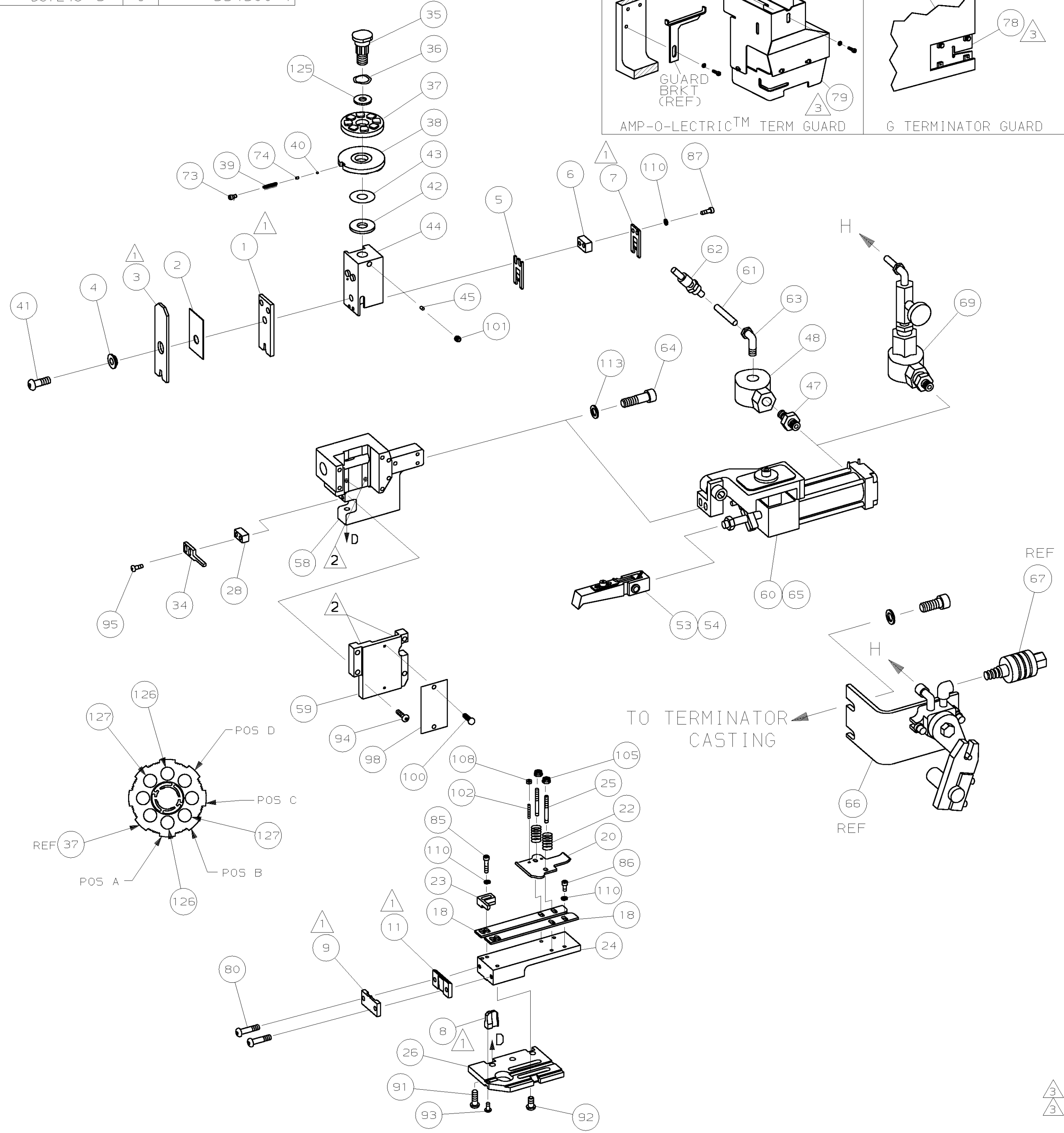
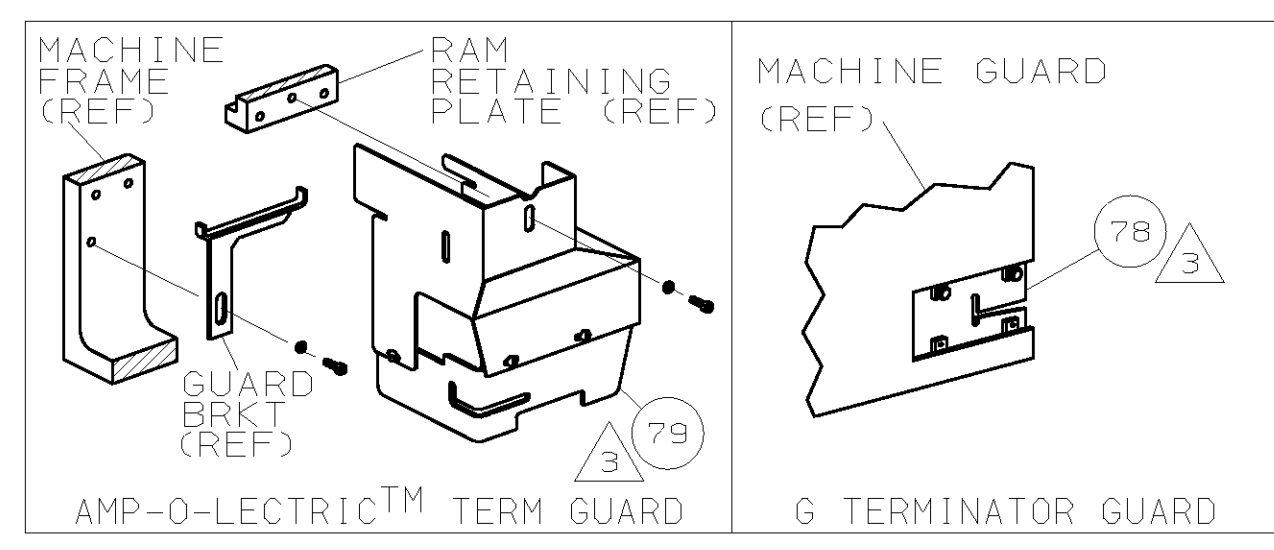


| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------|
| 567248-1 | G | 565435-5 |
| 567248-3 | G | 354500-1 |



- 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. DO NOT USE LUBRICANT ON TERMINAL STRIP.
- 6 FEED ON RECEPTACLE.
- 7 CHECK WINDOW OF TERMINAL TO .104±.004.

| TERMINAL NAME: CLUSTER PIN RECPT | | CRIMPING DATA | |
|----------------------------------|----------------|-----------------------------|------------------|
| PAD LTR | 63453 | CRIMP HEIGHT | WIRE SIZE |
| 1217122 | | A .050 ±.002 [1.27 ±0.05mm] | 1100-1600 CMA |
| 1217670 | | B .046 ±.002 [1.17 ±0.05mm] | 400-1000 CMA |
| | | C NOT | USED |
| | | D NOT | USED |
| CRIMP | SIZE | TYPE | RANGE |
| WIRE | .090 [2.29mm] | F | 400-1600 CMA |
| INSUL | .140 [3.56mm] | F | .060-.100 |
| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPL INSTRUCTION |
| - | 114-02019 | .935 | 408-8039 |
| | | SET UP GAGE | LAYOUT |
| | | 458638-1 | 778-C |

| QTY | REQD | PER | ASSY | PART NO | DESCRIPTION | ITEM NO | |
|-----|------|-----|------|----------|-------------|---------------------------------|---------|
| | | | | | | 129 | |
| | | | | | | 128 | |
| 2 | - | 2 | - | C | 4-354779-2 | PIN, WIRE DISC (.3200)B | 127 |
| 2 | - | 2 | - | C | 3-354779-4 | PIN, WIRE DISC (.3160)A | 126 |
| 1 | - | 1 | - | A | 986950-1 | WASHER, FLAT PRECISION | 125 |
| | | | | | | 124 | |
| | | | | | | 123 | |
| | | | | | | 122 | |
| | | | | | | 121 | |
| | | | | | | 120 | |
| | | | | | | 119 | |
| | | | | | | 118 | |
| | | | | | | 117 | |
| | | | | | | 116 | |
| | | | | | | 115 | |
| | | | | | | 114 | |
| 2 | - | 2 | - | A | 21024-5 | WASHER, LOCK (#10) AIR ASSY | 113 |
| | | | | | | 112 | |
| | | | | | | 111 | |
| 7 | - | 7 | - | A | 21024-4 | WASHER, LOCK (NO.8) SHEAR BL | 110 |
| | | | | | | 109 | |
| 2 | - | 2 | - | A | 21018-4 | NUT, HEX (4-40) DRAG | 108 |
| | | | | | | 107 | |
| | | | | | | 106 | |
| 2 | - | 2 | - | A | 21022-2 | NUT, HEX 5L (8-32) DRAG STUD | 105 |
| | | | | | | 104 | |
| | | | | | | 103 | |
| 2 | - | 2 | - | A | 2-21006-6 | SCR, SKT SET (4-40x.62) DRAG | 102 |
| 1 | - | 1 | - | A | 21009-2 | SCR, SKT SET (1/4-20x.25) RAM | 101 |
| 2 | - | 2 | - | A | 21017-2 | SCR, DRIVE (#2x.19) ID PLATE | 100 |
| | | | | | | 99 | |
| 1 | - | 1 | - | B | 461264-1 | PLATE, IDENTIFICATION | 98 |
| | | | | | | 97 | |
| | | | | | | 96 | |
| 2 | - | 2 | - | A | 2-21002-4 | SCR, BHC (8-32x.75) STRIPPER | 95 |
| 4 | - | 4 | - | A | 2-21002-9 | SCR, BHC (10-32x.75) CAP | 94 |
| 1 | - | 1 | - | A | 22733-8 | SCR, BHC (8-32x.38 LW) ANVIL | 93 |
| 4 | - | 4 | - | A | 3-21002-3 | SCR, BHC (1/4-20x.50) ST 6D PL | 92 |
| 3 | - | 3 | - | A | 2-22733-8 | SCR, BHC (1/4-20x.62) H5G | 91 |
| | | | | | | 90 | |
| | | | | | | 89 | |
| | | | | | | 88 | |
| 2 | - | 2 | - | A | 2-21000-7 | SCR, SHC (8-32x.50) SLUG BLADE | 87 |
| 3 | - | 3 | - | A | 2-21000-6 | SCR, SHC (8-32x.38) STRIP GUIDE | 86 |
| 2 | - | 2 | - | A | 2-21000-9 | SCR, SHC (8-32x.75) STRIP GUIDE | 85 |
| | | | | | | 84 | |
| | | | | | | 83 | |
| | | | | | | 82 | |
| | | | | | | 81 | |
| 2 | - | 2 | - | A | 3-21002-0 | SCR, BHC (10-32x.88) SHEAR PL | 80 |
| - | - | 1 | - | A | 455750-8 | GUARD ASSY | 79 |
| REF | - | - | - | A | 679532-1 | INSERT, GUARD | 78 |
| | | | | | | 77 | |
| | | | | | | 76 | |
| | | | | | | 75 | |
| 1 | - | 1 | - | A | 690603-1 | SPRING, ASSIST | 74 |
| 1 | - | 1 | - | A | 23030-1 | SCR, SKT CAP (6-32x.25) CP DSC | 73 |
| | | | | | | 72 | |
| | | | | | | 71 | |
| -3 | - | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
| | | | | | | | |

| QTY | REQD | PER | ASSY | PART NO | DESCRIPTION | ITEM NO | |
|-----|------|-----|------|---------------|-------------|------------------------------|---------|
| -1 | - | - | - | BENCH MODEL K | AIRFEED | 70 | |
| - | - | - | - | - | - | 68 | |
| -3 | - | - | - | BENCH MODEL G | AIRFEED | 67 | |
| | | | | | | 66 | |
| | | | | | | 65 | |
| | | | | | | 64 | |
| | | | | | | 63 | |
| | | | | | | 62 | |
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| | | | | | | 60 | |
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| | | | | | | 51 | |
| | | | | | | 50 | |
| | | | | | | 49 | |
| 1 | - | - | - | A | 22374-7 | VALVE, QUICK EXHAUST | 48 |
| 1 | - | - | - | A | 22304-1 | NIPPLE, HEX 1/8 NPT | 47 |
| | | | | | | 46 | |
| | | | | | | 45 | |
| 1 | - | 1 | - | A | 690191-1 | PLUG, NYLON | 44 |
| 1 | - | 1 | - | C | 455674-1 | RAM | 43 |
| 1 | - | 1 | - | A | 690125-1 | WASHER, LAMINATED | 42 |
| 1 | - | 1 | - | A | 690124-1 | WASHER, RAM | 41 |
| 1 | - | 1 | - | A | 690686-1 | BOLT, CRIMPER (5/16-24x1.00) | 40 |
| 1 | - | 1 | - | A | 23241-6 | BALL, STEEL | 39 |
| 1 | - | 1 | - | A | 690170-1 | SPRING, COMPRESSION | 38 |
| 1 | - | 1 | - | C | 690142-1 | DISC, INSULATION | 37 |
| 1 | - | 1 | - | D | 354777-1 | WIRE DISC, PLASTIC | 36 |
| 1 | - | 1 | - | A | 22480-5 | WASHER, SPRING | 35 |
| 1 | - | 1 | - | B | 690212-1 | POST, RAM | 34 |
| 1 | - | 1 | - | A | 240639-4 | STRIPPER, FRONT | 33 |
| | | | | | | 32 | |
| | | | | | | 31 | |
| | | | | | | 30 | |
| | | | | | | 29 | |
| 1 | - | 1 | - | B | 690451-8 | SPACER, STRIPPER | 28 |
| | | | | | | 27 | |
| 1 | - | 1 | - | D | 455676-1 | PLATE, BASE | 26 |
| 2 | - | 2 | - | A | 22354-8 | DRAG, STUD | 25 |
| 1 | - | 1 | - | B | 455678-1 | PLATE, STRIP GUIDE | 24 |
| 1 | - | 1 | - | C | 240825-3 | PLATE, STRIP HOLD DOWN | 23 |
| 2 | - | 2 | - | A | 4-22281-1 | SPRING, DRAG | 22 |
| | | | | | | 21 | |
| 1 | - | 1 | - | A | 454177-1 | DRAG, STOCK | 20 |
| | | | | | | 19 | |
| 2 | - | 2 | - | C | 454204-4 | GUIDE, STRIP (FRONT) | 18 |
| | | | | | | 17 | |
| | | | | | | 16 | |
| | | | | | | 15 | |
| | | | | | | 14 | |
| | | | | | | 13 | |
| | | | | | | 12 | |
| 1 | - | 1 | - | B | 240644-1 | PLATE, REAR SHEAR | 11 |
| | | | | | | 10 | |
| 1 | - | 1 | - | B | 690482-5 | PLATE, FRONT SHEAR | 9 |
| 1 | - | 1 | - | D | 1-459866-1 | ANVIL | 8 |
| 1 | - | 1 | - | B | 3-690474-7 | BLADE, SLUG | 7 |
| 1 | - | 1 | - | B | 4-240641-9 | SPACER, SLUG BLADE | 6 |
| 1 | - | 1 | - | B | 217573-1 | TOOL, SIZING | 5 |
| 1 | - | 1 | - | B | 238009-8 | SPACER, BLOCK CRIMPER | 4 |
| 1 | - | 1 | - | C | 7-456134-7 | CRIMPER, INSULATION | 3 |
| 1 | - | 1 | - | B | 1-455888-5 | SPACER, CRIMPER | 2 |
| 1 | - | 1 | - | C | 462808-5 | CRIMPER, WIRE | 1 |
| -3 | - | -1 | 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

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 4/26/95 APP 4-30-95
L. COLLINS T. BEDDICK
CHK 4-30-95 REL 5/31/95
C. ERISMAN B. MORGAN

AMP AMP Incorporated Harrisburg, PA 17105-3608

NAME END FEED HDM APPLICATOR MACHINE REF MINI APPL
SCALE - DWG NO 567248 SHEET 1 OF 1 REV G3

CASE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO

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LOC A
DIST 66