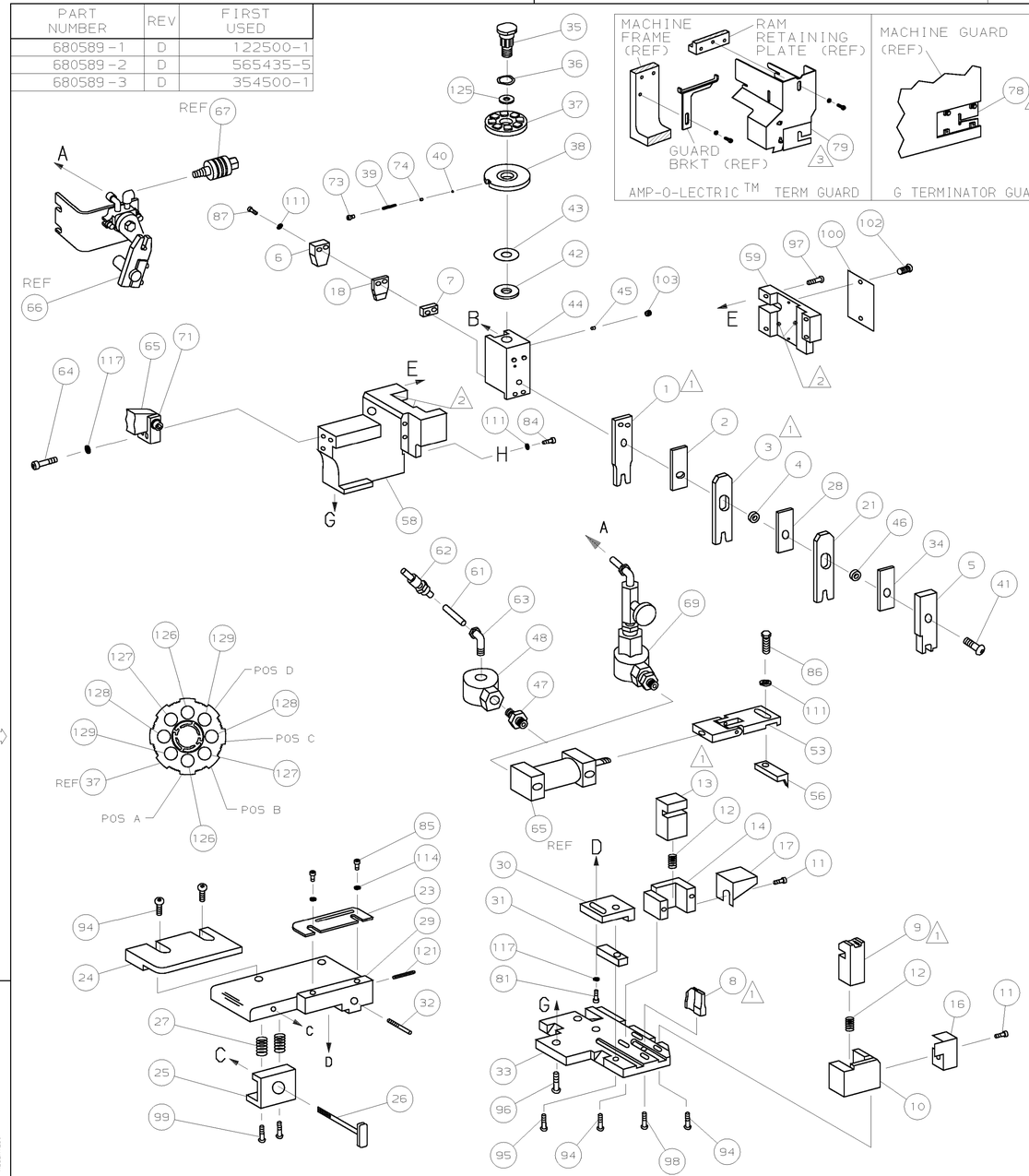
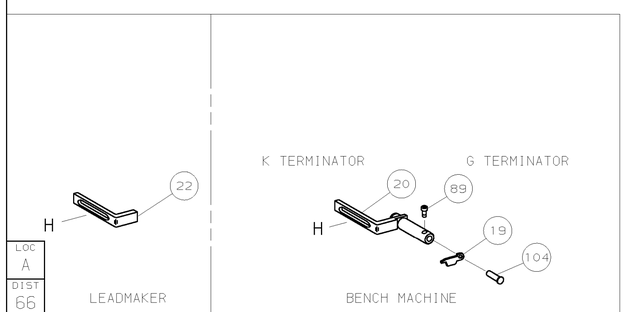
DRAWING MADE IN THIRD ANGLE PROJECTION

680589 ⇦ 680589

/home/ampl4442/edmmod

PART NUMBER	REV	FIRST USED
680589-1	D	122500-1
680589-2	D	565435-5
680589-3	D	354500-1





1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
4. SEE DRAWING FOR COMPONENTS
5. 16 AWG NOT RECOMMENDED PER PRODUCT ENGINEERING.

TERMINAL NAME: TERMINAL, SPECIAL 1217028

CRIMP DATA (AMP TERMINAL)

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.056 ±.002 [1.42 ±0.05mm]	16 5
B	.048 ±.002 [1.22 ±0.05mm]	18
C	.044 ±.002 [1.12 ±0.05mm]	20
D	.040 ±.002 [1.02 ±0.05mm]	22

CRIMP	SIZE	TYPE	RANGE
WIRE	.080 [2.03mm]	F	22-16
INSUL	.100 [2.54mm]	F	.070-.090

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.156-.187	NONE	.473	408-8040	458637-1	L2054

-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	2	2	-	C	4-354779-2	PIN, WIRE DISC (.3200)D	129
2	2	2	-	C	3-354779-4	PIN, WIRE DISC (.3160)C	128
2	2	2	-	C	2-354779-6	PIN, WIRE DISC (.3120)B	127
2	2	2	-	C	1-354779-0	PIN, WIRE DISC (.3040)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
							120
							119
							118
3	3	3	-	A	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
							116
							115
2	2	2	-	A	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
							113
							112
4	4	4	-	A	21024-4	WASHER,LOCK(#8)STRIPPER	111
							110
							109
							108
							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
							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
4	4	4	-	A	2-21002-9	SCR,BHC(10-32x.75)CAP	97
3	3	3	-	A	2-22733-8	SCR,BHC(1/4-20x.62)HSG	96
1	1	1	-	A	2-21002-8	SCR,BHC(10-32x.62)SG ADJ BLK	95
6	6	6	-	A	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
							93
							92
							91
							90
1	1	-	-	A	7-21000-9	SCR,SHC(4-40x.19)STRIPPER	89
							88
2	2	2	-	A	3-21000-0	SCR,SHC(8-32x.75)DEP-HOLD	87
1	1	1	-	A	2-22603-1	SCR,HEX HD(8-32x.38)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
							83
							82
1	1	1	-	A	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
							80
-	1	-	-	B	462992-7	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,SHC(6-32x.25 SL)INS DISC	73
							72
1	1	1	-	B	459610-3	MOUNT, FEED BRACKET	71

QTY REQD PER ASSY — PARTS LIST

-1	LEADMAKER	AIRFEED
-2	BENCH MODEL K	AIRFEED
-3	BENCH MODEL G	AIRFEED

-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
							70
-	1	-	-	C	692655-5	AIR FEED VALVE ASSY	69
							68
-	REF	-	-	A	24042-2	VALVE, SHUT OFF	67
-	REF	-	-	C	692655-6	AIR FEED VALVE ASSY	66
1	1	1	-	B	461065-1	AIR FEED ASSY (1 INCH)	65
2	2	2	-	A	3-21000-7	SCR,SHC(10-32x.75)AIR ASSY	64
1	-	1	-	A	980285-2	ELBOW, SWIVEL 1/8 NPT - 1/4 T	63
1	-	1	-	A	23238-1	QUICK DISCONNECT	62
21.00	-	21.00	IN	A	27319-4	TUBING, POLY-FLO ø.25	61
							60
1	1	1	-	C	454220-1	CAP, RAM	59
1	1	1	-	D	454485-1	HOUSING	58
							57
1	1	1	-	B	1-694433-6	PAWL, FEED	56
							55
							54
1	1	1	-	B	461062-1	FEED FINGER ASSY	53
							52
							51
							50
							49
1	-	1	-	A	22374-7	VALVE, QUICK EXHAUST	48
1	-	1	-	A	22304-1	NIPPLE, HEX 1/8 NPT	47
1	1	1	-	-	238011-6	SPACER, BLOCK CRIMPER	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	690686-1	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	-	-	455888-5	SPACER	34
1	1	1	-	D	455675-1	PLATE, BASE	33
1	1	1	-	A	690432-3	SCREW, ADJUSTMENT	32
1	1	1	-	A	1213543-1	SPACER, ADJ BLOCK	31
1	1	1	-	B	455689-3	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	C	3-455671-8	PLATE, STRIP GUIDE	29
1	1	1	-	C	455888-3	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	2-690754-9	DRAG, TERMINAL	25
1	1	1	-	D	9-690504-5	GUIDE, STRIP (REAR)	24
1	1	1	-	A	1-690438-0	GUIDE, STRIP (FRONT)	23
-	-	1	-	B	690472-2	STRIPPER	22
1	1	1	-	A	4-683453-6	INSULATION CRIMPER	21
1	1	-	-	A	679218-1	STRIPPER WIRE STOP ASSY	20
1	1	-	-	B	458949-1	STRIPPER	19
1	1	1	-	A	460801-6	TONKER	18
1	1	1	-	A	691668-1	GUARD, CHIP (REAR)	17
1	1	1	-	B	318563-1	GUARD, CHIP, FRONT	16
							15
1	1	1	-	B	690462-9	HOLDER, SHEAR (REAR)	14
1	1	1	-	C	1213540-1	SHEAR, FLOAT (REAR)	13
2	2	2	-	A	5-22280-0	SPRING, SHEAR	12
2	2	2	-	B	690461-1	STOP, SHEAR	11
1	1	1	-	C	1-690459-9	HOLDER, SHEAR (FRONT)	10
1	1	1	-	C	1213541-1	SHEAR, FLOAT (FRONT)	9
1	1	1	-	C	1338114-1	ANVIL	8
1	1	1	-	C	6-240641-5	SPACER, DEPRESSOR (REAR)	7
1	1	1	-	A	690468-2	DEPRESSOR, SHEAR (REAR)	6
1	1	1	-	C	2-455889-9	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	1-238011-0	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	4-456134-5	CRIMPER, INSULATION	3
1	1	1	-	C	1-455888-0	SPACER, CRIMPER	2
1	1	1	-	C	1-456405-6	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
		D	0150-0671-01	CE	JUN01
		C	ECN 0150-0534-00	AA	8-00
		B	ECN 0150-9448-99	DS	7-99
		A	REVISED	CE	5/98

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 B.HIGMAN 17MAR98 | APP T.ELBIN 17MAR98 | CHK C.ERISMAN 17MAR98 | REL - | - -

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR | MACHINE REF MINI APPL

SCALE - | D | DWG NO 680589 | SHEET 1 OF 1 | REV D

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO -

THIS DRAWING IS A CONTROLLED DOCUMENT.
RELEASED FOR PUBLICATION MAY 11,1998
BY AMP INCORPORATED. ALL RIGHTS RESERVED.
© COPYRIGHT 1998

LOC A | DIST 66

AMP 1756 REV 3-92 27-JUN-01 07:29:25 amp14442

8 7 6 5 4 3