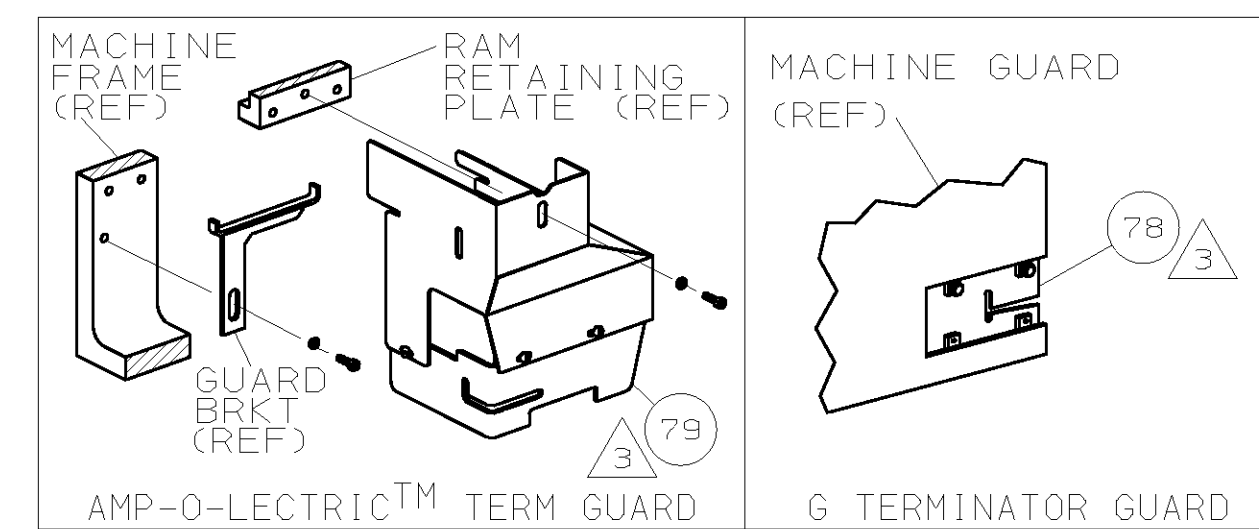


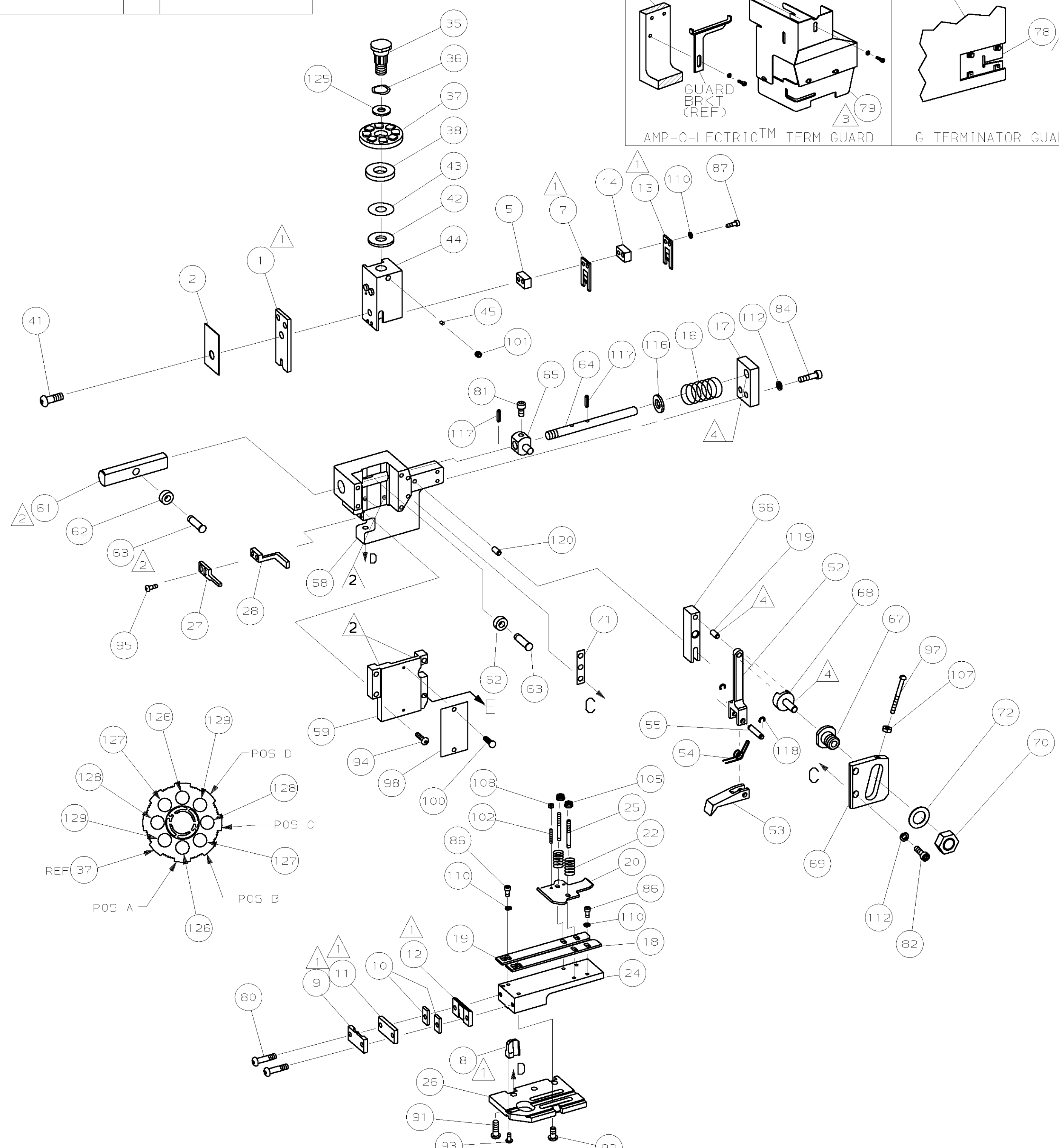
PART NUMBER	REV	FIRST USED
466691-3	B	122500-1 & 354500-1



TERMINAL NAME: AMPLIVAR™ RING		CRIMPING DATA			
PAD LTR	CRIMP HEIGHT	WIRE SIZE			
A	.076 ±.002 [1.93 ±0.05mm]	14 OR 14 1/2			
B	.073 ±.002 [1.85 ±0.05mm]	15			
C	.069 ±.002 [1.75 ±0.05mm]	16			
D	.065 ±.002 [1.65 ±0.05mm]	17 OR 18			
CRIMP	SIZE	TYPE	RANGE		
WIRE	.110 [2.79mm]	F	18-14		
INSUL	.155 [3.94mm]	F	.100-.140		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
-	114-2084	.898	408-8039	458638-1	L971

REF	QTY	DESCRIPTION	ITEM NO
REF	-	A 22594-8 NUT, HEX	70
REF	-	B 240628-1 PLATE, ADJ	69
REF	-	B 240626-1 SHAFT, PIVOT	68
REF	-	B 240633-1 BUSHING	67
REF	-	A 455680-1 LEVER, INTERMEDIATE	66
REF	-	B 240629-1 BLOCK, PIVOT	65
REF	-	A 240632-2 SCR, ADJ	64
REF	-	B 240659-3 PIN, CAM ROLLER	63
REF	-	B 240658-1 CAM, ROLLER	62
REF	-	B 454398-1 ROD, FEED	61

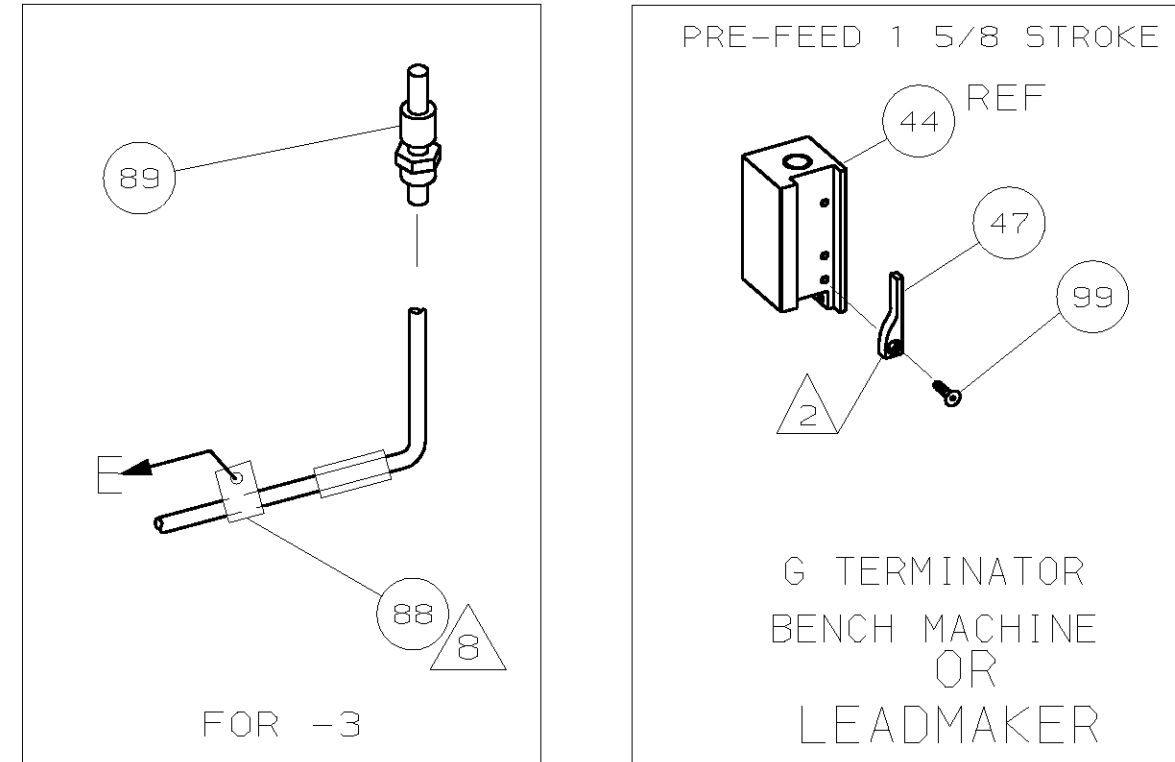
THIS DRAWING IS A CONTROLLED DOCUMENT.



QTY	REF	DESCRIPTION	ITEM NO
2	-	C 8-354778-1 PIN, WIRE DISC (.2900)D	129
2	-	C 7-354778-3 PIN, WIRE DISC (.2860)C	128
2	-	C 6-354778-5 PIN, WIRE DISC (.2820)B	127
2	-	C 5-354778-9 PIN, WIRE DISC (.2790)A	126
1	-	A 986950-1 WASHER, FLAT PRECISION	125
1	-	A 217238-1 DOCUMENTATION PACKAGE	124
1	-	- 4088039 EF APPL INST 408-8039	123
			122
			121
REF	-	A 1-21030-7 PIN, DOWEL (Ø.187x1.50)H5G	120
REF	-	A 1-21030-1 PIN, DOWEL (Ø.187x.50)LEVER	119
REF	-	A 21045-3 RING, RET "C" (Ø.187)FD PIN	118
REF	-	A 5-21028-1 PIN, STD SPRING (Ø.12)FD ADJ ROD	117
REF	-	A 21899-4 WASHER, FLAT (Ø5/16)SCR ADJ	116
			115
			114
			113
REF	-	A 21024-5 WASHER, LOCK (NO.10)FD ROD GDE	112
			111
6	-	A 21024-4 WASHER, LOCK (NO.8)SHEAR BL	110
			109
2	-	A 21018-4 NUT, HEX (4-40)DRAG	108
REF	-	A 21018-5 NUT, HEX (6-32)FD ADJ PL	107
			106
2	-	A 21022-2 NUT, HEX 5L (8-32)DRAG STUD	105
			104
			103
2	-	A 2-21006-6 SCR, SKT SET (4-40x.62)DRAG	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
1	-	A 1-21002-7 SCR, BHC (6-32x.38)CAM	99
1	-	B 461264-1 PLATE, IDENTIFICATION	98
REF	-	A 6-23715-5 SCR, PAN HD (6-32x1.50)FEED ADJ	97
			96
2	-	A 2-21002-2 SCR, BHC (8-32x.50)STRIPPER	95
REF	-	A 2-21002-9 SCR, BHC (10-32x.75)H5G CAP	94
1	-	A 22733-8 SCR, BHC (8-32x.38 LW)ANVIL	93
4	-	A 3-21002-3 SCR, BHC (1/4-20x.50)ST 6D PL	92
REF	-	A 2-22733-8 SCR, BHC (1/4-20x.62)BASE PL	91
			90
1	-	B 318848-1 AIR BLAST ASSEMBLY	89
REF	-	A 23545-1 CLAMP, WIRE	88
2	-	A 2-21000-9 SCR, SHC (8-32x.71)SLUG BLADE	87
4	-	A 2-21000-6 SCR, SHC (8-32x.38)STRIP GUIDE	86
			85
REF	-	A 3-21000-7 SCR, SHC (10-32x.75)FEED ROD GDE	84
			83
REF	-	A 3-21000-6 SCR, SHC (10-32x.62)FEED ADJ PL	82
REF	-	A 3-21000-4 SCR, SHC (10-32x.38)PIVOT BLOCK	81
2	-	A 3-21002-0 SCR, BHC (10-32x.88)SHEAR PL	80
-	-	A 455745-1 GUARD, WINDOW	79
REF	-	A 679532-1 INSERT, GUARD	78
			77
			76
			75
			74
			73
REF	-	A 458109-1 WASHER, FLAT (SPECIAL)	72
REF	-	A 690517-1 SPACER	71

QTY	REF	DESCRIPTION	ITEM NO
			60
			59
			58
			57
			56
			55
REF	-	B 240624-1 PIN, FEED FINGER	55
REF	-	B 691499-1 SPRING, FEED FINGER	54
REF	-	B 240635-1 FINGER, FEED	53
REF	-	B 240634-1 LEVER, TERMINAL	52
			51
			50
			49
			48
1	-	B 690602-6 CAM, PRE FEED 1 5/8 ST	47
			46
1	-	A 690191-1 PLUG, NYLON	45
1	-	C 455674-1 RAM	44
1	-	A 690125-1 WASHER, LAMINATED	43
1	-	A 690124-1 WASHER, RAM	42
1	-	A 7-21002-9 BOLT, CRIMPER (5/16-24x1.00)	41
			40
			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
			34
			33
1	-	D 458980-1 APPLICATOR, BASIC (SUB ASSY)	32
			31
			30
			29
1	-	B 356212-1 STRIPPER, SPECIAL	28
1	-	A 240639-1 STRIPPER	27
REF	-	C 455676-1 PLATE, BASE	26
2	-	A 22354-8 DRAG, STUD	25
1	-	B 455678-1 PLATE, STRIP GUIDE	24
			23
2	-	A 4-22281-1 SPRING, DRAG	22
			21
1	-	A 454177-1 DRAG, STOCK	20
1	-	B 356224-1 GUIDE, STRIP (REAR)	19
1	-	C 356225-1 GUIDE, STRIP (FRONT)	18
REF	-	A 454178-1 GUIDE, FEED ROD	17
REF	-	A 4-22284-9 SPRING, FEED RETURN	16
			15
1	-	C 240641-5 SPACER, SLUG BLADE	14
1	-	B 318706-1 BLADE, SLUG	13
1	-	B 1-240642-8 PLATE, REAR SHEAR	12
1	-	B 1-240644-5 PLATE, REAR SHEAR	11
2	-	C 240645-3 SPACER, SHEAR PLATE	10
1	-	B 690482-8 PLATE, FRONT SHEAR	9
1	-	D 459866-4 ANVIL	8
1	-	B 2-690474-1 BLADE, SLUG	7
			6
1	-	C 2-240641-9 SPACER, SLUG BLADE	5
			4
			3
1	-	B 1-455888-0 SPACER, CRIMPER	2
1	-	C 456408-9 CRIMPER, WIRE	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 ITEM 78 USED WITH G TERMINATOR ONLY.
- 8 INSTALL ITEM 88 TO ITEM 59 USING ITEM 94
- 9 THIS APPLICATOR REMOVES THE INSULATION BARREL
- 10 CUT TO LENGTH AT ASSY



LOC	A
DIST	66

QTY REOD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)					
DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED:			MATERIAL		
2 PLC DEC ±.25			HT TR		
3 PLC DEC ±			FIN		
4 PLC DEC ±			-		
ANGLES ±			-		
SURF TEXTURE:			-		
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX			-		
DR P. MATHIAS			APP T. ELBIN		
CHK 3-20-96			REL 3/22/96		
C. ERISMAN			B. MORGAN		
NAME			MACHINE REF		
END FEED HDM APPLICATOR			MINI APPL		
SCALE			SHEET		
D			1 OF 1		
DWG NO			REV		
466691-3			B2		
CASE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO					