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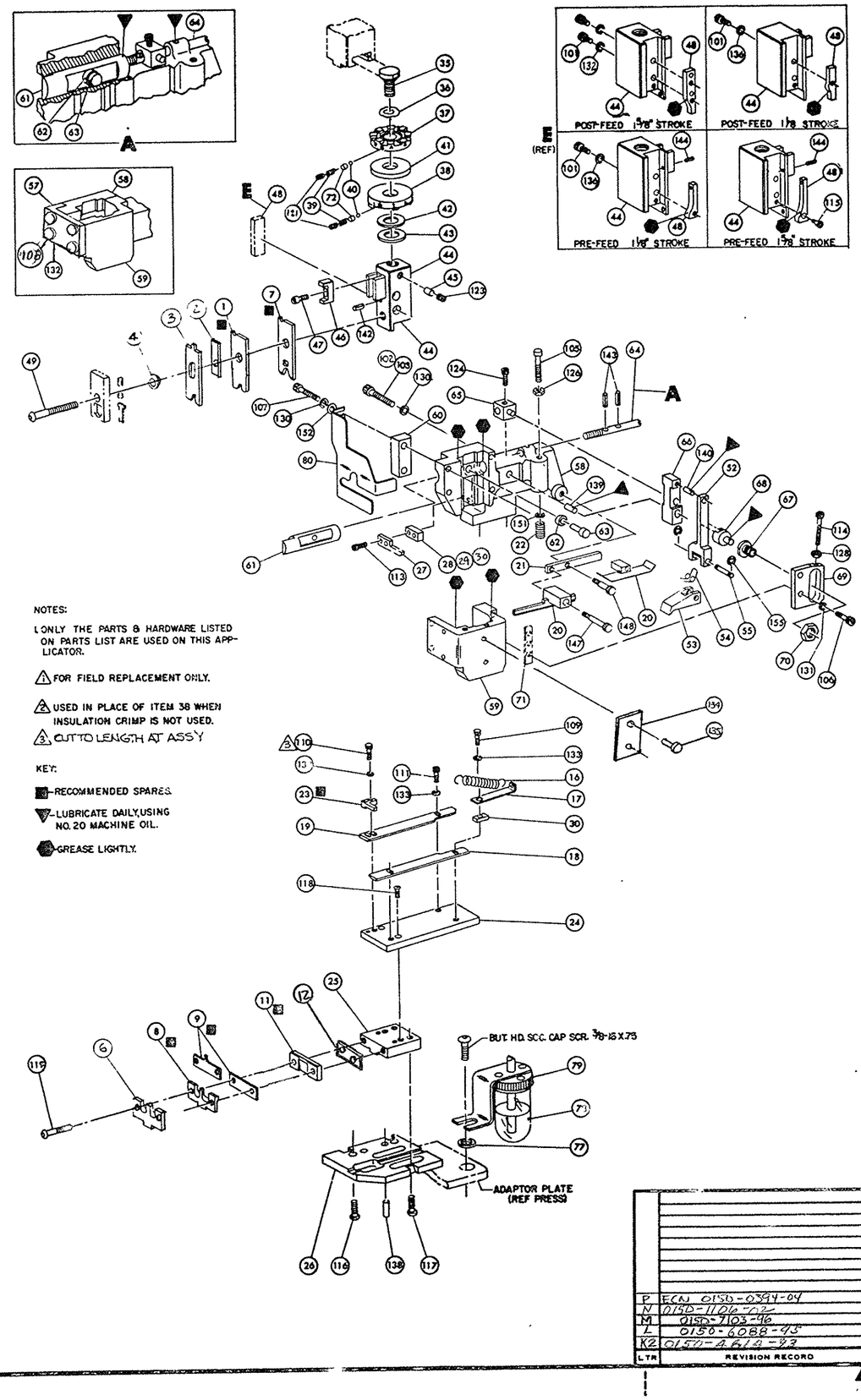
THIS IS A CONTROLLED DOCUMENT.



NOTES:

1. ONLY THE PARTS & HARDWARE LISTED ON PARTS LIST ARE USED ON THIS APPLICATOR.

⚠1 FOR FIELD REPLACEMENT ONLY.

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

⚠3 CUT TO LENGTH AT ASSY

KEY:

■ RECOMMENDED SPARES.

▼ LUBRICATE DAILY, USING NO. 20 MACHINE OIL.

⬢ GREASE LIGHTLY.

REQ.	PART NO.	DESCRIPTION	NO.
			162
			161
			160
			159
			158
			157
			156
2	21045-3	RING, RTNG. "C" (3/16 DIA) FEED PIN	155
			154
			153
~~2~~	~~21033-7~~	~~WASHER, FLAT (#10) GUARD~~	152
1	22260-5	WASHER, FLAT (#6) DRAG SPRING	151
			150
			149
1	5-21004-7	SCREW, SKT. HD. SHLDR. (¼ DIA X .250) DRAG ARM	148
1	21004-5	SCREW, SKT. HD. SHLDR. (¼ DIA X 1.000) DRAG	147
			146
			145
—	9-21028-0	PIN, SLOTTED SPRING (12 DIA X .25) CAM	144
2	5-21028-1	PIN, SLOTTED SPRING (1/8 DIA X .50) FEED ADJ. ROD	143
—	21028-2	PIN, SLOTTED SPRING (1/16 DIA X .25) RAM ⚠1	142
			141
1	1-21030-1	PIN, DOWEL (3/16 DIA X .50) LEVER	140
1	1-21030-7	PIN, DOWEL (3/16 DIA X 1.50) HOUSING	139
—	2-21030-2	PIN, DOWEL (¼ DIA X .75) BASE PLATE	138
			137
—	21024-5	WASHER, LOCK (#10) CAM	136
2	21017-2	SCR, DRIVE	135
1	461264-1	PLATE, IDENTIFICATION	134
5	21024-4	WASHER, LOCK (#8) STRIP GUIDE	133
8	21024-5	WASHER, LOCK (#10) HOUSING AND CAP	132
—	21024-5	WASHER, LOCK (#10) FEED ADJ. PLATE	131
~~4~~	~~21024-5~~	~~WASHER, LOCK (#10) HOUSING CAP~~	130
			129
1	21018-5	NUT HEX MACH. (6-32) FEED ADJ!	128
			127
1	21018-7	NUT, HEX MACH (10-32) DRAG SPRING	126
			125
1	3-21000-4	SCREW, SKT. HD. CAP (10-32 X .38) PIVOT BLOCK	124
1	21009-2	SCREW, SKT. SET (NYLOK) (¼-20 X .25) C.P. RAM	123
~~2~~	~~2-21006-2~~	~~SCREW, SKT. SET (8-32 X .12) C.P. DISC~~	122
2	23030-1	SCREW, SKT. HD. CAP (6-32X.25) (NYLOK) C.P. DISC	121
			120
2	2-21002-9	SCREW, BTN. HD. SKT. CAP (10-32 X .75) ANVIL	119
2	2-21002-5	SCREW, BTN. HD. SKT. CAP (10-32 X .25) STRIP GUIDE PLATE	118
4	3-21002-3	SCREW BTN. HD. SKT. CAP (¼-20 X .50) BASE BLOCK	117
2	2-22783-3	SCREW, BTN. HD. SKT. CAP (¼-20 X .62 HOUSING SELF-LOCK	116
—	1-21003-9	SCREW, FLAT HD. SOC CAP (6-32 X .38) CAM	115
1	6-23715-5	SCREW, RD HD. MACH (6-32 X 1.50) FEED ADJ.	114
2	8-21002-9	SCREW, BTN. HD. CAP (8-32 X1.00) STRIPPER	113
			112
2	7-21000-4	SCREW, SKT. HD. CAP (8-32 X .31) STRIP GUIDE	111
2	2-21002-4	SCREW, BTN HD. CAP (8-32 X .37) STRIP GUIDE ⚠2	110
1	2-21000-9	SCREW, SKT. HD. CAP (8-32 X .75) STRIP GUIDE	109
4	2-21002-7	SCREW, BUTTON HD CAP (10-32 X .50) HOUSING PLATE	108
~~2~~	~~3-21000-7~~	~~SCREW, SKT. HD. CAP (10-32 X .50) HOUSING PLATE~~	107
2	3-21000-6	SCREW, SKT. HD. CAP (10-32 X .62) HOUSING AND CAP	106
1	3-21000-9	SCREW, SKT. HD. CAP (10-32 X 1.00) DRAG SPRING	105
—	3-21000-6	SCREW, SKT. HD. CAP (10-32 X .62) FEED ADJ. PLATE	104
~~1~~	~~21000-1~~	~~SCREW, SKT. HD. CAP (10-32 X 1.50) HOUSING CAP~~	103
~~1~~	~~3-21000-9~~	~~SCREW, SKT. HD. CAP (10-32 X 1.25) HOUSING CAP~~	102
2	3-21000-3	SCREW, SKT. HD. CAP (10-32 X .50) CAM	101
REF	455745-1	GUARD (WINDOW)	80
—	465184-9	LUBRICATOR ASSY.	79
—	22014-1	OIL, SYNTHETIC	78
—	454406-1	SPACER, LUBRICATOR BRACKET	77
			76
			75
			74
			73
2	690603-1	ASSIST, SPRING	72

NO.	REQ.	PART NO.	DESCRIPTION	NO.
71	1	690517-1	SPACER	
70	1	22594-8	NUT, HEX	
69	1	240628-1	PLATE, ADJUSTMENT	
68	1	240626-1	SHAFT, PIVOT	
67	1	240633-1	BUSHING	
66	1	240630-1	LEVER, INTERMEDIATE	
65	1	240629-1	BLOCK, PIVOT	
64	1	240632-1	SCREW, ADJUSTMENT	
63	1	240659-1	PIN, CAM ROLLER	
62	1	240658-1	CAM, ROLLER	
61	1	240631-1	ROD, FEED	
60	1	~~240645-1~~	~~PLATE, REAR~~	
59	1	690741-1	CAP, RAM	
58	1	690746-1	HOUSING	
57	1	691868-1	PLATE, HOUSING	
56				
55	1	240624-1	PIN, FEED FINGER	
54	1	240638-1	SPRING FEED FINGER	
53	1	240635-1	FINGER, FEED	
52	1	240634-1	LEVER, TERMINAL	
51				
50				
49	1	7-21002-9	BOLT, CRIMPER	
48	1	238015-1	CAM POST FEED 1⅝ STROKE	
47	1	22353-8	SCREW, SHOULDER	
46	1	690402-1	BLOCK, INS, ADJUSTMENT	
45	1	690191-1	PLUG, NYLON	
44	1	690476-1	RAM	
43	1	690125-1	WASHER, LAMINATED	
42	1	690124-4	WASHER, RAM	
41			SPACER, DISC. ⚠2	
40	2	23241-6	BALL, STEEL	
39	2	690170-1	SPRING, COMPRESSION	
38	1	690142-1	DISC, INSULATION	
37	1	3-690141-4	DISC, WIRE	
36	1	22480-5	SPRING, WASHER	
35	1	690212-1	POST, RAM	
34				
33				
32				
31	1	5-690451-1	SPACER, ~~BASE BLOCK~~ STRIPPER	
30	~~1~~	~~690453-1~~	~~SPACER, ANCHOR~~	
29	1	1-690447-1	SPACER, STRIPPER	
28	1	1-690451-3	SPACER, STRIPPER	
27	1	690455-4	STRIPPER	
26	1	690658-1	PLATE, BASE	
25	1	240647-1	BLOCK, BASE	
24	1	240648-1	PLATE, STRIP GUIDE	
23	1	457261-1	PLATE, STRIP HOLD	
22	1	7-22282-5	SPRING, DRAG	
21	1	240636-1	DRAG, LEVER	
20	1	1-240696-5	DRAG, STOCK	
19	1	454204-1	GUIDE, STRIP, REAR	
18	1	454204-1	GUIDE STRIP, FRONT	
17	1	238008-1	ANCHOR, SPRING	
16	1	2-22287-7	SPRING, FEED RETURN	
15				
14				
13				
12	1	240645-3	SPACER	
11	1	679819-1	PLATE, REAR SHEAR	
10		~~1-240645-3~~	~~SPACER, REAR PLATE~~	
9	1	690619-6	PLATE, [redacted]	
8	1	3-690618-2	ANVIL	
7	1	457068-1	BLADE, SLUG	
6	1	456356-1	ANVIL, INS	
5				
4	1	238009-1	SPACER TUBULAR NS CRIMPER	
3	1	693110-3	CRIMPER, INS	
2	1	1-690707-2	SPACER, CRIMPER	
1	1	818252-1	CRIMPER, WIRE	

TERM APPL SPEC 114-2088

CRIMPING DATA

PAD LETTER	CRIMP HEIGHT	WIRE SIZE	WIRE STRIP LENGTH
A	.051	1.0MM² (18)	
B	.047	.75MM² (19)	
C	.045	.5 MM² (20)	
D	NOT USED		

	SIZE	TYPE	FEED
CRIMP			
WIRE	.100	F	.500
INSULATION	.130	F	

INSULATION RANGE	WIRE RANGE	APPLICATOR INSTRUCTION AI 3024
.070-.130	.5 TO 1.0MM2	

REMARKS

AMPOMATOR

THIS APPLICATOR WILL APPLY

325552-1
" -2
" -3
" -4
" -5
" -6
" -7
" -8
" -9
" -0
1- " -1
1- " -2
1- " -3

LTR	REVISION RECORD	ECN	DR	CK	DATE
P	ECN 0150-0394-04		M/re		3-04
N	0150-1106-02		TE		5-02
M	0150-7103-96		DR		8/96
L	0150-6088-93		M/re		4/95
K2	0150-4614-93		M/re		6-93
K1	OBS. PER A-292091	-			2-91
K	ECN R 6724	-			4-23-90
J	REV PER ECN	R			11-17-89
H	REV PER ECN	K			11-14-89
G	REV PER ECN	L			6-26-85
F	REV. PER ECN	L			9-17-73
E	REV PER ECN	L			8-15-72
D	REV PER ECN	L			5-11-72
C	REV PER ECN	L			2-15-72
B1	REV PER ECN	L			12-5-72
B	REV. PER ECN	L			11-9-71
A	ITEM 20 WAS-2	L			9-24-71

SET UP GAGE 679108-1 | LAYOUT NO. 513 | DRAWN | CHECKED | APPROVED | REL.

AMP INCORPORATED HARRISBURG, PENNA.

LOC A C | NO. 687483-1 | REV. P

SCALE NONE | NAME MINIATURE QUICK CHANGE APPLICATOR END-FEED, SPLICE TYPE.

00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

687483-1

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AMP 5085