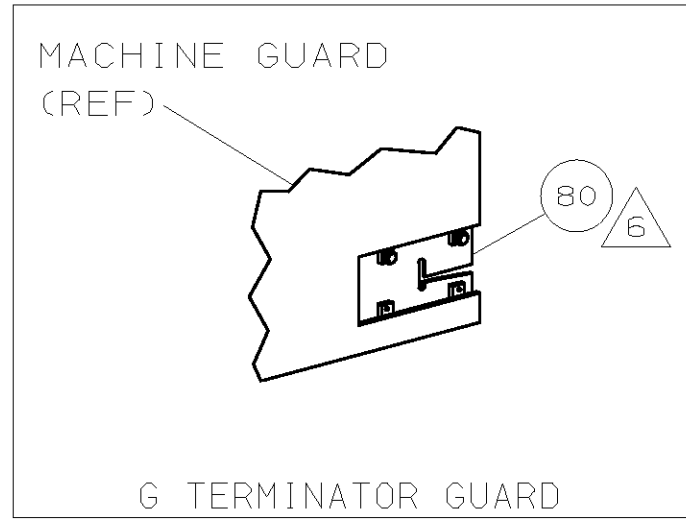
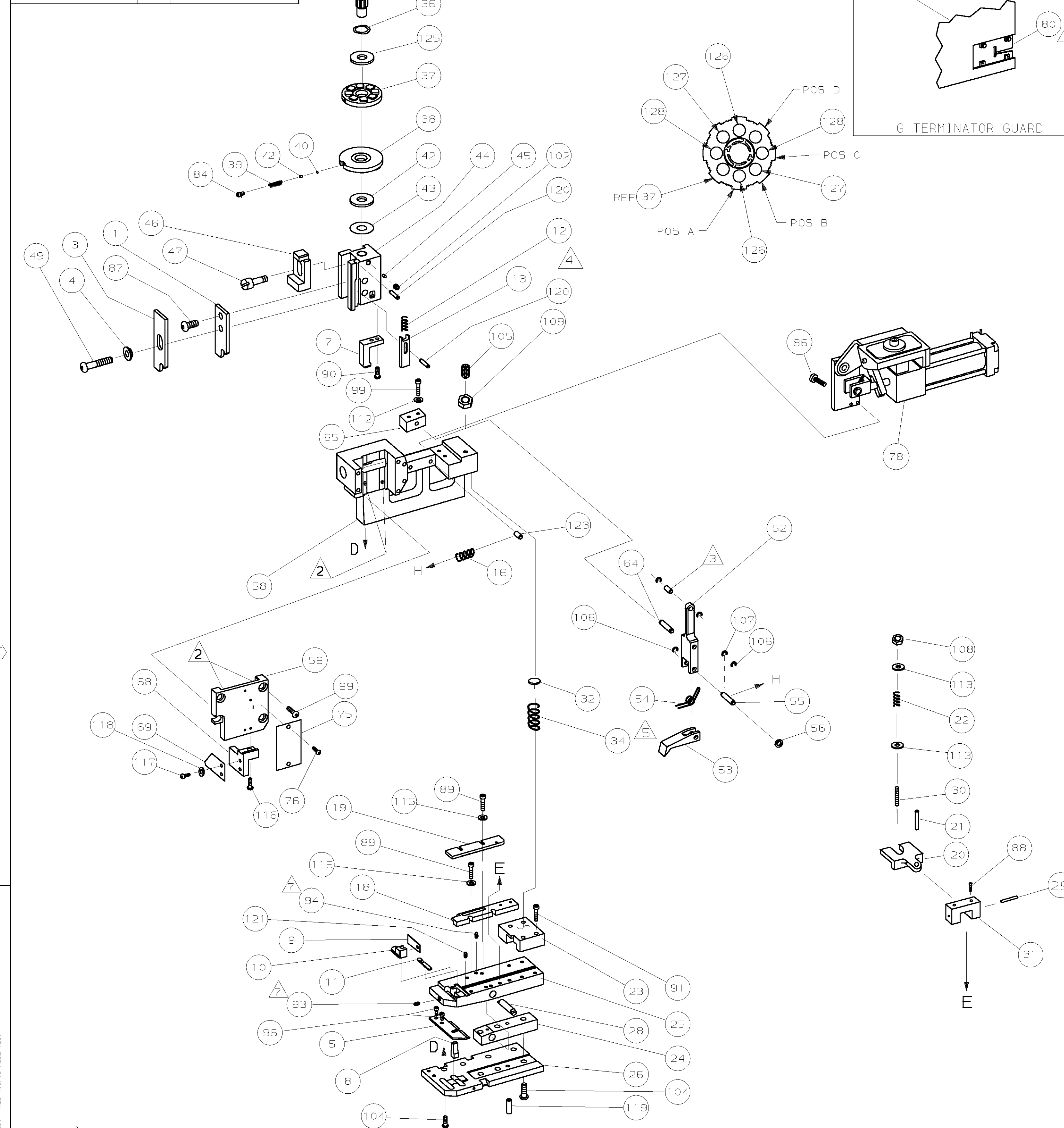


PART NUMBER	REV	FIRST USED
1385819-1	A	354500-1



TERMINAL		.187 FLAG RECPT. TERMINAL	
TYCO PN	MOLEX PN	CRIMPING DATA	
1572560	35718-2110	PAD LTR	CRIMP HEIGHT
		A	.040±.002 [1.01±0.05mm]
		B	.037±.002 [0.94±0.05mm]
		C	.035±.002 [0.89±0.05mm]
		D	NOT USED
		CRIMP WIRE	SIZE
			.140 [3.56mm]
		INSUL	.140 [3.56mm]
		TYPE	TAB LOCK
		RANGE	20-16
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
.173-.203	NONE	.650	408-8037
		SET UP GAGE	LAYOUT
		-	-

QTY	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-	-	-	-	-	-	129
2	-	C		6-354779-9	PIN, WIRE DISC (.3335)C	128
2	-	C		6-354779-7	PIN, WIRE DISC (.3325)B	127
2	-	C		6-354779-2	PIN, WIRE DISC (.3300)A	126
1	-	A		986950-1	WASHER, FLAT PRECISION	125
1	-	A		3-22183-9	PIN, GROOVED (.187 X 1.25)	123
2	-	A		3-21028-2	PIN, SLOTTED SPRING (ø.094x.25)	121
2	-	A		4-21028-9	PIN, SLOTTED SPRING (ø.125x.38)	120
1	-	A		21029-5	PIN, SLOTTED SPRING (ø.188x.75)	119
2	-	A		21024-3	WASHER, LOCK (#6)	118
2	-	A		1-21000-8	SCREW, SHC (6-32x.25) STOP	117
1	-	A		2-22603-0	SCREW, SHC (8-32x.38) MTG	116
4	-	A		21024-4	WASHER, LOCK (#8)	115
2	-	A		21055-6	WASHER, FLAT (#8)	114
2	-	A		21899-2	WASHER, FLAT (#10)	113
2	-	A		21024-5	WASHER, LOCK (#10)	112
						111
						110
1	-	A		1-22202-7	NUT, HEX (5/16-24)	109
1	-	A		21022-3	NUT, HEX (LOCKING) (10-32)	108
1	-	A		1-21986-2	RING, RET "E" ø3/16	107
2	-	A		21045-3	RING, RET "C" ø3/16	106
1	-	A		8-21007-5	SCREW, SKT SET (5/16-24x.75)	105
7	-	A		2-22733-8	SCREW, BHC (1/4-20X.63)	104
						103
1	-	A		21009-2	SCREW, SKT SET (1/4-20x.25)	102
						101
2	-	A		3-21000-9	SCREW, SHC (10-32X1.00)	100
6	-	A		3-21000-8	SCREW, SHC (10-32X.88)	99
1	-	A		3-21000-6	SCREW, SHC (10-32X.62)	98
						97
2	-	A		7-21000-6	SCREW, SHC (10-32X.38)	96
						95
2	-	A		4-21006-0	SCREW, SKT SET (8-32X.25)	94
1	-	A		21061-9	SCREW, SKT SET (8-32X.25)	93
						92
4	-	A		2-21000-9	SCREW, SHC (8-32X.75)	91
2	-	A		1-23030-1	SCREW, SHC (NYLON) (8-32X.62)	90
4	-	A		2-22603-3	SCREW, SHC (8-32X.62)	89
2	-	A		2-21000-8	SCREW, SHC (8-32X.62)	88
1	-	A		2-21002-1	SCREW, SBHC (8-32X.38)	87
2	-	A		21001-3	SCREW, SHC (1/4-20X.62)	86
						85
1	-	A		23030-1	SCREW, SHC (NYLON) (6-32X.25)	84
						83
						82
						81
REF	-	A		679532-1	INSERT, GUARD	80
1	-	D		462622-2	AIR FEED ASSEMBLY	78
						77
2	-	A		21017-2	SCR, DRIVE (#2X.19) ID	76
1	-	B		461264-1	PLATE, IDENTIFICATION	75
						74
						73
1	-	A		690603-1	SPRING, ASSIST	72
						71

QTY	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-1	-	-	-	-	-	70
1	-	B		318530-2	STOP, WIRE	69
1	-	B		318529-1	BLOCK, HOUSING	68
						67
						66
1	-	B		456987-1	BLOCK, PIVOT	65
1	-	A		457058-1	PIN, PIVOT	64
						63
						62
						61
						60
1	-	C		318528-1	CAP, RAM	59
1	-	D		457079-1	HOUSING	58
						57
1	-	B		25745-1	RING, SPLIT	56
1	-	B		240624-1	PIN, FEED FINGER	55
1	-	B		691499-1	SPRING, FEED FINGER	54
1	-	B		454568-2	FINGER, FEED	53
1	-	B		457057-1	ARM, PIVOT	52
						51
						50
1	-	A		3-21002-5	BOLT, CRIMPER	49
						48
1	-	A		22353-8	SCREW, SHOULDER	47
1	-	A		690578-1	BLOCK, INSULATION ADJUST	46
1	-	A		690191-1	PLUG, NYLON	45
1	-	C		454574-1	RAM	44
1	-	A		690125-1	WASHER, LAMINATED	43
1	-	A		1-690124-1	WASHER, RAM	42
						41
1	-	A		23241-6	BALL, STEEL	40
1	-	A		690170-1	SPRING, COMPRESSION	39
1	-	C		690142-1	DISC, INSULATION	38
1	-	D		354777-1	WIRE DISC, PLASTIC	37
1	-	B		22480-5	WASHER, SPRING	36
1	-	B		690212-1	POST, RAM	35
1	-	A		3-23846-5	SPRING, HINGE BAR	34
						33
1	-	A		690573-1	SPACER, SPRING	32
1	-	B		454569-1	DRAG MOUNT	31
1	-	A		1-22354-8	STUD, DRAG	30
1	-	B		21030-2	PIN, DRAG MOUNT	29
1	-	B		690582-1	PIN, HINGE	28
						27
1	-	C		684905-1	PLATE, BASE	26
1	-	B		454579-2	HINGE BAR	25
1	-	B		690571-1	BLOCK, STABILIZER	24
1	-	C		690585-1	BLOCK, PRESSURE	23
2	-	A		8-22282-6	SPRING, DRAG	22
1	-	A		21030-6	LEVER, DRAG	21
1	-	A		454570-1	DRAG, STOCK	20
1	-	C		454573-1	GUIDE, STRIP (REAR)	19
1	-	B		318739-9	GUIDE, STRIP (FRONT)	18
						17
1	-	A		2-22287-6	SPRING, FEED RETURN	16
						15
						14
1	-	C		692134-7	POSITIONER, TERMINAL	13
1	-	A		5-22280-5	SPRING, TERM. POSITIONER	12
1	-	B		454712-4	PLATE, REAR SHEAR	11
1	-	C		454578-1	ANVIL INSERT	10
1	-	B		690569-2	PLATE, FRONT SHEAR	9
1	-	D		690718-1	ANVIL	8
1	-	B		454575-3	BLADE, SLUG	7
						6
1	-	B		684906-1	PLATE, ANVIL RETAINING	5
1	-	B		690574-1	SPACER, TUBULAR INSUL CRIMPER	4
1	-	C		690715-1	CRIMPER, INSULATION	3
						2
1	-	C		1633164-1	CRIMPER, WIRE	1

- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 4 CHANGE TERMINAL POSITIONER AS REQUIRED TO KEEP TERMINAL ON CENTER OF ANVIL. FASTEN EXTRA TERMINAL POSITIONER TO APPLICATOR.
- 5 AFTER ASSEMBLY OF APPLICATOR, PROPER SPRING PRESSURE (ITEM 34) CAN BE OBTAINED BY TIGHTENING SET SCREW (ITEM 105) UNTIL CONTACT IS MADE WITH SPACER (ITEM 32) THEN TIGHTEN AN ADDITIONAL 5 1/2 - 6 REVOLUTIONS.

- 6 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
- 7 APPLY SEALANT 1-23419-5 AT ASSEMBLY.

LOC A  
DIST 66

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED:  
 2 PLC DEC ±  
 3 PLC DEC ±  
 4 PLC DEC ±  
 ANGLES ±  
 SURF TEXTURE: ✓  
 REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL - HT TR - FIN -

DR R.KNEPPER 27AUG04 APP T.ELBIN 27AUG04

CHK - REL -

NAME END FEED HINGE BAR APPLICATOR MACHINE REF MINI APPL

SCALE NT5 DWG NO 1385819 SHEET 1 OF 1 REV A

AMP Incorporated Harrisburg, PA 17105-3608

CUSTOMER AND ASSEMBLY DRAWING

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