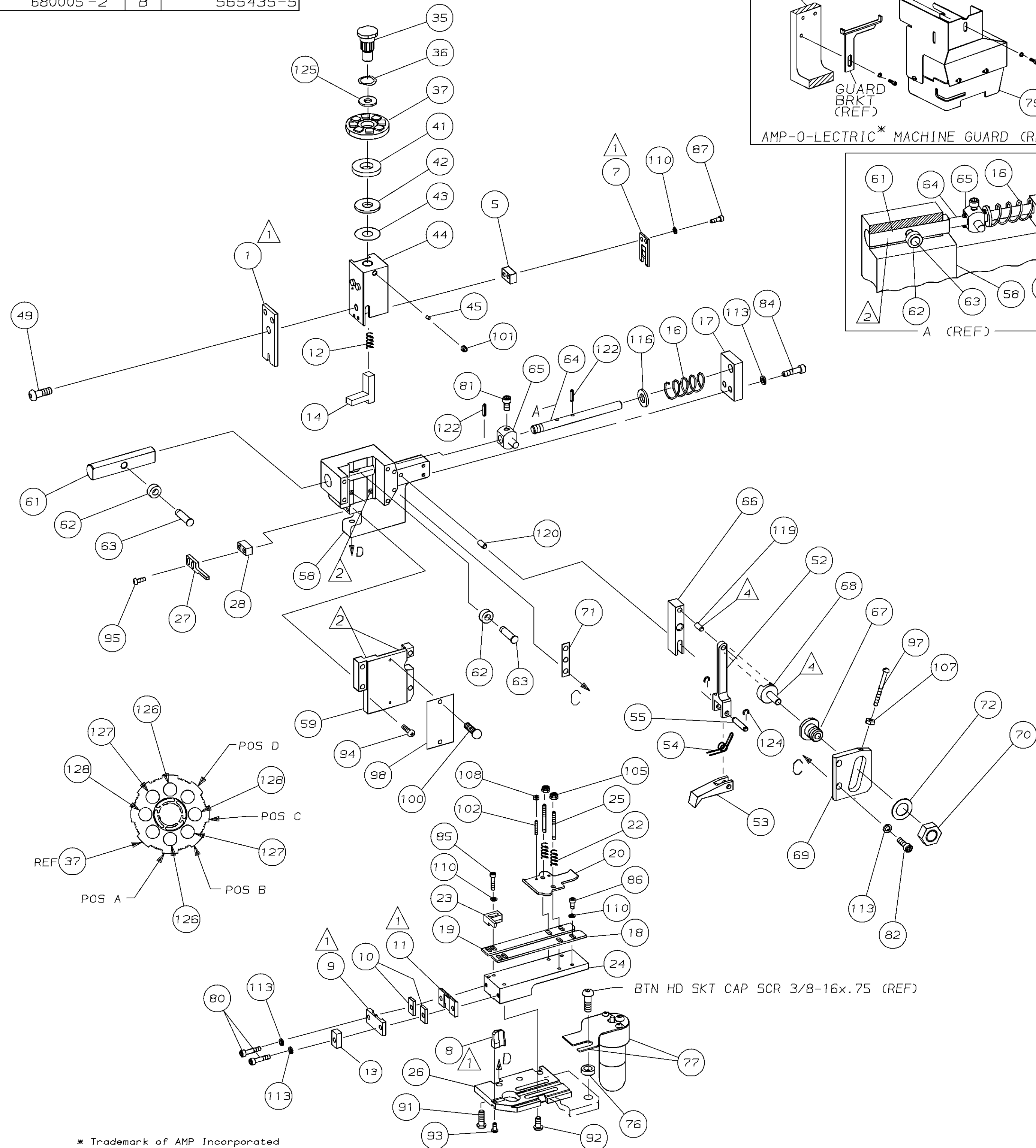
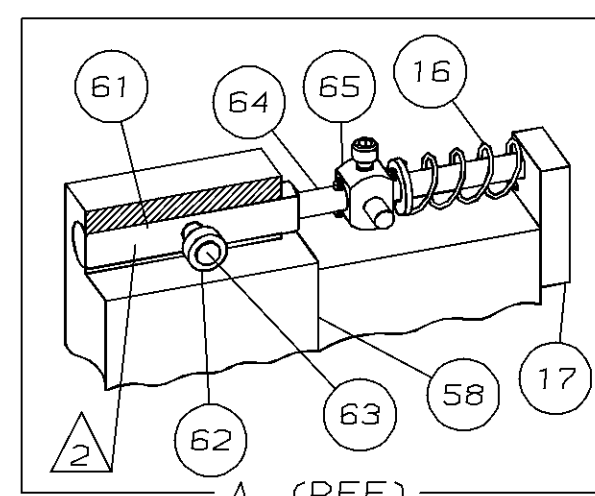
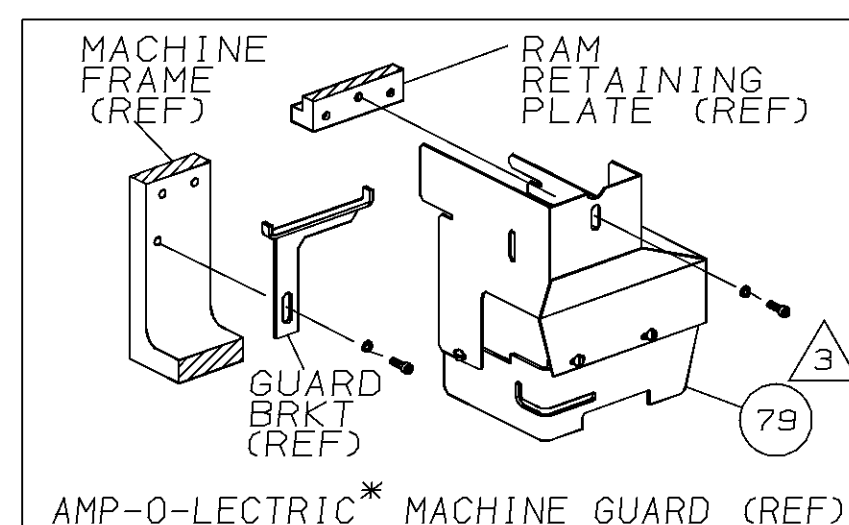
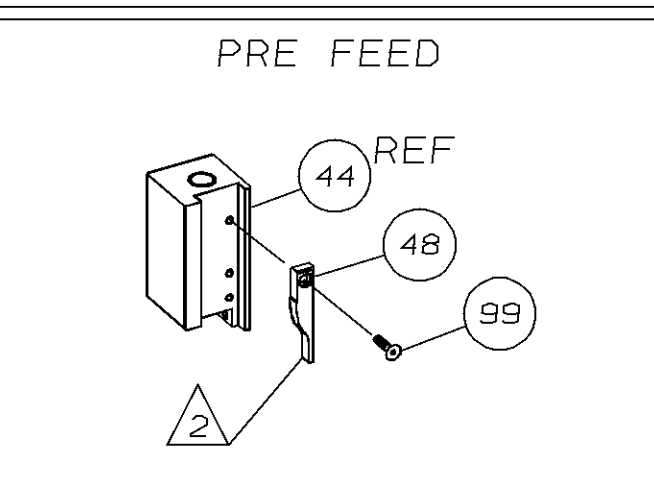
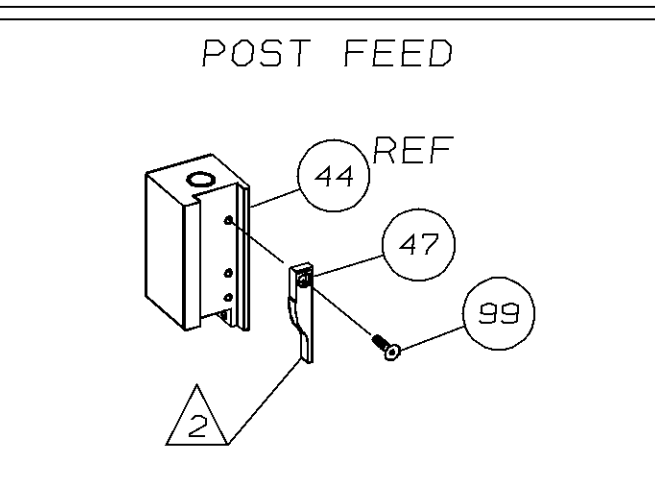


PART NUMBER	REV	FIRST USED
680005-1	A	854400-1
680005-2	B	565435-5

PRELIMINARY



* Trademark of AMP Incorporated



- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-O-LECTRIC MACHINE.
- 4 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 5 FEED OFF RECEPTACLE.
- 6 LUBRICATION REQUIRED WITH NICKEL PLATED TERMINALS.

TERMINAL NAME:
.180 DIA PLUG RECPT

	42868
	42891

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.085 ±.002	3.0 mm ²	
B	.081 ±.002	2.5 mm ²	
C	.076 ±.002	2.0 mm ²	
D	NOT USED		
CRIMP	SIZE	TYPE	RANGE
WIRE	.130	F	2.0-3.0 mm ²
INSUL	-	-	-
FEED:	APPL INST	SET UP GAGE	LAYOUT
.895	408-8039	458638-1	932
WIRE STRIP LENGTH -			

QTY	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	2	-	C	6-354778-9	PIN, WIRE DISC (.2840)C	128
2	2	-	C	5-354778-9	PIN, WIRE DISC (.2790)B	127
2	2	-	C	5-354778-1	PIN, WIRE DISC (.2750)A	126
1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
2	2	-	A	21045-3	RING, RET "C" (Ø.187)FD PIN	124
						123
2	2	-	A	5-21028-1	PIN, STD SPRING (Ø.12)FD ADJ ROD	122
						121
1	1	-	A	1-21030-7	PIN, DOWEL (Ø.187x1.50)HSG	120
1	1	-	A	1-21030-1	PIN, DOWEL (Ø.187x.50)LEVER	119
						118
						117
1	1	-	A	21899-4	WASHER, FLAT (Ø5/16)SCR ADJ	116
						115
						114
6	6	-	A	21024-5	WASHER, LOCK (NO.10)SHEAR PL	113
						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
1	1	-	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	4-21078-8	SKT SKT SET (4-40x.75)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
1	1	-	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
4	4	-	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 6D PL	92
3	3	-	A	2-22733-8	SCR, BHC (1/4-20x.62)BASE PL	91
						90
						89
						88
2	2	-	A	2-21000-8	SCR, SHC (8-32x.62)SLUG BLADE	87
3	3	-	A	2-21000-6	SCR, SHC (8-32x.38)STRIP GUIDE	86
2	2	-	A	2-21000-9	SCR, SHC (8-32x.75)R STRIP GUIDE	85
2	2	-	A	3-21000-7	SCR, SKT CAP (10-32x.75)FD GDE	84
						83
2	2	-	A	3-21000-6	SCR, SKT CAP (10-32x.62)FD ADJ P	82
1	1	-	A	3-21000-4	SCR, SKT CAP (10-32x.38)PIVOT BL	81
2	2	-	A	3-21000-8	SCR, SKT CAP (10-32x.88)SH PL	80
REF	-	-	A	455745-1	GUARD, WINDOW	79
						78
1	-	-	C	465184-9	LUBRICATOR ASSY	77
1	-	-	A	454406-1	SPACER, LUB BRACKET	76
						75
						74
						73
1	1	-	A	458109-1	WASHER, FLAT (SPECIAL)	72
1	1	-	A	690517-1	SPACER	71

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QTY	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
1	1	-	C	454220-1	CAP, RAM	59
1	1	-	D	453736-1	HOUSING	58
						57
						56
1	1	-	B	240624-1	PIN, FEED FINGER	55
1	1	-	B	691499-1	SPRING, FEED FINGER	54
1	1	-	B	240635-2	FINGER, FEED	53
1	1	-	B	240634-1	LEVER, TERMINAL	52
						51
						50
1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16-24x1.00)	49
1	-	-	B	576179-4	CAM, PRE FEED	48
-	1	-	B	576179-3	CAM, POST FEED	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	690223-2	SPACER, INSULATION DISC	41
						40
						39
						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
						32
						31
						30
						29
1	1	-	B	3-690451-2	SPACER, STRIPPER	28
1	1	-	A	240639-1	STRIPPER	27
1	1	-	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	240825-6	PLATE, STRIP HOLD DOWN	23
2	2	-	A	4-22281-1	SPRING, DRAG	22
						21
1	1	-	A	2-576118-4	DRAG, STOCK	20
						19
2	2	-	C	454204-4	GUIDE, STRIP (FRONT)	18
1	1	-	A	454178-1	GUIDE, FEED ROD	17
1	1	-	A	4-22284-9	SPRING, FEED RETURN	16
						15
1	1	-	D	5-455892-5	HOLD DOWN	14
1	1	-	B	690481-2	SPACER, HOLD DOWN	13
1	1	-	A	23846-1	SPRING, HOLD DOWN	12
1	1	-	B	240644-1	PLATE, REAR SHEAR	11
2	2	-	C	1-240645-7	SPACER, SHEAR PLATE	10
1	1	-	B	240642-1	PLATE, FRONT SHEAR	9
1	1	-	D	3-240654-4	ANVIL	8
1	1	-	B	6-240651-0	BLADE, SLUG	7
						6
						5
						4
						3
						2
1	1	-	C	456410-5	CRIMPER, WIRE	1

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LOC A	LEADMAKER	AMP-O-LECTRIC
DIST 66	T TERMINATING UNIT	K TERMINATING UNIT

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED.		MACHINING REF	
DR	B. A. WOLFE	5-6-93	MINI APPL
CHK	M. ENTERLINE	5-13-93	REV B
NAME: END FEED HDM APPLICATOR		MACHINE REF: 680005	
SCALE: -		DWG NO: 680005	