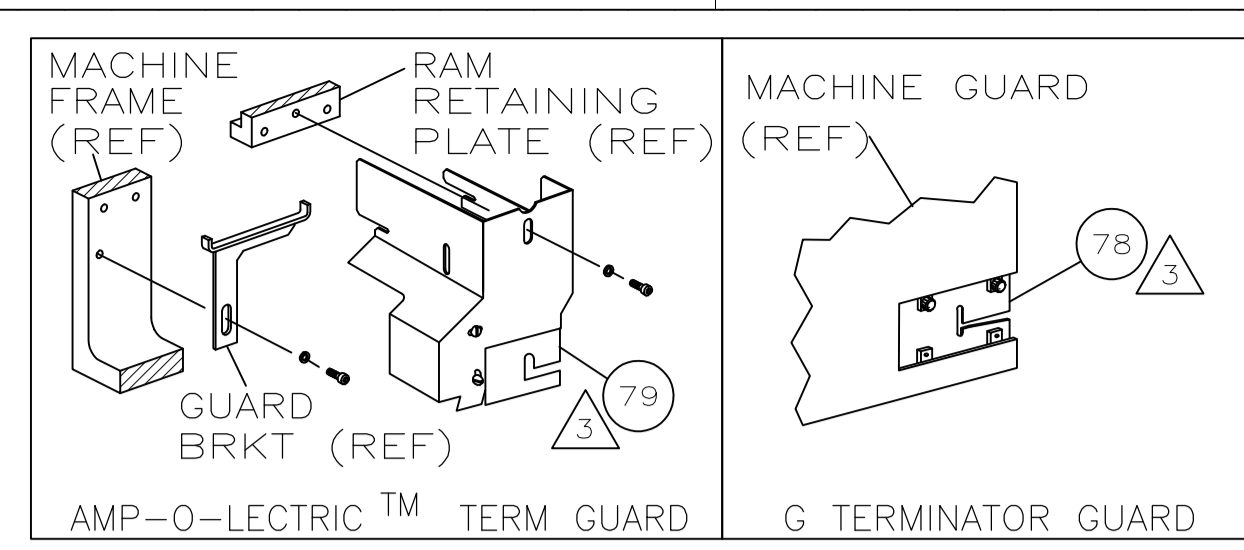


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PART NUMBER	REV	FIRST USED
680734-1	B	122500-1
680734-2	B	565435-5
680734-3	B	354500-1



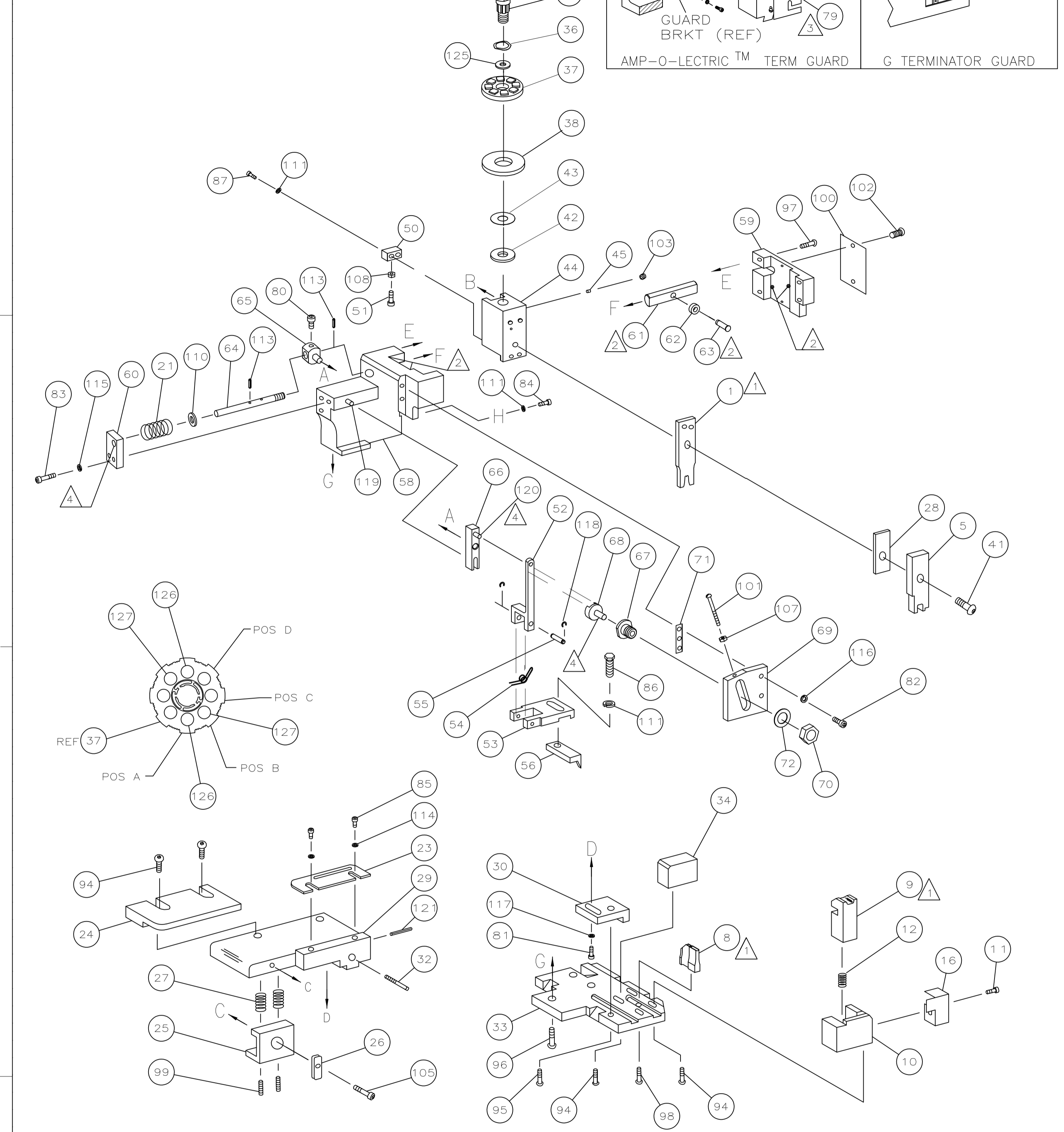
TERMINAL NAME: SOCKET & PIN

PIN	SOCKET	CRIMP DATA (NON-AMP TERMINAL-AMP SPEC)			
286768	286770	CRIMP HEIGHT			
		WIRE SIZE			
		A .054 ±.002 [1.37 ±.05mm] 18			
		B .058 ±.002 [1.47 ±.05mm] 16			
		C NOT USED			
		D NOT USED			
		CRIMP SIZE TYPE RANGE			
		WIRE .090 [2.29mm] F 16-18			
		INSUL - - -			
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.203-.234	NONE	.350	408-8040	458637-1	L2159

REV	DATE	BY	APPD
-1	5-2008	MY	GB

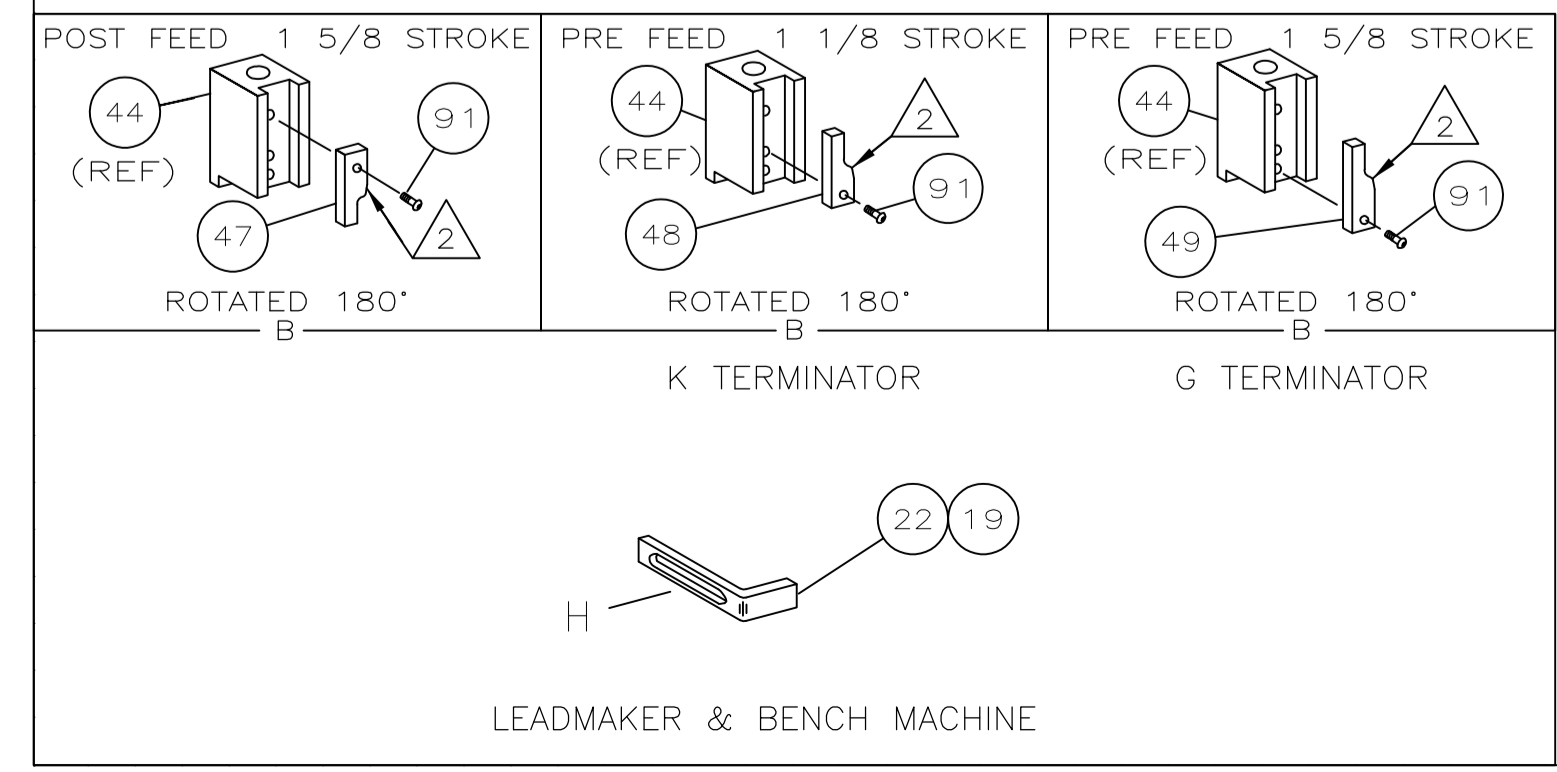
REVISIONS

REV	DESCRIPTION	DATE	BY	APPD
-1	LEADMAKER			
-2	BENCH MODEL K			
-3	BENCH MODEL G			



QTY	REF	P/N	DESCRIPTION	ITEM NO		
2	2	2	1-354779-4	PIN, WIRE DISC (.3060)B	127	
2	2	2	2-354779-3	PIN, WIRE DISC (.3105)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	
1	1	1	4-21028-0	PIN,SLT SPR(Ø.093x.75)ST GDE PL	122	
REF	REF	REF	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	120	
REF	REF	REF	1-21030-6	PIN,DOWEL(Ø.187x1.25)HOUSING	119	
REF	REF	REF	21045-3	RING,RET "C"(Ø.187)FD FING PIN	118	
1	1	1	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117	
REF	REF	REF	21024-5	WASHER,LOCK(#10)ADJ PLATE	116	
REF	REF	REF	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115	
2	2	2	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114	
REF	REF	REF	5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	113	
4	4	4	21024-4	WASHER,LOCK(#8)STRIPPER	111	
REF	REF	REF	21899-4	WASHER,FLAT(Ø5/16)SCREW ADJ	110	
REF	REF	REF	21018-5	NUT,HEX(NO. 6)HOLDDOWN	108	
1	1	1	21068-5	NUT,HEX(6-32)FEED ADJ	107	
1	1	1	22353-8	SCR,SHLD(Ø.187x.25)DRAG LEVER	105	
1	1	1	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103	
2	2	2	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102	
REF	REF	REF	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101	
1	1	1	461264-1	PLATE, IDENTIFICATION	100	
2	2	2	5-21006-6	SCR,SET(10-32x.75)DRAG	99	
1	1	1	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98	
REF	REF	REF	2-21002-9	SCR,BHC(10-32x.75)CAP	97	
REF	REF	REF	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96	
REF	REF	REF	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95	
4	4	4	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94	
1	1	1	1-21002-7	SCR,BHC(6-32x.38)CAM	91	
2	2	2	2-21002-7	SCR,BHC(8-32x.50)TERM H DWN	87	
1	1	1	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86	
2	2	2	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	85	
1	1	1	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84	
REF	REF	REF	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83	
REF	REF	REF	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	82	
1	1	1	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81	
REF	REF	REF	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	80	
-	REF	-	455749-1	GUARD, WINDOW	79	
REF	-	-	679532-1	INSERT, GUARD	78	
REF	REF	REF	458109-1	WASHER, SPECIAL	72	
REF	REF	REF	690517-1	SPACER	71	
-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
QTY	REQD	PER	ASSY			

QTY	REF	P/N	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	690223-2	SPACER, INSULATION DISC	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	690786-9	SUPPORT, TERMINAL	34	
REF	REF	REF	455675-1	PLATE, BASE	33	
1	1	1	690432-3	SCREW, ADJUSTMENT	32	
REF	REF	REF	455689-1	BLOCK, STRIP GUIDE ADJ	30	
1	1	1	3-458144-0	PLATE, STRIP GUIDE	29	
1	1	1	2-45888-2	SPACER, FRONT SHEAR DEP	28	
2	2	2	1-22284-0	SPRING, DRAG	27	
1	1	1	356835-1	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	
1	1	-	691353-1	STRIPPER	20	
1	1	1	318563-1	GUARD, CHIP, FRONT	16	
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	1-454276-9	SHEAR, FLOAT (FRONT)	9	
1	1	1	2-904132-8	ANVIL	8	
1	1	1	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5	
1	1	1	5-456406-4	CRIMPER, WIRE	1	
-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
QTY	REQD	PER	ASSY			



- 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.

THIS DRAWING IS A CONTROLLED DOCUMENT.

W. HOOVER 220CT98  
C. FERISMAN 220CT98  
J. ELBIN 220CT98

Tyco Electronics Corporation  
Harrisburg, PA 17105-3608

NAME: SIDE FEED HDM APPLICATOR

SIZE: A1  
CAGE CODE: 00779  
DRAWING NO: 680734

SCALE: - SHEET: 1 OF 1 REV: B