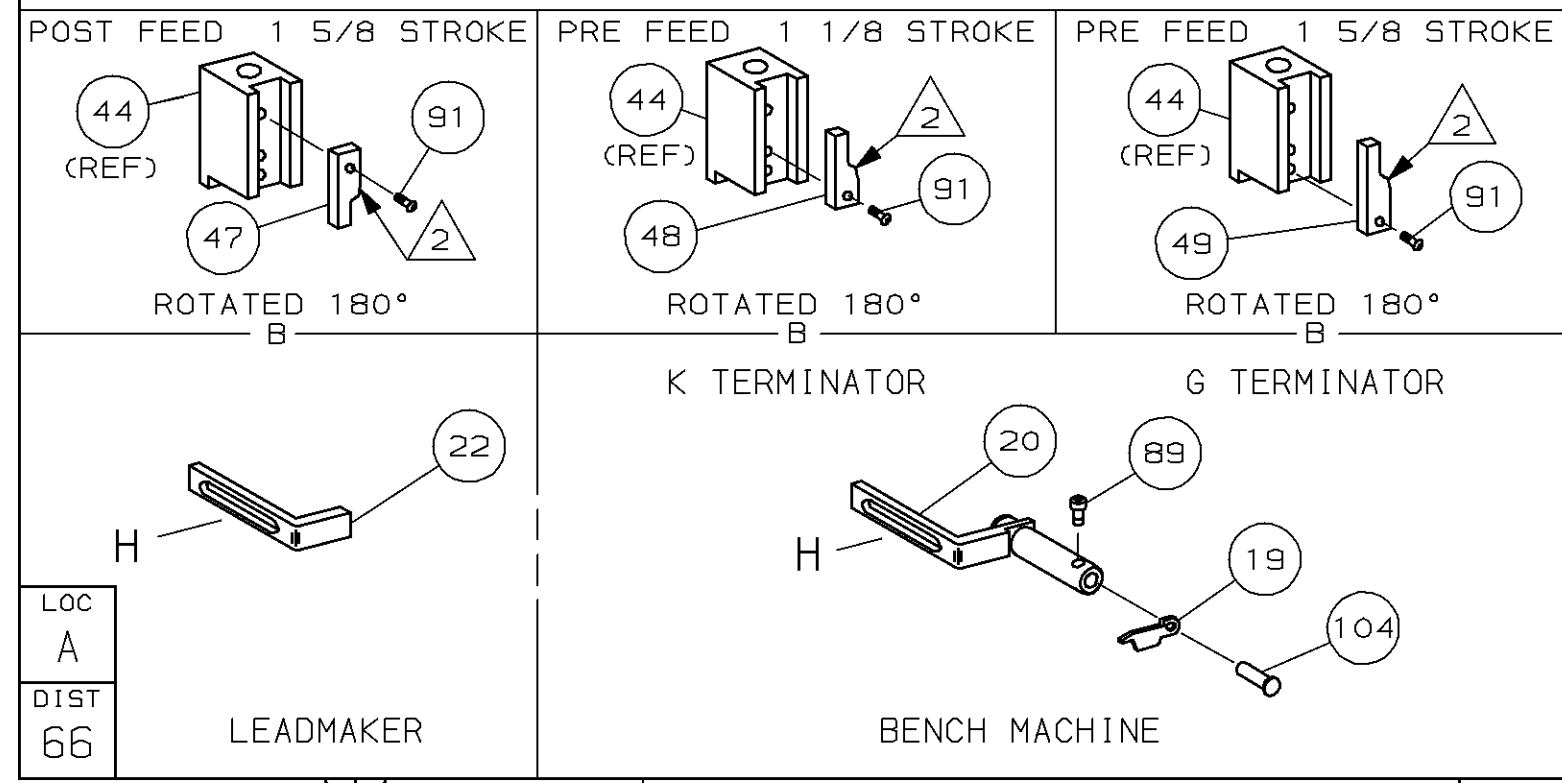
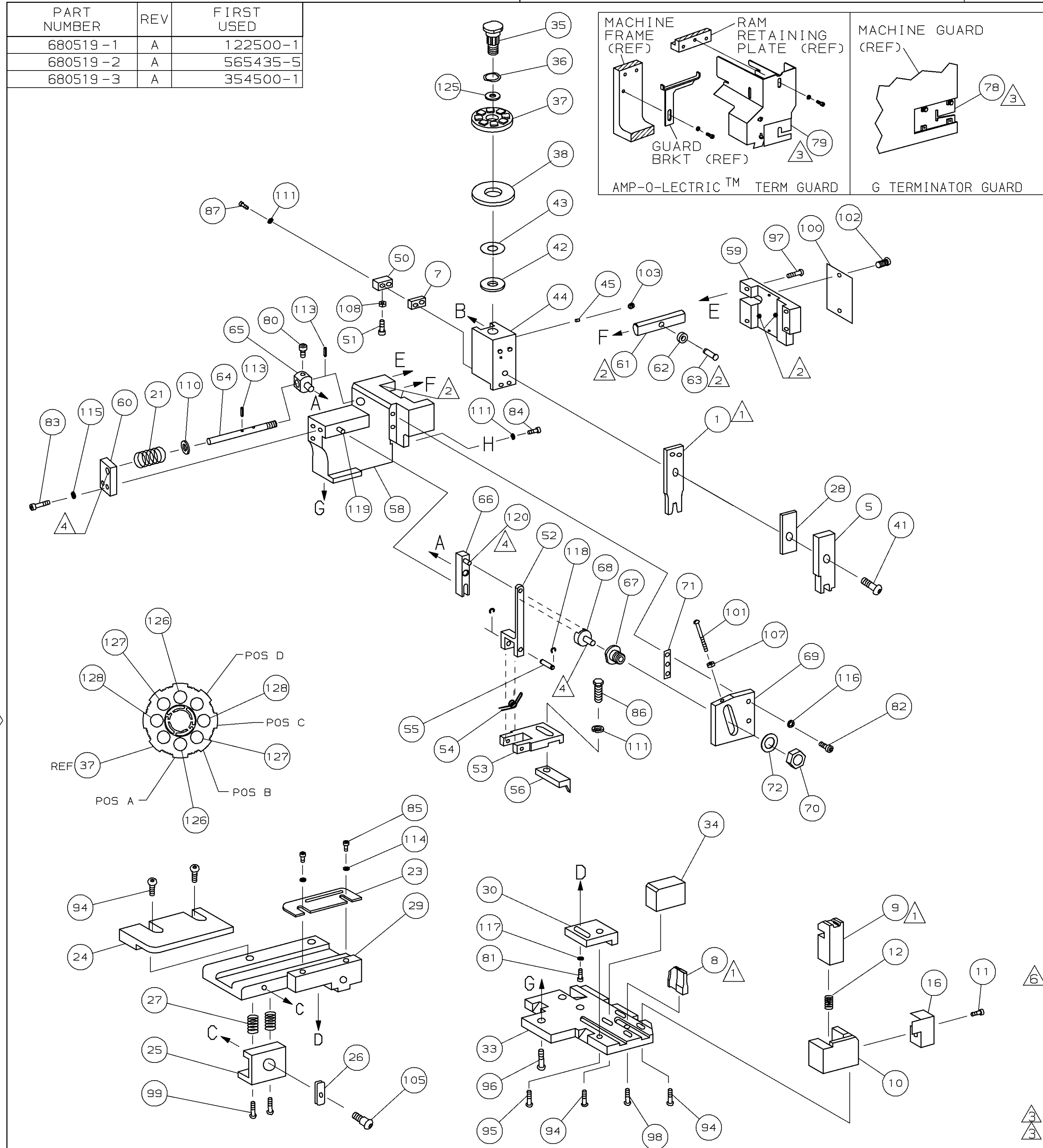


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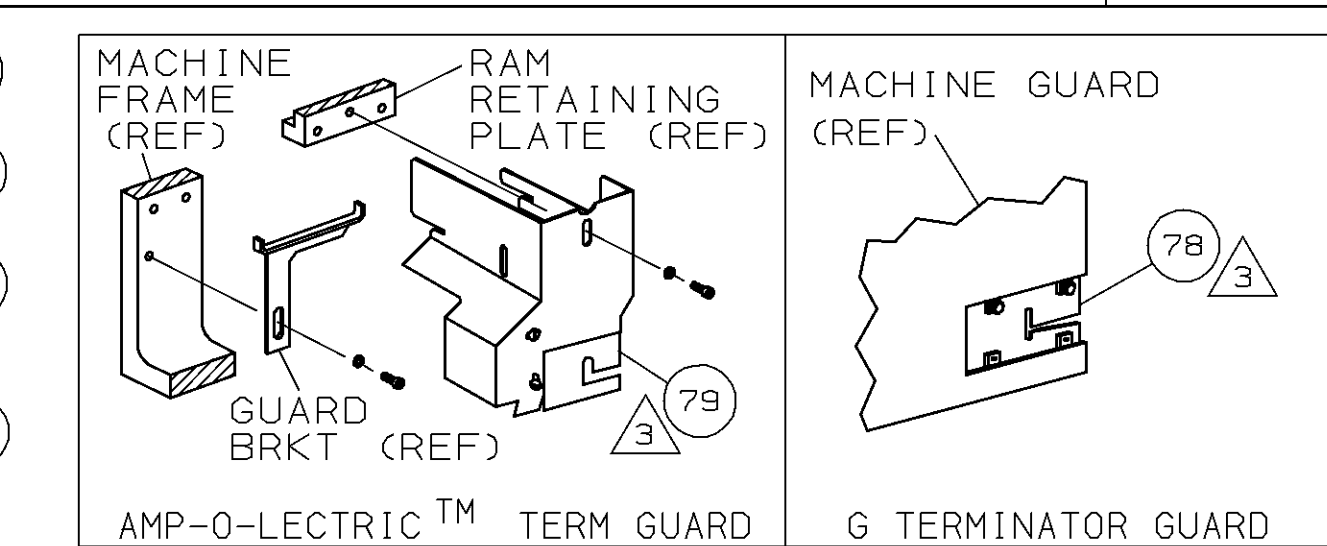
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DRAWING MADE IN THIRD ANGLE PROJECTION

PART NUMBER	REV	FIRST USED
680519-1	A	122500-1
680519-2	A	565435-5
680519-3	A	354500-1



AMP 3308 REV 3-92 21-OCT-97 07:17:46 amp06572 7



- 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.
6 CUT TO LENGTH AT ASSY.

680519

680519

TERMINAL NAME: TERMINAL, SWITCH					
286631					
CRIMPING DATA					
PAD LTR		CRIMP HEIGHT		WIRE SIZE	
A		.074 ±.002 [1.88 ±0.05mm]		16	
B		.068 ±.002 [1.73 ±0.05mm]		18	
C		.064 ±.002 [1.63 ±0.05mm]		20	
D		NOT		USED	
CRIMP		SIZE	TYPE	RANGE	
WIRE		.110 [2.79mm]	F	20-16	
INSUL		-	-	-	
WIRE STRIP LENGTH		TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE LAYOUT
.236		NONE	.500	408-8040	458637-1 L1979

2	2	2	-	C	8-354778-7	PIN, WIRE DISC (.2930)C	129
2	2	2	-	C	8-354778-1	PIN, WIRE DISC (.2900)B	127
2	2	2	-	C	6-354778-9	PIN, WIRE DISC (.2840)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
							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 STD 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	21018-5	NUT, HEX (6-32) FEED ADJ	107
							106
1	1	1	-	A	22353-8	SCR, SHLD (Ø.187x.25) DRAG LEVER	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	2-21000-9	SCR, SHC (8-32x.70) 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
							74
							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 REQD PER ASSY				PARTS LIST			

A		REVISED	CE	10-97
P/F		LTR	APP	DATE
		REVISION RECORD		
		REMOVE BURRS, BREAK SHARP EDGES R.015 MAX		

-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)
REF	REF	REF	-	B	240628-1	PLATE, ADJUSTMENT
REF	REF	REF	-	B	240626-1	SHAFT, PIVOT
REF	REF	REF	-	B	240633-1	BUSHING
REF	REF	REF	-	A	455680-1	LEVER, INTERMEDIATE
REF	REF	REF	-	B	240629-1	BLOCK, PIVOT
REF	REF	REF	-	A	240632-2	SCREW, ADJ FEED ROD
REF	REF	REF	-	B	240659-3	PIN, CAM ROLLER
REF	REF	REF	-	B	240658-1	ROLLER, CAM
REF	REF	REF	-	B	454398-2	ROD, FEED
REF	REF	REF	-	A	454178-1	GUIDE, FEED ROD
REF	REF	REF	-	C	454220-1	CAP, RAM
REF	REF	REF	-	D	454485-1	HOUSING
						57
1	1	1	-	B	690542-2	PAWL, FEED
REF	REF	REF	-	B	240624-1	PIN, FEED FINGER
REF	REF	REF	-	B	691499-1	SPRING, FEED FINGER
REF	REF	REF	-	B	690541-1	HOLDER, FEED FINGER
REF	REF	REF	-	A	455679-1	LEVER, TERMINAL FEED ARM
1	1	1	-	A	811242-2	BUMPER, HOLDDOWN
1	1	1	-	A	690753-1	SPACER, TONKER
1	-	-	-	B	690602-6	CAM, PRE-FEED 1 5/8 ST
-	1	-	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST
-	-	1	-	B	690501-4	CAM, POST-FEED 1 5/8 ST
1	1	1	-	B	459456-1	APPLICATOR, BASIC (SUBASSY)
1	1	1	-	A	690191-1	PLUG, NYLON
1	1	1	-	C	455673-1	RAM
1	1	1	-	A	690125-1	WASHER, LAMINATED
1	1	1	-	A	690124-1	WASHER, RAM
1	1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)
						40
						39
1	1	1	-	A	690223-2	SPACER, INSULATION DISC
1	1	1	-	D	354777-1	WIRE DISC, PLASTIC
1	1	1	-	A	22480-5	WASHER, SPRING
1	1	1	-	B	690212-1	POST, RAM
1	1	1	-	B	1-690786-5	SUPPORT, TERMINAL
REF	REF	REF	-	D	455675-1	PLATE, BASE
						32
						31
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ
1	1	1	-	C	843761-1	PLATE, ADJ STRIP GUIDE
1	1	1	-	C	1-455888-3	SPACER, FRONT SHEAR DEP
2	2	2	-	A	1-22284-0	SPRING, DRAG
1	1	1	-	B	240793-1	LEVER, DRAG RELEASE
1	1	1	-	B	240792-1	DRAG, TERMINAL
1	1	1	-	D	4-690440-9	GUIDE, STRIP (REAR)
1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)
-	-	1	-	B	690472-2	STRIPPER
REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN
1	1	-	-	A	679218-1	STRIPPER WIRE STOP ASSY
1	1	-	-	B	458949-1	STRIPPER
						18
						17
1	1	1	-	B	318563-1	GUARD, CHIP, FRONT
						15
						14
						13
1	1	1	-	A	5-22280-0	SPRING, SHEAR
1	1	1	-	B	690461-1	STOP, SHEAR
1	1	1	-	C	690459-1	HOLDER, SHEAR (FRONT)
1	1	1	-	C	454276-1	SHEAR, FLOAT (FRONT)
1	1	1	-	C	1-904717-0	ANVIL
1	1	1	-	C	6-240641-5	SPACER, DEPRESSOR (REAR)
						6
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)
						5
						4
						3
						2
1	1	1	-	C	4-456408-2	CRIMPER, WIRE
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION
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		MATERIAL		HT TR	FIN
DR M. OBRINE CHK 25AUG97 C. ERISMAN		APP 25AUG97 T. ELBIN	AMP Incorporated Harrisburg, PA 17105-3608		
NAME		SIDE FEED HDM APPLICATOR		MACHINE REF	
SCALE		DWG NO		SHEET	
-		680519		1 OF 1	

6

5

4

3

2

1

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