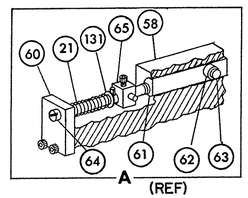
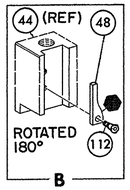
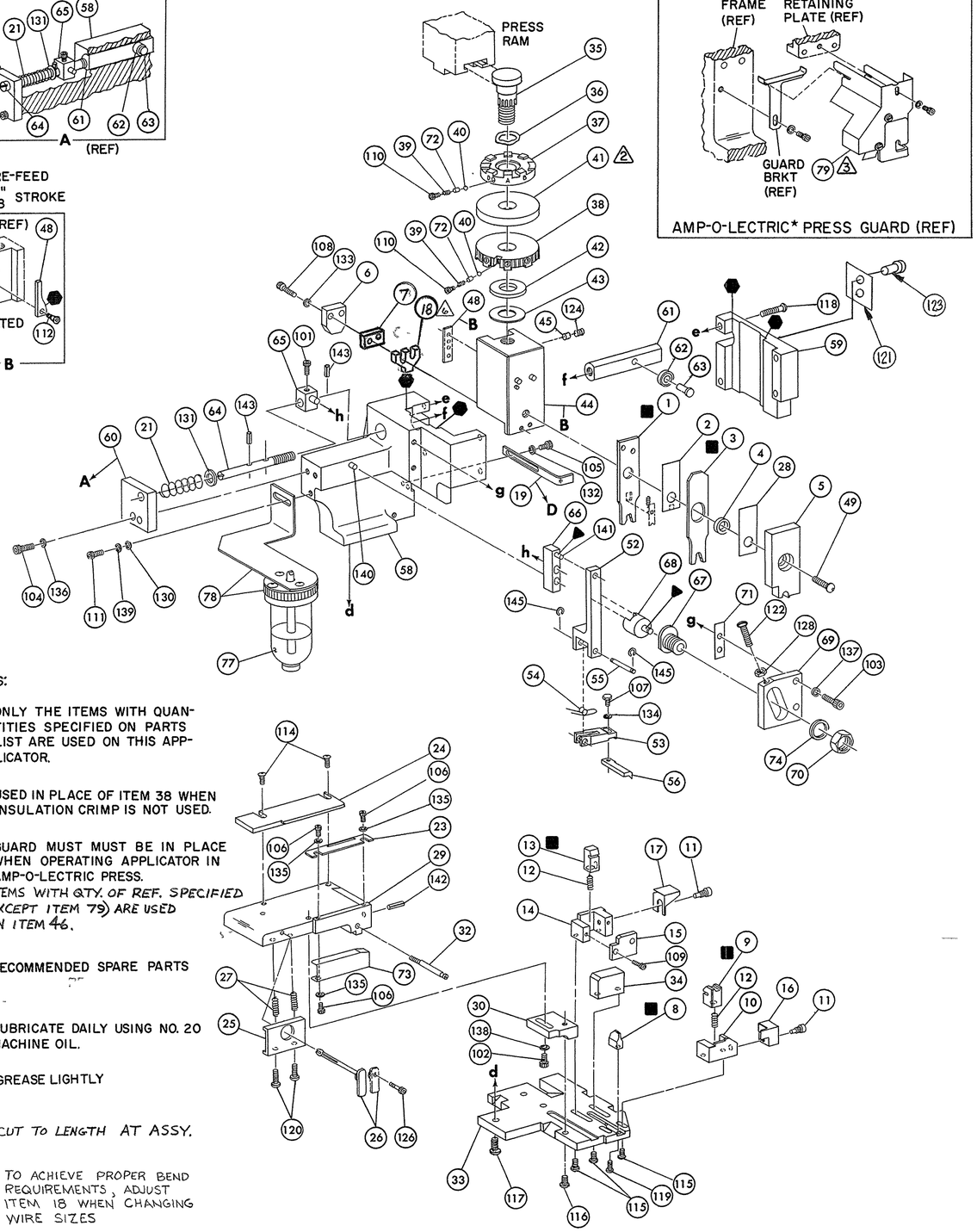
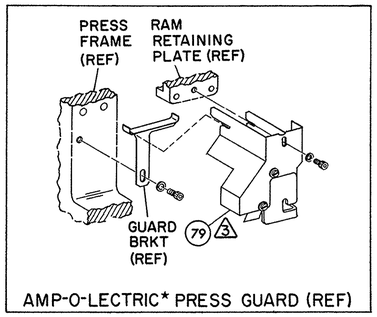


PRE-FEED
1 1/8" STROKE







NOTES:

1.- ONLY THE ITEMS WITH QUANTITIES SPECIFIED ON PARTS LIST ARE USED ON THIS APPLICATOR.

2 -USED IN PLACE OF ITEM 38 WHEN INSULATION CRIMP IS NOT USED.

3 -GUARD MUST MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-O-LECTRIC PRESS.

4. ITEMS WITH QTY. OF REF. SPECIFIED (EXCEPT ITEM 79) ARE USED ON ITEM 46.

KEY:

■ -RECOMMENDED SPARE PARTS

▲ -LUBRICATE DAILY USING NO. 20 MACHINE OIL.

⬢ GREASE LIGHTLY

5 CUT TO LENGTH AT ASSY.

6 TO ACHIEVE PROPER BEND REQUIREMENTS, ADJUST ITEM 18 WHEN CHANGING WIRE SIZES

QTY	PART NO	DESCRIPTION	ITEM NO
REF	21045-3	RING, RETAINING 'C' (.187 DIA) FEED FINGER PIN	145
			144
REF	5-21028-1	PIN, SLOT SPR (.125 DIA X .50) ADJ ROD	143
1	4-21028-0	PIN, SLOT SPR (.093 DIA X .75) STR G PLATE	142
REF	1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	141
REF	1-21030-6	PIN, DOWEL (.187 DIA X 1.25) HOUSING	140
—	21024-5	WASHER, LOCK (NO 10) LUB ASSY	139
1	21024-5	WASHER, LOCK (NO 10) STRIP GUIDE ADJ BLOCK	138
REF	21024-5	WASHER, LOCK (NO 10) ADJ PLATE	137
REF	21024-5	WASHER, LOCK (NO 10) FEED GUIDE ROD	136
2	21024-2	WASHER, LOCK (NO 4) FRONT STRIP GUIDE	135
1	21024-4	WASHER, LOCK (NO 8) FEED FINGER	134
—	21024-4	WASHER, LOCK (NO 8) DEPRESSOR	133
1	21024-4	WASHER, LOCK (NO 8) STRIPPER	132
REF	21899-4	WASHER, FLAT (5/16 DIA) SCREW ADJ	131
—	21899-2	WASHER, FLAT (NO 10) LUB ASSY	130
—	21068-5	NUT, HEX MACH (6-32) HOLDDOWN	129
REF	21068-5	NUT, HEX MACH (6-32) FEED ADJ	128
			127
—	22353-8	SCR, SHLD. (.187 DIA X .250 LG) DRAG LEVER	126
~~1~~	~~456567-1~~	~~SCR, SHLD (.188 DIA X .125 LG) STRIPPER~~	125
1	21009-2	SCR, SKT SET (1/4-20 X .25) (LOC-WEL) RAM	124
2	21017-2	SCREW, DRIVE # 2 X .19	123
REF	6-237125	SCR, RD HD MACH (6-32 X 1.50) FEED ADJ	122
1	461264-1	PLATE, IDENTICATION	121
2	5-21006-6	SCR, SOC SET (10-32 X .75) DRAG	120
1	22783-8	SCR, BUT HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	119
REF	2-21002-9	SCR, BUT HD SKT CAP (10-32 X .75) CAP	118
REF	17177-1	SCR, BUT HD SKT CAP (1/4-20 X .75) HOUSING	117
REF	2-21002-7	SCR, BUT HD SKT CAP (10-32 X .50) SG ADJ BLOCK	116
4	2-21002-2	SCR, BUT HD SKT CAP (8-32 X .50) SHEAR	115
2	2-21002-2	SCR, BUT HD SKT CAP (8-32 X .50) R STRIP GUIDE	114
			113
1	1-21002-7	SCR, BUT HD SKT CAP (6-32 X .38) CAM	112
—	3-21000-4	SCR, SKT HD CAP (10-32 X .38) LUBRICATOR ASSY	111
2	23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	110
2	1-21000-8	SCR, SKT HD CAP (6-32 X .25) REAR SHEAR PLATE	109
2	3-21000-0	SCR, SKT HD CAP (8-32 X .62) DEPRESSOR 5	108
1	2-22603-0	SCR, HEX HD MACH (8-32 X .31) FEED FINGER	107
2	1-21000-3	SCR, SKT HD CAP (4-40 X .25) F STRIP GUIDE	106
1	2-21000-7	SCR, SKT HD CAP (8-32 X .50) STRIPPER	105
REF	3-21000-7	SCR, SKT HD CAP (10-32 X .75) FEED ROD GUIDE	104
REF	3-21000-6	SCR, SKT HD CAP (10-32 X .62) FEED ADJ BLOCK	103
1	3-21000-4	SCR, SKT HD CAP (10-32 X .38) SG ADJ BLOCK	102
REF	3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLOCK	101
REF	455749-1	GUARD, WINDOW 3	79
1	1-465184-0	LUBRICATOR ASSY	78
REF	85293/-2	OIL, LUBRICATING	77
			76
			75
REF	458109-1	WASHER, SPECIAL	74
		~~PLATE, STRIP GUIDE COVER~~	73
2	690603-1	SPRING, ASSIST	72
REF	690517-1	SPACER	71
	22594-8	NUT, HEX	70
	240628-1	PLATE, ADJUSTMENT	69
	240626-1	SHAFT, PIVOT	68
	240633-1	BUSHING	67
	455680-1	LEVER, INTERMEDIATE	66
	240629-1	BLOCK, PIVOT	65
	240632-2	SCREW, ADJUSTMENT FEED ROD	64
	240659-3	PIN, CAM ROLLER	63
	240658-1	ROLLER, CAM	62
	454398-2	ROD, FEED	61
REF	454178-1	GUIDE, FEED ROD	60

QTY	PART NO	DESCRIPTION	ITEM NO
REF	454220-1	CAP, HOUSING	59
REF	454485-1	HOUSING	58
			57
1	458537-2	PAWL, FEED	56
REF	240624-1	PIN, FEED FINGER	55
REF	691499-1	SPRING, FEED FINGER	54
REF	690541-1	FINGER, FEED	53
REF	455679-1	LEVER, TERMINAL FEED ARM	52
		BUMPER, HOLDDOWN	51
		SPACER, TONKER	50
1	7-21002-9	BOLT, CRIMPER	49
1	690602-5	CAM PRE FEED 1 1/8 STROKE	48
			47
1	459456-1	APPLICATOR, BASIC (SUB ASSY)	46
1	690191-1	PLUG, NYLON	45
1	455673-1	RAM	44
1	690125-1	WASHER, LAMINATED	43
1	690124-1	WASHER, RAM	42
		DISC, SPACER	41
2	23241-6	BALL, STEEL	40
2	690170-1	SPRING, COMPRESSION	39
1	690142-1	DISC, INSULATION	38
1	9-690692-9	DISC, WIRE	37
1	22480-5	WASHER, SPRING	36
1	690212-1	POST, RAM	35
		SUPPORT, TERMINAL	34
REF	455675-1	PLATE, BASE	33
1	690432-3	SCREW, ADJUSTMENT	32
			31
REF	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	455671-2	PLATE, STRIP GUIDE	29
1	1-455888-0	SPACER, FRONT SHEAR DEPRESSOR	28
2	1-22284-0	SPRING, DRAG	27
1	690546-1	LEVER, DRAG RELEASE	26
1	240792-1	DRAG, STOCK	25
1	7-690504-1	GUIDE STRIP (REAR)	24
1	690438-1	GUIDE, STRIP (FRONT)	23
			22
REF	4-22284-9	SPRING, FEED RETURN	21
1	458950-1	ARM, STRIPPER	20
1	691353-2	STRIPPER	19
1	1-690518-9	HOLDER, TERMINAL 6	18
1	691668-1	GUARD, CHIP (REAR)	17
1	691667-1	GUARD, CHIP (FRONT)	16
1	690691-9	PLATE, SHEAR (REAR) ■	15
1	690462-1	HOLDER, SHEAR (REAR)	14
1	690463-1	SHEAR, FLOAT (REAR) ■	13
2	3-22280-3	SPRING, SHEAR	12
2	690461-1	STOP, SHEAR	11
1	690459-1	HOLDER, SHEAR (FRONT)	10
1	454276-1	SHEAR, FLOAT (FRONT) ■	9
1	7-690471-0	ANVIL ■	8
1	6-240641-8	SPACER, DEPRESSOR (REAR)	7
1	690468-1	DEPRESSOR, SHEAR (REAR)	6
1	455889-9	DEPRESSOR, SHEAR (FRONT)	5
1	2-238011-2	SPACER, TUBULAR, INS CRIMPER	4
1	4-456135-4	CRIMPER, INSULATION ■	3
1	455888-3	SPACER, CRIMPER	2
1	2-456403-0	CRIMPER, WIRE ■	1

QTY	PART NO	DESCRIPTION	ITEM NO

CRIMPING DATA				APPLICATOR WILL APPLY
PAD LTR	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH	583649
A	.046	18		530235
B	.040	20 OR 0.50 mm²		531478
C	.037	22		531482
D	NOT	USED		

CRIMP	SIZE	TYPE	FEED	APPL INST
WIRE	.062	F	.330	A1 8040
INSUL	.090	O		

WIRE RANGE	INSULATION RANGE	PRESS NO
22-18	.049-.085	565435-5

REMARKS

AMP-O-LECTRIC
PRE-FEED

APPLICATION SPEC. 114-9004

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

P	F	LTR	REVISION RECORD	APP	DATE
		J	ECR-08-014473	TM	6-08
	✓	H1	ECN 0150-0404-02	MM/JRF	3-02
		H	ECN 0150-0165-00	MM/JRF	2-00
✓	✓	G	REV PER ECN-272290	LJ/MM	10-90
✓	✓	F	ECN R-6031	DJ/CE	12/1/89
✓	✓	E2	REV SPARE PARTS NOTE	GG	6-12-84
✓	✓	E1	REV. PER ECN E 3708	TW	9/8/80
✓	✓	E	REV PER ECN R 3326	JM	12-79
✓	✓	D1	REV PER ECN R2975	RB	9-12-79
✓		D	REV PER ECN R2753	LSM	11-78
✓	✓	C1	ADDED 530235 R2719	JM	10-78
✓	✓	C	REV. PER R2666	SB	8-78
✓	✓	B	ADD ITEM 78-79 R2629	SB	7/28/78
✓	✓	A	REV PER ECN R2355	SB	2-78

SET UP GAGE 10-1 458637-1 1478
DR 10-28-77 APP 11/77
CHK 11/77 REL 11/77
LOC A D NO 466713-2 REV J

AMP INCORPORATED Harrisburg, Pa

NAME MINIATURE QUICK CHANGE APPLICATOR
SIDE FEED (CONTACT, TWIN LEAF)

CUSTOMER AND ASSEMBLY DRAWING

CAGE CODE 00779

RESTRICTED

DIST 66

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AMP 2983-3 (4-76)