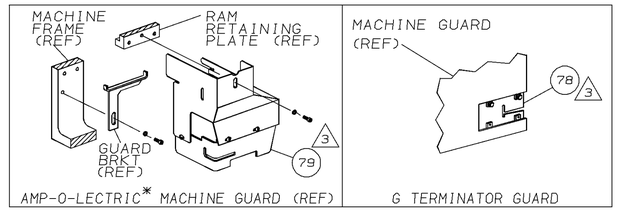
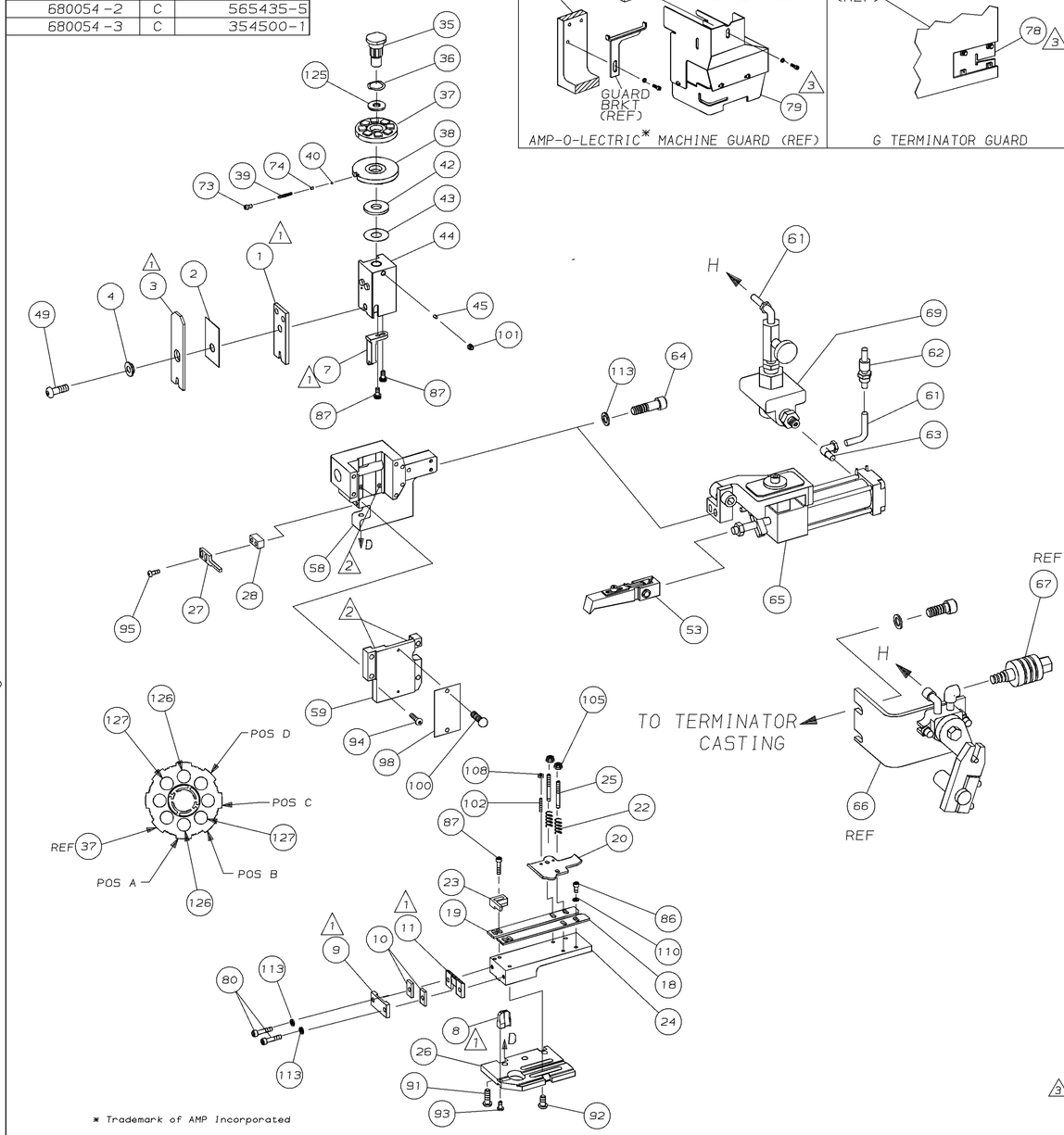
DRAWING MADE IN THIRD ANGLE PROJECTION

680054 ⇔ 680054

<UT161B>DEPT2230>AMP07567>U.MINI-APPL

PART NUMBER	REV	FIRST USED
680054 -1	C	854400-1
680054 -2	C	565435-5
680054 -3	C	354500-1





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1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-O-LECTRIC MACHINE.
4. SEE DRAWING FOR COMPONENTS
5. ALUMINUM WIRE

TERMINAL NAME: .187 SERIES RECEPTACLE, FASTON, FLAG, AMPLIVAR

63772

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	5 WIRE SIZE
A	.054±.002	(1)18 & (1)21 OR (1)17.5 & (1)21.5
B	.048±.002	(2)21 OR (2)21.5 OR (1)18 OR (1)17.5
C	NOT	USED
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.110	F	5 21.5-17.5
INSUL	.110	F	.030-.090

FEED	APPL INST	SET UP GAGE	LAYOUT
.570	408-8039	458638-1	L1537

TERM APPL SPEC – WIRE STRIP LENGTH –

-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
							129
							128
2	2	2	–	C	2-354779-6	PIN, WIRE DISC (.3120)B	127
2	2	2	–	C	1-354779-4	PIN, WIRE DISC (.3060)A	126
1	1	1	–	A	986950-1	WASHER, FLAT PRECISION	125
							124
							123
							122
							121
							120
							119
							118
							117
							116
							115
							114
4	4	4	–	A	21024-5	WASHER, LOCK (NO.10) SHEAR PL	113
							112
							111
7	7	7	–	A	21024-4	WASHER, LOCK (NO.8) SHEAR BL	110
							109
2	2	2	–	A	21018-4	NUT, HEX (4-40) DRAG	108
							107
							106
2	2	2	–	A	21022-2	NUT, HEX SL (8-32) DRAG STUD	105
							104
							103
2	2	2	–	A	2-21006-6	SKT SKT SET (4-40x.62) DRAG	102
1	1	1	–	A	21009-2	SCR, SKT SET (1/4-20x.25) RAM	101
2	2	2	–	A	21017-2	SCR, DRIVE (#2x.19) ID PLATE	100
							99
1	1	1	–	B	461264-1	PLATE, IDENTIFICATION	98
							97
							96
2	2	2	–	A	2-21002-2	SCR, BHC (8-32x.50) STRIPPER	95
4	4	4	–	A	2-21002-9	SCR, BHC (10-32x.75) CAP	94
1	1	1	–	A	22733-8	SCR, BHC (8-32x.38 LW) ANVIL	93
4	4	4	–	A	3-21002-3	SCR, BHC (1/4-20x.50) ST GD PL	92
3	3	3	–	A	2-22733-8	SCR, BHC (1/4-20x.62) HSG	91
2	2	2	–	A	1-21000-3	SCR, SKT CAP (4-40x.25) DRAG	90
							89
							88
4	4	4	–	A	2-21000-7	SCR, SHC (8-32x.50) SLUG BLADE	87
3	3	3	–	A	2-21000-5	SCR, SHC (8-32x.25) STRIP GUIDE	86
							85
							84
							83
							82
							81
2	2	2	–	A	3-21000-8	SCR, SKT CAP (10-32x.88) SH PL	80
–	1	–	–	A	455750-8	GUARD ASSY	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, SKT CAP (6-32x.25) CP DSC	73
							72
							71

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

QTY REQD PER ASSY — PARTS LIST

-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
	-1	LEADMAKER		AIRFEED			
	-2	BENCH MODEL K		AIRFEED			
	-3	BENCH MODEL G		AIRFEED			
							70
4 –	1	–	–	B	692655-5	AIR FEED VALVE ASSEMBLY	69
							68
–	REF	–	–	A	24042-2	VALVE, SHUT OFF	67
4 –	REF	–	–	B	692655-6	AIR FEED VALVE ASSEMBLY	66
4 1	1	1	–	B	460277-1	AIR FEED ASSY	65
2	2	2	–	A	3-21000-9	SCR, SHC (10-32x1.00) AIR FD ASSY	64
1	–	1	–	A	22294-6	ELBOW, TUBING 1/8NPT - 1/4 T	63
1	–	1	–	A	23238-1	QUICK DISCONNECT	62
15.00	15.00	15.00	IN	A	27319-4	TUBING, POLY-FLO 1/4 DIA	61
							60
1	1	1	–	C	454220-1	CAP, RAM	59
1	1	1	–	D	453736-4	HOUSING	58
							57
							56
							55
							54
4 1	1	1	–	B	460680-2	FEED FINGER ASSY	53
							52
							51
							50
1	1	1	–	A	7-21002-9	BOLT, CRIMPER (5/16-24x1.00)	49
							48
							47
							46
1	1	1	–	A	690191-1	PLUG, NYLON	45
1	1	1	–	C	679275-1	RAM	44
1	1	1	–	A	690125-1	WASHER, LAMINATED	43
1	1	1	–	A	690124-1	WASHER, RAM	42
							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
							34
							33
							32
							31
							30
							29
1	1	1	–	B	4-690451-7	SPACER, STRIPPER	28
1	1	1	–	A	240639-2	STRIPPER	27
1	1	1	–	D	455676-1	PLATE, BASE	26
2	2	2	–	A	22354-8	DRAG, STUD	25
1	1	1	–	B	122286-1	PLATE, STRIP GUIDE	24
1	1	1	–	B	122344-1	PLATE, STRIP HOLD DOWN	23
2	2	2	–	A	4-22281-1	SPRING, DRAG	22
							21
1	1	1	–	A	454177-3	DRAG	20
1	1	1	–	B	679877-1	GUIDE, STRIP (REAR)	19
1	1	1	–	C	454204-2	GUIDE, STRIP (FRONT)	18
							17
							16
							15
							14
							13
							12
1 1	1	1	–	B	240644-5	PLATE, REAR SHEAR	11
2	2	2	–	A	1-240645-2	SPACER, SHEAR PLATE	10
1 1	1	1	–	B	1-240642-8	PLATE, FRONT SHEAR	9
1 1	1	1	–	D	2-456537-1	ANVIL	8
1 1	1	1	–	B	679272-2	BLADE, SLUG	7
							6
							5
1	1	1	–	B	238009-8	SPACER, BLOCK CRIMPER	4
1 1	1	1	–	C	2-456134-9	CRIMPER, INSULATION	3
1	1	1	–	B	2-455888-2	SPACER, CRIMPER	2
1 1	1	1	–	C	679433-2	CRIMPER, WIRE	1

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

QTY REQD PER ASSY — PARTS LIST

P	F	LTR	REVISION RECORD	APP	DATE
		C	0150-6960-96	CE	6-96
		B	0150-5584-94, ADDED -3	CE	8-94
		A	REVISED	CE	11-93

DIMENSIONS IN INCHES. DO NOT SCALE PRINT.
TOLERANCES UNLESS OTHERWISE SPECIFIED:
2 PLC DEC ±.25
3 PLC DEC ±-
4 PLC DEC ±-
ANGLES ± -
SURF TEXTURE, √
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL – HT TR – FIN –

DR 11/1/93 M. O'BRINE | APP 11-2-93 B. WOLFE | CHK 11-2-93 C. ERISMAN | REL 6/3/94 B. MORGAN

AMP Incorporated Harrisburg, PA 17105-3608

NAME END FEED HDM APPLICATOR | MACHINE REF MINI APPL

SCALE – | D | DWG NO 680054 | SHEET 1 OF 1 | REV C

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