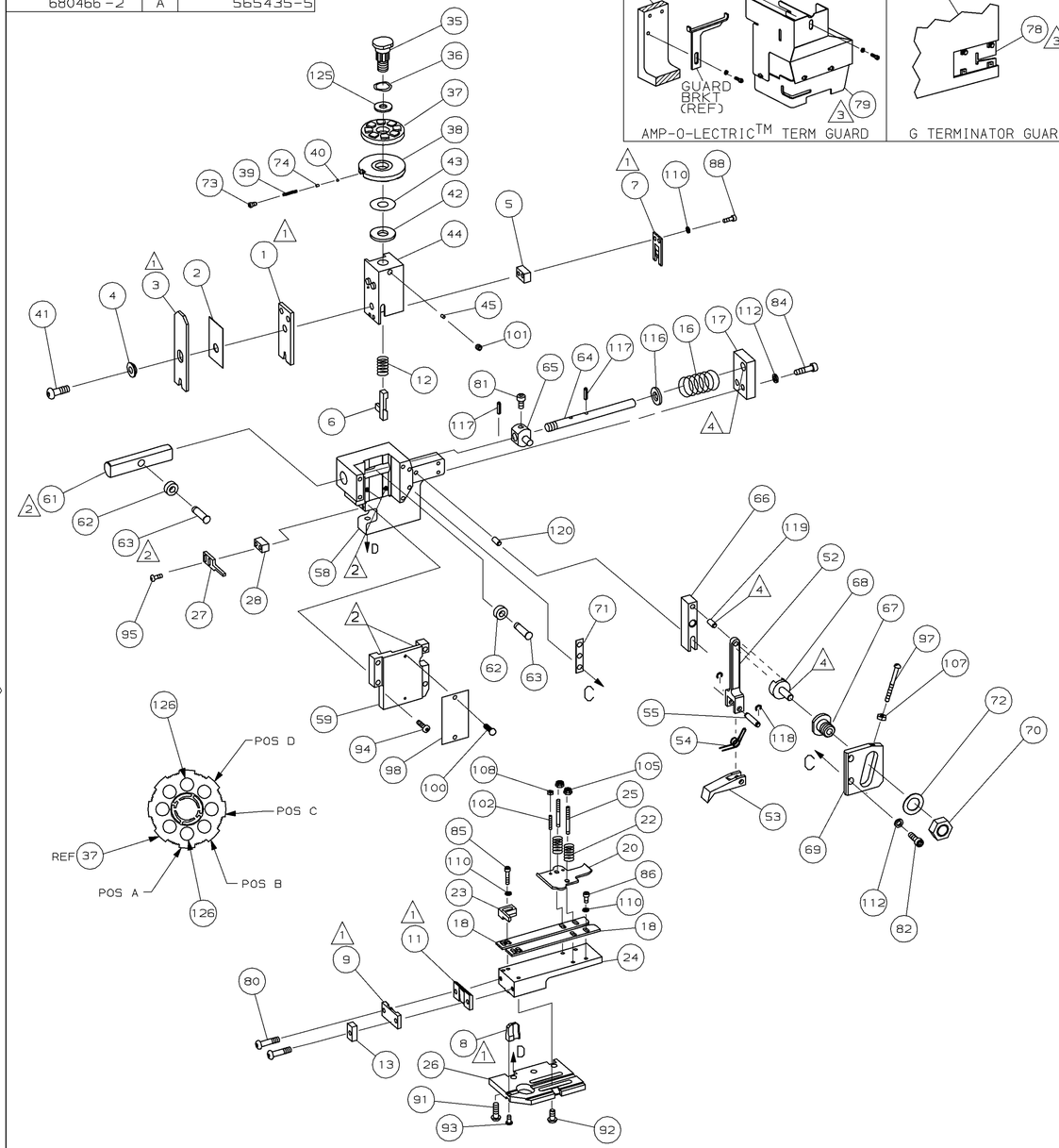
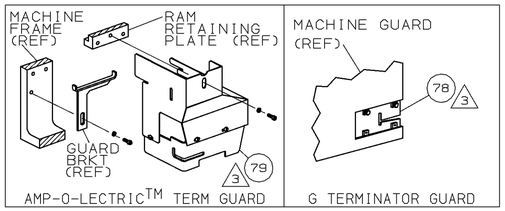
DRAWING MADE IN THIRD ANGLE PROJECTION

THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INCORPORATED. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

PART NUMBER	REV	FIRST USED
680466-1	A	122500-1
680466-2	A	565435-5





TERMINAL NAME: TERMINAL, RECPTACLE

286580

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.092 ±.002 [2.34 ±0.05mm]	14 MAG
B	NOT	USED
C	NOT	USED
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.140 [3.56mm]	F	14 MAG
INSUL	.180 [4.57mm]	F	–

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
–	NONE	.846	408-8039	458638-1	L1927

	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
							129
							128
							127
	2	2	–	C	4-354778-9	PIN, WIRE DISC (.2740) A	126
	1	1	–	A	986950-1	WASHER, FLAT PRECISION	125
	1	1	–	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
	1	1	–	–	4088039	EF APPL INST 408-8039	123
							122
							121
	REF	REF	–	A	1-21030-7	PIN,DOWEL (ø.187x1.50) HSG	120
	REF	REF	–	A	1-21030-1	PIN,DOWEL (ø.187x.50) LEVER	119
	REF	REF	–	A	21045-3	RING,RET "C" (ø.187) FD PIN	118
	REF	REF	–	A	5-21028-1	PIN,STD SPRING (ø.12) FD ADJ ROD	117
	REF	REF	–	A	21899-4	WASHER,FLAT (ø5/16) SCR ADJ	116
							115
							114
							113
	REF	REF	–	A	21024-5	WASHER,LOCK (NO.10) FD ROD GDE	112
							111
	7	7	–	A	21024-4	WASHER,LOCK (NO.8) SHEAR BL	110
							109
	2	2	–	A	21018-4	NUT,HEX (4-40) DRAG	108
	REF	REF	–	A	21018-5	NUT,HEX (6-32) FD ADJ PL	107
							106
	2	2	–	A	21022-2	NUT,HEX SL (8-32) DRAG STUD	105
							104
							103
	2	2	–	A	2-21006-6	SCR,SKT SET (4-40x.62) DRAG	102
	1	1	–	A	21009-2	SCR,SKT SET (1/4-20x.25) RAM	101
	2	2	–	A	21017-2	SCR,DRIVE (#2x.19) ID PLATE	100
	1	1	–	A	1-21002-7	SCR,BHC (6-32x.38) CAM	99
	1	1	–	B	461264-1	PLATE, IDENTIFICATION	98
	REF	REF	–	A	6-23715-5	SCR,PAN HD (6-32x1.50) FEED ADJ	97
							96
	2	2	–	A	2-21002-2	SCR,BHC (8-32x.50) STRIPPER	95
	REF	REF	–	A	2-21002-9	SCR,BHC (10-32x.75) HSG CAP	94
	1	1	–	A	22733-8	SCR,BHC (8-32x.38 LW) ANVIL	93
	4	4	–	A	3-21002-3	SCR,BHC (1/4-20x.50) ST GD PL	92
	REF	REF	–	A	2-22733-8	SCR,BHC (1/4-20x.62) BASE PL	91
							90
							89
	2	2	–	A	2-21000-7	SCR,SHC (8-32x.50) SLUG BLADE	88
							87
	3	3	–	A	2-21000-6	SCR,SHC (8-32x.38) STRIP GUIDE	86
	2	2	–	A	2-21000-8	SCR,SHC (8-32x.62) R STRIP GUIDE	85
	REF	REF	–	A	3-21000-7	SCR,SHC (10-32x.75) FEED ROD GDE	84
							83
	REF	REF	–	A	3-21000-6	SCR,SHC (10-32x.62) FEED ADJ PL	82
	REF	REF	–	A	3-21000-4	SCR,SHC (10-32x.38) PIVOT BLOCK	81
	2	2	–	A	3-21002-0	SCR,BHC (10-32x.88) SHEAR PL	80
3	REF	–	–	A	455745-1	GUARD, WINDOW	79
6 3	–	REF	–	A	679532-1	INSERT, GUARD	78
							77
							76
							75
	1	1	–	A	690603-1	SPRING, ASSIST	74
	1	1	–	A	23030-1	SCR,SKT CAP (6-32x.25) CP DSC	73
	REF	REF	–	A	458109-1	WASHER, FLAT (SPECIAL)	72
	REF	REF	–	A	690517-1	SPACER	71
	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

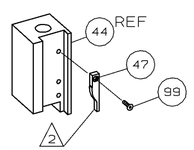
QTY REQD PER ASSY — PARTS LIST

	-1	-2	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
	LEADMAKER & BENCH MODEL G	MECH POST FEED					
	BENCH MODEL K	MECH POST FEED					
	REF	REF	–	A	22594-8	NUT, HEX	70
	REF	REF	–	B	240628-1	PLATE, ADJ	69
	REF	REF	–	B	240626-1	SHAFT, PIVOT	68
	REF	REF	–	B	240633-1	BUSHING	67
	REF	REF	–	A	455680-1	LEVER, INTERMEDIATE	66
	REF	REF	–	B	240629-1	BLOCK, PIVOT	65
	REF	REF	–	A	240632-2	SCR, ADJ	64
	REF	REF	–	B	240659-3	PIN, CAM ROLLER	63
	REF	REF	–	B	240658-1	CAM, ROLLER	62
	REF	REF	–	B	454398-1	ROD, FEED	61
							60
	REF	REF	–	C	454220-1	CAP, RAM	59
	REF	REF	–	D	453736-1	HOUSING	58
							57
							56
	REF	REF	–	B	240624-1	PIN, FEED FINGER	55
	REF	REF	–	B	691499-1	SPRING, FEED FINGER	54
	REF	REF	–	B	240635-1	FINGER, FEED	53
	REF	REF	–	B	240634-1	LEVER, TERMINAL	52
							51
							50
							49
	1	–	–	B	690501-3	CAM, POST FEED 1 1/8 ST	48
	–	1	–	B	690501-4	CAM, POST-FEED 1 5/8 ST	47
							46
	1	1	–	A	690191-1	PLUG, NYLON	45
	1	1	–	C	455674-1	RAM	44
	1	1	–	A	690125-1	WASHER, LAMINATED	43
	1	1	–	A	690124-1	WASHER, RAM	42
	1	1	–	A	7-21002-9	BOLT, CRIMPER (5/16-24x1.00)	41
	1	1	–	A	23241-6	BALL, STEEL	40
	1	1	–	A	690170-1	SPRING, COMPRESSION	39
	1	1	–	C	690142-1	DISC, INSULATION	38
	1	1	–	D	354777-1	WIRE DISC, PLASTIC	37
	1	1	–	A	22480-5	WASHER, SPRING	36
	1	1	–	B	690212-1	POST, RAM	35
							34
							33
	1	1	–	D	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
							31
							30
							29
	1	1	–	B	3-690451-2	SPACER, STRIPPER	28
	1	1	–	A	240639-1	STRIPPER	27
	REF	REF	–	C	455676-1	PLATE, BASE	26
	2	2	–	A	22354-8	DRAG, STUD	25
	1	1	–	B	455678-1	PLATE, STRIP GUIDE	24
	1	1	–	C	240825-3	PLATE, STRIP HOLD DOWN	23
	2	2	–	A	4-22281-1	SPRING, DRAG	22
							21
	1	1	–	A	454177-1	DRAG, STOCK	20
							19
	2	2	–	C	454204-2	GUIDE, STRIP (FRONT)	18
	REF	REF	–	A	454178-1	GUIDE, FEED ROD	17
	REF	REF	–	A	4-22284-9	SPRING, FEED RETURN	16
							15
							14
	1	1	–	C	690481-2	SPACER, HOLD DOWN	13
	1	1	–	A	23846-1	SPRING, HOLD DOWN	12
1	1	1	–	B	240644-1	PLATE, REAR SHEAR	11
							10
1	1	1	–	B	690482-1	PLATE, FRONT SHEAR	9
1	1	1	–	D	2-459866-0	ANVIL	8
1	1	1	–	B	690474-2	BLADE, SLUG	7
	1	1	–	D	1-455892-4	HOLD DOWN, TERMINAL	6
	1	1	–	C	240641-1	SPACER, SLUG BLADE	5
	1	1	–	B	1-238009-4	SPACER, BLOCK CRIMPER	4
1	1	1	–	C	9-683453-2	CRIMPER, INSULATION	3
	1	1	–	B	455888-6	SPACER, CRIMPER	2
1	1	1	–	C	1-462808-1	CRIMPER, WIRE	1
	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

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

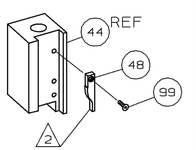
QTY REQD PER ASSY — PARTS LIST

POST-FEED 1 5/8 STROKE



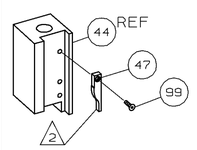
LEADMAKER

POST-FEED 1 1/8 STROKE



K TERMINATOR BENCH MACHINE

POST-FEED 1 5/8 STROKE



G TERMINATOR BENCH MACHINE

LOC A
DIST 66

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.
6. ITEM 78 USED WITH G TERMINATOR ONLY.

P F	LTR	REVISION RECORD	APP	DATE
	A	REVISED	CE	6-97

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

MATL –		HT TR –	FIN –
–		–	–
DR M. OBRINE 06MAY97	APP J.DODDS 06MAY97	AMP Incorporated Harrisburg, PA 17105-3608	
CHK C. ERISMAN 06MAY97	REL – –		
NAME END FEED HDM APPLICATOR		MACHINE REF MINI APPL	
SCALE –	D DWG NO 680466	SHEET 1 OF 1	REV A

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