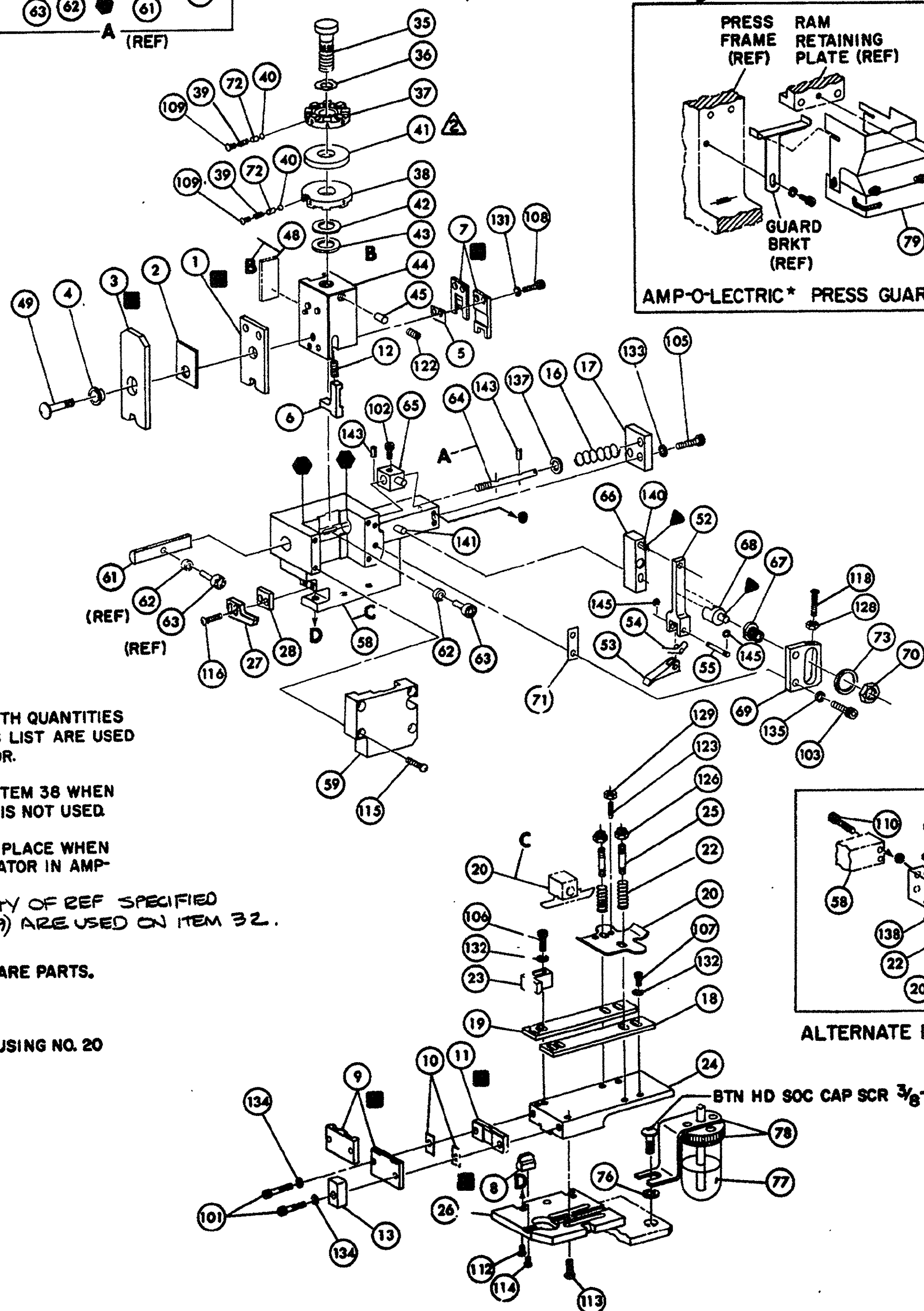
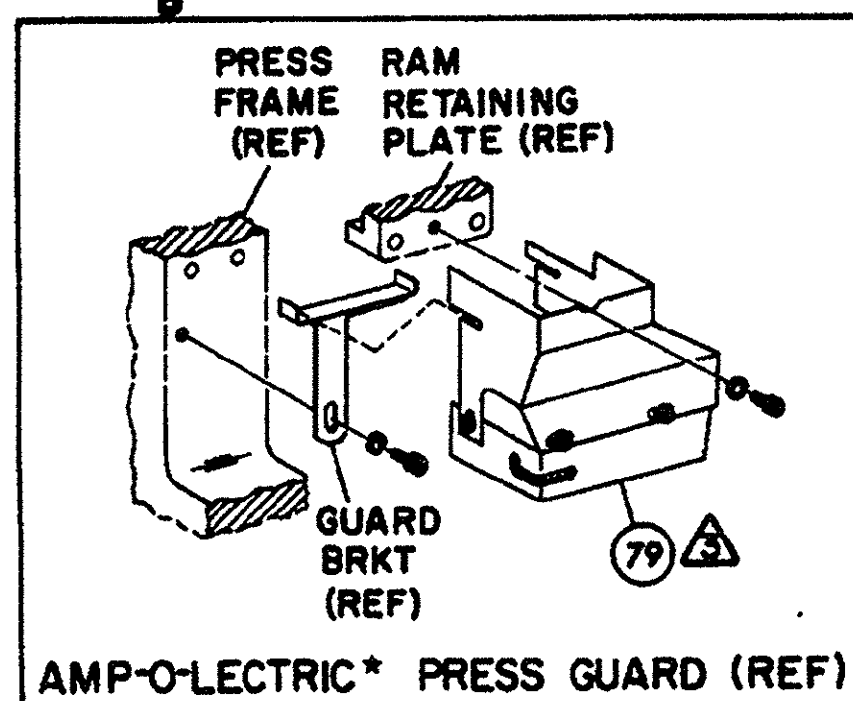
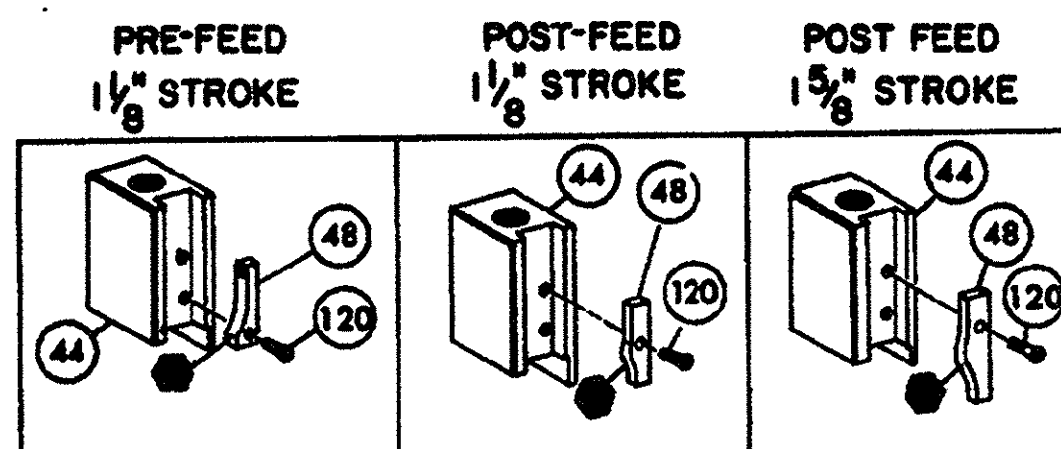
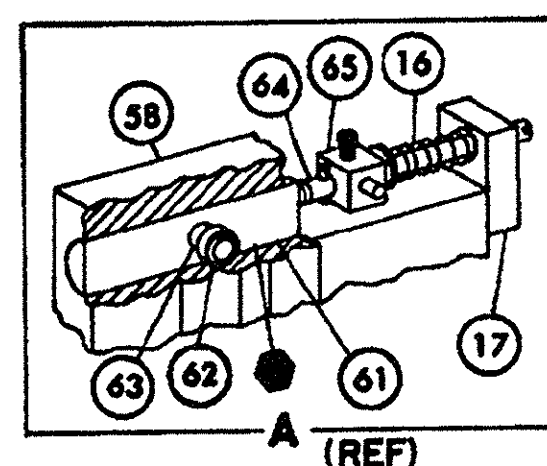




NOTES:

1. 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-ELECTRIC PRESS.

4. PARTS WITH QTY OF REF SPECIFIED (EXCEPT ITEM 79) ARE USED ON ITEM 32.

KEY:

■ RECOMMENDED SPARE PARTS.

▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.

● GREASE LIGHTLY.

ALTERNATE DRAG METHOD

REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED PIN	145	REF	454220-1	CAP, RAM	59
REF	5-21028-1	PIN, SLOT SPG (.12 DIA X .50) FD ADJ ROD	144	REF	453736-1	HOUSING	58
REF	1-21030-7	PIN, DOWEL (.187 DIA X 1.50) HOUSING	143				57
REF	1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	142				56
	22260-5	WASHER, FLAT (NO 6) DRAG SPRING	141	REF	247624-1	PIN, FEED FINGER	55
REF	21899-4	WASHER, FLAT (5/16 DIA) SCR ADJ	140	REF	691499-1	SPRING, FEED FINGER	54
			139	REF	240635-1	FINGER, FEED	53
			138	REF	240634-1	LEVER, TERMINAL	52
			137				51
			136				50
REF	21024-5	WASHER, LOCK (NO 10) FEED ADJ PLATE	135	1	7-21002-9	BOLT, CRIMPER	49
2	21024-5	WASHER, LOCK (NO 10) SHEAR PLATES	134	1	690501-4	CAM, POST FEED 1 5/8 STROKE	48
REF	21024-5	WASHER, LOCK (NO 10) FEED ROD GUIDE	133				47
5	21024-4	WASHER, LOCK (NO 8) STRIP GUIDE	132				46
2	21024-4	WASHER, LOCK (NO 8) SHEAR BLADE	131	1	690191-1	PLUG, NYLON	45
			130	1	455674-1	RAM	44
2	21018-4	NUT, HEX MACH (4-40) DRAG	129	1	690125-1	WASHER, LAMINATED	43
REF	21068-5	NUT, HEX MACH (6-32) FD ADJ PLATE	128	1	690124-1	WASHER, RAM	42
	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	127				41
2	21022-2	NUT, HEX SELF-LKG (8-32) DRAG STUD	126	2	23241-6	BALL, STEEL	40
	5-21004-7	SCR, SKT HD SHLD (250 DIA X .25) DRAG ARM	125	2	690170-1	SPRING, COMPRESSION	39
	21004-5	SCR, SKT HD SHLD (250 DIA X 1.00) DRAG	124		690142-1	DISC, INSULATION	38
2	4-21078-8	SCR, SKT SET OVAL POINT (4-40 X .75) DRAG	123	1	6-690141-8	DISC, WIRE	37
1	22651-9	SCR, SKT SET (1/4-20 X .25) (LOC-WEL) RAM	122	1	22480-5	WASHER, SPRING	36
			121	1	690212-1	POST, RAM	35
			120				34
1	2-21003-0	SCR, FLAT HD SKT CAP (6-32 X .50) CAM	119				33
REF	3-21064-2	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	118	1	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
			117				31
2	2-21002-2	SCR, BTN HD SKT CAP (8-32 X .50) STRIPPER	116				30
REF	2-21002-9	SCR, BTN HD SKT CAP (10-32 X .75) HSG CAP	115				29
1	24073-2	SCR, BTN HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	114	1	3-690451-2	SPACER, STRIPPER	28
4	3-21002-3	SCR, BTN HD SKT CAP (1/4-20 X .50) STR GDE PL	113	1	455566-1	STRIPPER	27
REF	1-24073-9	SCR, BTN HD SKT CAP (1/4-20 X .75) BASE PL	112	REF	455676-1	PLATE, BASE	26
			111	2	22354-8	DRAG, STUD	25
	2-21000-4	SCR, SKT HD CAP (6-32 X 1.00) DRAG ADAPTOR	110	1	455678-1	PLATE, STRIP GUIDE	24
2	3-23657-8	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	109	1	240825-3	PLATE, STRIP HOLD	23
2	2-21000-6	SCR, SKT HD CAP (8-32 X .38) SHEAR BLADE	108	2	4-22281-1	SPRING, DRAG	22
3	2-21000-6	SCR, SKT HD CAP (8-32 X .38) STRIP GUIDE	107		240636-1	LEVER, DRAG	21
2	2-21000-9	SCR, SKT HD CAP (8-32 X .75) STRIP GUIDE	106	1	454177-1	DRAG, STOCK	20
REF	3-21000-7	SCR, SKT HD CAP (10-32 X .75) FD ROD GUIDE	105	1	454204-3	GUIDE, STRIP (REAR)	19
	3-21000-9	SCR, SKT HD CAP (10-32 X 1.00) DRAG SPRING	104	1	454204-3	GUIDE, STRIP (FRONT)	18
REF	3-21000-6	SCR, SKT HD CAP (10-32 X .62) FD ADJ PLATE	103	REF	454178-1	GUIDE, FEED ROD	17
REF	3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLK	102	REF	4-22284-9	SPRING, FEED RETURN	16
2	3-21000-8	SCR, SKT HD CAP (10-32 X .88) SHEAR PLATE	101			ADAPTER, DRAG	15
REF	455745-1	GUARD, WINDOW	79				14
	465184-9	LUBRICATOR ASSY	78				13
	455985-1	OIL, LUBRICATING	77				12
	454406-1	SPACER, LUB BRACKET	76	1	240644-1	SPACER, HOLD DOWN	11
			75				10
			74	1	690495-3	SPACER, SHEAR PLATE	9
REF	458109-1	WASHER, FLAT (SPECIAL)	73	1	1-240635-7	PLATE, FRONT SHEAR	8
2	690603-1	SPRING, ASSIST	72	1	690474-5	ANVIL	7
REF	690517-1	SPACER	71				6
	22594-8	NUT, HEX	70	1	240641-6	BLADE, SLUG	5
	240628-1	PLATE, ADJ	69	1	238009-1	HOLD DOWN, TERMINAL	4
	240626-1	SHAFT, PIVOT	68	1	4-456134-6	SPACER, SHEAR BLADE	3
	240633-1	BUSHING	67	1	455888-5	SPACER, TUBULAR	2
	455680-1	LEVER, INTERMEDIATE	66	1	456408-7	CRIMPER, INSULATION	1
	240629-1	BLOCK, PIVOT	65			CRIMPER, WIRE	
	240632-2	SCREW, ADJ	64				
	240659-3	PIN, CAM ROLLER	63				
	240658-1	CAM, ROLLER	62				
REF	454398-1	ROD, FEED	61				

REMARKS		NO	REV
APPL USED ON MACHINE PART NO		MACH SERIAL NO	TO APPLY TERMINAL
CUSTOMER NAME		APPL SERIAL NO	DISTRIBUTION
ADDRESS		PURCHASE ORDER	ORIGINAL
CITY		ENG APP	CUSTOMER COPY
			FIELD ENG COPY

CRIMPING DATA				APPLICATOR WILL APPLY	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH		735210
A	.072	14			
B	.064	16			
C	.058	18			
D	NOT USED				
CRIMP	SIZE	TYPE	FEED	APPL INST	
WIRE	110	F	740	A18039	
INSUL	180	F			
WIRE RANGE	18-14	INSULATION RANGE	120-170	PRESS NO	
REMARKS AMPOMATOR					

REVISION RECORD		REVISION RECORD		REVISION RECORD	
DATE	BY	DATE	BY	DATE	BY
SETUP PAGE 10-1		458638-1 G17		AMP INCORPORATED Harrisburg, Pa.	
DRG-25-11111		11/11/11		REV A2	
NAME		NAME		NAME	
MINIATURE QUICK CHANGE APPLICATOR		MINIATURE QUICK CHANGE APPLICATOR		MINIATURE QUICK CHANGE APPLICATOR	
END FEED (250 FASTON RECEPT)		END FEED (250 FASTON RECEPT)		END FEED (250 FASTON RECEPT)	
CUSTOMER AND ASSEMBLY DRAWING					

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