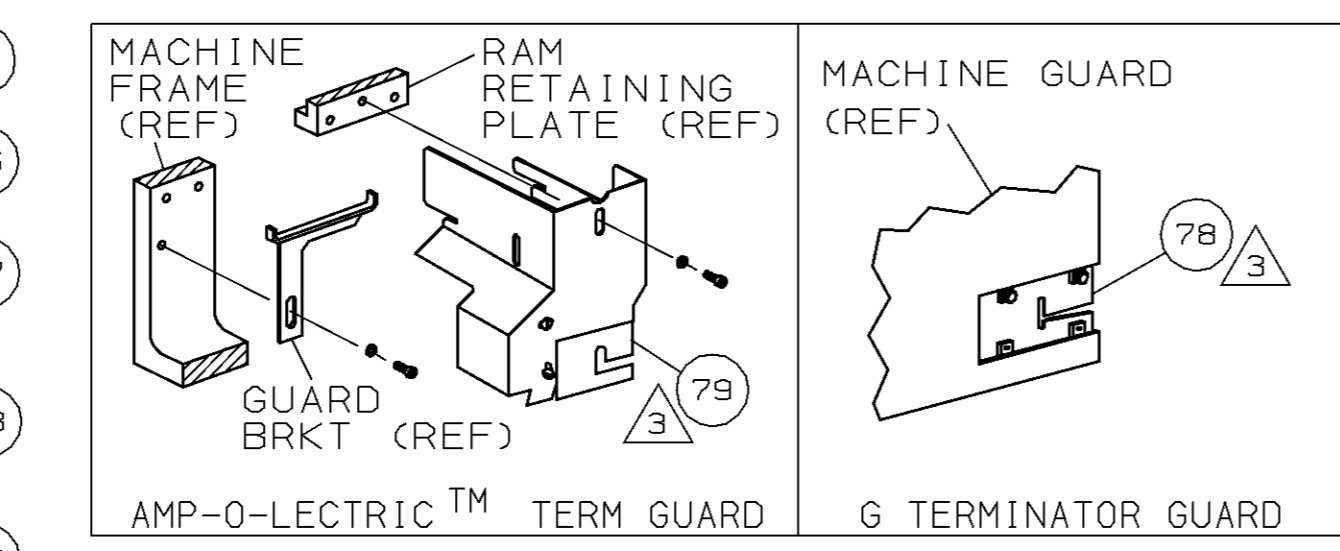
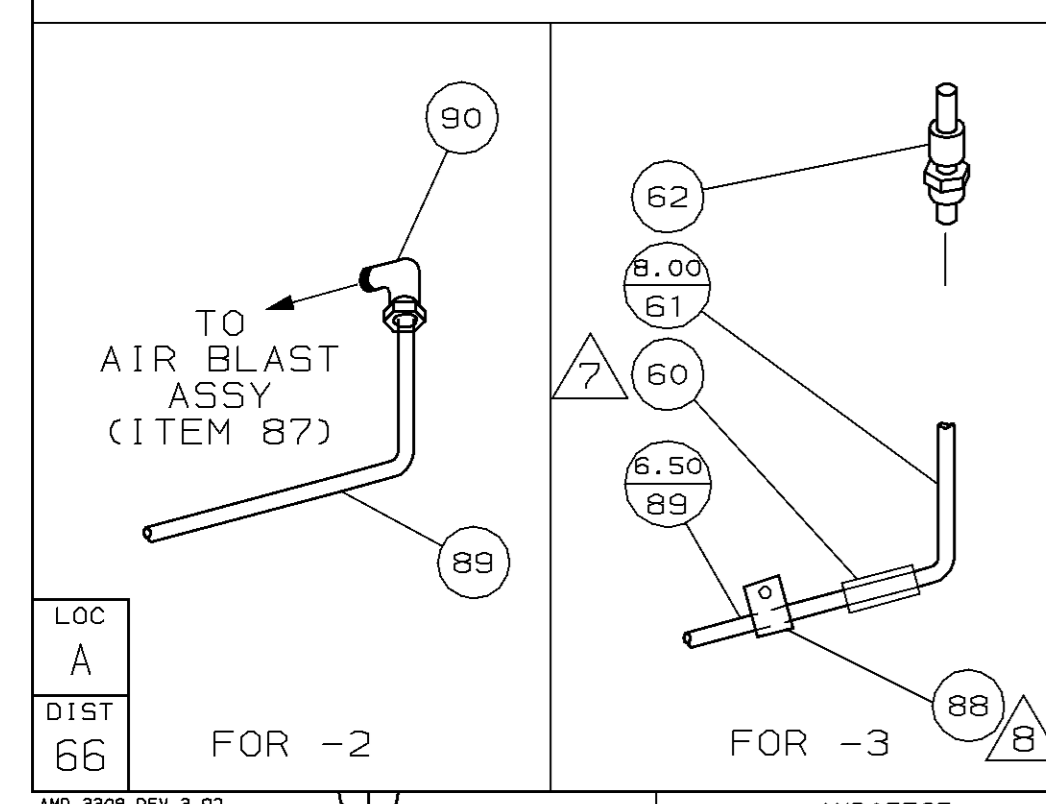
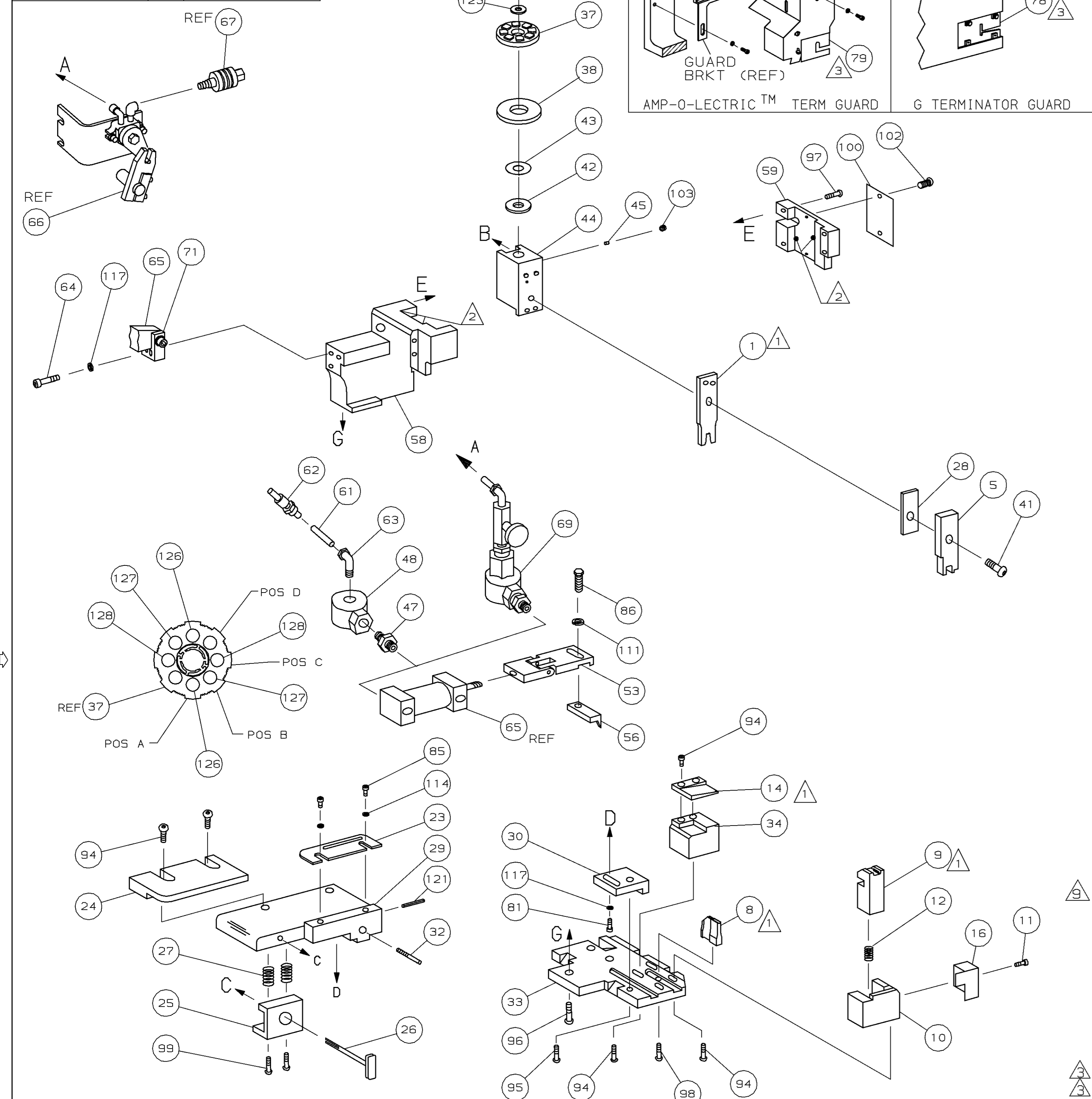


PART NUMBER	REV	FIRST USED
680198 -2	B	565435-5
680198 -3	B	354500-1



TERMINAL NAME: .125 BLADE, AMPLIVAR™ CONTACT	
63871	CRIMPING DATA
PAD LTR	CRIMP HEIGHT WIRE SIZE (A)
A	.036 ±.002 [0.91 ±0.5mm] 700-850 (21)
B	.033 ±.002 [0.84 ±0.05mm] 400-600 (24)
C	.031 ±.002 [0.79 ±0.05mm] 200-300 (27)
D	NOT USED
CRIMP	SIZE TYPE RANGE
WIRE	.055 [1.4mm] F 200-850 CMA
INSUL	- - -
WIRE STRIP LENGTH	TERM APPL SPEC FEED APPL INSTRUCTION SET UP GAGE LAYOUT
-	- .500 408-8040 458637-1 L1672

QTY	REQD	PER	ASSY	PARTS LIST	DESCRIPTION	ITEM NO
2	2	-	C	5-354779-6	PIN, WIRE DISC (.3270)C	129
2	2	-	C	5-354779-2	PIN, WIRE DISC (.3250)B	127
2	2	-	C	4-354779-6	PIN, WIRE DISC (.3220)A	126
1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
						124
						123
						122
1	1	-	A	4-21028-0	PIN, SLT SPR (Ø.093x.75) ST GDE PL	121
						120
						119
						118
3	3	-	A	21024-5	WASHER, LOCK (#10) ADJ BLOCK	117
						116
2	2	-	A	21024-2	WASHER, LOCK (#4) FRONT STP GUIDE	115
						114
						113
						112
1	1	-	A	21024-4	WASHER, LOCK (#8) STRIPPER	111
						110
						109
						108
						107
						106
						105
						104
1	1	-	A	21009-2	SCR, SKT SET (1/4-20x.25 LW) RAM	103
2	2	-	A	21017-2	SCR, DRIVE (#2x.19) ID PLATE	102
						101
1	1	-	B	461264-1	PLATE, IDENTIFICATION	100
2	2	-	A	3-21002-0	SCR, BHC (10-32x.88) DRAG	99
1	1	-	A	22733-8	SCR, BHC (8-32x.38 LW) ANVIL	98
4	4	-	A	2-21002-9	SCR, BHC (10-32x.75) CAP	97
3	3	-	A	2-22733-8	SCR, BHC (1/4-20x.62) HOUSING	96
1	1	-	A	2-21002-7	SCR, BHC (10-32x.50) SG ADJ BLOCK	95
8	8	-	A	2-21002-2	SCR, BHC (8-32x.50) TERM H DWN	94
						93
						92
						91
-	1	-	A	22317-3	ELBOW, METAL T .25T-1/8 NPT	90
1	1	-	B	689446-2	AIR BLAST TUBE	89
1	-	-	A	23545-1	CLAMP, WIRE	88
-	1	-	C	455350-1	AIR BLAST ASSEMBLY	87
1	1	-	A	2-22603-0	SCR, HEX HD (8-32x.31) FEED FINGER	86
2	2	-	A	1-21000-3	SCR, SHC (4-40x.25) F ST GUIDE	85
						84
						83
						82
1	1	-	A	3-21000-4	SCR, SHC (10-32x.38) SG ADJ BL	81
						80
-	REF	-	B	455749-1	GUARD, WINDOW	79
REF	-	-	B	679532-1	INSERT, GUARD	78
						77
						76
						75
						74
						73
						72
1	1	-	B	459610-3	MOUNT, FEED BRACKET	71
-3	-2	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 4 SEE DRAWING FOR COMPONENTS
- 5 WITH WIRE TRIM FEATURE
- 6 CENTER ITEM 60 BETWEEN ITEM 61 AND ITEM 89. ATTACH ITEM 60 TO ITEM 89 AND ITEM 61 USING ADHESIVE PN 28829-2.
- 7 INSTALL ITEM 88 TO ITEM 58 USING ITEM 84.
- 8 SET-UP ONLY
- 9 CUT TO 7 INCHES AT ASSY.

QTY	REQD	PER	ASSY	PARTS LIST	DESCRIPTION	ITEM NO
-2				BENCH MODEL K	AIR FEED	
-3				BENCH MODEL G	AIR FEED	
-	1	-	C	692655-5	AIR FEED VALVE ASSY	70
						69
						68
-	REF	-	A	24042-2	VALVE, SHUT OFF	67
-	REF	-	C	692655-6	AIR FEED VALVE ASSY	66
1	1	-	B	461065-1	AIR FEED ASSY (1 INCH)	65
2	2	-	A	3-21000-7	SCR, SHC (10-32x.75) AIR ASSY	64
1	-	-	A	983427-6	ELBOW, SWIVEL 1/8 NPT - 1/4 T	63
2	-	-	A	23238-1	QUICK DISCONNECT	62
21.00	-	IN	A	27319-4	TUBING, POLY-FLO Ø.25	61
2.00	-	IN	A	27319-3	TUBING, POLY-FLO Ø.38	60
1	1	-	C	454220-1	CAP, RAM	59
1	1	-	D	454485-1	HOUSING	58
						57
1	1	-	B	1-694433-7	PAWL, FEED	56
						55
						54
1	1	-	B	461062-1	FEED FINGER ASSY	53
						52
						51
						50
						49
1	-	-	A	22374-7	VALVE, QUICK EXHAUST	48
1	-	-	A	22304-1	NIPPLE, HEX 1/8 NPT	47
						46
1	1	-	A	690191-1	PLUG, NYLON	45
1	1	-	C	455673-1	RAM	44
1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	-	A	690124-1	WASHER, RAM	42
1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)	41
						40
						39
1	1	-	A	690223-2	SPACER, INSULATION DISC	38
1	1	-	D	354777-1	WIRE DISC, PLASTIC	37
1	1	-	A	22480-5	WASHER, SPRING	36
1	1	-	B	690212-1	POST, RAM	35
1	1	-	C	318548-1	SUPPORT, SHEAR	34
1	1	-	D	455675-1	PLATE, BASE	33
1	1	-	A	690432-3	SCREW, ADJUSTMENT	32
						31
1	1	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	-	C	455671-1	PLATE, STRIP GUIDE	29
1	1	-	C	1-455888-5	SPACER, FRONT SHEAR DEP	28
2	2	-	A	1-22284-0	SPRING, DRAG	27
1	1	-	B	690546-1	LEVER, DRAG RELEASE	26
1	1	-	B	240792-1	DRAG, TERMINAL	25
1	1	-	D	8-690504-3	GUIDE, STRIP (REAR)	24
1	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
						22
						21
						20
						19
						18
						17
1	1	-	B	318563-1	GUARD, CHIP, FRONT	16
						15
1	1	-	C	318547-1	SHEAR PLATE, WIRE	14
						13
1	1	-	A	5-22280-0	SPRING, SHEAR	12
1	1	-	B	690461-1	STOP, SHEAR	11
1	1	-	C	690459-1	HOLDER, SHEAR (FRONT)	10
1	1	-	C	454276-1	SHEAR, FLOAT (FRONT)	9
1	1	-	C	1-805840-0	ANVIL	8
						7
						6
1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
						4
						3
						2
1	1	-	C	318542-2	CRIMPER, WIRE	1
-3	-2	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

QTY REQD PER ASSY PARTS LIST

MATL HT TR FIN

DR J.BAKER 9/25/95 APP 10/13/95 A BEDDICK

CHK 10/13/95 REL 12/20/95 B. MORGAN

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL

SCALE SHEET 1 OF 1 REV B

DWG NO 680198

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