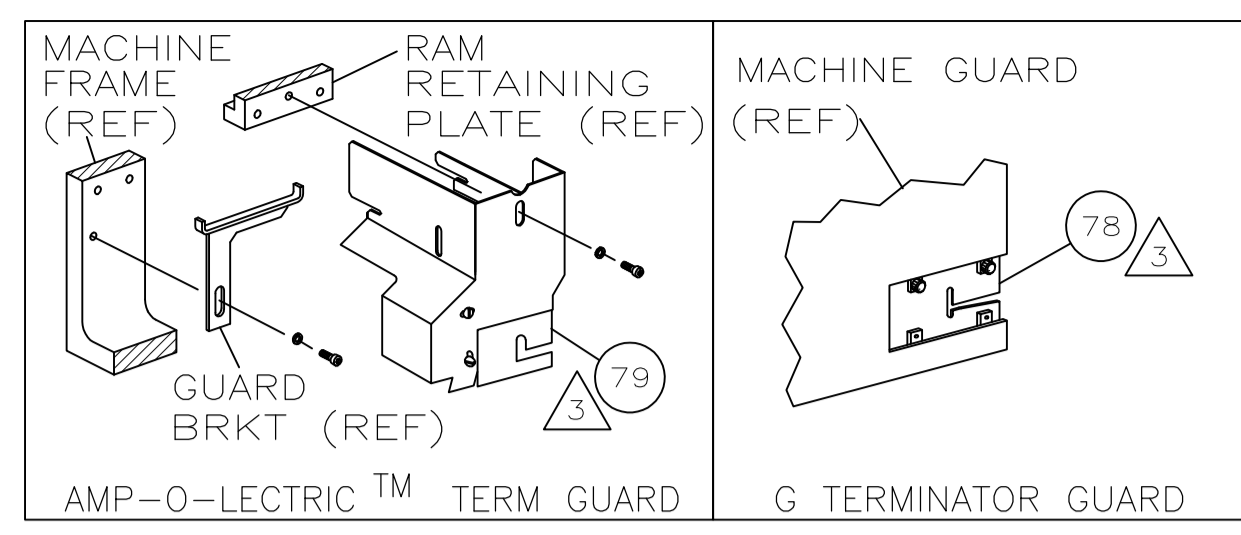
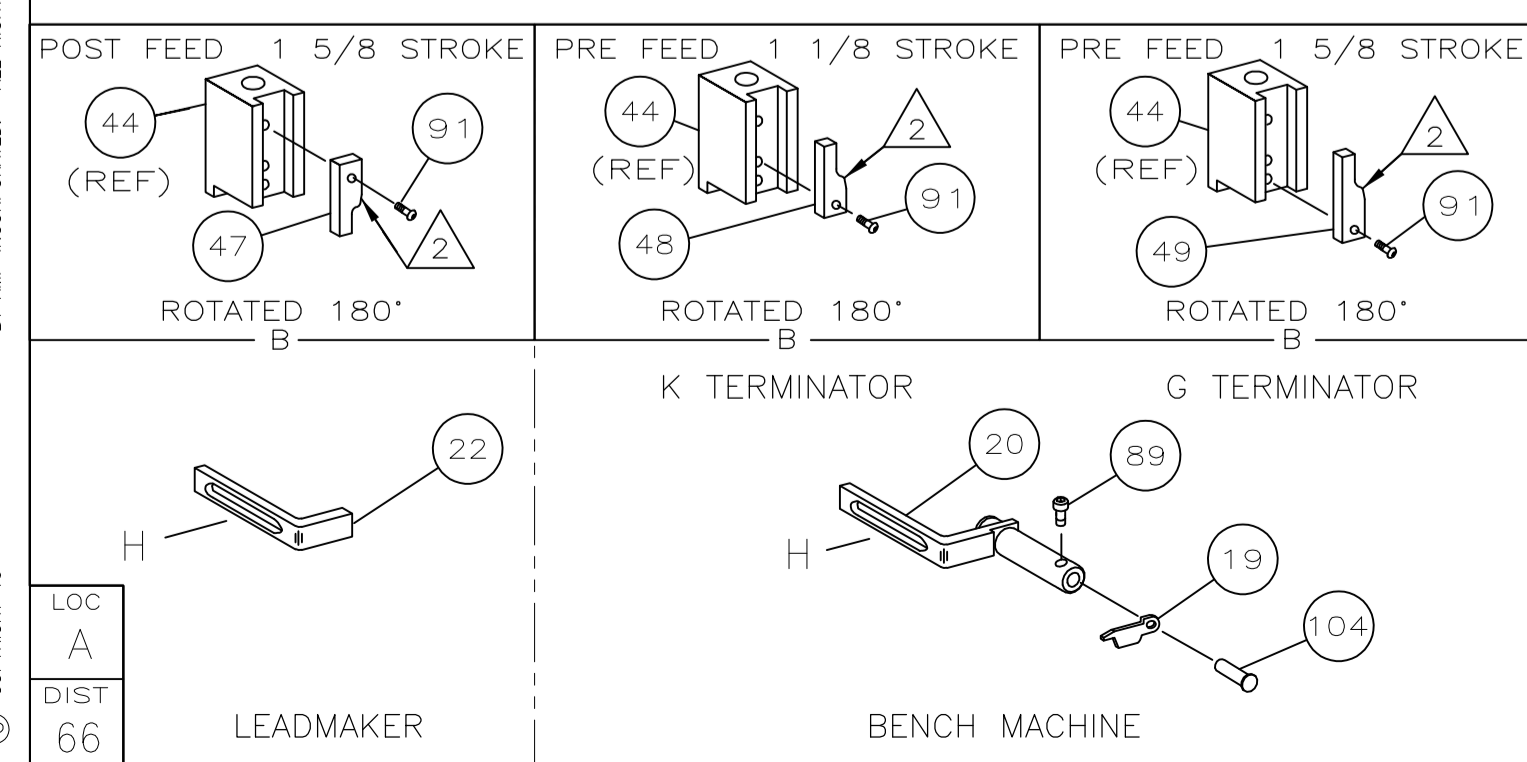
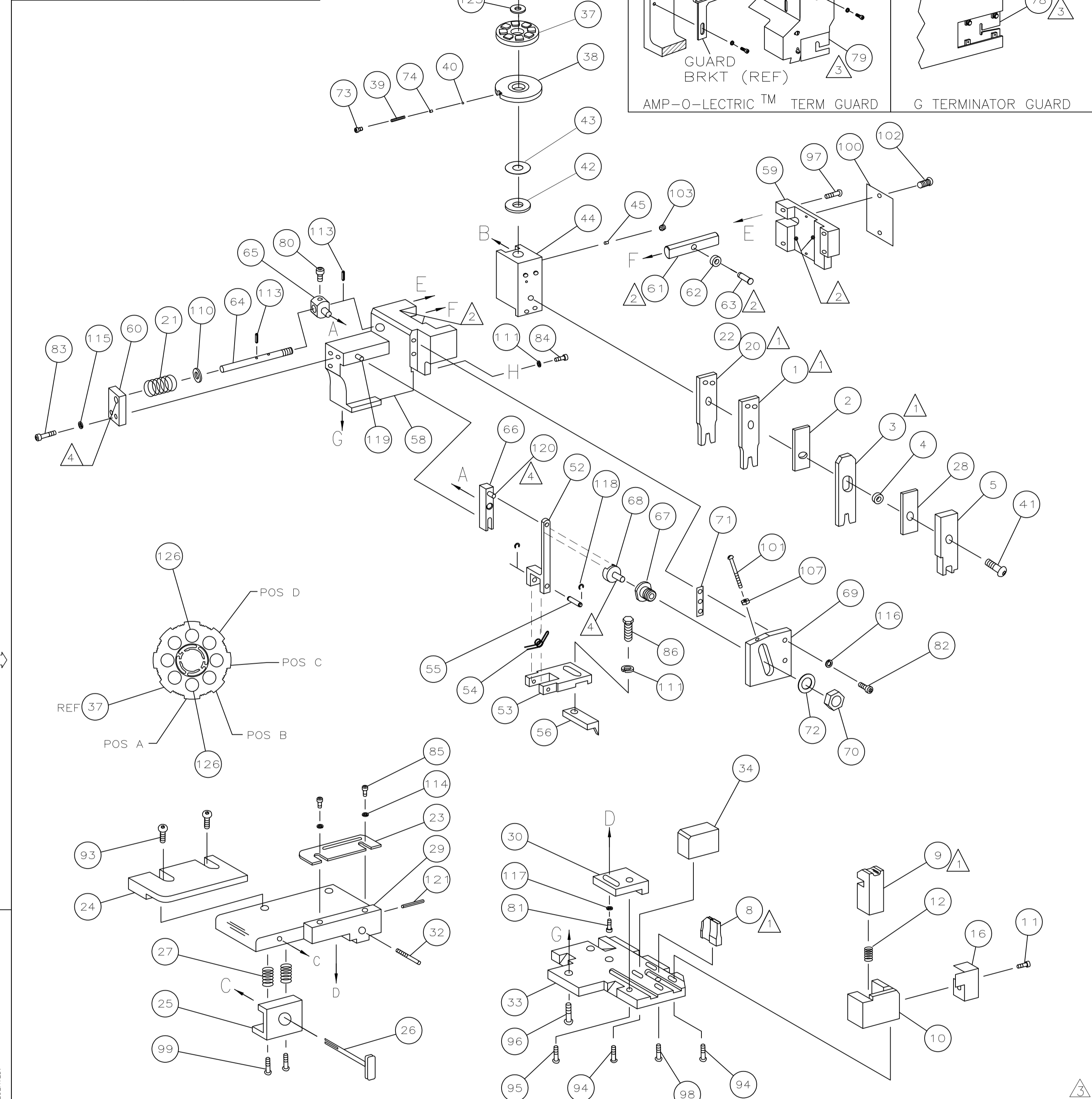


PART NUMBER	REV	FIRST USED
1385036-1	B	122500-1
1385036-2	B	565435-5
1385036-3	B	354500-1



TERMINAL NAME: TERMINAL, AMP-IN			
647334	CRIMP DATA (AMP TERMINAL)		
PAD LTR	STABILIZER CRIMP HEIGHT	WIRE SIZE	
A	.110 <sup>+0.005</sup> <sub>-0.000</sub> [3.94 ±0.05mm]	18-14	
B	NOT	USED	
C	NOT	USED	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.110 [2.79mm]	O	18-14
INSUL	.155 [3.94mm]	F	.090-.150
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
.189-.221	114-1016	.560	408-8040
			SET UP GAGE
			L2348

QTY	REQD	PER	ASSY	PARTS LIST	DESCRIPTION	ITEM NO	
						129	
						128	
						127	
2	2	2	-	C	2-354778-7	PIN, WIRE DISC (.2630)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
						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
						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	21068-5	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
4	4	4	-	A	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
2	2	2	-	A	2-21002-3	SCR,BHC(8-32x.93)R STP GDE	93
						92	
1	1	1	-	A	1-21002-7	SCR,BHC(6-32x.38)CAM	91
						90	
						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
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
						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
						71	
QTY	REQD	PER	ASSY	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-3	-2	-1	U/M				

RECOMMENDED SPARE PARTS.

GREASE LIGHTLY.

GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.

LUBRICATE DAILY USING NO. 20 MACHINE OIL.

5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46. CRIMP HEIGHT TO BE MEASURED OVER CENTER BARREL NOSE CRIMP HEIGHT TO BE .055±.002 FOR 14 AWG WIRE, FOR 16 AND 18 AWG .043±.002

CRIMP HT	WIRE SIZE	CRIMPER NO.	ITEM NO.
.055	14	4-456408-8	20
.043	16 & 18	4-456408-9	22

LOCATE ITEM 19 BETWEEN ITEM 1 & ITEM 3

FOR USE IN PRINTED CIRCUIT BOARD WITH A Ø.125 HOLE.

QTY	REQD	PER	ASSY	PARTS LIST	DESCRIPTION	ITEM NO	
						129	
						128	
						127	
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
						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
						47	
1	1	1	-	B	459456-2	APPLICATOR, BASIC (SUBASSY)	46
1	1	1	-	A	690191-1	PLUG, NYLON	45
1	1	1	-	C	455673-5	RAM	44
1	1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	1	-	A	1-690124-0	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
1	1	1	-	B	469465-1	WIRE, STOP	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
						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	7-690504-4	GUIDE, STRIP (REAR)	24
1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
1	1	1	-	B	4-456408-9	CRIMPER, WIRE	22
REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	21
1	1	1	-	B	4-456408-8	CRIMPER, WIRE	20
1	1	-	-	B	1-690472-3	STRIPPER	19
						18	
						17	
1	1	1	-	B	691667-1	GUARD, CHIP, FRONT	16
						15	
						14	
						13	
1	1	1	-	A	5-22280-0	SPRING, SHEAR	12
1	1	1	-	B	690461-2	STOP, SHEAR	11
1	1	1	-	C	1-690459-0	HOLDER, SHEAR (FRONT)	10
1	1	1	-	C	454276-5	SHEAR, FLOAT (FRONT)	9
1	1	1	-	C	3-662520-3	ANVIL	8
						7	
						6	
1	1	1	-	C	2-455889-0	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	238011-4	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	683454-1	CRIMPER, INSULATION	3
1	1	1	-	C	1-455888-8	SPACER, CRIMPER	2
1	1	1	-	C	815664-2	CRIMPER, WIRE	1
QTY	REQD	PER	ASSY	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-3	-2	-1	U/M				

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: T.KINT 24FEB00 APP: 24FEB00 T.ELBIN

CHK: 24FEB00 REL: -

NAME: SIDE FEED HDM APPLICATOR MACHINE REF: MINI APPL

SCALE: - DWG NO: 1385036 SHEET: 1 OF 1 REV: B1

CAGE CODE: 00779 CUSTOMER AND ASSEMBLY DRAWING

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