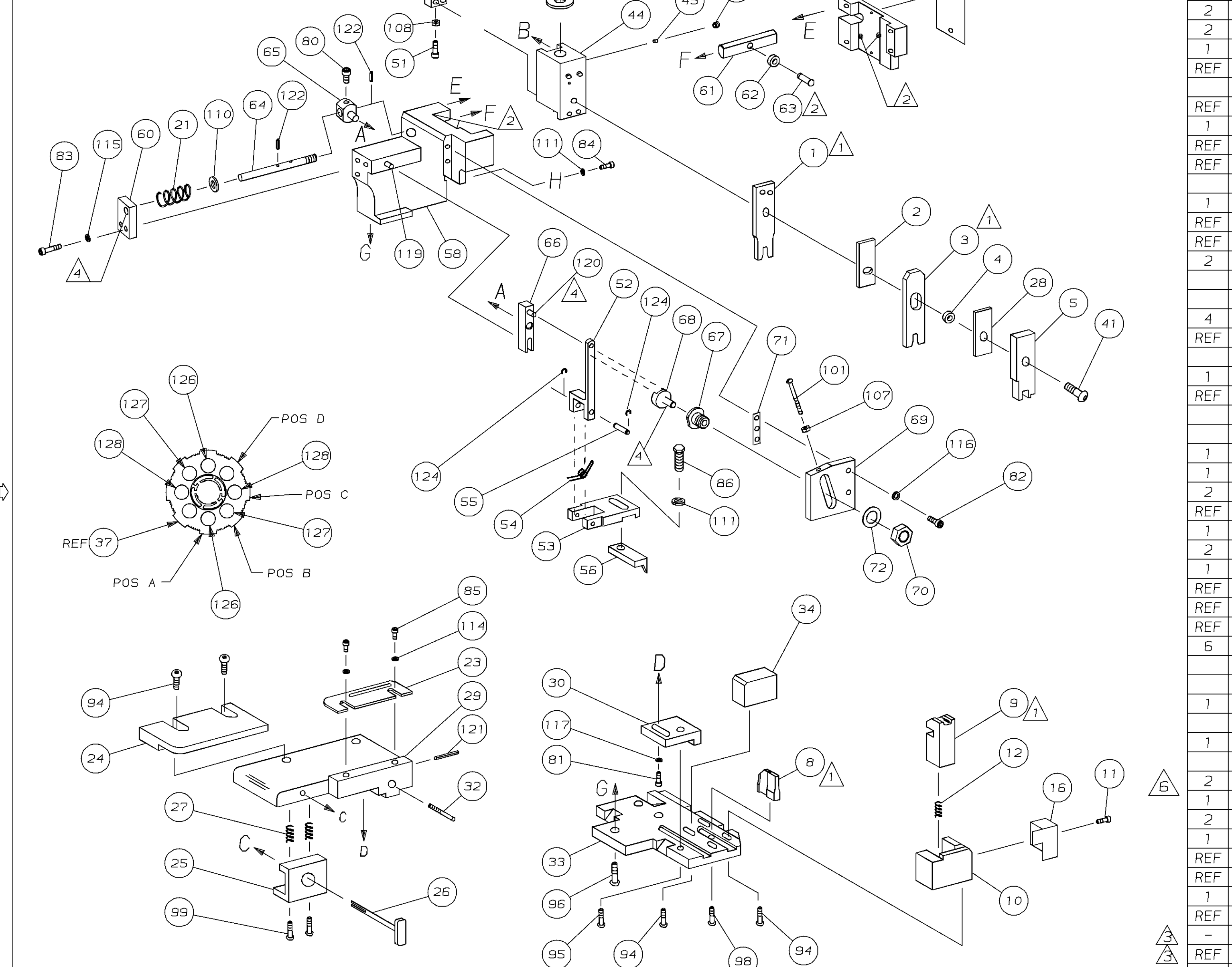
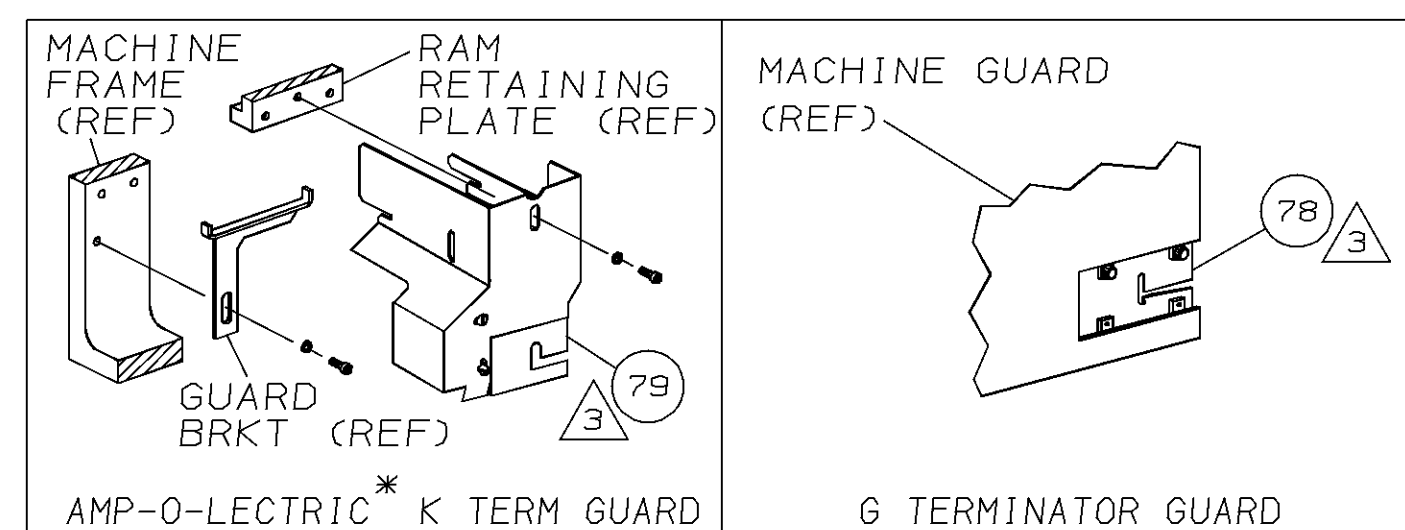
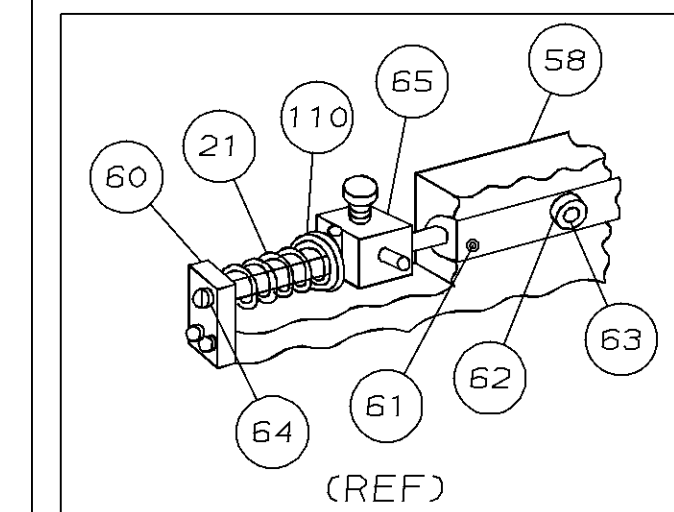


| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------|
| 680079-1 | 0 | 854400-1 |
| 680079-2 | 0 | 565435-5 |
| 680079-3 | 0 | 354500-1 |

PRELIMINARY

PRELIMINARY



| TERMINAL NAME: | SPADE |
|----------------|----------|
| | 60998 |
| TERM APPL SPEC | 114-2084 |

| CRIMPING DATA | | | |
|---------------------|--------------|--------------------|-------------|
| PAD LTR | CRIMP HEIGHT | WIRE SIZE | |
| A | .084 ±.002 | 18 | |
| B | .090 ±.002 | 16 | |
| C | .097 ±.002 | 14 | |
| D | NOT | USED | |
| CRIMP | SIZE | TYPE | RANGE |
| WIRE | .130 | F | 18 - 14 |
| INSUL | .210 | F | .120 - .180 |
| FEED | APPL INST | SET UP GAGE LAYOUT | |
| .580 | 408-8040 | 458637-1 L1564 | |
| WIRE STRIP LENGTH - | | | |

| LEADMAKER | | MECH POST FEED | |
|-----------|---------------|----------------|----------|
| -1 | BENCH MODEL K | MECH PRE FEED | |
| -2 | BENCH MODEL G | MECH PRE FEED | |
| REF | REF | - B | 22594-8 |
| REF | REF | - B | 240628-1 |
| REF | REF | - B | 240626-1 |
| REF | REF | - B | 240633-1 |
| REF | REF | - A | 455680-1 |
| REF | REF | - B | 240629-1 |
| REF | REF | - A | 240632-2 |
| REF | REF | - B | 240659-3 |
| REF | REF | - B | 240658-1 |
| REF | REF | - B | 454398-2 |
| REF | REF | - A | 454178-1 |
| REF | REF | - C | 454220-1 |
| REF | REF | - D | 454485-1 |

| | | | | | | | |
|---|-----|-----|-----|----------|------------|-----------------------------------|---------|
| 2 | 2 | 2 | - | C | 2-354778-7 | PIN, WIRE DISC (.2630)C | 128 |
| 2 | 2 | 2 | - | C | 4-354778-1 | PIN, WIRE DISC (.2700)B | 127 |
| 2 | 2 | 2 | - | C | 5-354778-3 | PIN, WIRE DISC (.2760)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 |
| 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 |
| 1 | 1 | 1 | - | A | 21024-5 | WASHER, LOCK (#10)ADJ BLOCK | 118 |
| REF | REF | REF | - | A | 21024-5 | WASHER, LOCK (#10)ADJ PLATE | 117 |
| REF | REF | REF | - | A | 21024-5 | WASHER, LOCK (#10)FEED GDE ROD | 116 |
| 2 | 2 | 2 | - | A | 21024-2 | WASHER, LOCK (#4)FRONT STP GUIDE | 114 |
| 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 | 1 | 1 | - | A | 21018-5 | NUT, HEX (NO. 6)HOLDDOWN | 108 |
| REF | REF | REF | - | A | 21018-5 | NUT, HEX (6-32)FEED ADJ | 107 |
| 1 | 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) SHEAR | 94 |
| 1 | 1 | 1 | - | A | 1-21002-7 | SCR, BHC (6-32x.38)CAM | 91 |
| 1 | 1 | 1 | - | A | 7-21000-9 | SCR, SHC (4-40x.19)STRIPPER | 89 |
| 2 | 2 | 2 | - | A | 2-21000-7 | SCR, SHC (8-32x.48)H. DOWN | 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 | 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 |
| 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 | | | | | | | |
| REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION) | | | | | | | |
| PARTS LIST | | | | | | | |

| | | | | | | | |
|---|-----|-----|-----|----------|------------|-----------------------------|---------|
| 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 |
| - | - | 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 | 455673-1 | 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 |
| 1 | 1 | 1 | - | A | 690432-3 | SCREW, ADJUSTMENT | 32 |
| REF | REF | REF | - | B | 455689-1 | BLOCK, STRIP GUIDE ADJ | 30 |
| 1 | 1 | 1 | - | C | 455671-1 | PLATE, STRIP GUIDE | 29 |
| 1 | 1 | 1 | - | C | 455888-8 | 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 | 7-690504-6 | 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 |
| 1 | 1 | 1 | - | B | 691667-1 | GUARD, CHIP (FRONT) | 16 |
| 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 | 454276-5 | SHEAR, FLOAT (FRONT) | 9 |
| 1 | 1 | 1 | - | C | 6-683403-7 | ANVIL | 8 |
| 1 | 1 | 1 | - | C | 1-455889-7 | DEPRESSOR, SHEAR (FRONT) | 5 |
| 1 | 1 | 1 | - | B | 1-238011-0 | SPACER, BLOCK CRIMPER | 4 |
| 1 | 1 | 1 | - | C | 3-456134-1 | CRIMPER, INSULATION | 3 |
| 1 | 1 | 1 | - | C | 1-455888-0 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | - | C | 1-456410-5 | CRIMPER, WIRE | 1 |
| -3 | -2 | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
| QTY REQD PER ASSY | | | | | | | |
| REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION) | | | | | | | |
| PARTS LIST | | | | | | | |

* Trademark of AMP Incorporated

| POST FEED 1 5/8 STROKE | PRE FEED 1 1/8 STROKE | PRE FEED 1 5/8 STROKE |
|------------------------|-----------------------|-----------------------|
| | | |
| ROTATED 180° | ROTATED 180° | ROTATED 180° |
| T TERMINATING UNIT | K TERMINATING UNIT | G TERMINATING UNIT |
| | | |
| LOC A | DIST 66 | LEADMAKER |
| | | BENCH MACHINE |

- 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.

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