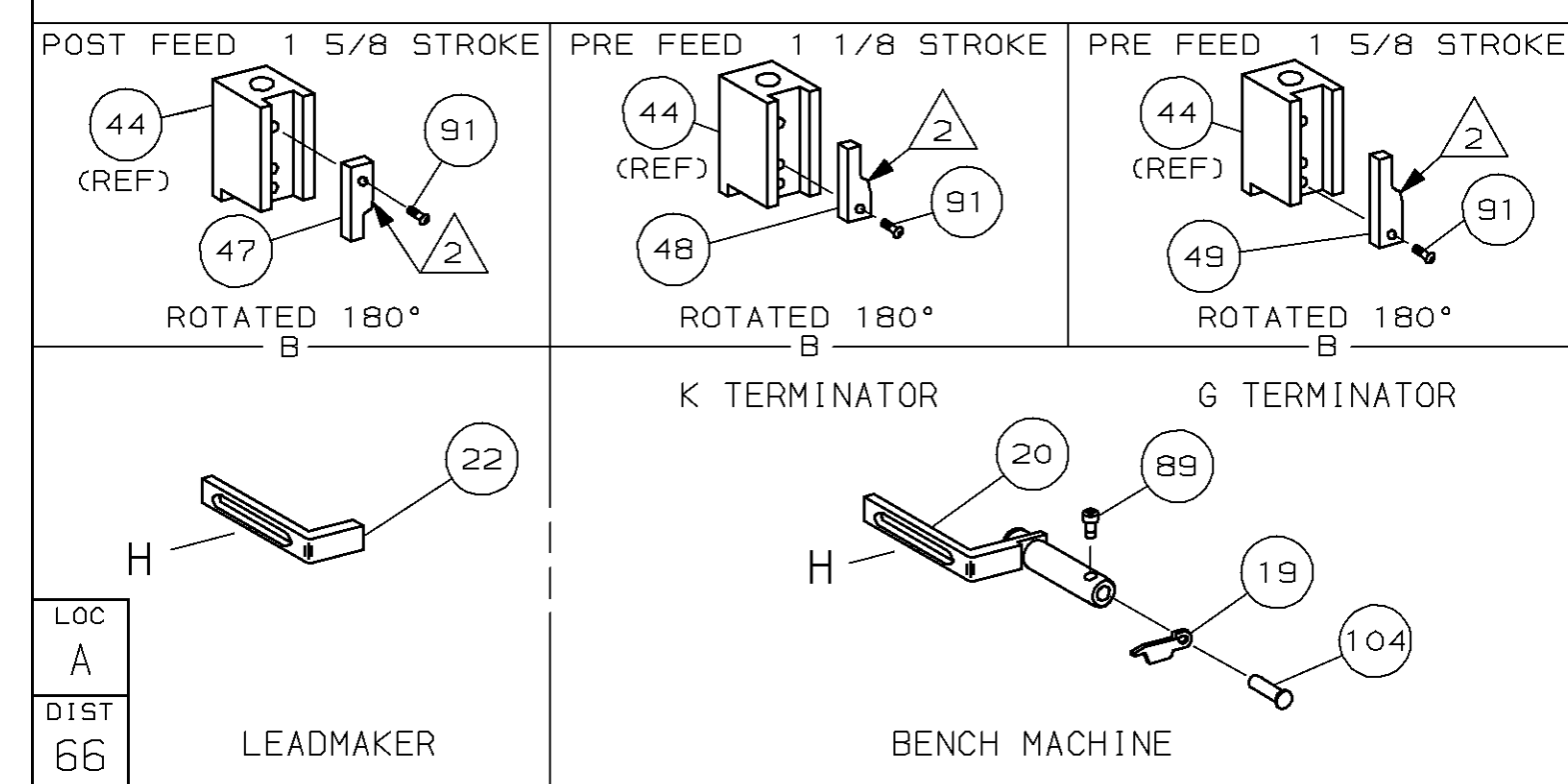
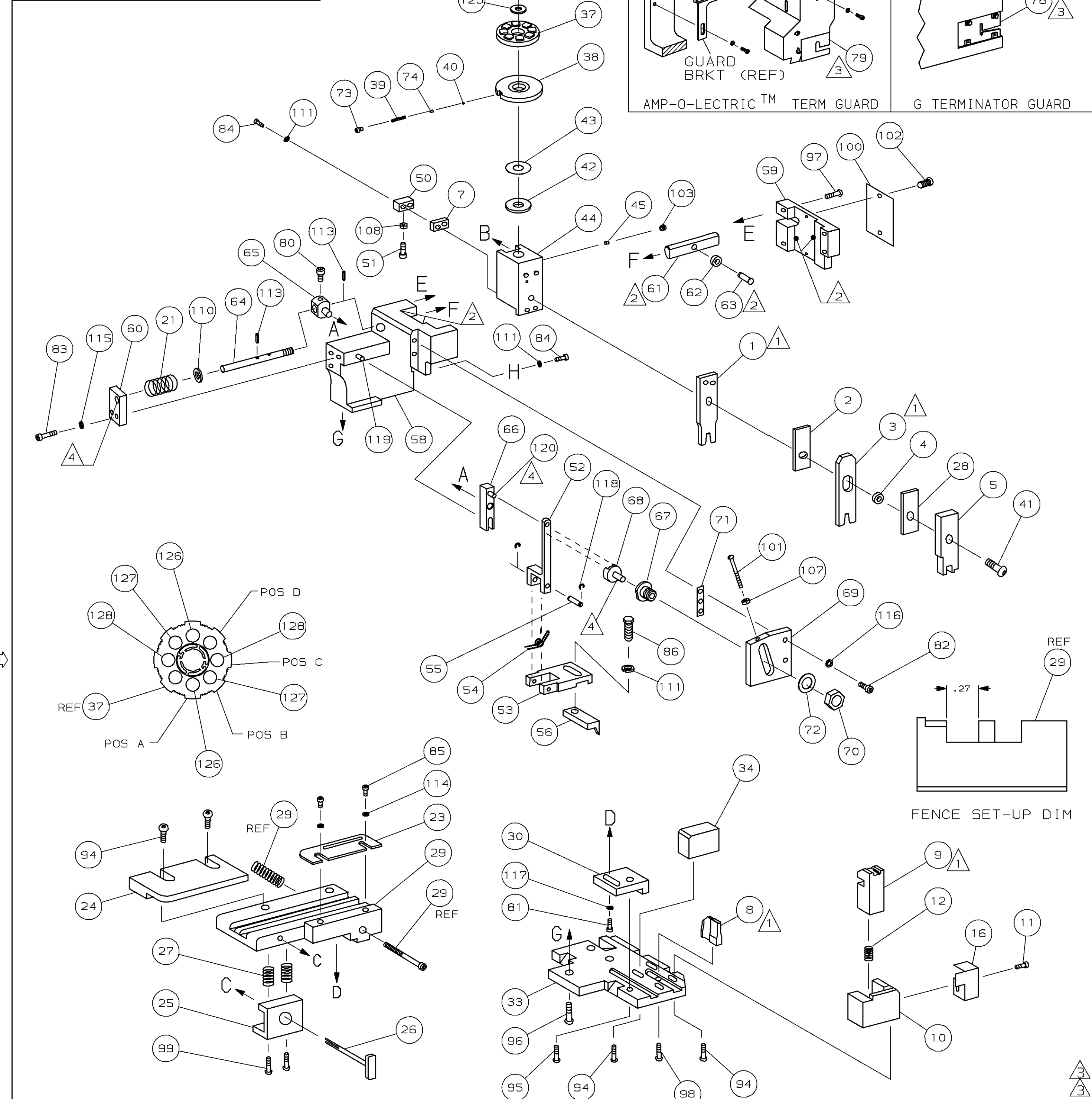


PART NUMBER	REV	FIRST USED
680514-1	A	122500-1
680514-2	A	565435-5
680514-3	A	354500-1



- 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.

TERMINAL NAME: SOCKET					
286626					
PAD LTR		CRIMP HEIGHT	WIRE SIZE		
A	.044 ±.002 [1.12 ±0.05mm]		20		
B	.040 ±.002 [1.02 ±0.05mm]		22		
C	.038 ±.002 [0.97 ±0.05mm]		24		
D	NOT		USED		
CRIMP	SIZE	TYPE	RANGE		
WIRE	.070 [1.78mm]	F	24-20		
INSUL	.100 [2.54mm]	F	.080-.100		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.109-.141	NONE	.394	408-8040	458637-1	

QTY	REQD	PER	ASSY	PARTS LIST	DESCRIPTION	ITEM NO		
2	2	2	-	C	4-354779-5	PIN, WIRE DISC (.3215)C	129	
2	2	2	-	C	4-354779-0	PIN, WIRE DISC (.3190)B	127	
2	2	2	-	C	3-354779-2	PIN, WIRE DISC (.3150)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	
							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	
REF	REF	REF	-	A	21045-3	RING, RET "C" (ø.187) FD FING PIN	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	
REF	REF	REF	-	A	5-21028-1	PIN, SLT SPR (ø.125x.50) ADJ ROD	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	
							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	
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	
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) SG ADJ BLOCK	95	
6	6	6	-	A	2-21002-2	SCR, BHC (8-32x.50) TERM H DWN	94	
							93	
							92	
							91	
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38) CAM	90	
							89	
1	1	-	-	A	7-21000-9	SCR, SHC (4-40x.19) STRIPPER	88	
							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	
3	3	3	-	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) 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	
							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	
-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	455679-1	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	
-	-	-	-	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	690786-3	SUPPORT, TERMINAL	34	
REF	REF	REF	-	D	455675-1	PLATE, BASE	33	
							32	
							31	
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30	
1	1	1	-	C	318042-1	STRIP GUIDE PLATE ASSY	29	
1	1	1	-	C	2-455888-2	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	240792-1	DRAG, TERMINAL	25	
1	1	1	-	D	5-690504-9	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	690461-1	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	-	C	662185-3	ANVIL	8	
1	1	1	-	C	2-240641-1	SPACER, DEPRESSOR (REAR)	7	
							6	
1	1	1	-	C	2-455889-0	DEPRESSOR, SHEAR (FRONT)	5	
1	1	1	-	B	238011-7	SPACER, BLOCK CRIMPER	4	
1	1	1	-	C	3-683453-0	CRIMPER, INSULATION	3	
1	1	1	-	C	455888-2	SPACER, CRIMPER	2	
1	1	1	-	C	2-456404-5	CRIMPER, WIRE	1	
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO	
QTY REQD PER ASSY				PARTS LIST				

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 7-24-97 APP J.DODDS 7-24-97
CHK 7-24-97 REL -
C.ERISMAN

AMP AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL
SCALE - DWG NO 680514 SHEET 1 OF 1 REV A

THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INCORPORATED. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

THIS INFORMATION IS CONFIDENTIAL AND IS DISCLOSED TO YOU ON CONDITION THAT NO FURTHER DISCLOSURE IS MADE BY YOU TO OTHER THAN AMP PERSONNEL WITHOUT WRITTEN AUTHORIZATION FROM AMP INCORPORATED, HARRISBURG, PA.