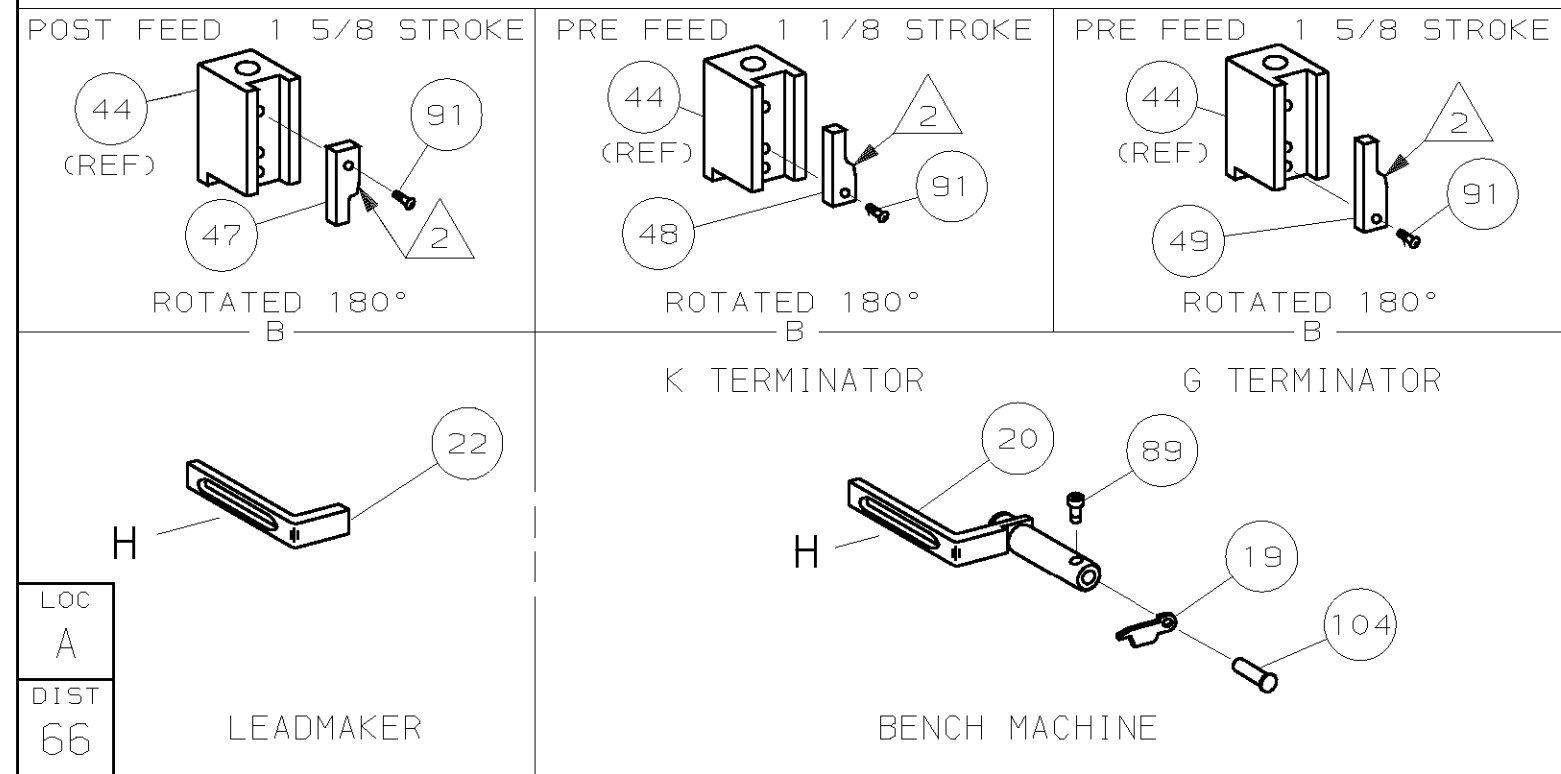
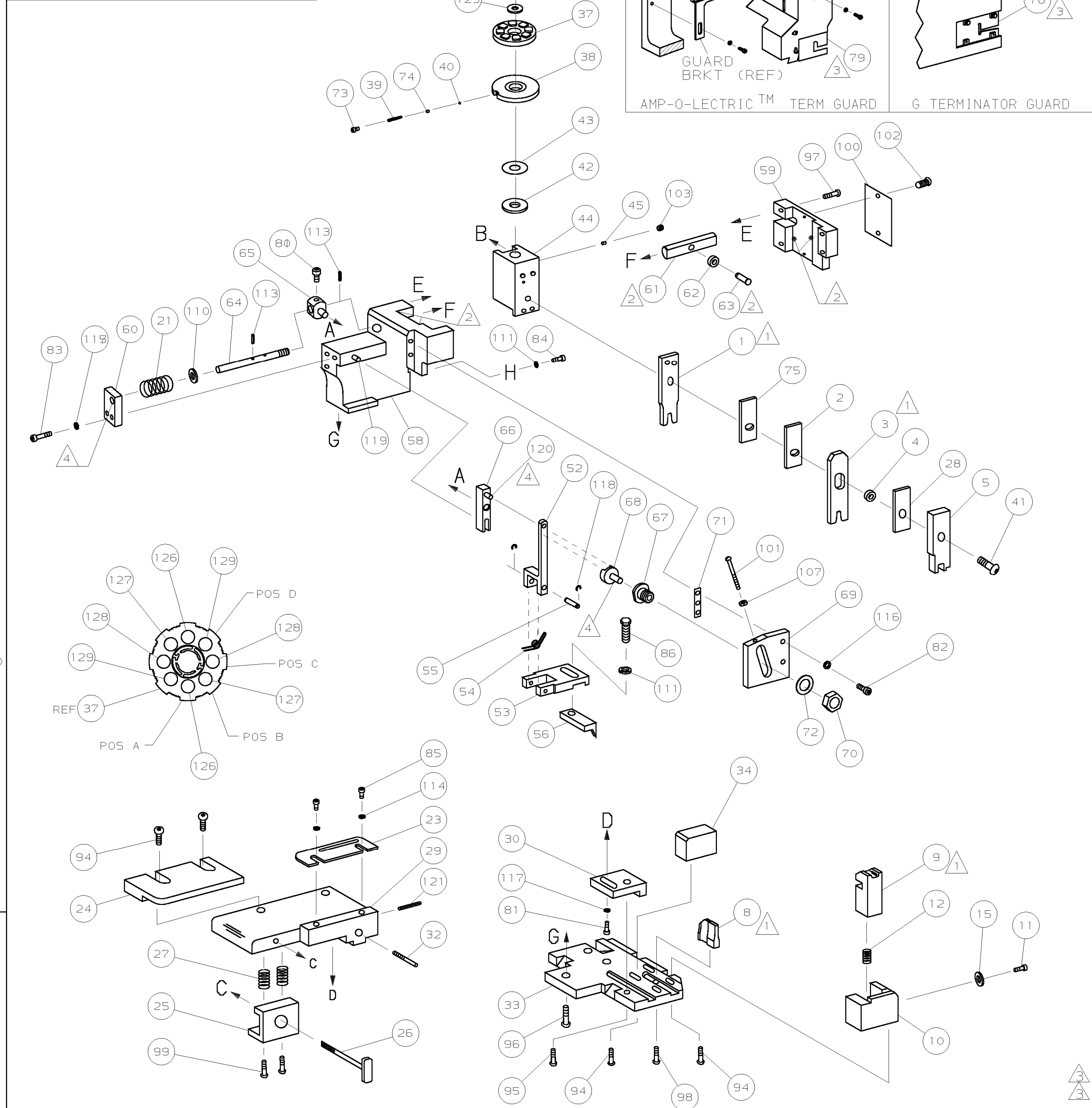


PART NUMBER	REV	FIRST USED
680248-1	B	122500-1
680248-2	B	565435-5
680248-3	B	354500-1



- 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.

TERMINAL NAME: .312 POSITIVE LOCK RECEPTACLE FLAG											
				281737	CRIMPING DATA						
				172795	PAD LTR	CRIMP HEIGHT		WIRE SIZE			
				172796							
						A	.070 ±.002 [1.78 ±0.05mm]		14		
						B	.060 ±.002 [1.52 ±0.05mm]		16		
					C	.053 ±.002 [1.35 ±0.05mm]		18			
					D	.051 ±.002 [1.3 ±0.05mm]		20			
					CRIMP	SIZE		TYPE	RANGE		
					WIRE	.090 [2.29mm]		F	20-14		
					INSUL	.140 [3.56mm]		F	.085-.135		
WIRE STRIP LENGTH				TERM APPL SPEC		FEED		APPL INSTRUCTION		SET UP GAGE	LAYOUT
-				114-20085		.913		408-8040		458637-1	L1718
2	2	2	-	C	3-354779-0		PIN, WIRE DISC (.3140)D		129		
2	2	2	-	C	2-354779-7		PIN, WIRE DISC (.3125)C		128		
2	2	2	-	C	1-354779-2		PIN, WIRE DISC (.3050)B		127		
2	2	2	-	C	9-354778-0		PIN, WIRE DISC (.2945)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		
1	1	1	-	A	4-21028-0		PIN, SLT SPR (.093 x .75)		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		
2	2	2	-	A	21024-4		WASHER, LOCK (#8) STRIPPER		111		
REF	REF	REF	-	A	21899-4		WASHER,FLAT (ø5/16) SCREW ADJ		110		
									109		
									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)56 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		
									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		
2	2	2	-	A	3-21000-4		SCR,SHC (10-32x.38)56 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		
1	1	1	-	B	455888-9		SPACER, CRIMPER		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	455679-1	LEVER, TERMINAL FEED ARM	52		
							51		
							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	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	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	690786-5	SUPPORT, TERMINAL	34		
REF	REF	REF	-	D	455675-1	PLATE, BASE	33		
1	1	1	-		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	2-455888-7	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	240792-1	DRAG, TERMINAL	25		
1	1	1	-	D	1-690440-2	GUIDE, STRIP (REAR)	24		
1	1	1	-	A	1-690438-0	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		
							16		
1	1	1	-		21024-3	WASHER, LOCK #6	15		
							14		
							13		
1	1	1	-	A	5-22280-0	SPRING, SHEAR	12		
1	1	1	-	B	1-690461-4	STOP, SHEAR	11		
1	1	1	-	C	690459-1	HOLDER, SHEAR (FRONT)	10		
1	1	1	-	C	454276-2	SHEAR, FLOAT (FRONT)	9		
1	1	1	-	C	8-683403-1	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	5-683453-1	CRIMPER, INSULATION	3		
1	1	1	-	C	3-455888-2	SPACER, CRIMPER	2		
1	1	1	-	C	4-456406-1	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 R.O.WILSON		1-4-96	APP T	1-9-96	ELBIN
				CHK 1-8-96 C ERISMAN		REL	-	 AMP Incorporated Harrisburg, PA 17105-3608	
NAME				SIDE FEED HDM APPLICATOR			MACHINE REF		
SCALE				680248			MINI APPL		
-				DWG NO			SHEET 1 OF 1		
							REV B		

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