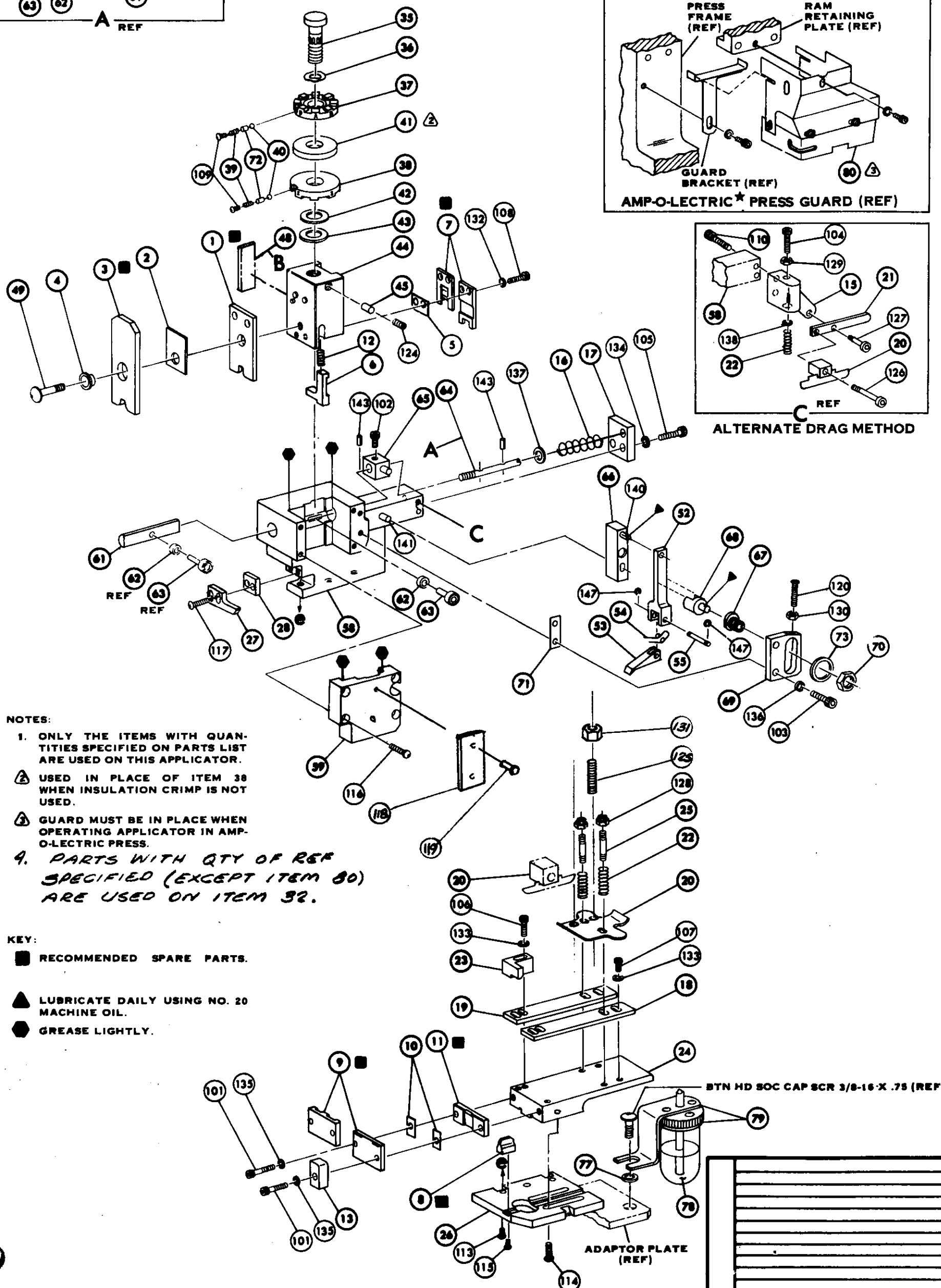
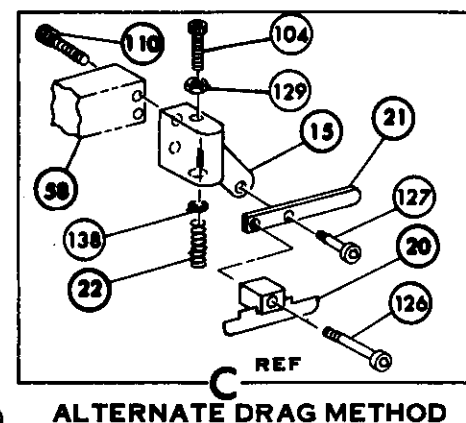
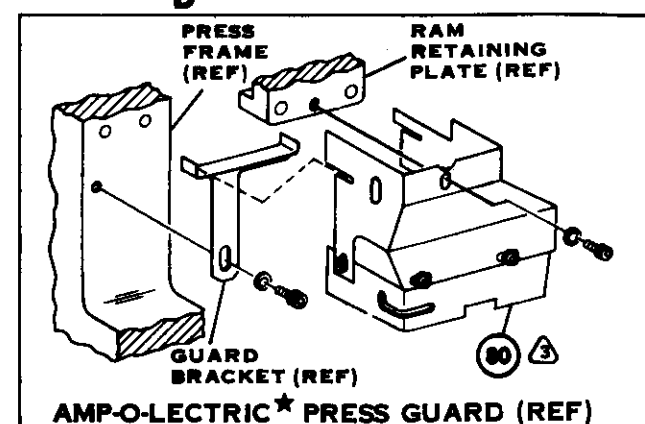
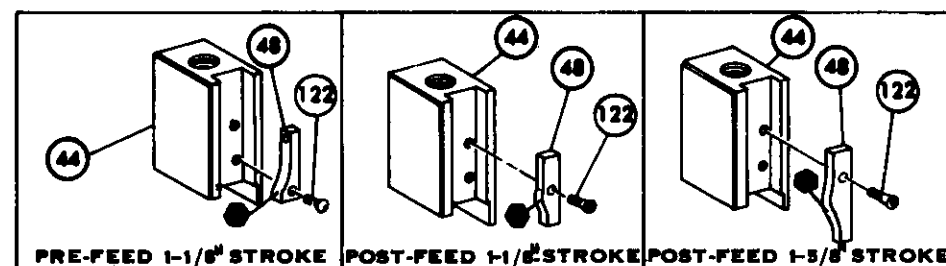
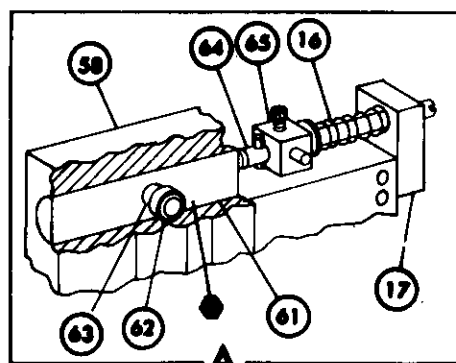




- NOTES:
- ONLY THE ITEMS WITH QUANTITIES SPECIFIED ON PARTS LIST ARE USED ON THIS APPLICATOR.
  - USED IN PLACE OF ITEM 38 WHEN INSULATION CRIMP IS NOT USED.
  - GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-O-LECTRIC PRESS.
  - PARTS WITH QTY OF REF SPECIFIED (EXCEPT ITEM 80) ARE USED ON ITEM 32.

- KEY:
- RECOMMENDED SPARE PARTS.
  - LUBRICATE DAILY USING NO. 20 MACHINE OIL.
  - GREASE LIGHTLY.

| 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        |                                               | 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    | 690501-3            | CAM, POST FEED 1- 1/8 STROKE | 48  |
|      |            |                                               | 138      |      |                     | 47                           |     |
|      | 22260-5    | WASH, FLAT (NO. 6) DRAG SPRING                | 137      |      |                     | 46                           |     |
| REF  | 21899-4    | WASH, FLAT (NO. 5/16 DIA) SCR ADJ             | 136      | 1    | 690191-1            | PLUG, NYLON                  | 45  |
| REF  | 21024-5    | WASH, LOCK (NO. 10) FEED ADJ PLATE            | 135      | 1    | 455674-1            | RAM                          | 44  |
| 2    | 21024-5    | WASH, LOCK (NO. 10) SHEAR PLATES              | 134      | 1    | 690125-1            | WASHER, LAMINATED            | 43  |
| REF  | 21024-5    | WASH, LOCK (NO. 10) FEED ROD GUIDE            | 133      | 1    | 690124-1            | WASHER, RAM                  | 42  |
| 5    | 21024-4    | WASH, LOCK (NO. 8) STRIP GUIDE                | 132      |      |                     | 41                           |     |
| 2    | 21024-4    | WASH, LOCK (NO. 8) SHEAR BLADE                | 131      | 2    | 23241-6             | BALL, STEEL                  | 40  |
| 2    | 21018-4    | NUT, HEX MACH (4-90) 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  |
|      | 21018-7    | NUT, HEX MACH (10-32) DRAG SPRING             | 128      | 1    | 5-690692-5          | DISC, WIRE                   | 37  |
| 2    | 21022-2    | NUT, HEX SELF-LKG (8-32) DRAG STUDS           | 127      | 1    | 22480-5             | WASHER, SPRING               | 36  |
|      | 5- 21004-7 | SCR, SKT HD SHLD (.250 DIA x .25) DRAG ARM    | 126      | 1    | 690212-1            | POST, RAM                    | 35  |
|      |            |                                               | 125      |      |                     | 34                           |     |
|      | 21004-5    | SCR, SKT HD SHLD (.250 DIA x 1.00) DRAG       | 124      |      |                     | 33                           |     |
| 2    | 21004-3    | SCR, SKT SET OVAL PT (4-40 x .75) DRAG        | 123      | 1    | 458980-1            | APPLICATOR, BASIC (SUB ASSY) | 32  |
| 1    | 21009-2    | SCR, SKT SET (1/4-20 x .25) NYLOK RAM         | 122      |      |                     | 31                           |     |
|      |            |                                               | 121      |      |                     | 30                           |     |
| 1    | 2- 21003-0 | SCR, FLAT HD SOC CAP (6-32 x .50) CAM         | 120      |      |                     | 29                           |     |
| REF  | 3- 21064-2 | SCR, RDH HD MACH (6-32 x 1.50) FEED ADJ       | 119      | 1    | 3-690451-2          | SPACER, STRIPPER             | 28  |
| 2    | 21017-2    | SCR, DRIVE (2X .19)                           | 118      | 1    | 240639-1            | STRIPPER                     | 27  |
| 1    | 461264-1   | PLATE, ID                                     | 117      | REF  | 455676-1            | PLATE, BASE                  | 26  |
| 2    | 21002-2    | SCR, BTN HD SKT CAP (8-32 x .50) STRIPPER     | 116      | 2    | 22354-3             | DRAG, STUD                   | 25  |
| REF  | 2- 21002-9 | SCR, BTN HD SKT CAP (10-32 x .75) HSG CAP     | 115      | 1    | 455678-3            | PLATE, STRIP GUIDE           | 24  |
| 1    | 22733-8    | SCR, BTN HD SKT CAP (8-32 x .38) NYLOK ANVIL  | 114      | 1    | 240625-7            | PLATE, STRIP HOLD            | 23  |
| 4    | 3- 21002-3 | SCR, BTN HD SKT CAP (1/4-20 x .50) STR GDE PL | 113      | 2    | 422281-1            | SPRING, DRAG                 | 22  |
| REF  | 1-24015-9  | SCR, BTN HD SKT CAP (1/4-20 x .75) BASE PLATE | 112      |      | 240636-1            | LEVER, DRAG                  | 21  |
|      |            |                                               | 111      | 1    | 454177-1            | DRAG, STOCK                  | 20  |
|      |            |                                               | 110      | 1    | 454204-1            | GUIDE, STRIP REAR            | 19  |
|      | 2- 21000-4 | SCR, SKT HD CAP (6-32 x 1.00) DRAG ADAPTOR    | 109      | 1    | 454204-1            | GUIDE, STRIP FRONT           | 18  |
| 2    | 23030-1    | SCR, SKT HD CAP (6-32 x .25) NYLOK C. P. DISC | 108      | REF  | 454178-1            | GUIDE, FEED ROD              | 17  |
| 2    | 2-21000-6  | SCR, SKT HD CAP (8-32 x .30) SHEAR BLADE      | 107      | REF  | 4-22284-9           | SPRING, FEED RETURN          | 16  |
| 3    | 7-21000-4  | SCR, SKT HD CAP (8-32 x .37) STRIP GUIDE      | 106      |      | 454665-1            | ADAPTOR, DRAG                | 15  |
| 2    | 2-21000-8  | SCR, SKT HD CAP (8-32 x .62) STRIP GUIDE      | 105      |      |                     | 14                           |     |
| REF  | 3- 21000-7 | SCR, SKT HD CAP (10-32 x .75) FD ROD GUIDE    | 104      | 1    | 690481-3            | SPACER, HOLD DOWN            | 13  |
|      | 3- 21000-9 | SCR, SKT HD CAP (10-32 x 1.00) DRAG SPRING    | 103      | 1    | 23346-1             | SPRING, HOLD DOWN            | 12  |
| REF  | 3- 21000-6 | SCR, SKT HD CAP (10-32 x .62) FD ADJ PLATE    | 102      | 1    | 240633-3            | PLATE, REAR SHEAR            | 11  |
| REF  | 3- 21000-4 | SCR, SKT HD CAP (10-32 x .38) PIVOT BLK       | 101      | 2    | 12404450            | SPACER, SHEAR PLATE          | 10  |
| 2    | 3- 21000-8 | SCR, SKT HD CAP (10-32 x .88) SHEAR PLATES    | 80       | 1    | 690481-1            | PLATE, FRONT SHEAR           | 9   |
| REF  | 455745-7   | GUARD                                         | 79       | 1    | 1-2406930           | ANVIL                        | 8   |
|      | 465184-9   | LUBRICATOR ASSY                               | 78       | 1    | 240650-9            | BLADE, SLUG                  | 7   |
|      | 22014-1    | OIL SYNTHETIC                                 | 77       | 1    | 455892-3            | HOLD DOWN                    | 6   |
|      | 454406-1   | SPACER, LUBRICATOR BRACKET                    | 76       | 1    | 3-2406419           | SPACER, SHEAR BLADE          | 5   |
|      |            |                                               | 75       | 1    | 238009-1            | SPACER, TUBULAR, INS CRIMPER | 4   |
|      |            |                                               | 74       | 1    | 456185-2            | CRIMPER, INSULATION          | 3   |
| REF  | 458109-1   | WASHER, FLAT (SPECIAL)                        | 73       | 1    | 455888-4            | SPACER, INSULATION           | 2   |
| 2    | 690603-1   | SPRING, ASSIST                                | 72       | 1    | 456404-5            | CRIMPER, WIRE                | 1   |

### CRIMPING DATA

| PAD LETTER       | CRIMP HEIGHT | WIRE SIZE              | WIRE STRIP LENGTH | THIS APPLICATOR WILL APPLY |
|------------------|--------------|------------------------|-------------------|----------------------------|
| A                | .036         | #22                    |                   | 41278                      |
| B                | .034         | #24                    |                   | 41496                      |
| C                | NOT          | USED                   |                   | 41640                      |
| D                | NOT          | USED                   |                   | 41646                      |
|                  |              |                        |                   | 42600                      |
|                  |              |                        |                   | 66091                      |
| CRIMP            | SIZE         | TYPE                   | FEED              | PRESS REF.                 |
| WIRE             | .070         | F                      |                   |                            |
| INSULATION       | .070         | O                      | .609              | 565435-5                   |
| INSULATION RANGE | WIRE RANGE   | APPLICATOR INSTRUCTION |                   |                            |
| .040-.055        | 24-22        | AMP 39                 |                   |                            |

AMP-O-LECTRIC  
POST FEED

E FCN A160488  
D EC-A-070888

SET UP CASE 458638-1  
LAYOUT NO. 6  
APPROVED 8-7-73  
CHECKED 8-7-73  
LOC A C NO. 687893-2

MINIATURE QUICK CHANGE APPLICATOR  
END-FEED (TAPER PIN)

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