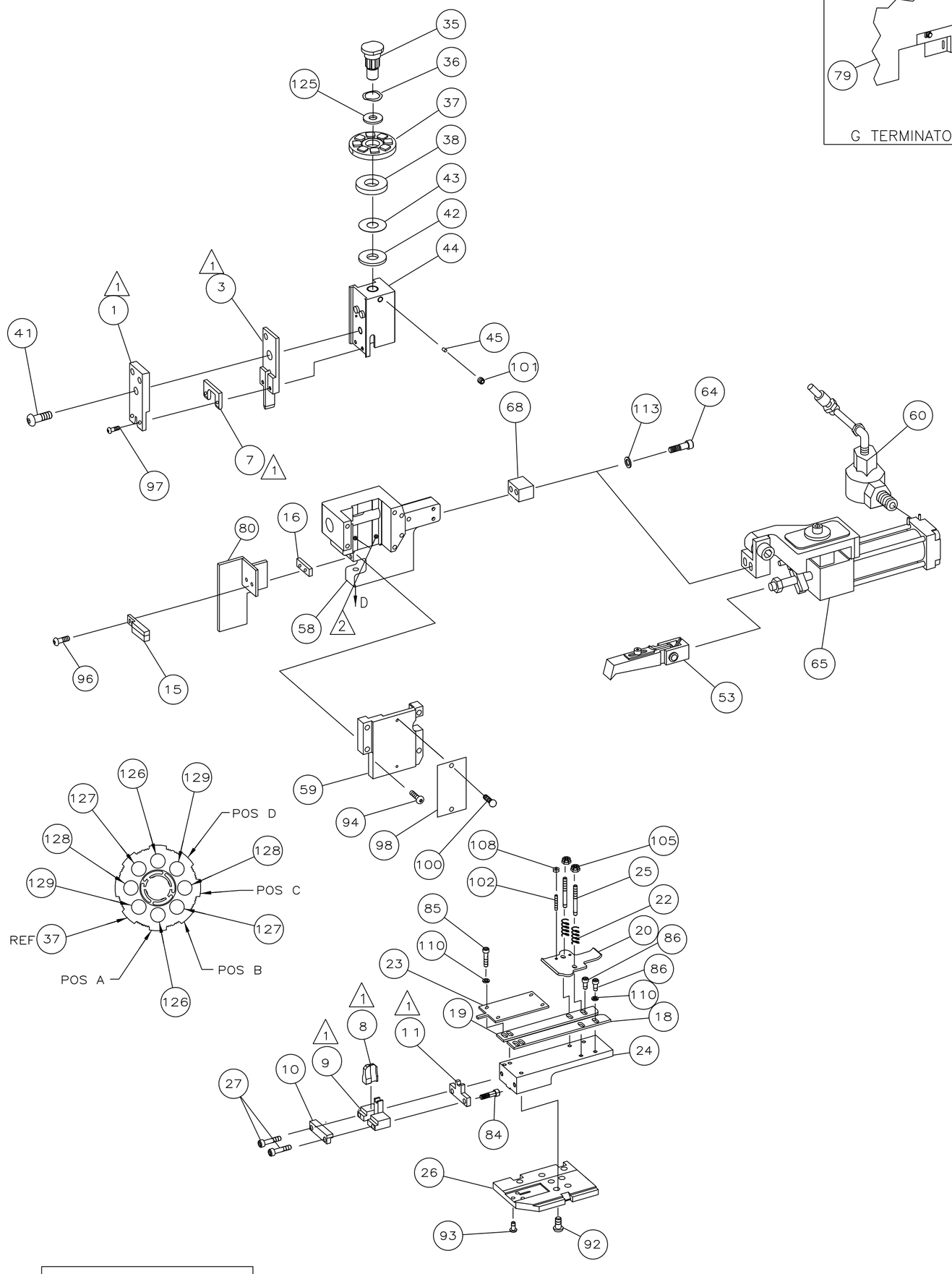
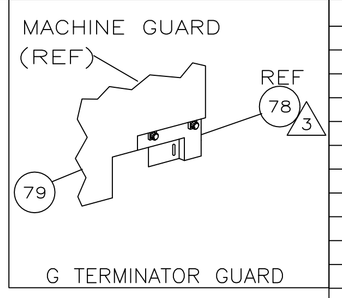
DRAWING MADE IN THIRD ANGLE PROJECTION

/home/us016926/DMTECmod

680186 ⇔ 680186

PART NUMBER	REV	FIRST USED
680186 −3	D	354500−1





TERMINAL NAME: AMPLIVAR™ SPLICE 7 SERRATIONS △6

62002

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	CMA
A	.103 ±.002 [2.97 ±0.05mm]	11,600−13,000
B	.099 ±.002 [2.84 ±0.05mm]	10,200−11,4000
C	.095 ±.002 [2.72 ±0.05mm]	8600−10,000
D	.091 ±.002 [2.59 ±0.05mm]	7000−8400

CRIMP	SIZE	TYPE	RANGE
WIRE	.220 [5.59mm]	F	7000−13,000 CMA
INSUL	−	−	−

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INST	SET UP GAGE	LAYOUT
−	114−2002	.315	408−8039	−	L1631Q

SET_UP WIRE

A	1(12)+ 1(13)
B	2(13)
C	1(12)+ 1(16)
D	2(14)

−3 BENCH MODEL G AIRFEED

△	QTY REQD PER ASSY −3	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO	△	QTY REQD PER ASSY −3	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
	2	–	C	7−354778−7	PIN, WIRE DISC (.2880)D	129							70
	2	–	C	6−354778−9	PIN, WIRE DISC (.2840)C	128							69
	2	–	C	6−354778−1	PIN, WIRE DISC (.2800)B	127		1	–	A	461690−1	SPACER, AIR FEED	68
	2	–	C	5−354778−6	PIN, WIRE DISC (.2775)A	126							67
	1	–	A	986950−1	WASHER, FLAT PRECISION	125							66
						124	△4	1	–	B	460277−1	AIR FEED ASSY	65
						123		2	–	A	4−21000−3	SCR,SHC 10−32x2.00 AIR ASSY	64
						122							63
						121							62
						120							61
						119		1	–	B	692655−7	AIR FEED VALVE ASSEMBLY	60
						118		1	–	A	462926−1	CAP, RAM	59
						117		1	–	D	453736−1	HOUSING	58
						116	△1	1	–	A	7−21013−3	SCR,SET(5/16−24x.38)CR BOLT	57
						115							56
						114							55
	2	–	A	21024−5	WASHER,LOCK(NO.10)	113							54
						112	△4	1	–	B	460680−7	FEED FINGER ASSY	53
						111							52
	6	–	A	21024−4	WASHER,LOCK(NO.8)SHEAR BL	110							51
						109		1	–	–	318848−1	AIR BLAST ASSEMBLY	50
	2	–	A	21018−4	NUT,HEX(4−40)DRAG	108							49
						107							48
						106							47
	2	–	A	21022−2	NUT,HEX SL(8−32)DRAG STUD	105							46
						104		1	–	A	690191−1	PLUG, NYLON	45
						103		1	–	D	459586−1	RAM	44
	2	–	A	2−21006−6	SCR,SKT SET(4−40x.62)DRAG	102		1	–	A	690125−1	WASHER, LAMINATED	43
	1	–	A	21009−2	SCR,SKT SET(1/4−20x.25)RAM	101		1	–	A	690124−4	WASHER, RAM	42
	2	–	A	1−21002−3	SCR,BHC(4−40x.25)ID PLATE	100		1	–	A	7−21002−9	BOLT, CRIMPER(5/16−24x1.00)	41
						99							40
	1	–	B	464249−1	PLATE, IDENTIFICATION	98							39
	2	–	A	2−21002−8	SCR,BHC(10−32x.63)	97		1	–	A	690223−2	SPACER, INSULATION DISC	38
	2	–	A	3−21000−2	SCR,SHC(8−32x1.25)GUARD	96		1	–	D	354777−1	WIRE DISC, PLASTIC	37
						95		1	–	A	22480−5	WASHER, SPRING	36
	4	–	A	2−21002−9	SCR,BHC(10−32x.75)CAP	94		1	–	B	690212−1	POST, RAM	35
	1	–	A	22733−8	SCR,BHC(8−32x.38 LW)ANVIL	93							34
	4	–	A	3−21002−4	SCR,BHC(1/4−20x.62)ST GD PL	92							33
						91							32
						90							31
						89							30
						88							29
						87							28
	2	–	A	2−21000−6	SCR,SHC(8−32x.38)STRIP GUIDE	86		2	–	B	1−21000−9	SCREW	27
	4	–	A	2−21000−7	SCR,SHC(8−32x.50)R STRIP GUIDE	85		1	–	A	224371−1	PLATE, BASE	26
	2	–	A	1−21002−6	SCR,BHC(6−32x.25)R STRIP GUIDE	84		2	–	A	22354−7	DRAG, STUD	25
						83		1	–	B	462931−1	PLATE, STRIP GUIDE	24
						82		1	–	C	462932−4	PLATE, STRIP COVER	23
						81		2	–	A	3−22281−8	SPRING, DRAG	22
△3	1	–	C	224383−1	GUARD,SIDE	80							21
△3	1	–	C	224388−1	GUARD ASSY	79		1	–	A	462925−1	DRAG, STOCK	20
△3	REF	–	A	224322−1	INSERT, GUARD	78		1	–	B	462929−2	GUIDE, STRIP (REAR)	19
						77		1	–	C	462930−2	GUIDE, STRIP (FRONT)	18
						76							17
						75		1	–	B	2−690451−5	SPACER, STRIPPER	16
						74		1	–	B	1633729−1	STRIPPER ASSEMBLY	15
						73							14
						72							13
						71							12
							△1	1	–	B	459684−2	PLATE, GUIDE RETAINING	11
								1	–	B	459580−1	SHERA PLATE,SPACER	10
							△1	1	–	B	1−458583−9	HOLDER, ANVIL	9
							△1	1	–	D	1−459582−1	ANVIL	8
							△1	1	–	B	459581−2	BLADE, SLUG	7
													6
													5
													4
								1	–	B	318158−1	GUIDE, CRIMPER	3
													2
							△1	1	–	C	1−459585−2	CRIMPER, WIRE	1

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

QTY REQD PER ASSY — PARTS LIST

△1 RECOMMENDED SPARE PARTS.

△2 GREASE LIGHTLY.

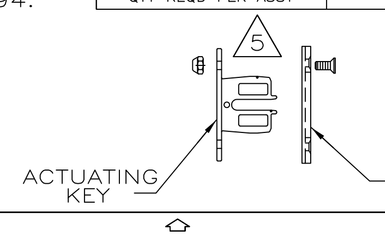
△3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.

△4 SEE DRAWING FOR COMPONENTS

△5 REMOVE ACTUATING KEY AND BLACK COVER PLATE FROM EXISTING G TERMINATING GUARD AND INSTALL ON ITEM 79

△6 LUBRICATOR REQUIRED WITH AMPLIVAR SPLICE TERMINAL

△7 INSTALL ITEM 50 TO ITEM 59 USING ITEM 94.



P	F	LTR	REVISION RECORD	APP	DATE
		D	ECR−15−015629	YY	10−15
		C	ECR−08−029663	DM	11−08
		B1	ECN 0150−0504−03	TE	5−03
		B	ECN 0150−0525−01	TE	5−01
		A2	0150−8428−98	TB	4−98
		A1	0150−8147−97	TB	12−97
		A	REVISED	CE	1−96

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 7−7−95 R O WILSON | APP 7−11−95 A BEDDICK | CHK 7−10−95 C ERISMAN | REL 12/3/97 B. MORGAN

TE Connectivity Harrisburg, PA 17105−3608

NAME END FEED HDM APPLICATOR | MACHINE REF MINI APPL

SCALE – | D | DWG NO 680186 | SHEET 1 OF 1 | REV D

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

LOC A | DIST 66

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