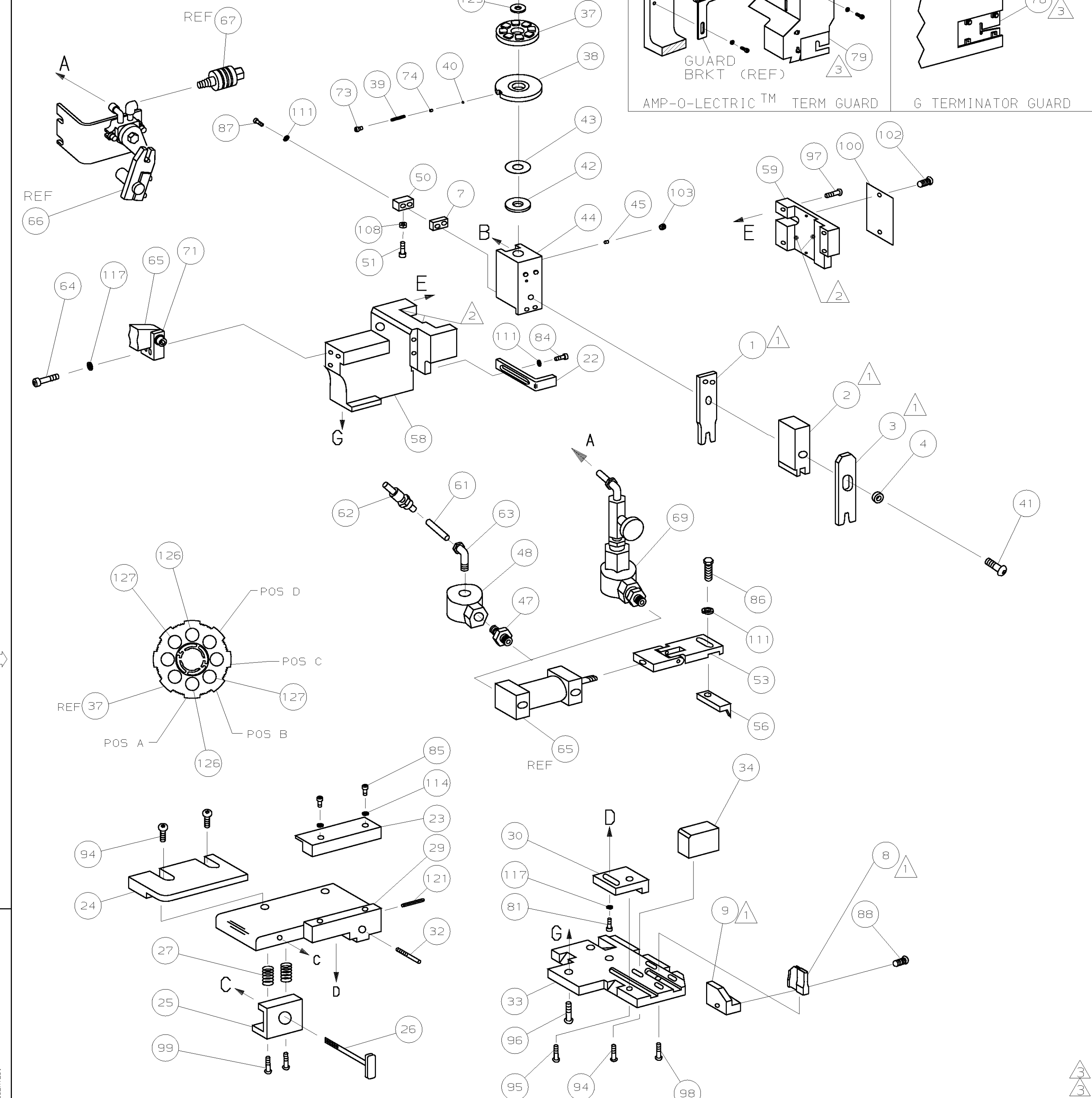


PART NUMBER	REV	FIRST USED
680630-1	A	122500-1
680630-2	A	565435-5
680630-3	A	354500-1



- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 4 SEE DRAWING FOR COMPONENTS

TERMINAL NAME: BLADE		CRIMP DATA (NON-AMP TERMINAL-CUST SPEC)	
AMP	MFR	PAD LTR	WIRE SIZE
286717	12160637	A	.059 ±.002 [1.50 ±0.05mm]
		B	.057 ±.002 [1.45 ±0.05mm]
		C	NOT USED
		D	NOT USED
WIRE	SIZE	TYPE	RANGE
	.095 [2.41mm]	F	18-16
INSUL	SIZE	TYPE	RANGE
	.140 [3.56mm]	F	-

QTY	REQD	PER	ASSY	PARTS LIST	DESCRIPTION	ITEM NO	
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	-	A	21018-5	NUT, HEX (NO. 6) HOLDDOWN	108
1	1	1	-	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	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) H5G	96
1	1	1	-	A	2-21002-7	SCR, BHC (10-32x.50) 5G ADJ BLK	95
4	4	4	-	A	2-21002-2	SCR, BHC (8-32x.50) TERM H DWN	94
1	1	1	-	A	3-21000-0	SCR, HEX HD (8-32x.88) SHEAR	88
2	2	2	-	A	2-21000-8	SCR, HEX HD (8-32x.62) SHEAR	87
1	1	1	-	A	2-22603-1	SCR, HEX HD (8-32x.38) 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
1	1	1	-	A	3-21000-4	SCR, SHC (10-32x.38) 5G 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	PARTS LIST	DESCRIPTION	ITEM NO	
-	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	3-21000-7	SCR, SHC (10-32x.75) 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 Ø.25	61
1	1	1	-	C	454220-1	CAP, RAM	59
1	1	1	-	D	454485-1	HOUSING	58
1	1	1	-	B	3-694433-2	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	819307-6	RAM	44
1	1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	1	-	A	1-690124-4	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	690786-1	SUPPORT, TERMINAL	34
1	1	1	-	D	455675-1	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	3-455671-9	PLATE, STRIP GUIDE	29
2	2	2	-	A	1-22284-0	SPRING, DRAG	27
1	1	1	-	B	690546-1	LEVER, DRAG RELEASE	26
1	1	1	-	B	690754-9	DRAG, TERMINAL	25
1	1	1	-	D	1-690440-9	GUIDE, STRIP (REAR)	24
1	1	1	-	A	1-690712-0	GUIDE, STRIP (FRONT)	23
1	1	1	-	B	690472-2	STRIPPER	22
1	1	1	-	B	853714-4	PLATE, REAR SHEAR	9
1	1	1	-	C	1214596-1	ANVIL	8
1	1	1	-	C	5-240641-8	SPACER, DEPRESSOR (REAR)	7
1	1	1	-	B	238009-8	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	4-683453-4	CRIMPER, INSULATION	3
1	1	1	-	C	853720-4	BLADE, SLUG	2
1	1	1	-	C	6-458141-6	CRIMPER, WIRE	1

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LOC A  
DIST 66

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED:  
 2 PLC DEC ±.25  
 3 PLC DEC ±.125  
 4 PLC DEC ±.0625  
 ANGLES ±.005  
 SURF TEXTURE: ✓  
 REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL - HT TR - FIN -

DR W.HOOVER 06JUN98 APP T.ELBIN 06JUN98  
 CHK C.ERISMAN 06JUN98 REL -

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL  
 SCALE - DWG NO 680630 SHEET 1 OF 1 REV A1

CASE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO