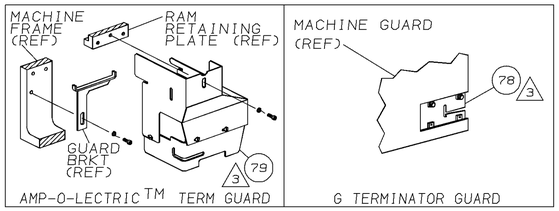
DRAWING MADE IN THIRD ANGLE PROJECTION

680091 ⇔ 680091

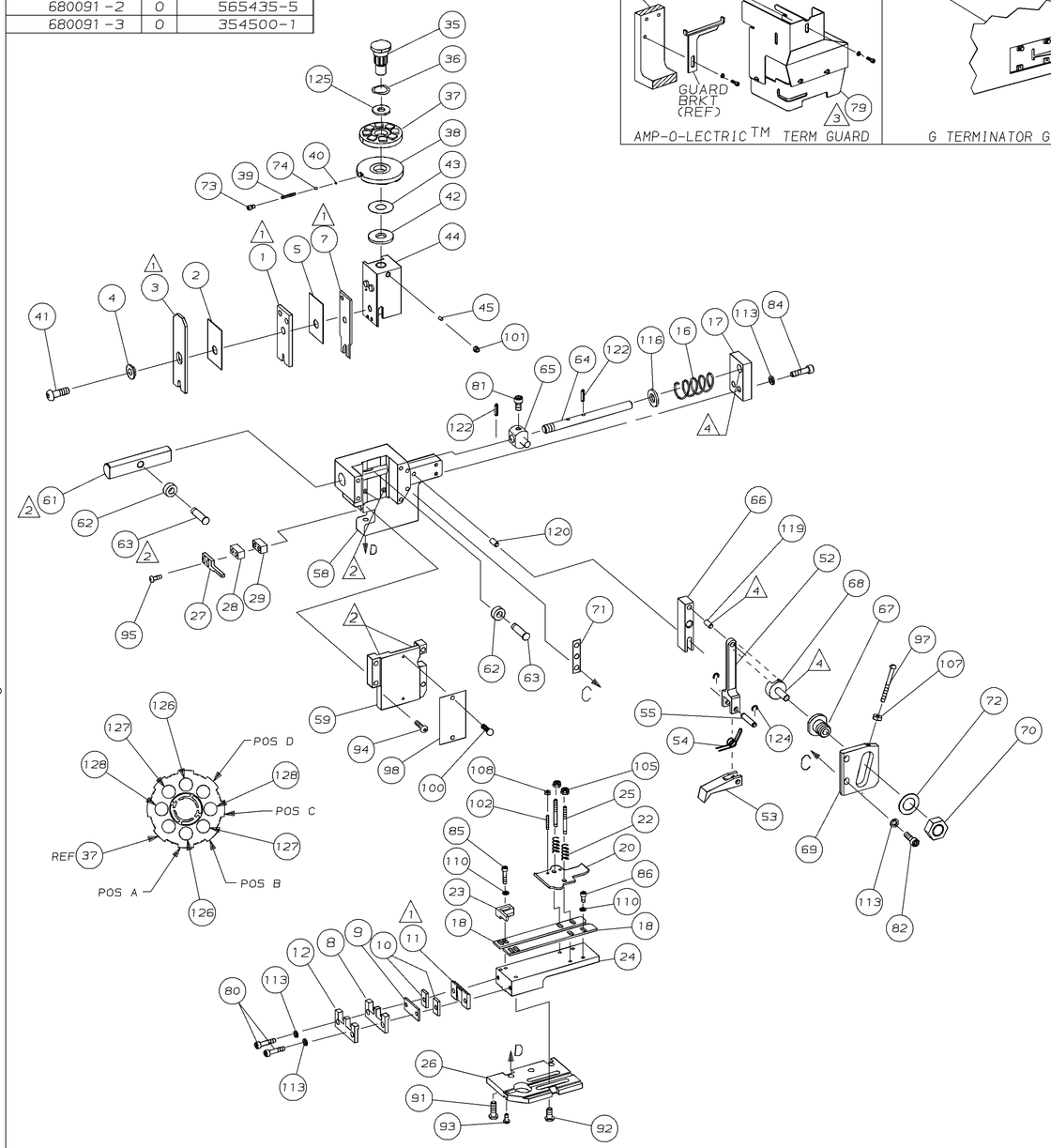
<US161B>DEPTPROJB>U.161B>U.MINI-APPL

PART NUMBER	REV	FIRST USED
680091 -1	0	854400-1
680091 -2	0	565435-5
680091 -3	0	354500-1



TERMINAL NAME: AUTOMACH WIRE PIN		
		927972
TERM APPL SPEC		–

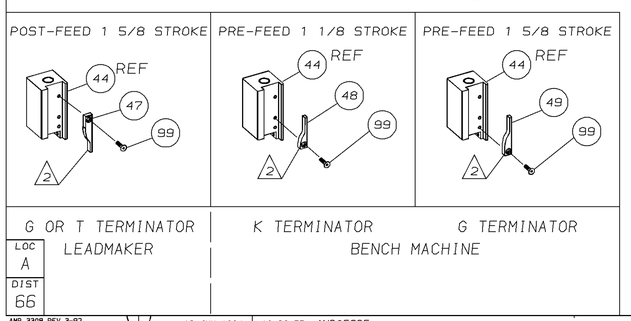
CRIMPING DATA			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.062 ±.002	1 mm²	
B	.057 ±.002	0.75 mm²	
C	.053 ±.002	0.50 mm²	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.080	F	.5-1 mm²
INSUL	.130	F	1.8-3.3mm
FEED	APPL INST	SET UP GAGE	LAYOUT
.500	408-8039	458638-1	L1573
WIRE STRIP LENGTH		–	



							129
2	2	2	–	C	5-354779-0	PIN, WIRE DISC (.3240)C	128
2	2	2	–	C	4-354779-2	PIN, WIRE DISC (.3200)B	127
2	2	2	–	C	3-354779-2	PIN, WIRE DISC (.3150)A	126
1	1	1	–	A	986950-1	WASHER, FLAT PRECISION	125
2	2	2	–	A	21045-3	RING,RET"C"(ø.187)FD PIN	124
							123
2	2	2	–	A	5-21028-1	PIN,STD SPRING(ø.12)FD ADJ ROD	122
							121
1	1	1	–	A	1-21030-7	PIN,DOWEL(ø.187x1.50)HSG	120
1	1	1	–	A	1-21030-1	PIN,DOWEL(ø.187x.50)LEVER	119
							118
							117
1	1	1	–	A	21899-4	WASHER,FLAT(ø5/16)SCR ADJ	116
							115
							114
6	6	6	–	A	21024-5	WASHER,LOCK(NO.10)SHEAR PL	113
							112
							111
5	5	5	–	A	21024-4	WASHER,LOCK(NO.8)SHEAR BL	110
							109
2	2	2	–	A	21018-4	NUT,HEX(4-40)DRAG	108
1	1	1	–	A	21018-5	NUT,HEX(6-32)FD ADJ PL	107
							106
2	2	2	–	A	21022-2	NUT,HEX SL(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
1	1	1	–	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
4	4	4	–	A	2-21002-9	SCR,BHC(10-32x.75)HSG 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 GD PL	92
3	3	3	–	A	2-22733-8	SCR,BHC(1/4-20x.62)BASE PL	91
							90
							89
							88
							87
3	3	3	–	A	2-21000-5	SCR,SHC(8-32x.25)STRIP GUIDE	86
2	2	2	–	A	2-21000-8	SCR,SHC(8-32x.62)R STRIP GUIDE	85
2	2	2	–	A	3-21000-7	SCR, SKT CAP(10-32x.75)FD GDE	84
							83
2	2	2	–	A	3-21000-6	SCR,SKT CAP(10-32x.62)FD ADJ P	82
1	1	1	–	A	3-21000-4	SCR,SKT CAP(10-32x.38)PIVOT BL	81
2	2	2	–	A	3-21000-8	SCR,SKT CAP(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
1	1	1	–	A	458109-1	WASHER, FLAT (SPECIAL)	72
1	1	1	–	A	690517-1	SPACER	71
–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			

–1	LEADMAKER				MECH POST FEED		
–2	BENCH MODEL K				MECH PRE FEED		
–3	BENCH MODEL G				MECH PRE FEED		
1	1	1	–	A	22594-8	NUT, HEX	70
1	1	1	–	B	240628-1	PLATE, ADJ	69
1	1	1	–	B	240626-1	SHAFT, PIVOT	68
1	1	1	–	B	240633-1	BUSHING	67
1	1	1	–	A	455680-1	LEVER, INTERMEDIATE	66
1	1	1	–	B	240629-1	BLOCK, PIVOT	65
1	1	1	–	A	240632-2	SCR, ADJ	64
1	1	1	–	B	240659-3	PIN, CAM ROLLER	63
1	1	1	–	B	240658-1	CAM, ROLLER	62
1	1	1	–	B	454398-1	ROD, FEED	61
							60
1	1	1	–	C	454220-1	CAP, RAM	59
1	1	1	–	D	453736-1	HOUSING	58
							57
							56
1	1	1	–	B	240624-1	PIN, FEED FINGER	55
1	1	1	–	B	691499-1	SPRING, FEED FINGER	54
1	1	1	–	B	240635-1	FINGER, FEED	53
1	1	1	–	B	240634-1	LEVER, TERMINAL	52
							51
							50
1	–	–	–	B	690602-6	CAM, PRE-FEED 1 5/8 ST	49
–	1	–	–	B	690602-5	CAM, PRE-FEED 1 1/8 ST	48
–	–	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	455674-9	RAM	44
1	1	1	–	A	690125-1	WASHER, LAMINATED	43
1	1	1	–	A	690124-1	WASHER, RAM	42
1	1	1	–	A	690686-3	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
							32
							31
							30
1	1	1	–	B	1-690451-4	SPACER, STRIPPER	29
1	1	1	–	B	2-690451-7	SPACER, STRIPPER	28
1	1	1	–	A	240639-1	STRIPPER	27
1	1	1	–	C	455676-1	PLATE, BASE	26
2	2	2	–	A	22354-8	DRAG, STUD	25
1	1	1	–	B	455678-3	PLATE, STRIP GUIDE	24
1	1	1	–	C	240825-2	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	454204-6	GUIDE, STRIP (FRONT)	18
1	1	1	–	A	454178-1	GUIDE, FEED ROD	17
1	1	1	–	A	4-22284-9	SPRING, FEED RETURN	16
							15
							14
							13
1	1	1	–	D	2-690702-7	ANVIL, INSULATION	12
1	1	1	–	B	240644-5	PLATE, REAR SHEAR	11
2	2	2	–	C	6-240645-2	SPACER, SHEAR PLATE	10
1	1	1	–	B	690619-4	PLATE, RETAINING	9
1	1	1	–	D	4-690618-0	ANVIL, WIRE	8
1	1	1	–	B	459722-8	BLADE, SLUG	7
							6
1	1	1	–	B	455888-1	SPACER, CRIMPER	5
1	1	1	–	B	1-238009-3	SPACER, BLOCK CRIMPER	4
1	1	1	–	C	5-683453-4	CRIMPER, INSULATION	3
1	1	1	–	B	455888-7	SPACER, CRIMPER	2
1	1	1	–	C	3-459736-3	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			

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.



LOC A
DIST 66

P	F	LTR	REVISION RECORD	APP	DATE
		–	–	.	.

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 5/16/94 P.MATHIAS	APP 5-24-94 T.ELBIN	AMP Incorporated Harrisburg, PA 17105-3608	
CHK 5-24-94 C.ERISMAN	REL 6/2/94 B. MORGAN		

NAME END FEED HDM APPLICATOR | MACHINE REF MINI APPL

SCALE – | D | DWG NO 680091 | SHEET 1 OF 1 | REV 0

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