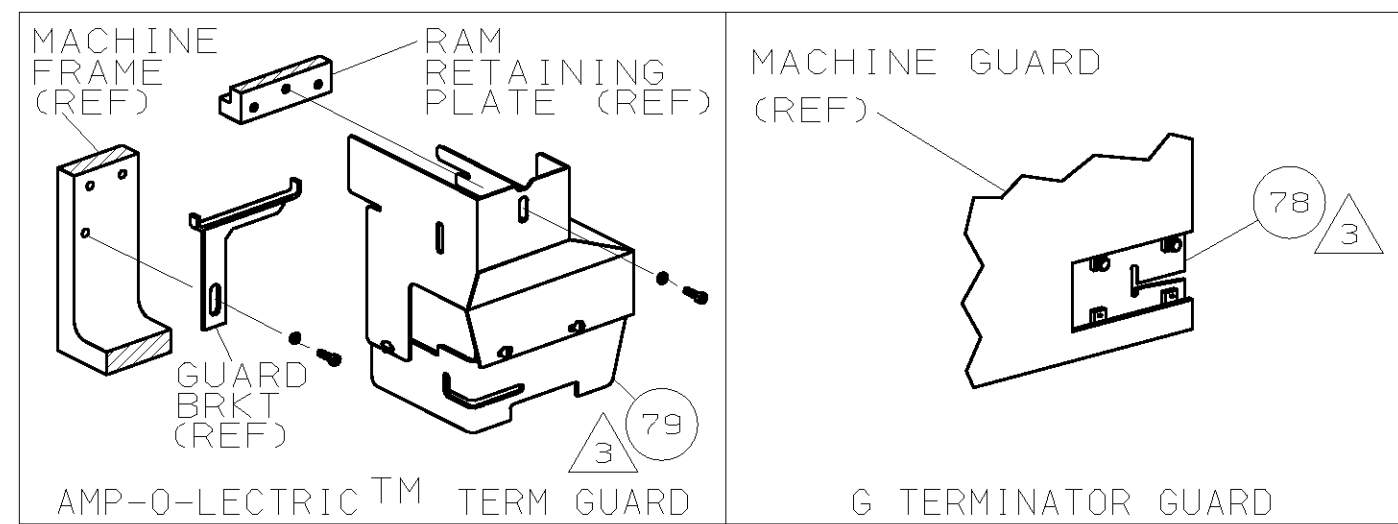


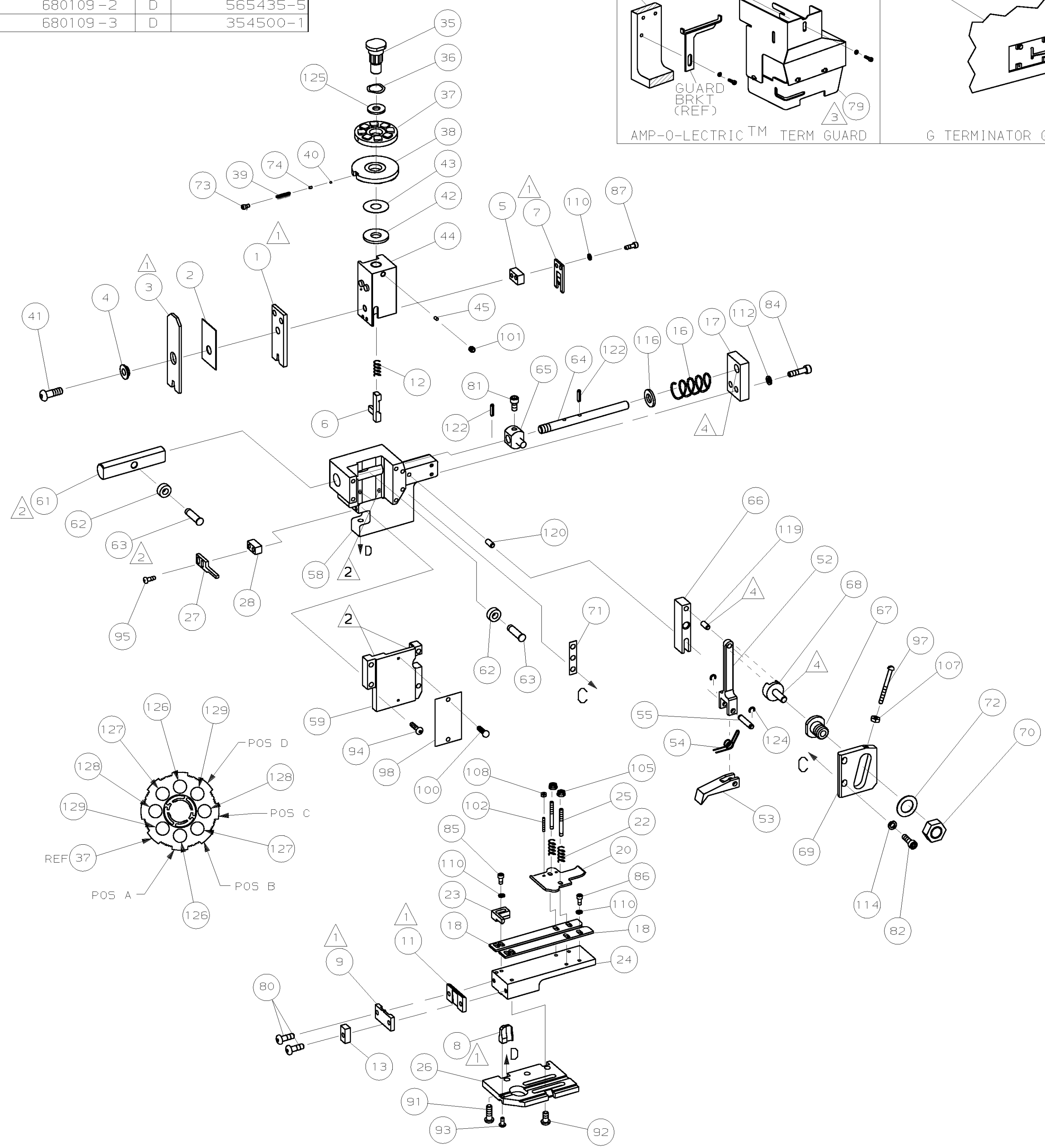
PART NUMBER	REV	FIRST USED
680109-1	D	854400-1
680109-2	D	565435-5
680109-3	D	354500-1



TERMINAL NAME:		CRIMPING DATA			
.250 RECEPTACLE FASTON		PAD LTR	CRIMP HEIGHT	WIRE SIZE	
	63648	A	.073 ±.002	14	
		B	.062 ±.002	16	
		C	.055 ±.002	18	
		D	.051 ±.002	20	
CRIMP	SIZE	TYPE	RANGE		
WIRE	.090	F	20-14		
INSUL	.180	F	.085-.135		
FEED	.845	APPL INST	SET UP GAGE	LAYOUT	
		408-8039	458638-1	L1587	
TERM APPL SPEC	114-2036	WIRE STRIP LENGTH			
		-			

-1	LEADMAKER	MECH POST FEED			
-2	BENCH MODEL K	MECH-POST FEED			
-3	BENCH MODEL G	MECH-POST FEED			
REF	REF	REF	- A	22594-8	NUT, HEX
REF	REF	REF	- B	240628-1	PLATE, ADJ
REF	REF	REF	- B	240626-1	SHAFT, PIVOT
REF	REF	REF	- B	240633-1	BUSHING
REF	REF	REF	- A	455680-1	LEVER, INTERMEDIATE
REF	REF	REF	- B	240629-1	BLOCK, PIVOT
REF	REF	REF	- A	240632-2	SCR, ADJ
REF	REF	REF	- B	240659-3	PIN, CAM ROLLER
REF	REF	REF	- B	240658-1	CAM, ROLLER
REF	REF	REF	- B	454398-1	ROD, FEED

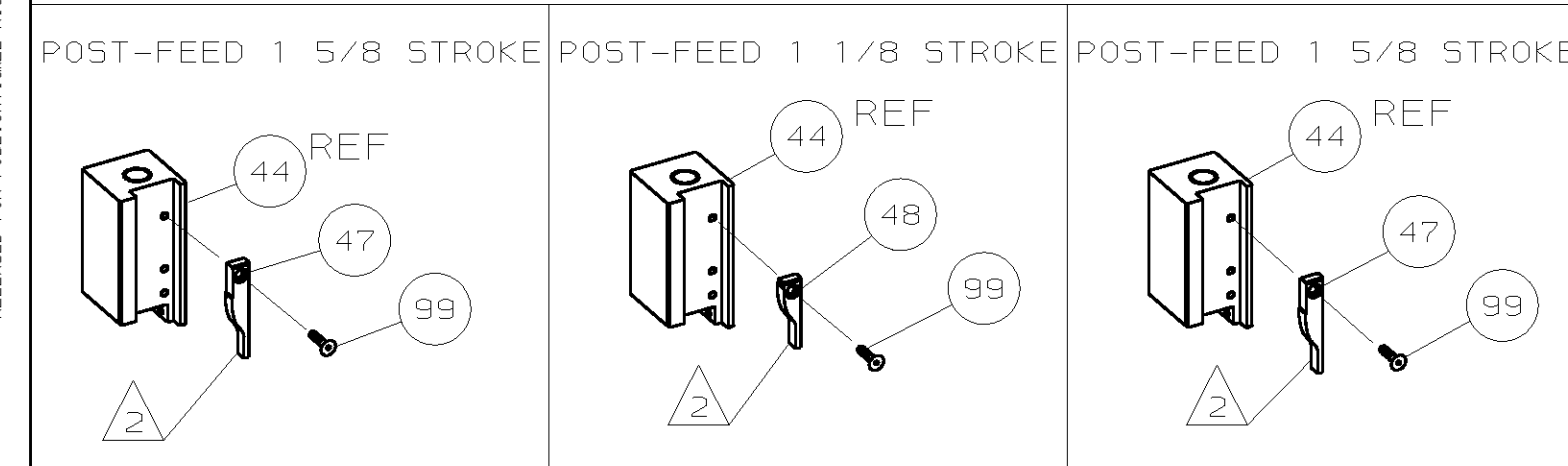
THIS DRAWING IS A CONTROLLED DOCUMENT.



2	2	2	-	C	2-354779-8	PIN, WIRE DISC (.3130)D	129
2	2	2	-	C	2-354779-2	PIN, WIRE DISC (.3100)C	128
2	2	2	-	C	354779-6	PIN, WIRE DISC (.3020)B	127
2	2	2	-	C	8-354778-1	PIN, WIRE DISC (.2900)A	126
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
REF	REF	REF	-	A	21045-3	RING, RET "C" (Ø.187)FD PIN	124
							123
REF	REF	REF	-	A	5-21028-1	PIN, STD SPRING (Ø.12)FD ADJ ROD	122
							121
REF	REF	REF	-	A	1-21030-7	PIN, DOWEL (Ø.187x1.50)H5G	120
REF	REF	REF	-	A	1-21030-1	PIN, DOWEL (Ø.187x.50)LEVER	119
							118
							117
REF	REF	REF	-	A	21899-4	WASHER, FLAT (Ø5/16)SCR ADJ	116
							115
REF	REF	REF	-	A	21024-5	WASHER, LOCK (NO.10)FD ADJ PL	114
							113
REF	REF	REF	-	A	21024-5	WASHER, LOCK (NO.10)FD ROD GDE	112
							111
6	6	6	-	A	21024-4	WASHER, LOCK (NO.8)SHEAR BL	110
							109
2	2	2	-	A	21018-4	NUT, HEX (4-40)DRAG	108
REF	REF	REF	-	A	21018-5	NUT, HEX (6-32)FD ADJ PL	107
							106
2	2	2	-	A	21022-2	NUT, HEX 5L (8-32)DRAG STUD	105
							104
							103
2	2	2	-	A	4-21078-8	SKT SKT SET (4-40x.75)DRAG	102
1	1	1	-	A	21009-2	SCR, SKT SET (1/4-20x.25)RAM	101
2	2	2	-	A	21017-2	SCR, DRIVE (#2x.19) ID PLATE	100
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38)CAM	99
1	1	1	-	B	461264-1	PLATE, IDENTIFICATION	98
REF	REF	REF	-	A	6-23715-5	SCR, PAN HD (6-32x1.50)FEED ADJ	97
							96
2	2	2	-	A	2-21002-2	SCR, BHC (8-32x.50)STRIPPER	95
REF	REF	REF	-	A	2-21002-9	SCR, BHC (10-32x.75)H5G CAP	94
1	1	1	-	A	22733-8	SCR, BHC (8-32x.38 LW)ANVIL	93
4	4	4	-	A	3-21002-3	SCR, BHC (1/4-20x.50)ST 6D PL	92
REF	REF	REF	-	A	2-22733-8	SCR, BHC (1/4-20x.62)BASE PL	91
							90
							89
							88
2	2	2	-	A	2-21000-7	SCR, 5HC (8-32x.50)SLUG BLADE	87
3	3	3	-	A	2-21000-6	SCR, 5HC (8-32x.38)STRIP GUIDE	86
2	2	2	-	A	2-21000-9	SCR, 5HC (8-32x.75)HOLD DOWN	85
REF	REF	REF	-	A	3-21000-7	SCR, SKT CAP (10-32x.75)FD GDE	84
							83
REF	REF	REF	-	A	3-21000-6	SCR, SKT CAP (10-32x.62)FD ADJ P	82
REF	REF	REF	-	A	3-21000-4	SCR, SKT CAP (10-32x.38)PIVOT BL	81
2	2	2	-	A	3-21002-0	SCR, BHC (10-32x.88)SH PL	80
-	REF	-	-	A	455745-1	GUARD, WINDOW	79
REF	-	-	-	A	679532-1	INSERT, GUARD	78
							77
							76
							75
1	1	1	-	A	690603-1	SPRING, ASSIST	74
1	1	1	-	A	23030-1	SCR, SKT CAP (6-32x.25)CP DSC	73
REF	REF	REF	-	A	458109-1	WASHER, FLAT (SPECIAL)	72
REF	REF	REF	-	A	690517-1	SPACER	71
							70
							69
							68
							67
							66
							65
							64
							63
							62
							61

							60
REF	REF	REF	-	C	454220-1	CAP, RAM	59
REF	REF	REF	-	D	453736-1	HOUSING	58
							57
							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	240635-1	FINGER, FEED	53
REF	REF	REF	-	B	240634-1	LEVER, TERMINAL	52
							51
							50
							49
-	1	-	-	B	690501-3	CAM, POST FEED 1 1/8 ST	48
1	-	1	-	B	690501-4	CAM, POST-FEED 1 5/8 ST	47
							46
1	1	1	-	A	690191-1	PLUG, NYLON	45
1	1	1	-	C	455674-1	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 (5/16-24x1.00)	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
							34
							33
1	1	1	-	D	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
							31
							30
							29
1	1	1	-	B	3-690451-2	SPACER, STRIPPER	28
1	1	1	-	A	240639-1	STRIPPER	27
REF	REF	REF	-	C	455676-1	PLATE, BASE	26
2	2	2	-	A	22354-8	DRAG, STUD	25
1	1	1	-	B	455678-1	PLATE, STRIP GUIDE	24
1	1	1	-	C	240825-1	PLATE, STRIP HOLD DOWN	23
2	2	2	-	A	4-22281-1	SPRING, DRAG	22
							21
1	1	1	-	A	454177-1	DRAG, STOCK	20
							19
2	2	2	-	C	454204-4	GUIDE, STRIP (FRONT)	18
REF	REF	REF	-	A	454178-1	GUIDE, FEED ROD	17
REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	16
							15
							14
1	1	1	-	C	690481-7	SPACER, HOLD DOWN	13
1	1	1	-	A	23846-1	SPRING, HOLD DOWN	12
1	1	1	-	B	240644-1	PLATE, REAR SHEAR	11
							10
1	1	1	-	B	690482-3	PLATE, FRONT SHEAR	9
1	1	1	-	D	4-461295-0	ANVIL	8
1	1	1	-	B	690474-3	BLADE, SLUG	7
1	1	1	-	D	1-455892-0	HOLD DOWN, TERMINAL	6
1	1	1	-	C	240641-4	SPACER, SLUG BLADE	5
1	1	1	-	B	238009-1	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	4-456134-6	CRIMPER, INSULATION	3
1	1	1	-	B	455888-8	SPACER, CRIMPER	2
1	1	1	-	C	2-456406-0	CRIMPER, WIRE	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 32.



POST-FEED 1 5/8 STROKE	POST-FEED 1 1/8 STROKE	POST-FEED 1 5/8 STROKE
REF 44, 47, 99	REF 44, 48, 99	REF 44, 47, 99
G OR T TERMINATOR LEADMAKER	K TERMINATOR BENCH MACHINE	G TERMINATOR BENCH MACHINE
A		
66		

AMP INCORPORATED

680109

END FEED HDM APPLICATOR

CUSTOMER AND ASSEMBLY DRAWING

AMP Incorporated Harrisburg, PA 17105-3608

DR 6/27/94 APP 6-28-94 M. O'BRINE T. ELBIN C. ERISMAN REL 10/5/94 B. MORGAN

NAME: END FEED HDM APPLICATOR MACHINE REF: MINI APPL

SCALE: DWG NO: 680109 SHEET: 1 OF 1 REV: D

REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

THIS DRAWING IS UNCLASSIFIED - RELEASED FOR PUBLICATION. RIGHTS RESERVED 2002