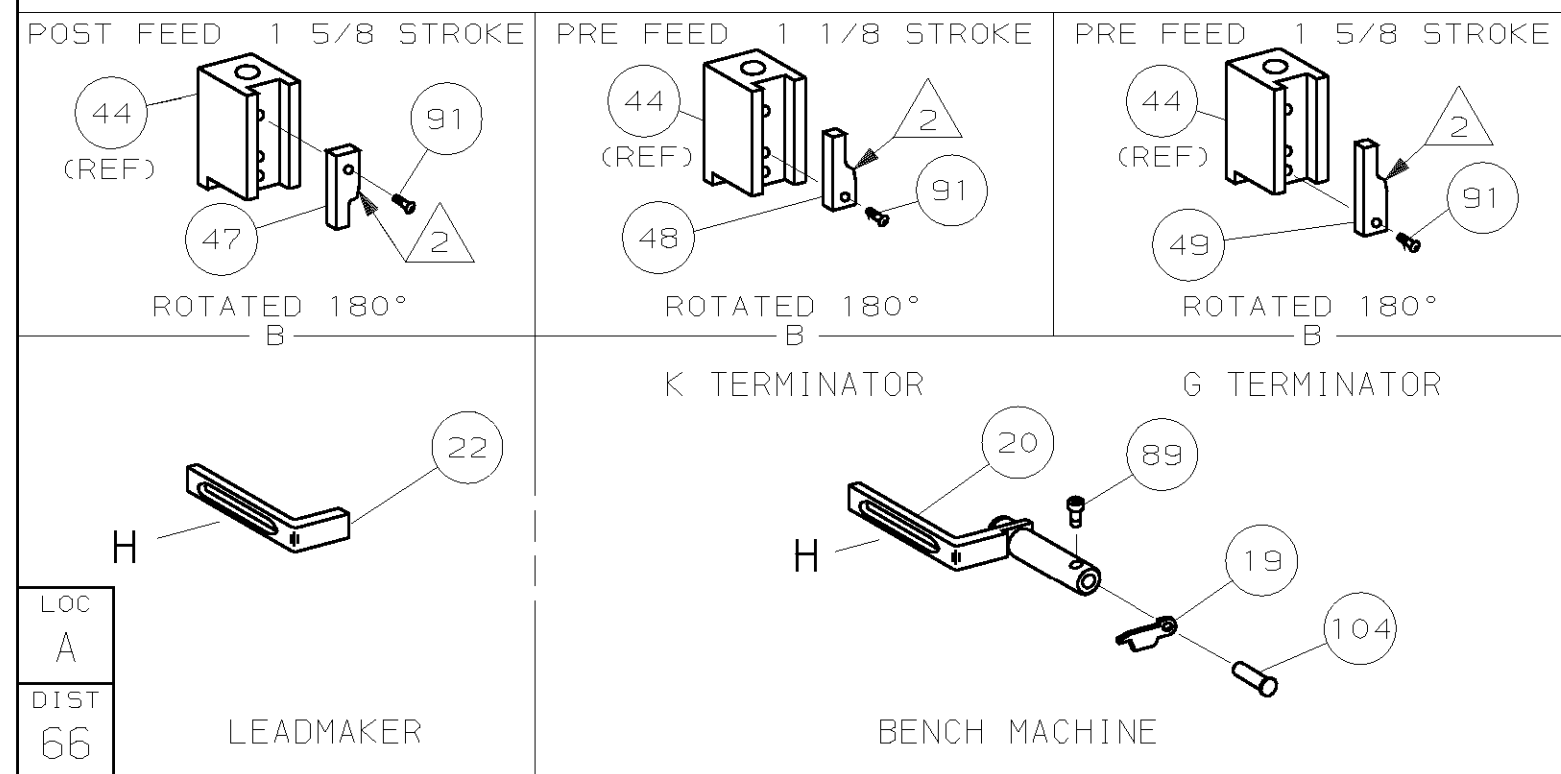
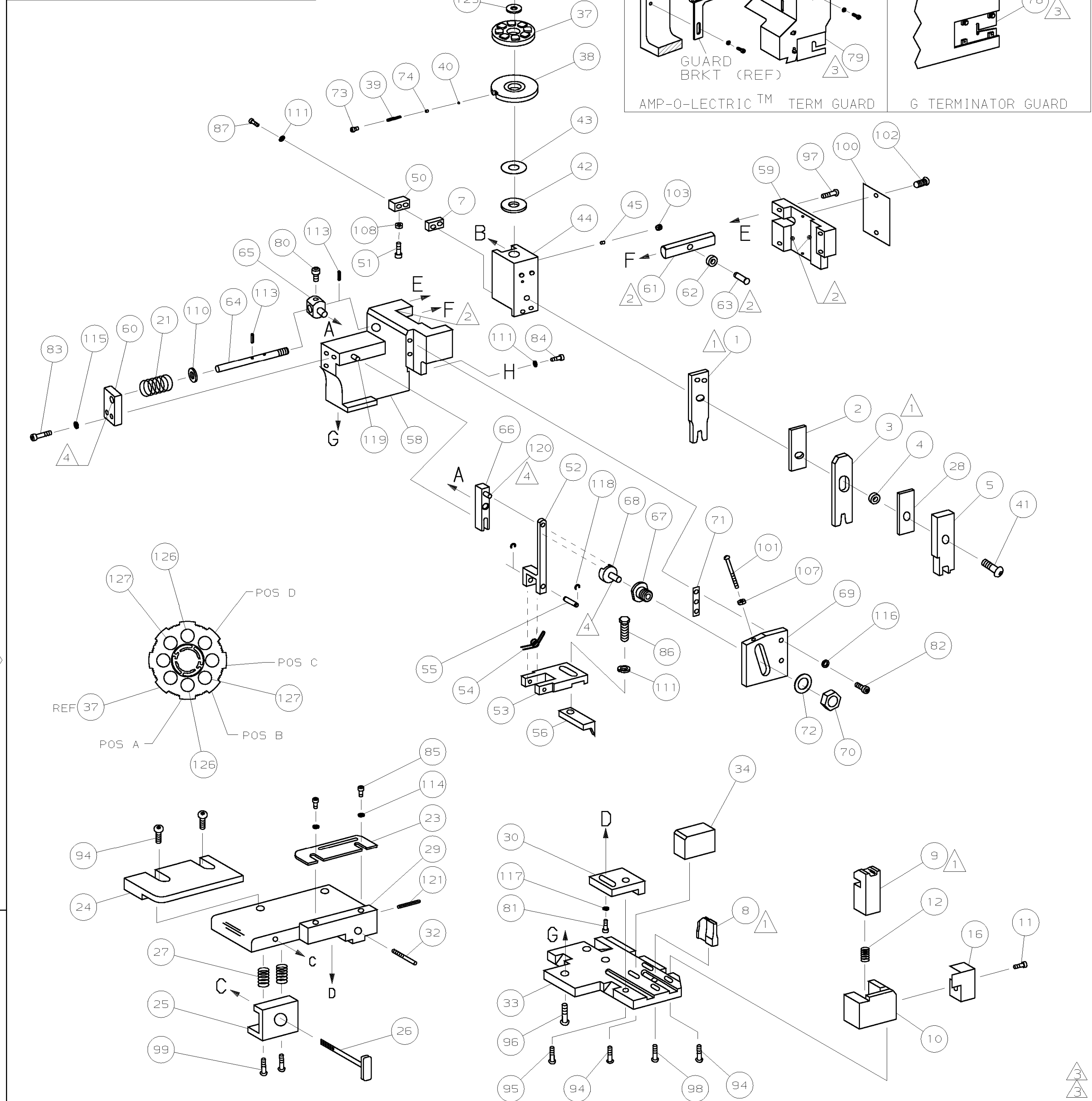


PART NUMBER	REV	FIRST USED
1385197-1	A	122500-1
1385197-2	A	565435-5
1385197-3	A	354500-1



- 1 RECOMMENDED SPARE PARTS.
2 GREASE LIGHTLY.
3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
4 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.

TERMINAL NAME: CONTACT ASSEMBLY, SOCKET ECU1 GENERATION II										
776326-2				AMP TERMINAL AMP CRIMP SPECS						
				PAD LTR	CRIMP HEIGHT			WIRE SIZE		
				A	.059 ±.002 [1.50 ±0.05mm]			16		
				B	.054 ±.002 [1.37 ±0.05mm]			18		
				C	NOT			USED		
				D	NOT			USED		
				CRIMP	SIZE		TYPE	RANGE		
				WIRE	.073 [1.88mm]		F	18-16		
				INSUL	.100 [2.54mm]		0	2.0-2.5mm		
WIRE STRIP LENGTH .193-.209			TERM APPL SPEC 114-6071		FEED .318		APPL INSTRUCTION 408-8040		SET UP GAGE 458637-1	LAYOUT L2456
										129
										128
2	2	2	-	C	1-354779-9	PIN, WIRE DISC (.3085)B				127
2	2	2	-	C	354779-6	PIN, WIRE DISC (.3020)A				126
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION				125
1	1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE				124
1	1	1	-	-	4088040	SF APPL INST 408-8040				123
										122
1	1	1	-	A	4-21028-0	PIN,SLT SPR(Ø.093x.75)ST GDE PL				121
REF	REF	REF	-	A	1-21030-1	PIN,DOWEL (Ø.187x.50)LEVER				120
REF	REF	REF	-	A	1-21030-6	PIN,DOWEL (Ø.187x1.25)HOUSING				119
REF	REF	REF	-	A	21045-3	RING,RET "C"(Ø.187)FD FING PIN				118
1	1	1	-	A	21024-5	WASHER, LOCK (#10)ADJ BLOCK				117
REF	REF	REF	-	A	21024-5	WASHER,LOCK (#10)ADJ PLATE				116
REF	REF	REF	-	A	21024-5	WASHER,LOCK (#10)FEED GDE ROD				115
2	2	2	-	A	21024-2	WASHER,LOCK (#4)FRONT STP GUIDE				114
REF	REF	REF	-	A	5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD				113
										112
4	4	4	-	A	21024-4	WASHER, LOCK (#8)STRIPPER				111
REF	REF	REF	-	A	21899-4	WASHER,FLAT (Ø5/16)SCREW ADJ				110
										109
1	1	1	-	A	21018-5	NUT, HEX (NO.6)HOLDDOWN				108
REF	REF	REF	-	A	21068-5	NUT, HEX (6-32)FEED ADJ				107
										106
										105
1	1	-	-	A	992031-1	PIN, CLEVIS				104
1	1	1	-	A	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM				103
2	2	2	-	A	21017-2	SCR,DRIVE (#2x.19)ID PLATE				102
REF	REF	REF	-	A	6-23715-5	SCR,PAN HD (6-32x1.50)FEED ADJ				101
1	1	1	-	B	461264-1	PLATE, IDENTIFICATION				100
2	2	2	-	A	3-21002-0	SCR,BHC (10-32x.88)DRAG				99
1	1	1	-	A	22733-8	SCR,BHC (8-32x.38 LW)ANVIL				98
REF	REF	REF	-	A	2-21002-9	SCR,BHC (10-32x.75)CAP				97
REF	REF	REF	-	A	2-22733-8	SCR,BHC (1/4-20x.62)HOUSING				96
REF	REF	REF	-	A	2-21002-7	SCR,BHC (10-32x.50)SG ADJ BLOCK				95
6	6	6	-	A	2-21002-2	SCR,BHC (8-32x.50)TERM H DWN				94
										93
										92
1	1	1	-	A	1-21002-7	SCR,BHC (6-32x.38)CAM				91
										90
1	1	-	-	A	7-21000-9	SCR,SHC (4-40x.19)STRIPPER				89
										88
2	2	2	-	A	2-21000-8	SCR,SHC (8-32x.58)DEP-HOLD				87
1	1	1	-	A	2-22603-0	SCR,HEX HD (8-32x.31)FEED FINGER				86
2	2	2	-	A	1-21000-3	SCR,SHC (4-40x.25)F ST GUIDE				85
1	1	1	-	A	2-21000-7	SCR,SHC (8-32x.50)STRIPPER				84
REF	REF	REF	-	A	3-21000-7	SCR,SHC (10-32x.75)FEED ROD GD				83
REF	REF	REF	-	A	3-21000-6	SCR,SHC (10-32x.62)FD ADJ BLK				82
1	1	1	-	A	3-21000-4	SCR,SHC (10-32x.38)SG ADJ BL				81
REF	REF	REF	-	A	3-21000-4	SCR,SHC (10-32x.38)PIVOT BLK				80
-	REF	-	-	B	455749-1	GUARD, WINDOW				79
REF	-	-	-	B	679532-1	INSERT, GUARD				78
										77
										76
										75
1	1	1	-	A	690603-1	SPRING, ASSIST				74
1	1	1	-	A	23030-1	SCR,SHC (6-32x.25 SL)INS DISC				73
REF	REF	REF	-	A	458109-1	WASHER, SPECIAL				72
REF	REF	REF	-	A	690517-1	SPACER				71
-3	-2	-1	U/M	DWG SIZE	PART NO		DESCRIPTION			ITEM NO
QTY RECD PER ASSY				PARTS LIST						

-1 LEADMAKER					MECH POST FEED						
-2 BENCH MODEL K					MECH PRE FEED						
-3 BENCH MODEL G					MECH PRE FEED						
REF	REF	REF	-	B	22594-8	NUT, HEX (1/2-20)				70	
REF	REF	REF	-	B	240628-1	PLATE, ADJUSTMENT				69	
REF	REF	REF	-	B	240626-1	SHAFT, PIVOT				68	
REF	REF	REF	-	B	240633-1	BUSHING				67	
REF	REF	REF	-	A	455680-1	LEVER, INTERMEDIATE				66	
REF	REF	REF	-	B	240629-1	BLOCK, PIVOT				65	
REF	REF	REF	-	A	240632-2	SCREW, ADJ FEED ROD				64	
REF	REF	REF	-	B	240659-3	PIN, CAM ROLLER				63	
REF	REF	REF	-	B	240658-1	ROLLER, CAM				62	
REF	REF	REF	-	B	454398-2	ROD, FEED				61	
REF	REF	REF	-	A	454178-1	GUIDE, FEED ROD				60	
REF	REF	REF	-	C	454220-1	CAP, RAM				59	
REF	REF	REF	-	D	454485-1	HOUSING				58	
										57	
1	1	1	-	B	690542-2	PAWL, FEED				56	
REF	REF	REF	-	B	240624-1	PIN, FEED FINGER				55	
REF	REF	REF	-	B	691499-1	SPRING, FEED FINGER				54	
REF	REF	REF	-	B	690541-1	HOLDER, FEED FINGER				53	
REF	REF	REF	-	A	455679-1	LEVER, TERMINAL FEED ARM				52	
1	1	1	-	A	811242-2	BUMPER, HOLDDOWN				51	
1	1	1	-	A	690753-1	SPACER, TONKER				50	
1	-	-	-	B	690602-6	CAM, PRE-FEED 1 5/8 ST				49	
-	1	-	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST				48	
-	-	1	-	B	690501-4	CAM, POST-FEED 1 5/8 ST				47	
1	1	1	-	B	459456-1	APPLICATOR, BASIC (SUBASSY)				46	
1	1	1	-	A	690191-1	PLUG, NYLON				45	
1	1	1	-	C	455673-1	RAM				44	
1	1	1	-	A	690125-1	WASHER, LAMINATED				43	
1	1	1	-	A	1-690124-4	WASHER, RAM				42	
1	1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)				41	
1	1	1	-	A	23241-6	BALL, STEEL				40	
1	1	1	-	A	690170-1	SPRING, COMPRESSION				39	
1	1	1	-	C	690142-1	DISC, INSULATION				38	
1	1	1	-	D	354777-1	WIRE DISC, PLASTIC				37	
1	1	1	-	A	22480-5	WASHER, SPRING				36	
1	1	1	-	B	690212-1	POST, RAM				35	
1	1	1	-	B	690786-6	SUPPORT, TERMINAL				34	
REF	REF	REF	-	D	455675-1	PLATE, BASE				33	
1	1	1	-	A	690432-3	SCREW, ADJUSTMENT				32	
										31	
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ				30	
1	1	1	-	C	455671-1	PLATE, STRIP GUIDE				29	
1	1	1	-	C	1-455888-0	SPACER, FRONT SHEAR DEP				28	
2	2	2	-	A	1-22284-0	SPRING, DRAG				27	
1	1	1	-	B	690546-1	LEVER, DRAG RELEASE				26	
1	1	1	-	B	240792-1	DRAG, TERMINAL				25	
1	1	1	-	D	6-690504-0	GUIDE, STRIP (REAR)				24	
1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)				23	
-	-	1	-	B	690472-2	STRIPPER				22	
REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN				21	
1	1	-	-	A	679218-1	STRIPPER WIRE STOP ASSY				20	
1	1	-	-	B	458949-1	STRIPPER				19	
										18	
										17	
1	1	1	-	B	318563-1	GUARD, CHIP, FRONT				16	
										15	
										14	
										13	
1	1	1	-	A	5-22280-0	SPRING, SHEAR				12	
1	1	1	-	B	690461-1	STOP, SHEAR				11	
1	1	1	-	C	690459-1	HOLDER, SHEAR (FRONT)				10	
1	1	1	-	C	1-454276-9	SHEAR, FLOAT (FRONT)				9	
1	1	1	-	C	1-318711-5	ANVIL				8	
1	1	1	-	C	1-240641-6	SPACER, DEPRESSOR (REAR)				7	
										6	
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)				5	
1	1	1	-	B	2-238011-2	SPACER, BLOCK CRIMPER				4	
1	1	1	-	C	5-456135-2	CRIMPER, INSULATION				3	
1	1	1	-	C	455888-9	SPACER, CRIMPER				2	
1	1	1	-	C	6-568176-4	CRIMPER, WIRE				1	
-3	-2	-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 ±- 3 PLC DEC ±- 4 PLC DEC ±- ANGLES ±- SURF TEXTURE: ✓ REMOVE BURRS, BREAK SHARP EDGES R.015 MAX					MATL		HT TR		FIN		
					-		-		-		-
					-		-		-		-
					-		-		-		-
DR B.HIGMAN		14NOV00		APP T.ELBIN		14NOV00		 AMP Incorporated Harrisburg, PA 17105-3608			
CHK 14NOV00		B.HIGMAN		REL -		-					
NAME					SIDE FEED HDM APPLICATOR					MACHINE REF	APPL
SCALE					1385197					SHEET 1 of 1	REV A
CAGE CODE 00779					CUSTOMER AND ASSEMBLY DRAWING					RESTRICTED TO -	

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