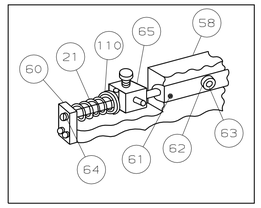
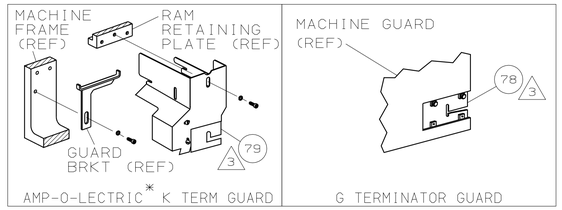
DRAWING MADE IN THIRD ANGLE PROJECTION

/home/amp16926/DMTECmod

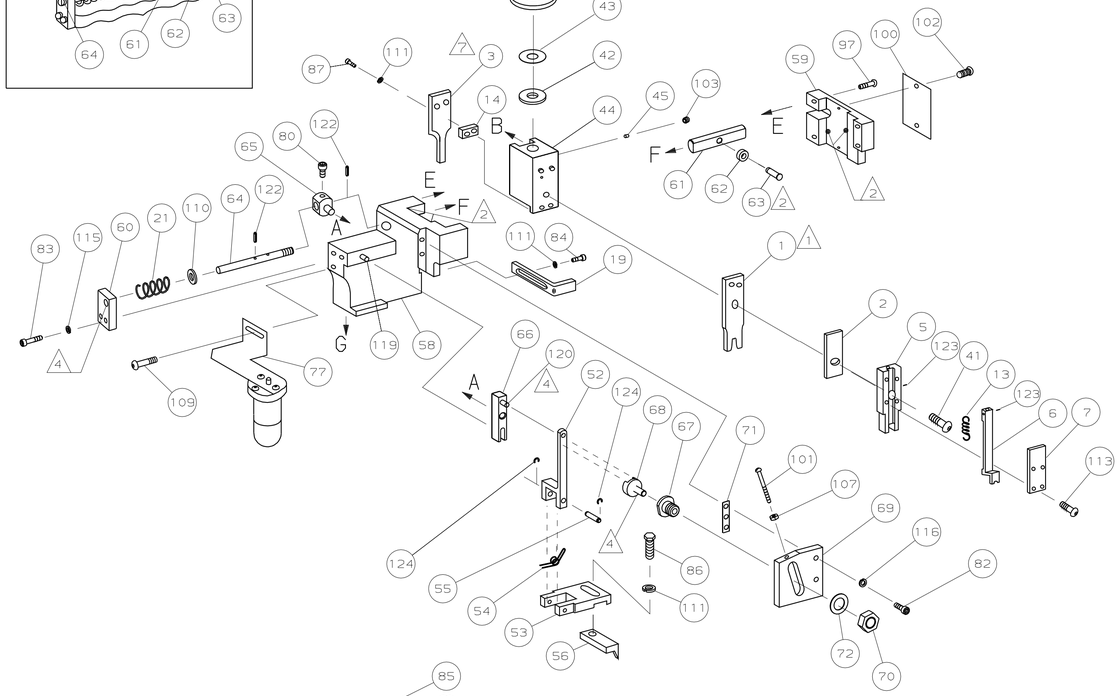
PART NUMBER	REV	FIRST USED
~~680069-1~~	A	~~854400-1~~ — OBS NOT RELEASED
680069-2	B	565435-5
680069-3	A	354500-1

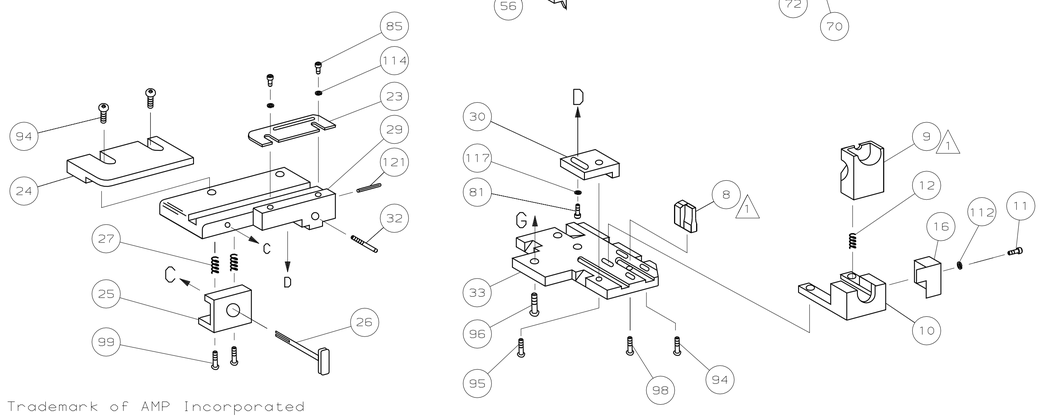




TERMINAL NAME: CONTACT, PLUG	
	414713
TERM APPL SPEC	–

CRIMPING DATA			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.029 ±.002	28	
B	NOT	USED	
C	NOT	USED	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.042	F	–
INSUL	–	–	–
FEED .270	APPL INST 408-8040	SET UP GAGE 458637-1	LAYOUT L1562
WIRE STRIP LENGTH	–		





								129
								128
								127
								126
								125
REF	REF	REF	–	A	21045-3	RING,RET "C"(ø.187)FD FING PIN		124
2	2	2	–	A	21028-5	PIN,SLT SPR(ø.062x.43)DEP		123
REF	REF	REF	–	A	5-21028-1	PIN,SLT SPR(ø.125x.50)ADJ ROD		122
1	1	1	–	A	4-21028-0	PIN,SLT SPR(ø.093x.75)ST GDE PL		121
REF	REF	REF	–	A	1-21030-1	PIN,DOWEL(ø.187x.50)LEVER		120
REF	REF	REF	–	A	1-21030-6	PIN,DOWEL(ø.187x1.25)HOUSING		119
								118
1	1	1	–	A	21024-5	WASHER, LOCK(#10)ADJ BLOCK		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
4	4	4	–	A	1-21003-9	SCR,FH(6-32X.38) DEPRESSOR		113
1	1	1	–	A	21024-3	WASHER,LOCK(#6)SHEAR STOP		112
4	4	4	–	A	21024-4	WASHER,LOCK(#8)STRIPPER		111
REF	REF	REF	–	A	21899-4	WASHER,FLAT(ø5/16)SCREW ADJ		110
–	1	–	–	A	2-21002-6	SCR,BHC(10-32x.38)LUBE ASSY		109
								108
REF	REF	REF	–	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
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
4	4	4	–	A	2-21002-2	SCR,BHC(8-32x.50)SHEAR		94
								93
								92
1	1	1	–	A	1-21002-7	SCR,BHC(6-32x.38)CAM		91
								90
								89
								88
2	2	2	–	A	2-21000-7	SCR,SHC(8-32X.45)RETAINER		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
–	1	–	–	D	1-455755-2	GUARD ASSY		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) DISC		73
REF	REF	REF	–	A	458109-1	WASHER, SPECIAL		72
REF	REF	REF	–	A	690517-1	SPACER		71
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION		ITEM NO
QTY REQD PER ASSY					← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)	PARTS LIST		

-1	LEADMAKER				MECH POST FEED	OBSOLETE		
-2	BENCH MODEL K				MECH PRE FEED			
-3	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	690542-2	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	455679-1	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
1	1	1	–	B	459456-1	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	–	A	690223-1	SPACER, INSULATION DISC		38
1	1	1	–	D	4-690141-1	DISC, WIRE		37
1	1	1	–	A	22480-5	WASHER, SPRING		36
1	1	1	–	B	690212-1	POST, RAM		35
								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	455671-8	PLATE, STRIP GUIDE		29
								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	90765-9	GUIDE, STRIP (REAR)		24
1	1	1	–	A	690438-1	GUIDE, STRIP (FRONT)		23
								22
REF	REF	REF	–	A	4-22284-9	SPRING, FEED RETURN		21
								20
1	1	–	–	B	690472-2	STRIPPER		19
								18
								17
1	1	1	–	B	691667-1	GUARD, CHIP (FRONT)		16
								15
1	1	1	–	C	5-240641-8	SPACER		14
1	1	1	–	A	1-22286-5	SPRING, EXT		13
1	1	1	–	A	1-23470-0	SPRING, SHEAR		12
1	1	1	–	B	1-690461-4	STOP, SHEAR		11
1	1	1	–	C	122536-1	HOLDER, SHEAR (FRONT)		10
1	1	1	–	C	122537-1	SHEAR, FLOAT (FRONT)		9
1	1	1	–	C	122535-1	ANVIL		8
1	1	1	–	B	122543-1	PLATE, COVER		7
1	1	1	–	B	122542-1	INSERT, DEPRESSOR		6
1	1	1	–	C	122538-1	DEPRESSOR, SHEAR (FRONT)		5
								4
1	1	1	–	B	122947-1	RETAINER,PRODUCT		3
1	1	1	–	C	1-455888-0	SPACER, CRIMPER		2
1	1	1	–	C	2-456401-1	CRIMPER, WIRE		1
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION		ITEM NO
QTY REQD PER ASSY					← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)	PARTS LIST		

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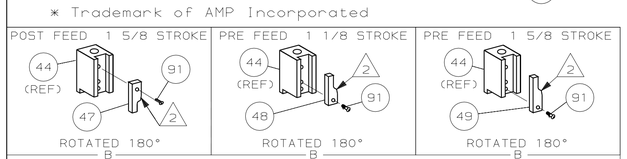

1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
4. LUBRICATE DAILY USING NO. 20 MACHINE OIL.
5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
6. CUT TO LENGTH AT ASSY
7. MAY BE GROUND AT ASSEMBLY TO GIVE ACCEPTABLE HOLD DOWN.

P	F	LTR	REVISION RECORD	APP	DATE
		B1	ECN 0150-0311-02	TE	3-02
		B	0150-6655-96	CE	2-96
		A1	OBSOLETE -1	TB	12-94
		A	ECN 0150-5465-94	CE	5-94

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

MATL –		HT TR –	FIN –
DR P.MATHIAS	3/21/94	APP B.WOLFE	3-23-94
CHK C.ERISMAN	3-23-94	REL B. MORGAN	4/4/94

AMP Incorporated, Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR — MACHINE REF MINI APPL
SCALE – — D — DWG NO 680069 — SHEET 1 OF 1 — REV B1

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