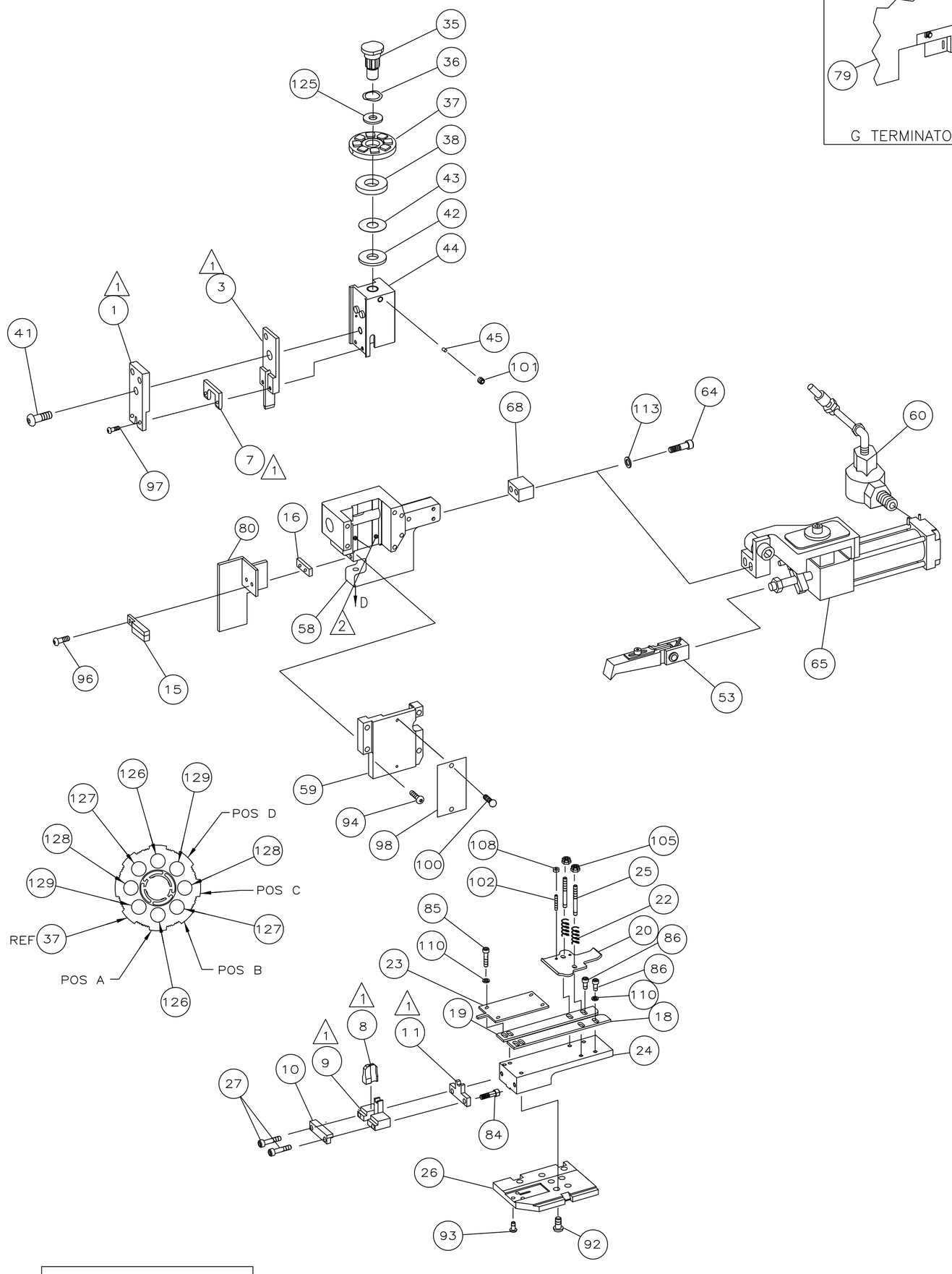
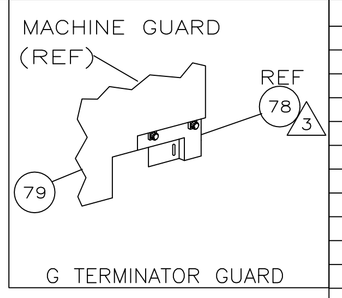
DRAWING MADE IN THIRD ANGLE PROJECTION

/home/us016926/DMTECmod

680186 ⇔ 680186

PART NUMBER	REV	FIRST USED
680186 −3	D	354500−1





TERMINAL NAME: AMPLIVAR™ SPLICE 7 SERRATIONS △6

62002

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	CMA
A	.103 ±.002 [2.97 ±0.05mm]	11,600−13,000
B	.099 ±.002 [2.84 ±0.05mm]	10,200−11,4000
C	.095 ±.002 [2.72 ±0.05mm]	8600−10,000
D	.091 ±.002 [2.59 ±0.05mm]	7000−8400

CRIMP	SIZE	TYPE	RANGE
WIRE	.220 [5.59mm]	F	7000−13,000 CMA
INSUL	−	−	−

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INST	SET UP GAGE	LAYOUT
−	114−2002	.315	408−8039	−	L1631Q

SET_UP WIRE

A	1(12)+ 1(13)
B	2(13)
C	1(12)+ 1(16)
D	2(14)

−3 BENCH MODEL G AIRFEED

	−3	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
	2	−	C	7−354778−7	PIN, WIRE DISC (.2880)D	129
	2	−	C	6−354778−9	PIN, WIRE DISC (.2840)C	128
	2	−	C	6−354778−1	PIN, WIRE DISC (.2800)B	127
	2	−	C	5−354778−6	PIN, WIRE DISC (.2775)A	126
	1	−	A	986950−1	WASHER, FLAT PRECISION	125
						124
						123
						122
						121
						120
						119
						118
						117
						116
						115
						114
	2	−	A	21024−5	WASHER,LOCK(NO.10)	113
						112
						111
	6	−	A	21024−4	WASHER,LOCK(NO.8)SHEAR BL	110
						109
	2	−	A	21018−4	NUT,HEX(4−40)DRAG	108
						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	1−21002−3	SCR,BHC(4−40x.25)ID PLATE	100
						99
	1	−	B	464249−1	PLATE, IDENTIFICATION	98
	2	−	A	2−21002−8	SCR,BHC(10−32x.63)	97
	2	−	A	3−21000−2	SCR,SHC(8−32x1.25)GUARD	96
						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	3−21002−4	SCR,BHC(1/4−20x.62)ST GD PL	92
						91
						90
						89
						88
						87
	2	−	A	2−21000−6	SCR,SHC(8−32x.38)STRIP GUIDE	86
	4	−	A	2−21000−7	SCR,SHC(8−32x.50)R STRIP GUIDE	85
	2	−	A	1−21002−6	SCR,BHC(6−32x.25)R STRIP GUIDE	84
						83
						82
						81
△3	1	−	C	224383−1	GUARD,SIDE	80
△3	1	−	C	224388−1	GUARD ASSY	79
△3	REF	−	A	224322−1	INSERT, GUARD	78
						77
						76
						75
						74
						73
						72
						71

QTY REQD PER ASSY — PARTS LIST

	−3	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
						70
						69
	1	−	A	461690−1	SPACER, AIR FEED	68
						67
						66
△4	1	−	B	460277−1	AIR FEED ASSY	65
	2	−	A	4−21000−3	SCR,SHC 10−32x2.00 AIR ASSY	64
						63
						62
						61
	1	−	B	692655−7	AIR FEED VALVE ASSEMBLY	60
	1	−	A	462926−1	CAP, RAM	59
	1	−	D	453736−1	HOUSING	58
△1	1	−	A	7−21013−3	SCR,SET(5/16−24x.38)CR BOLT	57
						56
						55
						54
△4	1	−	B	460680−7	FEED FINGER ASSY	53
						52
						51
	1	−	−	318848−1	AIR BLAST ASSEMBLY	50
						49
						48
						47
						46
	1	−	A	690191−1	PLUG, NYLON	45
	1	−	D	459586−1	RAM	44
	1	−	A	690125−1	WASHER, LAMINATED	43
	1	−	A	690124−4	WASHER, RAM	42
	1	−	A	7−21002−9	BOLT, CRIMPER(5/16−24x1.00)	41
						40
						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
						34
						33
						32
						31
						30
						29
						28
	2	−	B	1−21000−9	SCREW	27
	1	−	A	224371−1	PLATE, BASE	26
	2	−	A	22354−7	DRAG, STUD	25
	1	−	B	462931−1	PLATE, STRIP GUIDE	24
	1	−	C	462932−4	PLATE, STRIP COVER	23
	2	−	A	3−22281−8	SPRING, DRAG	22
						21
	1	−	A	462925−1	DRAG, STOCK	20
	1	−	B	462929−2	GUIDE, STRIP (REAR)	19
	1	−	C	462930−2	GUIDE, STRIP (FRONT)	18
						17
	1	−	B	2−690451−5	SPACER, STRIPPER	16
	1	−	B	1633729−1	STRIPPER ASSEMBLY	15
						14
						13
						12
△1	1	−	B	459684−2	PLATE, GUIDE RETAINING	11
	1	−	B	459580−1	SHERA PLATE,SPACER	10
△1	1	−	B	1−458583−9	HOLDER, ANVIL	9
△1	1	−	D	1−459582−1	ANVIL	8
△1	1	−	B	459581−2	BLADE, SLUG	7
						6
						5
						4
	1	−	B	318158−1	GUIDE, CRIMPER	3
						2
△1	1	−	C	1−459585−2	CRIMPER, WIRE	1

QTY REQD PER ASSY — PARTS LIST — REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

△1 RECOMMENDED SPARE PARTS.

△2 GREASE LIGHTLY.

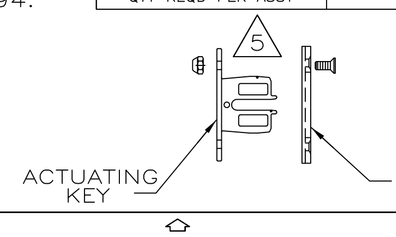
△3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.

△4 SEE DRAWING FOR COMPONENTS

△5 REMOVE ACTUATING KEY AND BLACK COVER PLATE FROM EXISTING G TERMINATING GUARD AND INSTALL ON ITEM 79

△6 LUBRICATOR REQUIRED WITH AMPLIVAR SPLICE TERMINAL

△7 INSTALL ITEM 50 TO ITEM 59 USING ITEM 94.



P	F	LTR	REVISION RECORD	APP	DATE
		D	ECR−15−015629	YY	10−15
		C	ECR−08−029663	DM	11−08
		B1	ECN 0150−0504−03	TE	5−03
		B	ECN 0150−0525−01	TE	5−01
		A2	0150−8428−98	TB	4−98
		A1	0150−8147−97	TB	12−97
		A	REVISED	CE	1−96

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 R O WILSON 7−7−95 APP A BEDDICK 7−11−95
CHK C ERISMAN 7−10−95 REL B. MORGAN 12/3/97

TE Connectivity Harrisburg, PA 17105−3608

NAME END FEED HDM APPLICATOR MACHINE REF MINI APPL

SCALE − D DWG NO 680186 SHEET 1 OF 1 REV D

CAGE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO

LOC A DIST 66

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