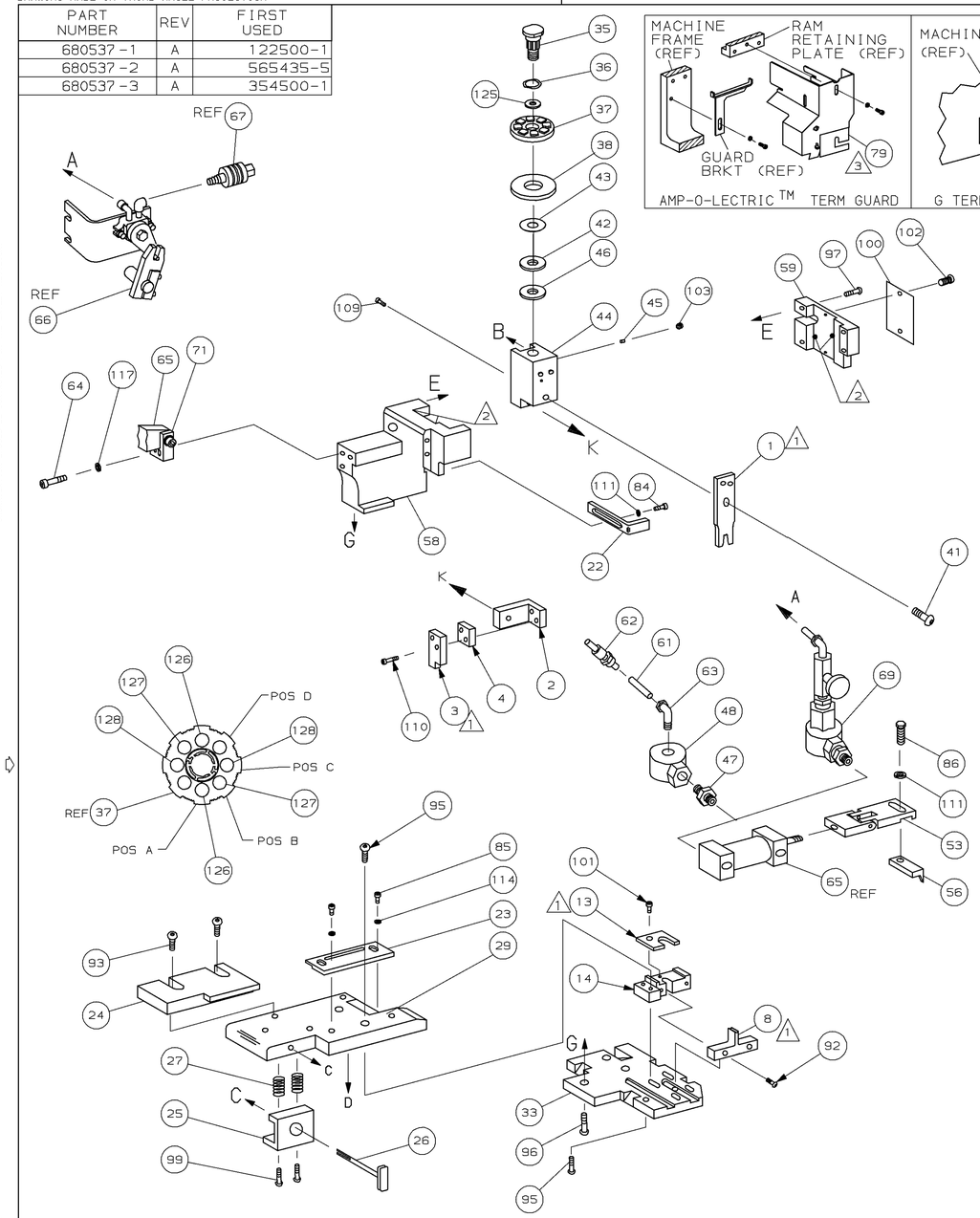
DRAWING MADE IN THIRD ANGLE PROJECTION

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
680537-1	A	122500-1
680537-2	A	565435-5
680537-3	A	354500-1



MACHINE FRAME (REF) — RAM RETAINING PLATE (REF) — GUARD BRKT (REF) — 3 — 79

AMP-O-LECTRIC™ TERM GUARD

MACHINE GUARD (REF) — 78 — 3

G TERMINATOR GUARD

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: MAG-MATE™ TERMINAL

63235
63236
63237

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.050 ±.002 [1.27 ±0.05mm]	18
B	.045 ±.002 [1.14 ±0.05mm]	20
C	.042 ±.002 [1.07 ±0.05mm]	22
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.070 [1.78mm]	F	22-18
INSUL	-	-	-

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.141-.172	114-2046	.330	408-8040	458637-1	1230

-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
							129
2	2	2	-	C	4-354779-1	PIN, WIRE DISC (.3195)C	128
2	2	2	-	C	3-354779-5	PIN, WIRE DISC (.3165)B	127
2	2	2	-	C	2-354779-5	PIN, WIRE DISC (.3115)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
2	2	2	-	A	21024-5	WASHER, LOCK(#10)FEED	117
							116
							115
2	2	2	-	A	21024-4	WASHER,LOCK(#8)FRONT STP GUIDE	114
							113
							112
2	2	2	-	A	21024-4	WASHER,LOCK(#8)STRIPPER	111
1	1	1	-	A	2-21000-2	SCR,SHC(6-32x.75)REAR SHEAR PL	110
2	2	2	-	A	2-21000-1	SCR,SHC(6-32x.62)DEPRESSOR	109
							108
							107
							106
							105
1	1	-	-	A	992031-1	PIN, CLEVIS	104
1	1	1	-	A	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
2	2	2	-	A	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
1	1	1	-	A	3-21000-4	SCR, SHC(10-32x.38)SHEAR PLATE	101
1	1	1	-	B	461264-1	PLATE, IDENTIFICATION	100
2	2	2	-	A	3-21002-0	SCR,BHC(10-32x.88)DRAG	99
							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)HSG	96
5	5	5	-	A	2-21002-6	SCR,BHC(10-32x.38)SHEAR BLK	95
2	2	2	-	A	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
2	2	2	-	A	2-21002-1	SCR,BHC(8-32x.38)R STP GDE	93
2	2	2	-	A	22733-8	SCR,BHC(8-32x.38)(LOC-WEL)ANVIL	92
							91
							90
1	1	-	-	A	7-21000-9	SCR,SHC(4-40x.19)STRIPPER	89
							88
							87
1	1	1	-	A	2-22603-1	SCR,HEX HD(8-32x.38)FEED FINGER	86
2	2	2	-	A	2-21000-6	SCR,SHC(8-32x.38)F ST GUIDE	85
1	1	1	-	A	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
							83
							82
							81
							80
-	1	-	-	B	462992-7	GUARD ASSY	79
REF	-	-	-	B	679532-1	INSERT, GUARD	78
							77
							76
							75
							74
							73
							72
1	1	1	-	B	459610-3	MOUNT, FEED BRACKET	71

QTY REQD PER ASSY — PARTS LIST

-1	LEADMAKER			AIRFEED				
-2	BENCH MODEL K			AIRFEED				
-3	BENCH MODEL G			AIRFEED				
								70
4	-	1	-	-	C	692655-5	AIR FEED VALVE ASSY	69
								68
	-	REF	-	-	A	24042-2	VALVE, SHUT OFF	67
4	-	REF	-	-	C	692655-6	AIR FEED VALVE ASSY	66
4	1	1	1	-	B	461065-1	AIR FEED ASSY (1 INCH)	65
	2	2	2	-	A	3-21000-9	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
								60
	1	1	1	-	C	454220-1	CAP, RAM	59
	1	1	1	-	D	454485-1	HOUSING	58
								57
	1	1	1	-	B	1-694433-3	PAWL, FEED	56
								55
								54
4	1	1	1	-	B	461062-1	FEED FINGER ASSY	53
								52
								51
								50
								49
	1	-	1	-	A	22374-7	VALVE, QUICK EXHAUST	48
	1	-	1	-	A	22304-1	NIPPLE, HEX 1/8 NPT	47
	1	1	1	-	A	690124-1	WASHER, RAM	46
	1	1	1	-	A	690191-1	PLUG, NYLON	45
	1	1	1	-	C	808965-1	RAM	44
	1	1	1	-	A	690125-1	WASHER, LAMINATED	43
	1	1	1	-	A	690124-5	WASHER, RAM	42
	1	1	1	-	A	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41
								40
								39
	1	1	1	-	A	690223-2	SPACER, INSULATION DISC	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
	1	1	1	-	D	809010-1	PLATE, BASE	33
								32
								31
								30
	1	1	1	-	C	809032-1	PLATE, STRIP GUIDE	29
								28
	2	2	2	-	A	1-22284-0	SPRING, DRAG	27
	1	1	1	-	B	454175-1	LEVER, DRAG RELEASE	26
	1	1	1	-	B	1-690754-6	DRAG, TERMINAL	25
	1	1	1	-	D	809030-1	GUIDE, STRIP (REAR)	24
	1	1	1	-	A	809033-1	GUIDE, STRIP (FRONT)	23
	-	-	1	-	B	690472-8	STRIPPER	22
								21
	1	1	-	-	A	679218-1	STRIPPER WIRE STOP ASSY	20
	1	1	-	-	B	458949-8	STRIPPER	19
								18
								17
								16
								15
	1	1	1	-	C	1213090-1	BLOCK, BASE	14
1	1	1	1	-	B	809036-2	PLATE, SHEAR, LEFT	13
								12
								11
								10
								9
1	1	1	1	-	B	1213091-1	ANVIL	8
								7
								6
								5
	1	1	1	-	C	809028-1	SPACER, SHEAR	4
1	1	1	1	-	C	809034-1	BLADE, SHEAR	3
1	1	1	1	-	C	809029-1	BLOCK, SHEAR	2
1	1	1	1	-	C	1-456404-6	CRIMPER, WIRE	1
-3	-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

P	F	LTR	REVISION RECORD	APP	DATE
		A	REVISED	CE	12/97

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

MATL - | HT TR - - | FIN - -

DR 29SEP97 L.COLLINS | APP 29SEP97 T.ELBIN | CHK 29SEP97 C. ERISMAN | REL - -

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR | MACHINE REF MINI APPL

SCALE - | D | DWG NO 680537 | SHEET 1 OF 1 | REV A

LOC A | DIST 66

AMP 3308 REV 3-92

16-DEC-97 | 15:00:30 amp29062

/home/amp29062/appl

680537

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