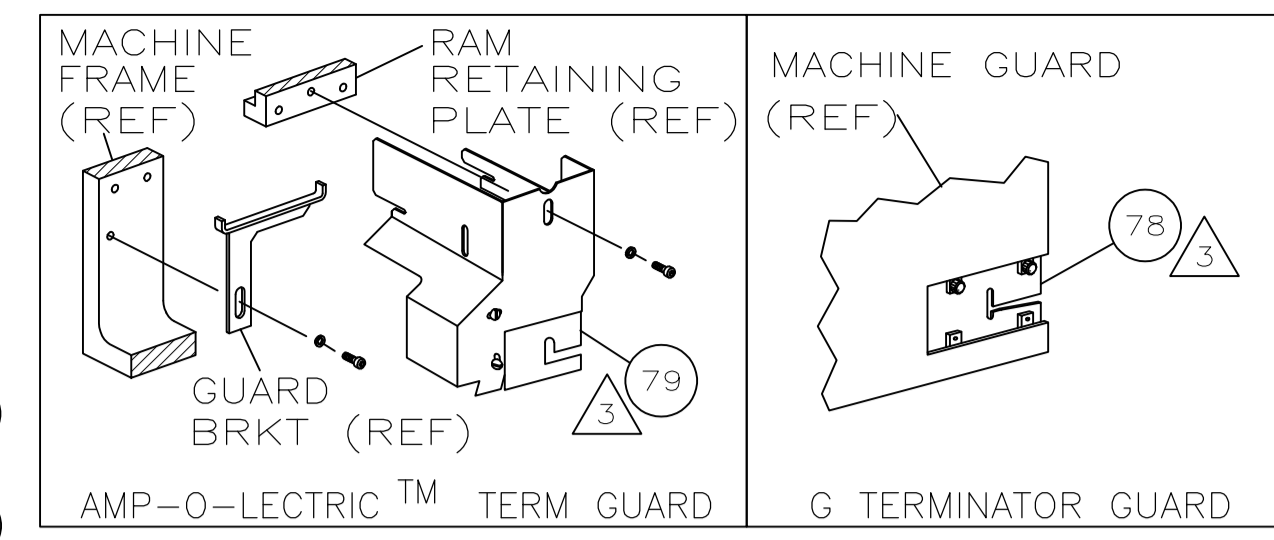


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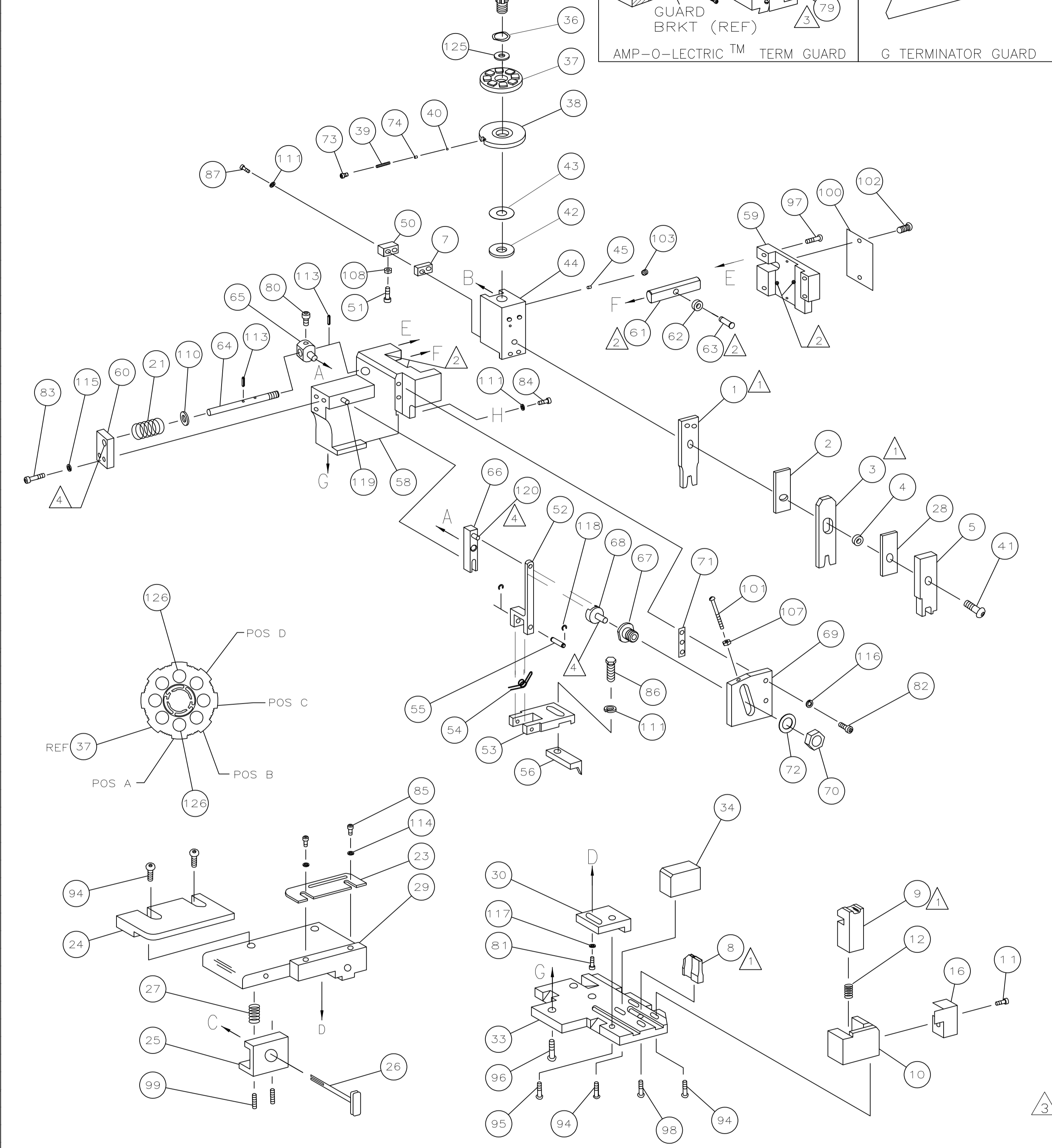
PART NUMBER	REV	FIRST USED
680874-1	E	122500-1
680874-2	E	565435-5
680874-3	E	354500-1



TERMINAL NAME: TERMINAL SOCKET		CRIMP DATA (NON-AMP TERMINAL-AMP SPEC)			
AMP	MFG	PAD LTR	CRIMP HEIGHT	WIRE SIZE	
286833	12084912	A	.053 ±.002 [1.34 ±.05mm]	18	
		B	NOT	USED	
		C	NOT	USED	
		D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE		
	.070 [1.78mm]	F	18		
WIRE	INSUL				
	.080 [2.03mm]	F	.080 MAX		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.1875-.219	NONE	.315	408-8040	458637-1	L2282

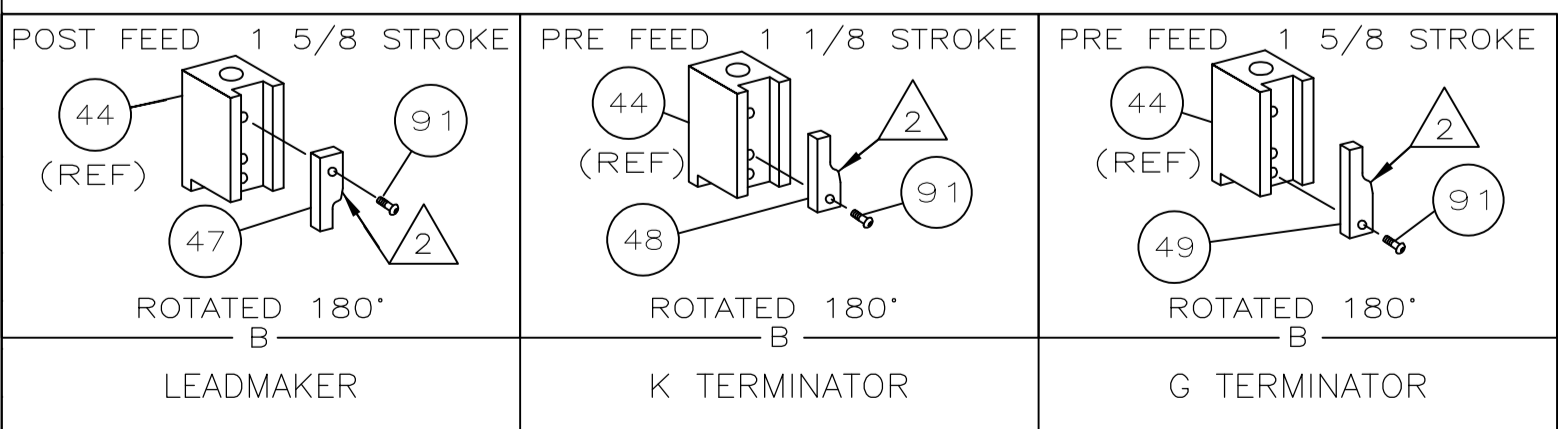
LOC	DIST	REVISIONS			
F	LTR	DESCRIPTION	DATE	BY	APPV
A	66	ECR-07-010264	5-2007	MY	TE

-1	LEADMAKER	MECH POST FEED
-2	BENCH MODEL K	MECH PRE FEED
-3	BENCH MODEL G	MECH PRE FEED

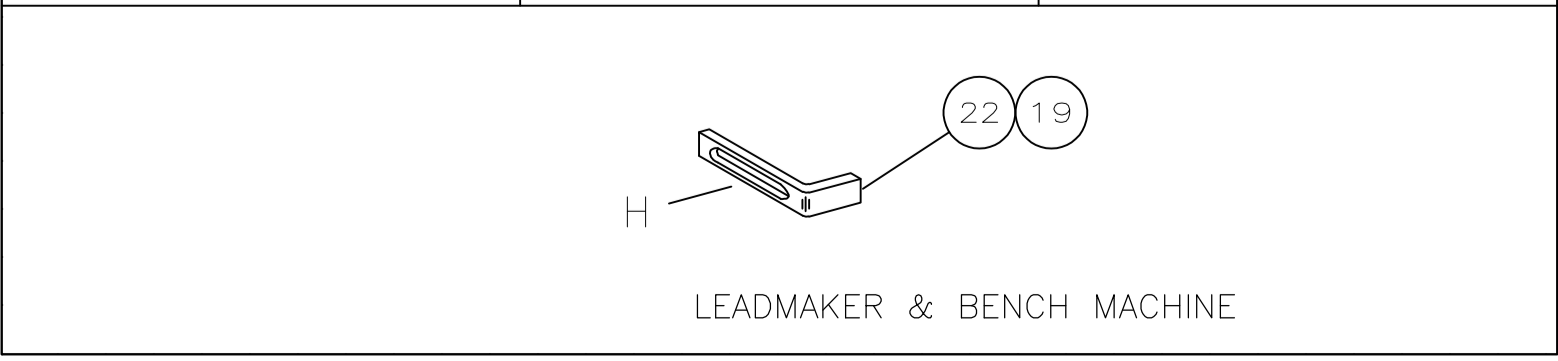


QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
2	2	2	-	2-354779-2	PIN, WIRE DISK ".3100"A	126
1	1	1	-	986950-1	WASHER, FLAT PRECISION	125
1	1	1	-	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	1	-	4088040	SF APPL INST 408-8040	123
REF	REF	REF	-	1-21030-1	PIN,DOWEL(Φ.187x.50)LEVER	122
REF	REF	REF	-	1-21030-6	PIN,DOWEL(Φ.187x1.25)HOUSING	121
REF	REF	REF	-	21045-3	RING,RET "C"(Φ.187)FD FING PIN	120
1	1	1	-	21024-5	WASHER, LOCK(#10)ADJ BLOCK	119
REF	REF	REF	-	21024-5	WASHER,LOCK(#10)ADJ PLATE	118
REF	REF	REF	-	21024-5	WASHER,LOCK(#10)FEED GDE ROD	117
2	2	2	-	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	116
REF	REF	REF	-	5-21028-1	PIN,SLT SPR(Φ.125x.50)ADJ ROD	115
4	4	4	-	21024-4	WASHER,LOCK(#8)STRIPPER	114
REF	REF	REF	-	21899-4	WASHER,FLAT(Φ5/16)SCREW ADJ	113
1	1	1	-	21018-5	NUT,HEX(NO.6)HOLDDOWN	112
REF	REF	REF	-	21068-5	NUT,HEX(6-32)FEED ADJ	111
1	1	1	-	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	110
2	2	2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE	109
REF	REF	REF	-	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	108
1	1	1	-	461264-1	PLATE, IDENTIFICATION	107
2	2	2	-	5-21006-6	SCR,SET(10-32x.75)DRAG	106
1	1	1	-	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	105
REF	REF	REF	-	2-21002-9	SCR,BHC(10-32x.75)CAP	104
REF	REF	REF	-	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	103
REF	REF	REF	-	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	102
6	6	6	-	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	101
1	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	100
2	2	2	-	2-21000-8	SCR,SHC(8-32x.63)	99
1	1	1	-	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	98
2	2	2	-	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	97
1	1	1	-	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	96
REF	REF	REF	-	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	95
REF	REF	REF	-	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	94
1	1	1	-	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	93
REF	REF	REF	-	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	92
-	REF	-	-	455749-1	GUARD, WINDOW	91
REF	-	-	-	679532-1	INSERT, GUARD	90
1	1	1	-	690603-1	SPRING, ASSIST	89
1	1	1	-	23030-1	SCR,SHC(6-32x.25 SL)INS DISC	88
REF	REF	REF	-	458109-1	WASHER, SPECIAL	87
REF	REF	REF	-	690517-1	SPACER	86
-3	-2	-1	U/M			85
						84
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QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
1	1	1	-	458537-2	PAWL, FEED	56
REF	REF	REF	-	240624-1	PIN, FEED FINGER	55
REF	REF	REF	-	691499-1	SPRING, FEED FINGER	54
REF	REF	REF	-	690541-1	HOLDER, FEED FINGER	53
REF	REF	REF	-	455679-1	LEVER, TERMINAL FEED ARM	52
1	1	1	-	811242-2	BUMPER, HOLDDOWN	51
1	1	1	-	690753-1	SPACER, TONKER	50
1	-	-	-	690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	1	-	-	690602-5	CAM, PRE-FEED 1 1/8 ST	48
-	-	1	-	690501-4	CAM, POST-FEED 1 5/8 ST	47
1	1	1	-	459456-1	APPLICATOR, BASIC (SUBASSY)	46
1	1	1	-	690191-1	PLUG, NYLON	45
1	1	1	-	455673-1	RAM	44
1	1	1	-	690125-1	WASHER, LAMINATED	43
1	1	1	-	690124-1	WASHER, RAM	42
1	1	1	-	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41
1	1	1	-	23241-6	BALL, STEEL	40
1	1	1	-	690170-1	SPRING, COMPRESSION	39
1	1	1	-	690142-1	DISC, INSULATION	38
1	1	1	-	354777-1	WIRE DISC, PLASTIC	37
1	1	1	-	22480-5	WASHER, SPRING	36
1	1	1	-	690212-1	POST, RAM	35
1	1	1	-	690786-1	SUPPORT, TERMINAL	34
REF	REF	REF	-	455675-1	PLATE, BASE	33
						32
						31
REF	REF	REF	-	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	318756-1	PLATE, STRIP GUIDE ASSY	29
1	1	1	-	2-455888-2	SPACER, FRONT SHEAR DEP	28
2	2	2	-	1-22284-0	SPRING, DRAG	27
1	1	1	-	690546-1	LEVER, DRAG RELEASE	26
1	1	1	-	240792-1	DRAG, TERMINAL	25
1	1	1	-	6-690504-0	GUIDE, STRIP (REAR)	24
1	1	1	-	690438-1	GUIDE, STRIP (FRONT)	23
-	-	1	-	690472-2	STRIPPER	22
REF	REF	REF	-	4-22284-9	SPRING, FEED RETURN	21
						20
1	1	-	-	691353-1	STRIPPER	19
						18
						17
1	1	1	-	318563-1	GUARD, CHIP, FRONT	16
						15
						14
						13
1	1	1	-	3-22280-3	SPRING, SHEAR	12
1	1	1	-	690461-1	STOP, SHEAR	11
1	1	1	-	690459-1	HOLDER, SHEAR (FRONT)	10
1	1	1	-	454276-1	SHEAR, FLOAT (FRONT)	9
1	1	1	-	2-662185-6	ANVIL	8
1	1	1	-	2-240641-4	SPACER, DEPRESSOR (REAR)	7
						6
1	1	1	-	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	2-238011-2	SPACER, BLOCK CRIMPER	4
1	1	1	-	5-456134-4	CRIMPER, INSULATION	3
1	1	1	-	1-455888-0	SPACER, CRIMPER	2
1	1	1	-	4-456404-3	CRIMPER, WIRE	1
-3	-2	-1	U/M			



- 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.



THIS DRAWING IS A CONTROLLED DOCUMENT.		DIN T.KINT 19AUG99	Tyco Electronics Corporation Harrisburg, PA 17105-3608	
DIMENSIONS: INCHES		APVD T.ELBIN 19AUG99	NAME SIDE FEED HDM APPLICATOR	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	SIZE CASE CODE DRAWING NO	
0 PLC ± .005		APPLICATION SPEC	RESTRICTED TO	
1 PLC ± .002		WEIGHT	A1 00779 680874	
2 PLC ± .001		CUSTOMER DRAWING	SCALE SHEET 1 of 1 REV E	
3 PLC ± .0005				
4 PLC ± .0002				
ANGLES ± .005				