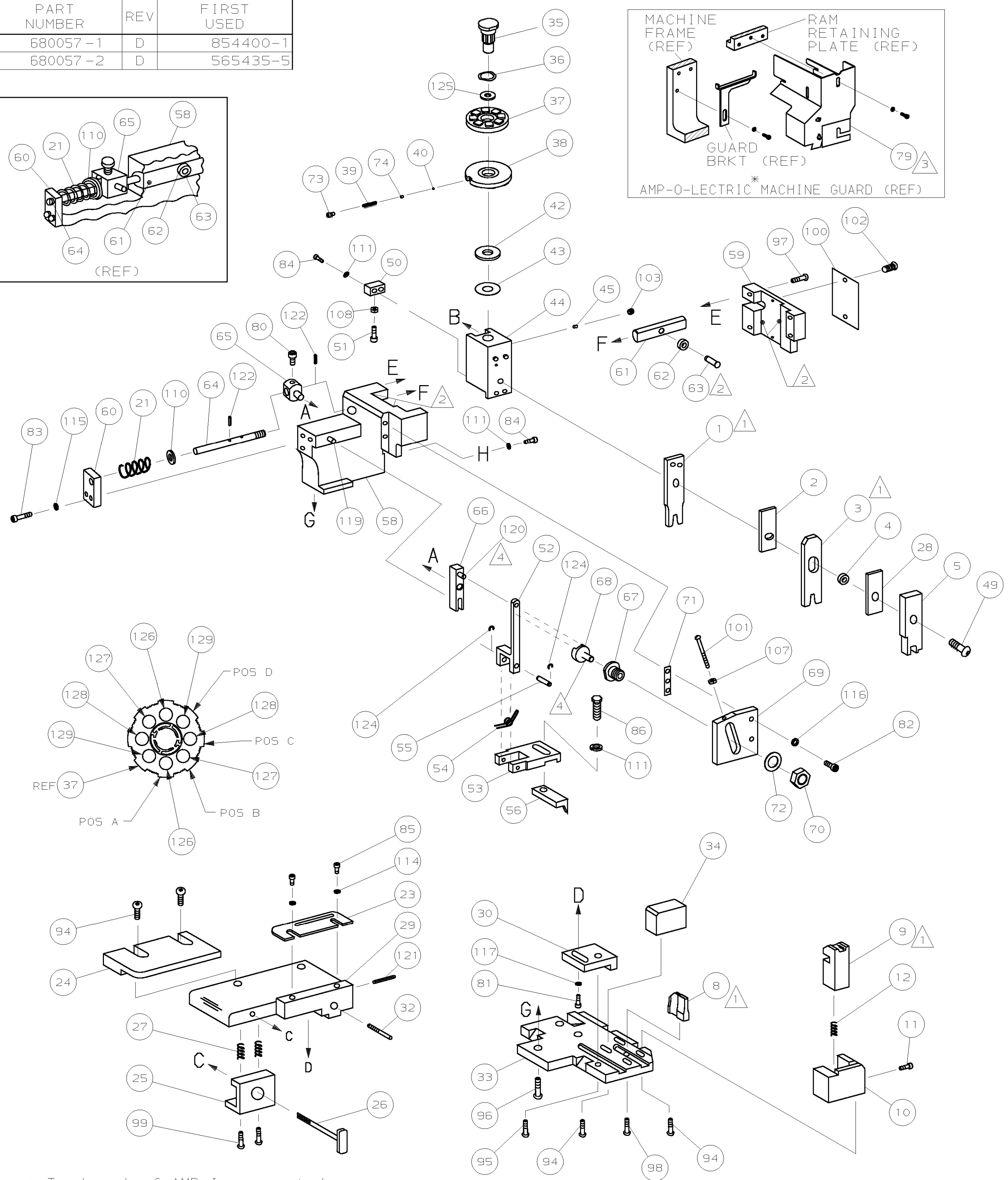
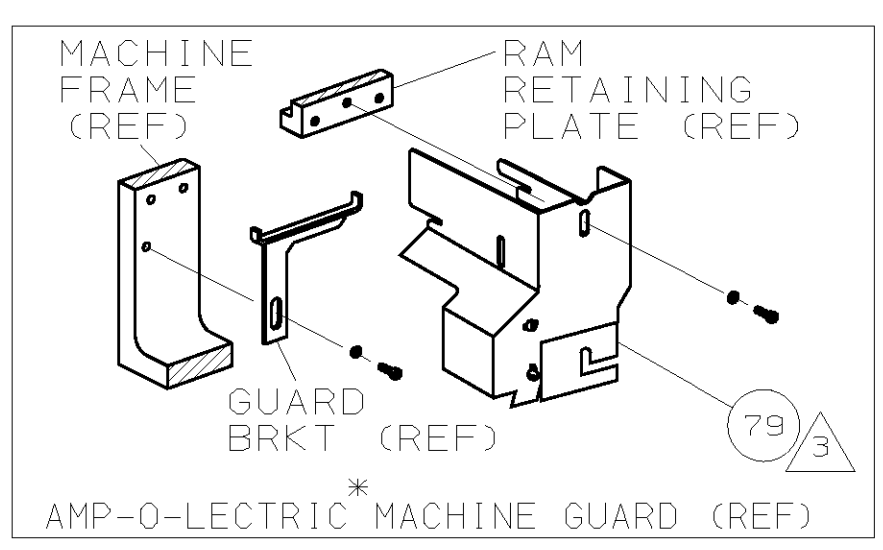
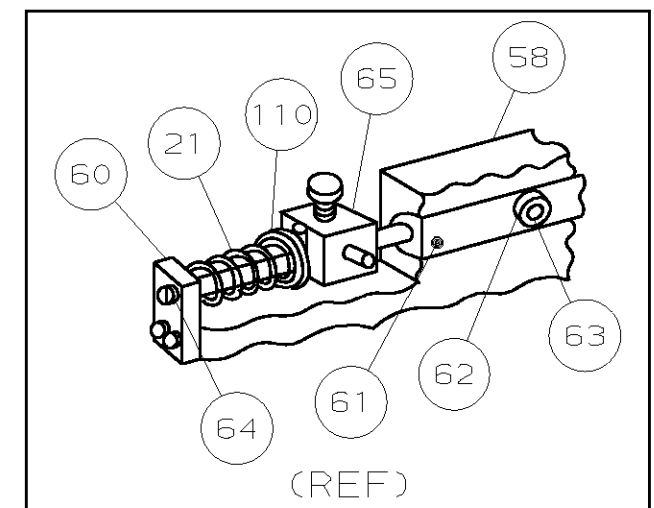


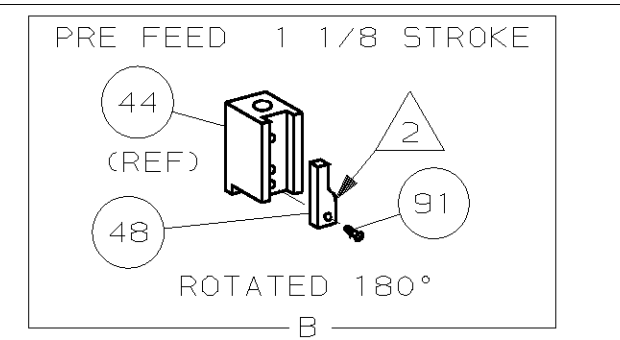
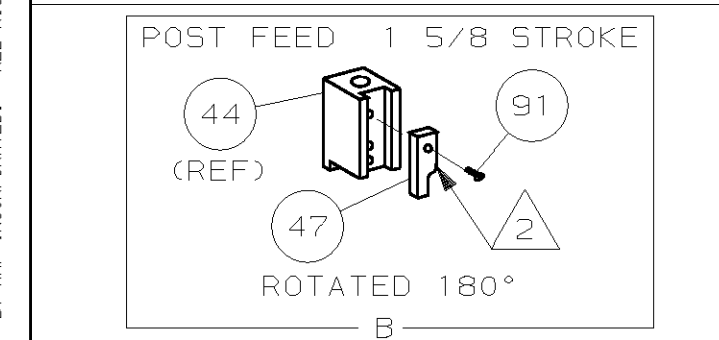
| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------|
| 680057-1 | D | 854400-1 |
| 680057-2 | D | 565435-5 |



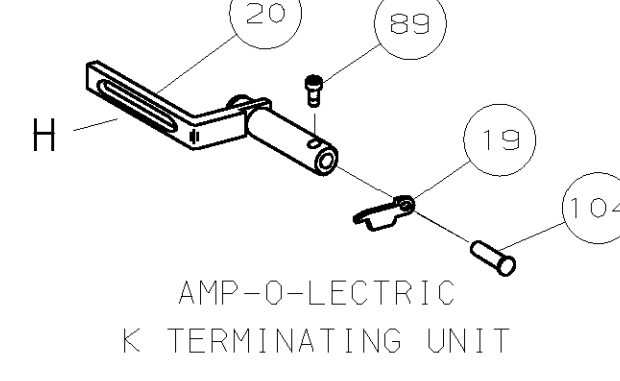
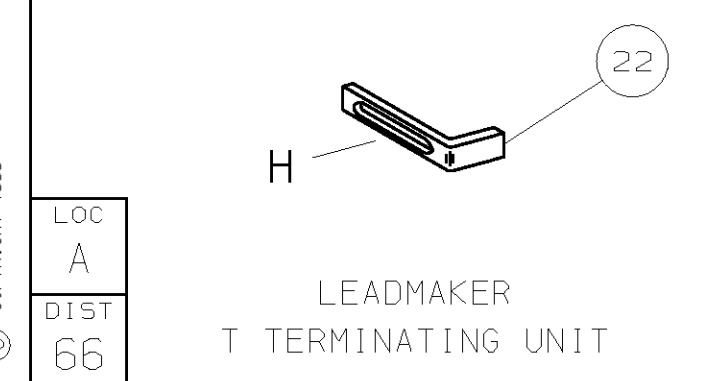
| TERMINAL NAME: | | CRIMPING DATA | | | |
|--------------------------|-----------|-------------------|---------------------------|----------------------|--|
| LOCKING TAB REC 3.3 | | PAD LTR | CRIMP HEIGHT | WIRE SIZE | |
| | 962889 | A | .044 ±.002 | 0.50 MM ² | |
| | | B | .041 ±.002 | 0.35 MM ² | |
| | | C | .039 ±.002 | 0.25 MM ² | |
| | | D | .038 ±.002 | 0.20 MM ² | |
| CRIMP | SIZE | TYPE | RANGE | | |
| WIRE | .062 | F | 0.20-0.50 MM ² | | |
| INSUL | .090 | 0 | 1.15-1.60 MM | | |
| FEED | APPL INST | SET UP GAGE | LAYOUT | | |
| .689 | | 458637-1 | L1541 | | |
| TERM APPL SPEC 114-18022 | | WIRE STRIP LENGTH | | | |
| | | - | | | |

| | | | | | | |
|-----|-----|---|---|------------|-----------------------------------|-----|
| 2 | 2 | - | C | 4-354779-0 | PIN, WIRE DISC (.3190)D | 129 |
| 2 | 2 | - | C | 3-354779-8 | PIN, WIRE DISC (.3180)C | 128 |
| 2 | 2 | - | C | 3-354779-4 | PIN, WIRE DISC (.3160)B | 127 |
| 2 | 2 | - | C | 2-354779-8 | PIN, WIRE DISC (.3130)A | 126 |
| 1 | 1 | - | A | 986950-1 | WASHER, FLAT PRECISION | 125 |
| REF | REF | - | A | 21045-3 | RING, RET "C" (Ø.187)FD FING PIN | 124 |
| REF | REF | - | A | | | 123 |
| REF | REF | - | A | 5-21028-1 | PIN, SLT SPR (Ø.125x.50)ADJ ROD | 122 |
| 1 | 1 | - | A | 4-21028-0 | PIN, SLT SPR (Ø.093x.75)ST GDE PL | 121 |
| REF | REF | - | A | 1-21030-1 | PIN, DOWEL (Ø.187x.50)LEVER | 120 |
| REF | REF | - | A | 1-21030-6 | PIN, DOWEL (Ø.187x1.25)HOUSING | 119 |
| | | | | | | 118 |
| 1 | 1 | - | A | 21024-5 | WASHER, LOCK (#10)ADJ BLOCK | 117 |
| REF | REF | - | A | 21024-5 | WASHER, LOCK (#10)ADJ PLATE | 116 |
| REF | REF | - | A | 21024-5 | WASHER, LOCK (#10)FEED GDE ROD | 115 |
| 2 | 2 | - | A | 21024-2 | WASHER, LOCK (#4)FRONT STP GUIDE | 114 |
| | | | | | | 113 |
| | | | | | | 112 |
| 4 | 4 | - | A | 21024-4 | WASHER, LOCK (#8)STRIPPER | 111 |
| REF | REF | - | A | 21899-4 | WASHER, FLAT (Ø5/16)SCREW ADJ | 110 |
| | | | | | | 109 |
| 1 | 1 | - | A | 21018-5 | NUT, HEX (NO. 6)HOLDDOWN | 108 |
| REF | REF | - | A | 21018-5 | NUT, HEX (6-32)FEED ADJ | 107 |
| | | | | | | 106 |
| | | | | | | 105 |
| 1 | - | - | A | 992031-1 | PIN, CLEVIS | 104 |
| 1 | 1 | - | A | 21009-2 | SCR, SKT SET (1/4-20x.25 LW)RAM | 103 |
| 2 | 2 | - | A | 21017-2 | SCR, DRIVE (#2x.19)ID PLATE | 102 |
| REF | REF | - | A | 6-23715-5 | SCR, PAN HD (6-32x1.50)FEED ADJ | 101 |
| 1 | 1 | - | B | 461264-1 | PLATE, IDENTIFICATION | 100 |
| 2 | 2 | - | A | 3-21002-0 | SCR, BHC (10-32x.88)DRAG | 99 |
| 1 | 1 | - | A | 22733-8 | SCR, BHC (8-32x.38 LW)ANVIL | 98 |
| REF | REF | - | A | 2-21002-9 | SCR, BHC (10-32x.75)CAP | 97 |
| REF | REF | - | A | 2-22733-8 | SCR, BHC (1/4-20x.62)HOUSING | 96 |
| REF | REF | - | A | 2-21002-7 | SCR, BHC (10-32x.50)5G ADJ BLOCK | 95 |
| 6 | 6 | - | A | 2-21002-2 | SCR, BHC (8-32x.50)SHEAR | 94 |
| | | | | | | 93 |
| | | | | | | 92 |
| 1 | 1 | - | A | 1-21002-7 | SCR, BHC (6-32x.38)CAM | 91 |
| | | | | | | 90 |
| 1 | - | - | A | 7-21000-9 | SCR, SHC (4-40x.19)STRIPPER | 89 |
| | | | | | | 88 |
| | | | | | | 87 |
| 1 | 1 | - | A | 2-22603-0 | SCR, HEX HD (8-32x.31)FEED FINGER | 86 |
| 2 | 2 | - | A | 1-21000-3 | SCR, SHC (4-40x.25)F ST GUIDE | 85 |
| 3 | 3 | - | A | 2-21000-7 | SCR, SHC (8-32x.50)STRIPPER | 84 |
| REF | REF | - | A | 3-21000-7 | SCR, SHC (10-32x.75)FEED ROD GD | 83 |
| REF | REF | - | A | 3-21000-6 | SCR, SHC (10-32x.62)FD ADJ BLK | 82 |
| 1 | 1 | - | A | 3-21000-4 | SCR, SHC (10-32x.38)5G ADJ BL | 81 |
| REF | REF | - | A | 3-21000-4 | SCR, SHC (10-32x.38)PIVOT BLK | 80 |
| REF | - | - | B | 455749-1 | GUARD, WINDOW | 79 |
| | | | | | | 78 |
| | | | | | | 77 |
| | | | | | | 76 |
| | | | | | | 75 |
| 1 | 1 | - | A | 690603-1 | SPRING, ASSIST | 74 |
| 1 | 1 | - | A | 23030-1 | SCR, SKT CAP (6-32x.25)CP DSC | 73 |
| REF | REF | - | A | 458109-1 | WASHER, SPECIAL | 72 |
| REF | REF | - | A | 690517-1 | SPACER | 71 |

| -1 | LEADMAKER | MECH-POST FEED | | | | |
|-----|----------------|----------------|---|------------|-----------------------------|----|
| -2 | AMP-0-ELECTRIC | MECH-PRE FEED | | | | |
| REF | REF | - | B | 22594-8 | NUT, HEX (1/2-20) | 70 |
| REF | REF | - | B | 240628-1 | PLATE, ADJUSTMENT | 69 |
| REF | REF | - | B | 240626-1 | SHAFT, PIVOT | 68 |
| REF | REF | - | B | 240633-1 | BUSHING | 67 |
| REF | REF | - | A | 455680-1 | LEVER, INTERMEDIATE | 66 |
| REF | REF | - | B | 240629-1 | BLOCK, PIVOT | 65 |
| REF | REF | - | A | 240632-2 | SCREW, ADJ FEED ROD | 64 |
| REF | REF | - | B | 240659-3 | PIN, CAM ROLLER | 63 |
| REF | REF | - | B | 240658-1 | ROLLER, CAM | 62 |
| REF | REF | - | B | 454398-2 | ROD, FEED | 61 |
| REF | REF | - | A | 454178-1 | GUIDE, FEED ROD | 60 |
| REF | REF | - | C | 454220-1 | CAP, RAM | 59 |
| REF | REF | - | D | 454485-1 | HOUSING | 58 |
| | | | | | | 57 |
| 1 | 1 | - | B | 690542-2 | PAWL, FEED | 56 |
| REF | REF | - | B | 240624-1 | PIN, FEED FINGER | 55 |
| REF | REF | - | B | 691499-1 | SPRING, FEED FINGER | 54 |
| REF | REF | - | B | 690541-1 | HOLDER, FEED FINGER | 53 |
| REF | REF | - | A | 455679-1 | LEVER, TERMINAL FEED ARM | 52 |
| 1 | 1 | - | A | 811242-2 | BUMPER, HOLDDOWN | 51 |
| 1 | 1 | - | A | 690753-1 | SPACER, TONKER | 50 |
| 1 | 1 | - | A | 7-21002-9 | BOLT, CRIMPER (5/16x1.00) | 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 | - | B | 459456-1 | APPLICATOR, BASIC (SUBASSY) | 46 |
| 1 | 1 | - | A | 690191-1 | PLUG, NYLON | 45 |
| 1 | 1 | - | C | 455673-1 | RAM | 44 |
| 1 | 1 | - | A | 690125-1 | WASHER, LAMINATED | 43 |
| 1 | 1 | - | A | 690124-1 | WASHER, RAM | 42 |
| | | | | | | 41 |
| 1 | 1 | - | A | 23241-6 | BALL, STEEL | 40 |
| 1 | 1 | - | A | 690170-1 | SPRING, COMPRESSION | 39 |
| 1 | 1 | - | C | 690142-1 | DISC, INSULATION | 38 |
| 1 | 1 | - | D | 354777-1 | WIRE DISC, PLASTIC | 37 |
| 1 | 1 | - | A | 22480-5 | WASHER, SPRING | 36 |
| 1 | 1 | - | B | 690212-1 | POST, RAM | 35 |
| 1 | 1 | - | B | 690786-3 | SUPPORT, TERMINAL | 34 |
| REF | REF | - | D | 455675-1 | PLATE, BASE | 33 |
| 1 | 1 | - | A | 690432-3 | SCREW, ADJUSTMENT | 32 |
| | | | | | | 31 |
| REF | REF | - | B | 455689-1 | BLOCK, STRIP GUIDE ADJ | 30 |
| 1 | 1 | - | C | 455671-1 | PLATE, STRIP GUIDE | 29 |
| 1 | 1 | - | C | 1-455888-9 | SPACER, FRONT SHEAR DEP | 28 |
| 2 | 2 | - | A | 1-22284-0 | SPRING, DRAG | 27 |
| 1 | 1 | - | B | 690546-1 | LEVER, DRAG RELEASE | 26 |
| 1 | 1 | - | B | 240792-1 | DRAG, TERMINAL | 25 |
| 1 | 1 | - | D | 6-690504-8 | GUIDE, STRIP (REAR) | 24 |
| 1 | 1 | - | A | 690438-1 | GUIDE, STRIP (FRONT) | 23 |
| - | 1 | - | B | 690472-2 | STRIPPER | 22 |
| REF | REF | - | A | 4-22284-9 | SPRING, FEED RETURN | 21 |
| 1 | - | - | A | 679218-1 | STRIPPER WIRE STOP ASSY | 20 |
| 1 | - | - | B | 458949-1 | STRIPPER | 19 |
| | | | | | | 18 |
| | | | | | | 17 |
| | | | | | | 16 |
| | | | | | | 15 |
| | | | | | | 14 |
| | | | | | | 13 |
| 1 | 1 | - | A | 5-22280-0 | SPRING, SHEAR | 12 |
| 1 | 1 | - | B | 690461-1 | STOP, SHEAR | 11 |
| 1 | 1 | - | C | 679625-1 | HOLDER, SHEAR (FRONT) | 10 |
| 1 | 1 | - | C | 462006-4 | SHEAR, FLOAT (FRONT) | 9 |
| 1 | 1 | - | C | 7-854014-9 | ANVIL | 8 |
| | | | | | | 7 |
| | | | | | | 6 |
| 1 | 1 | - | C | 2-455889-0 | DEPRESSOR, SHEAR (FRONT) | 5 |
| 1 | 1 | - | B | 238011-4 | SPACER, BLOCK CRIMPER | 4 |
| 1 | 1 | - | C | 1-683454-4 | CRIMPER, INSULATION | 3 |
| 1 | 1 | - | C | 455888-6 | SPACER, CRIMPER | 2 |
| 1 | 1 | - | C | 3-456403-2 | CRIMPER, WIRE | 1 |



- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-0-ELECTRIC MACHINE.
- 4 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEM 79) ARE USED ON ITEM 46.
- 6. THIS APPLICATOR DOES NOT SHEAR THE CARRIER STRIP.
- 7 GUIDE TERMINAL OFF OF INSULATION BARREL.



| QTY | RECD | PER | ASSY | U/M | DWG | SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|-----|------|-----|-----|------|---------|-------------|---------|
| | | | | | | | | | |

| QTY | RECD | PER | ASSY | U/M | DWG | SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|-----|------|-----|-----|------|---------|-------------|---------|
| | | | | | | | | | |

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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 P.MATHIAS 11/12/93 APP 11-15-93 B.WOLFE
 CHK 11-15-93 REL 12/1/93 C.ERISMAN G.OCHENIS
AMP AMP Incorporated Harrisburg, PA 17105-3608
 NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL
 SCALE - DWG NO 680057 SHEET 1 OF 1 REV D
 CASE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING 1 RESTRICTED TO