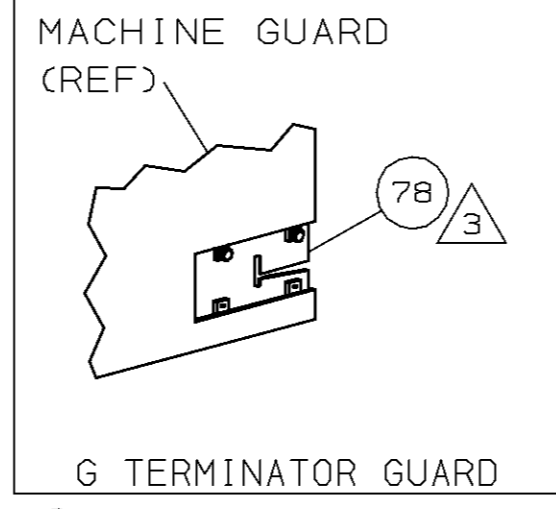
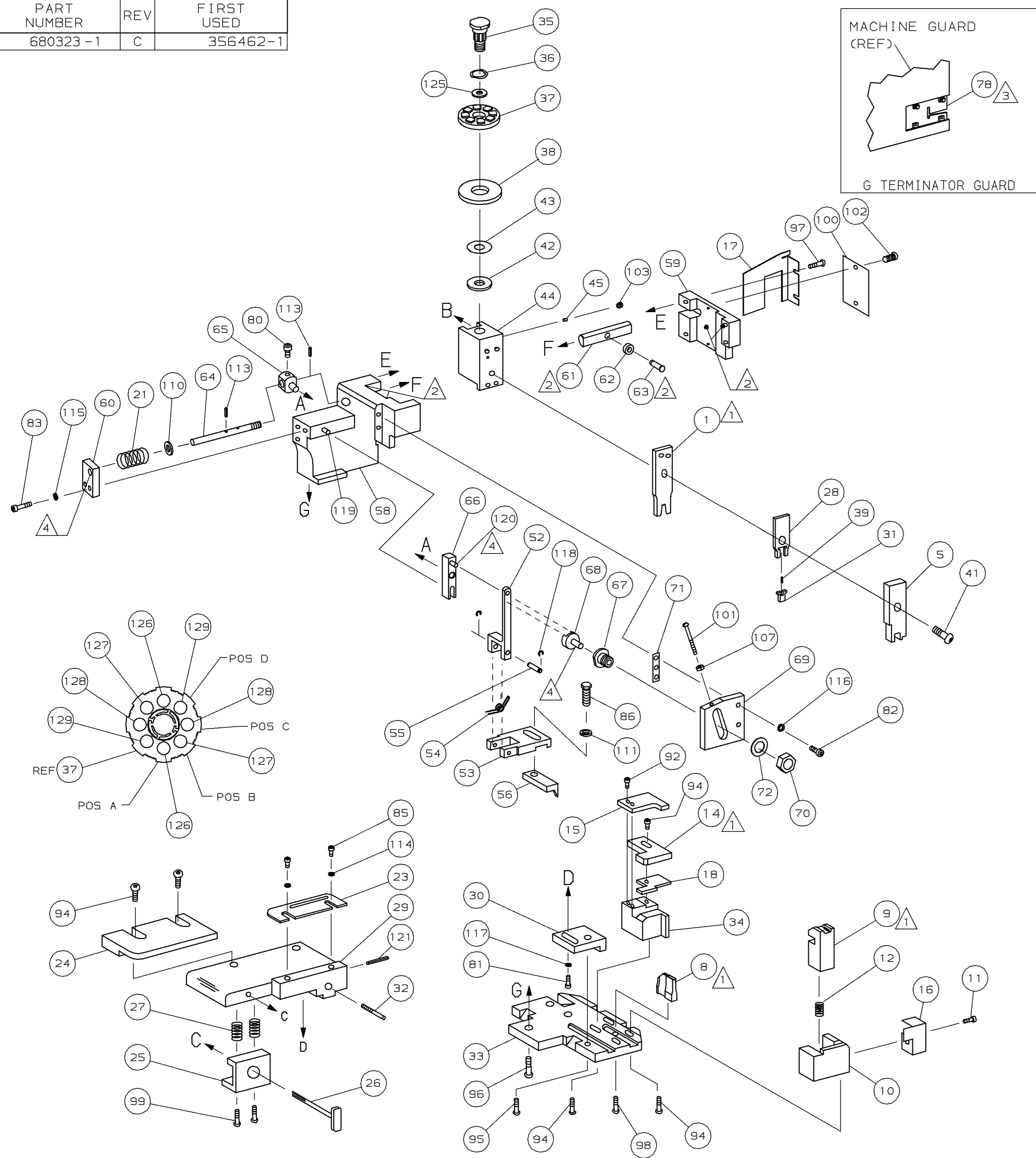


PART NUMBER	REV	FIRST USED
680323-1	C	356462-1

THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INCORPORATED. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

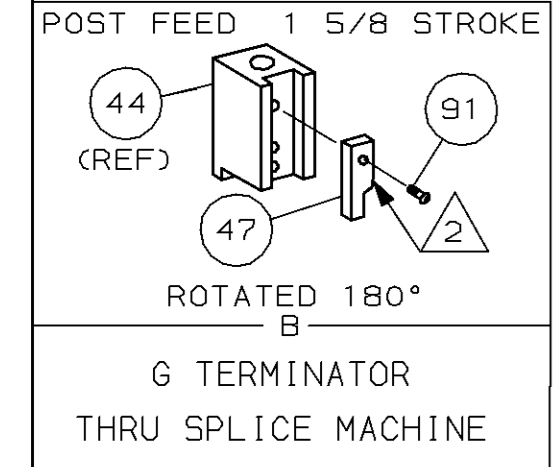
THIS INFORMATION IS CONFIDENTIAL AND IS DISCLOSED TO YOU ON CONDITION THAT NO FURTHER DISCLOSURE IS MADE BY YOU TO OTHER THAN AMP PERSONNEL WITHOUT WRITTEN AUTHORIZATION FROM AMP INCORPORATED, HARRISBURG, PA.



TERMINAL NAME: .125 BLADE, AMPLIVAR™ CONTACT		CRIMPING DATA	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.039 ± .002 [0.99 ± 0.05mm]	1100-1600 CMA	
B	.034 ± .002 [0.86 ± 0.05mm]	400-1000 CMA	
C	NOT	USED	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.090 [2.29mm]	F	400-1600 CMA
INSUL	-	-	-
WIRE STRIP LENGTH	TERM APPL SPEC PRELIMINARY	FEED .500	APPL INSTRUCTION 408-8040
			SET UP GAGE 458637-1
			LAYOUT L1672

QTY REQD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-	-	-	-	-	129
-	-	-	-	-	128
2	-	C	6-354779-5	PIN, WIRE DISC (.3315)B	127
2	-	C	5-354779-2	PIN, WIRE DISC (.3250)A	126
1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	-	-	4088040	SF APPL INST 408-8040	123
					122
1	-	A	4-21028-0	PIN, SLT SPR (Ø.093x.75)ST GDE PL	121
1	-	A	1-21030-1	PIN, DOWEL (Ø.187x.50) LEVER	120
1	-	A	1-21030-6	PIN, DOWEL (Ø.187x1.25) HOUSING	119
2	-	A	21045-3	RING, RET "C" (Ø.187) FD FING PIN	118
1	-	A	21024-5	WASHER, LOCK (#10) ADJ BLOCK	117
2	-	A	21024-5	WASHER, LOCK (#10) ADJ PLATE	116
2	-	A	21024-5	WASHER, LOCK (#10) FEED GDE ROD	115
2	-	A	21024-2	WASHER, LOCK (#4) FRONT STP GUIDE	114
2	-	A	5-21028-1	PIN, SLT SPR (Ø.125x.50) ADJ ROD	113
					112
1	-	A	21024-4	WASHER, LOCK (#8) STRIPPER	111
1	-	A	21899-4	WASHER, FLAT (Ø5/16) SCREW ADJ	110
					109
1	-	A	21018-5	NUT, HEX (NO. 6) HOLDDOWN	108
1	-	A	21018-5	NUT, HEX (6-32) FEED ADJ	107
					106
					105
1	-	A	992031-1	PIN, CLEVIS	104
1	-	A	21009-2	SCR, SKT SET (1/4-20x.25 LW) RAM	103
2	-	A	21017-2	SCR, DRIVE (#2x.19) ID PLATE	102
1	-	A	6-23715-5	SCR, PAN HD (6-32x1.50) FEED ADJ	101
1	-	B	461264-1	PLATE, IDENTIFICATION	100
2	-	A	3-21002-0	SCR, BHC (10-32x.88) DRAG	99
1	-	A	22733-8	SCR, BHC (8-32x.38 LW) ANVIL	98
4	-	A	2-21002-9	SCR, BHC (10-32x.75) CAP	97
3	-	A	2-22733-8	SCR, BHC (1/4-20x.62) HOUSING	96
1	-	A	2-21002-7	SCR, BHC (10-32x.50) SG ADJ BLOCK	95
7	-	A	2-21002-2	SCR, BHC (8-32x.50) TERM H DWN	94
					93
2	-	A	1-21002-9	SCR, BHC (6-32x.62) COVER	92
1	-	A	1-21002-7	SCR, BHC (6-32x.38) CAM	91
					90
1	-	A	7-21000-9	SCR, SHC (4-40x.19) STRIPPER	89
					88
					87
1	-	A	2-22603-0	SCR, HEX HD (8-32x.31) FEED FINGER	86
2	-	A	1-21000-3	SCR, SHC (4-40x.25) F ST GUIDE	85
					84
2	-	A	3-21000-7	SCR, SHC (10-32x.75) FEED ROD GD	83
2	-	A	3-21000-6	SCR, SHC (10-32x.62) FD ADJ BLK	82
1	-	A	3-21000-4	SCR, SHC (10-32x.38) SG ADJ BL	81
1	-	A	3-21000-4	SCR, SHC (10-32x.38) PIVOT BLK	80
					79
REF	-	C	356467-1	GUARD	78
					77
					76
					75
					74
					73
1	-	A	458109-1	WASHER, SPECIAL	72
1	-	A	690517-1	SPACER	71
-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
1	-	B	22594-8	NUT, HEX (1/2-20)	70
1	-	B	240628-1	PLATE, ADJUSTMENT	69
1	-	B	240626-1	SHAFT, PIVOT	68
1	-	B	240633-1	BUSHING	67
1	-	A	455680-1	LEVER, INTERMEDIATE	66
1	-	B	240629-1	BLOCK, PIVOT	65
1	-	A	240632-2	SCREW, ADJ FEED ROD	64
1	-	B	240659-3	PIN, CAM ROLLER	63
1	-	B	240658-1	ROLLER, CAM	62
1	-	B	454398-2	ROD, FEED	61
1	-	A	454178-1	GUIDE, FEED ROD	60
1	-	C	454220-1	CAP, RAM	59
1	-	D	454485-1	HOUSING	58
					57
1	-	B	690542-2	PAWL, FEED	56
1	-	B	240624-1	PIN, FEED FINGER	55
1	-	B	691499-1	SPRING, FEED FINGER	54
1	-	B	690541-1	HOLDER, FEED FINGER	53
1	-	A	455679-1	LEVER, TERMINAL FEED ARM	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	455673-1	RAM	44
1	-	A	690125-1	WASHER, LAMINATED	43
1	-	A	690124-1	WASHER, RAM	42
1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)	41
					40
1	-	A	1-23147-2	SPRING, COMPRESSION	39
1	-	A	690223-2	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
1	-	B	356469-1	SUPPORT, SHEAR	34
1	-	B	356600-1	PLATE, BASE MODIFIED	33
1	-	A	690432-3	SCREW, ADJUSTMENT	32
1	-	A3	356735-1	DEPRESSOR, WIRE	31
1	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	-	C	455671-1	PLATE, STRIP GUIDE	29
1	-	A3	356734-1	GUIDE, DEPRESSOR	28
2	-	A	1-22284-0	SPRING, DRAG	27
1	-	B	690546-1	LEVER, DRAG RELEASE	26
1	-	B	240792-1	DRAG, TERMINAL	25
1	-	D	6-690504-3	GUIDE, STRIP (REAR)	24
1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
					22
1	-	A	4-22284-9	SPRING, FEED RETURN	21
					20
					19
1	-	B	318714-1	HOLD DOWN	18
1	-	C	356598-1	GUARD	17
1	-	B	318563-1	GUARD, CHIP, FRONT	16
1	-	B	356468-1	COVER	15
1	-	B	356461-1	SHEAR PLATE, WIRE	14
					13
1	-	A	5-22280-0	SPRING, SHEAR	12
1	-	B	690461-1	STOP, SHEAR	11
1	-	C	690459-1	HOLDER, SHEAR (FRONT)	10
1	-	C	1-454276-7	SHEAR, FLOAT (FRONT)	9
1	-	C	1-805840-1	ANVIL	8
					7
					6
1	-	C	2-455889-8	DEPRESSOR, SHEAR (FRONT)	5
					4
					3
					2
1	-	C	318542-6	CRIMPER, WIRE	1
-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO



- 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 WITH WIRE TRIM FEATURE.
- 6 SET-UP ONLY.

LOC A	DIST 66
-------	---------

REVISION RECORD

REV	DATE	DESCRIPTION
C	0150-7406-96	TB 11-96
B	0150-7137-96	CE 8-96
A	REVISED	CE 7-96

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

AMP Incorporated Harrisburg, PA 17105-3608

NAME: SIDE FEED HDM APPLICATOR MACHINE REF: MINI APPL

SCALE: 1 OF 1 SHEET REV: C

DWG NO: 680323