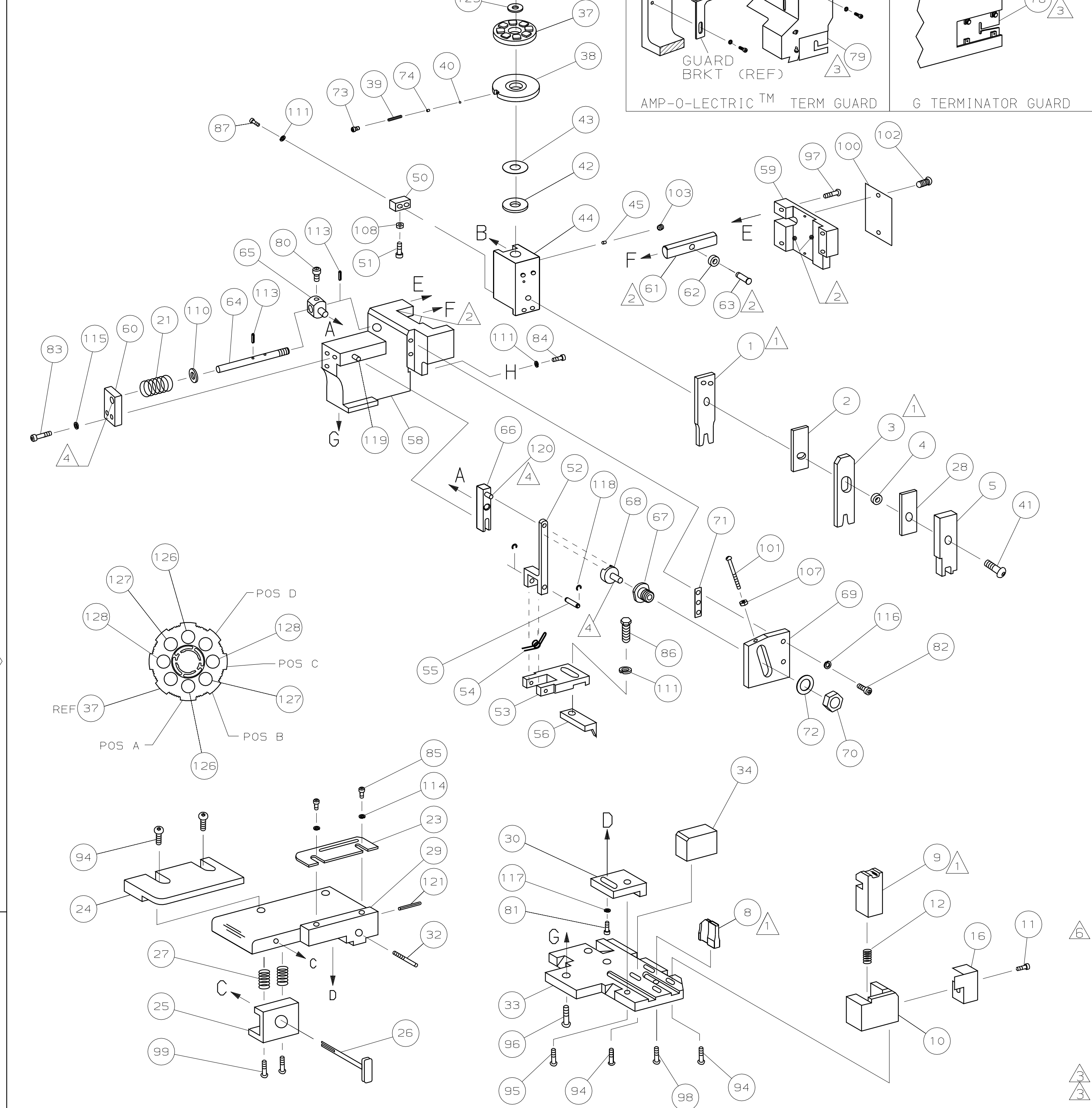


PART NUMBER	REV	FIRST USED
680307-1	D	122500-1
680307-2	D	565435-5
680307-3	D	354500-1



POST FEED 1 5/8 STROKE

LEADMAKER

PRE FEED 1 1/8 STROKE

K TERMINATOR

PRE FEED 1 5/8 STROKE

G TERMINATOR

LOC A

DIST 66

LEADMAKER & BENCH MACHINE

- 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

680307 680307

TERMINAL NAME: DUAC CONTACT SOCKET			
		CRIMPING DATA	
	PAD LTR	CRIMP HEIGHT	WIRE SIZE
	A	.031 ±.002 [0.79 ±0.05mm]	22
	B	.027 ±.002 [0.69 ±0.05mm]	24
	C	.025 ±.002 [0.64 ±0.05mm]	26
	D	NOT	USED
		CRIMP	SIZE
		WIRE	.048 [1.22mm]
		INSUL	.080 [2.03mm]
		FEED	.472
		APPL INSTRUCTION	408-8040
		SET UP GAGE	458637-1
		LAYOUT	L1768
WIRE STRIP LENGTH .094-.126		TERM APPL SPEC 114-19048	

2	2	2	-	C	6-354779-2	PIN, WIRE DISC (.3300)C	129
2	2	2	-	C	5-354779-8	PIN, WIRE DISC (.3280)B	127
2	2	2	-	C	5-354779-0	PIN, WIRE DISC (.3240)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	21018-5	NUT,HEX(6-32)FEED ADJ	107
							106
							105
							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
							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					
		D	ECR-05-018475	GB	12-05		
		C	ECN 0150-1058-04	TE	8-04		
		B	ECN 0150-0317-03	TE	3-03		
		A4	0150-0056-01	CE	JAN01		
		A3	0150-0215-00	TK	3-00		
		A2	0150-0110-00	TE	FEB00		
		A1	0150-8036-97	TB	10-97		
		A	REVISED	CE	7-96		
P	F	LTR	REVISION RECORD	APP	DATE		

-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	458537-2	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	455679-2	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	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					
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	1-455888-7	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	240792-5	DRAG, TERMINAL	25					
1	1	1	-	D	6-690504-3	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					
							20					
1	1	-	-	B	691353-1	STRIPPER	19					
							18					
							17					
1	1	1	-	B	318563-1	GUARD, CHIP, FRONT	16					
							15					
							14					
							13					
1	1	1	-	A	3-22280-3	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	462006-1	SHEAR, FLOAT (FRONT)	9					
1	1	1	-	C	8-189717-0	ANVIL	8					
							7					
							6					
1	1	1	-	C	2-455889-0	DEPRESSOR, SHEAR (FRONT)	5					
1	1	1	-	B	2-238011-5	SPACER, BLOCK CRIMPER	4					
1	1	1	-	C	9-456134-4	CRIMPER, INSULATION	3					
1	1	1	-	C	455888-6	SPACER, CRIMPER	2					
1	1	1	-	C	568176-6	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		4-30-96	APP	4-30-96	AMP AMP Incorporated Harrisburg, PA 17105-3608			
				M. OBRINE			T. ELBIN					
				CHK		4-30-96	REL	7/16/96				
						C. ERISMAN		B. MORGAN				
				NAME		SIDE FEED HDM APPLICATOR					MACHINE REF	MINI APPL
				SCALE		-	D	DWG NO	680307		SHEET	1 OF 1
											REV	D

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