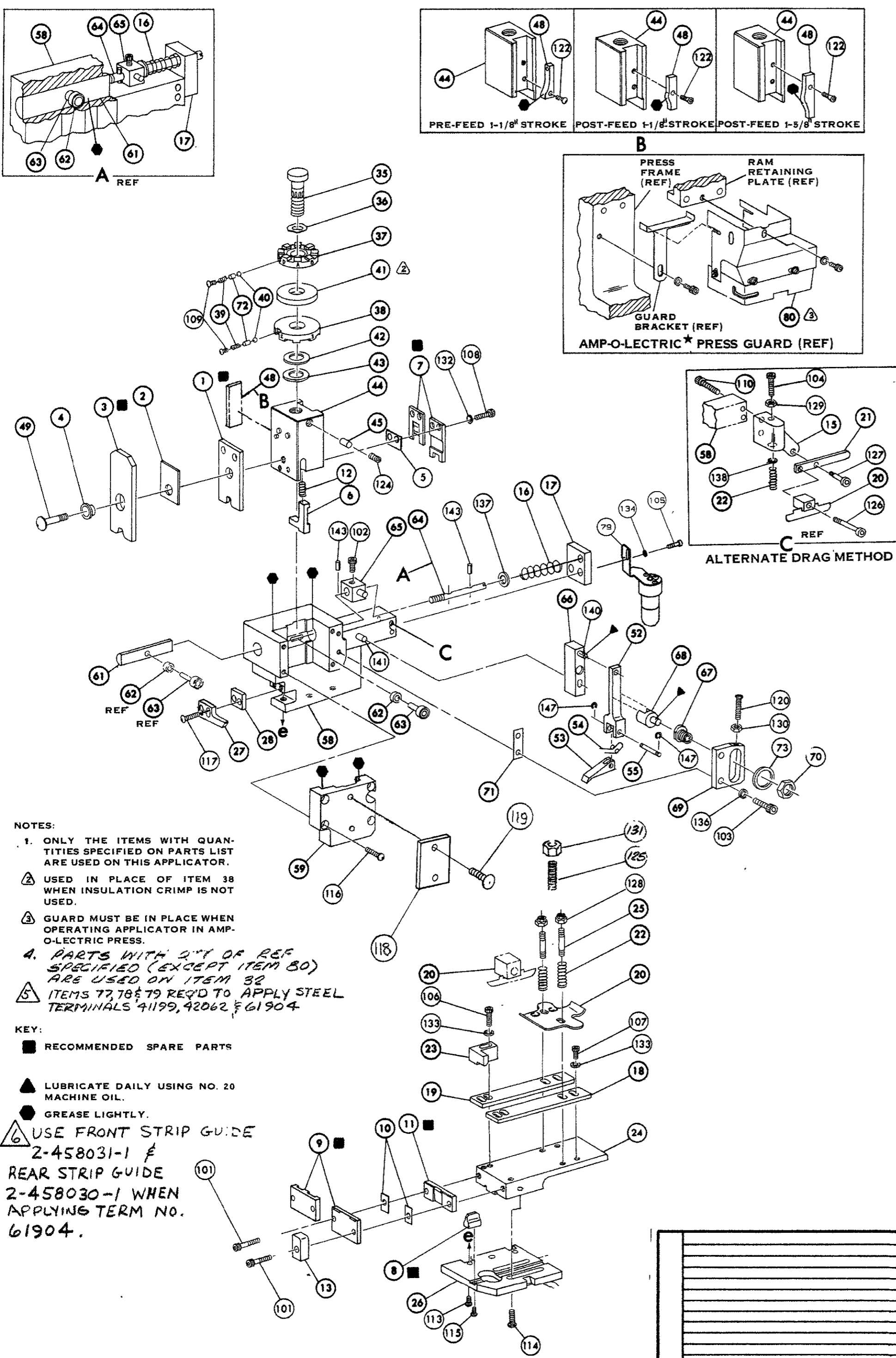


NO. 687874-3

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.

THIS IS A CONTROLLED DOCUMENT.

DIMENSIONS IN INCHES DO NOT SCALE PRINT



- 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 2% OF REF SPECIFIED (EXCEPT ITEM 80) ARE USED ON ITEM 32.
  - ITEMS 77, 78 & 79 REQ'D TO APPLY STEEL TERMINALS 41199, 42062 & 61904.

- KEY:**
- RECOMMENDED SPARE PARTS
  - LUBRICATE DAILY USING NO. 20 MACHINE OIL.
  - GREASE LIGHTLY.
  - USE FRONT STRIP GUIDE 2-458031-1 & REAR STRIP GUIDE 2-458030-1 WHEN APPLYING TERM NO. 61904.

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			
146	REF	240624-1	PIN, FEED FINGER	55			
145	REF	691499-1	SPRING, FEED FINGER	54			
144	REF	240635-1	FINGER, FEED	53			
143	REF	240634-1	LEVER, TERMINAL	52			
142				51			
141				50			
140	1	7-21002-9	BOLT, CRIMPER	49			
139	1	690602-5	CAM, PRE FEED 1-1/8 STROKE	48			
138				47			
137				46			
136	1	690191-1	PLUG, NYLON	45			
135	1	455674-1	RAM	44			
134	1	690125-1	WASHER, LAMINATED	43			
133	1	690124-1	WASHER, RAM	42			
132				41			
131	2	23241-6	BALL, STEEL	40			
130	2	690170-1	SPRING, COMPRESSION	39			
129	1	690142-1	DISC, INSULATION	38			
128	1	690672-4	DISC, WIRE	37			
127	1	22480-5	WASHER, SPRING	36			
126	1	690212-1	POST, RAM	35			
125				34			
124				33			
123	1	458980-1	APPLICATOR, BASIC (SUB ASSY)	32			
122				31			
121				30			
120				29			
119	1	3-690451-2	SPACER, STRIPPER	28			
118	1	240639-1	STRIPPER	27			
117	REF	455676-1	PLATE, BASE	26			
116	2	22354-8	DRAG, STUD	25			
115	1	455678-1	PLATE, STRIP GUIDE	24			
114	4	3-21002-3	SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL	23			
113	2	4-22281-1	SPRING, DRAG	22			
112	2	240636-1	LEVER, DRAG	21			
111	1	454177-1	DRAG, STOCK	20			
110	1	458030-3	GUIDE, STRIP REAR	19			
109	1	458031-3	GUIDE, STRIP FRONT	18			
108	REF	454178-1	GUIDE, FEED ROD	17			
107	REF	4-22284-9	SPRING, FEED RETURN	16			
106		454665-1	ADAPTOR, DRAG	15			
105				14			
104				13			
103				12			
102	1	240644-1	PLATE, REAR SHEAR	11			
101	2	1-240645-1	SPACER, SHEAR PLATE	10			
80	1	240642-1	PLATE, FRONT SHEAR	9			
79	1	3-240693-4	ANVIL	8			
78	1	1-240650-1	BLADE, SLUG	7			
77			HOLD DOWN	6			
76	1	1-240641-3	SPACER, SHEAR BLADE	5			
75	1	238009-1	SPACER, TUBULAR, INS CRIMPER	4			
74	1	1-456134-3	CRIMPER, INSULATION	3			
73	1	455888-2	SPACER, INSULATION	2			
72	1	1-456406-5	CRIMPER, WIRE	1			

TERM APPL SPEC 114-2084

CRIMPING DATA				THIS APPLICATOR WILL APPLY	
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH		
A	.073	#16		40505	
B	.072	#18		40888	
C	.067	#20		41199	
D	NOT USED			41852	
CRIMP	SIZE	TYPE	FEED	PRESS REF.	
WIRE	.090	F			42062
INSULATION	.120	F	.706		60840
INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION	A 8099		
.075-.120	20-16		61353		
REMARKS: AMP-O-LECTRIC PRE FEED					

H ECN 0150-1439-04 WY/E 11-04

G 0150-0444-02 7/84 7-02

F 0150-7420-96 02-11-96

E 0150-6987-96 02-11-96

D 0150-6274-95 02-11-96

C 0150-272390 02-11-96

B ECN 4160488 02-11-96

A REV PER ECO R-3517 02-11-96

04 ADD NOTE A R 2754 02-11-96

03 DELETED C 592 R 2754 02-11-96

02 ADD TERM 62693 R 1761 02-11-96

01 REV PER ECN R 1627 02-11-96

SET UP GAGE	LAYOUT NO.	AMP	AMP INCORPORATED
458638-1	90	HARRISBURG, PENNA.	
DATE	APPROVED	LOC	NO.
7/19/73	Den Nantz	A	C
CHECKED	SCALE	687874-3	
7-24-73	1:1	REV. H	
MINIATURE QUICK CHANGE APPLICATOR			
END-FEED (RING)			

LTR	REVISION RECORD	ECN	DATE	LTR	REVISION RECORD	ECN	DATE