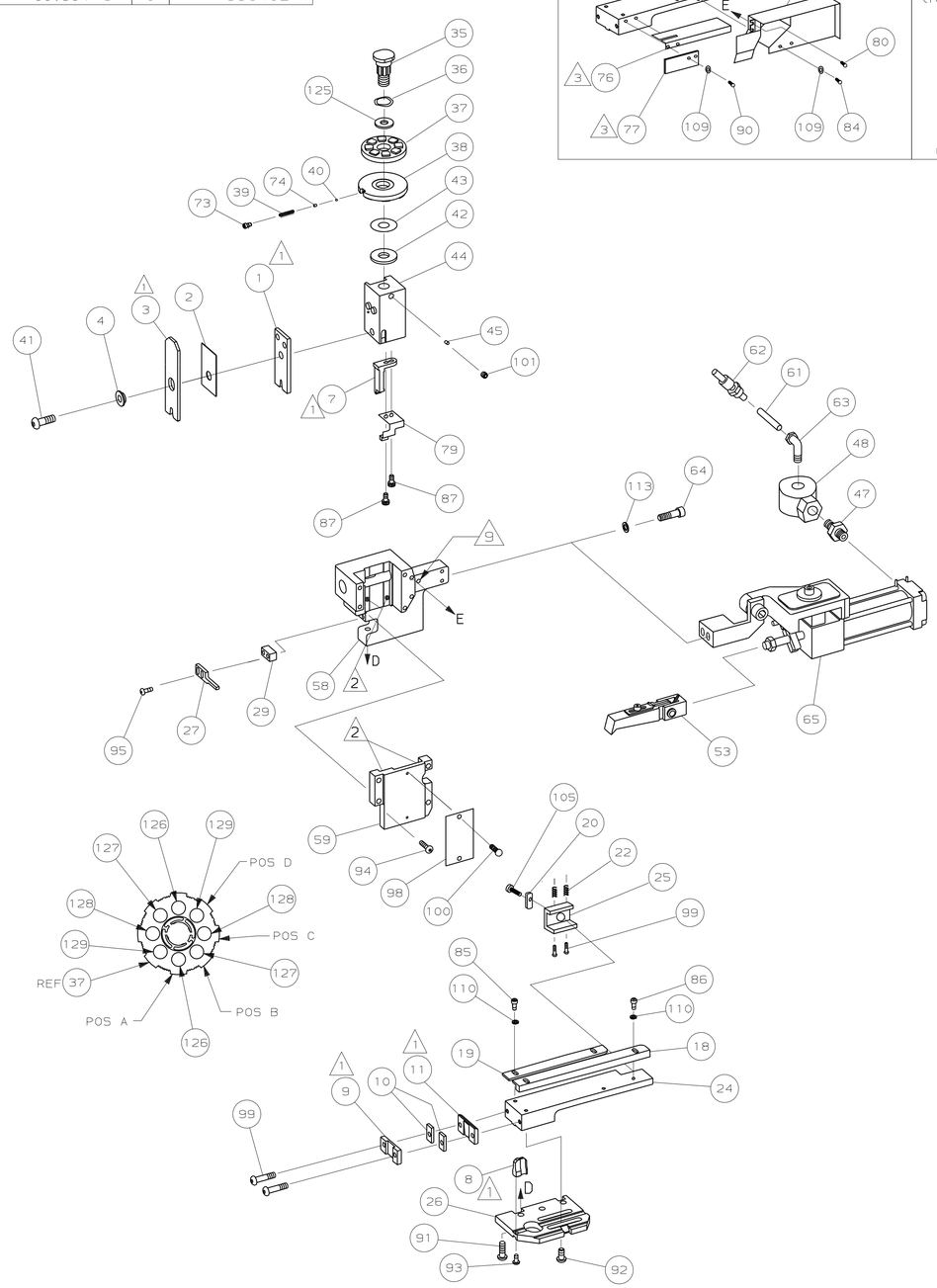
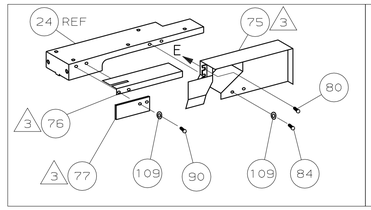
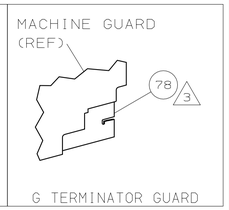
PART NUMBER	REV	FIRST USED
680364-3	G	356462-1







TERMINAL NAME: .187 AMPLIVAR FASTON™ FLAG RECEPT

–		63941

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.057 ±.002 [1.45 ±0.05mm]	2350 CMA (5)
B	.054 ±.002 [1.37 ±0.05mm]	1858 CMA (6)
C	.052 ±.002 [1.32 ±0.05mm]	1650 CMA (7)
D	.051 ±.002 [1.30 ±0.05mm]	1500 CMA (8)

CRIMP	SIZE	TYPE	RANGE
WIRE	.090 [2.29mm]	F	1200-2350 CMA
INSUL	.090 [2.29mm]	O	.020-.040

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
–	NONE	.570	408-8039	458638-1	L1810

-3	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	–	C	2-354779-8	PIN, WIRE DISC (.3130)D	129
2	–	C	2-354779-4	PIN, WIRE DISC (.3110)C	128
2	–	C	2-354779-0	PIN, WIRE DISC (.3090)B	127
2	–	C	1-354779-5	PIN, WIRE DISC (.3065)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
					120
					119
					118
					117
					116
					115
					114
2	–	A	21024-5	WASHER,LOCK(#10)AIR ASSY	113
					112
					111
5	–	A	21024-4	WASHER,LOCK(NO.6)ST GUIDE	110
4	–	A	21055-6	WASHER, FLAT(NO.8)GUARD	109
					108
					107
					106
1	–	A	22353-8	SCR,SHLD(ø.187x.25)DRAG LEVER	105
					104
					103
					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
4	–	A	3-21002-0	SCR,BHC(10-32x.88)DRAG	99
1	–	B	461264-1	PLATE, IDENTIFICATION	98
					97
					96
2	–	A	2-21002-2	SCR,BHC(8-32x.50)STRIPPER	95
4	–	A	2-21002-9	SCR,BHC(10-32x.75)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
3	–	A	2-22733-8	SCR,BHC(1/4-20x.62)HSG	91
2	–	A	2-21002-1	SCR,BHC(8-32x.38)GUARD	90
					89
					88
2	–	A	2-21000-7	SCR,SHC(8-32x.50)SLUG BLADE	87
3	–	A	1-21002-8	SCR,BHC(6-32x.50)STRIP GUIDE	86
2	–	A	1-21000-9	SCR,SHC(6-32x.38)STRIP GUIDE	85
2	–	A	2-21002-2	SCR,BHC(8-32x.50)GUARD	84
					83
					82
					81
2	–	A	2-21002-6	SCR,BHC(10-32x.38)GUARD MTG	80
1	–	A3	1320560-1	DEPRESSOR, TERMINAL	79
(3) REF	–	A	356467-3	INSERT, GUARD	78
(3) 1	–	A3	662435-1	GUARD, SIDE	77
(3) 1	–	A3	662434-1	GUARD, TERMINAL	76
(3) 1	–	A0	1320533-1	GUARD, AIR CYLINDER	75
1	–	A	690603-1	SPRING, ASSIST	74
1	–	A	23030-1	SCR,SKT CAP(6-32x.25)CP DSC	73
					72
					71

QTY REQD PER ASSY — PARTS LIST

-3	THRU MODEL G		AIR FEED		
					70
					69
					68
					67
					66
(4) 1	–	B	1-460277-8	AIR FEED ASSY (1 INCH)	65
2	–	A	4-21000-1	SCR,SHC(10-32x1.50)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
					60
1	–	C	454220-1	CAP, RAM	59
1	–	D	453736-1	HOUSING	58
					57
					56
					55
					54
(4) 1	–	B	2-460680-0	FEED FINGER ASSY	53
					52
					51
					50
					49
1	–	A	22374-7	VALVE, QUICK EXHAUST	48
1	–	A	22304-1	NIPPLE,HEX 1/8 NPT	47
					46
1	–	A	690191-1	PLUG, NYLON	45
1	–	C	679275-1	RAM	44
1	–	A	690125-1	WASHER, LAMINATED	43
1	–	A	690124-1	WASHER, RAM	42
1	–	A	7-21002-7	BOLT, CRIMPER(5/16-24x.75)	41
1	–	A	23241-6	BALL, STEEL	40
1	–	A	690170-1	SPRING, COMPRESSION	39
1	–	C	690142-5	DISC, INSULATION	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
					32
					31
					30
1	–	B	1-690451-4	SPACER, STRIPPER	29
					28
1	–	A	240639-4	STRIPPER	27
1	–	A3	662489-1	BASE PLATE, MODIFIED	26
1	–	A	240792-7	DRAG, TERMINAL	25
1	–	B	662383-1	PLATE, STRIP GUIDE	24
					23
2	–	A	1-22284-0	SPRING, DRAG	22
					21
1	–	A	240793-4	LEVER, DRAG RELEASE	20
1	–	C	662388-1	GUIDE, STRIP (REAR)	19
1	–	B	662387-1	GUIDE, STRIP (FRONT)	18
					17
					16
					15
					14
					13
					12
(1) 1	–	B	240644-5	PLATE, REAR SHEAR	11
2	–	C	1-240645-2	SPACER, SHEAR PLATE	10
(1) 1	–	B	318704-1	PLATE, FRONT SHEAR	9
(1) 1	–	D	2-456537-3	ANVIL	8
(1) 1	–	B	679272-2	BLADE, SLUG	7
					6
					5
1	–	B	238009-8	SPACER, BLOCK CRIMPER	4
(1) 1	–	C	5-456135-0	CRIMPER, INSULATION	3
1	–	B	2-455888-7	SPACER, CRIMPER	2
(1) 1	–	C	318702-3	CRIMPER, WIRE	1

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.

(5) SET-UP ONLY (1)#19 + (1)#20 MAGWIRE

(6) SET-UP ONLY (1)#20 + (1)#21 MAGWIRE

(7) SET-UP ONLY (1)#20 + (1)#22 MAGWIRE

(8) SET-UP ONLY (1)#21 + (1)#22 MAGWIRE

(9) PIN MUST BE REMOVED TO ALLOW FOR GUARD.

P	F	LTR	REVISION RECORD	APP	DATE
		G1	ECR-05-014606	GB	11-05
		G	0150-0476-03	TB	MAY03
		F	0150-0141-01	TE	2-01
		E	0150-9449-99	TB	7-99
		D	0150-9271-99	CE	4-99
		C	0150-7925-97	TB	7-97
		B	0150-7526-97	CE	2-97
		A	REVISED	CE	1-97

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 29AUG96 M. OBRINE | APP 8-29-96 T. ELBIN
CHK 8-29-96 C. ERISMAN | REL – –

AMP Incorporated, Harrisburg, PA 17105-3608

NAME END FEED HDM APPLICATOR | MACHINE REF MINI APPL
SCALE – | (D) DWG NO 680364 | SHEET 1 OF 1 | REV G1

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

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