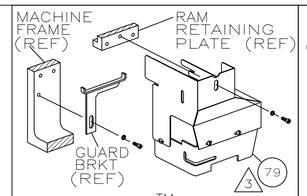
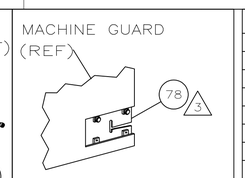
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION -,- .
© COPYRIGHT - BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

PART NUMBER	REV	FIRST USED
1852598-1	A	122500-1
1852598-2	A	565435-5



AMP-O-LECTRIC™ TERM GUARD



G TERMINATOR GUARD

TERMINAL NAME: FLAG

1544114

AMP TERMINAL AMP CRIMP SPECS		
PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.087 ±.002 [2.21 ±0.05mm]	12 AWG
B	.076 ±.002 [1.93 ±0.05mm]	14 AWG
C	.067 ±.002 [1.70 ±0.05mm]	16 AWG
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.125 [3.18mm]	F	12-16
INSUL	.180 [4.57mm]	F	2.4-3.5mm 7

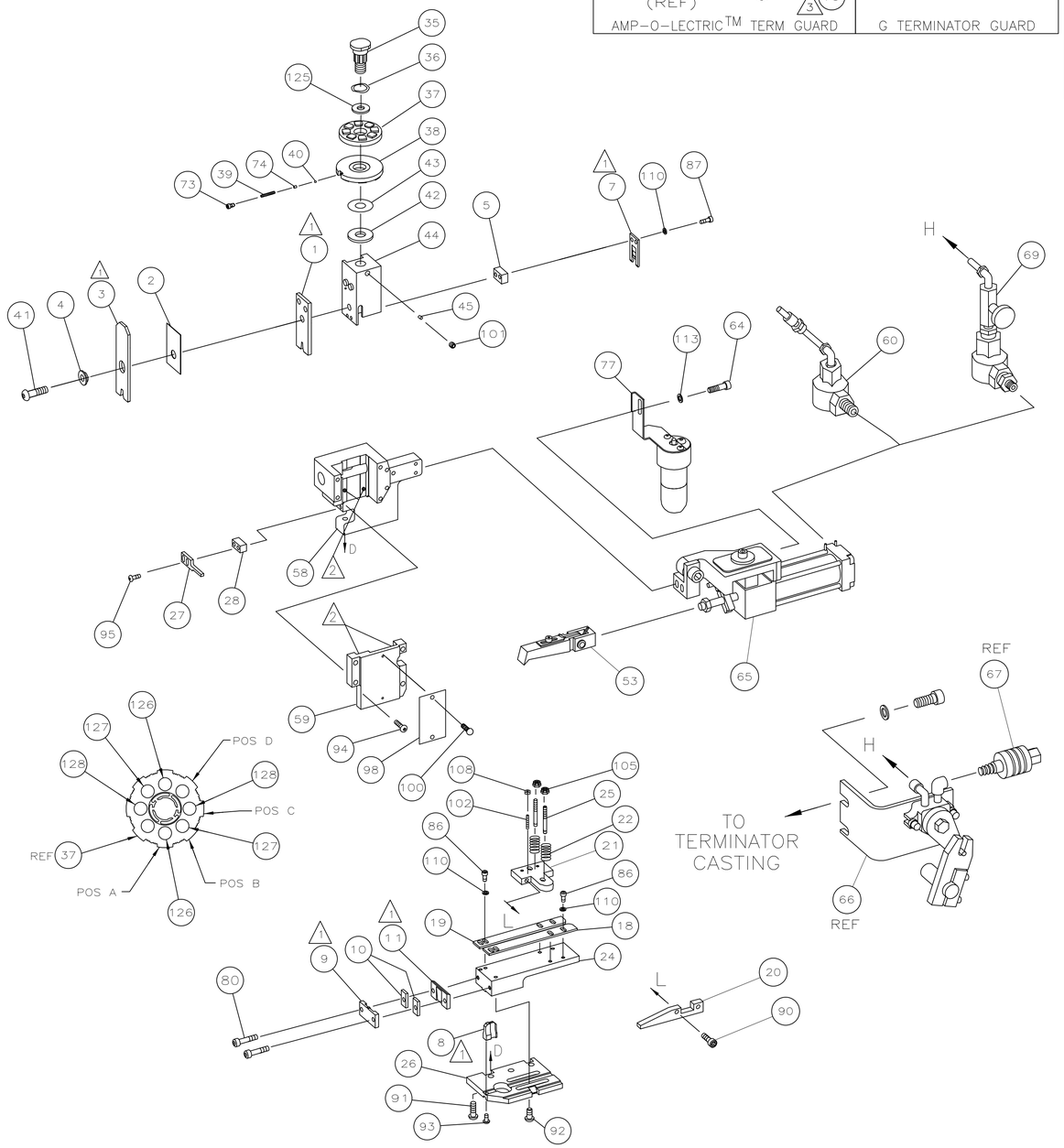
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.236-.252	NONE	.728	408-8039	458638-1	L2689

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	ORIGINAL	-	-	-

-1	LEADMAKER & BENCH MODEL G	AIR FEED
-2	BENCH MODEL K	AIR FEED



	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
						129
	2	2	-	354779-8	PIN, WIRE DISC (.3030)C	128
	2	2	-	8-354778-7	PIN, WIRE DISC (.2930)B	127
	2	2	-	6-354778-7	PIN, WIRE DISC (.2830)A	126
	1	1	-	986950-1	WASHER, FLAT PRECISION	125
	1	1	-	217238-1	GENERAL INSTRUCTION PACKAGE	124
	1	1	-	4088039	EF APPL INST 408-8039	123
						122
						121
						120
						119
						118
						117
						116
						115
						114
	2	2	-	21024-5	WASHER,LOCK(#10)AIR ASSY	113
						112
						111
	4	4	-	21024-4	WASHER,LOCK(NO.8)SHEAR BL	110
						109
	2	2	-	21018-4	NUT,HEX(4-40)DRAG	108
						107
						106
	2	2	-	21022-2	NUT,HEX SL(8-32)DRAG STUD	105
						104
						103
	2	2	-	2-21006-6	SCR,SKT SET(4-40x.62)DRAG	102
	1	1	-	21009-2	SCR,SKT SET(1/4-20x.25)RAM	101
	2	2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE	100
						99
	1	1	-	461264-1	PLATE, IDENTIFICATION	98
						97
						96
	2	2	-	2-21002-2	SCR,BHC(8-32x.50)STRIPPER	95
	4	4	-	2-21002-9	SCR,BHC(10-32x.75)CAP	94
	1	1	-	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	93
	4	4	-	3-21002-3	SCR,BHC(1/4-20x.50)ST GD PL	92
	3	3	-	2-22733-8	SCR,BHC(1/4-20x.62)HSG	91
	2	2	-	1-21000-3	SCR,SHC(4-40X.25)DRAG	90
						89
						88
	2	2	-	2-21000-6	SCR,SHC(8-32x.38)SLUG BLADE	87
	4	4	-	2-21000-6	SCR,SHC(8-32x.38)STRIP GUIDE	86
						85
						84
						83
						82
						81
	2	2	-	3-21002-0	SCR,BHC(10-32x.88)SHEAR PL	80
3	1	-	-	455750-8	GUARD ASSY	79
5 3	-	REF	-	679532-1	INSERT, GUARD	78
	1	-	-	465184-9	LUBRICATOR ASSY	77
						76
						75
	1	1	-	690603-1	SPRING, ASSIST	74
	1	1	-	23030-1	SCR,SKT CAP(6-32x.25)CP DSC	73
						72
						71

QTY REQD PER ASSY — PARTS LIST

	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
						70
4	1	-	-	692655-5	AIR FEED VALVE ASSY	69
						68
	REF	-	-	24042-2	VALVE, SHUT OFF	67
4	REF	-	-	692655-6	AIR FEED VALVE ASSY	66
	1	1	-	460277-1	AIR FEED ASSY (1 INCH)	65
	2	2	-	3-21000-9	SCR,SHC(10-32x1.00)AIR ASSY	64
						63
						62
						61
4	-	1	-	692655-7	AIR FEED VALVE ASSY	60
	1	1	-	454220-1	CAP, RAM	59
	1	1	-	453736-1	HOUSING	58
						57
						56
						55
						54
4	1	1	-	2-460680-3	FEED FINGER ASSY	53
						52
						51
						50
						49
						48
						47
						46
	1	1	-	690191-1	PLUG, NYLON	45
	1	1	-	455674-2	RAM	44
	1	1	-	690125-1	WASHER, LAMINATED	43
	1	1	-	690124-1	WASHER, RAM	42
	1	1	-	7-21002-9	BOLT, CRIMPER(5/16-24x1.00)	41
	1	1	-	23241-6	BALL, STEEL	40
	1	1	-	690170-1	SPRING, COMPRESSION	39
	1	1	-	690142-3	DISC, INSULATION	38
	1	1	-	354777-1	WIRE DISC, PLASTIC	37
	1	1	-	22480-5	WASHER, SPRING	36
	1	1	-	690212-1	POST, RAM	35
						34
						33
						32
						31
						30
						29
	1	1	-	3-690451-7	SPACER, STRIPPER	28
	1	1	-	240639-4	STRIPPER	27
	1	1	-	455676-1	PLATE, BASE	26
	2	2	-	22354-8	DRAG, STUD	25
	1	1	-	856076-1	PLATE, STRIP GUIDE	24
						23
	2	2	-	3-22281-5	SPRING, DRAG	22
	1	1	-	464451-5	ARM, STOCK DRAG	21
	1	1	-	464452-4	DRAG, STOCK	20
	1	1	-	1338002-1	GUIDE, STRIP (REAR)	19
	1	1	-	1338003-4	GUIDE, STRIP (FRONT)	18
						17
						16
						15
						14
						13
						12
1	1	1	-	240644-1	PLATE, REAR SHEAR	11
	2	2	-	6-240645-0	SPACER, SHEAR PLATE	10
	1	1	-	1-240642-1	PLATE, FRONT SHEAR	9
1	1	1	-	9-461295-1	ANVIL	8
	1	1	-	1633043-1	BLADE, SLUG	7
						6
	1	1	-	2-240641-1	SPACER, SLUG BLADE	5
	1	1	-	238009-4	SPACER, BLOCK CRIMPER	4
	1	1	-	6-1213077-6	CRIMPER, INSULATION	3
	1	1	-	2-455888-7	SPACER, CRIMPER	2
1	1	1	-	9-568176-5	CRIMPER, WIRE	1

QTY REQD PER ASSY — PARTS LIST

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. ITEM 78 USED WITH G TERMINATOR ONLY.
6. FEED OFF INSULATION BARREL.
7. INSULATION CRIMP HEIGHT MUST BE HELD; SEE SPEC.

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ± -
1 PLC ± -
2 PLC ± .25
3 PLC ± -
4 PLC ± -
ANGLES ± -

MATERIAL -
FINISH -

DWN M.YOUNGER 18DEC2007
CHK -
APVD T.ELBIN 11JUL02
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

Tyco Electronics
Tyco Electronics Corporation
Harrisburg, PA 17105-3608

NAME END FEED HDM APPLICATOR

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1852598	-

CUSTOMER DRAWING — SCALE - — SHEET 1 OF 1 — REV A

AMP 4805 REV 31MAR2000

18DEC2007 11:21am