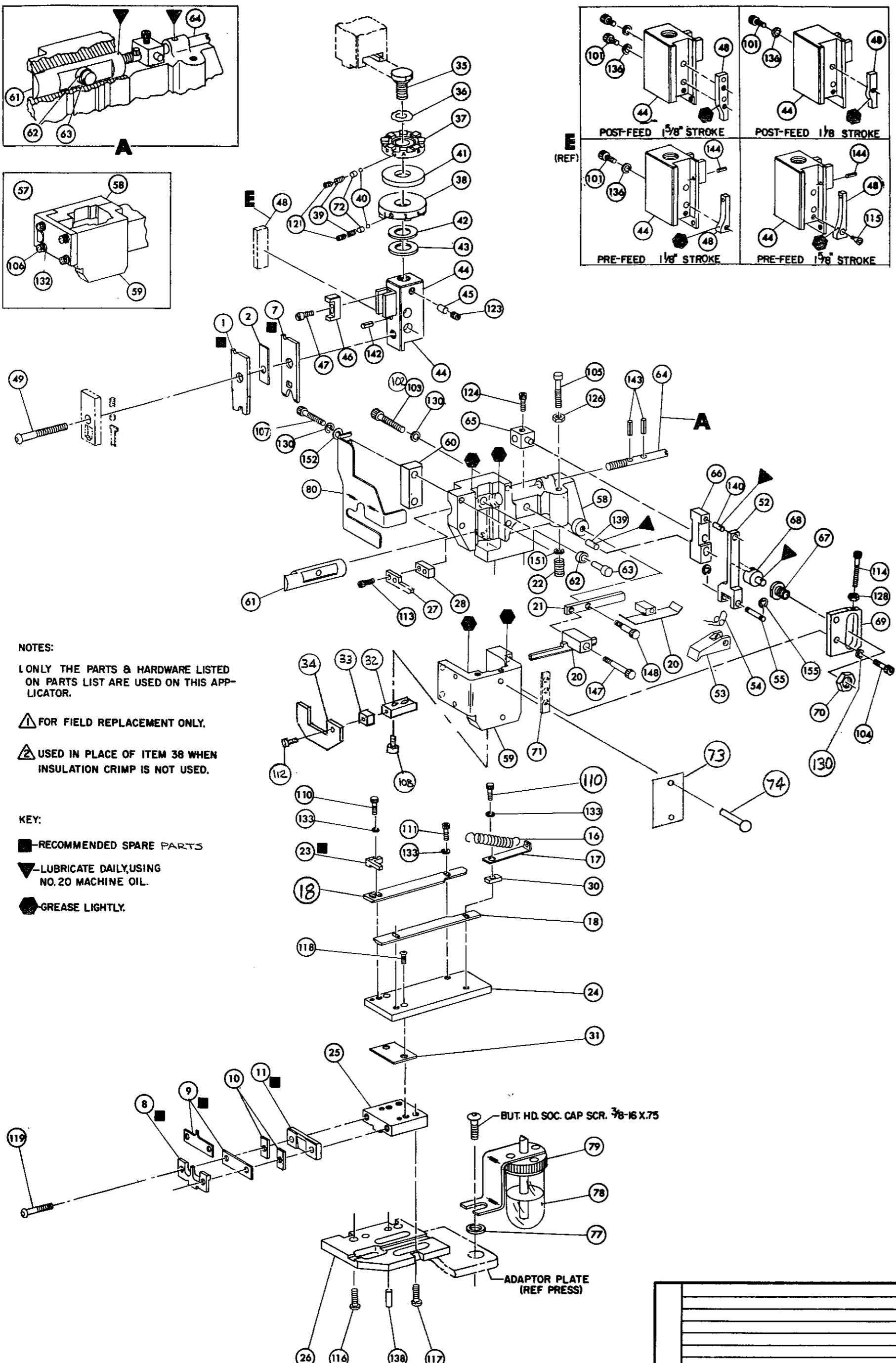


THIS DRAWING IS A CONTROLLED DOCUMENT.



**NOTES:**  
 ONLY THE PARTS & HARDWARE LISTED ON PARTS LIST ARE USED ON THIS APPLICATOR.  
 ▲ FOR FIELD REPLACEMENT ONLY.  
 ▲ USED IN PLACE OF ITEM 38 WHEN INSULATION CRIMP IS NOT USED.

**KEY:**  
 ■ RECOMMENDED SPARE PARTS  
 ▼ LUBRICATE DAILY, USING NO. 20 MACHINE OIL.  
 ● GREASE LIGHTLY.

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 DIMENSIONS IN INCHES DO NOT SCALE PRINT.

| REQ. | PART NO. | DESCRIPTION | NO. | REQ. | PART NO.   | DESCRIPTION             | NO. |
|------|----------|-------------|-----|------|------------|-------------------------|-----|
|      |          |             | 162 | 1    | 690517-1   | SPACER                  | 71  |
|      |          |             | 161 | 1    | 22594-8    | NUT, HEX                | 70  |
|      |          |             | 160 | 1    | 240628-1   | PLATE, ADJUSTMENT       | 69  |
|      |          |             | 159 | 1    | 240626-1   | SHAFT, PIVOT            | 68  |
|      |          |             | 158 | 1    | 240633-1   | BUSHING                 | 67  |
|      |          |             | 157 | 1    | 240630-1   | LEVER, INTERMEDIATE     | 66  |
|      |          |             | 156 | 1    | 240629-1   | BLOCK, PIVOT            | 65  |
|      |          |             | 155 | 1    | 240632-1   | SCREW, ADJUSTMENT       | 64  |
|      |          |             | 154 | 1    | 240659-1   | PIN, CAM ROLLER         | 63  |
|      |          |             | 153 | 1    | 240658-1   | CAM, ROLLER             | 62  |
|      |          |             | 152 | 1    | 240631-1   | ROD, FEED               | 61  |
|      |          |             | 151 | 1    | 240845-1   | PLATE, WEAR             | 60  |
|      |          |             | 150 | 1    | 454059-1   | CAP, RAM                | 59  |
|      |          |             | 149 | 1    | 240619-1   | HOUSING                 | 58  |
|      |          |             | 148 |      |            |                         | 57  |
|      |          |             | 147 |      |            |                         | 56  |
|      |          |             | 146 | 1    | 240624-1   | PIN, FEED FINGER        | 55  |
|      |          |             | 145 | 1    | 240628-1   | SPRING FEED FINGER      | 54  |
|      |          |             | 144 | 1    | 240625-1   | FINGER, FEED            | 53  |
|      |          |             | 143 | 1    | 240634-1   | LEVER, TERMINAL         | 52  |
|      |          |             | 142 |      |            |                         | 51  |
|      |          |             | 141 |      |            |                         | 50  |
|      |          |             | 140 | 1    | 7-21002-9  | BOLT, CRIMPER           | 49  |
|      |          |             | 139 | 1    | 690602-2   | CAM PRE FEED 1/8 STROKE | 48  |
|      |          |             | 138 |      |            | SCREW, SHOULDER         | 47  |
|      |          |             | 137 |      |            | BLOCK, INS. ADJUSTMENT  | 46  |
|      |          |             | 136 | 1    | 690191-1   | PLUG, NYLON             | 45  |
|      |          |             | 135 | 1    | 690747-1   | RAM                     | 44  |
|      |          |             | 134 | 1    | 690125-1   | WASHER, LAMINATED       | 43  |
|      |          |             | 133 | 1    | 690124-4   | WASHER, RAM             | 42  |
|      |          |             | 132 | 1    | 690223-1   | SPACER, DISC.           | 41  |
|      |          |             | 131 | 1    | 23241-6    | BALL, STEEL             | 40  |
|      |          |             | 130 | 1    | 690170-1   | SPRING, COMPRESSION     | 39  |
|      |          |             | 129 |      |            | DISC, INSULATION        | 38  |
|      |          |             | 128 | 1    | 7-690692-1 | DISC, WIRE              | 37  |
|      |          |             | 127 | 1    | 22480-5    | SPRING, WASHER          | 36  |

|  |  |  |     |   |            |   |    |
|--|--|--|-----|---|------------|---|----|
|  |  |  | 126 | 1 | 690212-1   | POST, RAM   | 35 |
|  |  |  | 125 | 1 | 453173-4   | STRIPPER  | 34 |
|  |  |  | 124 | 1 | 453774-4   | SPACER, STRIPPER                                  | 33 |
|  |  |  | 123 | 1 | 453775-1   | STRIPPER, BLOCK                                   | 32 |
|  |  |  | 122 | 1 |            | SPACER, BASE BLOCK                                | 31 |
|  |  |  | 121 | 1 |            | SPACER, ANCHOR                                    | 30 |
|  |  |  | 120 |   |            |   | 29 |
|  |  |  | 119 |   |            | SPACER, STRIPPER                                  | 28 |
|  |  |  | 118 |   |            | STRIPPER  | 27 |
|  |  |  | 117 | 1 | 690658-1   | PLATE, BASE                                       | 26 |
|  |  |  | 116 | 1 | 240647-1   | BLOCK, BASE                                       | 25 |
|  |  |  | 115 | 1 | 240648-1   | PLATE, STRIP GUIDE                                | 24 |
|  |  |  | 114 | 1 | 240825-7   | PLATE, STRIP HOLD                                 | 23 |
|  |  |  | 113 | 1 | 7-22282-5  | SPRING, DRAG                                      | 22 |
|  |  |  | 112 | 1 | 240636-1   | DRAG, LEVER                                       | 21 |
|  |  |  | 111 | 1 | 240637-1   | DRAG, STOCK                                       | 20 |
|  |  |  | 110 | 1 | 7-454204-3 | GUIDE, STRIP, REAR                                | 19 |
|  |  |  | 109 | 2 | 7-454204-3 | GUIDE, STRIP, FRONT & REAR                        | 18 |
|  |  |  | 108 | 1 | 238008-1   | ANCHOR, SPRING                                    | 17 |
|  |  |  | 107 | 1 | 3-22287-0  | SPRING, FEED RETURN                               | 16 |
|  |  |  | 106 |   |            |   | 15 |
|  |  |  | 105 |   |            | SCREW, SKT. HD. CAP (10-32 X 1.00) DRAG SPRING    | 14 |
|  |  |  | 104 |   |            | SCREW, SKT. HD. CAP (10-32 X .62) FEED ADJ. PLATE | 13 |
|  |  |  | 103 |   |            | SCREW, SKT. HD. CAP (10-32 X 1.50) HOUSING CAP    | 12 |
|  |  |  | 102 | 1 | 694872-1   | PLATE, REAR SHEAR                                 | 11 |
|  |  |  | 101 | 1 | 690619-6   | SPACER, SHEAR PLATE                               | 10 |
|  |  |  | 80  | 1 | 690619-6   | PLATE, FRONT SHEAR                                | 9  |
|  |  |  | 79  | 1 | 1-690618-9 | ANVIL   | 8  |
|  |  |  | 78  | 1 | 468931-1   | BLADE, SLUG                                       | 7  |
|  |  |  | 77  |   |            |   | 6  |
|  |  |  | 76  |   |            |   | 5  |
|  |  |  | 75  |   |            |   | 4  |
|  |  |  | 74  |   |            |   | 3  |
|  |  |  | 73  | 1 | 3-690407-9 | SPACER, CRIMPER                                   | 2  |
|  |  |  | 72  | 1 | 4-53839-2  | CRIMPER, WIRE                                     | 1  |

| CRIMPING DATA        |              |            |                   | THIS APPLICATOR WILL APPLY |       |
|----------------------|--------------|------------|-------------------|----------------------------|-------|
| PAD LETTER           | CRIMP HEIGHT | WIRE SIZE  | WIRE STRIP LENGTH |                            |       |
| A                    | .068         | 16         |                   |                            | 40662 |
| B                    | .063         | 18         |                   |                            | 40792 |
| C                    | .059         | 20         |                   |                            | 42523 |
| D                    | NOT USED     |            |                   |                            |       |
| CRIMP                | SIZE         | TYPE       | FEED              | PRESS REF                  |       |
| WIRE                 | .120         | F          | .234              | 565435-5                   |       |
| INSULATION           | —H—          | —H—        |                   |                            |       |
| INSULATION RANGE     | —H—          | WIRE RANGE | 20-16             | APPLICATOR INSTRUCTION #   | 8024  |
| REMARKS              |              |            |                   |                            |       |
| AMPOLECTRIC PRE-FEED |              |            |                   |                            |       |

| REV | DATE            | DESCRIPTION | BY     | CHK      |
|-----|-----------------|-------------|--------|----------|
| SZ  | 0150-1          | -99         | JES    | 499      |
| S1  | 0150-6785-96    |             | M7     | 109      |
| S   | ECN R-6728      |             | CPM    | 4-86     |
| R   | REV PER ECN     |             | R 5024 | 3-31-88  |
| Q   | REV ITEM 8 & 9  |             | R 2887 | 2-79     |
| P   | REV PER ECN     |             | R 1847 | 10-276   |
| N   | REV PER ECN     |             | R 1754 | 7-26-76  |
| M   | REV PER ECN     |             | R 1220 | 10-11-75 |
| L   | REV PER ECN     |             | R 897  | 8-28-74  |
| K   | REV PER ECN     |             | R 8830 | 4-16-73  |
| J   | REV PER ECN     |             | R 8719 | 11-20-72 |
| I   | REV PER ECN     |             | R 8614 | 11-20-72 |
| H   | REV PER ECN     |             | R 8476 | 10-13-71 |
| G   | REDRAWN PER ECN |             | R 8476 | 10-13-71 |

| SET UP GAGE | LAYOUT NO. | APPROVED | CHECKED | SCALE | NAME |
|-------------|------------|----------|---------|-------|------|
| 69108-1     | 201        | BAWOLEE  | 9-13-71 | NONE  |      |
|             |            |          |         |       |      |

| AMP                                      | AMP INCORPORATED   | LOC | NO. | REV.     |
|--|--------------------|-----|-----|----------|
|  | HARRISBURG, PENNA. | A   | C   | 686183-3 |
| <b>MINIATURE QUICK CHANGE APPLICATOR</b> |                    |     |     |          |
| <b>END-FEED, SPLICE TYPE.</b>            |                    |     |     |          |

686183-3