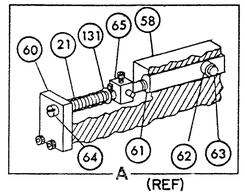
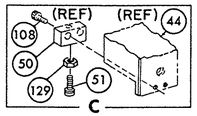
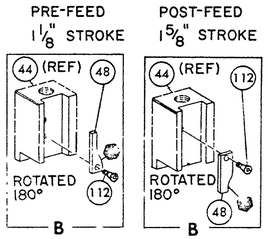
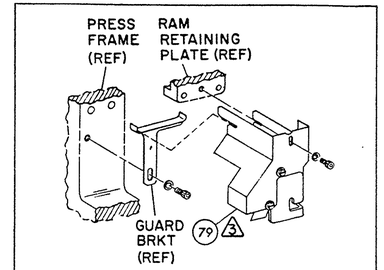
THIS DRAWING IS A CONTROLLED DOCUMENT. FOR THE LATEST REVISION, AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

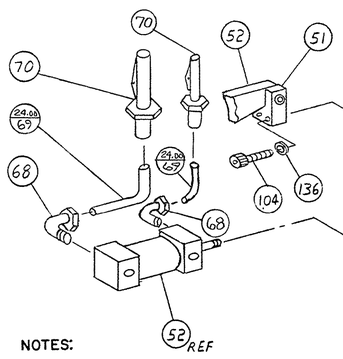
THIS IS A CONTROLLED DOCUMENT.











NOTES:

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

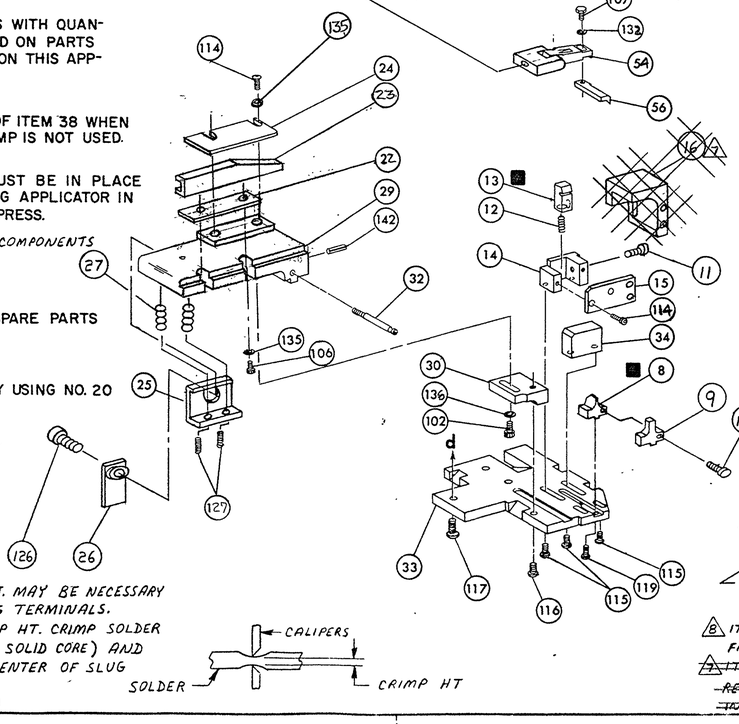
2. USED IN PLACE OF ITEM 38 WHEN INSULATION CRIMP IS NOT USED.

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

4. SEE DRWG FOR COMPONENTS

KEY:

- ■ RECOMMENDED SPARE PARTS
- ▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- ⬢ GREASE LIGHTLY



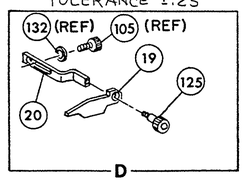
5. FEED ASS'Y ADJ. MAY BE NECESSARY WHEN SWITCHING TERMINALS.

6. TO CHECK CRIMP HT. CRIMP SOLDER (1/8 DIA 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG

14. ITEM NOT SHOWN.

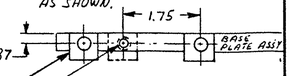
13. ITEMS 75 & 144 MUST BE INSTALLED IN THE G.T.U CHIP RELIEF HOLE BEFORE INSTALLING APPLICATOR.

12. QTY IN INCHES
TOLERANCE ±.25



11. INSTALL ITEM 75 IN CHIP RELIEF HOLE OF T-PRESS BEFORE INSTALLING APPL.

10. IT MAY BE NECESSARY TO MODIFY THE T-PRESS BASE PLATE BEFORE INSTALLING THIS APPL. BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.



8. ITEM 76 REQ'D WHEN APPL. IS REMOVED FROM AMP-O-MATOR & PLACED IN A-O-L PRESS.

7. ~~ITEM 16 MUST BE REMOVED IF APPL. IS REMOVED FROM AMP-O-MATOR & PLACED IN A-O-L PRESS~~

—	21045-3	RING, RETAINING 'C' (.187 DIA) FEED FINGER PIN	145	1	454220-1	CAP, HOUSING	59
1	189728-1	BRACKET, SPACER 4 13	144	1	454485-1	HOUSING	58
—	5-21028-1	PIN, SLOT SPR (.125 DIA X .50) ADJ ROD	143				57
1	4-21028-0	PIN, SLOT SPR (.093 DIA X .75) STR G PLATE	142	1	462427-1	PAWL, FEED	56
—	1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	141	—	240624-1	PIN, FEED FINGER	55
—	1-21030-6	PIN, DOWEL (.187 DIA X 1.25) HOUSING	140	1	461062-2	ASS'Y, FEED FINGER	54
—	21024-5	WASHER, LOCK (NO 10) LUB ASSY	139			FINGER, FEED	53
~~1~~	~~21024-5~~	~~WASHER, LOCK (NO 10) STRIP GUIDE ADJ BLOCK~~	138	1	461065-4	ASS'Y, AIR FEED 5	52
—	21024-5	WASHER, LOCK (NO 10) ADJ PLATE	137	1	459610-3	MOUNT, FEED BRACKET	51
3	21024-5	WASHER, LOCK (NO 10) FEED GUIDE ROD	136			SPACER, TONKER	50
3	21024-2	WASHER, LOCK (NO 4) FRONT STRIP GUIDE	135	1	7-21002-9	BOLT, CRIMPER	49
~~1~~	~~21024-4~~	~~WASHER, LOCK (NO 8) FEED FINGER~~	134			CAM FEED STROKE	48
~~2~~	~~21024-4~~	~~WASHER, LOCK (NO 8) DEPRESSOR~~	133				47
4	21024-4	WASHER, LOCK (NO 8) STRIPPER, DEP & FINGER	132		459456-1	APPLICATOR, BASIC (SUB ASSY)	46
—	21899-4	WASHER, FLAT (5/16 DIA) SCREW ADJ	131	1	690191-1	PLUG, NYLON	45
—	21899-2	WASHER, FLAT (NO 10) LUB ASSY	130	1	455673-1	RAM	44
—	21018-5	NUT, HEX MACH (6-32) HOLDDOWN	129	1	690125-1	WASHER, LAMINATED	43
—	21018-5	NUT, HEX MACH (6-32) FEED ADJ	128	1	690124-1	WASHER, RAM	42
2	5-21006-6	SCR, SET (10-32 X .75) DRAG	127	8	1-22280-2	SPRING, INS. DISC	41
1	22353-8	SCR, SHLD. (.187 DIA X .250 LG) DRAG LEVER	126	2	23241-6	BALL, STEEL	40
~~—~~	~~456567-1~~	~~SCR, SHLD (.188 DIA X .125 LG) STRIPPER~~	125	2	690170-1	SPRING, COMPRESSION	39
.1	21007-2	SCR, SKT SET (1/4-20 X .25) (LOC-WEL) RAM	124	1	690142-5	DISC, INSULATION	38
2	21017-2	SCR, DRIVE #2 X .19	123	1	808834-1	DISC, WIRE	37
—	6-23715-5	SCR, PAN HD MACH (6-32 X 1.50) FEED ADJ	122	1	22480-5	WASHER, SPRING	36
1	461264-1	PLATE, IDENTIFICATION	121	1	690212-1	POST, RAM	35
~~2~~	~~21002-9~~	~~SCR, BUT HD SKT CAP (10-32 X .75) DRAG~~	120			SUPPORT, TERMINAL	34
1	22733-8	SCR, BUT HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	119	1	808835-1	PLATE, BASE	33
4	2-21002-9	SCR, BUT HD SKT CAP (10-32 X .75) CAP	118	1	690432-3	SCREW, ADJUSTMENT	32
3	17177-1	SCR, BUT HD SKT CAP (1/4-20 X .62) HOUSING	117				31
1	2-21002-7	SCR, BUT HD SKT CAP (10-32 X .50) SG ADJ BLOCK	116	1	455689-1	BLOCK, STRIP GUIDE ADJ	30
4	2-21002-2	SCR, BUT HD SKT CAP (8-32 X .50) SHEAR	115	1	684045-2	PLATE, STRIP GUIDE	29
4	1-21000-3	SCR, SKT HD SKT CAP (4-40 X .25) R STRIP GUIDE	114			SPACER, FRONT SHEAR DEPRESSOR	28
~~2~~	~~2-21000-7~~	~~SCR, SKT HD CAP (8-32 X .50) ANVIL, INS'L~~	113	2	22281-9	SPRING, DRAG	27
1	2-21003-0	SCR, FLAT HD SKT CAP (6-32 X .50) CAM	112	1	240793-4	LEVER, DRAG RELEASE	26
—	3-21000-4	SCR, SKT HD CAP (10-32 X .38) LUBRICATOR ASSY	111	1	240792-6	DRAG, STOCK	25
2	23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	110	1	690438-1	GUIDE STRIP (REAR,	24
~~4~~	~~1-21000-3~~	~~SCR, SKT HD CAP (4-40 X .25) REAR SHEAR PLATE~~	109	1	684042-2	GUIDE, STRIP (FRONT)	23
2	2-21000-9	SCR, SKT HD CAP (8-32 X .75) DEPRESSOR	108	1	817682-1	SPACER, FRONT STRIP GUIDE	22
1	2-22603-0	SCR, HEX HD MACH (8-32 X .31) FEED FINGER	107	—	4-22284-9	SPRING, FEED RETURN	21
3	1-21000-4	SCR, SKT HD CAP (4-40 X .38) F STRIP GUIDE	106			ARM, STRIPPER	20
2	2-21000-7	SCR, SKT HD CAP (8-32 X .50) STRIPPER & ANVIL	105	1	690472-2	STRIPPER	19
2	3-21000-9	SCR, SKT HD CAP (10-32 X 1.00) AIR FEED ASS'Y	104	1	463460-3	HOLDER, TERMINAL	18
—	3-21000-6	SCR, SKT HD CAP (10-32 X .62) FEED ADJ BLOCK	103				17
1	3-21000-4	SCR, SKT HD CAP (10-32 X .38) SG ADJ BLOCK	102	1	803925-1	~~GUIDE, CARRIER STRIP~~	16
—	3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLOCK	101	1	803926-1	PLATE, SHEAR (REAR) ■	15
REF	462992-7	GUARD 3	79	1	467590-1	HOLDER, SHEAR (REAR)	14
—	1-465184-0	LUBRICATOR ASSY	78	1	469542-3	SHEAR, FLOAT (REAR) ▲	13
—	692655-1	VALVE ASS'Y 4	77	1	5-22280-0	SPRING, SHEAR	12
REF	803931-1	BRACKET, HOLD DOWN 8	76	1	1-690461-1	STOP, SHEAR	11
1	568681-1	SPACER, BASE PLATE 1 11	75			HOLDER, SHEAR (FRONT)	10
—	458109-1	WASHER, SPECIAL	74	1	1-454766-4	ANVIL, INSULATION ■	9
1	1-18023-1	SCR, SHC, METRIC, M4 x 10 LG 14 13	73	1	808025-2	ANVIL, WIRE ■	8
2	690603-1	SPRING, ASSIST	72	1	240641-9	SPACER, DEPRESSOR (REAR)	7
—	690517-1	SPACER	71	1	690468-6	DEPRESSOR, SHEAR (REAR)	6
2	23238-1	QUICK DISCONNECT	70			DEPRESSOR, SHEAR (FRONT)	5
12 48"	27319-4	TUBING 1/4 O.D.	69	1	238009-1	SPACER, TUBULAR, INS CRIMPER	4
2	22294-6	ELBOW, MALE 1/8 NPT - 1/4 T	68	1	2-454765-2	CRIMPER, INSULATION ■	3
—	240633-1	BUSHING	67			SPACER, CRIMPER	2
—	455680-1	LEVER, INTERMEDIATE	66	1	808830-2	CRIMPER, WIRE ■	1
—	240629-1	BLOCK, PIVOT	65	QTY	PART NO	DESCRIPTION	ITEM NO
—	240632-2	SCREW, ADJUSTMENT FEED ROD	64				
—	240659-3	PIN, CAM ROLLER	63				
—	240658-1	ROLLER, CAM	62				
—	454398-2	ROD, FEED	61				
—	454178-1	GUIDE, FEED ROD	60				
QTY	PART NO	DESCRIPTION	ITEM NO				

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE	SOLDER DIA. 6
A	.070 6	18	.12 DIA
B	.065 6	20 OR 22	.12 DIA
C	NOT	USED	
D	NOT	USED	

CRIMP	SIZE	TYPE	FEED	APPL INST
WIRE	.176	D	.785	A1 8079
INSUL	—	—		

WIRE RANGE	INSULATION RANGE	PRESS NO
22-18	.135 MAX	—

REMARKS

KOMAX MODEL 40

AIR FEED DOUBLE ACTING

TERM APPL SPEC 114-2123

APPLICATOR WILL APPLY

520401
520403
520405

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
		B	ECN 0150-1011-01		10-01
		A	D150 5553 94		7-94

SET UP GAGE 10-1 458637-1 1213
DR 8-26-93 P. Mathias
CHK 8-26-93 C. Cuson
APP
REL

AMP INCORPORATED Harrisburg, Pa.

LOC A D NO 680040-1 REV B

NAME MINIATURE QUICK CHANGE APPLICATOR
SIDE FEED (FULLY INSULATED FASTON)

CAGE CODE 00779 — CUSTOMER AND ASSEMBLY DRAWING — RESTRICTED TO

DIST 66

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AMP 2983-3 (4-76)

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