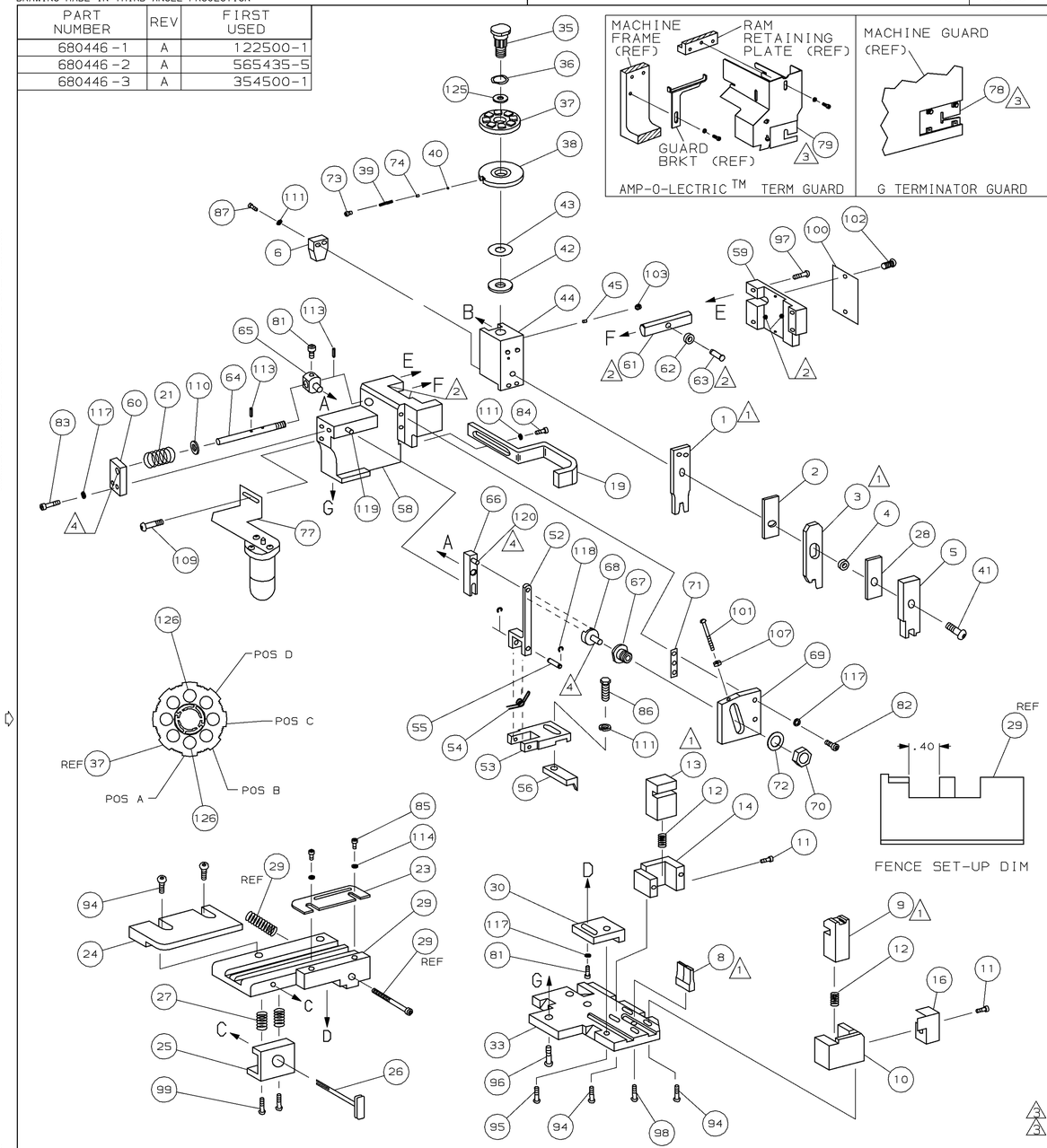
DRAWING MADE IN THIRD ANGLE PROJECTION

680446 ⇔ 680446

/home/amp14442/newdesign

PART NUMBER	REV	FIRST USED
680446-1	A	122500-1
680446-2	A	565435-5
680446-3	A	354500-1



TERMINAL NAME: TAB, .250 RIGHT ANGLE

286569

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.095 ±.002 [2.41 ±0.05mm]	18
B	NOT	USED
C	NOT	USED
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.130 [3.30mm]	F	18
INSUL	.160 [4.06mm]	O	ø.104

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.219-.250	NONE	.900	408-8040	458637-1	L1902

-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
							129
							128
							127
2	2	2	-	C	4-354778-3	PIN, WIRE DISC (.2710)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
1	1	1	-	A	1-21030-1	PIN,DOWEL(ø.187x.50)LEVER	120
1	1	1	-	A	1-21030-6	PIN,DOWEL(ø.187x1.25)HOUSING	119
2	2	2	-	A	21045-3	RING,RET "C"(ø.187)FD FING PIN	118
5	5	5	-	A	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
							116
							115
2	2	2	-	A	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
2	2	2	-	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
1	1	1	-	A	21899-4	WASHER,FLAT(ø5/16)SCREW ADJ	110
-	1	-	-	A	2-21002-6	SCR,BHC(10-32x.38)LUBE ASSY	109
							108
1	1	1	-	A	21018-5	NUT,HEX(6-32)FEED ADJ	107
							106
							105
							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	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
2	2	2	-	A	2-21002-9	SCR,BHC(10-32x.75)CAP	97
3	3	3	-	A	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
1	1	1	-	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
							89
							88
2	2	2	-	A	2-21000-6	SCR,SHC(8-32x.38)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
2	2	2	-	A	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
2	2	2	-	A	3-21000-6	SCR,SHC(10-32x.62)FEED ADJ BLK	82
2	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
-	1	-	-	C	1-465184-0	LUBRICATOR ASSY	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
1	1	1	-	A	458109-1	WASHER, SPECIAL	72
1	1	1	-	A	690517-1	SPACER	71

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
1	1	1	-	B	22594-8	NUT,HEX(1/2-20)	70
1	1	1	-	B	240628-1	PLATE, ADJUSTMENT	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	SCREW, ADJ FEED ROD	64
1	1	1	-	B	240659-3	PIN, CAM ROLLER	63
1	1	1	-	B	240658-1	ROLLER, CAM	62
1	1	1	-	B	454398-2	ROD, FEED	61
1	1	1	-	A	454178-1	GUIDE, FEED ROD	60
1	1	1	-	C	454220-1	CAP, RAM	59
1	1	1	-	D	454485-1	HOUSING	58
							57
1	1	1	-	B	3-694433-0	PAWL, FEED	56
1	1	1	-	B	240624-1	PIN, FEED FINGER	55
1	1	1	-	B	691499-1	SPRING, FEED FINGER	54
1	1	1	-	A	690541-1	HOLDER, FEED FINGER	53
1	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
-	-	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	455673-1	RAM	44
1	1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	1	-	A	690124-1	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	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
1	1	1	-	D	455675-6	PLATE, BASE	33
							32
							31
1	1	1	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	C	318042-1	STRIP GUIDE PLATE ASSY	29
1	1	1	-	C	455888-3	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	6-690440-0	GUIDE, STRIP (REAR)	24
1	1	1	-	A	690438-9	GUIDE, STRIP (FRONT)	23
							22
1	1	1	-	A	4-22284-9	SPRING, FEED RETURN	21
							20
1	1	-	-	B	458230-1	STRIPPER	19
							18
							17
1	1	1	-	B	318563-1	GUARD, CHIP, FRONT	16
							15
1	1	1	-	B	690462-1	HOLDER, SHEAR (REAR)	14
1	1	1	-	C	690463-1	SHEAR, FLOAT (REAR)	13
2	2	2	-	A	5-22280-0	SPRING, SHEAR	12
2	2	2	-	B	690461-1	STOP, SHEAR	11
1	1	1	-	C	690459-1	HOLDER, SHEAR (FRONT)	10
1	1	1	-	C	454276-1	SHEAR, FLOAT (FRONT)	9
1	1	1	-	C	904199-1	ANVIL	8
							7
1	1	1	-	A	690468-1	DEPRESSOR, SHEAR (REAR)	6
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	1-238011-9	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	461296-6	CRIMPER, INSULATION	3
1	1	1	-	C	2-455888-4	SPACER, CRIMPER	2
1	1	1	-	C	467681-4	CRIMPER, WIRE	1

QTY REQD PER ASSY — PARTS LIST

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

POST FEED 1 5/8 STROKE	PRE FEED 1 1/8 STROKE	PRE FEED 1 5/8 STROKE
ROTATED 180°	ROTATED 180°	ROTATED 180°
B	B	B
	K TERMINATOR	G TERMINATOR

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. POSITION FEED FINGER ON OUTSIDE EDGE OF FRONT STRIP GUIDE PLATE.

P	F	LTR	REVISION RECORD	APP	DATE
		A	RELEASED	CE	6-97

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

MATL - | HT TR - | FIN -

DR C.ERISMAN 21MAR97 | APP J.DODDS 25MAR97

CHK C.ERISMAN 25MAR97 | REL -

AMP — AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR | MACHINE REF MINI APPL

SCALE - | D | DWG NO 680446 | SHEET 1 OF 1 | REV A

LOC A | DIST 66 | LEADMAKER | BENCH MACHINE

AMP 3308 REV 3-92 | 02-JUN-97 | 14:27:14 amp14442

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