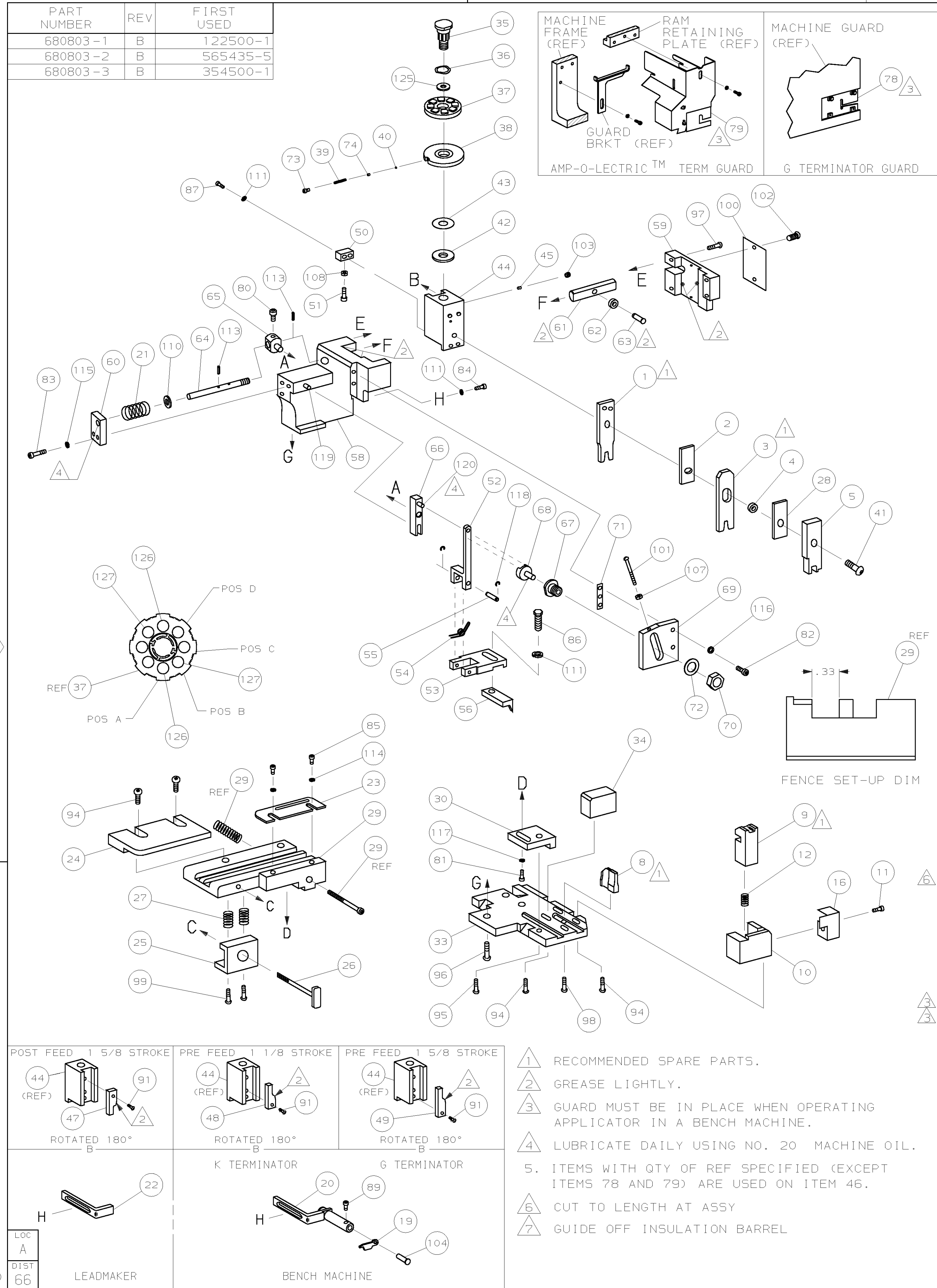


PART NUMBER	REV	FIRST USED
680803-1	B	122500-1
680803-2	B	565435-5
680803-3	B	354500-1



TERMINAL NAME: RECEPTICAL

AMP	MFG	PAD LTR	CRIMP HEIGHT	WIRE SIZE
286796	12089139	A	.061 ±.002 [1.55 ±0.05mm]	16
		B	.053 ±.002 [1.35 ±0.05mm]	18
		C	NOT	USED
		D	NOT	USED

WIRE	SIZE	TYPE	RANGE
.100	[2.54mm]	F	16-18
.140	[3.56mm]	F	φ.110 MAX

WIRE STRIP LENGTH	TERM APPL	SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.187-.218	NONE		.551	408-8040	458637-1	L2225

QTY	REF	REF	REF	A	DESCRIPTION	ITEM NO
						129
						128
2	2	2	-	C	3-354779-0 PIN, WIRE DISC (.3140)B	127
2	2	2	-	C	1-354779-2 PIN, WIRE DISC (.3050)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
						120
						119
						118
1	1	1	-	A	21024-5 WASHER, LOCK (#10) ADJ BLK	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 (φ.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 (φ5/16) SCREW ADJ	110
						109
1	1	1	-	A	21018-5 NUT, HEX (NO. 6) HOLDDOWN	108
REF	REF	REF	-	A	21068-5 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 5ET (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) 56 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
1	1	-	-	A	7-21000-9 SCR, SHC (4-40x.19) STRIPPER	89
						88
2	2	2	-	A	2-21000-7 SCR, SHC (8-32x.48) DEP-HOLD	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) 56 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

POST FEED 1 5/8 STROKE

ROTATED 180°

PRE FEED 1 1/8 STROKE

ROTATED 180°

PRE FEED 1 5/8 STROKE

ROTATED 180°

LOC A

LEADMAKER

LOC B

BENCH MACHINE

RECOMMENDED SPARE PARTS.

GREASE LIGHTLY.

GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.

LUBRICATE DAILY USING NO. 20 MACHINE OIL.

ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.

CUT TO LENGTH AT ASSY

GUIDE OFF INSULATION BARREL

QTY	REF	REF	REF	A	DESCRIPTION	ITEM NO
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

QTY	REF	REF	REF	A	DESCRIPTION	ITEM NO
						70
						69
						68
						67
						66
						65
						64
						63
						62
						61
						60
						59
						58
						57
1	1	1	-	B	458537-4 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
-	-	-	-	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	459456-2 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	690124-1 WASHER, RAM	42
1	1	1	-	A	690686-1 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
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	1-455888-7 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	1-90765-2 GUIDE, STRIP (REAR)	24
1	1	1	-	A	690438-1 GUIDE, STRIP (FRONT)	23
-	-	-	-	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	454276-2 SHEAR, FLOAT (FRONT)	9
1	1	1	-	C	1-662188-5 ANVIL	8
						7
						6
1	1	1	-	C	1-455889-4 DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	238011-2 SPACER, BLOCK CRIMPER	4
1	1	1	-	C	6-683453-9 CRIMPER, INSULATION	3
1	1	1	-	C	455888-9 SPACER, CRIMPER	2
1	1	1	-	C	456407-6 CRIMPER, WIRE	1

AMP AMP Incorporated Harrisburg, PA 17105-3608

SIDE FEED HDM APPLICATOR

SCALE: 1:1 (D) DWG NO: 680803 SHEET 1 OF 1

CUSTOMER AND ASSEMBLY DRAWING