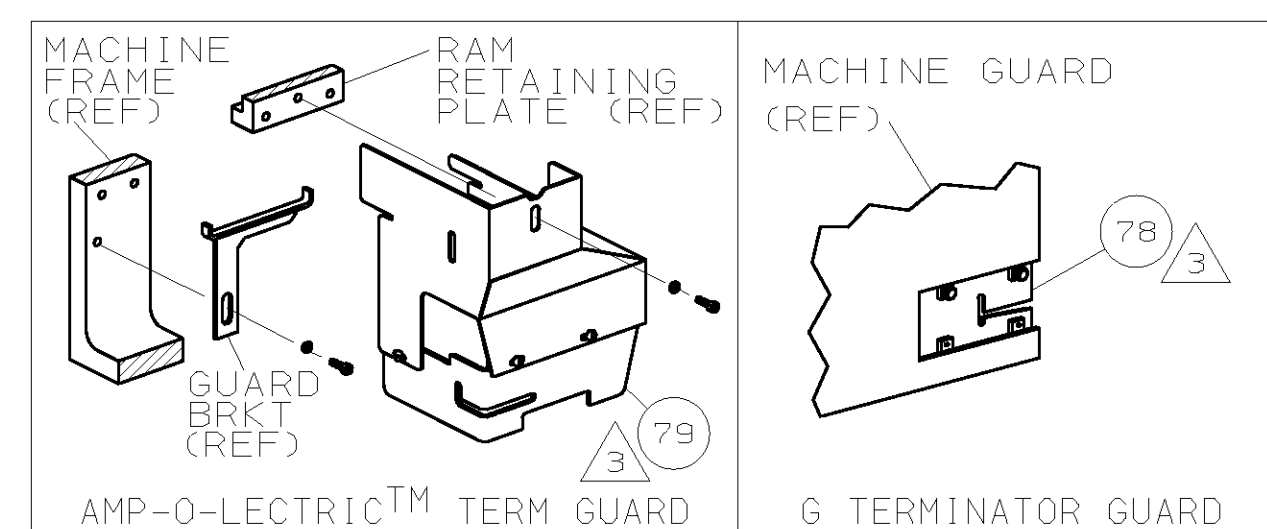


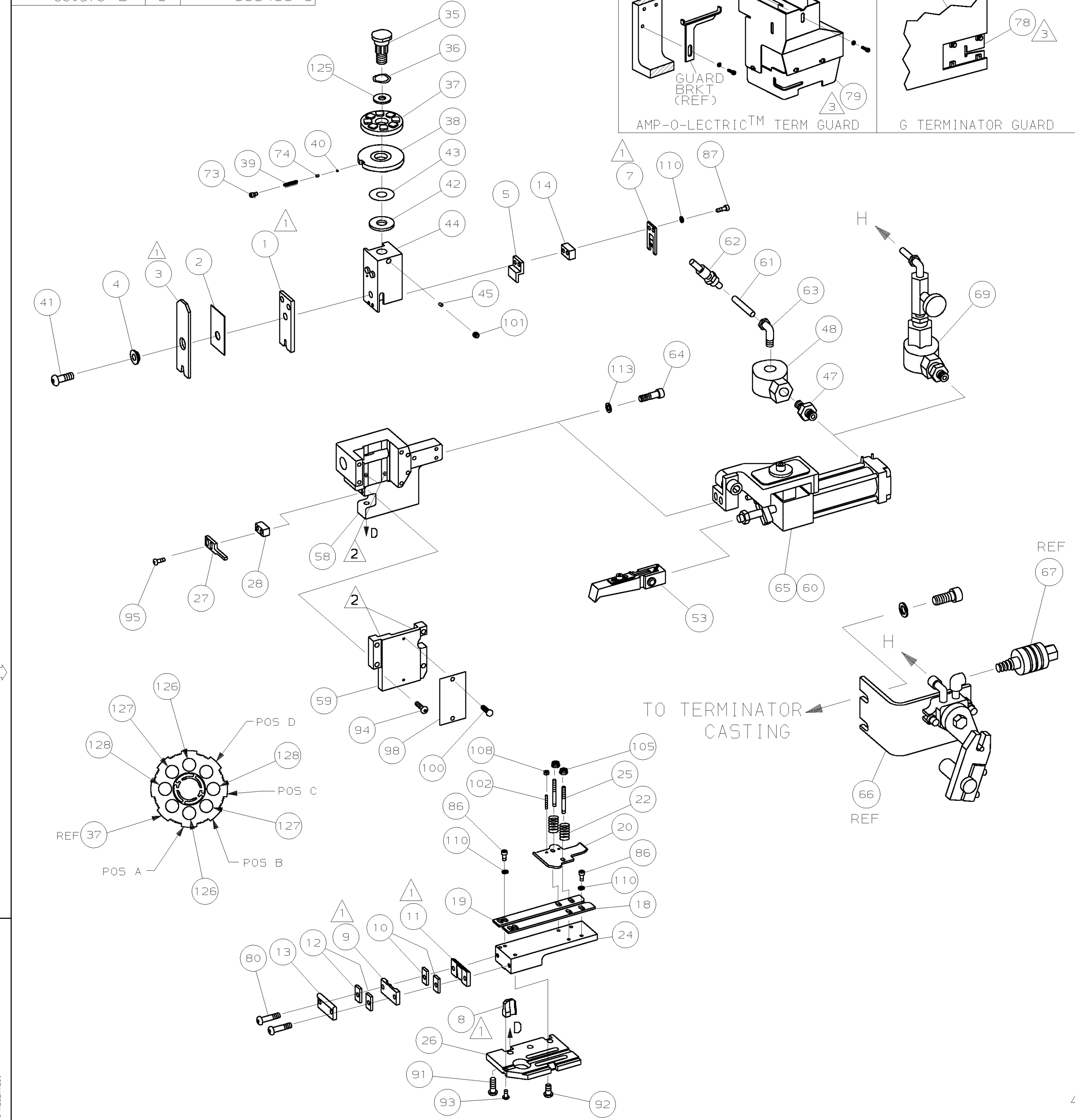
PART NUMBER	REV	FIRST USED
680576-1	D	122500-1
680576-2	D	565435-5



TERMINAL NAME: RING		CRIMPING DATA		
PAD LTR	CRIMP HEIGHT	WIRE SIZE		
A	.062 ±.002 [1.57 ±0.05mm]	16		
B	.056 ±.002 [1.42 ±0.05mm]	18		
C	.052 ±.002 [1.32 ±0.05mm]	20		
D	NOT USED	USED		
CRIMP	SIZE	TYPE	RANGE	
WIRE	.110 [2.79mm]	F	20-16	
INSUL	.140 [3.56mm]	0	.080-.120	

QTY	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-1				LEADMAKER & BENCH MODEL G	AIR FEED	
-2				BENCH MODEL K	AIR FEED	

QTY	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
1				692655-5	AIR FEED VALVE ASSY	70
REF				24042-2	VALVE, SHUT OFF	68
REF				692655-6	AIR FEED VALVE ASSY	66
1	1			1-460277-9	AIR FEED ASSY (2 INCH)	65
2	2			3-21000-9	SCR,SHC (10-32x1.00)AIR ASSY	64
-	1			980285-2	ELBOW, SWIVEL 1/8 NPT - 1/4 T	63
-	1			23238-1	QUICK DISCONNECT	62
-	12.00	IN		27319-4	TUBING, POLY-FLO Ø.25	61
1				1-460277-5	AIR FEED ASSY	60
1	1			454220-1	CAP, RAM	59
1	1			453736-1	HOUSING	58
						57
						56
						55
						54
1	1			460680-1	FEED FINGER ASSY	53
						52
						51
						50
						49
-	1			22374-7	VALVE, QUICK EXHAUST	48
-	1			22304-1	NIPPLE, HEX 1/8 NPT	47
						46
1	1			690191-1	PLUG, NYLON	45
1	1			455674-1	RAM	44
1	1			690125-1	WASHER, LAMINATED	43
1	1			690124-1	WASHER, RAM	42
1	1			7-21002-9	BOLT, CRIMPER (5/16-24x1.00)	41
1	1			23241-6	BALL, STEEL	40
1	1			690170-1	SPRING, COMPRESSION	39
1	1			690142-1	DISC, INSULATION	38
1	1			354777-1	WIRE DISC, PLASTIC	37
1	1			22480-5	WASHER, SPRING	36
1	1			690212-1	POST, RAM	35
						34
						33
						32
						31
						30
						29
1	1			2-690451-4	SPACER, STRIPPER	28
1	1			240639-4	STRIPPER	27
1	1			455676-1	PLATE, BASE	26
2	2			22354-8	DRAG, STUD	25
1	1			1-455678-6	PLATE, STRIP GUIDE	24
						23
2	2			4-22281-1	SPRING, DRAG	22
						21
1	1			462925-1	DRAG, STOCK	20
1	1			458030-9	GUIDE, STRIP (REAR)	19
1	1			458031-9	GUIDE, STRIP (FRONT)	18
						17
						16
						15
1	1			7-240641-5	SPACER, SLUG BLADE	14
1	1			683661-4	PLATE, BEND	13
2	2			240645-3	SPACER, SHEAR PLATE	12
1	1			1-240644-8	PLATE, REAR SHEAR	11
2	2			1-240645-0	SPACER, SHEAR PLATE	10
1	1			2-240642-0	PLATE, FRONT SHEAR	9
1	1			2-240655-7	ANVIL	8
1	1			7-240651-6	BLADE, SLUG	7
						6
1	1			468430-3	TOOL, BENDING	5
1	1			238009-1	SPACER, BLOCK CRIMPER	4
1	1			456135-6	CRIMPER, INSULATION	3
1	1			455888-9	SPACER, CRIMPER	2
1	1			456408-6	CRIMPER, WIRE	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 32.
- 6 ITEM 78 USED WITH G TERMINATOR ONLY.
- 7 THIS APPLICATOR BENDS TERMINAL UP 80°±5°

QTY	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	2			4-354779-2	PIN, WIRE DISC (.3200)C	129
2	2			3-354779-1	PIN, WIRE DISC (.3145)B	127
2	2			1-354779-6	PIN, WIRE DISC (.3070)A	126
1	1			986950-1	WASHER, FLAT PRECISION	125
1	1			217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1			4088039	EF APPL INST 408-8039	123
						122
						121
						120
						119
						118
						117
						116
						115
						114
2	2			21024-5	WASHER, LOCK (#10)AIR ASSY	113
						112
4	4			21024-4	WASHER, LOCK (NO.8)SHEAR BL	110
						109
2	2			21018-4	NUT, HEX (4-40)DRAG	108
						107
						106
2	2			21022-2	NUT, HEX 5L (8-32)DRAG STUD	105
						104
						103
2	2			2-21006-6	SCR,SKT SET (4-40x.62)DRAG	102
1	1			21009-2	SCR,SKT SET (1/4-20x.25)RAM	101
2	2			21017-2	SCR,DRIVE (#2x.19) ID PLATE	100
						99
1	1			461264-1	PLATE, IDENTIFICATION	98
						97
						96
2	2			2-21002-2	SCR,BHC (8-32x.50)STRIPPER	95
4	4			2-21002-9	SCR,BHC (10-32x.75)CAP	94
1	1			22733-8	SCR,BHC (8-32x.38 LW)ANVIL	93
4	4			3-21002-3	SCR,BHC (1/4-20x.50)ST 6D PL	92
3	3			2-22733-8	SCR,BHC (1/4-20x.62)H5G	91
						90
						89
						88
2	2			2-21000-9	SCR,SHC (8-32x.75)SLUG BLADE	87
4	4			7-21000-4	SCR,SHC (8-32x.31)STRIP GUIDE	86
						85
						84
						83
						82
						81
2	2			3-21002-1	SCR,BHC (10-32x1.00)SHEAR PL	80
1				455750-7	GUARD ASSY	79
-	REF			679532-1	INSERT, GUARD	78
						77
						76
						75
1	1			690603-1	SPRING, ASSIST	74
1	1			23030-1	SCR,SKT CAP (6-32x.25)CP DSC	73
						72
						71

QTY	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-2	-1					

QTY	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-2	-1					

LOC A
DIST 66

REVISION RECORD

REV	DATE	DESCRIPTION
D	ECN 0150-0356-03	TE 4-03
C	0150-0683-01	TE 7-01
B	0150-8547-98	TB 6-98
A	REVISED	CE 3-98

REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

DR 19JAN98 APP 20JAN98
R.O.WILSON T.ELBIN
CHK 20JAN98 REL -
C. ERISMAN

AMP Incorporated
Harrisburg, PA 17105-3608

NAME END FEED HDM APPLICATOR MACHINE REF
SCALE - DWG NO 680576 SHEET 1 OF 1 REV 0

CUSTOMER AND ASSEMBLY DRAWING