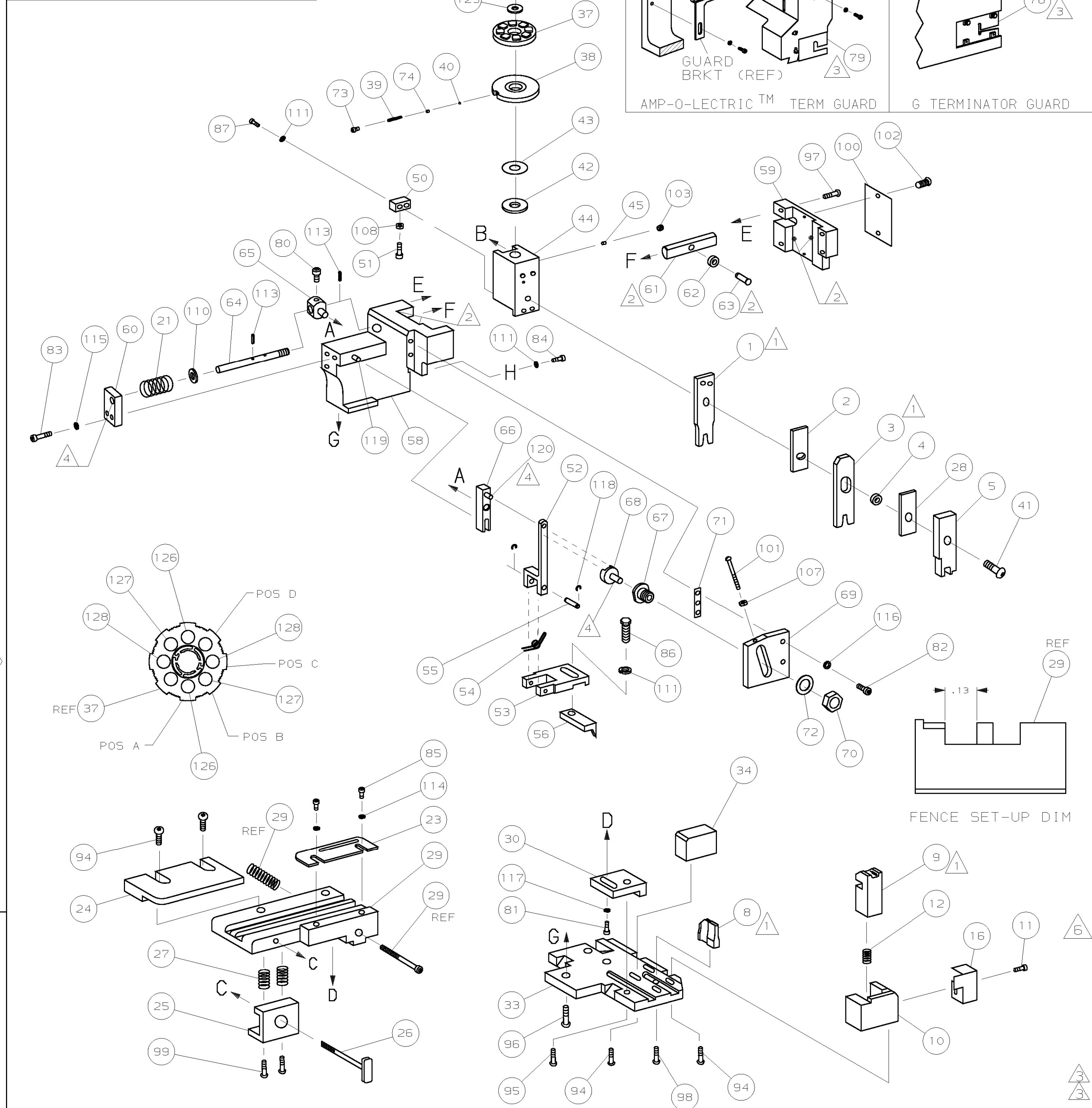


PART NUMBER	REV	FIRST USED
680239-1	A	122500-1
680239-2	A	565435-5
680239-3	A	354500-1



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

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.
- 7 FEED ADJUSTMENT NECESSARY WHEN CHANGING TERMINALS.

TERMINAL NAME: Ø4 CONTACT SOCKET			
962868 962862		CRIMPING DATA	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.078 ±.002 [1.98 ±0.05mm]	2.5mm ²	
B	.072 ±.002 [1.84 ±0.05mm]	2mm ²	
C	.067 ±.002 [1.71 ±0.05mm]	1.5mm ²	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.100 [2.54mm]	F	1.5 - 2.5mm ²
INSUL	.140 [3.556mm]	OV	2.10 - 3mm
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
.203-.234	-	.748 1.669	408-8040
		SET UP GAGE	LAYOUT
		458637-1	L1708

2	2	2	-	C	9-354778-4	PIN, WIRE DISC (.2965) C	129
2	2	2	-	C	8-354778-3	PIN, WIRE DISC (.2910) 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	DOCUMENTATION 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	21018-5	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.49) 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
							70
							69
							68
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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	690542-2	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	690786-4	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	1-455888-8	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	7-690440-4	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	
										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	1-454276-9	SHEAR, FLOAT (FRONT)				9	
1	1	1	-	C	6-189717-1	ANVIL				8	
										7	
										6	
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)				5	
1	1	1	-	B	238011-5	SPACER, BLOCK CRIMPER				4	
1	1	1	-	C	854830-8	CRIMPER, INSULATION				3	
1	1	1	-	C	1-455888-0	SPACER, CRIMPER				2	
1	1	1	-	C	2-456407-0	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		
					-		-		-		
DR J.BAKER 1/5/96 APP T ELBIN CHK 1/5/96 C.ERISMAN REL -					AMP		AMP Incorporated Harrisburg, PA 17105-3608				
NAME					SIDE FEED HDM APPLICATOR					MACHINE REF	
SCALE					680239					MINI APPL	
1 of 1					REV A						
CAGE CODE 00779					CUSTOMER AND ASSEMBLY DRAWING					RESTRICTED TO	

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