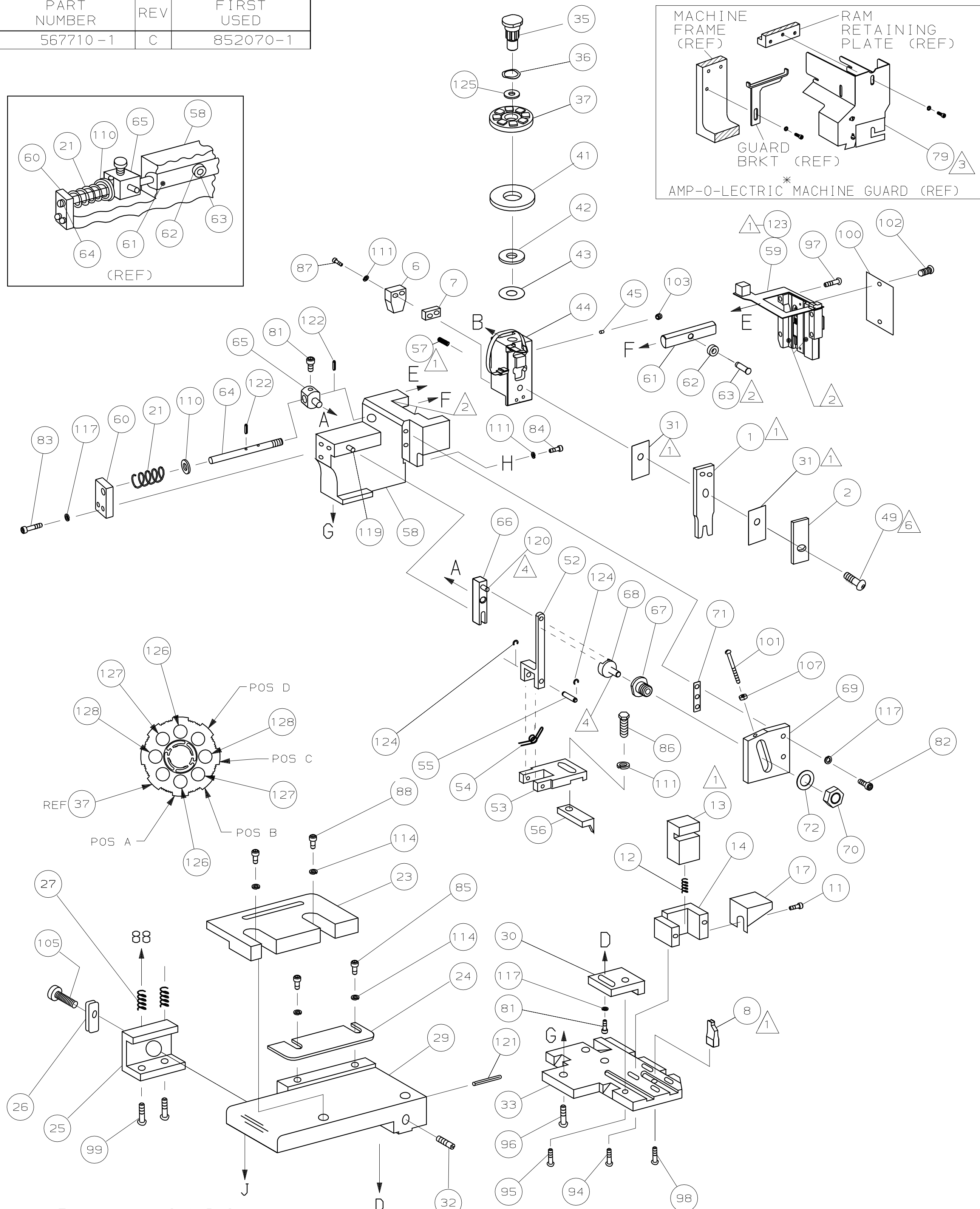
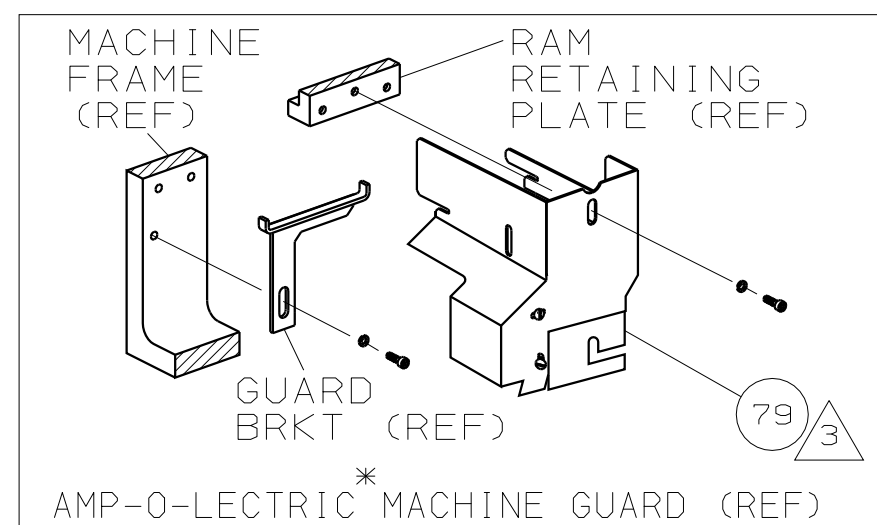
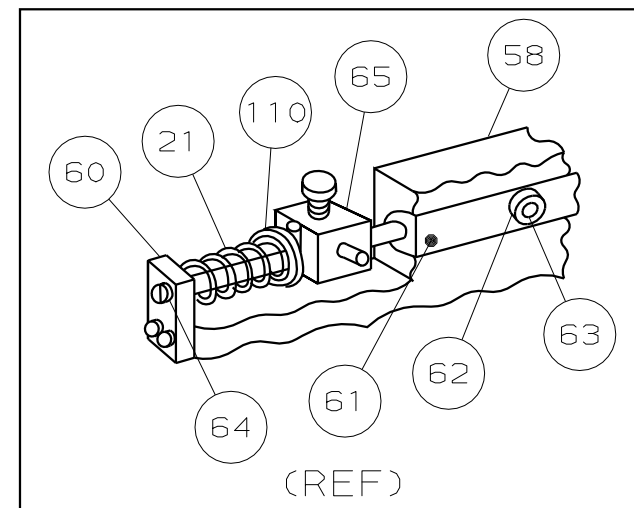
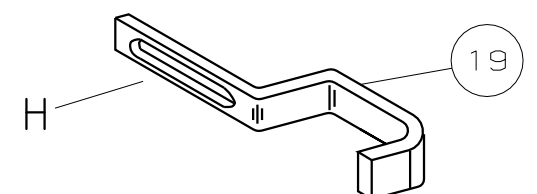
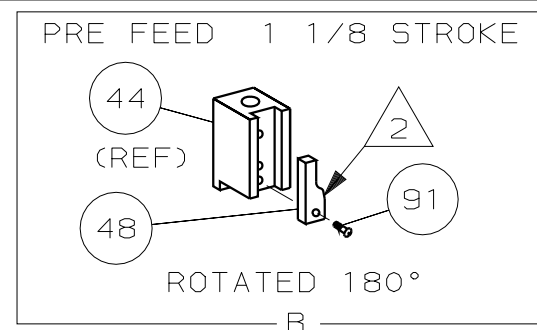


PART NUMBER	REV	FIRST USED
567710-1	C	852070-1



* Trademark of AMP Incorporated



AMP-O-ELECTRIC
K II TERMINATING UNIT

- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-O-ELECTRIC MACHINE.
- 4 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 5 CUT TO LENGTH AT ASSY.
- 6 TORQUE ITEM 49 TO 60 INCH POUNDS.

TERMINAL NAME:
MINI AMPLIVAR SPLICE

[illegible]

CRIMPING DATA				
PAD LTR	CRIMP HEIGHT		WIRE SIZE	
A	.052 ±.002		1200-1600 CMA	
B	.048 ±.002		800-1100 CMA	
C	.044 ±.002		300-700 CMA	
D	NOT		USED	
CRIMP	SIZE	TYPE	RANGE	
WIRE	.070	F	300-1600 CMA	
INSUL	-	-	-	
FEED .330	APPL INST A18040 & 9640		SET UP GAGE	LAYOUT L1504
WIRE STRIP LENGTH		-		

						129
2	-	C	3-354779-4	PIN, WIRE DISC (.3160)C		128
2	-	C	2-354779-6	PIN, WIRE DISC (.3120)B		127
2	-	C	1-354779-8	PIN, WIRE DISC (.3080)A		126
1	-	A	986950-1	WASHER, FLAT PRECISION		125
2	-	A	21045-3	RING,RET "C"(ø.187)FD FING PIN		124
1	-	B	856698-1	PCB ASSEMBLY		123
2	-	A	5-21028-1	PIN,SLT SPR(ø.125x.50)ADJ ROD		122
1	-	A	4-21028-0	PIN,SLT SPR(ø.093x.75)ST GDE PL		121
1	-	A	1-21030-1	PIN,DOWEL(ø.187x.50)LEVER		120
1	-	A	1-21030-6	PIN,DOWEL(ø.187x1.25)HOUSING		119
						118
5	-	A	21024-5	WASHER, LOCK(#10)ADJ BLOCK		117
						116
						115
2	-	A	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE		114
						113
						112
4	-	A	21024-4	WASHER,LOCK(#8)STRIPPER		111
1	-	A	21899-4	WASHER,FLAT(ø5/16)SCREW ADJ		110
						109
						108
1	-	A	21018-5	NUT,HEX(6-32)FEED ADJ		107
						106
1	-	A	22353-8	SCR,SHLD(ø.187 X .25)DRAG LEVER		105
						104
1	-	A	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM		103
REF	-	A	1-21002-3	SCR,BHC(4-40x.25)ID PLATE		102
1	-	A	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ		101
1	-	B	461264-1	PLATE, IDENTIFICATION		100
2	-	A	3-21002-0	SCR,BHC(10-32x.88)DRAG		99
1	-	A	22733-8	SCR,BHC(8-32x.38 LW)ANVIL		98
2	-	A	2-21002-9	SCR,BHC(10-32x.75)CAP		97
3	-	A	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING		96
1	-	A	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK		95
2	-	A	2-21002-2	SCR,BHC(8-32x.50)SHEAR		94
2	-	A	1-21002-4	SCR,BHC(4-40x.38)R STRIP GUIDE		93
						92
1	-	A	1-21002-7	SCR,BHC(6-32x.38)CAM		91
						90
						89
2	-	A	1-21000-5	SCR,SHC(4-40x.50)ST GUIDE		88
2	-	A	2-21000-8	SCR,SHC(8-32x.63)DEP-HOLD		87
1	-	A	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER		86
2	-	A	1-21000-3	SCR,SHC(4-40x.25)R ST GUIDE		85
1	-	A	2-21000-7	SCR,SHC(8-32x.50)STRIPPER		84
2	-	A	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD		83
2	-	A	3-21000-6	SCR,SHC(10-32x.62)FEED ADJ BLK		82
2	-	A	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL		81
						80
REF	-	B	455749-1	GUARD, WINDOW		79
						78
						77
						76
						75
						74
						73
1	-	A	458109-1	WASHER, SPECIAL		72
1	-	A	690517-1	SPACER		71

	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
		X	←	REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)		
QTY REQD PER ASSY			PARTS LIST			

		C	ECN 0150-5168-94	CE	1-93
		B	ECN 0150-4824-93	CE	9-93
		A	ECN 0150-4692-93	CE	8-93
P	F	LTR	REVISION RECORD	APP	DAT

-1 AMP-O-ELECTRIC MECH-PRE FEED			STANDARD FORCE CRIMP QUALITY MONITOR APPLICATOR
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	1	-	B	22594-8	NUT, HEX (1/2-20)	70
	1	-	B	240628-1	PLATE, ADJUSTMENT	69
	1	-	B	240626-1	SHAFT, PIVOT	68
	1	-	B	240633-1	BUSHING	67
	1	-	A	455680-1	LEVER, INTERMEDIATE	66
	1	-	B	240629-1	BLOCK, PIVOT	65
	1	-	A	240632-2	SCREW, ADJ FEED ROD	64
	1	-	B	240659-3	PIN, CAM ROLLER	63
	1	-	B	240658-1	ROLLER, CAM	62
	1	-	B	454398-2	ROD, FEED	61
	1	-	A	454178-1	GUIDE, FEED ROD	60
	1	-	C	768325-1	MODIFIED CAP ASSEMBLY	59
	1	-	D	454485-1	HOUSING	58
△	1	-	A	7-21013-3	SCR SET (5/16x.38) CR BOLT	57
	1	-	B	694433-8	PAWL, FEED	56
	1	-	B	240624-1	PIN, FEED FINGER	55
	1	-	B	691499-1	SPRING, FEED FINGER	54
	1	-	A	690541-1	HOLDER, FEED FINGER	53
	1	-	B	455679-1	LEVER, TERMINAL FEED ARM	52
						51
						50
△	1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)	49
	1	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST	48
						47
						46
	1	-	A	690191-1	PLUG, NYLON	45
	1	-	B	853493-1	SIDE FEED RAM ASSEMBLY	44
	1	-	A	690125-1	WASHER, LAMINATED	43
	1	-	A	690124-1	WASHER, RAM	42
	1	-	A	690223-2	SPACER, INSULATION DISC	41
						40
						39
						38
	1	-	D	354777-1	WIRE DISC, PLASTIC	37
	1	-	A	22480-5	WASHER, SPRING	36
	1	-	B	690212-1	POST, RAM	35
						34
	1	-	D	679254-1	PLATE, BASE	33
	1	-	A	690432-3	SCREW, ADJUSTMENT	32
△	2	-	B	853495-1	GASKET	31
	1	-	B	816182-1	BLOCK, STRIP GUIDE ADJ	30
	1	-	C	844048-4	PLATE, STRIP GUIDE	29
						28
	2	-	A	1-22284-0	SPRING, DRAG	27
	1	-	B	240793-1	LEVER, DRAG RELEASE	26
	1	-	B	240792-1	DRAG, TERMINAL	25
	1	-	D	690438-1	GUIDE, STRIP (REAR)	24
	1	-	A	690487-6	GUIDE, STRIP (FRONT)	23
						22
	1	-	A	4-22284-9	SPRING, FEED RETURN	21
						20
	1	-	B	456468-5	STRIPPER	19
						18
	1	-	A	691668-1	GUARD, CHIP (REAR)	17
						16
						15
△	1	-	B	690462-1	HOLDER, SHEAR (REAR)	14
	1	-	C	690463-6	SHEAR, FLOAT (REAR)	13
	1	-	A	5-22281-0	SPRING, SHEAR	12
	1	-	B	690461-1	STOP, SHEAR	11
						10
						9
△	1	-	C	6-683403-6	ANVIL	8
	1	-	C	2-240641-4	SPACER, DEPRESSOR (REAR)	7
	1	-	A	690468-1	DEPRESSOR, SHEAR (REAR)	6
						5
						4
						3
	1	-	C	455888-8	SPACER, CRIMPER	2
△	1	-	C	2-456404-1	CRIMPER, WIRE	1

	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
		X	REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)			
QTY REQD PER ASSY			PARTS LIST			

DIMENSIONS IN INCHES. DO NOT SCALE PRINT.		MATL -		HT TR -		FIN -	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		DR M. 5/18/93		APP 5/27/93			
2 PLC DEC ±		W. 0" BRINE		J. H. YOUNG			
4 PLC DEC ±		CHK 5/26/93		REL 5/28/93		AMP AMP Incorporated Harrisburg, PA 17105-3508	
2 PLC DEC ±		C. ERISMAN		6. C. CHENIS			
ANGLES ±		NAME SIDE FEED CQM APPLICATOR				MACHINE REF	
SURF TEXTURE: ✓						MINI APPL	
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX		SCALE -		DWG NO 567710		SHEET 1 of 1	
		D				REV C	

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