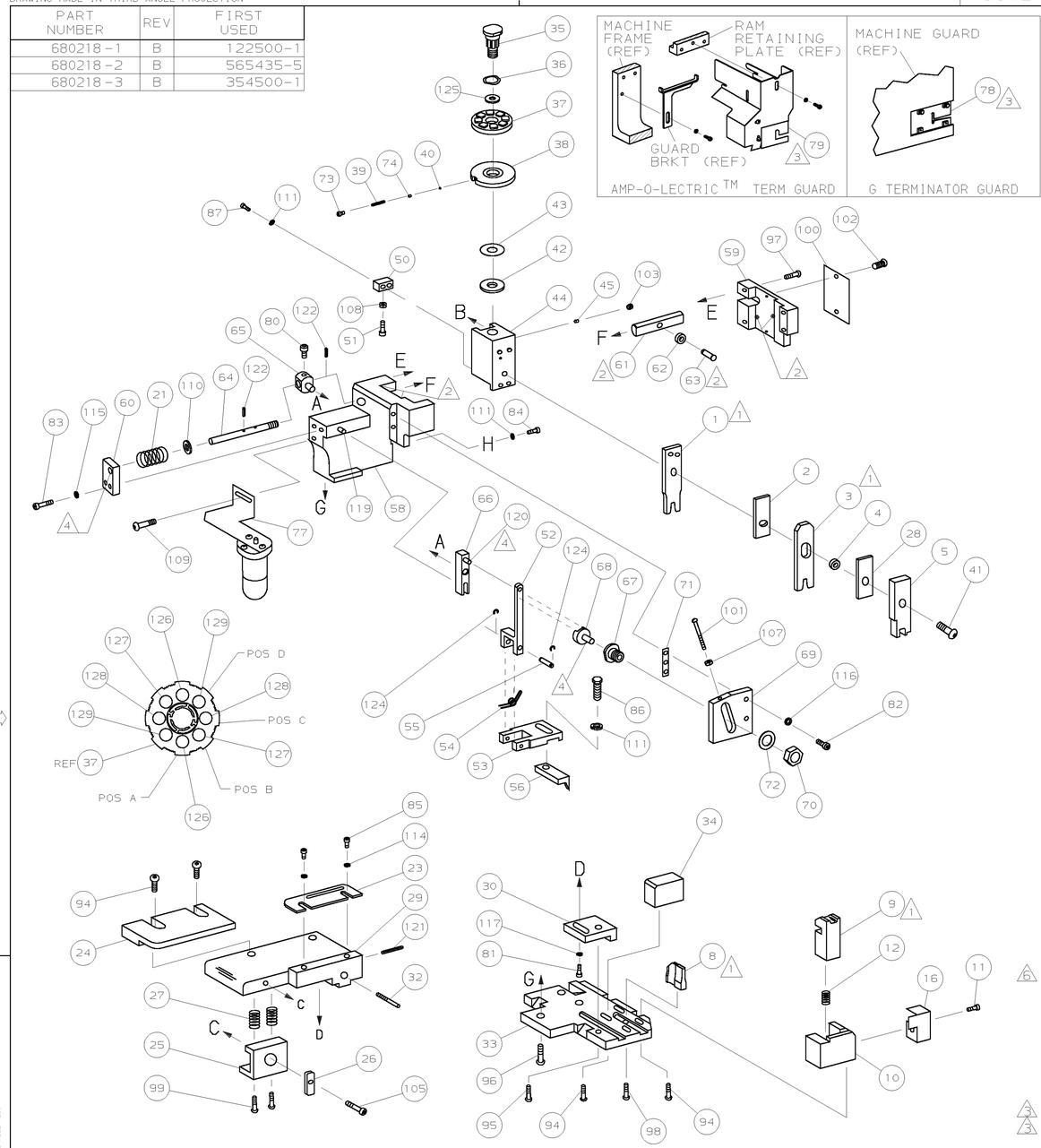
DRAWING MADE IN THIRD ANGLE PROJECTION

/home/amp29062/9194

| PART NUMBER | REV | FIRST USED |
|---|---|---|
| 680218-1 | B | 122500-1 |
| 680218-2 | B | 565435-5 |
| 680218-3 | B | 354500-1 |




TERMINAL NAME: FUSE CONTACT

| 626560 | 626613 |
|---|---|

CRIMPING DATA

| PAD LTR | CRIMP HEIGHT | WIRE SIZE |
|---|---|---|
| A | .088 ±.002 [2.24 ±0.05mm] | 4mm² |
| B | .083 ±.002 [2.11 ±0.05mm] | 3.5mm² |
| C | .079 ±.002 [2.01 ±0.05mm] | 3mm² |
| D | .075 ±.002 [1.91 ±0.05mm] | 2.5mm² |

| CRIMP | SIZE | TYPE | RANGE |
|---|---|---|---|
| WIRE | .140 [3.56mm] | F | 2.5mm²-4mm² |
| INSUL | .220 [5.59mm] | F | 3.3mm-4.5mm |

| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPL INSTRUCTION | SET UP GAGE | LAYOUT |
|---|---|---|---|---|---|
| – | 114-37000 | .590 | 408-8040 | 458637-1 | L1690 |

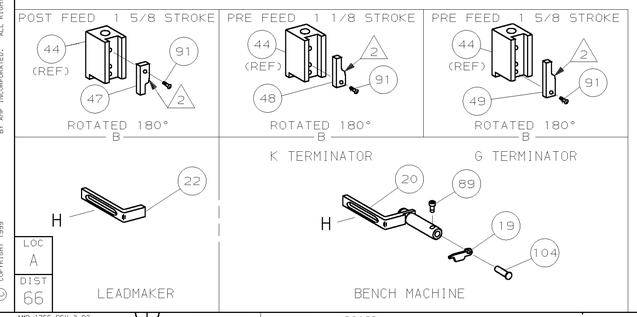
| | | | | | | | |
|---|---|---|---|---|---|---|---|
| 2 | 2 | 2 | – | C | 7-354778-1 | PIN, WIRE DISC (.2850)D | 129 |
| 2 | 2 | 2 | – | C | 6-354778-3 | PIN, WIRE DISC (.2810)C | 128 |
| 2 | 2 | 2 | – | C | 5-354778-5 | PIN, WIRE DISC (.2770)B | 127 |
| 2 | 2 | 2 | – | C | 4-354778-5 | PIN, WIRE DISC (.2720)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.125×.50)ADJ ROD | 122 |
| 1 | 1 | 1 | – | A | 4-21028-0 | PIN,SLT SPR(ø.093×.75)ST GDE PL | 121 |
| REF | REF | REF | – | A | 1-21030-1 | PIN,DOWEL(ø.187×.50)LEVER | 120 |
| REF | REF | REF | – | A | 1-21030-6 | PIN,DOWEL(ø.187×1.25)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 |
| 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 | 2-21002-6 | SCR,BHC(10-32×.38)LUBE 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 |
| 1 | 1 | 1 | – | A | 22353-8 | SCR,SHLD(ø.187×.25)DRAG LEVER | 105 |
| 1 | 1 | – | – | A | 992031-1 | PIN, CLEVIS | 104 |
| 1 | 1 | 1 | – | A | 21009-2 | SCR,SKT SET(1/4-20×.25 LW)RAM | 103 |
| 2 | 2 | 2 | – | A | 21017-2 | SCR,DRIVE(#2×.19)ID PLATE | 102 |
| REF | REF | REF | – | A | 6-23715-5 | SCR,PAN HD(6-32×1.50)FEED ADJ | 101 |
| 1 | 1 | 1 | – | B | 461264-1 | PLATE, IDENTIFICATION | 100 |
| 2 | 2 | 2 | – | A | 3-21002-0 | SCR,BHC(10-32×.88)DRAG | 99 |
| 1 | 1 | 1 | – | A | 22733-8 | SCR,BHC(8-32×.38 LW)ANVIL | 98 |
| REF | REF | REF | – | A | 2-21002-9 | SCR,BHC(10-32×.75)CAP | 97 |
| REF | REF | REF | – | A | 2-22733-8 | SCR,BHC(1/4-20×.62)HOUSING | 96 |
| REF | REF | REF | – | A | 2-21002-7 | SCR,BHC(10-32×.50)SG ADJ BLOCK | 95 |
| 6 | 6 | 6 | – | A | 2-21002-2 | SCR,BHC(8-32×.50)TERM H DWN | 94 |
| | | | | | | | 93 |
| | | | | | | | 92 |
| 1 | 1 | 1 | – | A | 1-21002-7 | SCR,BHC(6-32×.38)CAM | 91 |
| | | | | | | | 90 |
| 1 | 1 | – | – | A | 7-21000-9 | SCR,SHC(4-40×.19)STRIPPER | 89 |
| | | | | | | | 88 |
| 2 | 2 | 2 | – | A | 2-21000-7 | SCR,SHC(8-32×.48)DEP-HOLD | 87 |
| 1 | 1 | 1 | – | A | 2-22603-0 | SCR,HEX HD(8-32×.31)FEED FINGER | 86 |
| 2 | 2 | 2 | – | A | 1-21000-3 | SCR,SHC(4-40×.25)F ST GUIDE | 85 |
| 1 | 1 | 1 | – | A | 2-21000-7 | SCR,SHC(8-32×.50)STRIPPER | 84 |
| REF | REF | REF | – | A | 3-21000-7 | SCR,SHC(10-32×.75)FEED ROD GD | 83 |
| REF | REF | REF | – | A | 3-21000-6 | SCR,SHC(10-32×.62)FD ADJ BLK | 82 |
| 1 | 1 | 1 | – | A | 3-21000-4 | SCR,SHC(10-32×.38)SG ADJ BL | 81 |
| REF | REF | REF | – | A | 3-21000-4 | SCR,SHC(10-32×.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(6-32×.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 |

QTY REQD PER ASSY — PARTS LIST

| -1 | LEADMAKER | MECH POST FEED |
|---|---|---|
| -2 | BENCH MODEL K | MECH PRE FEED |
| -3 | BENCH MODEL G | MECH PRE FEED |

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| 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 | 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 | 455679-2 | 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 | 459456-2 | 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 | 690124-9 | WASHER, RAM | 42 |
| 1 | 1 | 1 | – | A | 7-21002-9 | BOLT, CRIMPER(5/16×1.00) | 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 | 690786-1 | SUPPORT, TERMINAL | 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 | 458144-1 | PLATE, STRIP GUIDE | 29 |
| 1 | 1 | 1 | – | C | 1-455888-5 | SPACER, FRONT SHEAR DEP | 28 |
| 2 | 2 | 2 | – | A | 1-22284-0 | SPRING, DRAG | 27 |
| 1 | 1 | 1 | – | B | 240793-1 | LEVER, DRAG RELEASE | 26 |
| 1 | 1 | 1 | – | B | 240792-1 | DRAG, TERMINAL | 25 |
| 1 | 1 | 1 | – | D | 1-90765-2 | GUIDE, STRIP (REAR) | 24 |
| 1 | 1 | 1 | – | A | 690438-1 | GUIDE, STRIP (FRONT) | 23 |
| – | – | 1 | – | B | 690472-2 | STRIPPER | 22 |
| REF | REF | REF | – | A | 4-22284-9 | SPRING, FEED RETURN | 21 |
| 1 | 1 | – | – | A | 679218-1 | STRIPPER WIRE STOP ASSY | 20 |
| 1 | 1 | – | – | B | 458949-1 | STRIPPER | 19 |
| | | | | | | | 18 |
| | | | | | | | 17 |
| 1 | 1 | 1 | – | B | 318563-1 | 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 | 454276-7 | SHEAR, FLOAT (FRONT) | 9 |
| 1 | 1 | 1 | – | C | 4-189717-2 | ANVIL | 8 |
| | | | | | | | 7 |
| | | | | | | | 6 |
| 1 | 1 | 1 | – | C | 1-455889-8 | DEPRESSOR, SHEAR (FRONT) | 5 |
| 1 | 1 | 1 | – | B | 238011-4 | SPACER, BLOCK CRIMPER | 4 |
| 1 | 1 | 1 | – | C | 3-683453-6 | CRIMPER, INSULATION | 3 |
| 1 | 1 | 1 | – | C | 1-455888-2 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | – | C | 456411-3 | CRIMPER, WIRE | 1 |
| -3 | -2 | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |

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

| | | | | |
|---|---|---|---|---|
| B | 0150-9194-99 | MY | 4/99 | |
| A | REVISED | CE | 1/96 | |
| P F | LTR REVISION RECORD | APP | DATE | |

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 03-NOV-95 M. O'BRINE | APP 11-3-95 T. BEDDICK | AMP Incorporated Harrisburg, PA 17105-3608 | |
| CHK 11-3-95 C. ERISMAN | REL 2/8/96 B. MORGAN | | |
| NAME SIDE FEED HDM APPLICATOR | | MACHINE REF MINI APPL | |
| SCALE – | D | DWG NO 680218 | SHEET 1 OF 1 |
| CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | | RESTRICTED TO – |

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