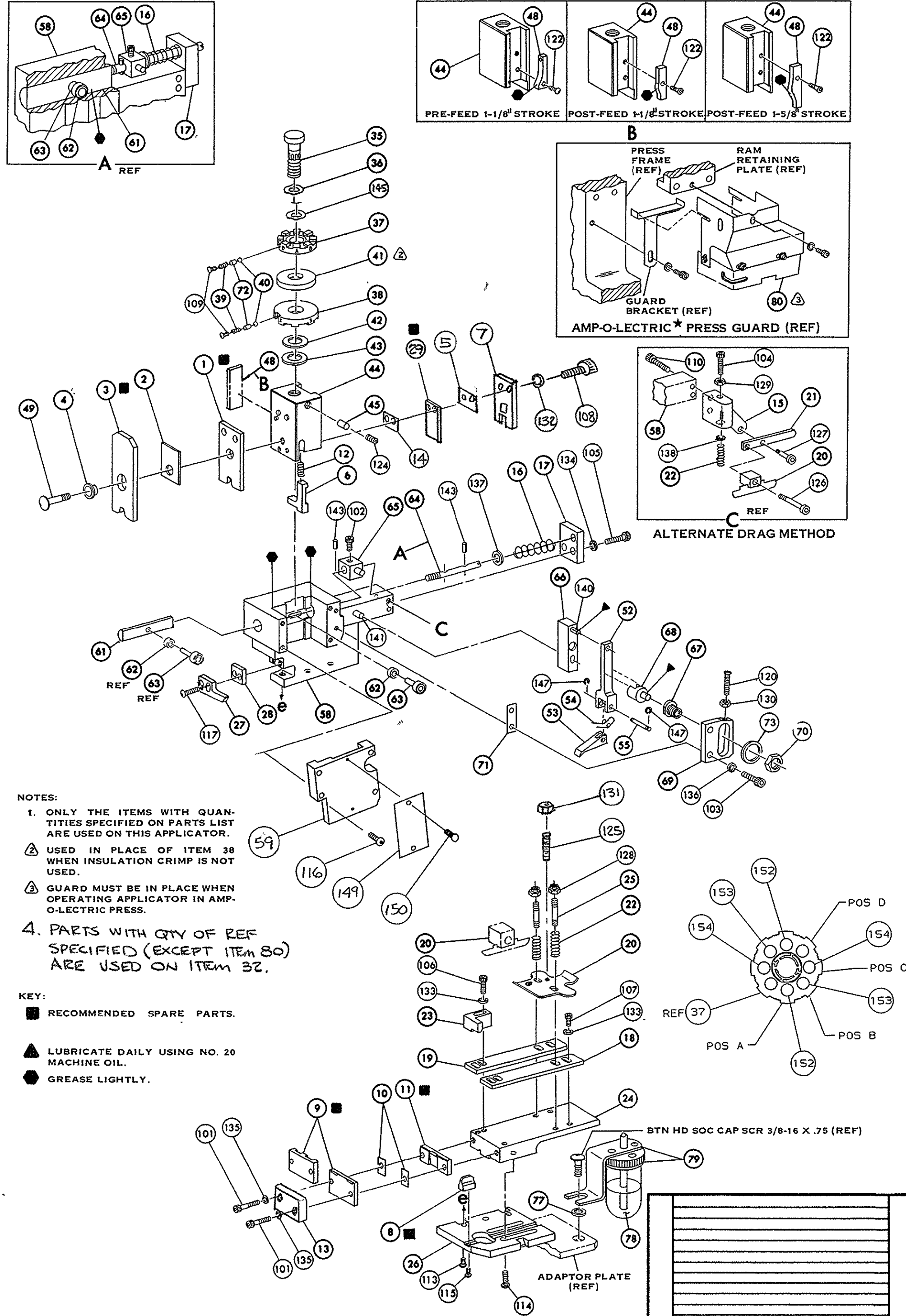


THIS IS A CONTROLLED DOCUMENT.



- 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	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	240634-3	LEVER, TERMINAL	52
			142				51
			141				50
			140				49
			139		7-21002-9	BOLT, CRIMPER	48
			138		690501-3	CAM, POSTFEED 1-1/8 STROKE	47
			137				46
			136				45
			135		690191-1	PLUG, NYLON	44
			134		455674-2	RAM	43
			133		690125-1	WASHER, LAMINATED	42
			132		690124-1	WASHER, RAM	41
			131		690223-1	SPACER, DISC	40
			130		23241-6	BALL, STEEL	39
			129		690170-1	SPRING, COMPRESSION	38
			128			DISC, INSULATION	37
			127		354777-1	DISC, WIRE	36
			126		22480-5	WASHER, SPRING	35
			125				34
			124				33
			123				32
			122		458980-2	APPLICATOR, BASIC (SUB ASSY)	31
			121				30
			120				29
			119		690759-1	TOOL, FLANGING	28
			118		2-690451-2	SPACER, STRIPPER	27
			117		240639-1	STRIPPER	26
			116		455676-1	PLATE, BASE	25
			115		22354-8	DRAG, STUD	24
			114		455678-6	PLATE, STRIP GUIDE	23
			113			PLATE, STRIP HOLD	22
			112		4-22281-1	SPRING, DRAG	21
			111		240636-1	LEVER, DRAG	20
			110		454177-1	DRAG, STOCK	19
			109		458030-3	GUIDE, STRIP REAR	18
			108		458031-3	GUIDE, STRIP FRONT	17
			107		454178-1	GUIDE, FEED ROD	16
			106		4-22284-9	SPRING, FEED RETURN	15
			105		454665-1	ADAPTOR, DRAG	14
			104		2-240641-8	SPACER, HOLD DOWN FLANGE	13
			103		690783-1	PLATE, RETAINING	12
			102			SPRING, HOLD DOWN	11
			101		1-240833-0	PLATE, REAR SHEAR	10
			100		240645-7	SPACER, SHEAR PLATE	9
			99		690784-2	PLATE, FRONT SHEAR	8
			98		2-240654-3	ANVIL	7
			97		1-240651-5	BLADE, SLUG	6
			96			HOLD DOWN	5
			95		4-240641-8	SPACER, SHEAR BLADE	4
			94			SPACER, TUBULAR, INS CRIMPER	3
			93			CRIMPER, INSULATION	2
			92			SPACER, INSULATION	1
			91		1-456411-4	CRIMPER, WIRE	

CRIMPING DATA				THIS APPLICATOR WILL APPLY																	
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH																		
A	.089	14		40577- -A																	
B	.082	16		40705- -A																	
C	.078	18		40819- -A																	
D	NOT USED			41473- -A																	
				350435- -A																	
CRIMP	SIZE	TYPE	FEED	PRESS REF.																	
WIRE	.140	F	.562	565435-5																	
INSULATION	WIRE RANGE		APPLICATOR INSTRUCTION #8039																		
	18-14																				
REMARKS: AMP-O-LECTRIC POST FEED																					
I.D. PLATE (REF): 461264-1																					
SET UP GAGE 458638-1		LAYOUT NO. 237-A		AMP INCORPORATED HARRISBURG, PENNA.																	
DRAWN BY J.E. BEATTY		CHECKED BY J.E. BEATTY		LOC A C NO. 687810-8																	
DATE 5-12-80		DATE 5/14/80		REV. F																	
<table border="1"> <tr> <th>LTR</th> <th>REVISION RECORD</th> <th>ECN</th> <th>DATE</th> <th>LTR</th> <th>REVISION RECORD</th> <th>ECN</th> <th>DATE</th> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>						LTR	REVISION RECORD	ECN	DATE	LTR	REVISION RECORD	ECN	DATE								
LTR	REVISION RECORD	ECN	DATE	LTR	REVISION RECORD	ECN	DATE														
MINIATURE QUICK CHANGE APPLICATOR																					
END-FEED (FLANGED SPADE)																					