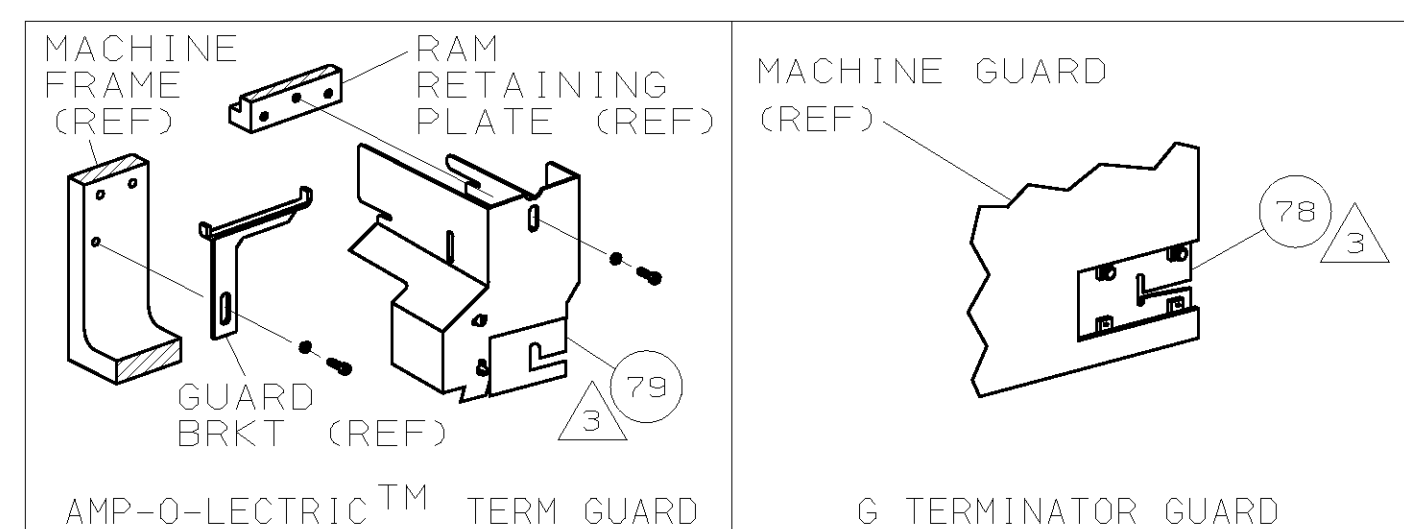


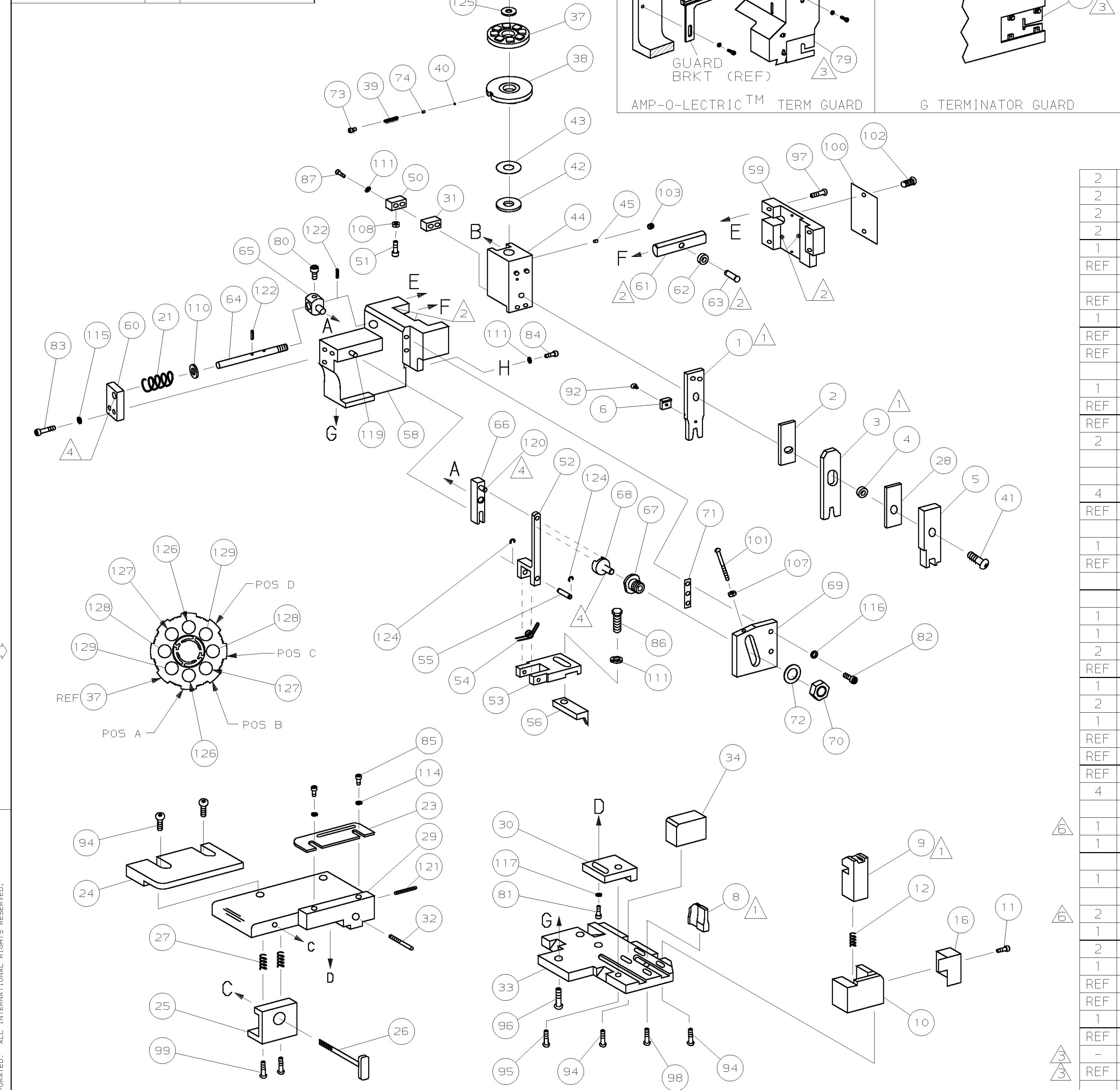
PART NUMBER	REV	FIRST USED
680124-1	F	854400-1
680124-2	F	565435-5
680124-3	F	354500-1



TERMINAL NAME:		CRIMPING DATA	
.040 SERIES RECEPTACLE		PAD LTR	WIRE SIZE
	638009-5	A	18
	638187-3	B	0.75mm ²
	638098-7	C	20
	638099-7	D	0.5mm ²
CRIMP	SIZE	TYPE	RANGE
WIRE	.066 [1.68mm]	F	20-18 & 0.5-0.75mm ²
INSUL	.080 MAX [2.03mm]	F	.047-.075
FEED	APPL INST	SET UP GAGE	LAYOUT
.453	408-8040	458637-1	L1603
TERM APPL SPEC		WIRE STRIP LENGTH	
114-6063		.189-.220	

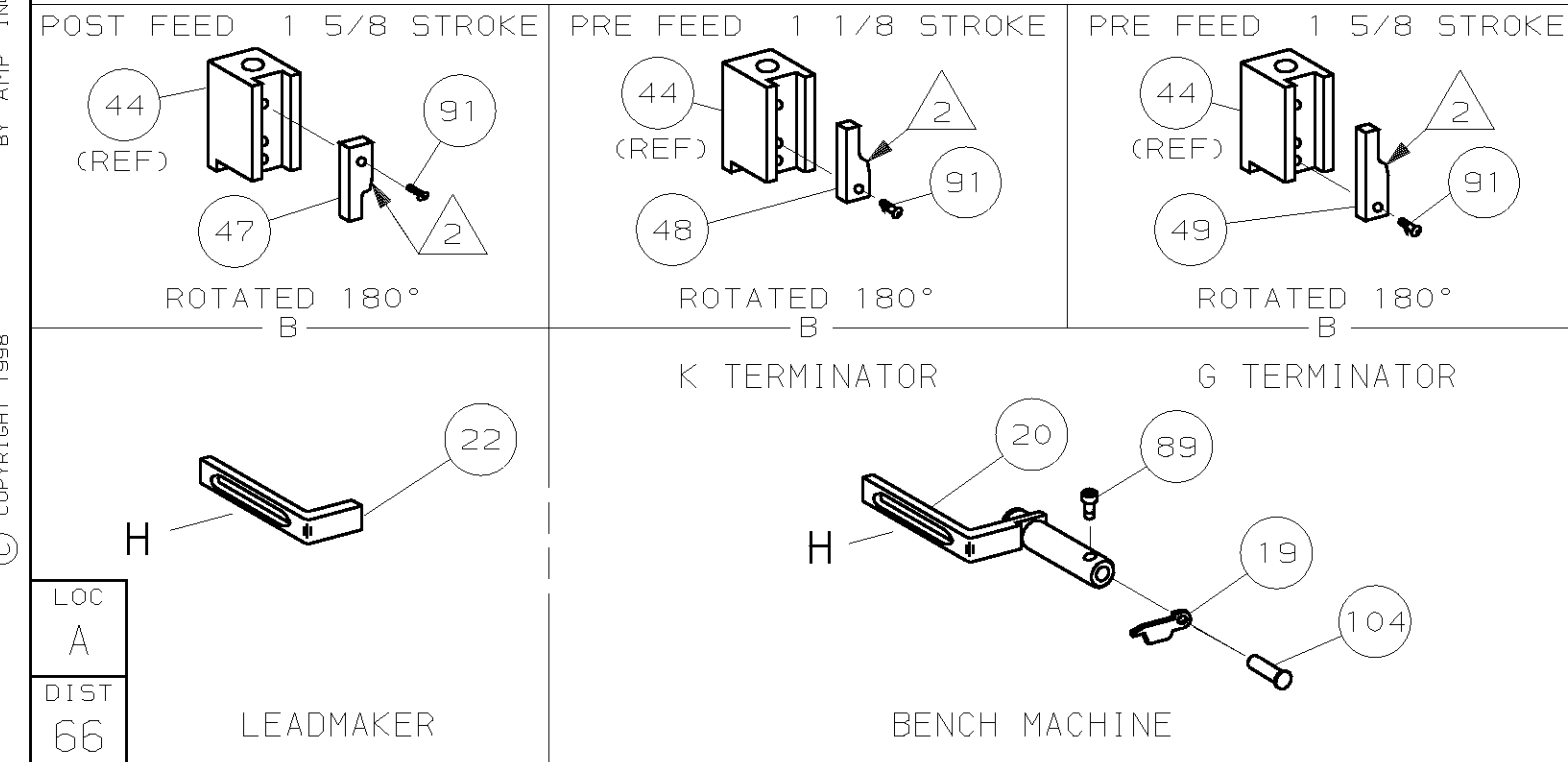
LEADMAKER		MECH POST FEED		MECH PRE FEED	
-1	-2	BENCH MODEL K	BENCH MODEL G	MECH PRE FEED	
REF	REF	REF	- B	22594-8	NUT, HEX (1/2-20)
REF	REF	REF	- B	240628-1	PLATE, ADJUSTMENT
REF	REF	REF	- B	240626-1	SHAFT, PIVOT
REF	REF	REF	- B	240633-1	BUSHING
REF	REF	REF	- A	455680-1	LEVER, INTERMEDIATE
REF	REF	REF	- B	240629-1	BLOCK, PIVOT
REF	REF	REF	- A	240632-2	SCREW, ADJ FEED ROD
REF	REF	REF	- B	240659-3	PIN, CAM ROLLER
REF	REF	REF	- B	240658-1	ROLLER, CAM
REF	REF	REF	- B	454398-2	ROD, FEED
REF	REF	REF	- A	454178-1	GUIDE, FEED ROD
REF	REF	REF	- C	454220-1	CAP, RAM
REF	REF	REF	- D	454485-1	HOUSING

THIS DRAWING IS A CONTROLLED DOCUMENT



2	2	2	-	C	4-354779-8	PIN, WIRE DISC (.3230)D	129
2	2	2	-	C	4-354779-4	PIN, WIRE DISC (.3210)C	128
2	2	2	-	C	3-354779-8	PIN, WIRE DISC (.3180)B	127
2	2	2	-	C	3-354779-4	PIN, WIRE DISC (.3160)A	126
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
REF	REF	REF	-	A	21045-3	RING, RET "C" (Ø.187)FD FING PIN	124
REF	REF	REF	-	A	5-21028-1	PIN, SLT SPR (Ø.125x.50)ADJ ROD	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
1	1	1	-	A	21024-5	WASHER, LOCK (#10)ADJ BLOCK	118
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
4	4	4	-	A	21024-4	WASHER, LOCK (#8)STRIPPER	111
REF	REF	REF	-	A	21899-4	WASHER, FLAT (Ø5/16) SCREW ADJ	110
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
1	1	1	-	A	992031-1	PIN, CLEVIS	105
1	1	1	-	A	21009-2	SCR, SKT 5ET (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
4	4	4	-	A	2-21002-2	SCR, BHC (8-32x.50)SHEAR	94
1	1	1	-	A	1-21003-8	SCR, FHC (6-32x.25)DEP	92
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38)CAM	91
1	1	1	-	A	7-21000-9	SCR, SHC (4-40x.19)STRIPPER	89
2	2	2	-	A	2-21000-7	SCR, SHC (8-32x.47)SPACER	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)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
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
REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)							
QTY REOD PER ASSY							
PARTS LIST							
F	0150-0720-02	GB	MAY02	DIMENSIONS IN INCHES. DO NOT SCALE PRINT.			
E	0150-0561-01	CE	JUN01	TOLERANCES UNLESS OTHERWISE SPECIFIED:			
D2	0150-9401-99	PM	6-99	3 PLC DEC ±			
D1	0150-8547-98	TB	5-98	4 PLC DEC ±			
D	0150-8333-98	TB	3-98	ANGLES ±			
C	0150-7978-97	TB	9-97	SURF TEXTURE: ✓			
B1	0150-7644-97	TB	4/97	REMOVE BURRS, BREAK SHARP EDGES R.015 MAX			
B	EC 0150-5983-95	CE	3-95	SCALE			
A	RELEASED	CE	11-94	DWG NO 680124			
P/F	LTR	REVISION RECORD	APP	DATE	SHEET 1 OF 1		

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
-	-	-	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST	48
-	-	-	-	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	690786-6	SUPPORT, TERMINAL	34
REF	REF	REF	-	D	455675-1	PLATE, BASE	33
1	1	1	-	A	690432-3	SCREW, ADJUSTMENT	32
1	1	1	-	B	6-240641-4	SPACER, TONKER	31
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	C	217231-1	PLATE, STRIP GUIDE	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	217233-1	DRAG, TERMINAL	25
1	1	1	-	B	1-679651-4	GUIDE, STRIP (FRONT)	23
-	-	1	-	B	690472-2	STRIPPER	22
REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	21
1	1	1	-	A	679218-1	STRIPPER WIRE STOP ASSY	20
1	1	1	-	B	458949-1	STRIPPER	19
1	1	1	-	B	691667-1	GUARD, CHIP (FRONT)	16
1	1	1	-	C	224405-1	DEPRESSOR, WIRE	6
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	2-238011-2	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	5-456134-4	CRIMPER, INSULATION	3
1	1	1	-	C	1-455888-5	SPACER, CRIMPER	2
1	1	1	-	C	856313-2	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 REOD PER ASSY							
PARTS LIST							
MATL	-	HT TR	-	FIN	-	DIMENSIONS IN INCHES. DO NOT SCALE PRINT.	
TOLERANCES UNLESS OTHERWISE SPECIFIED:							
DR	8/26/94	APP	9-11-94	AMP Incorporated			
R O WILSON	REL	11/30/94	T ELBIN	Harrisburg, PA 17105-3608			
CHK 9-7-94	REL	11/30/94	B. MORGAN	AMP Incorporated			
C ERISMAN	REL	11/30/94	B. MORGAN	Harrisburg, PA 17105-3608			
NAME: SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL							
SCALE: DWG NO 680124 SHEET 1 OF 1 REV F							
CAGE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO							



- 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 ASSEMBLY.

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