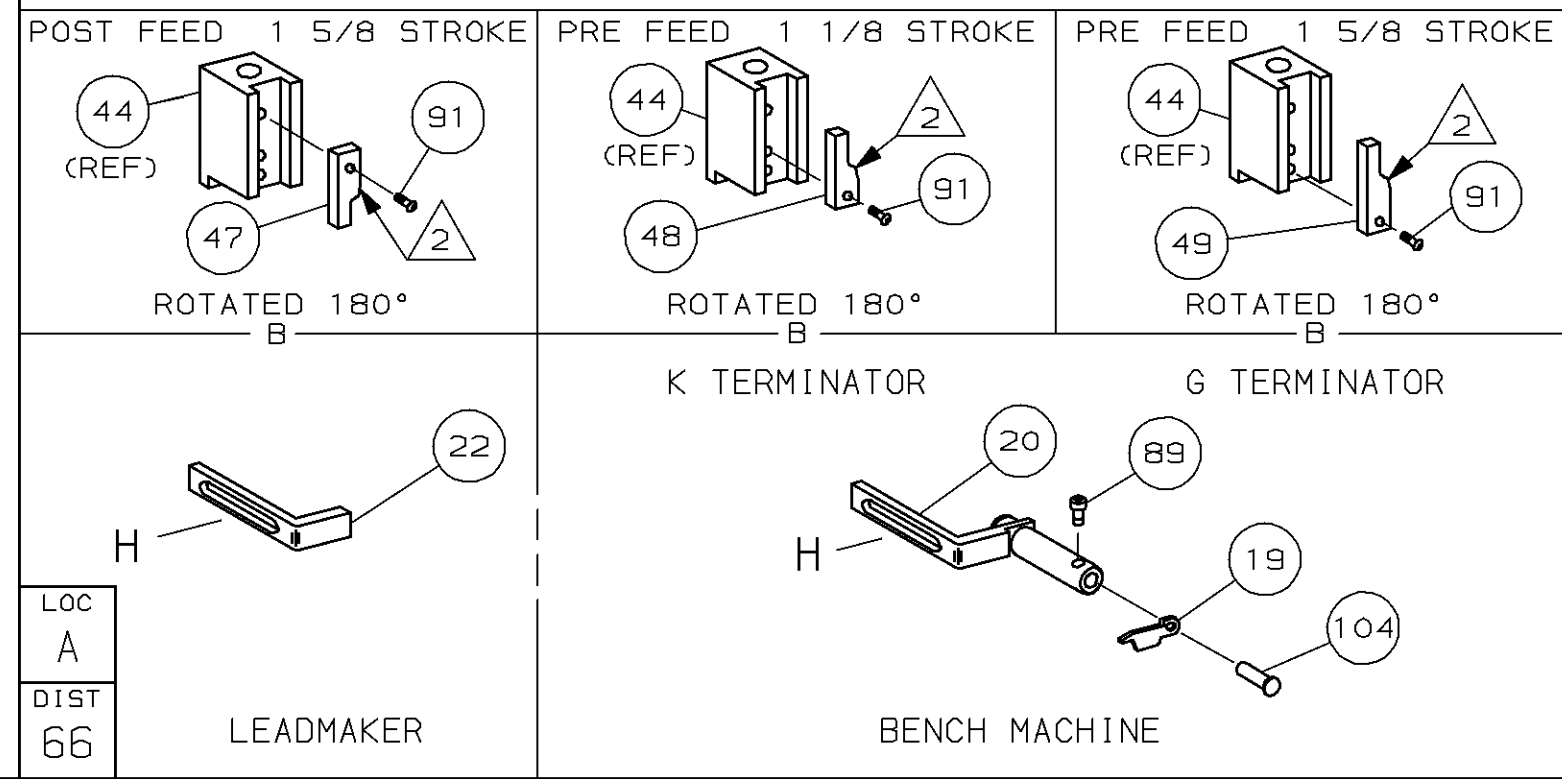
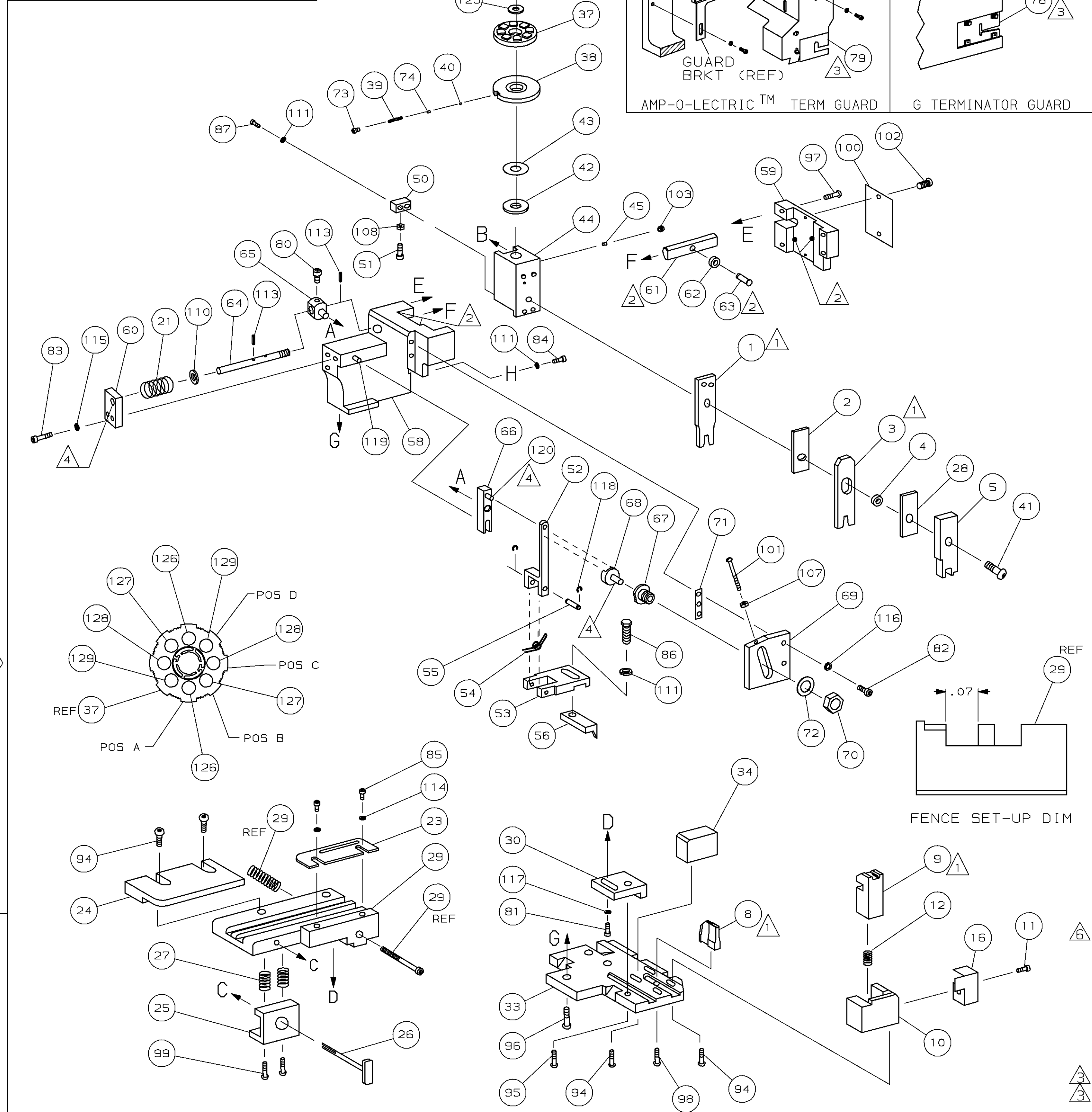


PART NUMBER	REV	FIRST USED
680694-1	A	122500-1
680694-2	A	565435-5
680694-3	A	354500-1



- 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.
- 6 CUT TO LENGTH AT ASSY

TERMINAL NAME: 1MM Ø CONTACT									
				CRIMP DATA (AMP TERMINAL)					
1-962820-2				PAD LTR	CRIMP HEIGHT			WIRE SIZE	
				A	.039 ±.002 [1.0 ±0.05mm]			.5mm ²	
				B	.036 ±.002 [0.91 ±0.05mm]			.35mm ²	
				C	.033 ±.002 [0.85 ±0.05mm]			.25mm ²	
				D	.032 ±.002 [0.83 ±0.05mm]			.2mm ²	
				CRIMP	SIZE		TYPE	RANGE	
				WIRE	.055 [1.40mm]		F	.2mm ² - .5mm ²	
				INSUL	.080 [2.03mm]		0	1.0-1.6mm	
WIRE STRIP LENGTH		TERM APPL SPEC		FEED	APPL INSTRUCTION		SET UP GAGE	LAYOUT	
.140-.156		114-2083		.390	408-8040		458637-1	L2125	
2	2	2	-	C	5-354779-2	PIN, WIRE DISC (.3250)D		129	
2	2	2	-	C	5-354779-0	PIN, WIRE DISC (.3240)C		128	
2	2	2	-	C	4-354779-3	PIN, WIRE DISC (.3205)B		127	
2	2	2	-	C	3-354779-8	PIN, WIRE DISC (.3180)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 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	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	
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.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					

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	455679-1	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	459456-1	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	2-690786-3	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	1-455888-0	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	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 <td>4-22284-9</td> <td>SPRING, FEED RETURN</td> <td>21</td>	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	462006-1	SHEAR, FLOAT (FRONT)	9
1	1	1	-	C	662183-8	ANVIL	8
							7
							6
1	1	1	-	C	2-455889-0	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	1-238011-0	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	7-683454-8	CRIMPER, INSULATION	3
1	1	1	-	C	455888-7	SPACER, CRIMPER	2
1	1	1	-	C	456402-1	CRIMPER, WIRE	1
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY					PARTS LIST		
DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±.02 3 PLC DEC ±.01 4 PLC DEC ±.005 ANGLES ±.005 SURF TEXTURE: ✓ REMOVE BURRS, BREAK SHARP EDGES R.015 MAX					MATL		
					HT TR		
					FIN		
DR B.HIGMAN 10SEP98 APP 10SEP98 T.ELBIN					AMP		
CHK 10SEP98 C.ERISMAN REL -					AMP Incorporated Harrisburg, PA 17105-3608		
NAME					MACHINE REF		
SIDE FEED HDM APPLICATOR					MINI APPL		
SCALE					SHEET		
-					1 OF 1		
DWG NO					REV		
680694					A		
CASE CODE 00779					RESTRICTED TO		
CUSTOMER AND ASSEMBLY DRAWING					-		

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