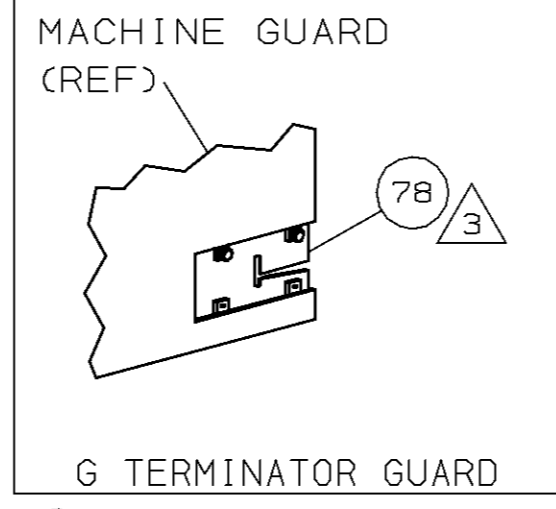
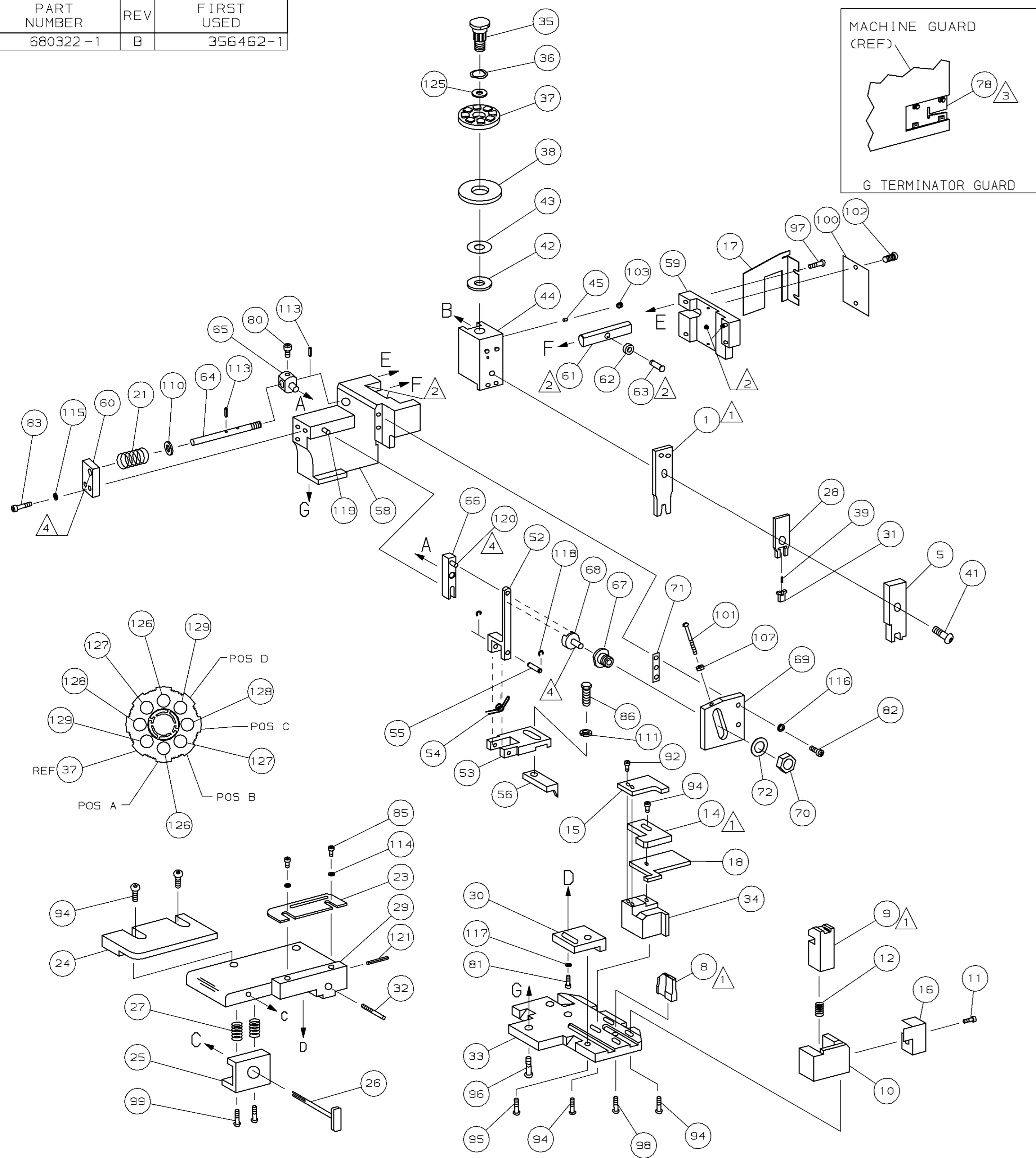


PART NUMBER	REV	FIRST USED
680322 -1	B	356462-1

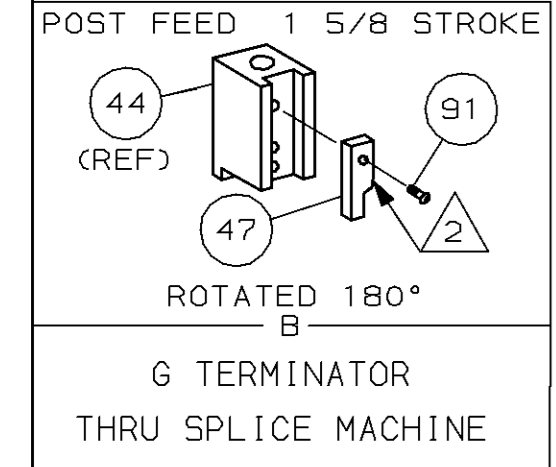
THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INCORPORATED. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.



TERMINAL NAME: .125 BLADE, AMPLIVAR™ CONTACT		CRIMPING DATA	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.038 ±.002 [0.91 ±0.05mm]	700-850 CMA (21)	
B	.033 ±.002 [0.84 ±0.05mm]	400-600 CMA (24)	
C	.031 ±.002 [0.79 ±0.05mm]	200-300 CMA (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
-	114-2145	.500	408-8040
			SET UP GAGE LAYOUT
			458637-1 L1672

QTY REQD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-	-	-	-	-	129
2	-	C	6-354779-4	PIN, WIRE DISC (.3310)C	128
2	-	C	5-354779-8	PIN, WIRE DISC (.3280)B	127
2	-	C	4-354779-8	PIN, WIRE DISC (.3230)A	126
1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	-	-	4088040	SF APPL INST 408-8040	123
					122
1	-	A	4-21028-0	PIN,SLT SPR(φ.093x.75)ST GDE PL	121
1	-	A	1-21030-1	PIN,DOWEL (φ.187x.50)LEVER	120
1	-	A	1-21030-6	PIN,DOWEL (φ.187x1.25)HOUSING	119
2	-	A	21045-3	RING,RET "C"(φ.187)FD FING PIN	118
1	-	A	21024-5	WASHER, LOCK (#10)ADJ BLOCK	117
2	-	A	21024-5	WASHER,LOCK (#10)ADJ PLATE	116
2	-	A	21024-5	WASHER,LOCK (#10)FEED GDE ROD	115
2	-	A	21024-2	WASHER,LOCK (#4)FRONT ST GUIDE	114
2	-	A	5-21028-1	PIN,SLT SPR(φ.125x.50)ADJ ROD	113
					112
1	-	A	21024-4	WASHER, LOCK (#8) STRIPPER	111
1	-	A	21899-4	WASHER, FLAT (φ5/16) SCREW ADJ	110
					109
1	-	A	21018-5	NUT, HEX (NO. 6) HOLDDOWN	108
1	-	A	21018-5	NUT, HEX (6-32) FEED ADJ	107
					106
					105
1	-	A	992031-1	PIN, CLEVIS	104
1	-	A	21009-2	SCR,SKT SET (1/4-20x.25 LW)RAM	103
2	-	A	21017-2	SCR,DRIVE (#2x.19) 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
4	-	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
7	-	A	2-21002-2	SCR,BHC (8-32x.50)TERM H DWN	94
					93
2	-	A	1-21002-8	SCR,BHC (6-32x.50)SHEAR	92
1	-	A	1-21002-7	SCR,BHC (6-32x.38)CAM	91
					90
1	-	A	7-21000-9	SCR,SHC (4-40x.19)STRIPPER	89
					88
					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)F ST GUIDE	85
					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)FD ADJ BLK	82
1	-	A	3-21000-4	SCR,SHC (10-32x.38)SG ADJ BL	81
1	-	A	3-21000-4	SCR,SHC (10-32x.38)PIVOT BLK	80
					79
REF	-	C	356467-1	GUARD	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

QTY REQD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
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	454220-1	CAP, RAM	59
1	-	D	454485-1	HOUSING	58
					57
1	-	B	690542-2	PAWL, FEED	56
1	-	B	240624-1	PIN, FEED FINGER	55
1	-	B	691499-1	SPRING, FEED FINGER	54
1	-	B	690541-1	HOLDER, FEED FINGER	53
1	-	A	455679-1	LEVER, TERMINAL FEED ARM	52
					51
					50
					49
					48
1	-	B	690501-4	CAM, POST-FEED 1 5/8 ST	47
					46
1	-	A	690191-1	PLUG, NYLON	45
1	-	C	455673-1	RAM	44
1	-	A	690125-1	WASHER, LAMINATED	43
1	-	A	690124-1	WASHER, RAM	42
1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)	41
					40
1	-	A	1-23147-2	SPRING, COMPRESSION	39
1	-	A	690223-2	SPACER, INSULATION DISC	38
1	-	D	354777-1	WIRE DISC, PLASTIC	37
1	-	A	22480-5	WASHER, SPRING	36
1	-	B	690212-1	POST, RAM	35
1	-	B	356469-1	SUPPORT, SHEAR	34
1	-	B	356600-1	PLATE, BASE MODIFIED	33
1	-	A	690432-3	SCREW, ADJUSTMENT	32
1	-	A3	356735-1	DEPRESSOR, WIRE	31
1	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	-	C	455671-1	PLATE, STRIP GUIDE	29
1	-	A3	356734-1	GUIDE, DEPRESSOR	28
2	-	A	1-22284-0	SPRING, DRAG	27
1	-	B	690546-1	LEVER, DRAG RELEASE	26
1	-	B	240792-1	DRAG, TERMINAL	25
1	-	D	8-690504-3	GUIDE, STRIP (REAR)	24
1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
					22
1	-	A	4-22284-9	SPRING, FEED RETURN	21
					20
					19
1	-	A3	318714-1	HOLD DOWN	18
1	-	C	356598-1	GUARD	17
1	-	B	318563-1	GUARD, CHIP, FRONT	16
1	-	B	356468-1	COVER	15
1	-	B	356461-1	SHEAR PLATE, WIRE	14
					13
1	-	A	5-22280-0	SPRING, SHEAR	12
1	-	B	690461-1	STOP, SHEAR	11
1	-	C	690459-1	HOLDER, SHEAR (FRONT)	10
1	-	C	1-454276-7	SHEAR, FLOAT (FRONT)	9
1	-	C	1-805840-0	ANVIL	8
					7
					6
1	-	C	2-455889-8	DEPRESSOR, SHEAR (FRONT)	5
					4
					3
					2
1	-	C	318542-2	CRIMPER, WIRE	1
-1	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 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 5 WITH WIRE TRIM FEATURE.
- 6 SET-UP ONLY.

LOC	A
DIST	66

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

2 PLC DEC ±
3 PLC DEC ±
4 PLC DEC ±
ANGLES ±
SURF TEXTURE: ✓
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL - HT TR - FIN -

DR 6-11-96 APP 6-11-96
M. OBRINE J. STACHURA
CHK 6-11-96 REL 7-96
C. ERISMAN

AMP AMP Incorporated
Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR MACHINE REF
SCALE - DWG NO 680322 SHEET 1 OF 1 REV B