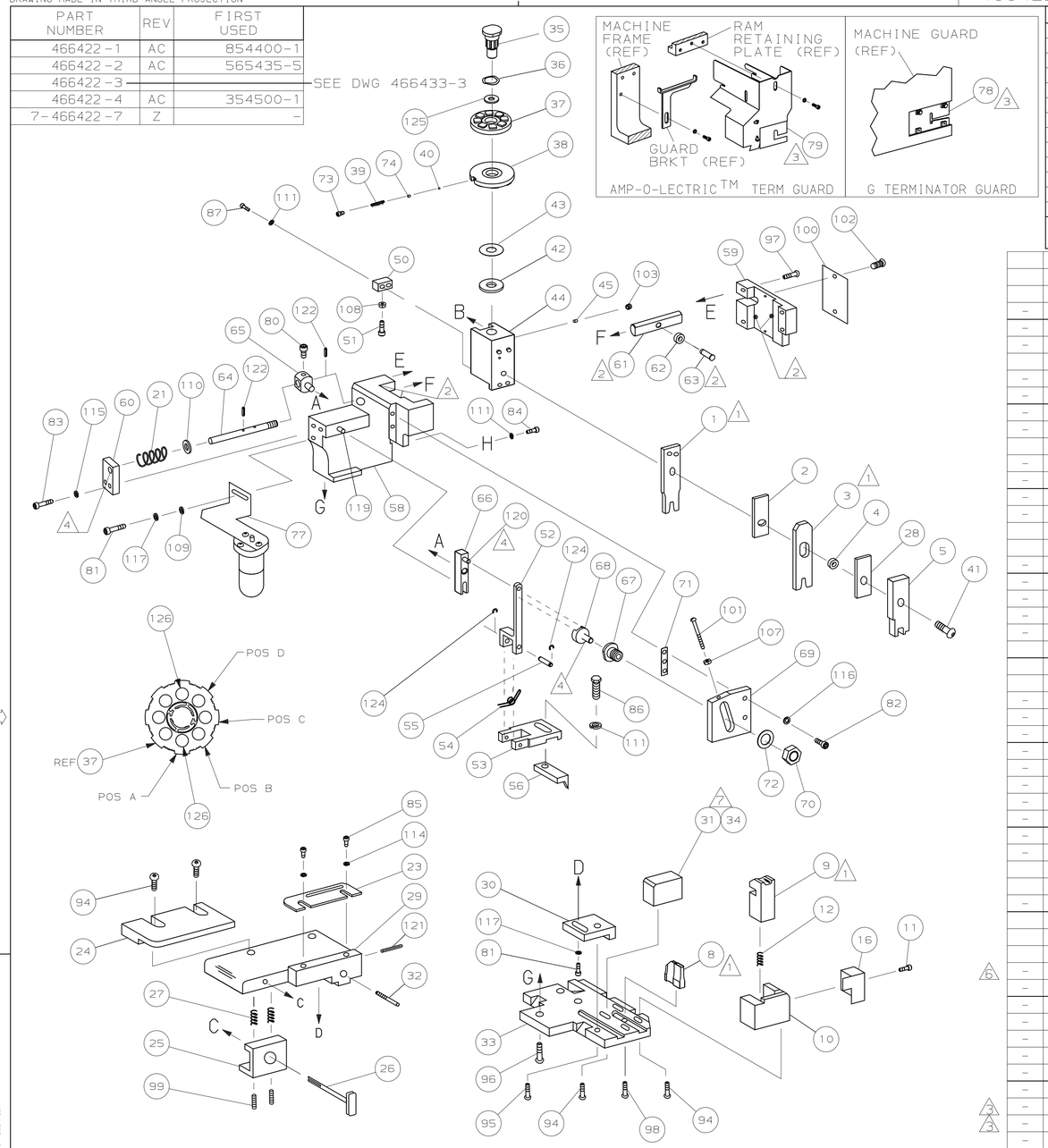
DRAWING MADE IN THIRD ANGLE PROJECTION

466422 ⇔ 466422

/home/us016926/DMTECmod

PART NUMBER	REV	FIRST USED
466422-1	AC	854400-1
466422-2	AC	565435-5
466422-3		SEE DWG 466433-3
466422-4	AC	354500-1
7-466422-7	Z	-



TERMINAL NAME: CONTACT, SOC & PIN,20DF

PIN		SOCKET
66506		66504
745037		748321
166053		166051
786743		

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.032 ±.002 [0.81 ±0.05mm]	20, 22 OR 24
B	NOT	USED
C	NOT	USED
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.055 [1.40mm]	F	24 -20
INSUL	.062 [1.57mm]	O	.050 - .060

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.084-.104	114-10000	.300	408-8040	458637-1	644

-1	LEADMAKER	MECH POST FEED
-2	BENCH MODEL K	MECH PRE FEED
-4	BENCH MODEL G	MECH PRE FEED

-77 SPARE TOOLING KIT

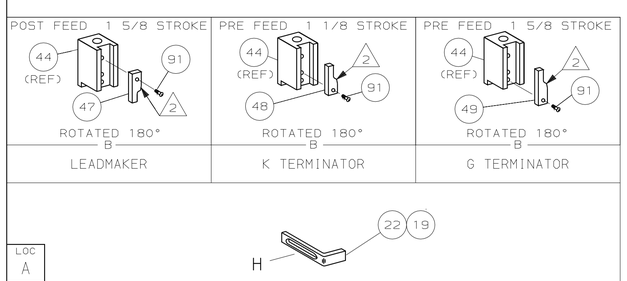
-77	-4	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
								129
								128
								127
-	2	2	2	-	C	5-354779-6	PIN, WIRE DISC (.3270)A	126
-	1	1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
-	REF	REF	REF	-	A	21045-3	RING,RET "C"(ø.187)FD FING PIN	124
								123
-	REF	REF	REF	-	A	5-21028-1	PIN,SLT SPR(ø.125x.50)ADJ 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
								118
-	1	2	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
-	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	-	-	A	21899-2	WASHER,FLAT(NO.10)LUB ASSY	109
-	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
								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	5-21006-6	SCR,SET(10-32x.75)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)SHEAR	94
								93
								92
-	1	1	1	-	A	1-21002-7	SCR,BHC(6-32x.38)CAM	91
								90
								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	2	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
-	-	1	-	-	C	1-465184-0	LUBRICATOR ASSY	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

QTY REQD PER ASSY — PARTS LIST

-77	-4	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-	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	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	455679-1	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	455673-3	RAM	44
-	1	1	1	-	A	690125-1	WASHER, LAMINATED	43
-	1	1	1	-	A	690124-3	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	690142-4	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	1-690786-4	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	690786-6	SUPPORT, TERMINAL	31
-	REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
-	1	1	1	-	C	455671-8	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	679754-1	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	690472-1	STRIPPER	22
-	REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	21
								20
-	1	1	-	-	B	691353-1	STRIPPER	19
								18
								17
-	1	1	1	-	B	691667-1	GUARD, CHIP (FRONT)	16
								15
								14
								13
-	1	1	1	-	A	3-22280-3	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	1	-	C	3-662183-1	ANVIL	8
								7
								6
-	1	1	1	-	C	1-455889-8	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	-	B	2-238011-0	SPACER, BLOCK CRIMPER	4
1	1	1	1	-	C	5-456135-7	CRIMPER, INSULATION	3
-	1	1	1	-	C	455888-2	SPACER, CRIMPER	2
1	1	1	1	-	C	1-456402-5	CRIMPER, WIRE	1

QTY REQD PER ASSY — PARTS LIST

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



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
7. USE ITEM 31 FOR ALL SOCKET STYLE TERMINALS. USE ITEM 34 FOR ALL PIN STYLE TERMINALS.

P	F	LTR	REVISION RECORD	APP	DATE
		AC	ECR-06-026694	TE	11-06
		AB	ECR 05-014015	GB	10-05
		AA	ECN 0150-0219-05	TE	3-05
		Z	0150-0688-03	RK	JUL03
		Y1	0150-0292-02	TB	MAR02
		Y	ECN 0150-0533-01	TE	5-01
		W1	ECN 0150-0307-01	TE	4-01
		W	0150-6764-96	CE	3-96
		V	0150-6507-95	MO	11-95

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

MATL - - | HT TR - - | FIN - -

DR J.BAKER 2/15/95 | APP A BEDDICK 2/15/95
CHK C.ERISMAN 2/15/95 | REL B. MORGAN 4/20/95

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR | MACHINE REF MINI APPL

SCALE - | D | DWG NO 466422 | SHEET 1 of 1 | REV AC

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

LOC A | DIST 66

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