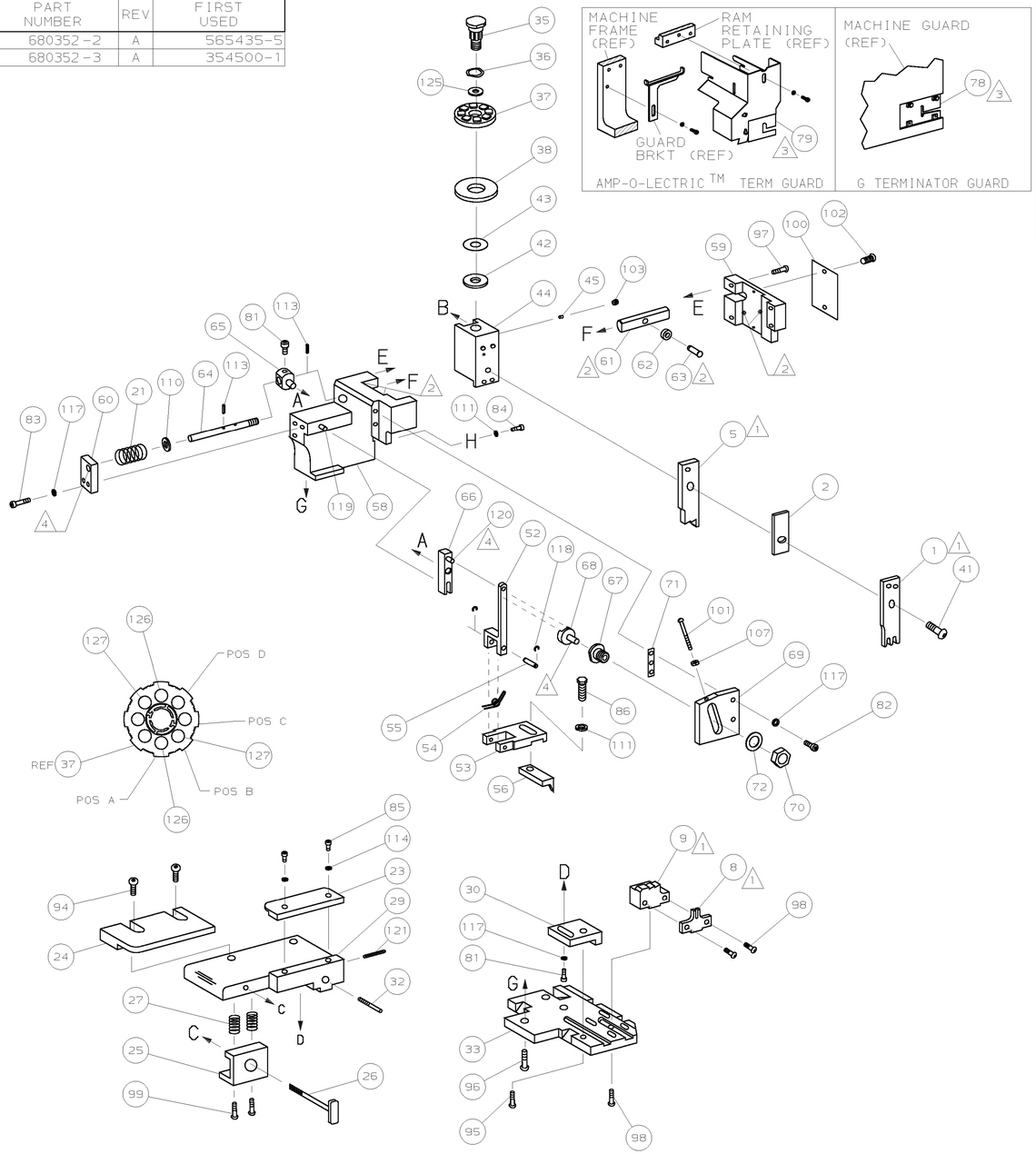
DRAWING MADE IN THIRD ANGLE PROJECTION

680352 ⇔ 680352

/home/amp18246

PART NUMBER	REV	FIRST USED
680352-2	A	565435-5
680352-3	A	354500-1



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.

TERMINAL NAME: POWER BLADE

156523

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.064 ±.002 [1.63 ±0.05mm]	18
B	.061 ±.002 [1.55 ±0.05mm]	20
C	NOT	USED
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.090 [2.29mm]	F	20-18
INSUL	-	-	-

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
-	114-21002	.252	408-8040	458637-1	L1808

-2	BENCH MODEL K	MECH PRE FEED
-3	BENCH MODEL G	MECH PRE FEED

-3	-2	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
						129
						128
2	2	-	C	2-354779-4	PIN, WIRE DISC (.3110)B	127
2	2	-	C	1-354779-8	PIN, WIRE DISC (.3080)A	126
1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	-	-	4088040	SF APPL INST 408-8040	123
						122
1	1	-	A	4-21028-0	PIN,SLT SPR(ø.093x.75)ST GDE PL	121
1	1	-	A	1-21030-1	PIN,DOWEL(ø.187x.50)LEVER	120
1	1	-	A	1-21030-6	PIN,DOWEL(ø.187x1.25)HOUSING	119
2	2	-	A	21045-3	RING,RET "C"(ø.187)FD FING PIN	118
5	5	-	A	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
						116
						115
2	2	-	A	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
2	2	-	A	5-21028-1	PIN,SLT SPR(ø.125x.50)ADJ ROD	113
						112
2	2	-	A	21024-4	WASHER,LOCK(#8)STRIPPER	111
1	1	-	A	21899-4	WASHER,FLAT(ø5/16)SCREW ADJ	110
						109
						108
1	1	-	A	21018-5	NUT,HEX(6-32)FEED ADJ	107
						106
						105
1	1	-	A	992031-1	PIN, CLEVIS	104
1	1	-	A	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
2	2	-	A	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
1	1	-	A	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
1	1	-	B	461264-1	PLATE, IDENTIFICATION	100
2	2	-	A	3-21002-0	SCR,BHC(10-32x.88)DRAG	99
3	3	-	A	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
2	2	-	A	2-21002-9	SCR,BHC(10-32x.75)CAP	97
3	3	-	A	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
1	1	-	A	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
4	4	-	A	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
						93
						92
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
						87
1	1	-	A	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
2	2	-	A	1-21000-4	SCR,SHC(4-40x.38)F ST GUIDE	85
1	1	-	A	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
2	2	-	A	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
2	2	-	A	3-21000-6	SCR,SHC(10-32x.62)FEED ADJ BLK	82
2	2	-	A	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
						80
-	REF	-	B	455749-1	GUARD, WINDOW	79
REF	-	-	B	679532-1	INSERT, GUARD	78
						77
						76
						75
						74
						73
1	1	-	A	458109-1	WASHER, SPECIAL	72
1	1	-	A	690517-1	SPACER	71

QTY REQD PER ASSY — PARTS LIST

-3	-2	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
1	1	-	B	22594-8	NUT,HEX(1/2-20)	70
1	1	-	B	240628-1	PLATE, ADJUSTMENT	69
1	1	-	B	240626-1	SHAFT, PIVOT	68
1	1	-	B	240633-1	BUSHING	67
1	1	-	A	455680-1	LEVER, INTERMEDIATE	66
1	1	-	B	240629-1	BLOCK, PIVOT	65
1	1	-	A	240632-2	SCREW, ADJ FEED ROD	64
1	1	-	B	240659-3	PIN, CAM ROLLER	63
1	1	-	B	240658-1	ROLLER, CAM	62
1	1	-	B	454398-2	ROD, FEED	61
1	1	-	A	454178-1	GUIDE, FEED ROD	60
1	1	-	C	454220-1	CAP, RAM	59
1	1	-	D	454485-1	HOUSING	58
						57
1	1	-	B	690542-2	PAWL, FEED	56
1	1	-	B	240624-1	PIN, FEED FINGER	55
1	1	-	B	691499-1	SPRING, FEED FINGER	54
1	1	-	A	690541-1	HOLDER, FEED FINGER	53
1	1	-	B	455679-1	LEVER, TERMINAL FEED ARM	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
						47
						46
1	1	-	A	690191-1	PLUG, NYLON	45
1	1	-	C	455673-2	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(5/16x1.00)	41
						40
						39
1	1	-	A	690223-2	SPACER, INSULATION DISC	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
1	1	-	D	461141-1	PLATE, BASE	33
1	1	-	A	690432-3	SCREW, ADJUSTMENT	32
						31
1	1	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	-	C	455671-1	PLATE, STRIP GUIDE	29
						28
2	2	-	A	1-22284-0	SPRING, DRAG	27
1	1	-	B	690546-1	LEVER, DRAG RELEASE	26
1	1	-	B	690754-9	DRAG, TERMINAL	25
1	1	-	D	5-690440-5	GUIDE, STRIP (REAR)	24
1	1	-	A	690712-3	GUIDE, STRIP (FRONT)	23
						22
1	1	-	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
						16
						15
						14
						13
						12
						11
						10
1	1	-	C	662403-1	SHEAR, LOWER	9
1	1	-	C	662404-1	ANVIL, DUAL	8
						7
						6
1	1	-	C	662402-1	SHEAR, UPPER	5
						4
						3
1	1	-	C	2-455888-4	SPACER, CRIMPER	2
1	1	-	C	3-458209-5	CRIMPER, DUAL WIRE	1

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

P	F	LTR	REVISION RECORD	APP	DATE
		A	RELEASED	CE	10-96

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 9-5-96 R.O.WILSON APP 9-11-96 J.DODDS CHK 9-6-96 C.ERISMAN REL - -

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL

SCALE - D DWG NO 680352 SHEET 1 OF 1 REV A

CAGE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO -

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