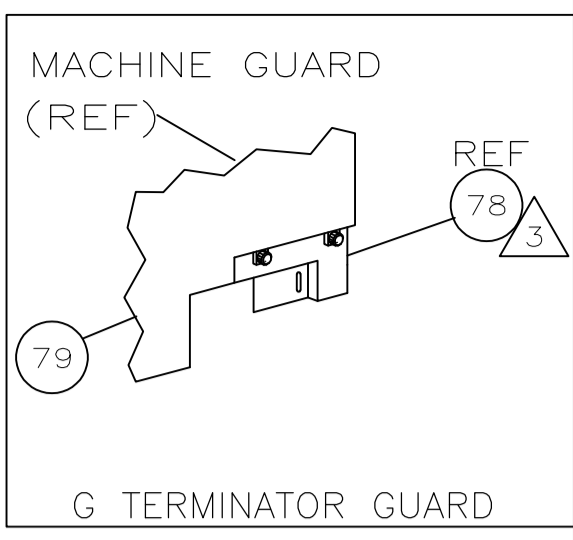


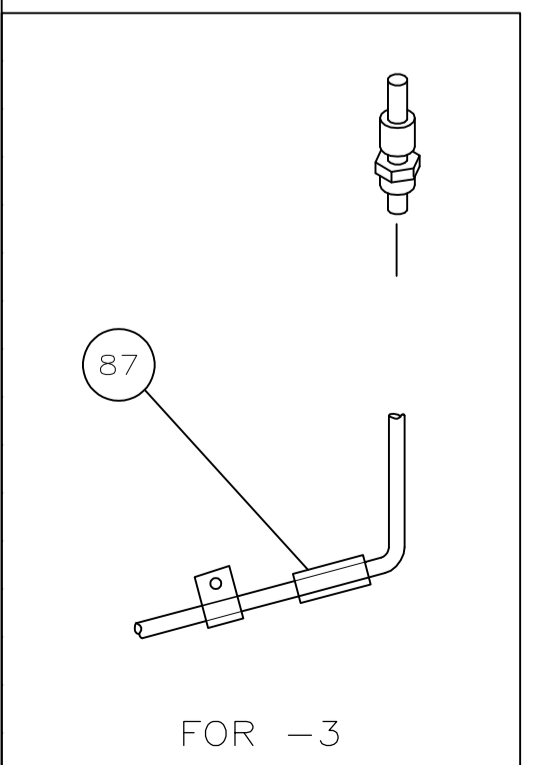
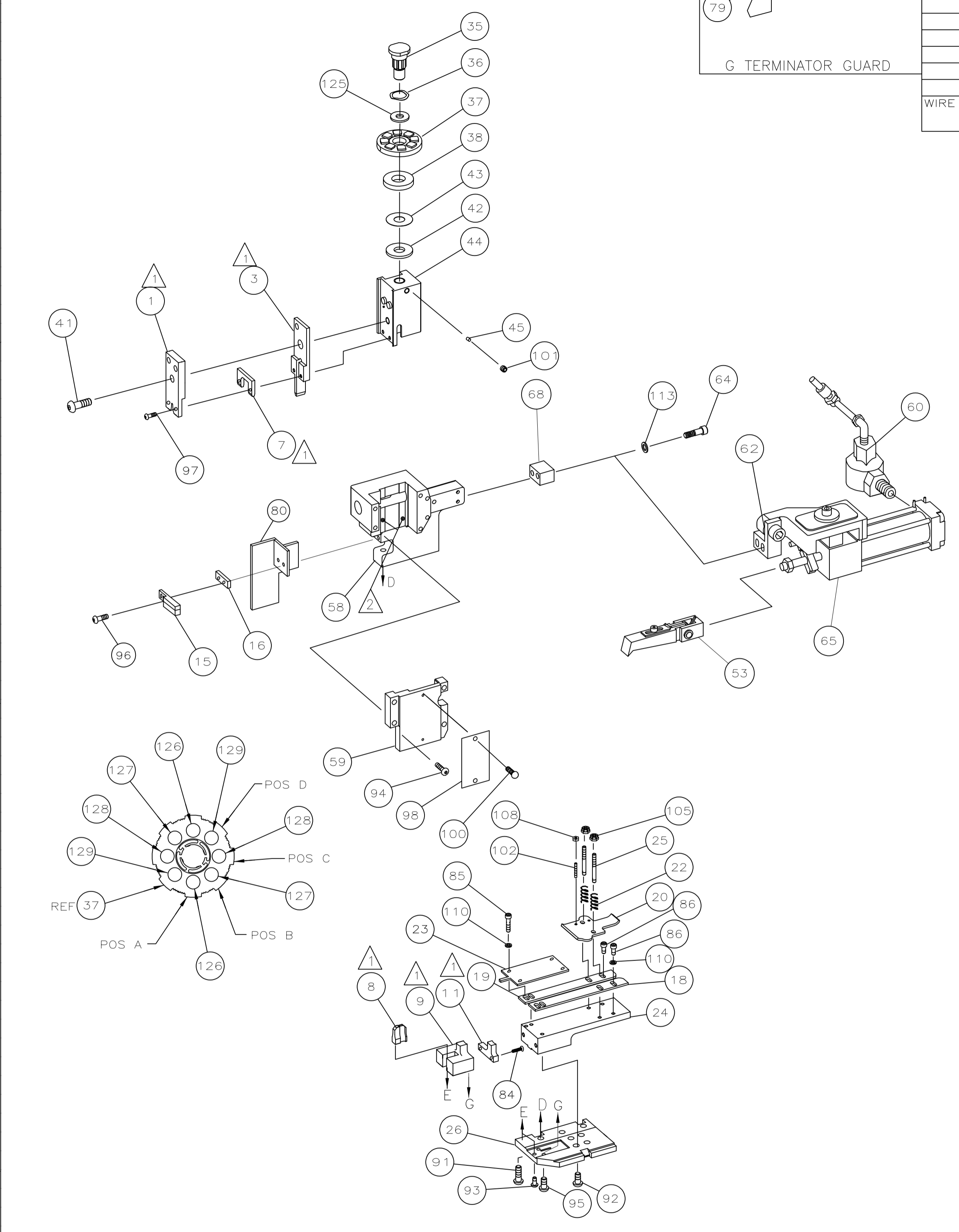
| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------|
| 680184-3 | G | 354500-1 |



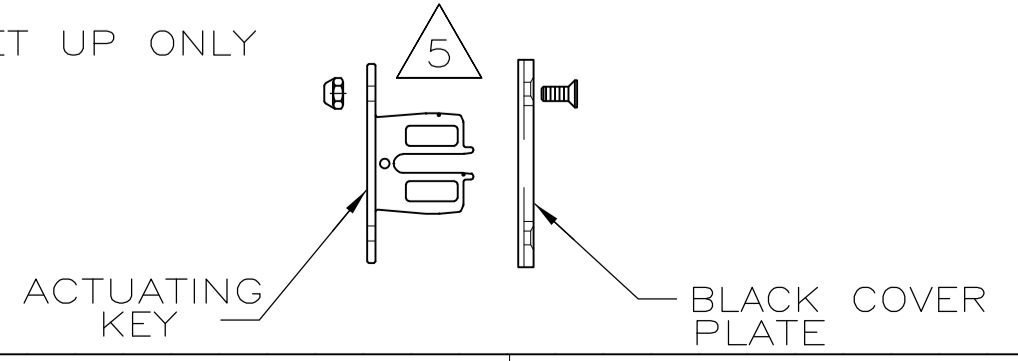
| TERMINAL NAME: AMPLIVAR™ SPLICE 7 SERRATIONS | | | | | |
|--|---------------------------|-----------|---------------|-------------|--------|
| CRIMPING DATA | | | | | |
| PAD LTR | CRIMP HEIGHT | CMA | | | |
| A | .076 ±.002 [1.93 ±0.05mm] | 6200-7000 | (2) | 15 | |
| B | .072 ±.002 [1.83 ±0.05mm] | 5200-6000 | (2) | 16 | |
| C | .069 ±.002 [1.75 ±0.05mm] | 4000-5000 | (2) | 17 | |
| D | .065 ±.002 [1.65 ±0.05mm] | 3000-3800 | (2) | 18 | |
| CRIMP | SIZE | TYPE | RANGE | | |
| WIRE | .180 [4.57mm] | F | 3000-7000 CMA | | |
| INSUL | - | - | - | | |
| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPL INST | SET UP GAGE | LAYOUT |
| - | 114-2002 | .315 | 408-8039 | - | L1623Q |

| LOC | DIST | REVISIONS | | | |
|-----|------|-----------|---------------|-----------|---------|
| A | 66 | REV | DESCRIPTION | DATE | BY |
| | | G | ECR-11-018388 | 06SEP2011 | L.Z S.X |

-3 BENCH MODEL G AIRFEED



- 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 MAG WIRE SIZES FOR SET UP ONLY



| | | | | |
|-----|---|------------|---------------------------------|-----|
| 2 | - | 3-354779-0 | PIN, WIRE DISC (.3140)D | 129 |
| 2 | - | 1-354779-7 | PIN, WIRE DISC (.3075)C | 128 |
| 2 | - | 1-354779-0 | PIN, WIRE DISC (.3040)B | 127 |
| 2 | - | 354779-4 | PIN, WIRE DISC (.3010)A | 126 |
| 1 | - | 986950-1 | WASHER, FLAT PRECISION | 125 |
| | | | | 124 |
| | | | | 123 |
| | | | | 122 |
| | | | | 121 |
| | | | | 120 |
| | | | | 119 |
| | | | | 118 |
| | | | | 117 |
| | | | | 116 |
| | | | | 115 |
| | | | | 114 |
| 2 | - | 21024-5 | WASHER, LOCK(NO.10) | 113 |
| | | | | 112 |
| | | | | 111 |
| 6 | - | 21024-4 | WASHER, LOCK(NO.8)SHEAR BL | 110 |
| | | | | 109 |
| 2 | - | 21018-4 | NUT, HEX(4-40)DRAG | 108 |
| | | | | 107 |
| | | | | 106 |
| 2 | - | 21022-2 | NUT, HEX SL(8-32)DRAG STUD | 105 |
| | | | | 104 |
| | | | | 103 |
| 2 | - | 2-21006-6 | SCR, SKT SET(4-40x.62)DRAG | 102 |
| 1 | - | 21009-2 | SCR, SKT SET(1/4-20x.25)RAM | 101 |
| 2 | - | 1-21002-3 | SCR, BHC(4-40x.25)ID PLATE | 100 |
| | | | | 99 |
| 1 | - | 464249-1 | PLATE, IDENTIFICATION | 98 |
| 2 | - | 2-21002-8 | SCR, BHC(10-32x.63) | 97 |
| 2 | - | 3-21000-2 | SCR, SHC(8-32x1.25)GUARD | 96 |
| 2 | - | 2-22733-0 | SCR, BHC(10-32x.38 LW)ANVIL | 95 |
| 4 | - | 2-21002-9 | SCR, BHC(10-32x.75)CAP | 94 |
| 1 | - | 22733-8 | SCR, BHC(8-32x.38 LW)ANVIL | 93 |
| 4 | - | 3-21002-4 | SCR, BHC(1/4-20x.62)ST GD PL | 92 |
| 3 | - | 2-22733-8 | SCR, BHC(1/4-20x.62)HSG | 91 |
| | | | | 90 |
| | | | | 89 |
| | | | | 88 |
| 1 | - | 318848-1 | AIR BLAST ASSY | 87 |
| 2 | - | 2-21000-6 | SCR, SHC(8-32x.38)STRIP GUIDE | 86 |
| 4 | - | 2-21000-7 | SCR, SHC(8-32x.50)R STRIP GUIDE | 85 |
| 2 | - | 1-21002-6 | SCR, BHC(6-32x.25)R STRIP GUIDE | 84 |
| | | | | 83 |
| | | | | 82 |
| | | | | 81 |
| | | | | 80 |
| 1 | - | 224383-1 | GUARD, SIDE | 79 |
| 1 | - | 224388-1 | GUARD ASSY | 78 |
| REF | - | 224322-1 | INSERT, GUARD | 77 |
| | | | | 76 |
| | | | | 75 |
| | | | | 74 |
| | | | | 73 |
| | | | | 72 |
| | | | | 71 |

| QTY REQD PER ASSY | U/M | PART NO | DESCRIPTION | ITEM NO |
|-------------------|-----|---------|-------------|---------|
| | | | PARTS LIST | |

| | | | | | |
|---|---|------------|------------------------------|--|----|
| | | | | | 70 |
| | | | | | 69 |
| 1 | - | 461690-1 | SPACER, AIR FEED | | 68 |
| | | | | | 67 |
| | | | | | 66 |
| 4 | 1 | 460277-1 | AIR FEED ASSY | | 65 |
| | | | | | 64 |
| 2 | - | 4-21000-3 | SCR, SHC 10-32x2.00 AIR ASSY | | 63 |
| | | | | | 62 |
| 1 | - | 371178 | WASHER, BASE MOUNT | | 61 |
| | | | | | 60 |
| 1 | - | 692655-7 | AIR FEED VALVE ASSEMBLY | | 60 |
| 1 | - | 462926-1 | CAP, RAM | | 59 |
| 1 | - | 453736-1 | HOUSING | | 58 |
| | | | | | 57 |
| | | | | | 56 |
| | | | | | 55 |
| | | | | | 54 |
| 4 | 1 | 2-460680-9 | FEED FINGER ASSY | | 53 |
| | | | | | 52 |
| | | | | | 51 |
| | | | | | 50 |
| | | | | | 49 |
| | | | | | 48 |
| | | | | | 47 |
| | | | | | 46 |
| | | | | | 45 |
| 1 | - | 690191-1 | PLUG, NYLON | | 45 |
| 1 | - | 459586-1 | RAM | | 44 |
| 1 | - | 690125-1 | WASHER, LAMINATED | | 43 |
| 1 | - | 690124-9 | WASHER, RAM | | 42 |
| 1 | - | 7-21002-9 | BOLT, CRIMPER(5/16-24x1.00) | | 41 |
| | | | | | 40 |
| | | | | | 39 |
| | | | | | 38 |
| 1 | - | 690223-2 | SPACER, INSULATION DISC | | 38 |
| 1 | - | 354777-1 | WIRE DISC, PLASTIC | | 37 |
| 1 | - | 22480-5 | WASHER, SPRING | | 36 |
| 1 | - | 690212-1 | POST, RAM | | 35 |
| | | | | | 34 |
| | | | | | 33 |
| | | | | | 32 |
| | | | | | 31 |
| | | | | | 30 |
| | | | | | 29 |
| | | | | | 28 |
| | | | | | 27 |
| 1 | - | 224371-1 | PLATE, BASE | | 26 |
| 2 | - | 22354-7 | DRAG, STUD | | 25 |
| 1 | - | 462931-2 | PLATE, STRIP GUIDE | | 24 |
| 1 | - | 462932-1 | PLATE, STRIP COVER | | 23 |
| 2 | - | 3-22281-8 | SPRING, DRAG | | 22 |
| | | | | | 21 |
| 1 | - | 462925-1 | DRAG, STOCK | | 20 |
| 1 | - | 462929-1 | GUIDE, STRIP (REAR) | | 19 |
| 1 | - | 462930-1 | GUIDE, STRIP (FRONT) | | 18 |
| | | | | | 17 |
| 1 | - | 2-690451-5 | SPACER, STRIPPER | | 16 |
| 1 | - | 1633729-1 | STRIPPER ASSEMBLY | | 15 |
| | | | | | 14 |
| | | | | | 13 |
| | | | | | 12 |
| 1 | - | 459684-2 | PLATE, GUIDE RETAINING | | 11 |
| | | | | | 10 |
| 1 | - | 224372-1 | BODY, ANVIL | | 9 |
| 1 | - | 224319-1 | ANVIL | | 8 |
| 1 | - | 459581-2 | BLADE, SLUG | | 7 |
| | | | | | 6 |
| | | | | | 5 |
| | | | | | 4 |
| 1 | - | 318158-1 | GUIDE, CRIMPER | | 3 |
| | | | | | 2 |
| 1 | - | 1-459585-0 | CRIMPER, WIRE | | 1 |

| QTY REQD PER ASSY | U/M | PART NO | DESCRIPTION | ITEM NO |
|-------------------|-----|---------|-------------|---------|
| | | | PARTS LIST | |

THIS DRAWING IS A CONTROLLED DOCUMENT.

| | | | | |
|--------------------|--|-----|---------|------------|
| DIMENSIONS: INCHES | TOLERANCES UNLESS OTHERWISE SPECIFIED: | REV | DATE | BY |
| 0 PLC ± .005 | 1 PLC ± .002 | 1 | 6-30-95 | R O WILSON |
| 1 PLC ± .002 | 2 PLC ± .001 | 2 | 7-6-95 | C FRISMAN |
| 2 PLC ± .001 | 3 PLC ± .0005 | 3 | 7-7-95 | A BEDDICK |
| 3 PLC ± .0005 | 4 PLC ± .0002 | | | |
| 4 PLC ± .0002 | ANGLES ± .001 | | | |

MATERIAL: - FINISH: -

WEIGHT: -

CUSTOMER DRAWING: A1 00779 C=680184

TE Connectivity
Harrisburg, PA 17105-3608

END FEED HDM APPLICATOR

SCALE: - SHEET: 1 OF 1 REV: G