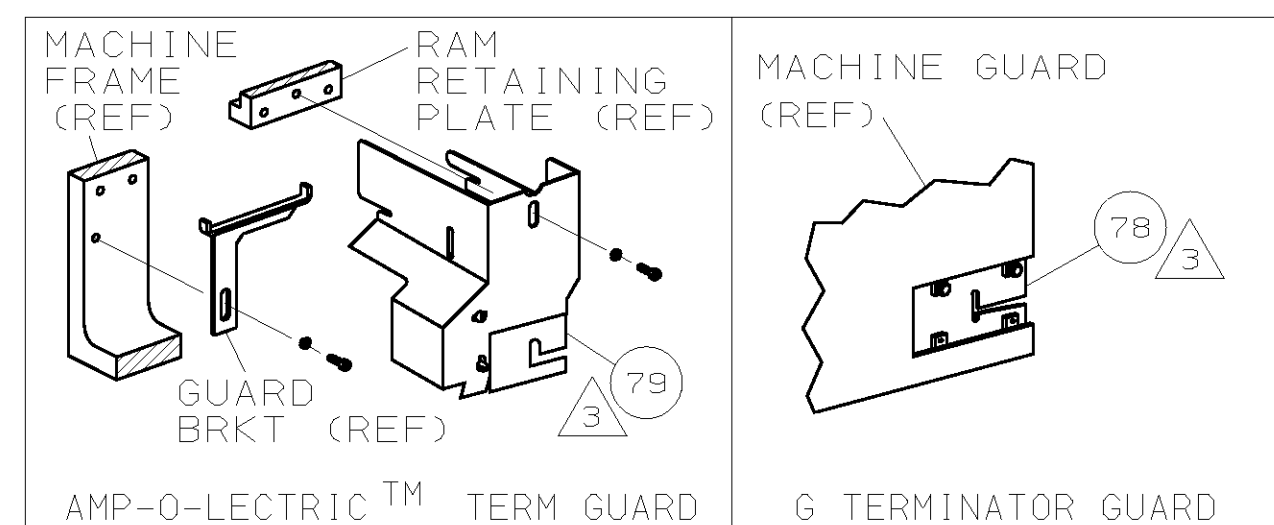


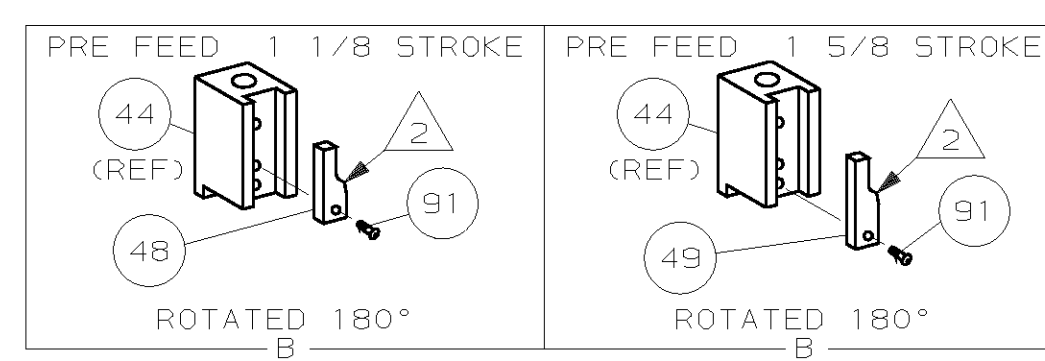
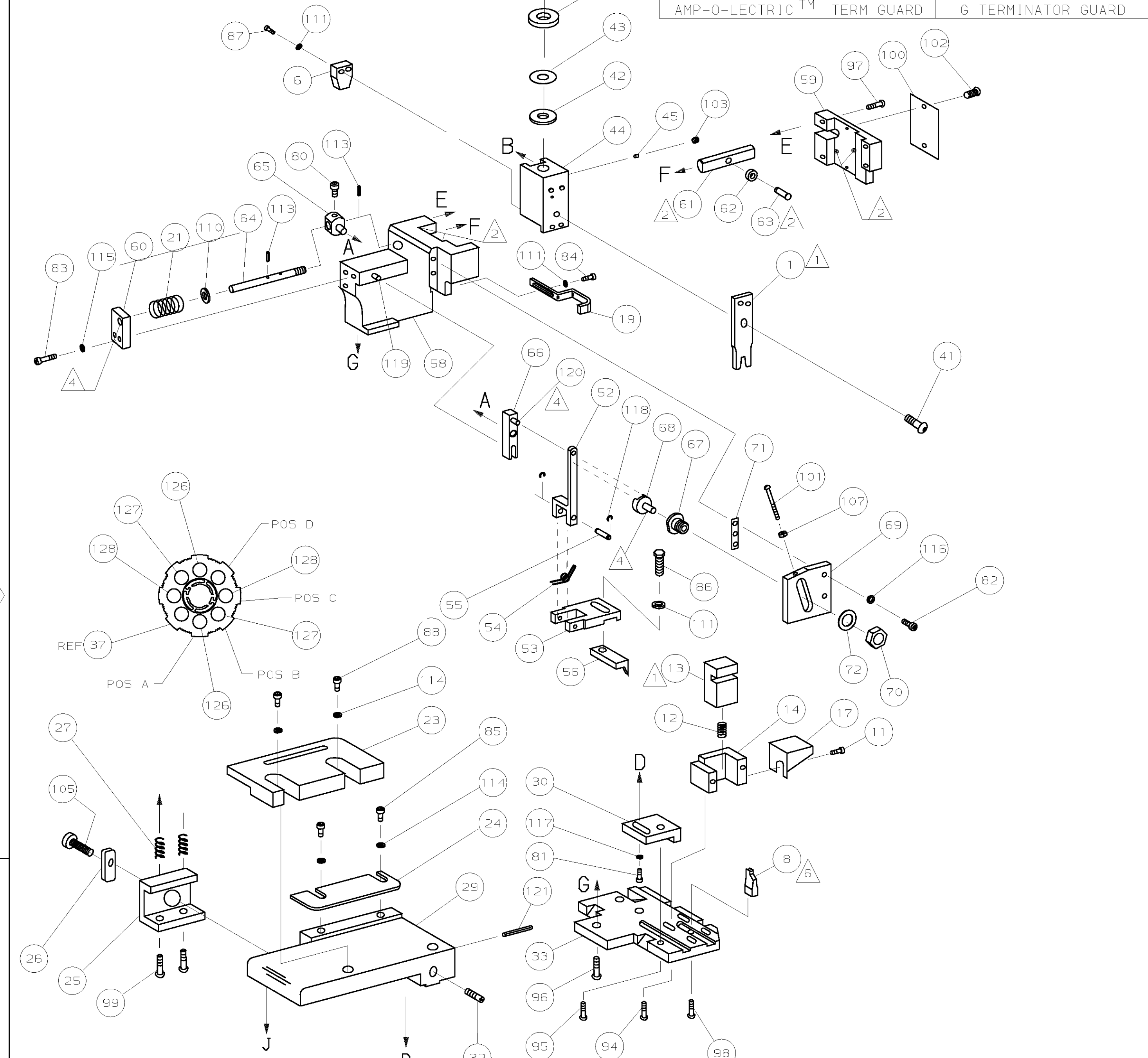
PART NUMBER	REV	FIRST USED
680721-2	C	565435-5
680721-3	C	354500-1



TERMINAL NAME: MINI AMPLIVAR™ SPLICE					
62194					
CRIMP DATA (AMP TERMINAL)					
PAD LTR	CRIMP HEIGHT		WIRE SIZE		
A	.052 ±.002 [1.32 ±0.05mm]		1200-1600 CMA		
B	.048 ±.002 [1.22 ±0.05mm]		800-1100 CMA		
C	.044 ±.002 [1.12 ±0.05mm]		300-700 CMA		
D	NOT USED		USED		
CRIMP	SIZE	TYPE	RANGE		
WIRE	.070 [1.78mm]	F	300-1600 CMA		
INSUL	-	-	-		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.119-.181	114-2006	.330	408-8040	458637-1	L1504

QTY	REF	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
1	1	-		22594-8	NUT, HEX (1/2-20)	70
1	1	-		240628-1	PLATE, ADJUSTMENT	69
1	1	-		240626-1	SHAFT, PIVOT	68
1	1	-		240633-1	BUSHING	67
1	1	-		455680-1	LEVER, INTERMEDIATE	66
1	1	-		240629-1	BLOCK, PIVOT	65
1	1	-		240632-2	SCREW, ADJ FEED ROD	64
1	1	-		240659-3	PIN, CAM ROLLER	63
1	1	-		240658-1	ROLLER, CAM	62
1	1	-		454398-2	ROD, FEED	61
1	1	-		454178-1	GUIDE, FEED ROD	60
1	1	-		454220-1	CAP, RAM	59
1	1	-		454485-1	HOUSING	58
						57
1	1	-		694433-8	PAWL, FEED	56
1	1	-		240624-1	PIN, FEED FINGER	55
1	1	-		691499-1	SPRING, FEED FINGER	54
1	1	-		690541-1	HOLDER, FEED FINGER	53
1	1	-		455679-1	LEVER, TERMINAL FEED ARM	52
						51
						50
1	-	-		690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	1	-		690602-5	CAM, PRE-FEED 1 1/8 ST	48
						47
						46
1	1	-		690191-1	PLUG, NYLON	45
1	1	-		455673-1	RAM	44
1	1	-		690125-1	WASHER, LAMINATED	43
1	1	-		690124-1	WASHER, RAM	42
1	1	-		7-21002-9	BOLT, CRIMPER (5/16x1.00)	41
						40
						39
1	1	-		690223-2	SPACER, INSULATION DISC	38
1	1	-		354777-1	WIRE DISC, PLASTIC	37
1	1	-		22480-5	WASHER, SPRING	36
1	1	-		690212-1	POST, RAM	35
						34
1	1	-		679254-1	PLATE, BASE	33
1	1	-		690432-3	SCREW, ADJUSTMENT	32
						31
REF	REF	-		816182-1	BLOCK, STRIP GUIDE ADJ	30
1	1	-		844048-4	PLATE, STRIP GUIDE	29
						28
2	2	-		1-22284-0	SPRING, DRAG	27
1	1	-		240793-1	LEVER, DRAG RELEASE	26
1	1	-		240792-1	DRAG, TERMINAL	25
1	1	-		690438-1	GUIDE, STRIP (REAR)	24
1	1	-		690487-6	GUIDE, STRIP (FRONT)	23
						22
1	1	-		4-22284-9	SPRING, FEED RETURN	21
						20
1	1	-		456468-5	STRIPPER	19
						18
1	1	-		691668-1	GUARD, CHIP (REAR)	17
						16
						15
1	1	-		690462-1	HOLDER, SHEAR (REAR)	14
1	1	-		690463-6	SHEAR, FLOAT (REAR)	13
1	1	-		5-22280-0	SPRING, SHEAR	12
1	1	-		690461-1	STOP, SHEAR	11
						10
						9
1	1	-		6-683403-6	ANVIL	8
						7
1	1	-		690468-1	DEPRESSOR, SHEAR (REAR)	6
						5
						4
						3
						2
1	1	-		2-456404-1	CRIMPER, WIRE	1

THIS DRAWING IS A CONTROLLED DOCUMENT.



- 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 46.
- 6 CUTTING EDGE OF ANVIL TO FACE REAR OF APPLICATOR.

QTY REQD PER ASSY	PARTS LIST	
2	2 - C 3-354779-4 PIN, WIRE DISC (.3160)C 129	
2	2 - C 2-354779-6 PIN, WIRE DISC (.3120)B 127	
2	2 - C 1-354779-8 PIN, WIRE DISC (.3080)A 126	
1	1 - A 986950-1 WASHER, FLAT PRECISION 125	
1	1 - A 217238-1 GENERAL INSTRUCTION PACKAGE 124	
1	1 - - 4088040 SF APPL INST 408-8040 123	
		122
1	1 - A 4-21028-0 PIN, SLT SPR (φ.093x.75) ST GDE PL 121	
1	1 - A 1-21030-1 PIN, DOWEL (φ.187x.50) LEVER 120	
1	1 - A 1-21030-6 PIN, DOWEL (φ.187x1.25) HOUSING 119	
2	2 - A 21045-3 RING, RET "C" (φ.187) FD FING PIN 118	
1	1 - A 21024-5 WASHER, LOCK (#10) ADJ BLOCK 117	
1	1 - A 21024-5 WASHER, LOCK (#10) ADJ PLATE 116	
1	1 - A 21024-5 WASHER, LOCK (#10) FEED GDE ROD 115	
2	2 - A 21024-2 WASHER, LOCK (#4) FRONT STP GUIDE 114	
2	2 - A 5-21028-1 PIN, SLT SPR (φ.125x.50) ADJ ROD 113	
		112
4	4 - A 21024-4 WASHER, LOCK (#8) STRIPPER 111	
1	1 - A 21899-4 WASHER, FLAT (φ5/16) SCREW ADJ 110	
		109
		108
1	1 - A 21068-5 NUT, HEX (6-32) FEED ADJ 107	
		106
1	1 - A 22353-8 SCR, SHLD (φ.187x.25) 105	
		104
1	1 - A 21009-2 SCR, SKT 5ET (1/4-20x.25 LW) RAM 103	
2	2 - A 21017-2 SCR, DRIVE (#2x.19) ID PLATE 102	
1	1 - A 6-23715-5 SCR, PAN HD (6-32x1.50) FEED ADJ 101	
1	1 - B 461264-1 PLATE, IDENTIFICATION 100	
2	2 - A 5-21006-6 SCR, SET, 10-32 X .75 99	
1	1 - A 22733-8 SCR, BHC (8-32x.38 LW) ANVIL 98	
2	2 - A 2-21002-9 SCR, BHC (10-32x.75) CAP 97	
3	3 - A 2-22733-8 SCR, BHC (1/4-20x.62) HOUSING 96	
1	1 - A 2-21002-7 SCR, BHC (10-32x.50) 56 ADJ BLOCK 95	
2	2 - A 2-21002-2 SCR, BHC (8-32x.50) TERM H DWN 94	
2	2 - A 1-21002-4 SCR, BHC (3-32x.25) R STP GDE 93	
		92
1	1 - A 1-21002-7 SCR, BHC (6-32x.38) CAM 91	
		90
		89
2	2 - A 1-21000-4 SCR, SHC (4-40x.38) F ST GUIDE 88	
2	2 - A 2-21000-8 SCR, SHC (8-32x.62) DEP-HOLD 87	
1	1 - A 2-22603-0 SCR, HEX HD (8-32x.31) FEED FINGER 86	
2	2 - A 1-21000-3 SCR, SHC (4-40x.25) R ST GUIDE 85	
1	1 - A 2-21000-7 SCR, SHC (8-32x.50) STRIPPER 84	
2	2 - A 3-21000-7 SCR, SHC (10-32x.75) FEED ROD GD 83	
2	2 - A 3-21000-6 SCR, SHC (10-32x.62) FD ADJ BLK 82	
1	1 - A 3-21000-4 SCR, SHC (10-32x.38) 56 ADJ BL 81	
1	1 - A 3-21000-4 SCR, SHC (10-32x.38) PIVOT BLK 80	
-	REF - B 455749-1 GUARD, WINDOW 79	
REF	- B 679532-1 INSERT, GUARD 78	
		77
		76
		75
		74
		73
1	1 - A 458109-1 WASHER, SPECIAL 72	
1	1 - A 690517-1 SPACER 71	

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LOC A  
DIST 66

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

QTY REQD PER ASSY	PARTS LIST
	DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ± 3 PLC DEC ± 4 PLC DEC ±
	DR W.HOOVER CHK 09SEP98 C.ERISMAN
	APP 09SEP98 T.ELBIN
	REL -
	NAME SIDE FEED HDM APPLICATOR
	MACHINE REF MINI APPL
	SCALE - DWG NO 680721 SHEET 1 OF 1 REV C

AMP Incorporated Harrisburg, PA 17105-3608

REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

CASE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING