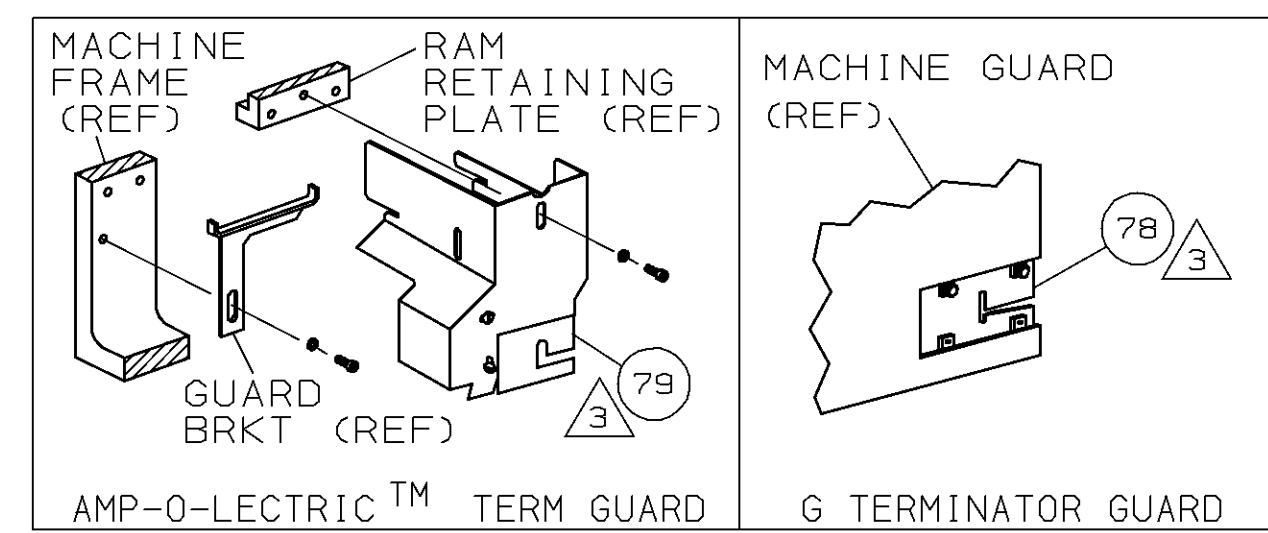


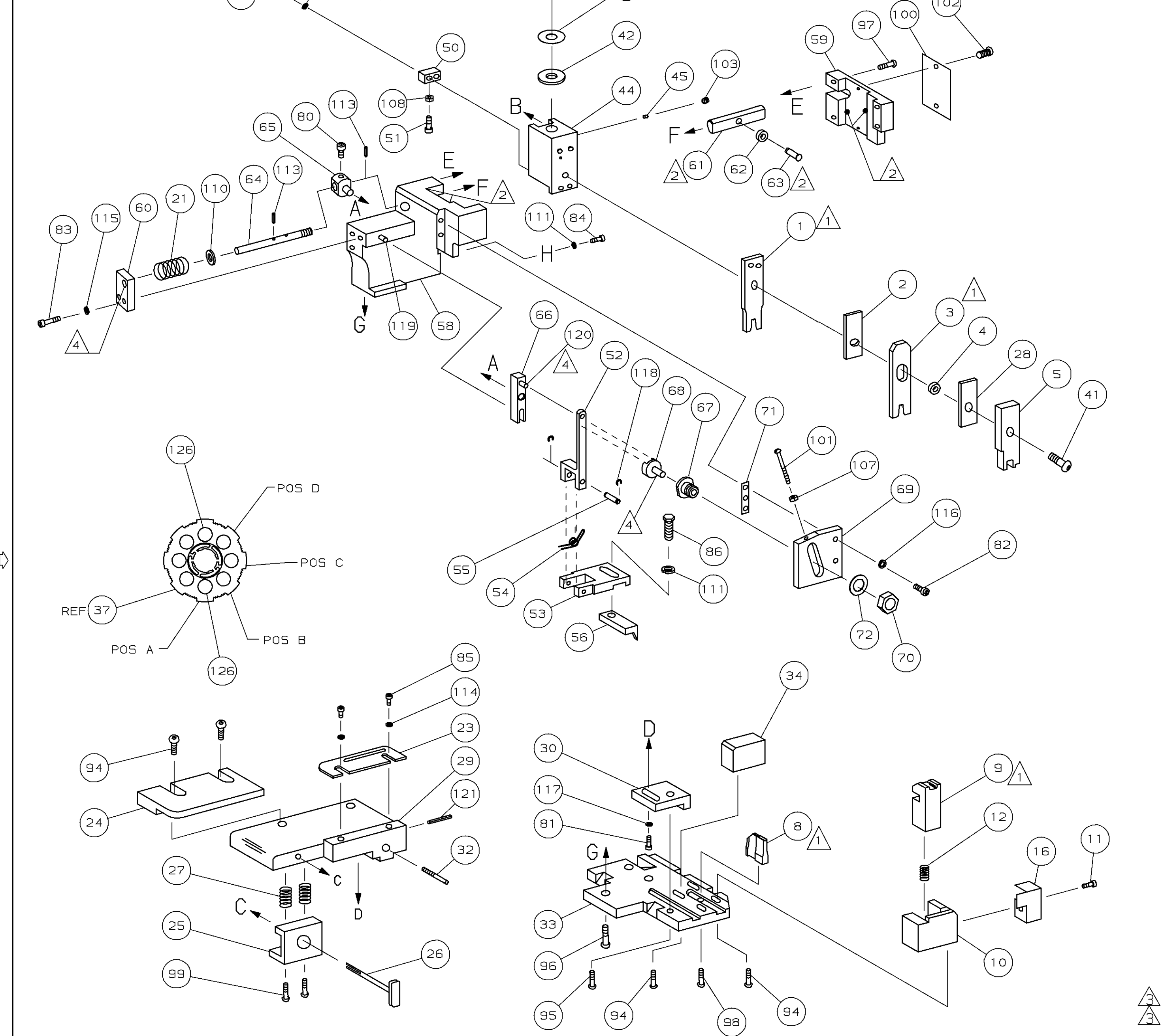
PART NUMBER	REV	FIRST USED
680480-1	A	122500-1
680480-2	A	565435-5
680480-3	A	354500-1



TERMINAL NAME: RECEPTACLE			
286591			
CRIMPING DATA			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.067 ±.002 [1.70 ±0.05mm]	14	
B	NOT	USED	
C	NOT	USED	
D	NOT	USED	
CRIMP SIZE TYPE RANGE			
WIRE	.130 [3.30mm]	F	14
INSUL	.160 [4.06mm]	F	.106-.157
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
.203-.234	NONE	.571	408-8040
SET UP GAGE	LAYOUT		
458637-1	L1940		

LEADMAKER			MECH POST FEED				
BENCH MODEL K			MECH PRE FEED				
BENCH MODEL G			MECH PRE FEED				
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	690786-1	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	455671-1	PLATE, STRIP GUIDE	29
1	1	1	-	C	2-455888-1	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	6-690504-9	GUIDE, STRIP (REAR)	24
1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
-	-	1	-	B	690472-2	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	690461-1	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	662191-1	ANVIL	8
							7
							6
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	238011-4	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	7-456134-5	CRIMPER, INSULATION	3
1	1	1	-	C	1-455888-1	SPACER, CRIMPER	2
1	1	1	-	C	456410-1	CRIMPER, WIRE	1
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)							

THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INCORPORATED. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.



POST FEED 1 5/8 STROKE

ROTATED 180°

PRE FEED 1 1/8 STROKE

ROTATED 180°

PRE FEED 1 5/8 STROKE

ROTATED 180°

K TERMINATOR

G TERMINATOR

LOC A

DIST 66

LEADMAKER

BENCH MACHINE

- 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.

QTY REQD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
1			992031-1	PIN, CLEVIS	104
1			21009-2	SCR, SKT SET (1/4-20x.25 LW) RAM	103
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			461264-1	PLATE, IDENTIFICATION	100
2			3-21002-0	SCR, BHC (10-32x.88) DRAG	99
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
6			2-21002-2	SCR, BHC (8-32x.50) TERM H DWN	94
					93
					92
1			1-21002-7	SCR, BHC (6-32x.38) CAM	91
					90
1			7-21000-9	SCR, SHC (4-40x.19) STRIPPER	89
					88
					87
1			2-22603-0	SCR, HEX HD (8-32x.31) FEED FINGER	86
2			1-21000-3	SCR, SHC (4-40x.25) F ST GUIDE	85
3			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			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
					77
					76
					75
1			690603-1	SPRING, ASSIST	74
1			23030-1	SCR, SHC (6-32x.25 SL) INS DISC	73
REF	REF	REF	458109-1	WASHER, SPECIAL	72
REF	REF	REF	690517-1	SPACER	71
-3	-2	-1	U/M	DWG SIZE	PART NO
PARTS LIST					

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED.

DR L. COLLINS 26JUN97 APP J. HIRNEISEN 26JUN97

CHK 26JUN97 REL C. ERISMAN 26JUN97

NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL

SCALE 1 OF 1 SHEET REV A

DWG NO 680480

REMOVE BURRS, BREAK SHARP EDGES R.015 MAX