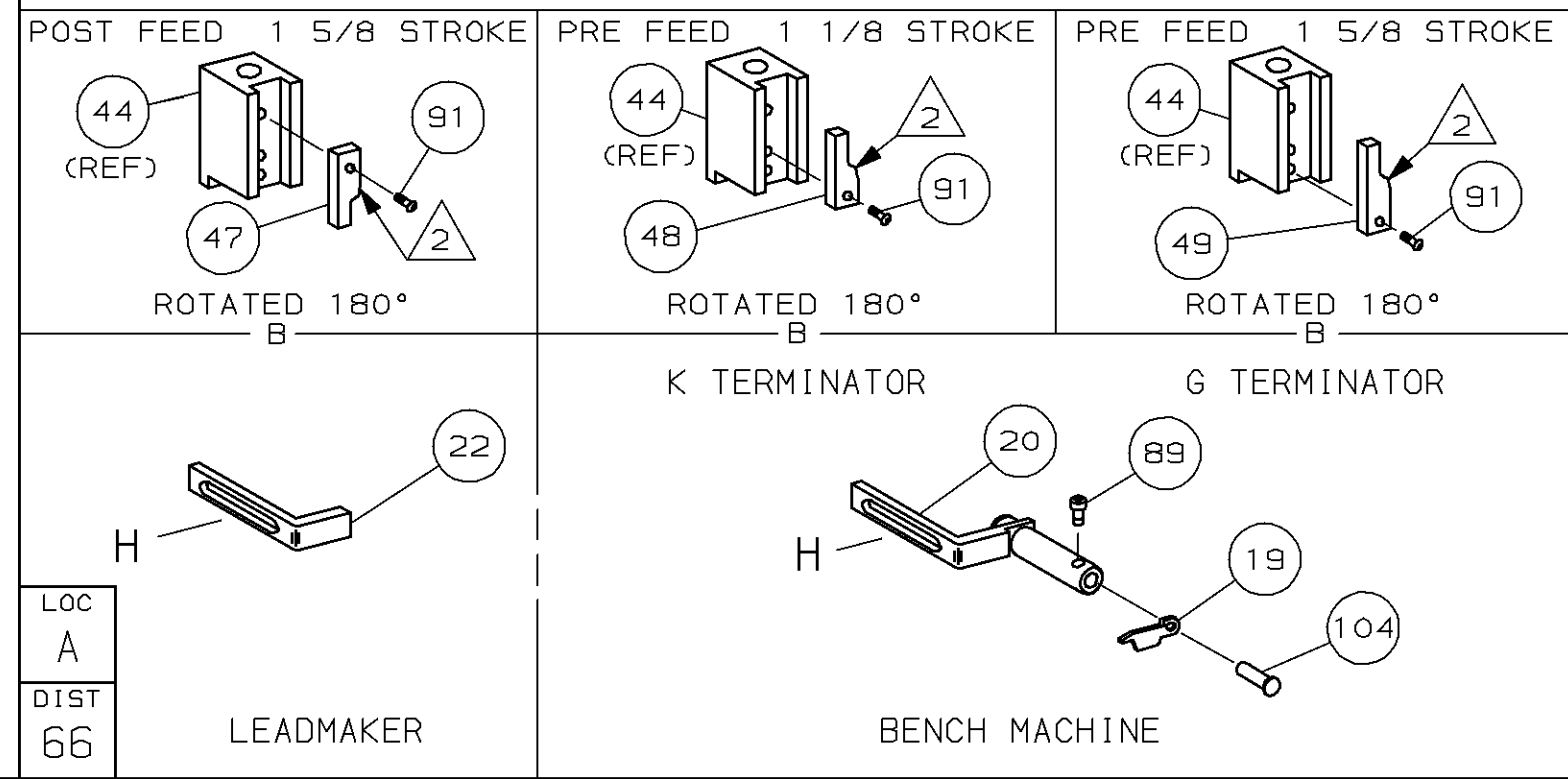
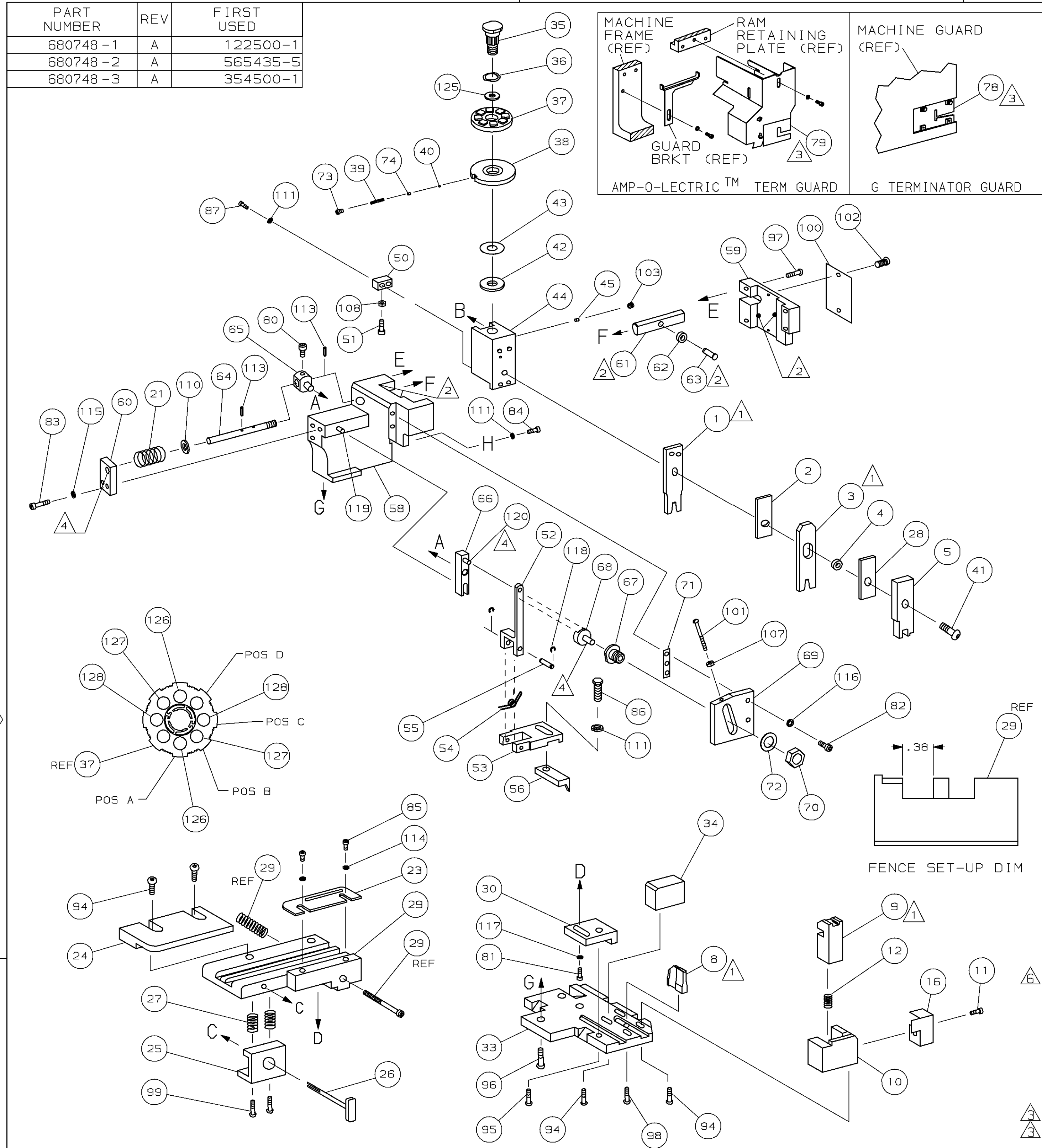


PART NUMBER	REV	FIRST USED
680748-1	A	122500-1
680748-2	A	565435-5
680748-3	A	354500-1



- 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.
6 CUT TO LENGTH AT ASSY

TERMINAL NAME: STANDARD-TIMER CONTACT				
927865				
PAD LTR		CRIMP DATA (AMP TERMINAL)		
		CRIMP HEIGHT	WIRE SIZE	
A		.054 ±.002 [1.36 ±0.05mm]	1.00mm ²	
B		.050 ±.002 [1.27 ±0.05mm]	.75mm ²	
C		.046 ±.002 [1.18 ±0.05mm]	.50mm ²	
D		NOT	USED	
CRIMP		SIZE	TYPE	RANGE
WIRE		.080 [2.03mm]	F	.50-1.00mm ²
INSUL		.130 [3.30mm]	F	Ø2-3.3mm
WIRE STRIP LENGTH		TERM APPL SPEC	FEED	APPL INSTRUCTION
.156-.187		114-2020	.800	408-8040
				SET UP GAGE
				L2171

2	2	2	-	C	2-354779-8	PIN, WIRE DISC (.3130)C	129
2	2	2	-	C	1-354779-8	PIN, WIRE DISC (.3080)B	127
2	2	2	-	C	1-354779-0	PIN, WIRE DISC (.3040)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	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	2-21000-7	SCR,SHC (8-32x.48)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 REQD PER ASSY					PARTS LIST		

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	690542-6	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	690124-1	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	690786-1	SUPPORT, TERMINAL	34				
REF	REF	REF	-	D	455675-1	PLATE, BASE	33				
							32				
							31				
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30				
1	1	1	-	C	318042-1	STRIP GUIDE PLATE ASSY	29				
1	1	1	-	C	1-455888-9	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	8-690504-9	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	454276-1	SHEAR, FLOAT (FRONT)	9				
1	1	1	-	C	2-662186-2	ANVIL	8				
							7				
							6				
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5				
1	1	1	-	B	238011-7	SPACER, BLOCK CRIMPER	4				
1	1	1	-	C	6-456134-9	CRIMPER, INSULATION	3				
1	1	1	-	C	455888-8	SPACER, CRIMPER	2				
1	1	1	-	C	2-456405-3	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 ±.02 3 PLC DEC ±-. 4 PLC DEC ±-. ANGLES ±- SURF TEXTURE: ✓ REMOVE BURRS, BREAK SHARP EDGES R.015 MAX					MATL		HT TR	FIN			
					-		-	-			
					OR W.HOOVER		06NOV98	APP	06NOV98	T.ELBIN	
					CHK 06NOV98		REL	-	AMP		
					C.ERISMAN		AMP Incorporated Harrisburg, PA 17105-3608				
NAME					SIDE FEED HDM APPLICATOR		MACHINE	REF	APPL		
SCALE					-	D	DWG NO	680748	SHEET	REV	
								1 of 1	A		

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