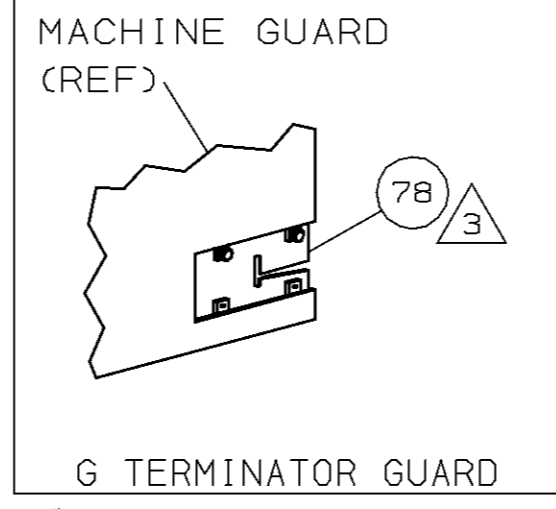
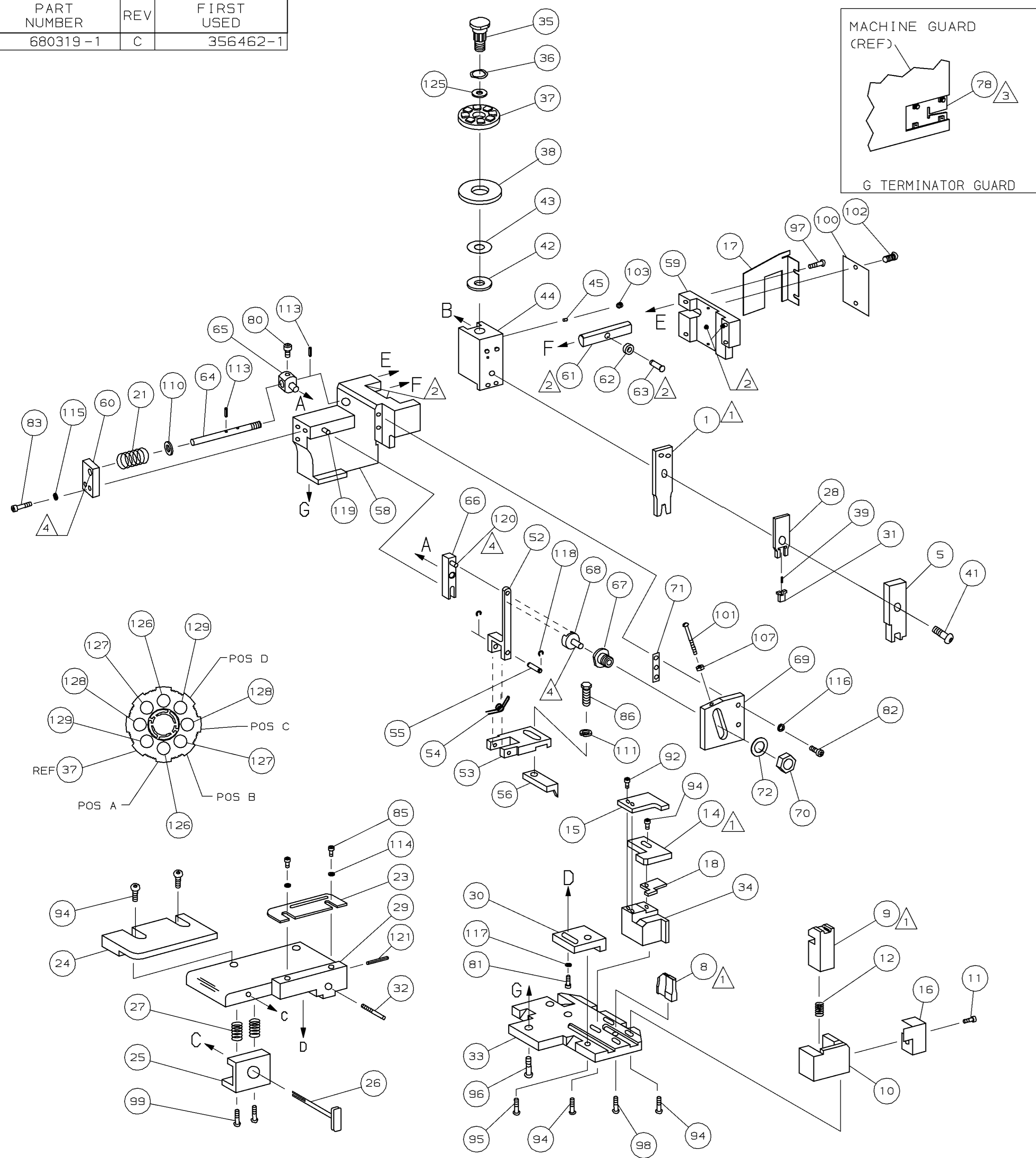


| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------|
| 680319-1    | C   | 356462-1   |

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.



| PAD LTR |                              | CRIMP HEIGHT               |               | WIRE SIZE |  |
|---------|------------------------------|----------------------------|---------------|-----------|--|
| A       | .072 ± 0.002 [1.83 ± 0.05mm] | 4400-5000 (1)178 (1)16 1/2 |               |           |  |
| B       | .067 ± 0.002 [1.70 ± 0.05mm] | 3400-4200 (14)             |               |           |  |
| C       | .062 ± 0.002 [1.57 ± 0.05mm] | 2400-3200 (16)             |               |           |  |
| D       | .057 ± 0.002 [1.45 ± 0.05mm] | 1400-2200 (18)             |               |           |  |
| CRIMP   | SIZE                         | TYPE                       | RANGE         |           |  |
| WIRE    | .110 [2.79mm]                | F                          | 1400-5000 CMA |           |  |
| INSUL   | -                            | -                          | -             |           |  |

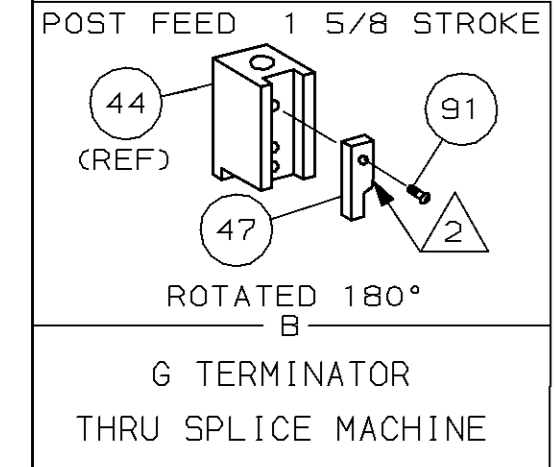
  

| WIRE STRIP LENGTH | TERM APPL | SPEC | FEED | APPL INSTRUCTION | SET UP GAGE | LAYOUT |
|-------------------|-----------|------|------|------------------|-------------|--------|
| -                 | 114-2145  |      | .500 | 408-8040         | 458637-1    | L1672  |

| QTY | REF | U/M      | DWG SIZE | PART NO    | DESCRIPTION                        | ITEM NO |
|-----|-----|----------|----------|------------|------------------------------------|---------|
| 2   | -   | C        |          | 1-354779-6 | PIN, WIRE DISC (.3070)D            | 129     |
| 2   | -   | C        |          | 354779-8   | PIN, WIRE DISC (.3030)C            | 128     |
| 2   | -   | C        |          | 354779-1   | PIN, WIRE DISC (.2995)B            | 127     |
| 2   | -   | C        |          | 8-354778-6 | PIN, WIRE DISC (.2925)A            | 126     |
| 1   | -   | A        |          | 986950-1   | WASHER, FLAT PRECISION             | 125     |
| 1   | -   | A        |          | 217238-1   | GENERAL INSTRUCTION PACKAGE        | 124     |
| 1   | -   | -        |          | 4088040    | SF APPL INST 408-8040              | 123     |
|     |     |          |          |            |                                    | 122     |
| 1   | -   | A        |          | 4-21028-0  | PIN, SLT SPR (Ø.093x.75)ST GDE PL  | 121     |
| 1   | -   | A        |          | 1-21030-1  | PIN, DOWEL (Ø.187x.50) LEVER       | 120     |
| 1   | -   | A        |          | 1-21030-6  | PIN, DOWEL (Ø.187x1.25) HOUSING    | 119     |
| 2   | -   | A        |          | 21045-3    | RING, RET "C" (Ø.187) FD FING PIN  | 118     |
| 1   | -   | A        |          | 21024-5    | WASHER, LOCK (#10) ADJ BLOCK       | 117     |
| 2   | -   | A        |          | 21024-5    | WASHER, LOCK (#10) ADJ PLATE       | 116     |
| 2   | -   | A        |          | 21024-5    | WASHER, LOCK (#10) FEED GDE ROD    | 115     |
| 2   | -   | A        |          | 21024-2    | WASHER, LOCK (#4) FRONT STP GUIDE  | 114     |
| 2   | -   | A        |          | 5-21028-1  | PIN, SLT SPR (Ø.125x.50) ADJ ROD   | 113     |
|     |     |          |          |            |                                    | 112     |
| 1   | -   | A        |          | 21024-4    | WASHER, LOCK (#8) STRIPPER         | 111     |
| 1   | -   | A        |          | 21899-4    | WASHER, FLAT (Ø5/16) SCREW ADJ     | 110     |
|     |     |          |          |            |                                    | 109     |
| 1   | -   | A        |          | 21018-5    | NUT, HEX (NO. 6) HOLDDOWN          | 108     |
| 1   | -   | A        |          | 21018-5    | NUT, HEX (6-32) FEED ADJ           | 107     |
|     |     |          |          |            |                                    | 106     |
|     |     |          |          |            |                                    | 105     |
| 1   | -   | A        |          | 992031-1   | PIN, CLEVIS                        | 104     |
| 1   | -   | A        |          | 21009-2    | SCR, SKT SET (1/4-20x.25 LW) RAM   | 103     |
| 2   | -   | A        |          | 21017-2    | SCR, DRIVE (#2x.19) ID PLATE       | 102     |
| 1   | -   | A        |          | 6-23715-5  | SCR, PAN HD (6-32x1.50) FEED ADJ   | 101     |
| 1   | -   | B        |          | 461264-1   | PLATE, IDENTIFICATION              | 100     |
| 2   | -   | A        |          | 3-21002-0  | SCR, BHC (10-32x.88) DRAG          | 99      |
| 1   | -   | A        |          | 22733-8    | SCR, BHC (8-32x.38 LW) ANVIL       | 98      |
| 4   | -   | A        |          | 2-21002-9  | SCR, BHC (10-32x.75) CAP           | 97      |
| 3   | -   | A        |          | 2-22733-8  | SCR, BHC (1/4-20x.62) HOUSING      | 96      |
| 1   | -   | A        |          | 2-21002-7  | SCR, BHC (10-32x.50) SG ADJ BLOCK  | 95      |
| 7   | -   | A        |          | 2-21002-2  | SCR, BHC (8-32x.50) TERM H DWN     | 94      |
|     |     |          |          |            |                                    | 93      |
| 2   | -   | A        |          | 1-21002-9  | SCR, BHC (6-32x.62) COVER          | 92      |
| 1   | -   | A        |          | 1-21002-7  | SCR, BHC (6-32x.38) CAM            | 91      |
|     |     |          |          |            |                                    | 90      |
| 1   | -   | A        |          | 7-21000-9  | SCR, SHC (4-40x.19) STRIPPER       | 89      |
|     |     |          |          |            |                                    | 88      |
|     |     |          |          |            |                                    | 87      |
| 1   | -   | A        |          | 2-22603-0  | SCR, HEX HD (8-32x.31) FEED FINGER | 86      |
| 2   | -   | A        |          | 1-21000-3  | SCR, SHC (4-40x.25) F ST GUIDE     | 85      |
|     |     |          |          |            |                                    | 84      |
| 2   | -   | A        |          | 3-21000-7  | SCR, SHC (10-32x.75) FEED ROD GD   | 83      |
| 2   | -   | A        |          | 3-21000-6  | SCR, SHC (10-32x.62) FD ADJ BLK    | 82      |
| 1   | -   | A        |          | 3-21000-4  | SCR, SHC (10-32x.38) SG ADJ BL     | 81      |
| 1   | -   | A        |          | 3-21000-4  | SCR, SHC (10-32x.38) PIVOT BLK     | 80      |
|     |     |          |          |            |                                    | 79      |
| REF | -   | C        |          | 356467-1   | GUARD                              | 78      |
|     |     |          |          |            |                                    | 77      |
|     |     |          |          |            |                                    | 76      |
|     |     |          |          |            |                                    | 75      |
|     |     |          |          |            |                                    | 74      |
|     |     |          |          |            |                                    | 73      |
| 1   | -   | A        |          | 458109-1   | WASHER, SPECIAL                    | 72      |
| 1   | -   | A        |          | 690517-1   | SPACER                             | 71      |
| -1  | U/M | DWG SIZE |          | PART NO    | DESCRIPTION                        | ITEM NO |

△ RECOMMENDED SPARE PARTS.

- △ RECOMMENDED SPARE PARTS.
- △ GREASE LIGHTLY.
- △ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- △ LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- △ WITH WIRE TRIM FEATURE.
- △ SET-UP ONLY.



|      |    |
|------|----|
| LOC  | A  |
| DIST | 66 |

| QTY | REF | U/M | DWG SIZE | PART NO    | DESCRIPTION               | ITEM NO |
|-----|-----|-----|----------|------------|---------------------------|---------|
| 1   | -   | B   |          | 22594-8    | NUT, HEX (1/2-20)         | 70      |
| 1   | -   | B   |          | 240628-1   | PLATE, ADJUSTMENT         | 69      |
| 1   | -   | B   |          | 240626-1   | SHAFT, PIVOT              | 68      |
| 1   | -   | B   |          | 240633-1   | BUSHING                   | 67      |
| 1   | -   | A   |          | 455680-1   | LEVER, INTERMEDIATE       | 66      |
| 1   | -   | B   |          | 240629-1   | BLOCK, PIVOT              | 65      |
| 1   | -   | A   |          | 240632-2   | SCREW, ADJ FEED ROD       | 64      |
| 1   | -   | B   |          | 240659-3   | PIN, CAM ROLLER           | 63      |
| 1   | -   | B   |          | 240658-1   | ROLLER, CAM               | 62      |
| 1   | -   | B   |          | 454398-2   | ROD, FEED                 | 61      |
| 1   | -   | A   |          | 454178-1   | GUIDE, FEED ROD           | 60      |
| 1   | -   | C   |          | 454220-1   | CAP, RAM                  | 59      |
| 1   | -   | D   |          | 454485-1   | HOUSING                   | 58      |
|     |     |     |          |            |                           | 57      |
| 1   | -   | B   |          | 690542-2   | PAWL, FEED                | 56      |
| 1   | -   | B   |          | 240624-1   | PIN, FEED FINGER          | 55      |
| 1   | -   | B   |          | 691499-1   | SPRING, FEED FINGER       | 54      |
| 1   | -   | B   |          | 690541-1   | HOLDER, FEED FINGER       | 53      |
| 1   | -   | A   |          | 455679-1   | LEVER, TERMINAL FEED ARM  | 52      |
|     |     |     |          |            |                           | 51      |
|     |     |     |          |            |                           | 50      |
|     |     |     |          |            |                           | 49      |
|     |     |     |          |            |                           | 48      |
| 1   | -   | B   |          | 690501-4   | CAM, POST-FEED 1 5/8 ST   | 47      |
|     |     |     |          |            |                           | 46      |
| 1   | -   | A   |          | 690191-1   | PLUG, NYLON               | 45      |
| 1   | -   | C   |          | 455673-1   | RAM                       | 44      |
| 1   | -   | A   |          | 690125-1   | WASHER, LAMINATED         | 43      |
| 1   | -   | A   |          | 690124-1   | WASHER, RAM               | 42      |
| 1   | -   | A   |          | 7-21002-9  | BOLT, CRIMPER (5/16x1.00) | 41      |
|     |     |     |          |            |                           | 40      |
| 1   | -   | A   |          | 1-23147-2  | SPRING, COMPRESSION       | 39      |
| 1   | -   | A   |          | 690223-2   | SPACER, INSULATION DISC   | 38      |
| 1   | -   | D   |          | 354777-1   | WIRE DISC, PLASTIC        | 37      |
| 1   | -   | A   |          | 22480-5    | WASHER, SPRING            | 36      |
| 1   | -   | B   |          | 690212-1   | POST, RAM                 | 35      |
| 1   | -   | B   |          | 356469-1   | SUPPORT, SHEAR            | 34      |
| 1   | -   | B   |          | 356600-1   | PLATE, BASE MODIFIED      | 33      |
| 1   | -   | A   |          | 690432-3   | SCREW, ADJUSTMENT         | 32      |
| 1   | -   | A3  |          | 356735-1   | DEPRESSOR, WIRE           | 31      |
| 1   | -   | B   |          | 455689-1   | BLOCK, STRIP GUIDE ADJ    | 30      |
| 1   | -   | C   |          | 455671-1   | PLATE, STRIP GUIDE        | 29      |
| 1   | -   | A3  |          | 356734-1   | GUIDE, DEPRESSOR          | 28      |
| 2   | -   | A   |          | 1-22284-0  | SPRING, DRAG              | 27      |
| 1   | -   | B   |          | 690546-1   | LEVER, DRAG RELEASE       | 26      |
| 1   | -   | B   |          | 240792-1   | DRAG, TERMINAL            | 25      |
| 1   | -   | D   |          | 6-690504-3 | GUIDE, STRIP (REAR)       | 24      |
| 1   | -   | A   |          | 690438-1   | GUIDE, STRIP (FRONT)      | 23      |
|     |     |     |          |            |                           | 22      |
|     |     |     |          |            |                           | 21      |
| 1   | -   | A   |          | 4-22284-9  | SPRING, FEED RETURN       | 20      |
|     |     |     |          |            |                           | 19      |
|     |     |     |          |            |                           | 18      |
| 1   | -   | B   |          | 318714-1   | HOLD DOWN                 | 18      |
| 1   | -   | C   |          | 356598-1   | GUARD                     | 17      |
| 1   | -   | B   |          | 318563-1   | GUARD, CHIP, FRONT        | 16      |
| 1   | -   | B   |          | 356468-1   | COVER                     | 15      |
| 1   | -   | B   |          | 356461-1   | SHEAR PLATE, WIRE         | 14      |
|     |     |     |          |            |                           | 13      |
| 1   | -   | A   |          | 5-22280-0  | SPRING, SHEAR             | 12      |
| 1   | -   | B   |          | 690461-1   | STOP, SHEAR               | 11      |
| 1   | -   | C   |          | 690459-1   | HOLDER, SHEAR (FRONT)     | 10      |
| 1   | -   | C   |          | 1-454276-7 | SHEAR, FLOAT (FRONT)      | 9       |
| 1   | -   | C   |          | 805840-9   | ANVIL                     | 8       |
|     |     |     |          |            |                           | 7       |
|     |     |     |          |            |                           | 6       |
| 1   | -   | C   |          | 2-455889-8 | DEPRESSOR, SHEAR (FRONT)  | 5       |
|     |     |     |          |            |                           | 4       |
|     |     |     |          |            |                           | 3       |
|     |     |     |          |            |                           | 2       |
| 1   | -   | C   |          | 318542-4   | CRIMPER, WIRE             | 1       |

△ REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

|  |              |          |       |
|--|--------------|----------|-------|
| DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED. |              | MACH REF |       |
| C1   | 0150-7644-97 | TB       | 4/97  |
| C  | 0150-7378-96 | TB       | 11-96 |
| B  | 0150-7137-96 | CE       | 8-96  |
| A  | REVISED      | CE       | 7-96  |
| P/F  | LTR          | APP      | DATE  |

|       |         |             |         |             |   |
|-------|---------|-------------|---------|-------------|---|
| DR    | 6-11-96 | APP         | 6-11-96 | J. STACHURA | AMP Incorporated<br>Harrisburg, PA 17105-3608 |
| CHK   | 6-11-96 | REL         | -       | -           |   |
| NAME  |         | MACHINE REF |         | MINI APPL   |   |
| SCALE |         | DWG NO      |         | SHEET REV   |   |
| -     |         | D 680319    |         | 1 OF 1 C1   |   |