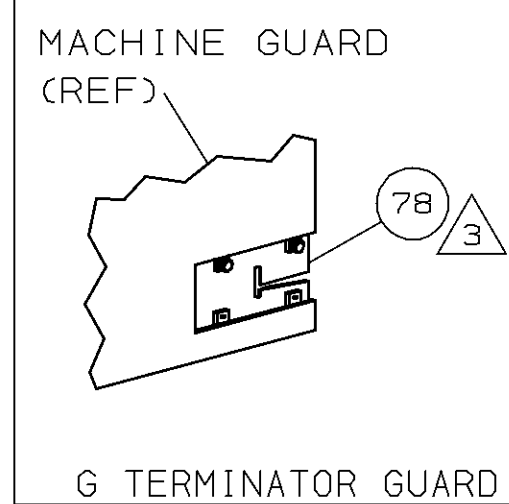


PART NUMBER	REV	FIRST USED
687725-4	0	354500-1



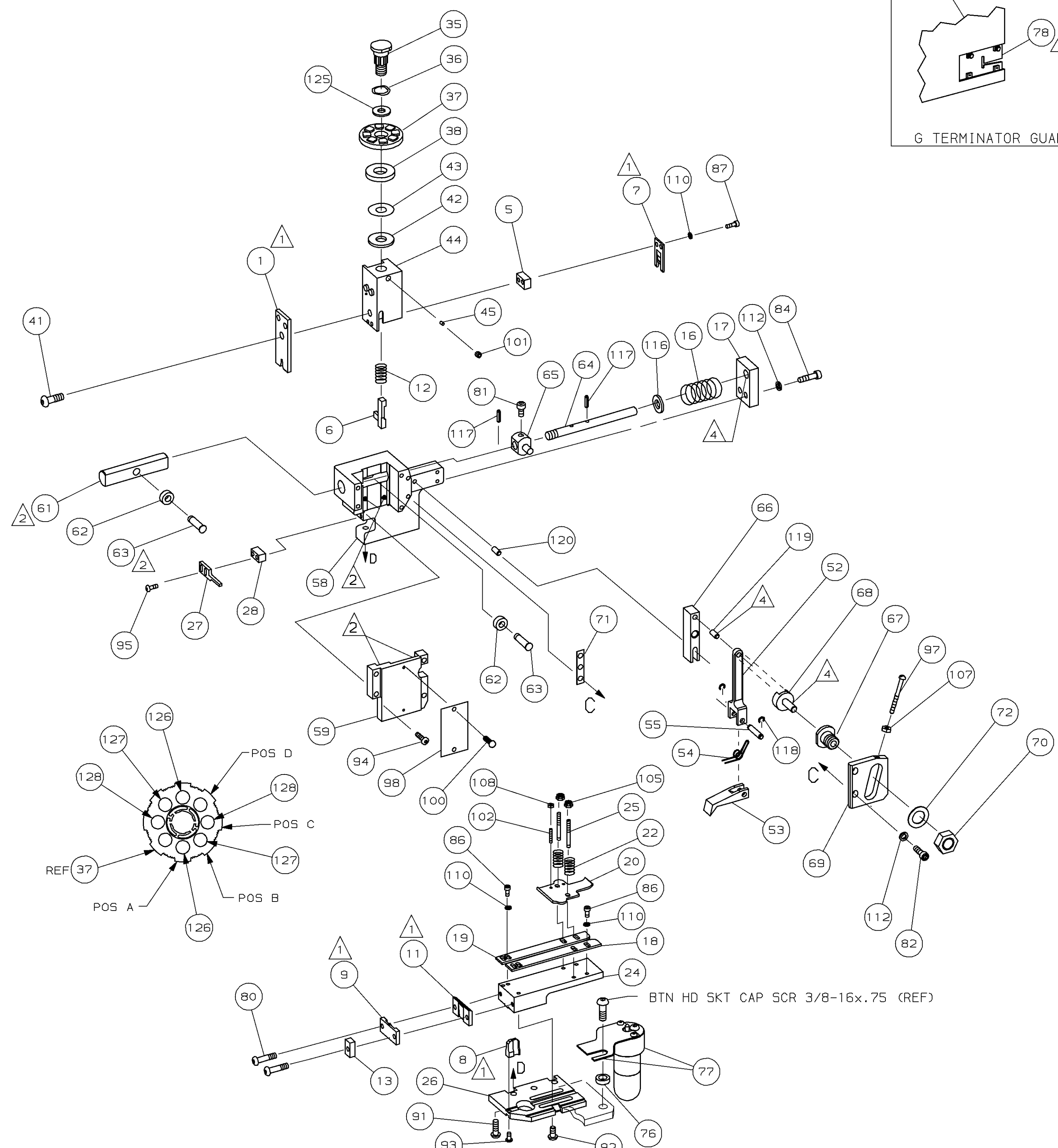
TERMINAL NAME: AMPLIVAR™ RING TONGUE					
CRIMP DATA (NON-AMP TERMINAL-AMP SPEC)					
PAD LTR	CRIMP HEIGHT		WIRE SIZE		
A	.058 ± 0.002 [1.47 ± 0.05mm]		18		
B	.054 ± 0.002 [1.37 ± 0.05mm]		20		
C	.052 ± 0.002 [1.32 ± 0.05mm]		22		
D	NOT		USED		
CRIMP	SIZE	TYPE	RANGE		
WIRE	.110 [2.79mm]	F	22-18		
INSUL	-	-	-		

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.173-204	114-2084	.590	408-8039	458638-1	598

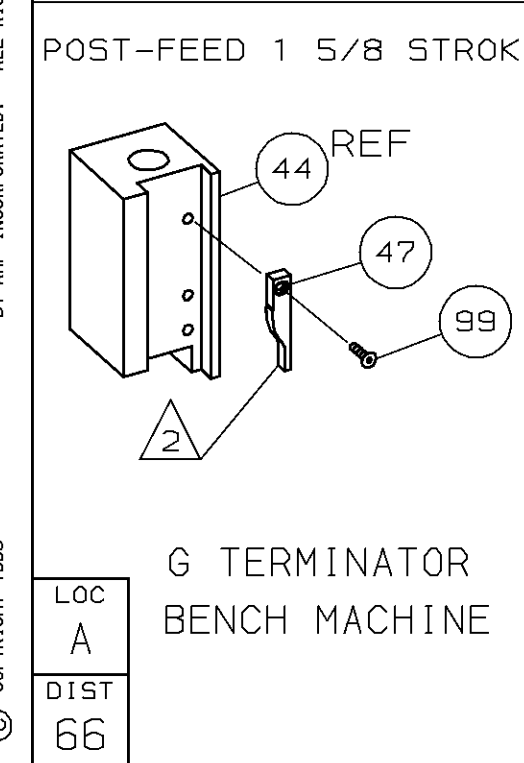
-4	BENCH MODEL G	MECH POST FEED
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THIS DRAWING IS A CONTROLLED DOCUMENT.



QTY	REF	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	-	C		1-354779-8	PIN, WIRE DISC (.3080)C	129
2	-	C		1-354779-4	PIN, WIRE DISC (.3060)B	128
2	-	C		354779-6	PIN, WIRE DISC (.3020)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
REF	-	A		1-21030-7	PIN, DOWEL (Ø.187x1.50)HSG	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
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 SL (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)HSG 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 GD PL	92
REF	-	A		2-22733-8	SCR, BHC (1/4-20x.62)BASE PL	91
						90
						89
						88
						87
6	-	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
						79
REF	-	A		679532-1	INSERT, GUARD	78
1	-	C		465184-9	LUBRICATOR ASSY	77
						76
						75
						74
						73
REF	-	A		458109-1	WASHER, FLAT (SPECIAL)	72
REF	-	A		690517-1	SPACER	71

REF					
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
					60
REF	-	C	454220-1	CAP, RAM	59
REF	-	D	453736-1	HOUSING	58
					57
					56
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	690501-4	CAM, POST-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	690223-1	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	1-690451-1	SPACER, STRIPPER	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	1-458030-6	GUIDE, STRIP (REAR)	19
1	-	C	1-458031-6	GUIDE, STRIP (FRONT)	18
REF	-	A	454178-1	GUIDE, FEED ROD	17
REF	-	A	4-22284-9	SPRING, FEED RETURN	16
					15
					14
1	-	C	690481-8	SPACER, HOLD DOWN	13
1	-	A	23846-1	SPRING, HOLD DOWN	12
1	-	B	240644-1	PLATE, REAR SHEAR	11
					10
1	-	B	690482-3	PLATE, FRONT SHEAR	9
1	-	D	456537-2	ANVIL	8
1	-	B	690474-3	BLADE, SLUG	7
1	-	D	5-455892-8	HOLD DOWN, TERMINAL	6
1	-	C	1-240641-1	SPACER, SLUG BLADE	5
					4
					3
					2
1	-	C	456422-1	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.

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QTY REQD PER ASSY		PARTS LIST	
DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED.		MACH REF MINI APPL	
DR D. SALTZER 16 JUL 98 APP T. ELBIN 16 JUL 98		AMP Incorporated Harrisburg, PA 17105-3608	
CHK C. ERISMAN 16 JUL 98 REL -		NAME END FEED HDM APPLICATOR	
SCALE -		SHEET 1 OF 1	
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX		CUSTOMER AND ASSEMBLY DRAWING	