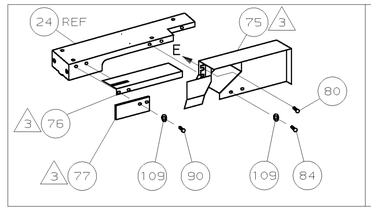
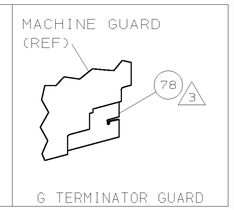
DRAWING MADE IN THIRD ANGLE PROJECTION

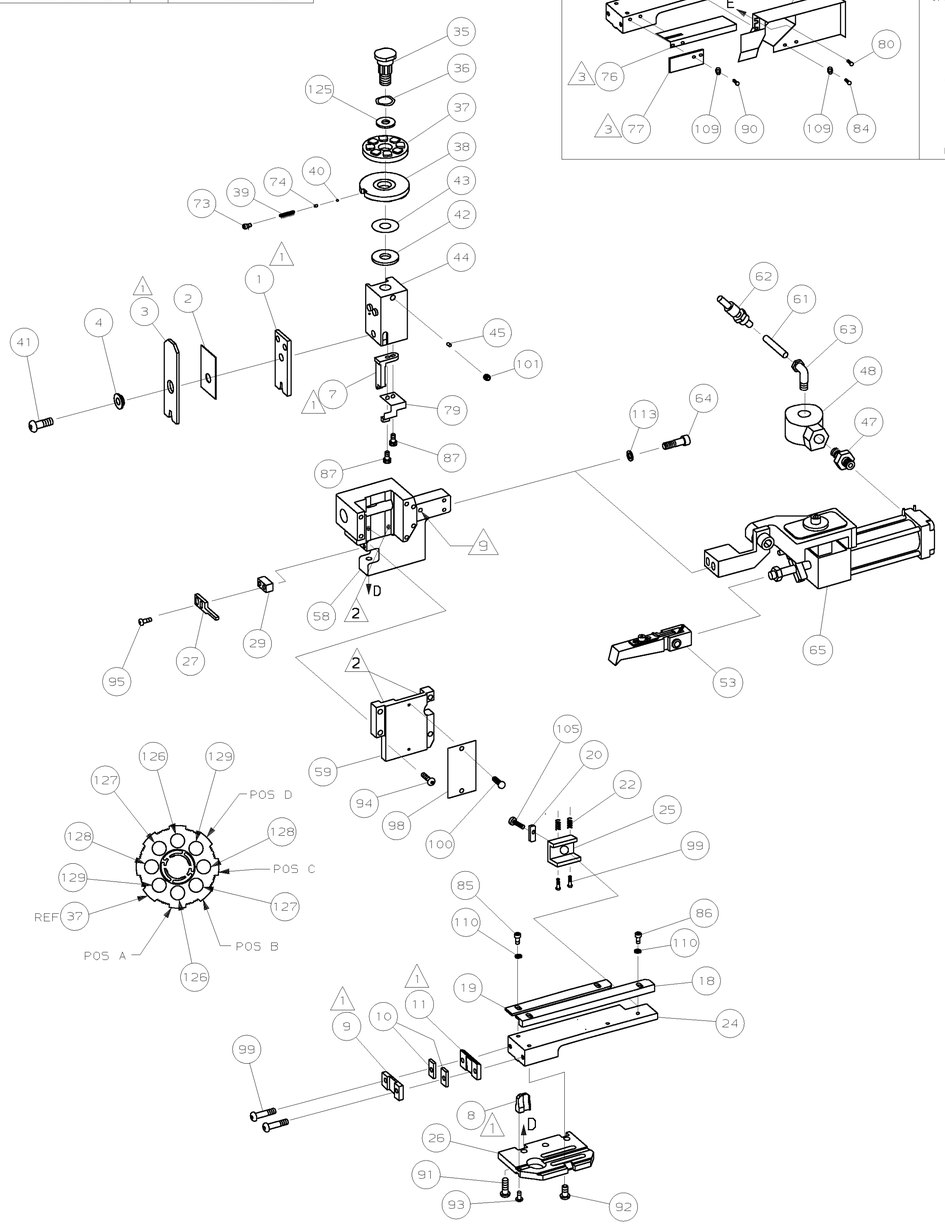
680353 ⇔ 680353

/home/us016926/DMTECmod

PART NUMBER	REV	FIRST USED
680353-3	H	356462-1







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. SET-UP ONLY (2)#17 1/2 MAGWIRE
6. SET-UP ONLY (2)#18 MAGWIRE
7. SET-UP ONLY (2)#19 MAGWIRE
8. SET-UP ONLY (2)#20 MAGWIRE
9. PIN MUST BE REMOVED TO ALLOW FOR GUARD

TERMINAL NAME: .187 AMPLIVAR FASTON™ FLAG RECEPT

63940
1217417

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.069 ±.002 [1.75 ±0.05mm]	4050 CMA 5
B	.065 ±.002 [1.65 ±0.05mm]	3250 CMA 6
C	.061 ±.002 [1.55 ±0.05mm]	2600 CMA 7
D	.057 ±.002 [1.45 ±0.05mm]	2000 CMA 8

CRIMP	SIZE	TYPE	RANGE
WIRE	.100 [2.54mm]	F	2000-4050 CMA
INSUL	.100 [2.54mm]	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	1-354779-9	PIN, WIRE DISC (.3085)B	129
	2	–	C	1-354779-1	PIN, WIRE DISC (.3045)B	128
	2	–	C	354779-6	PIN, WIRE DISC (.3020)B	127
	2	–	C	9-354778-5	PIN, WIRE DISC (.2970)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(8-32x.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	–	A2	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	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
						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	2-690451-4	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	2-456537-2	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	318702-2	CRIMPER, WIRE	1

-3 THRU MODEL G — AIR FEED

	-3	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

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

QTY REQD PER ASSY — PARTS LIST

P	F	LTR	REVISION RECORD	APP	DATE
		H	ECR 05-003483	TE	5-05
		G	0150-0476-03	TB	MAY03
		F	0150-0141-01	TE	2-01
		E2	0150-0736-00	RK	10-00
		E1	0150-0537-00	CE	AUG00
		E	0150-9449-99	TB	7-99
		D	0150-9300-99	TB	5-99
		C	0150-7925-97	TB	8-97
		B	0150-7526-97	CE	2-97

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. OBRIEN	APP 8-29-96 T. ELBIN	AMP Incorporated Harrisburg, PA 17105-3608	
CHK 8-29-96 C. ERISMAN	REL – –		
NAME END FEED HDM APPLICATOR		MACHINE REF MINI APPL	
SCALE –	D DWG NO 680353	SHEET 1 OF 1	REV H

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