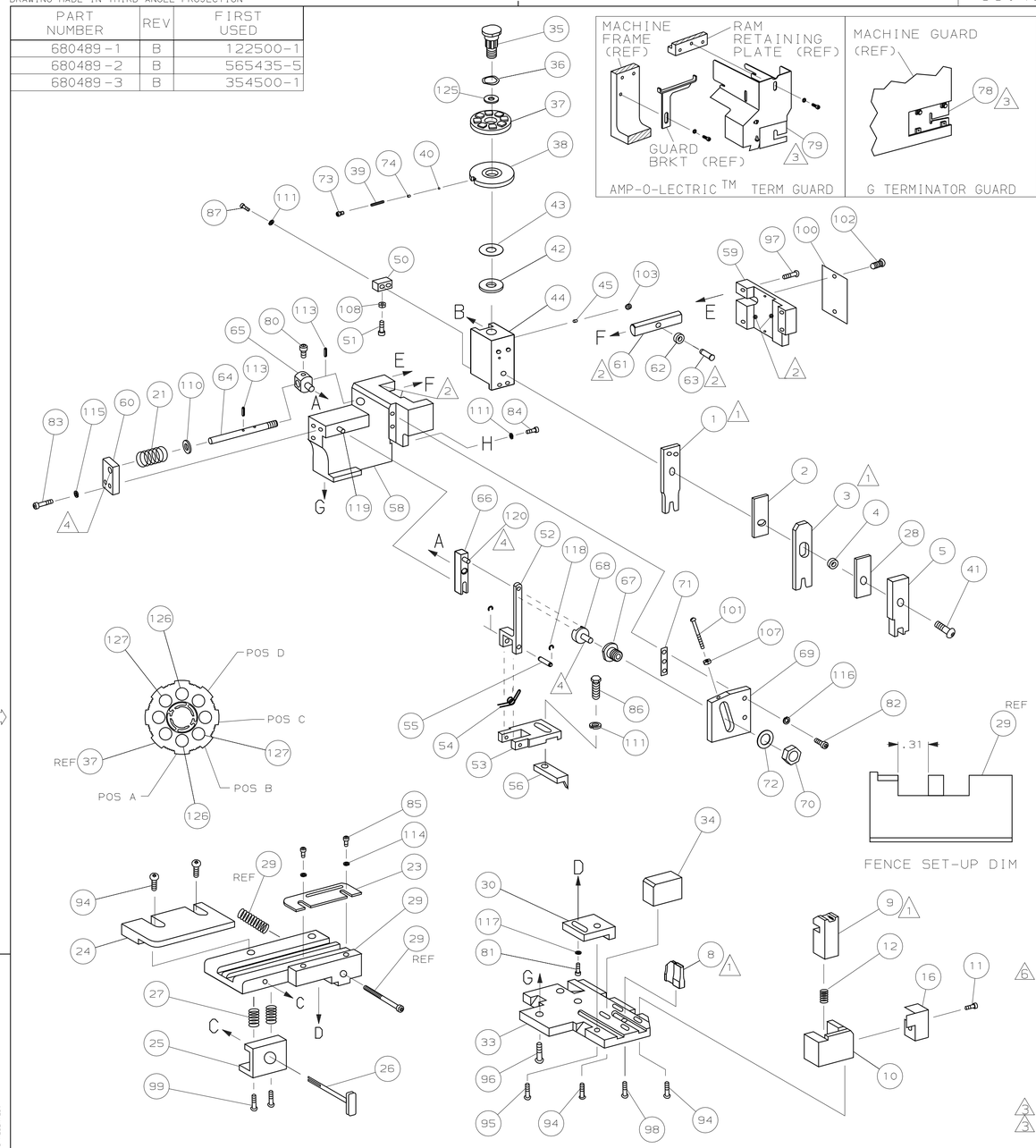
DRAWING MADE IN THIRD ANGLE PROJECTION

/home/amp18577/edmmod

| PART NUMBER | REV | FIRST USED |
|---|---|---|
| 680489-1 | B | 122500-1 |
| 680489-2 | B | 565435-5 |
| 680489-3 | B | 354500-1 |




TERMINAL NAME: TERMINAL BLADE, FEMALE

286602

CRIMPING DATA

| PAD LTR | CRIMP HEIGHT | WIRE SIZE |
|---|---|---|
| A | .097 ±.002 [2.46 ±0.05mm] | 10 |
| B | .081 ±.002 [2.06 ±0.05mm] | 12 |
| C | NOT | USED |
| D | NOT | USED |

| CRIMP | SIZE | TYPE | RANGE |
|---|---|---|---|
| WIRE | .160 [4.06mm] | F | 12-10 |
| INSUL | .210 [5.33mm] | F | ø.157-.209 |

| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPL INSTRUCTION | SET UP GAGE | LAYOUT |
|---|---|---|---|---|---|
| .188-.219 | NONE | .800 | 408-8040 | 458637-1 | L1947 |

| -3 | -2 | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|---|---|---|---|
| | | | | | | | 129 |
| | | | | | | | 128 |
| 2 | 2 | 2 | - | C | 5-354778-7 | PIN, WIRE DISC (.2780)B | 127 |
| 2 | 2 | 2 | - | C | 2-354778-3 | PIN, WIRE DISC (.2610)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 |
| REF | REF | REF | - | A | 1-21030-1 | PIN,DOWEL(ø.187x.50)LEVER | 120 |
| REF | REF | REF | - | A | 1-21030-6 | PIN,DOWEL(ø.187x1.25)HOUSING | 119 |
| REF | REF | REF | - | A | 21045-3 | RING,RET "C"(ø.187)FD FING PIN | 118 |
| 1 | 1 | 1 | - | A | 21024-5 | WASHER, LOCK(#10)ADJ BLOCK | 117 |
| REF | REF | REF | - | A | 21024-5 | WASHER,LOCK(#10)ADJ PLATE | 116 |
| REF | REF | REF | - | A | 21024-5 | WASHER,LOCK(#10)FEED GDE ROD | 115 |
| 2 | 2 | 2 | - | A | 21024-2 | WASHER,LOCK(#4)FRONT STP GUIDE | 114 |
| REF | REF | REF | - | A | 5-21028-1 | PIN,SLT SPR(ø.125x.50)ADJ ROD | 113 |
| | | | | | | | 112 |
| 4 | 4 | 4 | - | A | 21024-4 | WASHER,LOCK(#8)STRIPPER | 111 |
| REF | REF | REF | - | A | 21899-4 | WASHER,FLAT(ø5/16)SCREW ADJ | 110 |
| | | | | | | | 109 |
| 1 | 1 | 1 | - | A | 21018-5 | NUT,HEX(NO.6)HOLDDOWN | 108 |
| REF | REF | REF | - | A | 21018-5 | NUT,HEX(6-32)FEED ADJ | 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 |
| REF | REF | REF | - | A | 6-23715-5 | SCR,PAN HD(6-32x1.50)FEED ADJ | 101 |
| 1 | 1 | 1 | - | B | 461264-1 | PLATE, IDENTIFICATION | 100 |
| 2 | 2 | 2 | - | A | 3-21002-0 | SCR,BHC(10-32x.88)DRAG | 99 |
| 1 | 1 | 1 | - | A | 22733-8 | SCR,BHC(8-32x.38 LW)ANVIL | 98 |
| REF | REF | REF | - | A | 2-21002-9 | SCR,BHC(10-32x.75)CAP | 97 |
| REF | REF | REF | - | A | 2-22733-8 | SCR,BHC(1/4-20x.62)HOUSING | 96 |
| REF | REF | REF | - | A | 2-21002-7 | SCR,BHC(10-32x.50)SG ADJ BLOCK | 95 |
| 6 | 6 | 6 | - | A | 2-21002-2 | SCR,BHC(8-32x.50)TERM H DWN | 94 |
| | | | | | | | 93 |
| | | | | | | | 92 |
| 1 | 1 | 1 | - | A | 1-21002-7 | SCR,BHC(6-32x.38)CAM | 91 |
| | | | | | | | 90 |
| 1 | 1 | - | - | A | 7-21000-9 | SCR,SHC(4-40x.19)STRIPPER | 89 |
| | | | | | | | 88 |
| 2 | 2 | 2 | - | A | 2-21000-7 | SCR,SHC(8-32x.48)DEP-HOLD | 87 |
| 1 | 1 | 1 | - | A | 2-22603-0 | SCR,HEX HD(8-32x.31)FEED FINGER | 86 |
| 2 | 2 | 2 | - | A | 1-21000-3 | SCR,SHC(4-40x.25)F ST GUIDE | 85 |
| 1 | 1 | 1 | - | A | 2-21000-7 | SCR,SHC(8-32x.50)STRIPPER | 84 |
| REF | REF | REF | - | A | 3-21000-7 | SCR,SHC(10-32x.75)FEED ROD GD | 83 |
| REF | REF | REF | - | A | 3-21000-6 | SCR,SHC(10-32x.62)FD ADJ BLK | 82 |
| 1 | 1 | 1 | - | A | 3-21000-4 | SCR,SHC(10-32x.38)SG ADJ BL | 81 |
| REF | REF | REF | - | A | 3-21000-4 | SCR,SHC(10-32x.38)PIVOT BLK | 80 |
| - | REF | - | - | B | 455749-1 | GUARD, WINDOW | 79 |
| REF | - | - | - | B | 679532-1 | INSERT, GUARD | 78 |
| | | | | | | | 77 |
| | | | | | | | 76 |
| | | | | | | | 75 |
| 1 | 1 | 1 | - | A | 690603-1 | SPRING, ASSIST | 74 |
| 1 | 1 | 1 | - | A | 23030-1 | SCR,SHC(6-32x.25 SL)INS DISC | 73 |
| REF | REF | REF | - | A | 458109-1 | WASHER, SPECIAL | 72 |
| REF | REF | REF | - | A | 690517-1 | SPACER | 71 |
| -3 | -2 | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |

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 |

| -3 | -2 | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|---|---|---|---|
| REF | REF | REF | - | B | 22594-8 | NUT,HEX(1/2-20) | 70 |
| REF | REF | REF | - | B | 240628-1 | PLATE, ADJUSTMENT | 69 |
| REF | REF | REF | - | B | 240626-1 | SHAFT, PIVOT | 68 |
| REF | REF | REF | - | B | 240633-1 | BUSHING | 67 |
| REF | REF | REF | - | A | 455680-1 | LEVER, INTERMEDIATE | 66 |
| REF | REF | REF | - | B | 240629-1 | BLOCK, PIVOT | 65 |
| REF | REF | REF | - | A | 240632-2 | SCREW, ADJ FEED ROD | 64 |
| REF | REF | REF | - | B | 240659-3 | PIN, CAM ROLLER | 63 |
| REF | REF | REF | - | B | 240658-1 | ROLLER, CAM | 62 |
| REF | REF | REF | - | B | 454398-2 | ROD, FEED | 61 |
| REF | REF | REF | - | A | 454178-1 | GUIDE, FEED ROD | 60 |
| REF | REF | REF | - | C | 454220-1 | CAP, RAM | 59 |
| REF | REF | REF | - | D | 454485-1 | HOUSING | 58 |
| | | | | | | | 57 |
| 1 | 1 | 1 | - | B | 1-694433-6 | PAWL, FEED | 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 | 690541-1 | HOLDER, FEED FINGER | 53 |
| REF | REF | REF | - | A | 455679-2 | LEVER, TERMINAL FEED ARM | 52 |
| 1 | 1 | 1 | - | A | 811242-2 | BUMPER, HOLDDOWN | 51 |
| 1 | 1 | 1 | - | A | 690753-1 | SPACER, TONKER | 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 |
| 1 | 1 | 1 | - | B | 459456-2 | APPLICATOR, BASIC (SUBASSY) | 46 |
| 1 | 1 | 1 | - | A | 690191-1 | PLUG, NYLON | 45 |
| 1 | 1 | 1 | - | C | 819307-7 | RAM | 44 |
| 1 | 1 | 1 | - | A | 690125-1 | WASHER, LAMINATED | 43 |
| 1 | 1 | 1 | - | A | 690124-9 | WASHER, RAM | 42 |
| 1 | 1 | 1 | - | A | 7-21002-9 | BOLT, CRIMPER(5/16x1.00) | 41 |
| 1 | 1 | 1 | - | A | 23241-6 | BALL, STEEL | 40 |
| 1 | 1 | 1 | - | A | 690170-1 | SPRING, COMPRESSION | 39 |
| 1 | 1 | 1 | - | C | 1-690142-0 | 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 |
| 1 | 1 | 1 | - | B | 690786-1 | SUPPORT, TERMINAL | 34 |
| REF | REF | REF | - | D | 455675-1 | PLATE, BASE | 33 |
| | | | | | | | 32 |
| | | | | | | | 31 |
| REF | REF | REF | - | B | 455689-1 | BLOCK, STRIP GUIDE ADJ | 30 |
| 1 | 1 | 1 | - | C | 318042-1 | STRIP GUIDE PLATE ASSY | 29 |
| 1 | 1 | 1 | - | C | 2-455888-8 | SPACER, FRONT SHEAR DEP | 28 |
| 2 | 2 | 2 | - | A | 1-22284-0 | SPRING, DRAG | 27 |
| 1 | 1 | 1 | - | B | 690546-1 | LEVER, DRAG RELEASE | 26 |
| 1 | 1 | 1 | - | B | 240792-1 | DRAG, TERMINAL | 25 |
| 1 | 1 | 1 | - | D | 1-90765-7 | GUIDE, STRIP (REAR) | 24 |
| 1 | 1 | 1 | - | A | 690438-2 | GUIDE, STRIP (FRONT) | 23 |
| - | - | 1 | - | B | 690472-2 | STRIPPER | 22 |
| REF | REF | REF | - | A | 4-22284-9 | SPRING, FEED RETURN | 21 |
| 1 | 1 | - | - | A | 679218-1 | STRIPPER WIRE STOP ASSY | 20 |
| 1 | 1 | - | - | B | 458949-1 | STRIPPER | 19 |
| | | | | | | | 18 |
| | | | | | | | 17 |
| 1 | 1 | 1 | - | B | 318563-1 | GUARD, CHIP, FRONT | 16 |
| | | | | | | | 15 |
| | | | | | | | 14 |
| | | | | | | | 13 |
| 1 | 1 | 1 | - | A | 5-22280-0 | SPRING, SHEAR | 12 |
| 1 | 1 | 1 | - | B | 690461-2 | STOP, SHEAR | 11 |
| 1 | 1 | 1 | - | C | 1-690459-0 | HOLDER, SHEAR (FRONT) | 10 |
| 1 | 1 | 1 | - | C | 454276-9 | SHEAR, FLOAT (FRONT) | 9 |
| 1 | 1 | 1 | - | C | 1-662520-3 | ANVIL | 8 |
| | | | | | | | 7 |
| | | | | | | | 6 |
| 1 | 1 | 1 | - | C | 1-455889-8 | DEPRESSOR, SHEAR (FRONT) | 5 |
| 1 | 1 | 1 | - | B | 238011-2 | SPACER, BLOCK CRIMPER | 4 |
| 1 | 1 | 1 | - | C | 6-456134-7 | CRIMPER, INSULATION | 3 |
| 1 | 1 | 1 | - | C | 1-455888-0 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | - | C | 456414-1 | CRIMPER, WIRE | 1 |
| -3 | -2 | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |

QTY REQD PER ASSY — REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION) — PARTS LIST

POST FEED 1 5/8 STROKE — ROTATED 180° B

PRE FEED 1 1/8 STROKE — ROTATED 180° B

PRE FEED 1 5/8 STROKE — ROTATED 180° B

LEADMAKER

K TERMINATOR

G TERMINATOR

BENCH MACHINE

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 46.
6. CUT TO LENGTH AT ASSY

| P | F | LTR | REVISION RECORD | APP | DATE |
|---|---|---|---|---|---|
| | | B | 0150-9709-99 | MEH | 11/99 |
| | | A | REVISED | CE | 11/97 |

DIMENSIONS IN INCHES. DO NOT SCALE PRINT.
TOLERANCES UNLESS OTHERWISE SPECIFIED:
2 PLC DEC ±.02
3 PLC DEC ±-
4 PLC DEC ±-
ANGLES ± -
SURFACE TEXTURE: √
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL - - | HT TR - - | FIN - -

DR 18JUN97 M. OBRINE | APP 18JUN97 J.HIRNEISEN | CHK 18JUN97 C. ERISMAN | REL - -

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR | MACHINE REF MINI APPL

SCALE - | SIZE D | DWG NO 680489 | SHEET 1 OF 1 | REV B

CAGE CODE 00779 — CUSTOMER AND ASSEMBLY DRAWING — RESTRICTED TO

THIS DRAWING IS A CONTROLLED DOCUMENT.
RELEASED FOR PUBLICATION NOV 12,1999
BY AMP INCORPORATED. ALL RIGHTS RESERVED.
COPYRIGHT 1999

LOC A | DIST 66