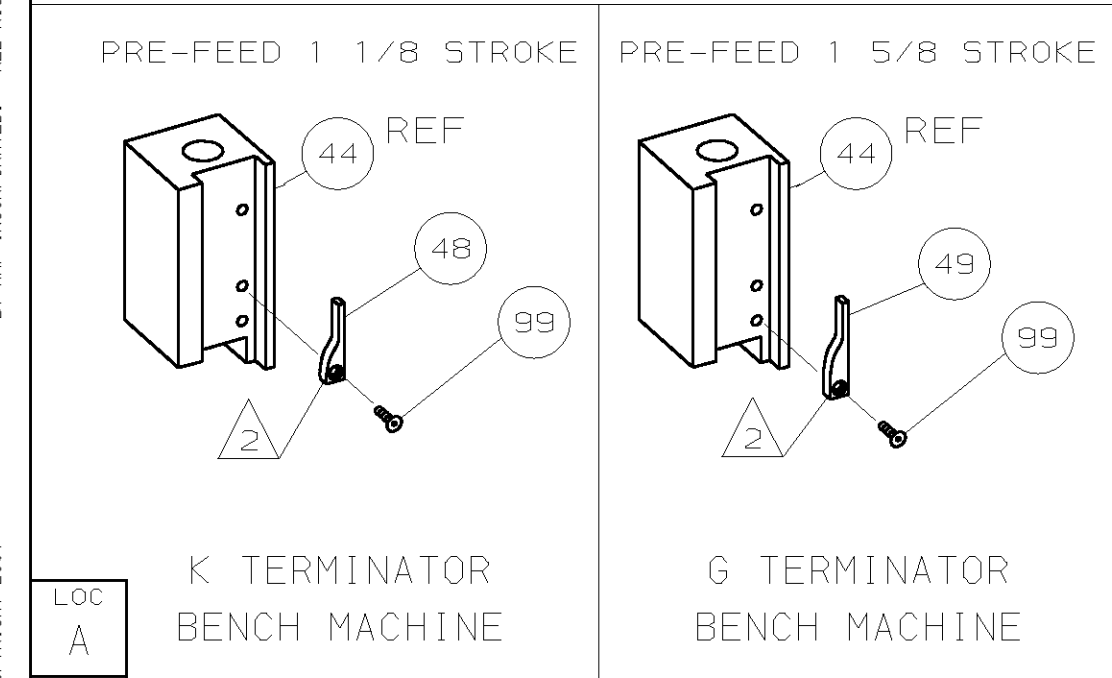
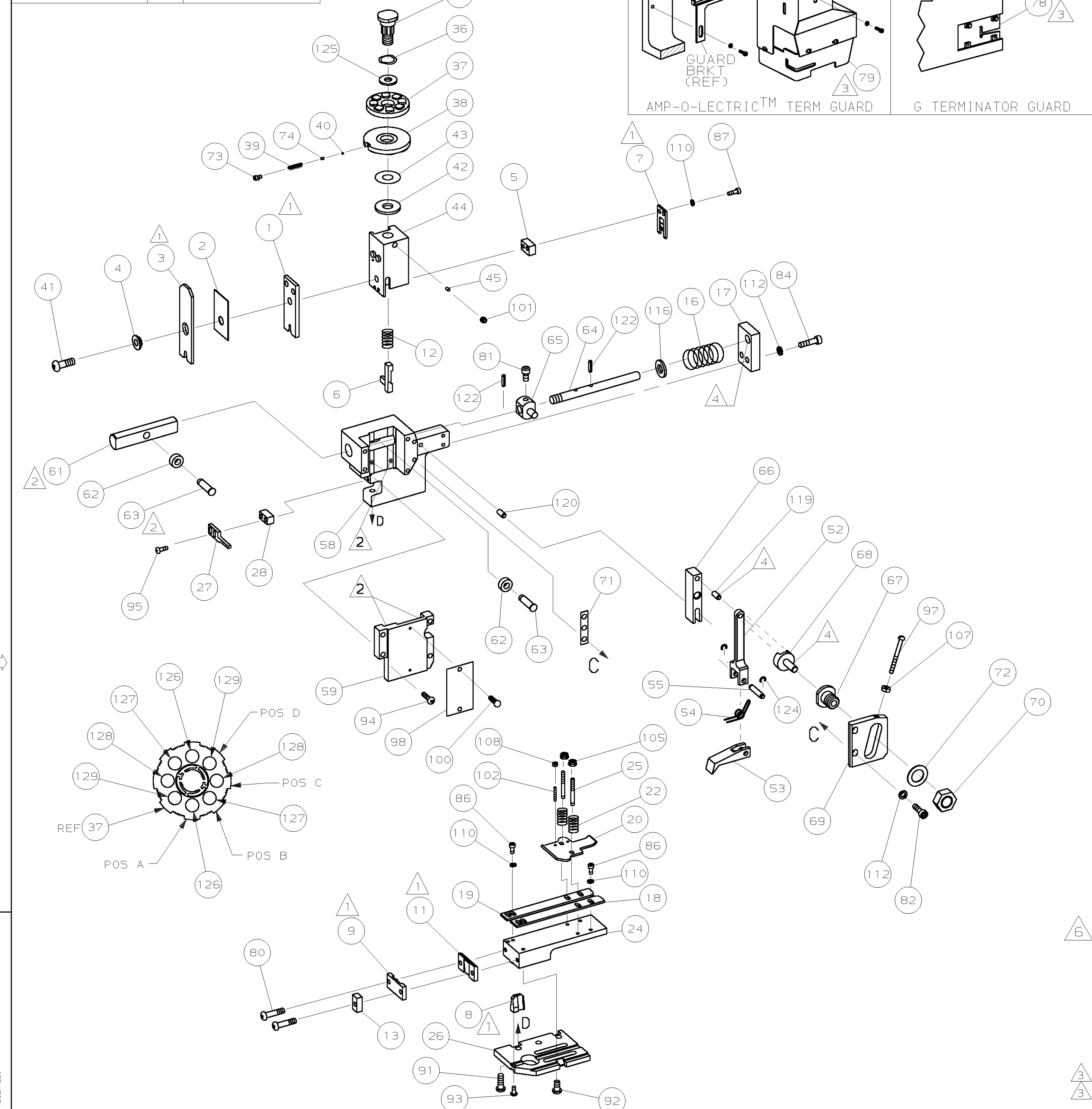


PART NUMBER	REV	FIRST USED
466729-1	H	565435-5
466729-3	H	354500-1



- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 4 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 32.
- 6 CUT TO LENGTH AT ASSY.
- 7 USE PADS A & B FOR TERMINALS 60752, 61151 & 640027 ONLY.
- 8 USE PADS C & D FOR TERMINAL 63864 ONLY

WIRE STRIP LENGTH		TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.218-.248		114-2084	.897	408-8039	458638-1	999

TERMINAL NAME: AMPLIVAR™ RING		CRIMPING DATA		
PAD LTR	CRIMP HEIGHT	WIRE SIZE		
A	.070 ±.002 [1.78 ±0.05mm]	(2) #17		
B	.078 ±.002 [1.98 ±0.05mm]	(2) #15		
C	.088 ±.002 [2.24 ±0.05mm]	#12		
D	.100 ±.002 [2.54 ±0.05mm]	(1)#10 or (2)#13		
CRIMP	SIZE	TYPE	RANGE	
WIRE	.180 [4.57mm]	F	(2)#17 - (1)#10	
INSUL	.220 [5.58mm]	F	.150 - .190 OR (2).115	

QTY	RECD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	2	-	C	4-354778-3	PIN, WIRE DISC (.2710)D	129
2	2	-	C	6-354778-7	PIN, WIRE DISC (.2830)C	128
2	2	-	C	8-354778-9	PIN, WIRE DISC (.2940)B	127
2	2	-	C	354779-6	PIN, WIRE DISC (.3020)A	126
1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
REF	REF	-	A	21045-3	RING, RET "C" (Ø.187)FD PIN	124
REF	REF	-	A	5-21028-1	PIN, STD SPRING (Ø.12)FD ADJ ROD	122
REF	REF	-	A	1-21030-7	PIN, DOWEL (Ø.187x1.50)H5G	120
REF	REF	-	A	1-21030-1	PIN, DOWEL (Ø.187x.50)LEVER	119
REF	REF	-	A	21899-4	WASHER, FLAT (Ø5/16)SCR ADJ	116
6	6	-	A	21024-5	WASHER, LOCK (NO.10)FD ROD GDE	112
6	6	-	A	21024-4	WASHER, LOCK (NO.8)SHEAR BL	110
2	2	-	A	21018-4	NUT, HEX (4-40)DRAG	108
REF	REF	-	A	21018-5	NUT, HEX (6-32)FD ADJ PL	107
2	2	-	A	21022-2	NUT, HEX 5L (8-32)DRAG STUD	105
2	2	-	A	2-21006-6	SCR, SKT SET (4-40x.62)DRAG	102
1	1	-	A	21009-2	SCR, SKT SET (1/4-20x.25)RAM	101
2	2	-	A	21017-2	SCR, DRIVE (#2x.19) ID PLATE	100
1	1	-	A	1-21002-7	SCR, BHC (6-32x.38)CAM	99
1	1	-	B	461264-1	PLATE, IDENTIFICATION	98
REF	REF	-	A	6-23715-5	SCR, PAN HD (6-32x1.50)FEED ADJ	97
2	2	-	A	2-21002-2	SCR, BHC (8-32x.50)STRIPPER	95
REF	REF	-	A	2-21002-9	SCR, BHC (10-32x.75)H5G CAP	94
1	1	-	A	22733-8	SCR, BHC (8-32x.38 LW)ANVIL	93
4	4	-	A	3-21002-3	SCR, BHC (1/4-20x.50)ST 6D PL	92
REF	REF	-	A	2-22733-8	SCR, BHC (1/4-20x.62)BASE PL	91
						90
						89
						88
2	2	-	A	2-21000-8	SCR, 5HC (8-32x.56)SLUG BLADE	87
4	4	-	A	2-21000-6	SCR, 5HC (8-32x.38)STRIP GUIDE	86
REF	REF	-	A	3-21000-7	SCR, 5HC (10-32x.75)FEED ROD GDE	84
REF	REF	-	A	3-21000-6	SCR, 5HC (10-32x.62)FEED ADJ PL	82
REF	REF	-	A	3-21000-4	SCR, 5HC (10-32x.38)PIVOT BLOCK	81
2	2	-	A	3-21002-0	SCR, BHC (10-32x.88)SHEAR PL	80
-	REF	-	A	455745-1	GUARD, WINDOW	79
REF	REF	-	A	679532-1	INSERT, GUARD	78
						77
						76
						75
1	1	-	A	690603-1	SPRING, ASSIST	74
1	1	-	A	23030-1	SCR, SKT CAP (6-32x.25)CP DSC	73
REF	REF	-	A	458109-1	WASHER, FLAT (SPECIAL)	72
REF	REF	-	A	690517-1	SPACER	71
						70
						69
						68
						67
						66
						65
						64
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						51
						50
1	-	-	B	690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	1	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST	48
-	-	-	B	690501-4	CAM, POST-FEED 1 5/8 ST	47
						46
1	1	-	A	690191-1	PLUG, NYLON	45
1	1	-	C	455674-1	RAM	44
1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	-	A	690124-4	WASHER, RAM	42
1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16-24x1.00)	41
1	1	-	A	23241-6	BALL, STEEL	40
1	1	-	A	690170-1	SPRING, COMPRESSION	39
1	1	-	C	690142-1	DISC, INSULATION	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
						34
						33
1	1	-	D	458980-2	APPLICATOR, BASIC (SUB ASSY)	32
						31
						30
						29
1	1	-	B	3-690451-2	SPACER, STRIPPER	28
1	1	-	A	240639-1	STRIPPER	27
REF	REF	-	C	455676-1	PLATE, BASE	26
2	2	-	A	22354-8	DRAG, STUD	25
1	1	-	B	455678-1	PLATE, STRIP GUIDE	24
						23
2	2	-	A	4-22281-1	SPRING, DRAG	22
						21
1	1	-	A	454177-1	DRAG, STOCK	20
1	1	-	B	458030-4	GUIDE, STRIP (REAR)	19
1	1	-	C	458031-4	GUIDE, STRIP (FRONT)	18
REF	REF	-	A	454178-1	GUIDE, FEED ROD	17
REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	16
						15
						14
1	1	-	C	1-690481-9	SPACER, HOLD DOWN	13
1	1	-	A	23846-1	SPRING, HOLD DOWN	12
1	1	-	B	240644-1	PLATE, REAR SHEAR	11
						10
1	1	-	B	690482-5	PLATE, FRONT SHEAR	9
1	1	-	D	459866-6	ANVIL	8
1	1	-	B	1-690474-6	BLADE, SLUG	7
1	1	-	D	455892-3	HOLD DOWN, TERMINAL	6
1	1	-	C	2-240641-0	SPACER, SLUG BLADE	5
1	1	-	B	238009-1	SPACER, BLOCK CRIMPER	4
1	1	-	C	6-456134-2	CRIMPER, INSULATION	3
1	1	-	B	455888-6	SPACER, CRIMPER	2
1	1	-	C	456412-3	CRIMPER, WIRE	1

QTY	RECD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-1	-1	U/M	DWG SIZE			
-3	-1	U/M	DWG SIZE			

QTY	RECD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-1	-1	U/M	DWG SIZE			
-3	-1	U/M	DWG SIZE			

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED:

DR	J. BAKER	9/11/95	APP	9/11/95	A. BEDDICK
CHK	C. ERISMANN	9/25/95	REL	9/25/95	B. MORGAN

NAME: END FEED HDM APPLICATOR MACHINE REF: MINI APPL

SCALE: 1 OF 1 REV: H1

REVISION RECORD: P/F LTR REVISION RECORD APP DATE

REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

AMP Incorporated Harrisburg, PA 17105-3608

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LOC A K TERMINATOR BENCH MACHINE
D1ST 66
G TERMINATOR BENCH MACHINE