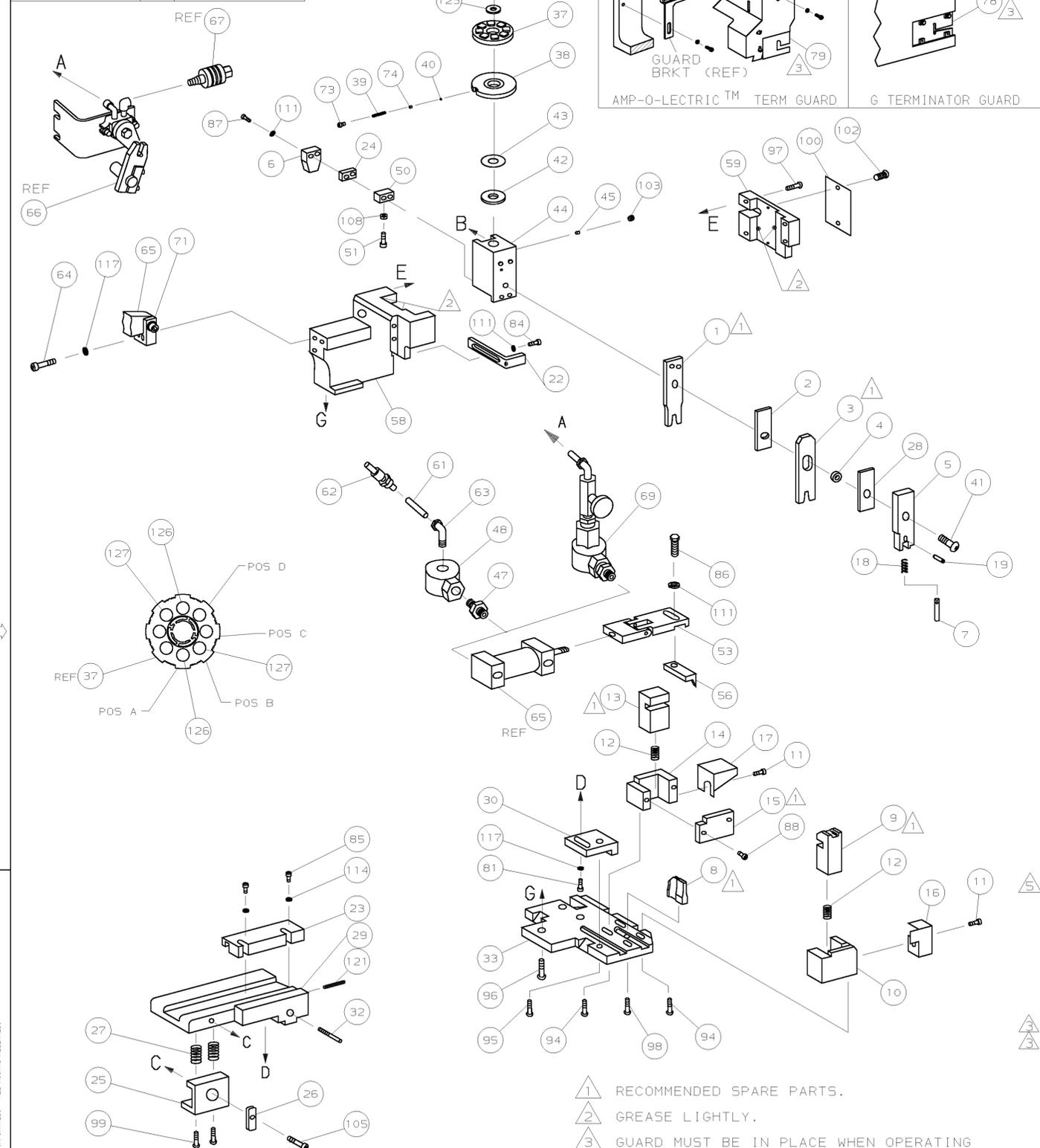


PART NUMBER	REV	FIRST USED
680676-1	C	122500-1
680676-2	C	565435-5
680676-3	C	354500-1



- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 4 SEE DRAWING FOR COMPONENTS
- 5 CUT LENGTH AT ASSEMBLY.
- 6 DETERMINE AT SET-UP.

TERMINAL NAME: PIN		CRIMP DATA (NON-AMP TERMINAL-CUST SPEC)			
AMP	MFG	PAD LTR	CRIMP HEIGHT	WIRE SIZE	
286749	12084449	A	.043 ±.002 [1.09 ±0.05mm]	18	
		B	.041 ±.002 [1.04 ±0.05mm]	20	
		C	NOT	USED	
		D	NOT	USED	
WIRE	INSUL	CRIMP	SIZE	TYPE	RANGE
			.078 [2.18mm]	F	20-18
			.086 [2.18mm]	F	20-18

QTY	REQD	PER	ASSY	U/M	DWG	SIZE	PART NO	DESCRIPTION	ITEM NO
1	1	1	-	A			4-354779-5	PIN, WIRE DISC (.3215)B	127
2	2	2	-	C			4-354779-3	PIN, WIRE DISC (.3205)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
1	1	1	-	A			4-21028-0	PIN, SLT SPR(φ.093x.75)ST 6DE PL	122
3	3	3	-	A			21024-5	WASHER, LOCK (#10)ADJ BLOCK	117
2	2	2	-	A			21024-2	WASHER, LOCK (#4)FRONT STP GUIDE	114
4	4	4	-	A			21024-4	WASHER, LOCK (#8) STRIPPER	111
1	1	1	-	A			21018-5	NUT, HEX (NO. 6) HOLDDOWN	108
1	1	1	-	A			22353-8	SCR, SHLD (φ.187x.25) DRAG LEVER	105
1	1	1	-	A			21009-2	SCR, SKT 5ET (1/4-20x.25 LW) RAM	103
2	2	2	-	A			21017-2	SCR, DRIVE (#2x.19) ID PLATE	102
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
4	4	4	-	A			2-21002-9	SCR, BHC (10-32x.75) CAP	97
3	3	3	-	A			2-22733-8	SCR, BHC (1/4-20x.62) HSG	96
1	1	1	-	A			2-21002-7	SCR, BHC (10-32x.50) 56 ADJ BLK	95
4	4	4	-	A			2-21002-2	SCR, BHC (8-32x.50) TERM H DWN	94
2	2	2	-	A			1-21000-8	SCR, SHC (6-32x.25) R SHEAR PLATE	88
2	2	2	-	A			3-21000-2	SCR, SHC (8-32x1.12) DEP-HOLD	87
1	1	1	-	A			2-22603-1	SCR, HEX HD (8-32x.38) FEED FINGER	86
2	2	2	-	A			1-21000-4	SCR, SHC (4-40x.38) F ST GUIDE	85
1	1	1	-	A			2-21000-7	SCR, SHC (8-32x.50) STRIPPER	84
1	1	1	-	A			3-21000-4	SCR, SHC (10-32x.38) 56 ADJ BL	81
-	1	-	-	B			462992-7	GUARD ASSY	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
1	1	1	-	B			459610-3	MOUNT, FEED BRACKET	71

QTY	REQD	PER	ASSY	U/M	DWG	SIZE	PART NO	DESCRIPTION	ITEM NO
-1								LEADMAKER	AIRFEED
-2								BENCH MODEL K	AIRFEED
-3								BENCH MODEL G	AIRFEED
-	1	-	-	C			692655-5	AIR FEED VALVE ASSY	70
-	REF	-	-	A			24042-2	VALVE, SHUT OFF	67
-	REF	-	-	C			692655-6	AIR FEED VALVE ASSY	66
1	1	1	-	B			461065-1	AIR FEED ASSY (1 INCH)	65
2	2	2	-	A			3-21000-9	SCR, SHC (10-32x1.00) AIR ASSY	64
1	-	1	-	A			980285-2	ELBOW, SWIVEL 1/8 NPT - 1/4 T	63
1	-	1	-	A			23238-1	QUICK DISCONNECT	62
21.00	-	21.00	IN	A			27319-4	TUBING, POLY-FLO φ.25	61
1	1	1	-	C			454220-1	CAP, RAM	59
1	1	1	-	D			454485-1	HOUSING	58
1	1	1	-	B			3-694433-0	PAWL, FEED	56
1	1	1	-	B			461062-1	FEED FINGER ASSY	53
1	1	1	-	A			811242-2	BUMPER, HOLDDOWN	51
1	1	1	-	A			690753-1	SPACER, TONKER	50
1	-	1	-	A			22374-7	VALVE, QUICK EXHAUST	48
1	-	1	-	A			22304-1	NIPPLE, HEX 1/8 NPT	47
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	-	D			455675-9	PLATE, BASE	33
1	1	1	-	A			690432-3	SCREW, ADJUSTMENT	32
1	1	1	-	B			455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	C			458144-1	PLATE, STRIP GUIDE	29
1	1	1	-	C			455888-4	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			7-240641-3	SPACER, REAR SHEAR DEP	24
1	1	1	-	A			1-679651-5	GUIDE, STRIP (FRONT)	23
1	1	1	-	B			690472-9	STRIPPER	22
1	1	1	-	B			21028-2	PIN, SLOTTED SPRING	19
1	1	1	-	A			1-22278-0	SPRING, COMPRESSION	18
1	1	1	-	A			691668-1	GUARD, CHIP (REAR)	17
1	1	1	-	B			318563-1	GUARD, CHIP, FRONT	16
1	1	1	-	B			690464-1	PLATE, SHEAR (REAR)	15
1	1	1	-	B			690462-1	HOLDER, SHEAR (REAR)	14
1	1	1	-	C			690463-1	SHEAR, FLOAT (REAR)	13
2	2	2	-	A			5-22280-0	SPRING, SHEAR	12
2	2	2	-	B			690461-1	STOP, SHEAR	11
1	1	1	-	C			690459-1	HOLDER, SHEAR (FRONT)	10
1	1	1	-	C			462006-7	SHEAR, FLOAT (FRONT)	9
1	1	1	-	C			1-904717-8	ANVIL	8
1	1	1	-	C			854769-1	HOLDER, INSULATION	7
1	1	1	-	A			453393-1	DEPRESSOR, SHEAR (REAR)	6
1	1	1	-	C			854772-1	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B			238011-6	SPACER, BLOCK CRIMPER	4
1	1	1	-	C			1-1213077-1	CRIMPER, INSULATION	3
1	1	1	-	C			455888-9	SPACER, CRIMPER	2
1	1	1	-	C			4-568176-6	CRIMPER, WIRE	1

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

QTY	REQD	PER	ASSY	U/M	DWG	SIZE	PART NO	DESCRIPTION	ITEM NO
-3	-2	-1	U/M						

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED:
 2 PLC DEC ±.25
 3 PLC DEC ±.25
 4 PLC DEC ±.25
 ANGLES ± -
 SURF TEXTURE: ✓
 REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

DR	W.HOOVER	290CT98	APP	T.ELBIN	290CT98
CHK	C.ERISMAN	290CT98	REL		

AMP Incorporated
 Harrisburg, PA 17105-3608

NAME: SIDE FEED HDM APPLICATOR MACHINE REF: MINI APPL
 SCALE: D DWG NO: 680676 SHEET: 1 OF 1 REV: C1

CUSTOMER AND ASSEMBLY DRAWING

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