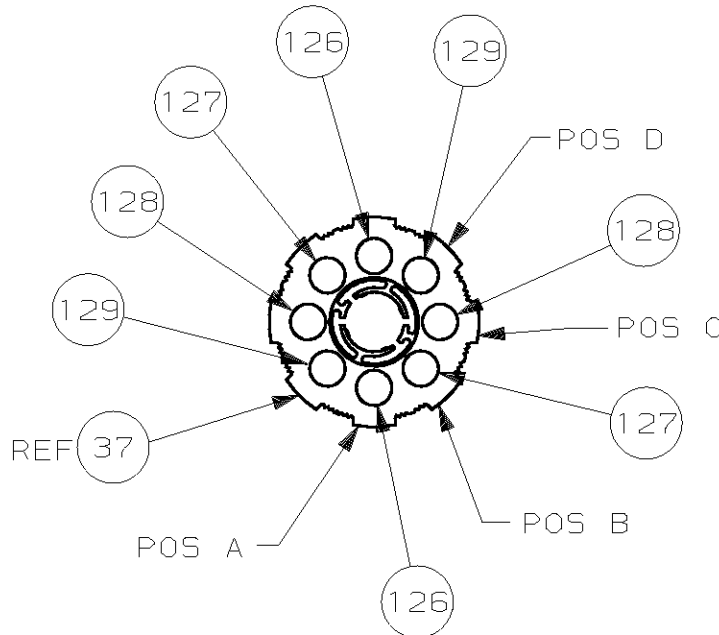
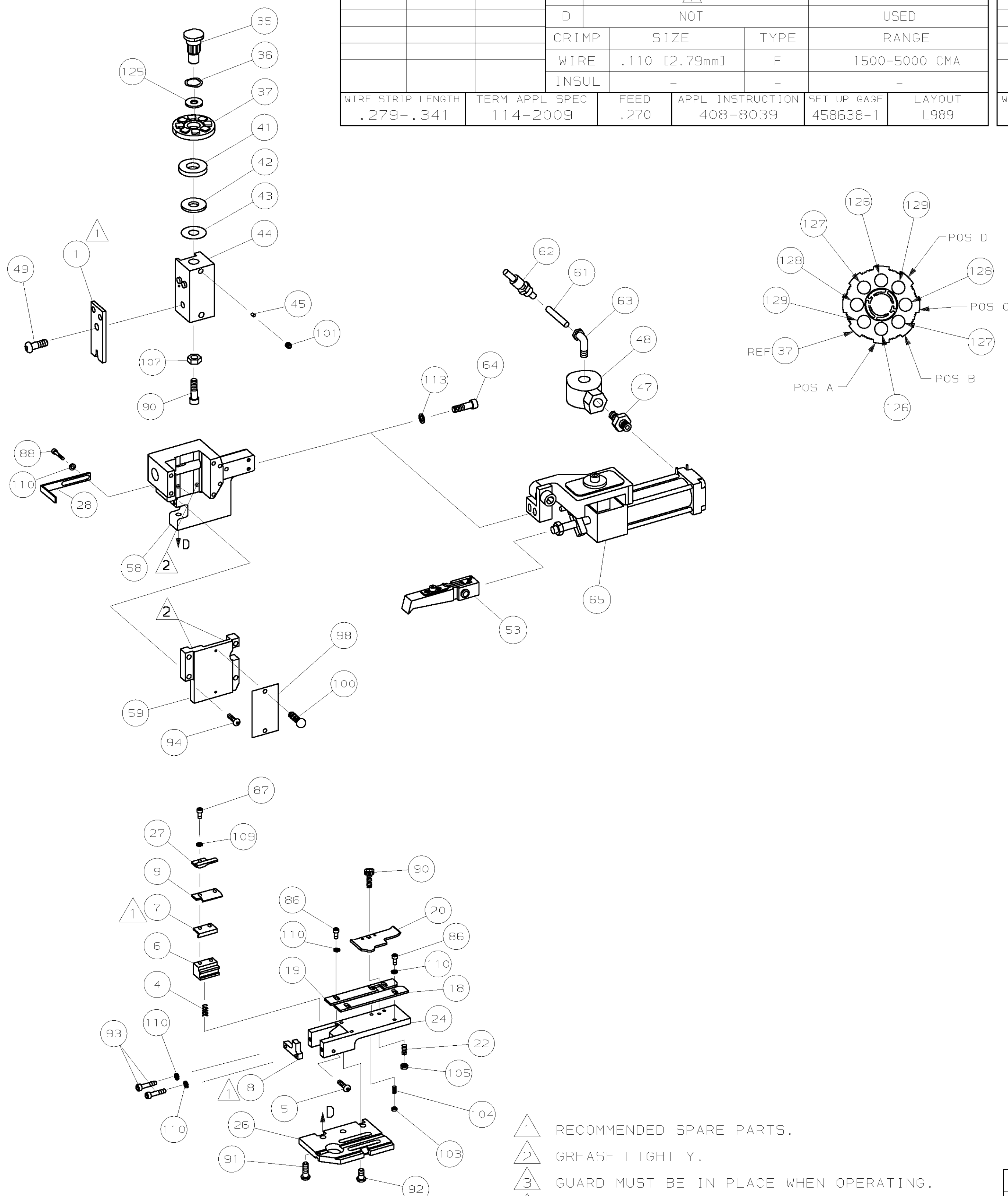


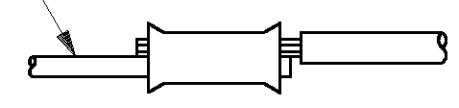
PART NUMBER	REV	PART USED
680513	A	356462-1

TERMINAL NAME: AMPLIVAR™ THRU SPLICE			
41765	CRIMPING DATA		
41899	PAD LTR	CRIMP HEIGHT	WIRE COMBINATION
42119	A	△	3600-5000 CMA
140778	B	△	2200-3600 CMA
140837	C	△	1500-2000 CMA
	D	NOT	USED
	CRIMP	SIZE	TYPE
	WIRE	.110 [2.79mm]	F
	INSUL	-	-
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
.279-.341	114-2009	.270	408-8039
			SET UP GAGE
			458638-1
			LAYOUT
			L989

TERMINAL NAME: AMPLIVAR™ THRU SPLICE			
42076	CRIMPING DATA		
42192	PAD LTR	CRIMP HEIGHT	WIRE COMBINATION
140723	A	.079 ±.001 [2.0 ±0.02mm]	4200 CMA △8
140780	B	.072 ±.001 [1.83 ±0.02mm]	2800 CMA △8
170152	C	.064 ±.001 [1.63 ±0.02mm]	1400 CMA △8
1217384	D	.057 ±.001 [1.45 ±0.02mm]	1200 CMA △8
	CRIMP	SIZE	TYPE
	WIRE	.110 [2.79mm]	F
	INSUL	-	-
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
.279-.341	114-2009	.270	408-8039
			SET UP GAGE
			458638-1
			LAYOUT
			L989



- △1 RECOMMENDED SPARE PARTS.
- △2 GREASE LIGHTLY.
- △3 GUARD MUST BE IN PLACE WHEN OPERATING.
- △4 SEE DRAWING FOR COMPONENTS.
- △5 USE MANUAL PRECISION ADJUSTMENT LEVER ON G TERMINATOR TO ACHIEVE PROPER CRIMP HEIGHT.
- △6 SOLID WIRE ON BOTTOM
- △7 SEE SHEET 2 FOR CRIMP HEIGHT INFORMATION.



2	-	C	2-354779-2	PIN, WIRE DISC (.3100)D	129	
2	-	C	354779-4	PIN, WIRE DISC (.3010)C	128	
2	-	C	8-354778-7	PIN, WIRE DISC (.2930)B	127	
2	-	C	7-354778-3	PIN, WIRE DISC (.2860)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 (NO.10) SHEAR PL	113	
					112	
					111	
8	-	A	21024-4	WASHER, LOCK (NO.8) SHEAR BL	110	
2	-	A	21024-3	WASHER, LOCK (NO.6) STRIP & SHEAR	109	
					108	
1	-	A	21019-1	NUT, HEX (1/4-20) RAM	107	
					106	
2	-	A	21022-4	NUT, HEX SL (1/4-20) DRAG STUD	105	
2	-	A	5-21061-5	SCR, SKT SET (8-32x.88) DRAG	104	
2	-	A	21018-6	NUT, HEX (8-32) DRAG	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	
					99	
1	-	B	461264-1	PLATE, IDENTIFICATION	98	
					97	
					96	
					95	
4	-	A	2-21002-9	SCR, BHC (10-32x.75) CAP	94	
2	-	A	2-21000-7	SCR, SKT CAP (8-32x.50) ANVIL	93	
2	-	A	3-21002-3	SCR, BHC (1/4-20x.50) ST 6D PL	92	
3	-	A	2-22733-8	SCR, BHC (1/4-20x.62) H5G	91	
2	-	A	21001-7	SCR, SHC (1/4-20x1.25) DRAG & RAM	90	
					89	
2	-	A	2-21000-6	SCR, SHC (8-32x.38) STRIPPER	88	
2	-	A	2-21000-0	SCR, SHC (6-32x.50) STRIPPER&SHEAR	87	
4	-	A	1-21000-8	SCR, SHC (6-32x.25) STRIP. GUIDE	86	
					85	
					84	
					83	
					82	
					81	
					80	
△3	1	-	A	1213015-1	GUARD ASSY	79
						78
						77
						76
						75
						74
						73
						72
						71

-3		BENCH MODEL G	AIRFEED			
					70	
					69	
					68	
					67	
					66	
△4	1	-	B	460277-1	AIR FEED ASSY	65
	2	-	A	3-21000-9	SCR, SHC (10-32x1.00) AIR FD ASSY	64
	1	-	A	22294-6	ELBOW, TUBING 1/8NPT - 1/4 T	63
	1	-	A	23238-1	QUICK DISCONNECT	62
15.00	IN	A	A	27319-4	TUBING, POLY-FLO 1/4 DIA	61
					60	
					59	
					58	
					57	
					56	
					55	
					54	
△4	1	-	B	460680-1	FEED FINGER ASSY	53
					52	
					51	
					50	
					49	
					48	
					47	
					46	
					45	
					44	
					43	
					42	
					41	
					40	
					39	
					38	
					37	
					36	
					35	
					34	
					33	
					32	
					31	
					30	
					29	
					28	
					27	
					26	
					25	
					24	
					23	
					22	
					21	
					20	
					19	
					18	
					17	
					16	
					15	
					14	
					13	
					12	
					11	
					10	
					9	
					8	
					7	
					6	
					5	
					4	
					3	
					2	
					1	
△1	1	-	C	456408-4	CRIMPER, WIRE	1

QTY	RECD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
					REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)	
PARTS LIST						

QTY	RECD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
					REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)	
PARTS LIST						

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±.25 3 PLC DEC ±. 4 PLC DEC ±.			MACHINING REF MINI APPL		
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX			MACHINE REF MINI APPL		
SCALE			SHEET 1 OF 2		
DWG NO 680513			REV A2		

THIS DRAWING IS A CONTROLLED DOCUMENT.

THIS DRAWING IS UNRELEASED. RELEASE FOR PUBLICATION BY AMP INCORPORATED. ALL RIGHTS RESERVED. COPYRIGHT 19

TERMINAL NUMBER	
41765	
41899	
42119	
140778	
140837	

CRIMPING DATA		
PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.083 ±.002 [2.12 ±0.05mm]	5000 CMA
A	.082 ±.002 [2.08 ±0.05mm]	4800 CMA
A	.081 ±.002 [2.06 ±0.05mm]	4600 CMA
A	.080 ±.002 [2.03 ±0.05mm]	4400 CMA
A	.079 ±.002 [2.01 ±0.05mm]	4200 CMA
A	.078 ±.002 [1.98 ±0.05mm]	4000 CMA
A	.077 ±.002 [1.96 ±0.05mm]	3800 CMA
A	.076 ±.002 [1.93 ±0.05mm]	3600 CMA
B	.075 ±.002 [1.91 ±0.05mm]	3400 CMA
B	.074 ±.002 [1.88 ±0.05mm]	3200 CMA
B	.073 ±.002 [1.85 ±0.05mm]	3000 CMA
B	.072 ±.002 [1.83 ±0.05mm]	2800 CMA
B	.071 ±.002 [1.80 ±0.05mm]	2600 CMA
B	.070 ±.002 [1.78 ±0.05mm]	2400 CMA
B	.069 ±.002 [1.75 ±0.05mm]	2200 CMA
C	.067 ±.002 [1.70 ±0.05mm]	2000 CMA
	.066 ±.002 [1.68 ±0.05mm]	1800 CMA
	.065 ±.002 [1.65 ±0.05mm]	1600 CMA
	.064 ±.002 [1.63 ±0.05mm]	1400 CMA

TERMINAL NUMBER	
42076	
42192	
140723	
140780	
170152	

CRIMPING DATA		
PAD LTR	CRIMP HEIGHT	WIRE SIZE
C	.066 ±.002 [1.68 ±0.05mm]	3000 CMA
C	.065 ±.002 [1.65 ±0.05mm]	2800 CMA
C	.064 ±.002 [1.63 ±0.05mm]	2600 CMA
C	.063 ±.002 [1.60 ±0.05mm]	2400 CMA
C	.062 ±.002 [1.57 ±0.05mm]	2200 CMA
C	.061 ±.002 [1.55 ±0.05mm]	2000 CMA
C	.060 ±.002 [1.52 ±0.05mm]	1800 CMA
D	.059 ±.002 [1.50 ±0.05mm]	1600 CMA
D	.058 ±.002 [1.47 ±0.05mm]	1400 CMA
D	.057 ±.002 [1.45 ±0.05mm]	1200 CMA
D	.056 ±.002 [1.42 ±0.05mm]	1000 CMA
D	.054 ±.002 [1.37 ±0.05mm]	800 CMA

THIS DRAWING IS A CONTROLLED DOCUMENT.

THIS DRAWING IS UNRELEASED. RELEASE FOR PUBLICATION BY AMP INCORPORATED. ALL RIGHTS RESERVED. COPYRIGHT 19

A
66

P	F	LTR	REVISION RECORD	APP	DATE

DWG SIZE	PART NO	DESCRIPTION	ITEM NO
REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)			
QTY REQD PER ASSY		PARTS LIST	
DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±.25 3 PLC DEC ± 4 PLC DEC ± ANGLES ± - SURF TEXTURE: ✓		MATL	HT TR FIN
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX		DR 8-13-97 R.O.WILSON	APP 8-14-97 T.ELBIN
SCALE		DWG NO 680513	
NAME END FEED HDM APPLICATOR		MACHINE REF MINI APPL	
SHEET 2 OF 2		REV A2	

680513

D

C

B

A