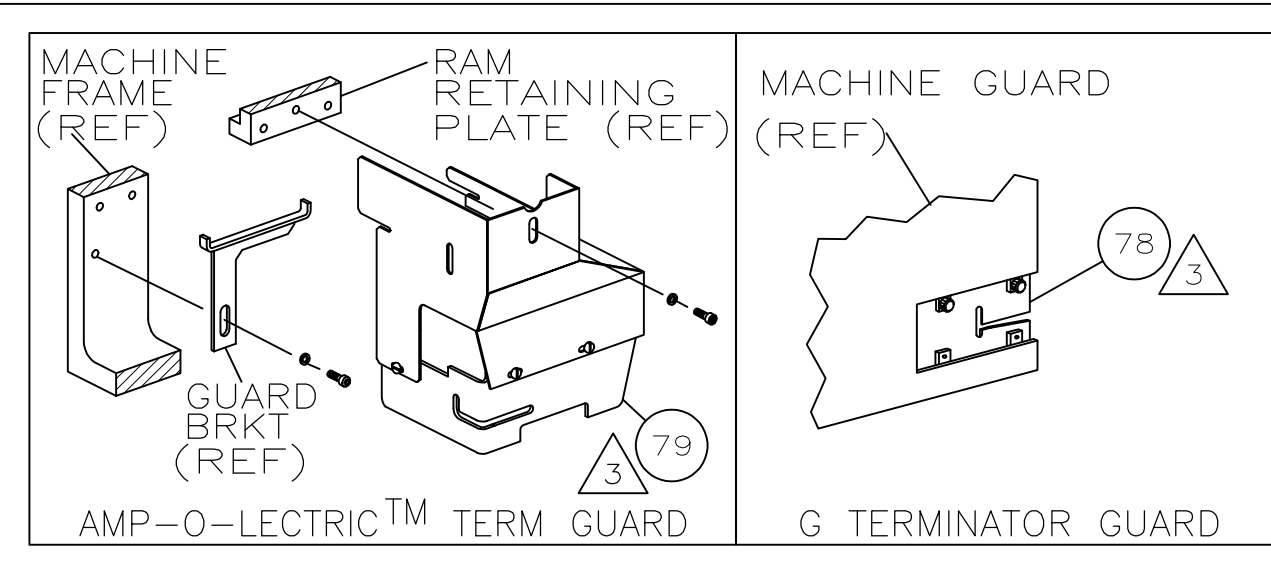


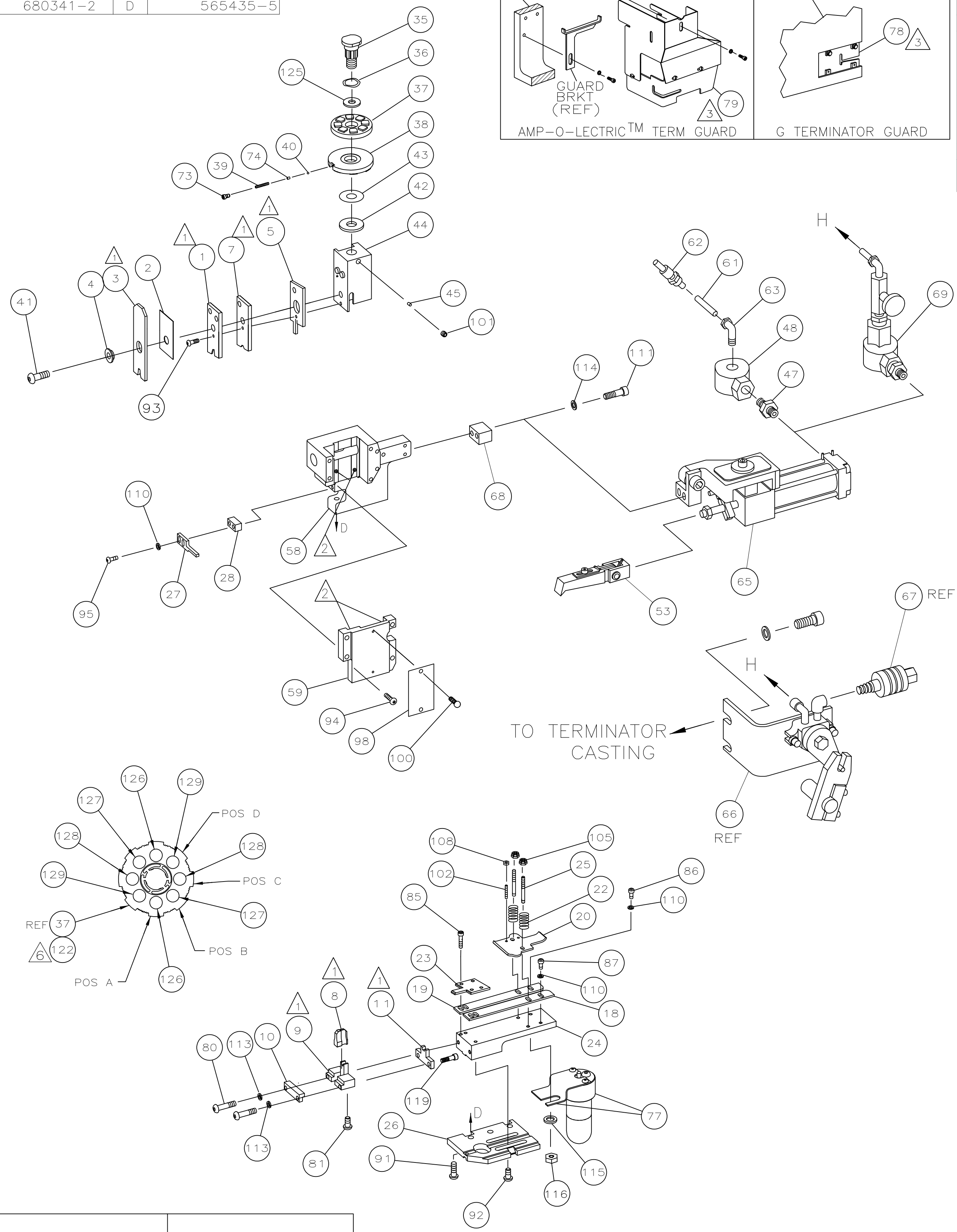
THIS DRAWING IS A CONTROLLED DOCUMENT.

PART NUMBER	REV	FIRST USED
680341-1	D	354500-1
680341-2	D	565435-5



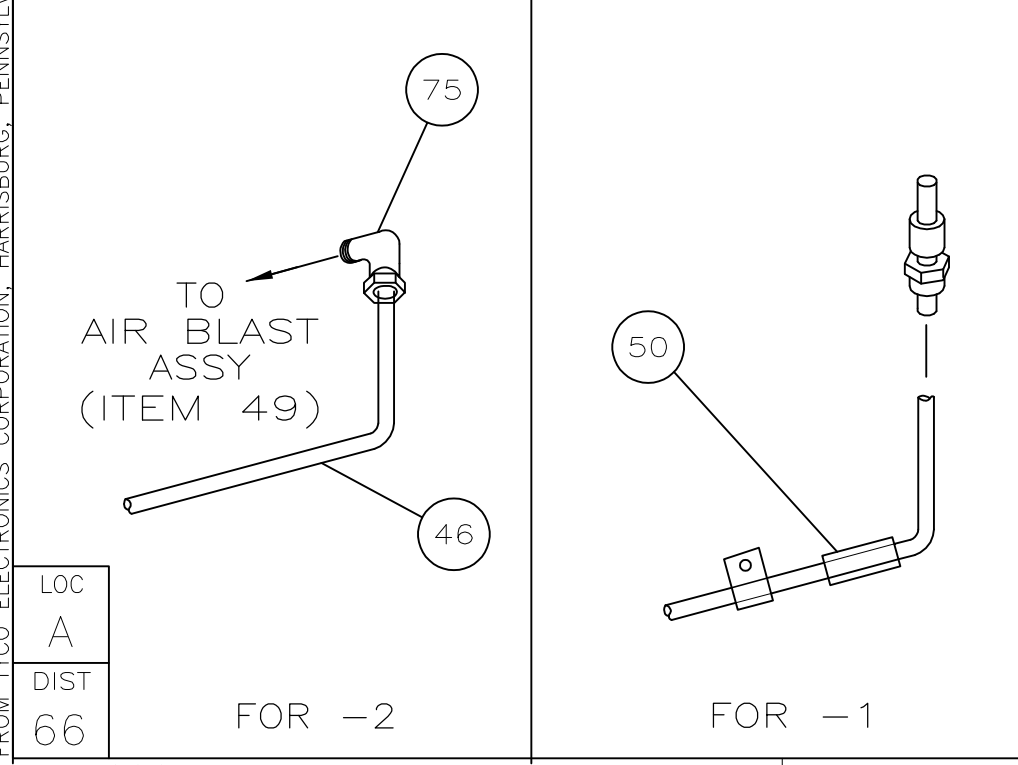
TERMINAL NAME: AMPLIVAR™ SPLICE WITH INSULATION SUPPORT					
141175					
CRIMPING DATA					
PAD LTR	CRIMP HEIGHT		WIRE SIZE		
A	.046 ±.002 [1.18 ±0.05mm]		(2)0.5mm		
B	.045 ±.002 [1.15 ±0.05mm]		(2)0.45mm		
C	.043 ±.002 [1.09 ±0.05mm]		0.5mm		
D	.042 ±.002 [1.08 ±0.05mm]		0.45mm		
CRIMP	SIZE	TYPE	RANGE		
WIRE	.080 [2.03mm]	F	0.45mm-0.71mm		
INSUL	.130 [3.30mm]	F	Ø2.54mm-3.81mm		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
-	114-2008	.395	408-8039	458638-1	L1679A

-1	BENCH MODEL G	AIR FEED
-2	BENCH MODEL K	AIR FEED



2	2	-	3-354779-8	PIN, WIRE DISC (.3180)D	129
2	2	-	3-354779-6	PIN, WIRE DISC (.3170)C	128
2	2	-	3-354779-2	PIN, WIRE DISC (.3150)B	127
2	2	-	3-354779-0	PIN, WIRE DISC (.3140)A	126
1	1	-	986950-1	WASHER, FLAT PRECISION	125
1	1	-	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	-	4088039	EF APPL INST 408-8039	123
1	1	-	1-679600-4	PLASTIC WIRE DISC ASSY	122
					121
					120
2	2	-	1-21002-6	SCR,BHC(6-32x.25)PLATE STR GUI	119
					118
					117
1	1	-	21018-6	NUT,HEX (8-32)LUBE	116
1	1	-	21055-6	WASHER, FLAT #8 LUBE	115
2	2	-	22260-7	WASHER, FLAT #10	114
2	2	-	21024-3	WASHER,LOCK(#6)SHEAR PL	113
					112
2	2	-	4-21000-3	SCR,SHC(10-32x2.00)AIR FEED BRKT	111
4	4	-	21024-4	WASHER,LOCK(NO.8)SHEAR BL	110
					109
2	2	-	21018-4	NUT,HEX(4-40)DRAG	108
					107
					106
2	2	-	21022-2	NUT,HEX SL(8-32)DRAG STUD	105
					104
					103
2	2	-	2-21006-6	SCR,SKT SET(4-40x.62)DRAG	102
1	1	-	21009-2	SCR,SKT SET(1/4-20x.25)RAM	101
2	2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE	100
					99
1	1	-	464249-1	PLATE, IDENTIFICATION	98
					97
					96
2	2	-	3-21000-2	SCR,SHC(8-32x1.25)STRIPPER	95
4	4	-	2-21002-9	SCR,BHC(10-32x.75)CAP	94
1	1	-	2-21002-6	SCR,BHC(10-32x.38)SLUG BL	93
4	4	-	3-21002-5	SCR,BHC(1/4-20x.75)ST GD PL	92
3	3	-	2-22733-8	SCR,BHC(1/4-20x.62)HSG	91
					90
					89
					88
1	1	-	2-21000-9	SCR,SHC(8-32x.75)LUBE	87
1	1	-	2-21000-6	SCR,SHC(8-32x.38)STRIP GUIDE	86
4	4	-	2-21002-2	SCR,BHC(8-32x.50)R STRIP GUIDE	85
					84
					83
					82
2	2	-	2-21002-6	SCR,BHC(10-32x.38)BODY ANVIL	81
2	2	-	1-21000-9	SCR,SHC(6-32x.38)SHEAR PL	80
1	-	-	460980-2	GUARD ASSY	79
-	REF	-	679532-1	INSERT, GUARD	78
1	-	-	1-465184-7	LUBRICATOR ASSY	77
1	-	-	454406-1	SPACER, LUB BRACKET	76
1	-	-	22317-3	ELBOW, COPPER TUBE	75
1	1	-	690603-1	SPRING, ASSIST	74
1	1	-	23030-1	SCR,SKT CAP(6-32x.25)CP DSC	73
					72
					71
-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY					

4	1	-	-	692655-5	AIR FEED VALVE ASSY	70
	1	1	-	461690-1	SPACER, AIR FEED	69
	REF	-	-	24042-2	VALVE, SHUT OFF	67
4	REF	-	-	692655-6	AIR FEED VALVE ASSY	66
	1	1	-	2-460277-5	AIR FEED ASSY (1 INCH)	65
	2	2	-	4-21000-3	SCR,SHC(10-32x1.00)AIR ASSY	64
	-	1	-	983427-6	ELBOW, SWIVEL 1/8 NPT - 1/4 T	63
	-	1	-	23238-1	QUICK DISCONNECT	62
	12.00	12.00	IN	27319-4	TUBING, POLY-FLO Ø.25	61
						60
	1	1	-	462926-1	CAP, RAM	59
	1	1	-	453736-1	HOUSING	58
						57
						56
						55
						54
4	1	1	-	460680-7	FEED FINGER ASSY	53
						52
						51
	-	1	-	318848-1	AIR BLAST ASSEMBLY	50
	1	-	-	455350-1	AIR BLAST ASSEMBLY	49
	-	1	-	22374-7	VALVE, QUICK EXHAUST	48
	-	1	-	22304-1	NIPPLE,HEX 1/8 NPT	47
	1	-	-	689446-2	TUBE, AIR BLAST	46
	1	1	-	690191-1	PLUG, NYLON	45
	1	1	-	662559-1	RAM	44
	1	1	-	690125-1	WASHER, LAMINATED	43
	1	1	-	690124-4	WASHER, RAM	42
	1	1	-	7-21002-9	BOLT, CRIMPER(5/16-24x1.00)	41
	1	1	-	23241-6	BALL, STEEL	40
	1	1	-	690170-1	SPRING, COMPRESSION	39
	1	1	-	690142-1	DISC, INSULATION	38
	1	1	-	354777-1	WIRE DISC, PLASTIC	37
	1	1	-	22480-5	WASHER, SPRING	36
	1	1	-	690212-1	POST, RAM	35
						34
						33
						32
						31
						30
						29
	1	1	-	1-690451-6	SPACER, STRIPPER	28
	1	1	-	460276-1	STRIPPER	27
	1	1	-	459584-1	PLATE, BASE	26
	2	2	-	22354-8	DRAG, STUD	25
	1	1	-	462931-2	PLATE, STRIP GUIDE	24
	1	1	-	462932-7	PLATE, STRIP GOVER	23
	2	2	-	4-22281-1	SPRING, DRAG	22
						21
	1	1	-	462925-1	DRAG, STOCK	20
	1	1	-	462929-1	GUIDE, STRIP (REAR)	19
	1	1	-	462930-1	GUIDE, STRIP (FRONT)	18
						17
						16
						15
						14
						13
						12
1	1	1	-	459684-7	PLATE, GUIDE RETAINER	11
1	1	1	-	459580-2	PLATE, ANVIL RETAINER	10
1	1	1	-	1-459583-0	BODY, ANVIL	9
1	1	1	-	318573-3	ANVIL	8
1	1	1	-	662603-1	BLADE, SLUG	7
						6
	1	1	-	662601-1	CRIMPER GUIDE	5
	1	1	-	238009-1	SPACER, BLOCK CRIMPER	4
1	1	1	-	6-1424909-8	CRIMPER, INSULATION	3
1	1	1	-	455888-5	SPACER, CRIMPER	2
1	1	1	-	662602-1	CRIMPER, WIRE	1
-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO	
QTY REQD PER ASSY						



- 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 ITEM 78 USED WITH G TREMINATOR ONLY.
- 6 REPLACE ITEM 37 WITH ITEM 122 TO USE THE FOLLOWING WIRE SIZES:

CRIMPING DATA		
PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.048 ±.002 [1.22 ±0.05mm]	0.8mm or (2)0.56mm
B	.046 ±.002 [1.18 ±0.05mm]	0.71mm
C	.044 ±.002 [1.12 ±0.05mm]	0.56mm
D	NOT	USED

D	ECR-09-024527	11-2009	MY	GB
P	LTR	REVISION RECORD	DATE	DWN

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
INCHES	0 PLC ± .	1 PLC ± .	2 PLC ± .25
ANGLES	3 PLC ± .	4 PLC ± .	
SURFACE TEXTURE	√		

DWN	M. OBRINE	30JUL96	MATERIAL	-	HEAT TREAT	-
CHK	C. ERISMAN	7-30-96				
APVD	T. ELBIN	7-30-96				
NAME						
END FEED HDM APPLICATOR						
SCALE	SIZE	DRAWING NO	SHEET	OF	REV	
-	A1	680341	1	of	1	D

CUSTOMER ACCESSIBLE PRODUCTION DRAWING