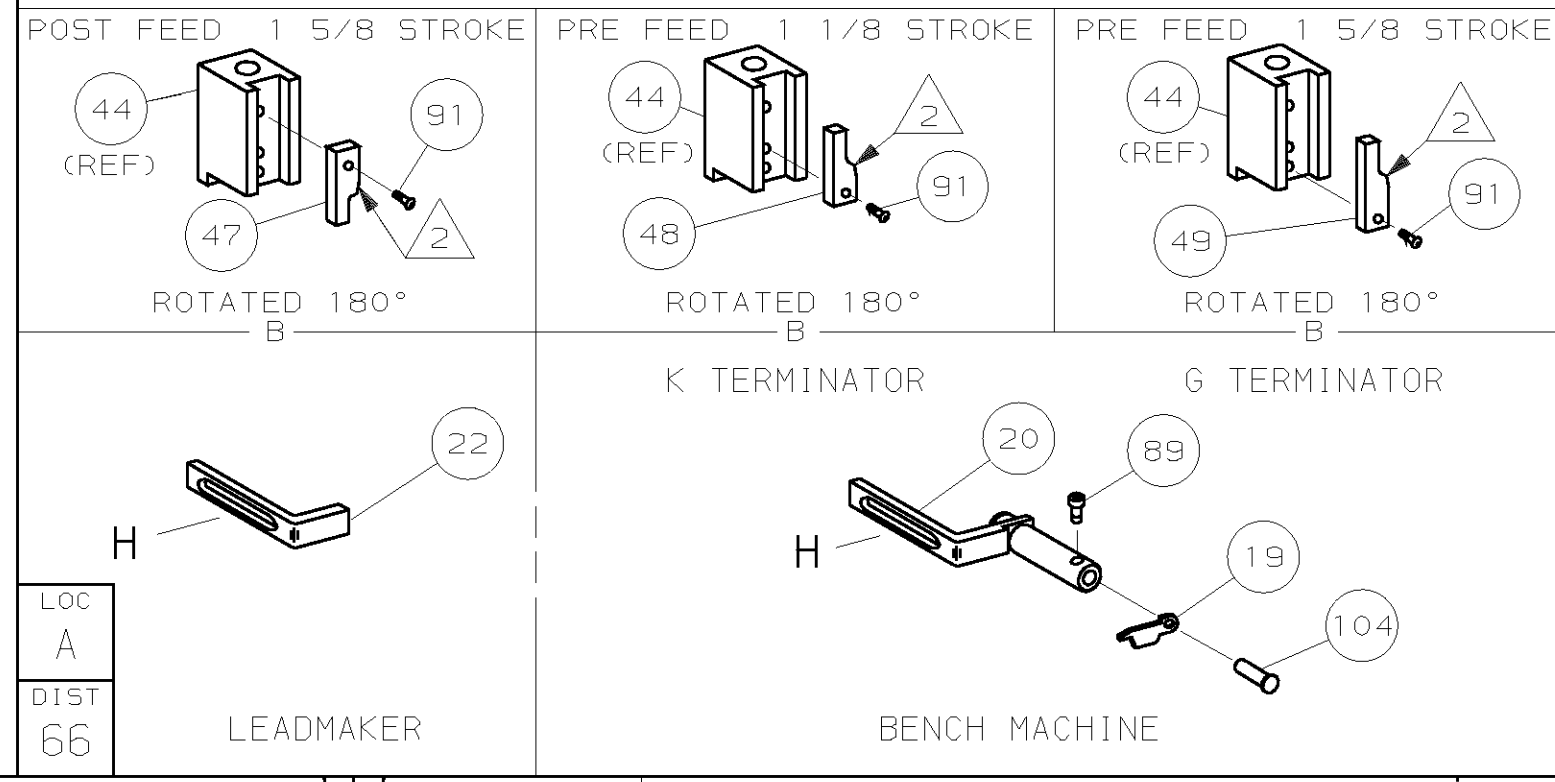
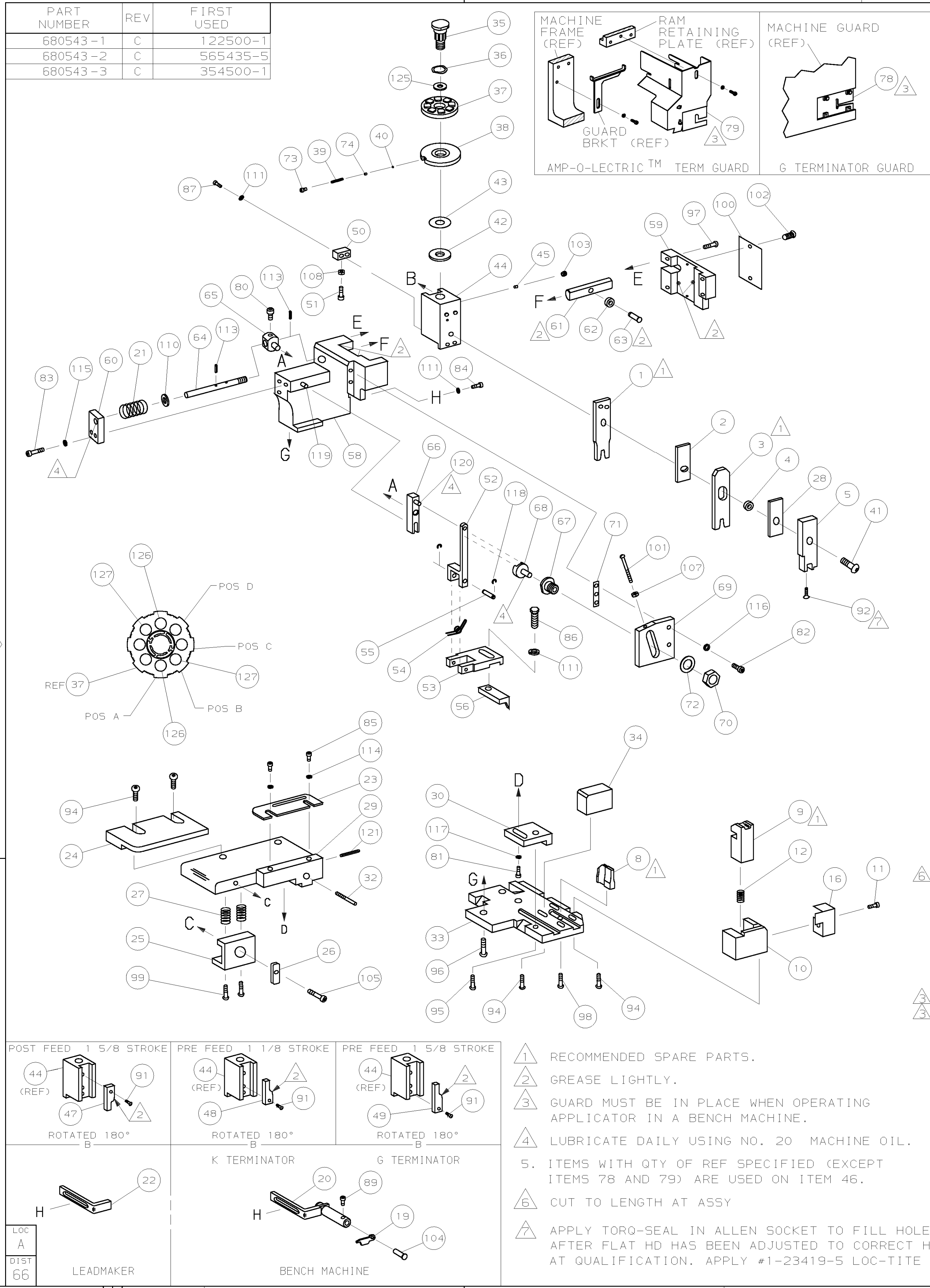


PART NUMBER	REV	FIRST USED
680543-1	C	122500-1
680543-2	C	565435-5
680543-3	C	354500-1



- 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.
- 5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
- 6 CUT TO LENGTH AT ASSY
- 7 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 8 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

TERMINAL NAME: BOX RECEPTACLE				CRIMP DATA PER AMP SPEC			
SEAL 286649				CRIMPING DATA			
SEAL	TERMINAL	PAD LTR	CRIMP HEIGHT	WIRE SIZE			
AMP 286648	MFG 12124598	A	.061 ±.002 [1.55 ±0.05mm]	18			
		B	.057 ±.002 [1.45 ±0.05mm]	20			
		C	NOT	USED			
		D	NOT	USED			
CRIMP	SIZE	TYPE	RANGE				
WIRE	.090 [2.29mm]	F	20-18				
INSUL	.220 [5.59mm]	0	-				
WIRE STRIP LENGTH .219-.250		TERM APPL SPEC NONE	FEED .691	APPL INSTRUCTION 408-8040	SET UP GAGE 458637-1	LAYOUT L2002	
PARTS LIST							ITEM NO
2	2	2	-	C	1-354779-6	PIN, WIRE DISC (.3070)B	127
2	2	2	-	C	354779-8	PIN, WIRE DISC (.3030)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
1	1	1	-	-			122
1	1	1	-	A	4-21028-0	PIN, SLT SPR(φ.093x.75)ST GDF PL	121
REF	REF	REF	-	A	1-21030-1	PIN, DOWEL(φ.187x.50)LEVER	120
REF	REF	REF	-	A	1-21030-6	PIN, DOWEL(φ.187x1.25)HOUSING	119
REF	REF	REF	-	A	21045-3	RING, RET "C"(φ.187)FD FING PIN	118
1	1	1	-	A	21024-5	WASHER, LOCK(#10)ADJ BLK	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(φ.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(φ5/16)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
1	1	1	-	A	22353-8	SCR, SHLD(φ.187x.25)DRAG LEVER	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
1	1	1	-	A	1-21003-9	SCR, FHC(6-32x.38)DEP	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	1-456406-1	SPACER	71
QTY REOD PER ASSY	QTY REOD PER ASSY	U/M	DWG SIZE	REV	PART NO	DESCRIPTION	ITEM NO
					PARTS LIST		
C1	ECN 0150-0299-04	TE	3-04				
C	0150-9584-99	TE	SEP99				
B	0150-8197-97	TB	12/97				
A	REVISED	CE	12/97				
P/F	LTR	REVISION RECORD	APP	DATE			

REV	QTY	U/M	DWG SIZE	REV	PART NO	DESCRIPTION	ITEM NO
-1						LEADMAKER	
-2						BENCH MODEL K	
-3						BENCH MODEL G	
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	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
1	1	1	-	B	690786-9	SUPPORT, TERMINAL	34
REF	REF	REF	-	D	455675-1	PLATE, BASE	33
1	1	1	-	A	690432-3	SCREW, ADJUSTMENT	32
							31
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	C	458144-1	PLATE, STRIP GUIDE	29
1	1	1	-	C	455888-8	SPACER, FRONT SHEAR DEP	28
2	2	2	-	A	1-22284-0	SPRING, DRAG	27
1	1	1	-	B	240793-1	LEVER, DRAG RELEASE	26
1	1	1	-	B	240792-1	DRAG, TERMINAL	25
1	1	1	-	D	7-690504-7	GUIDE, STRIP (REAR)	24
1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
-	-	1	-	B	690472-8	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	318707-2	SHEAR, FLOAT (FRONT)	9
1	1	1	-	C	1-662187-8	ANVIL	8
							7
							6
1	1	1	-	C	318701-1	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	238011-1	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	3-456135-4	CRIMPER, INSULATION	3
1	1	1	-	C	455888-8	SPACER, CRIMPER	2
1	1	1	-	C	1-456406-6	CRIMPER, WIRE	1
QTY REOD PER ASSY	QTY REOD PER ASSY	U/M	DWG SIZE	REV	PART NO	DESCRIPTION	ITEM NO
					PARTS LIST		
DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED:				MATL		HT TR	
2 PLG DEC ±				DR	200CT97	APP	200CT97
3 PLG DEC ±				C.ERISMAN		T.ELBIN	
4 PLG DEC ±				CHK 200CT97			
REL				C.ERISMAN			
ANGLE ±				AMP AMP Incorporated Harrisburg, PA 17105-3608			
SURF TEXTURE: ✓				NAME	SIDE FEED HDM APPLICATOR		MACHINE REF
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX				SCALE	D		MINI APPL
				SHEET	680543		REV
				CASE CODE	00779		1 OF 1
				REV	CUSTOMER AND ASSEMBLY DRAWING 1		C1
				RESTRICTED TO			