



- 1 RECOMMENDED SPARE PARTS.
- 2 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 3 SEE DRAWING FOR COMPONENTS.
- 4 RECOMMENDED SET UP WIRE FOR TERMINAL 41899. FOR APPLICATOR QUALIFICATION ONLY.
- 5 USE MANUAL PRECISION ADJUSTMENT LEVER ON G TERMINATOR TO ACHIEVE PROPER CRIMP HEIGHT.
- 6 SOLID WIRE ON BOTTOM
- 7 ITEM NOT SHOWN.
- 8 ITEM 81 IS ATTACHED TO THE G TERMINATOR GUARD DOOR WITH ITEM 80.
- 9 CRIMPER BOLT MUST BE LOOSENED TO CHANGE CRIMP HEIGHT ADJUSTING WHEEL. BE SURE TO SEAT THE CRIMPER AGAINST THE ADJUSTING WHEEL AND REALIGN THE TOOLING.
- 10 THIS APPLICATOR HAS A THICKER WIRE CRIMPER FOR GERMAN CUSTOMERS.

WIRE COMBINATION DATA			
REF PAD LTR	REF CRIMP HEIGHT	MAG STRANDED WIRE	WIRE
7	.079	(1)17 & (1)16	
5	.064	(1)21 & (1)20	

TERMINAL NAME: AMPLIVAR THRU SPLICE		CRIMPING DATA	
REF PAD LTR	CRIMP HEIGHT	WIRE COMBINATION	
41765			
41899			
42119			
140778	7 .079 ±.002 [2.0 ±0.05mm]	4000-5000 CMA	
140837	6 .074 ±.002 [1.88 ±0.05mm]	3000-4000 CMA	
	6 .069 ±.002 [1.75 ±0.05mm]	2000-3000 CMA	
	5 .064 ±.002 [1.63 ±0.05mm]	1500-2000 CMA	
	CRIMP SIZE TYPE RANGE		
	WIRE .110 [2.79mm] F	1500-5000 CMA	
	INSUL		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
.279-.341	114-2009	.315	408-8039
			SET UP GAGE LAYOUT

TERMINAL NAME: AMPLIVAR THRU SPLICE		CRIMPING DATA	
REF PAD LTR	CRIMP HEIGHT	WIRE COMBINATION	
42076			
42192			
140723			
140780	5 .064 ±.002 [1.63 ±0.05mm]	2600-3000 CMA	
170152	5 .061 ±.002 [1.55 ±0.05mm]	1800-2600 CMA	
1217384	5 .057 ±.002 [1.45 ±0.05mm]	1000-1800 CMA	
	5 .053 ±.002 [1.35 ±0.05mm]	600-1000 CMA	
	CRIMP SIZE TYPE RANGE		
	WIRE .110 [2.79mm] F	600-3000 CMA	
	INSUL		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
.279-.341	114-2009	.270	408-8318 (-1) 408-127000 (-2)
			SET UP GAGE LAYOUT

QTY REQD PER ASSY	REF	DESCRIPTION	ITEM NO
2	2	M4 HEX NUT	118
2	2	M4 LOCK WASHER	117
2	2	M4 FLAT WASHER	116
1	1	THRU SPLICE IS SHEET-GII	115
-	-	GENERAL INSTRUCTION PACKAGE	114
-	-	SQUARE HD SCR	113
-	-	WASHER, LOCK (3/8)	112
-	-	WASHER,LOCK(NO.6)STR & SHR	111
-	-	WASHER,LOCK(NO.8)SHEAR BL	110
-	-	WASHER,LOCK(NO.10)	109
-	-	NUT,HEX SELF LKG(1/4-20)	108
-	-	NUT,HEX(8-32)DRAG	107
-	-	THRU SPLICE IS SHEET	106
-	-	THRU SPLICE IS SHEET	105
-	-	SCR,SKT,SET NYLON (6-32x.156)	104
-	-		103
-	-	SCR,SKT,SET CONE PT (8-32x.88)	102
2	2	SCR, SHC (M6x50)	101
-	-	SCR, SHC (M6x30)	100
-	-	PLATE, IDENTIFICATION	99
-	-	TAPE, POLYURETHANE	98
-	-	PLATE, IDENTIFICATION	97
-	-		96
-	-		95
-	-	SCR, SHC (10-32x.50)	94
-	-		93
-	-	SCR,BHC(1/4-20x.50)ST GD PL	92
-	-	SCR, SHC (1/4-20x.62) FEED BKT	91
-	-	SCR, BHC 8-32 X .25 LG.	90
-	-	SCR, BHC 6-32 X .25 LG.	89
-	-	SCR, SHC 6-32 X .38 LG.	88
-	-	SCR, BHC 8-32 X .75 LG.	87
-	-	SCR,SHC(1/4-20x1.25)DRAG & ARM	86
-	-	SCR, BHC 6-32 X .25 LG. LOCWEL	85
-	-	SCR, SHC 6-32 X .50 LG. LOCWEL	84
-	-		83
-	-		82
-	-	GUARD,APPLICATOR FEED	81
-	-	SCR,BHC10-32UNCX.50LG.	80
-	-	SCR,SHC(8-32X.50)ANVIL	79
-	-		78
-	-		77
-	-		76
-	-		75
-	-		74
-	-	SCR, BHC (2-56x.25) GUARD WINDOW	73
-	-	WINDOW, GUARD	72
-	-	SCR, SHC (3/8-16x.75) FEED ASSY	71
-78	-77	-2 -1	PART NO DESCRIPTION ITEM NO

TERMINAL NAME: AMPLIVAR THRU SPLICE		CRIMPING DATA			
REF PAD LTR	CRIMP HEIGHT	WIRE COMBINATION			
2	2	1-18023-3	SCR, SHC, M4 X 16	70	
2	2	18024-6	SCR, BHC, M4 X 8	69	
1	1	2168489-1	ACTUATOR, SPARE MCI	68	
1	1	2161273-1	GUARD, END FEED INSERT	67	
1	1	2161272-1	GUARD, END FEED	66	
-	-	460277-1	AIR FEED ASSY	65	
-	-			64	
-	-	980285-2	ELBOW, SWIVEL (1 1/8NPT-1/4T)	63	
-	-	23238-1	QUICK DISCONNECT	62	
-	-	12.0012.00	TUBING, POLY-FLO Ø.25	61	
-	-			60	
-	-	1338207-1	BRACKET, FEED EXT	59	
-	-	1338208-1	BRACKET, FEED	58	
-	-			57	
-	-			56	
-	-			55	
-	-			54	
-	-	460680-1	FEED FINGER ASSY	53	
-	-			52	
-	-			51	
-	-			50	
-	-			49	
-	-	22374-7	VALVE, QUICK EXHAUST	48	
-	-	22304-1	NIPPLE, HEX 1/8 NPT	47	
-	-			46	
-	-			45	
-	-			44	
-	-			43	
-	-			42	
-	-	7-21002-6	BOLT, CRIMPER(5/16-24x.75)	41	
-	-			40	
-	-			39	
-	-			38	
-	-			37	
-	-			36	
-	-			35	
-	-			34	
-	-			33	
-	-			32	
-	-			31	
-	-	18027-4	WASHER, FLAT M6	30	
-	-	2-18023-9	SCR,SHC M6 X 20	29	
-	-	3-690451-3	SPACER	28	
-	-	240639-1	STRIPPER	27	
-	-	1424318-1	PLATE, BASE	26	
-	-			25	
-	-	458412-3	PLATE, STRIP GUIDE	24	
-	-			23	
-	-	3-22283-0	SPRING, DRAG	22	
-	-			21	
-	-	458403-1	DRAG, STOCK	20	
-	-	458406-8	GUIDE, STRIP (REAR)	19	
-	-	458404-9	GUIDE, STRIP (FRONT)	18	
-	-			17	
-	-	1424330-1	GUIDE, TERMINAL	16	
-	-	1424334-1	REAR STRIPPER	15	
-	-	27058-2	PLUNGER, SPRING, STUBBY	14	
-	-	21004-9	SCR, SHLD .31 DIA X .50 LG.	13	
-	-	1338124-1	WHEEL, ADJUSTING	12	
-	-	1424319-1	ANVIL	11	
-	-	1424335-6	SHEAR	10	
-	-	458409-5	HOLDER, SHEAR	9	
-	-	6-22282-8	SPRING, SHEAR RETURN	8	
-	-	1424322-1	BLOCK, SHEAR DEPRESSOR	7	
-	-			6	
-	-	1338212-1	HOLDER, TOOL	5	
-	-	690461-4	SCREW, SHEAR STOP	4	
-	-			3	
-	-			2	
-1	-1	1	1-1338223-6	CRIMPER, WIRE, MODIFIED	1
-78	-77	-2 -1	PART NO DESCRIPTION ITEM NO		

THIS DRAWING IS A CONTROLLED DOCUMENT.

DATE: 31JAN03	BY: C. CRISMAN	TE Connectivity
DATE: 31JAN03	CHK: C. CRISMAN	Harrisburg, PA 17105-3608
DATE: 31JAN03	APP: T. ELBIN	
PRODUCT SPEC: -	APPLICATION SPEC: -	SIZE: A1
WEIGHT: -	SCALE: -	SHEET 1 OF 1
CUSTOMER DRAWING	DRAWING NO: 566423	REV: B