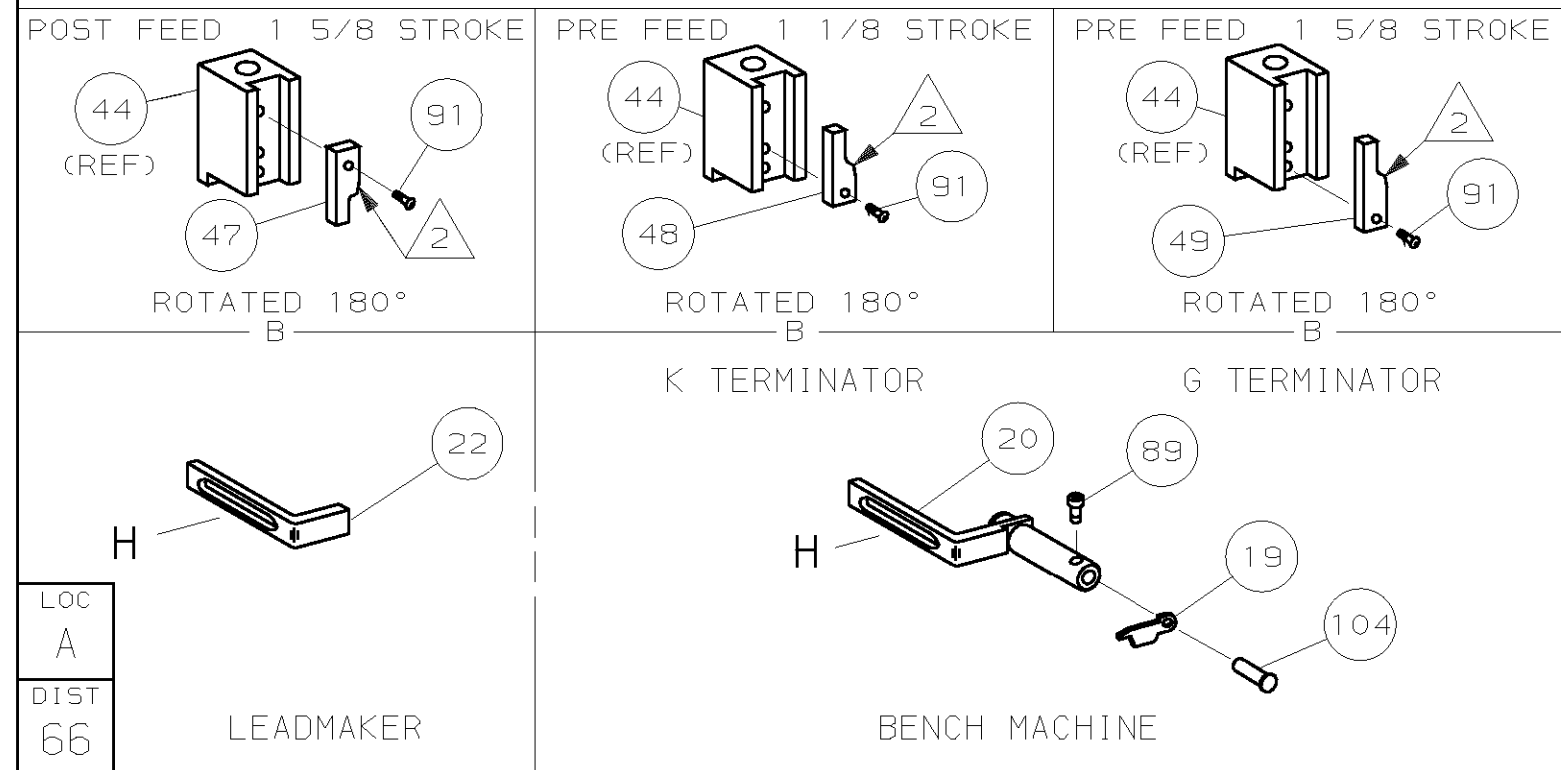
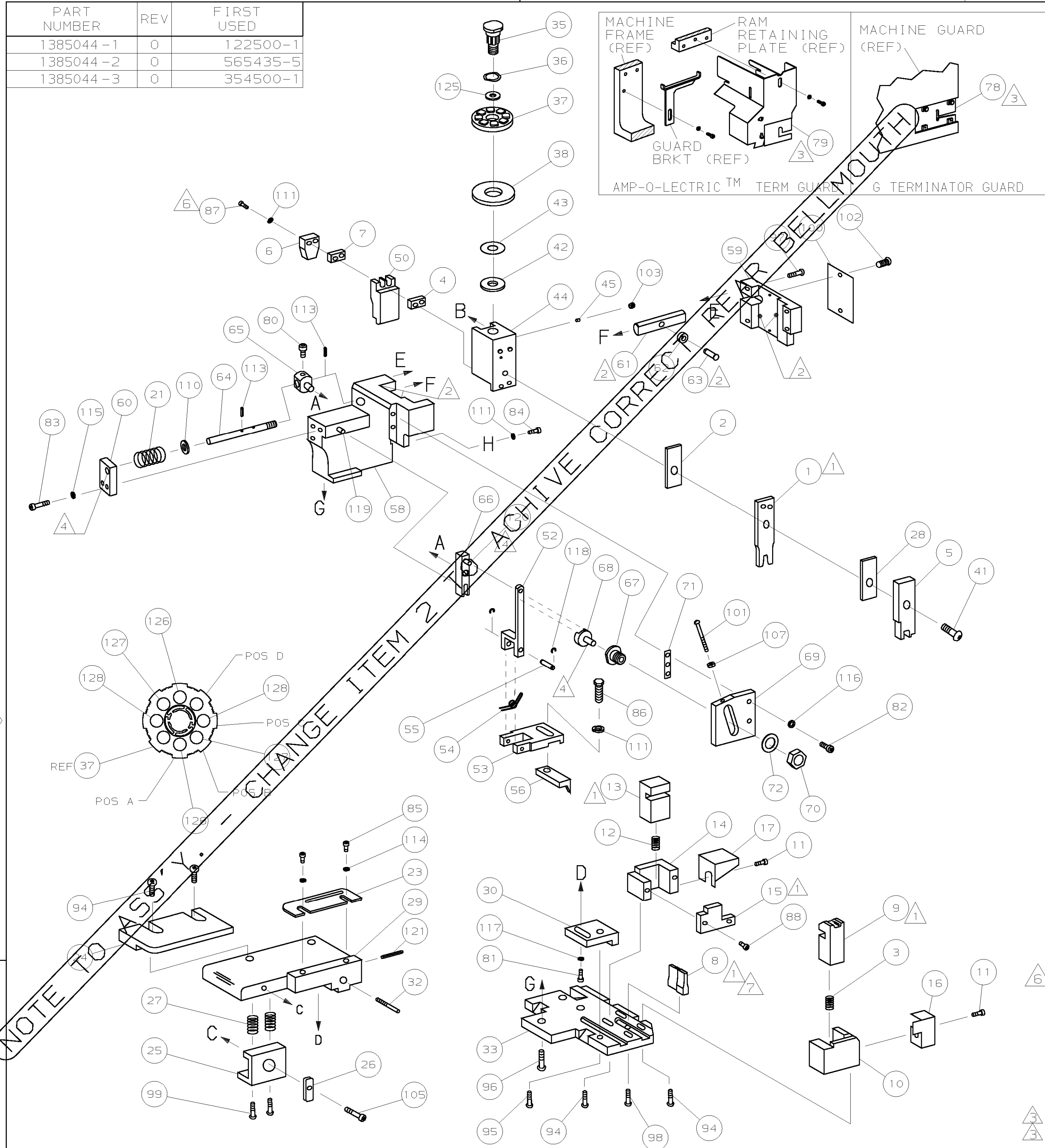


PART NUMBER	REV	FIRST USED
1385044-1	0	122500-1
1385044-2	0	565435-5
1385044-3	0	354500-1



- 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.
- 6 CUT TO LENGTH AT ASSEMBLY.
- 7 ANVIL TO BE ASSEMBLED IN FAR RIGHT SLOT IN CURRENT VIEW.
- 8 THIS IS A TWO STAGE APPLICATOR. FIRST STAGE SHEARS REAR CARRIER; SECOND STAGE CRIMPS, BENDS TERMINAL TO 90° AND SHEARS FRONT CARRIER STRIP.

TERMINAL NAME: TAB, SPECIAL									
P990R11-1100-0									
CRIMP DATA (AMP TERMINAL)									
PAD LTR			CRIMP HEIGHT				WIRE SIZE		
A			.095 ±.002 [2.41 ±0.05mm]				14		
B			.087 ±.002 [2.21 ±0.05mm]				16		
C			.082 ±.002 [2.08 ±0.05mm]				18		
D			NOT				USED		
CRIMP		SIZE		TYPE		RANGE			
WIRE		.120 [3.05mm]		F		18-14			
INSUL		-		-		-			
WIRE STRIP LENGTH		TERM APPL SPEC		FEED		APPL INSTRUCTION		SET UP GAGE	
.195-.211		NONE		.470		408-8040		458637-1	
L2371									
2	2	2	-	C	5-354778-7	PIN, WIRE DISC (.2780)C		129	
2	2	2	-	C	4-354778-7	PIN, WIRE DISC (.2730)B		128	
2	2	2	-	C	3-354778-1	PIN, WIRE DISC (.2650)A		127	
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	
1	1	1	-	A	1-21030-1	PIN,DOWEL (Ø.187x.50)LEVER		120	
1	1	1	-	A	1-21030-6	PIN,DOWEL (Ø.187x1.25)HOUSING		119	
2	2	2	-	A	21045-3	RING,RET "C"(Ø.187)FD FING PIN		118	
1	1	1	-	A	21024-5	WASHER, LOCK (#10)ADJ BLOCK		117	
1	1	1	-	A	21024-5	WASHER,LOCK (#10)ADJ PLATE		116	
1	1	1	-	A	21024-5	WASHER,LOCK (#10)FEED GDE ROD		115	
2	2	2	-	A	21024-2	WASHER,LOCK (#4)FRONT STP GUIDE		114	
2	2	2	-	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	
1	1	1	-	A	21899-4	WASHER,FLAT (Ø5/16)SCREW ADJ		110	
								109	
								108	
1	1	1	-	A	21068-5	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	
1	1	1	-	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	
4	4	4	-	A	2-21002-9	SCR,BHC (10-32x.75)CAP		97	
3	3	3	-	A	2-22733-8	SCR,BHC (1/4-20x.62)HOUSING		96	
1	1	1	-	A	2-21002-7	SCR,BHC (10-32x.50)5G ADJ BLOCK		95	
6	6	6	-	A	2-21002-2	SCR,BHC (8-32x.50)TERM H DW		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	
2	2	2	-	A	1-21002-7	SCR,SHC (6-32x.38)SHEAR PLATE		88	
2	2	2	-	A	3-21000-2	SCR,SHC (6-32x.38)DEP-HOLD		87	
1	1	1	-	A	2-22603-0	SCR,HEV HLX (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	
1	1	1	-	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)5G ADJ BL		81	
1	1	1	-	A	3-21000-4	SCR,SHC (10-32x.38)PIVOT BLK		80	
-	1	-	-	B	455745-1	GUARD, WINDOW		79	
1	-	-	-	B	679532-1	INSERT, GUARD		78	
								77	
								76	
								75	
								74	
								73	
1	1	1	-	A	458109-1	WASHER, SPECIAL		72	
1	1	1	-	A	690517-1	SPACER		71	
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION		ITEM NO	
QTY REQ PER ASSY					PARTS LIST				

-1 LEADMAKER				MECH POST FEED								
-2 BENCH MODEL K				MECH PRE FEED								
-3 BENCH MODEL G				MECH PRE FEED								
1	1	1	-	B	22594-8	NUT, HEX (1/2-20)	70					
1	1	1	-	B	240628-1	PLATE, ADJUSTMENT	69					
1	1	1	-	B	240626-1	SHAFT, PIVOT	68					
1	1	1	-	B	240633-1	BUSHING	67					
1	1	1	-	A	455680-1	LEVER, INTERMEDIATE	66					
1	1	1	-	B	240629-1	BLOCK, PIVOT	65					
1	1	1	-	A	240632-2	SCREW, ADJ FEED ROD	64					
1	1	1	-	B	240659-3	PIN, CAM ROLLER	63					
1	1	1	-	B	240658-1	ROLLER, CAM	62					
1	1	1	-	B	454398-2	ROD, FEED	61					
1	1	1	-	A	454178-1	GUIDE, FEED ROD	60					
1	1	1	-	C	454220-1	CAP, RAM	59					
1	1	1	-	D	454485-3	HOUSING	58					
							57					
1	1	1	-	B	690542-2	PAWL, FEED	56					
1	1	1	-	B	240624-1	PIN, FEED FINGER	55					
1	1	1	-	B	691499-1	SPRING, FEED FINGER	54					
1	1	1	-	B	690541-1	HOLDER, FEED FINGER	53					
1	1	1	-	A	455679-1	LEVER, TERMINAL FEED ARM	52					
							51					
1	1	1	-	A	1320119-3	TERMINAL BENDING TOOL	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	690501-1	CAM, POST-FEED 1 5/8 ST	47					
							46					
1	1	1	-	A	690151-1	PLUG, NYLON	45					
1	1	1	-	C	455679-1	RAM	44					
1	1	1	-	A	690125-1	WASHER, LAMINATED	43					
1	1	1	-	A	690124-1	WASHER, RAM	42					
1	1	1	-	-	7-21002-9	BOLT, CRIMPER (5/16x1.00)	41					
							40					
							39					
1	1	1	-	A	690223-2	SPACER, INSULATION DISC	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					
							34					
1	1	1	-	D	462504-5	PLATE, BASE	33					
1	1	1	-	A	690432-3	SCREW, ADJUSTMENT	32					
							31					
1	1	1	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30					
1	1	1	-	C	458144-6	PLATE, STRIP GUIDE	29					
1	1	1	-	C	455888-4	SPACER, FRONT SHEAR DEP	28					
2	2	2	-	A	1-22284-0	SPRING, DRAG	27					
1	1	1	-	B	240793-1	LEVER, DRAG RELEASE	26					
1	1	1	-	B	240792-1	DRAG, TERMINAL	25					
1	1	1	-	D	2-90765-4	GUIDE, STRIP (REAR)	24					
1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23					
-	-	1	-	B	690472-2	STRIPPER	22					
1	1	1	-	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					
1	1	1	-	A	691668-1	GUARD, CHIP (REAR)	17					
1	1	1	-	B	318563-1	GUARD, CHIP, FRONT	16					
1	1	1	-	B	1338990-1	PLATE, SHEAR (REAR)	15					
1	1	1	-	B	1-690462-2	HOLDER, SHEAR (REAR)	14					
1	1	1	-	C	1-690463-0	SHEAR, FLOAT (REAR)	13					
1	1	1	-	A	5-22280-0	SPRING, SHEAR	12					
2	2	2	-	B	690461-2	STOP, SHEAR	11					
1	1	1	-	C	2-690459-1	HOLDER, SHEAR (FRONT)	10					
1	1	1	-	C	1-462006-3	SHEAR, FLOAT (FRONT)	9					
1	1	1	-	C	1338991-1	ANVIL	8					
1	1	1	-	C	2-240641-0	SPACER, DEPRESSOR (REAR)	7					
1	1	1	-	A	1-690468-2	DEPRESSOR, SHEAR (REAR)	6					
1	1	1	-	C	2-455889-6	DEPRESSOR, SHEAR (FRONT)	5					
1	1	1	-	C	5-240641-7	SPACER, DEPRESSOR (REAR)	4					
1	1	1	-	A	5-22279-2	SPRING, SHEAR	3					
1	1	1	-	C	2-455888-8	WIRE CRIMPER SPACER	2					
1	1	1	-	C	1-456409-4	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 RECD 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		19APR00	APP T.ELBIN	19APR00				
				CHK B.HIGMAN		19APR00	REL -					
				AMP AMP Incorporated Harrisburg, PA 17105-3608								
				NAME SIDE FEED HDM APPLICATOR MACHINE REF								
				SCALE - 1385044 SHEET 1 OF 1 REV 01								

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