1 | 456407-1 | CRIMPER, WIRE ■ | 1 |

## CRIMPING DATA

| PAD LETTER | CRIMP HEIGHT | WIRE SIZE | WIRE STRIP LENGTH |
|---|---|---|---|
| A | .059 | 18 | |
| B | .056 | 20 | |
| C | .053 | 22 | |
| D | NOT | USED | |

| | SIZE | TYPE | FEED | PRESS REF. |
|---|---|---|---|---|
| CRIMP | | | | |
| WIRE | .100 | F | .657 | — " — |
| INSULATION | .140 | F | | |

| INSULATION RANGE | WIRE RANGE | APPLICATOR INSTRUCTION |
|---|---|---|
| .060 — .110 | 20-18 | AI 8039 |

REMARKS AMPOMATOR

THIS APPLICATOR WILL APPLY

| | |
|---|---|
| | 40697 |
| | 40698 |
| | ~~40699~~ OBS |
| | ~~40731~~ OBS |
| | 40732 |
| | ~~40733~~ OBS |
| | ~~40870~~ |
| | ~~40971~~ |
| | ~~42121~~ OBS |
| | ~~42555~~ |
| | ~~640262~~ OBS |

| LTR | REVISION RECORD | ECN | DR | CK | DATE |
|---|---|---|---|---|---|
| J | ECR-10-009128 | | TM | | 4-10 |
| H | ECN 0150-0087-01 | | MA/TE | | 1-01 |
| G | ECN 0150-0242-00 | | MA/TE | | 4-00 |
| F | 0150-5907-95 | | JEB/CE | | 2-95 |
| E | EC-220789 | — | JEB/CE | | 11-89 |
| D | ECN A166488 | — | MB/DE | | 11-88 |
| C | REV. PER ECN R-5510 | | RM/MA | | 2-15-84 |
| B | REV PER ECN | R | 2070 | RM/JB | 2/5/79 |
| A2 | DELETE ITEM PER ECN | R | 1877 | DR/JN | 11/1/76 |
| A1 | ADD ITEM 640262 | R | 1547 | JB/TE | 3/19/76 |
| A | REV PER ECN | R | 722 | DR/JN | 8/12/74 |
| 01 | REV. PER ECN | C | 380 | DR/JN | 3/13/74 |

SET UP GAGE 458638-1 | LAYOUT NO. 655 | DRAWN 6-7-73 B.WOLFE | APPROVED 6-11-73 | CHECKED 6-8-73 | REL. 6-11-73

AMP INCORPORATED HARRISBURG, PENNA.

LOC A C | NO. 687851-1 | REV. J

SCALE NONE

NAME **MINIATURE QUICK CHANGE APPLICATOR END-FEED (RING (SHEAR TERM))**

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT
DIMENSIONS IN INCHES DO NOT SCALE PRINT
THIS DRAWING S UNPUBL SHED | RELEASED FOR PUBLICATION JUL-" 998
© COPYRIGHT 998 BY AMP INCORPORATED ALL RIGHTS RESERVED

PRINT 66

3076-1