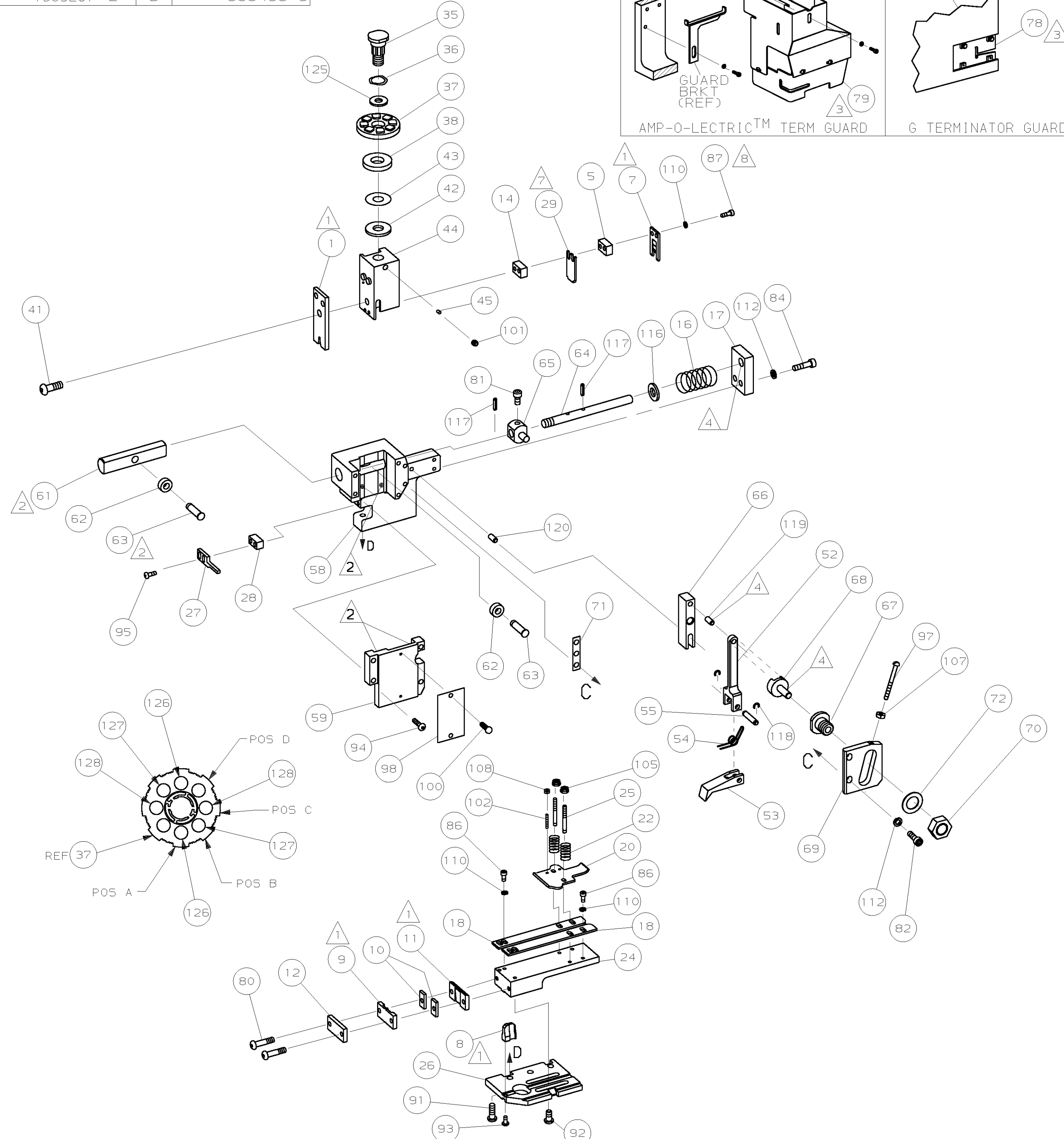
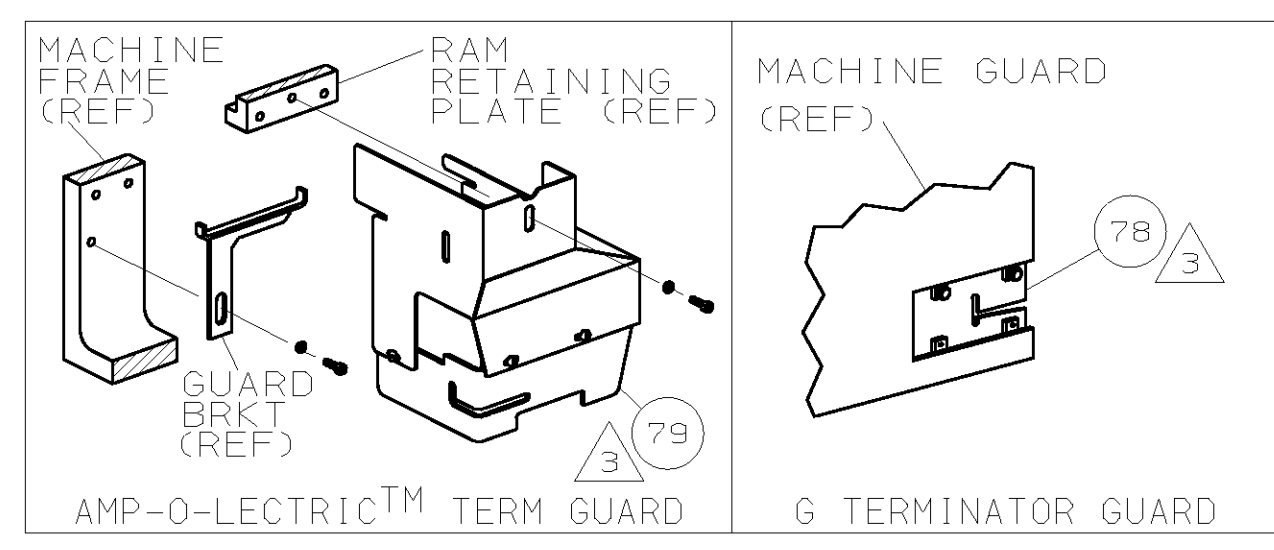
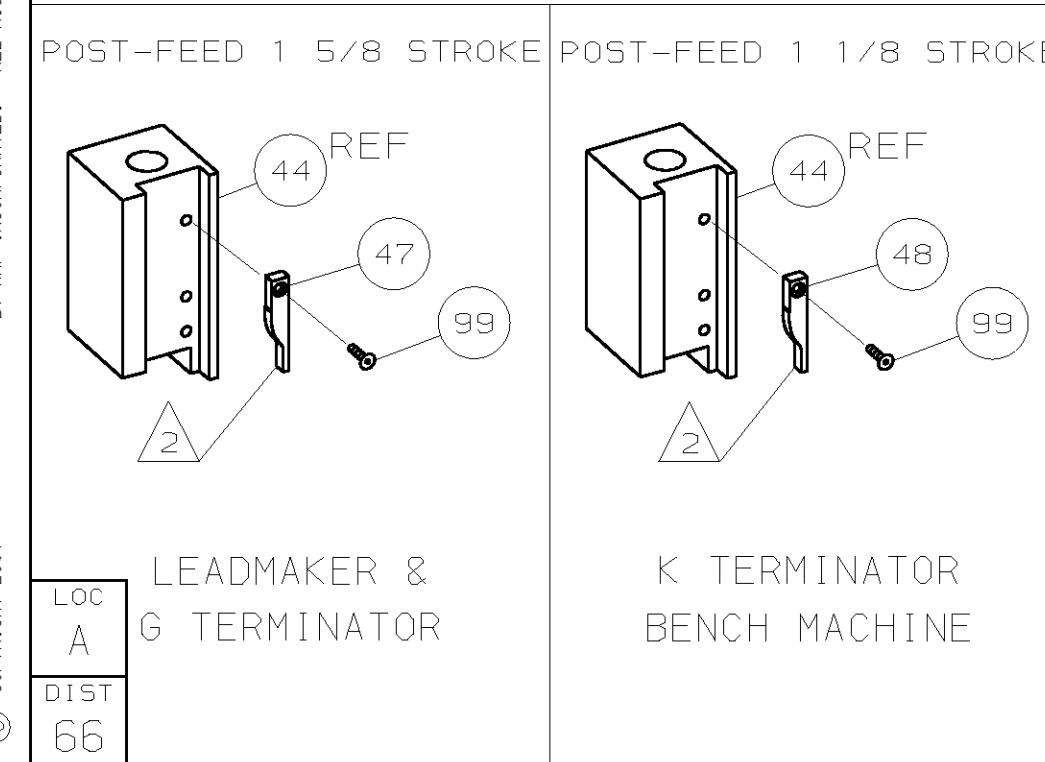


PART NUMBER	REV	FIRST USED
1385267-1	B	122500-1
1385267-2	B	565435-5



TERMINAL NAME: #6 STUD, SPADE		AMP TERMINAL		AMP CRIMP SPECS	
PAD LTR	CRIMP HEIGHT	WIRE SIZE			
A	.078 ±.002 [1.98 ±0.05mm]	16			
B	.071 ±.002 [1.80 ±0.05mm]	18			
C	.067 ±.002 [1.70 ±0.05mm]	20			
D	NOT	USED			
CRIMP	SIZE	TYPE	RANGE		
WIRE	.090 [2.29mm]	F	20-16		
INSUL	-	-	-		

QTY	REF	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	2	-	C		5-354778-7	PIN, WIRE DISC (.2780)C	129
2	2	-	C		4-354778-9	PIN, WIRE DISC (.2740)B	127
2	2	-	C		3-354778-5	PIN, WIRE DISC (.2670)A	126
1	1	-	A		986950-1	WASHER, FLAT PRECISION	125
1	1	-	A		217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	-	-		4088039	EF APPL INST 408-8039	123
							122
							121
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		21045-3	RING, RET "C" (Ø.187)FD PIN	118
REF	REF	-	A		5-21028-1	PIN, STD SPRING (Ø.12)FD ADJ ROD	117
REF	REF	-	A		21899-4	WASHER, FLAT (Ø5/16)SCR ADJ	116
							115
							114
							113
REF	REF	-	A		21024-5	WASHER, LOCK (NO.10)FD ROD GDE	112
							111
6	6	-	A		21024-4	WASHER, LOCK (NO.8)SHEAR BL	110
							109
2	2	-	A		21018-4	NUT, HEX (4-40)DRAG	108
REF	REF	-	A		21018-5	NUT, HEX (6-32)FD ADJ PL	107
							106
2	2	-	A		21022-2	NUT, HEX 5L (8-32)DRAG STUD	105
							104
							103
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
							96
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		2-21000-7	SCR, 5HC (8-32x.50)SLUG BLADE	87
4	4	-	A		2-21000-5	SCR, 5HC (8-32x.25)STRIP GUIDE	86
							85
REF	REF	-	A		3-21000-7	SCR, 5HC (10-32x.75)FEED ROD GDE	84
							83
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	-	A		679532-1	INSERT, GUARD	78
							77
							76
							75
							74
							73
REF	REF	-	A		458109-1	WASHER, FLAT (SPECIAL)	72
REF	REF	-	A		690517-1	SPACER	71



- 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.
- 7 ADJUST ITEM 29 TO ACHIEVE PROPER BEND WHEN CHANGING WIRE SIZES.
- 8 CUT TO LENGTH AT ASSEMBLY.

QTY	REF	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-1	REF	REF	-	A	22594-8	NUT, HEX	70
-2	REF	REF	-	B	240628-1	PLATE, ADJ	69
	REF	REF	-	B	240626-1	SHAFT, PIVOT	68
	REF	REF	-	B	240633-1	BUSHING	67
	REF	REF	-	A	455680-1	LEVER, INTERMEDIATE	66
	REF	REF	-	B	240629-1	BLOCK, PIVOT	65
	REF	REF	-	A	240632-2	SCR, ADJ	64
	REF	REF	-	B	240659-3	PIN, CAM ROLLER	63
	REF	REF	-	B	240658-1	CAM, ROLLER	62
	REF	REF	-	B	454398-1	ROD, FEED	61
							60
	REF	REF	-	C	454220-1	CAP, RAM	59
	REF	REF	-	D	453736-1	HOUSING	58
							57
							56
	REF	REF	-	B	240624-1	PIN, FEED FINGER	55
	REF	REF	-	B	691499-1	SPRING, FEED FINGER	54
	REF	REF	-	B	240635-1	FINGER, FEED	53
	REF	REF	-	B	240634-1	LEVER, TERMINAL	52
							51
							50
							49
1	-	-	B		690501-3	CAM, POST FEED 1 1/8 ST	48
-	1	-	B		690501-4	CAM, POST-FEED 1 5/8 ST	47
							46
1	1	-	A		690191-1	PLUG, NYLON	45
1	1	-	C		455674-2	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
							40
							39
1	1	-	A		690223-2	SPACER, INSULATION DISC	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		458980-1	APPLICATOR, BASIC (SUB ASSY)	32
							31
							30
1	1	-	B		690759-9	TOOL, FORMING	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		455678-6	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		1-458030-8	GUIDE, STRIP (REAR)	19
1	1	-	C		1-458031-8	GUIDE, STRIP (FRONT)	18
REF	REF	-	A		454178-1	GUIDE, FEED ROD	17
REF	REF	-	A		4-22284-9	SPRING, FEED RETURN	16
							15
1	1	-	B		2-240641-1	SPACER, SLUG BLADE	14
							13
1	1	-	B		690783-1	SPACER, PLATE	12
1	1	-	B		1-240644-1	PLATE, REAR SHEAR	11
2	2	-	C		240645-8	SPACER, SHEAR PLATE	10
1	1	-	B		690784-2	PLATE, FRONT SHEAR	9
1	1	-	D		5-240654-2	ANVIL	8
1	1	-	B		1-240651-2	BLADE, SLUG	7
							6
							5
							4
							3
							2
1	1	-	C		1-456406-2	CRIMPER, WIRE	1

REVISION RECORD

REV	DATE	DESCRIPTION
A	05/01	REVISED

DR A. ANDERSON
CHK -
REL -

APP T. ELBIN

AMP Incorporated
Harrisburg, PA 17105-3608

NAME END FEED HDM APPLICATOR

SCALE -

DWG NO 1385267

SHEET 1 OF 1

REV B

CUSTOMER AND ASSEMBLY DRAWING

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