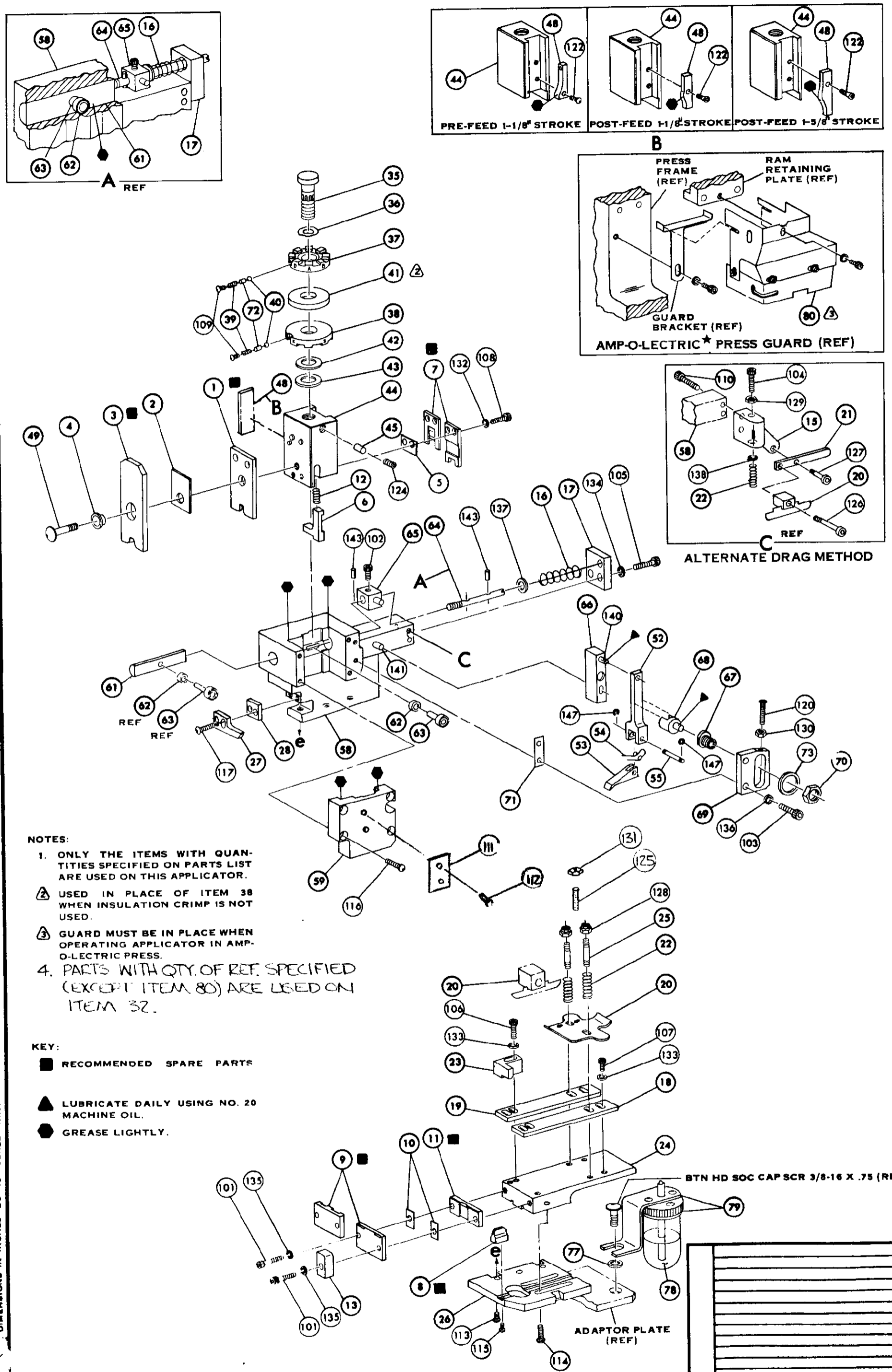


THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INC. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.



- 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.

THIS INFORMATION IS CONFIDENTIAL AND IS DISCLOSED TO YOU ON CONDITION THAT NO FURTHER DISCLOSURE IS MADE BY YOU TO OTHER THAN AMP PERSONNEL, WITHOUT WRITTEN AUTHORIZATION FROM AMP INCORPORATED, HARRISBURG, PA.

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
	147						56
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	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	670602-5	CAM, PRE-FEED 1-1/8 STROKE	48
			138				47
			137				46
REF	22260-5	WASH, FLAT (NO. 6) DRAG SPRING	136	1	690191-1	PLUG, NYLON	45
REF	21899-4	WASH, FLAT (NO. 5/16 DIA) SCR ADJ	135	1	455674-1	RAM	44
REF	21024-5	WASH, LOCK (NO. 10) FEED ADJ PLATE	134	1	690125-1	WASHER, LAMINATED	43
REF	21024-5	WASH, LOCK (NO. 10) SHEAR PLATES	133	1	690124-1	WASHER, RAM	42
REF	21024-5	WASH, LOCK (NO. 10) FEED ROD GUIDE	132			SPACER, DISC	41
REF	21024-4	WASH, LOCK (NO. 8) STRIP GUIDE	131	2	23241-6	BALL, STEEL	40
REF	21018-4	NUT, HEX MACH (4-40) DRAG	130	2	690170-1	SPRING, COMPRESSION	39
REF	21068-5	NUT, HEX MACH (6-32) FEED ADJ PLATE	129	1	690142-1	DISC, INSULATION	38
			129	1	690141-7	DISC, WIRE	37
			128	1	22480-5	WASHER, SPRING	36
			127				35
			126	1	690212-1	POST, RAM	34
			125				33
REF	21009-2	SCR, SKT SET (1/4-20 x 25) NYLOK RAM	124				32
			123	1	458980-1	APPL, BASIC (SUB ASSY)	31
			122				30
REF	3-21064-2	SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ	121				29
			120				28
			119	1	3-690451-2	SPACER, STRIPPER	27
			118	1	240639-1	STRIPPER	26
			117	REF	455676-1	PLATE, BASE	25
REF	2-21002-2	SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER	116	2	22254-8	DRAG, STUD	24
REF	2-21002-8	SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP	115	1	455678-7	PLATE, STRIP GUIDE	23
REF	22733-8	SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL	114			PLATE, STRIP HOLD	22
REF	3-21002-3	SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL	113	2	4-22281-1	SPRING, DRAG	21
REF	2-22733-8	SCR, BTN HD SKT CAP (1/4-20 x .62) BASE PLATE	112			LEVER, DRAG	20
REF	2-21017-2	SCR, DRIVE (# 2 x .19) I.D. PLATE	111	1	454177-1	DRAG, STOCK	19
REF	461264-1	PLATE, IDENTIFICATION	110	1	458030-3	GUIDE, STRIP REAR	18
REF	2-21000-4	SCR, SKT HD CAP (6-32 x 1.00) DRAG ADAPTOR	109	1	458031-3	GUIDE, STRIP FRONT	17
REF	23030-1	SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC	108	REF	454178-1	GUIDE, FEED ROD	16
REF	2-21000-6	SCR, SKT HD CAP (8-32 x .38) SHEAR BLADE	107	REF	4-22284-9	SPRING, FEED RETURN	15
REF	7-21000-4	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE	106			ADAPTOR, DRAG	14
REF	7-21000-7	SCR, SKT HD CAP (8-32 x .31) STRIP GUIDE	105				13
REF	3-21000-7	SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE	104			SPACER, HOLD DOWN	12
REF	3-21000-9	SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING	103			SPRING, HOLD DOWN	11
REF	3-21000-6	SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE	102	1	691901-3	PLATE, REAR SHEAR	10
REF	3-21000-4	SCR, SKT HD CAP (10-32 x .38) PIVOT BLK	101	2	2240645-1	SPACER, SHEAR PLATE	9
REF	3-21000-8	SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES	100			PLATE, FRONT SHEAR	8
REF	455745-1	GUARD WINDOW	80	1	690783-3	ANVIL	7
			79	1	8240655-8	BLADE, SLUG	6
			78	1	691157-8	HOLD DOWN	5
			77			SPACER, SHEAR BLADE	4
			76	1	6240641-9	SPACER, TUBULAR, INS CRIMPER	3
			75	1	238009-5	CRIMPER, INSULATION	2
			74	1	1-456134-7	SPACER, INSULATION	1
REF	458109-1	WASHER, FLAT (SPECIAL)	73	1	455888-1	CRIMPER, WIRE	
REF	690603-1	SPRING, ASSIST	72	1	456407-1		

CRIMPING DATA				THIS APPLICATOR WILL APPLY	
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH		
A	.059	18			40627
B	.056	20			40628
C	.053	22			40629
D	NOT USED				40630
CRIMP	SIZE	TYPE	FEED	PRESS REF.	
WIRE	100	F	.657	505435-5	40631
INSULATION	140	F			40632
INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION			
260-110	20-18	M8039			40633
REMARKS: AMP-O-LECTRIC PRE-FEED					

G	0150-7420-96				
E	0150-5907-95				
E	EC-A220989				
C	REV. PER 20 7-3510				
B	REV. PER 10 7-3510				
A	ADD TRIM 690212-1				
H	REV. PER 5-21				
C	REV. PER 5-21				

SET UP PAGE	LAYOUT NO.	AMP INCORPORATED HARRISBURG, PENNA.
458635-1	65E	
DRAWN	APPROVED	LOC
PAWLOFF	REL.	A
CHECKED	REL.	C
SCALE	NAME	NO.
1/1	MINIATURE QUICK CHANGE APPLICATOR	691551-2
	END-FEED (RING (RAM TO 10))	G

LTR	REVISION RECORD	ECN	DATE	LTR	REVISION RECORD	ECN	DATE
-----	-----------------	-----	------	-----	-----------------	-----	------