

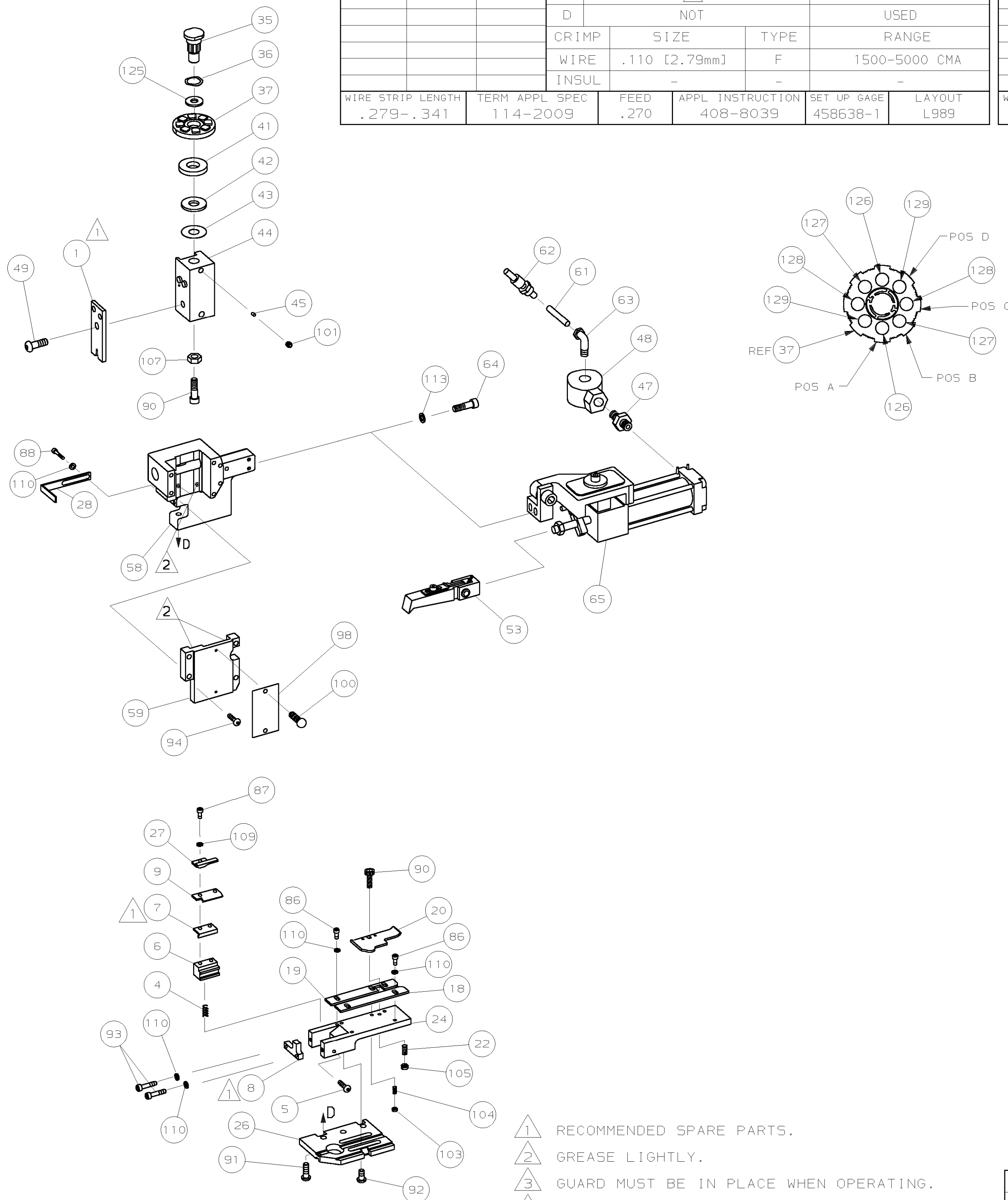
PART NUMBER	REV	FIRST USED
680513-3	A	356462-1

TERMINAL NAME: AMPLIVAR™ THRU SPLICE					
PAD LTR	CRIMP HEIGHT	WIRE COMBINATION			
		A	B	C	D
		3600-5000 CMA			
		2200-3600 CMA			
		1500-2000 CMA			
		USED			
CRIMP	SIZE	TYPE	RANGE		
WIRE	.110 [2.79mm]	F	1500-5000 CMA		
INSUL	-	-	-		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.279-.341	114-2009	.270	408-8039	458638-1	L989

TERMINAL NAME: AMPLIVAR™ THRU SPLICE					
PAD LTR	CRIMP HEIGHT	WIRE COMBINATION			
		A	B	C	D
		4200 CMA			
		2800 CMA			
		1400 CMA			
		1200 CMA			
CRIMP	SIZE	TYPE	RANGE		
WIRE	.110 [2.79mm]	F	600-3000 CMA		
INSUL	-	-	-		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.279-.341	114-2009	.270	408-8039	458638-1	L989

-3	BENCH MODEL G	AIRFEED
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- ① RECOMMENDED SPARE PARTS.
- ② GREASE LIGHTLY.
- ③ GUARD MUST BE IN PLACE WHEN OPERATING.
- ④ SEE DRAWING FOR COMPONENTS.
- ⑤ USE MANUAL PRECISION ADJUSTMENT LEVER ON G TERMINATOR TO ACHIEVE PROPER CRIMP HEIGHT.
- ⑥ SOLID WIRE ON BOTTOM
- ⑦ SEE SHEET 2 FOR CRIMP HEIGHT INFORMATION.

QTY	REV	DESCRIPTION	ITEM NO
2	-	C 2-354779-2	PIN, WIRE DISC (.3100)D 129
2	-	C 354779-4	PIN, WIRE DISC (.3010)C 128
2	-	C 8-354778-7	PIN, WIRE DISC (.2930)B 127
2	-	C 7-354778-3	PIN, WIRE DISC (.2860)A 126
1	-	A 986950-1	WASHER, FLAT PRECISION 125
1	-	A 217238-1	GENERAL INSTRUCTION PACKAGE 124
1	-	-	4088039 EF APPL INST 408-8039 123
			122
			121
			120
			119
			118
			117
			116
			115
			114
2	-	A 21024-5	WASHER, LOCK (NO.10) SHEAR PL 113
			112
			111
8	-	A 21024-4	WASHER, LOCK (NO.8) SHEAR BL 110
2	-	A 21024-3	WASHER, LOCK (NO.6) STRIP & SHEAR 109
			108
1	-	A 21019-1	NUT, HEX (1/4-20) RAM 107
			106
2	-	A 21022-4	NUT, HEX SL (1/4-20) DRAG STUD 105
2	-	A 5-21061-5	SCR, SKT SET (8-32x.88) DRAG 104
2	-	A 21018-6	NUT, HEX (8-32) DRAG 103
			102
1	-	A 21009-2	SCR, SKT SET (1/4-20x.25) RAM 101
2	-	A 21017-2	SCR, DRIVE (#2x.19) ID PLATE 100
			99
1	-	B 461264-1	PLATE, IDENTIFICATION 98
			97
			96
			95
4	-	A 2-21002-9	SCR, BHC (10-32x.75) CAP 94
2	-	A 2-21000-7	SCR, SKT CAP (8-32x.50) ANVIL 93
2	-	A 3-21002-3	SCR, BHC (1/4-20x.50) ST GD PL 92
3	-	A 2-22733-8	SCR, BHC (1/4-20x.62) HSG 91
2	-	A 21001-7	SCR, SHC (1/4-20x1.25) DRAG & RAM 90
			89
2	-	A 2-21000-6	SCR, SHC (8-32x.38) STRIPPER 88
2	-	A 2-21000-0	SCR, SHC (6-32x.50) STRIPPER&SHEAR 87
4	-	A 1-21000-8	SCR, SHC (6-32x.25) STRIP GUIDE 86
			85
			84
			83
			82
			81
			80
③ 1	-	A 1213015-1	GUARD ASSY 79
			78
			77
			76
			75
			74
			73
			72
			71

QTY	REV	DESCRIPTION	ITEM NO
			70
			69
			68
			67
			66
④ 1	-	B 460277-1	AIR FEED ASSY 65
2	-	A 3-21000-9	SCR, SHC (10-32x1.00) AIR FD ASSY 64
1	-	A 22294-6	ELBOW, TUBING 1/8NPT - 1/4 T 63
1	-	A 23238-1	QUICK DISCONNECT 62
15.00	IN	A 27319-4	TUBING, POLY-FLO 1/4 DIA 61
			60
1	-	C 458408-1	CAP, RAM 59
1	-	D 458414-1	HOUSING 58
			57
			56
			55
			54
④ 1	-	B 460680-1	FEED FINGER ASSY 53
			52
			51
			50
1	-	A 7-21002-9	BOLT, CRIMPER (5/16-24x1.00) 49
			48
			47
			46
1	-	A 690191-1	PLUG, NYLON 45
1	-	C 458413-2	RAM 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
			33
			32
			31
			30
			29
1	-	A3 1213014-1	STRIPPER, FRONT 28
1	-	A 458405-1	STRIPPER, REAR 27
1	-	D 458411-1	PLATE, BASE 26
			25
1	-	B 458412-1	PLATE, STRIP GUIDE 24
			23
1	-	A 3-22283-0	SPRING, DRAG 22
			21
1	-	A 458403-1	DRAG, STOCK 20
1	-	B 458406-2	GUIDE, STRIP (REAR) 19
1	-	C 458404-2	GUIDE, STRIP (FRONT) 18
			17
			16
			15
			14
			13
			12
			11
			10
1	-	A3 904190-1	PLATE, GUIDE 9
1	-	D 462320-3	ANVIL 8
1	-	B 458410-6	SHEAR 7
1	-	C 458409-5	HOLDER, SHEAR 6
1	-	A 690461-4	SCR, SHEAR STOP 5
1	-	A 6-22282-8	SPRING, SHEAR RETURN 4
			3
			2
④ 1	-	C 456408-4	CRIMPER, WIRE 1

LOC A
DIST 66

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±.25 3 PLC DEC ±. 4 PLC DEC ±. ANGLES ± - SURF TEXTURE: ✓ REMOVE BURRS, BREAK SHARP EDGES R.015 MAX				MATL -	HT TR -	FIN -
DR 8-13-97 R.O. WILSON CHK 8-14-97 C. ERISMAN		APP 8-14-97 T. ELBIN	AMP AMP Incorporated Harrisburg, PA 17105-3608			
NAME END FEED HDM APPLICATOR MACHINE REF MINI APPL						
SCALE -	DWG NO 680513	SHEET 1 OF 2	REV A			

TERMINAL NUMBER		CRIMPING DATA		
		PAD LTR	CRIMP HEIGHT	WIRE SIZE
	41765			
	41899			
	42119	A	.083 ±.002 [2.12 ±0.05mm]	5000 CMA
	140778	A	.082 ±.002 [2.08 ±0.05mm]	4800 CMA
	140837	A	.081 ±.002 [2.06 ±0.05mm]	4600 CMA
		A	.080 ±.002 [2.03 ±0.05mm]	4400 CMA
		A	.079 ±.002 [2.01 ±0.05mm]	4200 CMA
		A	.078 ±.002 [1.98 ±0.05mm]	4000 CMA
		A	.077 ±.002 [1.96 ±0.05mm]	3800 CMA
		A	.076 ±.002 [1.93 ±0.05mm]	3600 CMA
		B	.075 ±.002 [1.91 ±0.05mm]	3400 CMA
		B	.074 ±.002 [1.88 ±0.05mm]	3200 CMA
		B	.073 ±.002 [1.85 ±0.05mm]	3000 CMA
		B	.072 ±.002 [1.83 ±0.05mm]	2800 CMA
		B	.071 ±.002 [1.80 ±0.05mm]	2600 CMA
		B	.070 ±.002 [1.78 ±0.05mm]	2400 CMA
		B	.069 ±.002 [1.75 ±0.05mm]	2200 CMA
		C	.067 ±.002 [1.70 ±0.05mm]	2000 CMA
		C	.066 ±.002 [1.68 ±0.05mm]	1800 CMA
		C	.065 ±.002 [1.65 ±0.05mm]	1600 CMA
		C	.064 ±.002 [1.63 ±0.05mm]	1400 CMA

TERMINAL NUMBER		CRIMPING DATA		
		PAD LTR	CRIMP HEIGHT	WIRE SIZE
	42076			
	42192			
	140723	C	.066 ±.002 [1.68 ±0.05mm]	3000 CMA
	140780	C	.065 ±.002 [1.65 ±0.05mm]	2800 CMA
	170152	C	.064 ±.002 [1.63 ±0.05mm]	2600 CMA
		C	.063 ±.002 [1.60 ±0.05mm]	2400 CMA
		C	.062 ±.002 [1.57 ±0.05mm]	2200 CMA
		C	.061 ±.002 [1.55 ±0.05mm]	2000 CMA
		C	.060 ±.002 [1.52 ±0.05mm]	1800 CMA
		D	.059 ±.002 [1.50 ±0.05mm]	1600 CMA
		D	.058 ±.002 [1.47 ±0.05mm]	1400 CMA
		D	.057 ±.002 [1.45 ±0.05mm]	1200 CMA
		D	.056 ±.002 [1.42 ±0.05mm]	1000 CMA
		D	.054 ±.002 [1.37 ±0.05mm]	800 CMA

680513

D

C


B

A

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LOC
A
DIST
66

	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	8-13-97	APP 8-14-97
		R.O.WILSON	T.ELBIN	
		CHK 8-14-97	REL -	
		C. ERISMAN	-	
		 AMP Incorporated Harrisburg, PA 17105-3608		
		NAME	END FEED HDM APPLICATOR	MACHINE REF
				MINI APPL
	SCALE	DWG NO	680513	SHEET 2 OF 2
				REV A

P	F	LTR	REVISION RECORD	APP	DATE				