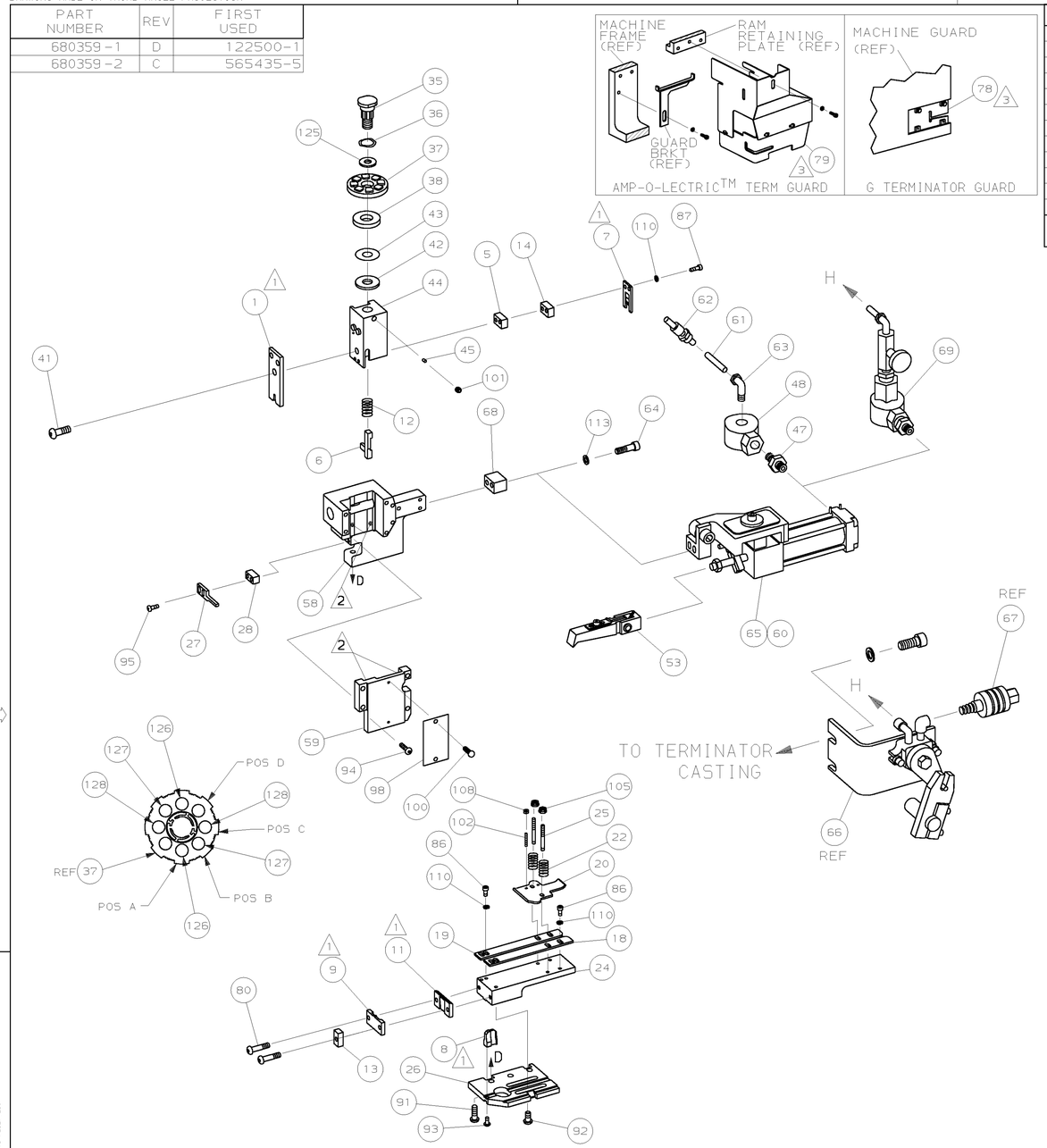
| PART NUMBER | REV | FIRST USED |
|---|---|---|
| 680359-1 | D | 122500-1 |
| 680359-2 | C | 565435-5 |




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

TERMINAL NAME: AMPLIVAR™ RING

62755

CRIMPING DATA

| PAD LTR | CRIMP HEIGHT | WIRE SIZE |
|---|---|---|
| A | .087 ±.002 [2.21 ±0.05mm] | (2)15 |
| B | .086 ±.002 [2.18 ±0.05mm] | 12 |
| C | .078 ±.002 [1.98 ±0.05mm] | 14 |
| D | NOT | USED |

| CRIMP | SIZE | TYPE | RANGE |
|---|---|---|---|
| WIRE | .180 [4.57mm] | F | 12-14 OR (2)15 |
| INSUL | - | - | - |

| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPL INSTRUCTION | SET UP GAGE | LAYOUT |
|---|---|---|---|---|---|
| .218-.248 | 114-2084 | 1.015 | 408-8039 | 458638-1 | L1816 |

| -2 | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|---|---|---|
| 2 | 2 | - | C | 6-354778-0 | PIN, WIRE DISC (.2795)C | 128 |
| 2 | 2 | - | C | 4-354778-4 | PIN, WIRE DISC (.2715)B | 127 |
| 2 | 2 | - | C | 4-354778-5 | PIN, WIRE DISC (.2720)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 |
| 4 | 4 | - | A | 21024-4 | WASHER,LOCK(NO.8)SHEAR BL | 110 |
| 2 | 2 | - | A | 21018-4 | NUT,HEX(4-40)DRAG | 108 |
| 2 | 2 | - | A | 21022-2 | NUT,HEX SL(8-32)DRAG STUD | 105 |
| 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 | - | B | 461264-1 | PLATE, IDENTIFICATION | 98 |
| 2 | 2 | - | A | 2-21002-2 | SCR,BHC(8-32x.50)STRIPPER | 95 |
| 4 | 4 | - | A | 2-21002-9 | SCR,BHC(10-32x.75)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 GD PL | 92 |
| 3 | 3 | - | A | 2-22733-8 | SCR,BHC(1/4-20x.62)H5G | 91 |
| 2 | 2 | - | A | 2-21000-9 | SCR,SHC(8-32x.75)SLUG BLADE | 87 |
| 4 | 4 | - | A | 2-21000-6 | SCR,SHC(8-32x.38)STRIP GUIDE | 86 |
| 2 | 2 | - | A | 3-21002-0 | SCR,BHC(10-32x.88)SHEAR PL | 80 |
| 1 | - | - | A | 455750-8 | GUARD ASSY | 79 |
| - | REF | - | A | 679532-1 | INSERT, GUARD | 78 |

QTY REQD PER ASSY — PARTS LIST

| -1 | -2 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|---|---|---|
| 1 | - | - | C | 692655-5 | AIR FEED VALVE ASSY | 69 |
| 1 | 1 | - | A | 461690-3 | SPACER, AIR FEED | 68 |
| REF | - | - | A | 24042-2 | VALVE, SHUT OFF | 67 |
| REF | - | - | C | 692655-6 | AIR FEED VALVE ASSY | 66 |
| 1 | - | - | B | 1-460277-5 | AIR FEED ASSY (2 INCH) | 65 |
| 2 | 2 | - | A | 4-21000-3 | SCR,SHC (10-32x2.00)AIR ASSY | 64 |
| - | 1 | - | A | 983427-6 | ELBOW, SWIVEL 1/8 NPT - 1/4 T | 63 |
| - | 1 | - | A | 23238-1 | QUICK DISCONNECT | 62 |
| - | 12.00 | IN | A | 27319-4 | TUBING, POLY-FLO Ø.25 | 61 |
| - | 1 | - | B | 1-460277-9 | AIR FEED ASSY (2 INCH) | 60 |
| 1 | 1 | - | C | 454220-1 | CAP, RAM | 59 |
| 1 | 1 | - | D | 453736-1 | HOUSING | 58 |
| 1 | 1 | - | B | 460680-1 | FEED FINGER ASSY | 53 |
| - | 1 | - | A | 22374-7 | VALVE, QUICK EXHAUST | 48 |
| - | 1 | - | A | 22304-1 | NIPPLE,HEX 1/8 NPT | 47 |
| 1 | 1 | - | A | 690191-1 | PLUG, NYLON | 45 |
| 1 | 1 | - | C | 455674-1 | 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 |
| 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 |
| 1 | 1 | - | B | 3-690451-2 | SPACER, STRIPPER | 28 |
| 1 | 1 | - | A | 240639-1 | STRIPPER | 27 |
| 1 | 1 | - | D | 455676-1 | PLATE, BASE | 26 |
| 2 | 2 | - | A | 22354-8 | DRAG, STUD | 25 |
| 1 | 1 | - | B | 455678-1 | PLATE, STRIP GUIDE | 24 |
| 2 | 2 | - | A | 4-22281-1 | SPRING, DRAG | 22 |
| 1 | 1 | - | A | 454177-1 | DRAG, STOCK | 20 |
| 1 | 1 | - | B | 1-458030-5 | GUIDE, STRIP (REAR) | 19 |
| 1 | 1 | - | C | 1-458031-5 | GUIDE, STRIP (FRONT) | 18 |
| 1 | 1 | - | C | 6-240641-8 | SPACER, SLUG BLADE | 14 |
| 1 | 1 | - | C | 1-690481-0 | SPACER, HOLD DOWN | 13 |
| 1 | 1 | - | A | 23846-1 | SPRING, HOLD DOWN | 12 |
| 1 | 1 | - | B | 240644-1 | PLATE, REAR SHEAR | 11 |
| 1 | 1 | - | B | 690482-5 | PLATE, FRONT SHEAR | 9 |
| 1 | 1 | - | D | 7-240654-2 | ANVIL | 8 |
| 1 | 1 | - | B | 690474-5 | BLADE, SLUG | 7 |
| 1 | 1 | - | D | 1-455892-7 | HOLD DOWN, TERMINAL | 6 |
| 1 | 1 | - | C | 240641-4 | SPACER, SLUG BLADE | 5 |
| 1 | 1 | - | C | 456428-3 | CRIMPER, WIRE | 1 |

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

QTY REQD PER ASSY — PARTS LIST

| LTR | REVISION RECORD | APP | DATE |
|---|---|---|---|
| D | ECN 0150-0941-03 | TE | 8-03 |
| C2 | ECN 0150-0077-03 | TE | 1-03 |
| C1 | ECN 0150-1615-02 | TE | 12-02 |
| C | ECN 0150-0500-00 | TE | 8-00 |
| B | 0150-8168-97 | TB | 12-97 |
| A | REVISED | CE | 10-96 |

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 P.MCCARTY 9-5-96 APP T.ELBIN 9-5-96
CHK C.ERISMAN 9-5-96 REL B. MORGAN 12/10/97

AMP Incorporated Harrisburg, PA 17105-3608

NAME END FEED HDM APPLICATOR — MACHINE REF MINI APPL

SCALE - D DWG NO 680359 SHEET 1 OF 1 REV D

CAGE CODE 00779 — CUSTOMER AND ASSEMBLY DRAWING — RESTRICTED TO -

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