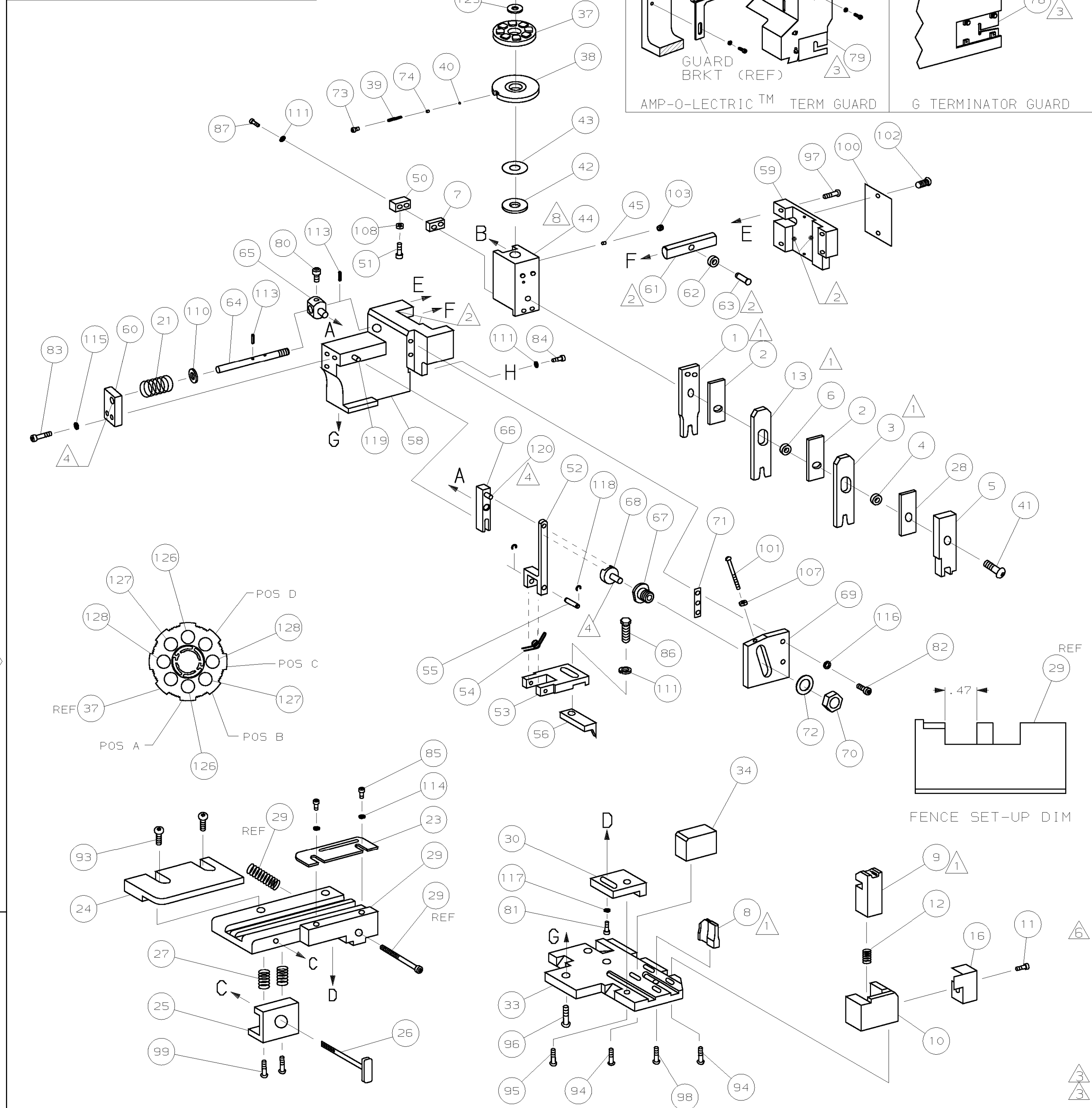


PART NUMBER	REV	FIRST USED
680709-1	B	122500-1
680709-2	B	565435-5
680709-3	B	354500-1



POST FEED 1 5/8 STROKE

ROTATED 180°

PRE FEED 1 1/8 STROKE

ROTATED 180°

PRE FEED 1 5/8 STROKE

ROTATED 180°

LOC A

DIST 66

LEADMAKER

K TERMINATOR

G TERMINATOR

- 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
- 7 GUIDE OFF STABILIZER BARREL.
- 8 PRESS SPRING PIN INTO RAM, FLUSH WITH WIRE CRIMPER, AT ASSEMBLY.

TERMINAL NAME: .140 Ø SOCKET									
			927873	CRIMP DATA (AMP TERMINAL)					
			927875	PAD LTR	CRIMP HEIGHT			WIRE SIZE	
				A	.073 ±.002 [1.86 ±0.05mm]			2.5 mm ²	
				B	.068 ±.002 [1.72 ±0.05mm]			2 mm ²	
				C	.062 ±.002 [1.58 ±0.05mm]			1.5 mm ²	
				D	NOT			USED	
				CRIMP	SIZE		TYPE	RANGE	
				WIRE	.110 [2.79mm]		F	1.5mm-2.5mm	
				INSUL	.155 [3.94mm]		F	2.7mm-3.7mm	
WIRE STRIP LENGTH			TERM APPL SPEC		FEED	APPL INSTRUCTION		SET UP GAGE	LAYOUT
.171-.188			NONE		.590	408-8040		458637-1	L2143
									129
2	2	2	-	C	1-354779-0		PIN, WIRE DISC (.3040)C		128
2	2	2	-	C	9-354778-5		PIN, WIRE DISC (.2970)B		127
2	2	2	-	C	8-354778-7		PIN, WIRE DISC (.2930)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 STP GUIDE		114
REF	REF	REF	-	A	5-21028-1		PIN,SLT 5PR (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
4	4	4	-	A	2-21002-2		SCR,BHC (8-32x.50)TERM H DWN		94
2	2	2	-	A	2-21002-3		SCR,BHC (8-32x.62)R STP GDE		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.54)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					

-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	1-694433-6	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	455679-2	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	459456-2	APPLICATOR, BASIC (SUBASSY)	46	
1	1	1	-	A	690191-1	PLUG, NYLON	45	
1	1	1	-	C	819307-4	RAM	44	
1	1	1	-	A	690125-1	WASHER, LAMINATED	43	
1	1	1	-	A	690124-1	WASHER, RAM	42	
1	1	1	-	A	690686-2	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	1-690142-0	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	318756-1	STRIP GUIDE PLATE ASSY	29	
1	1	1	-	C	1-455888-5	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	9-690504-4	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	
1	1	1	-	C	9-456135-4	CRIMPER, STABILIZER	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	1213557-2	ANVIL	8	
1	1	1	-	C	6-240641-4	SPACER, DEPRESSOR (REAR)	7	
1	1	1	-	B	238011-2	SPACER, BLOCK CRIMPER	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	683453-3	CRIMPER, INSULATION	3	
2	2	2	-	C	455888-4	SPACER, CRIMPER	2	
1	1	1	-	C	456408-8	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 ±-.04 4 PLC DEC ±-.05 ANGLES ±- SURF TEXTURE: ✓ REMOVE BURRS, BREAK SHARP EDGES R.015 MAX				MATL		HT TR	FIN	
				-		-	-	
				DR B.HIGMAN 090CT98		APP T.ELBIN 090CT98	 AMP Incorporated Harrisburg, PA 17105-3608	
				CHK 090CT98 C.ERISMAN		REL -		
NAME				SIDE FEED HDM APPLICATOR		MACHINE REF		
SCALE				680709		MINI APPL		
-				D		1 OF 1		
CAGE CODE 00779				CUSTOMER AND ASSEMBLY DRAWING		RESTRICTED TO		

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