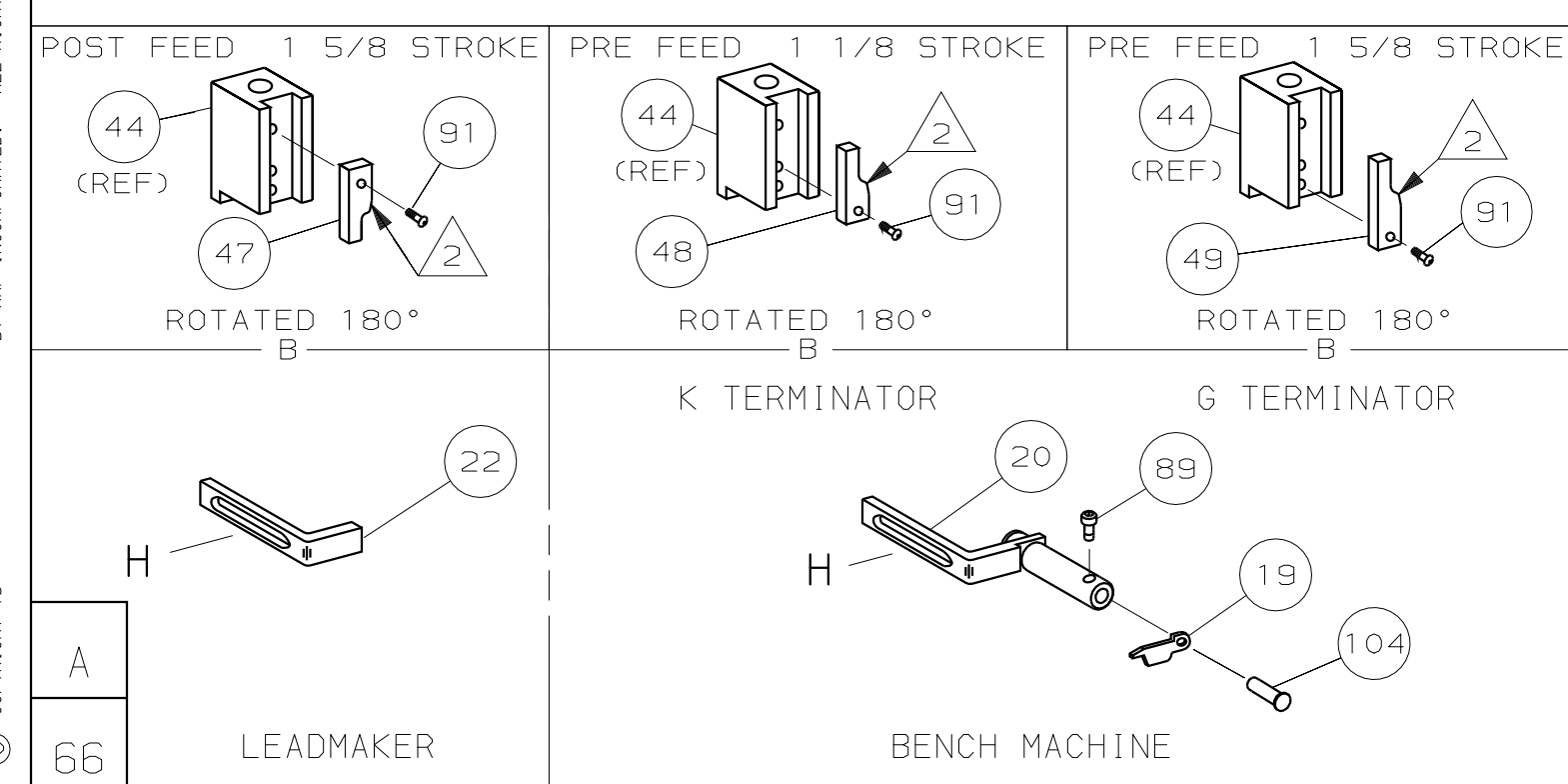
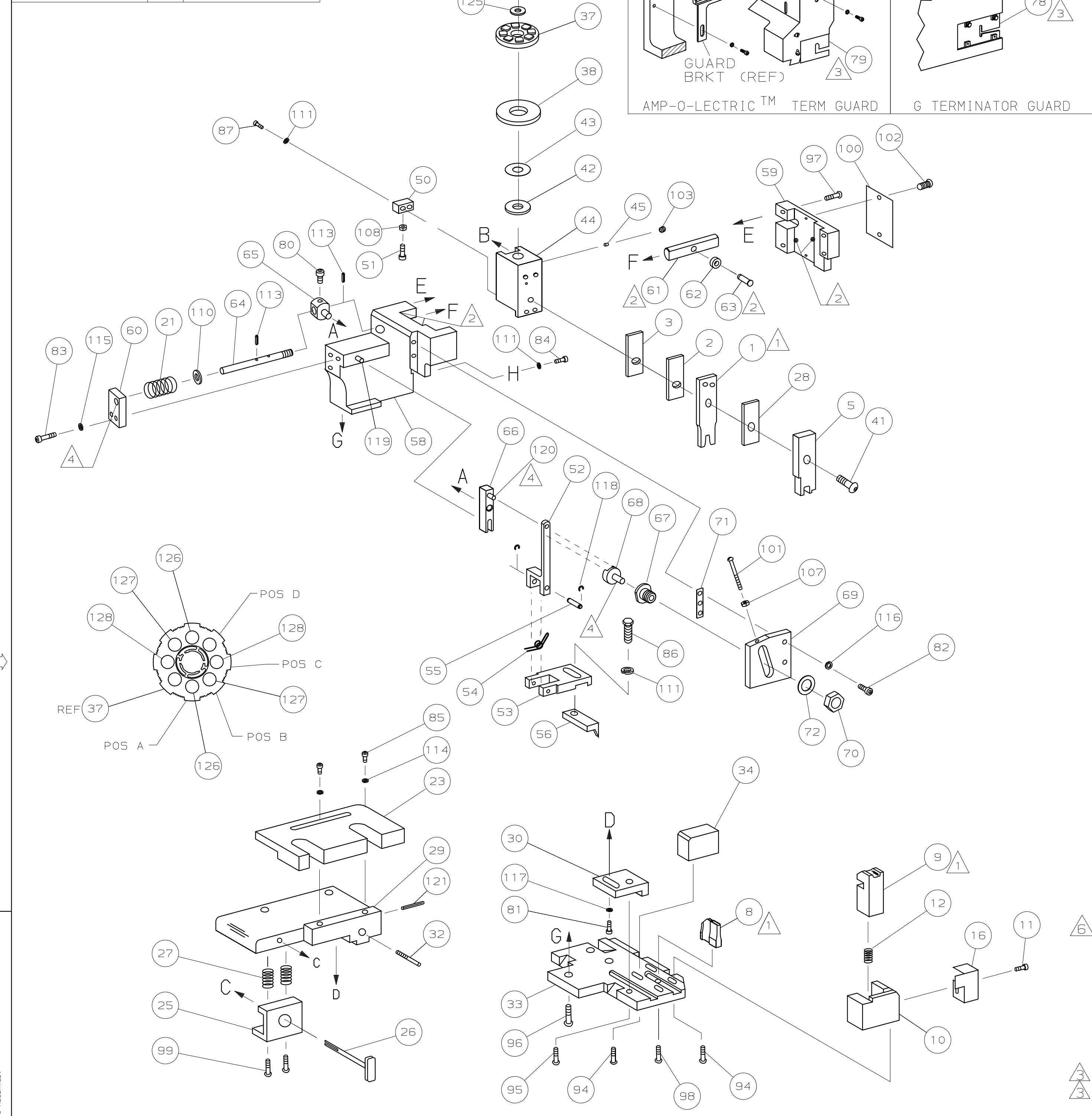


PART NUMBER	REV	FIRST USED
680581-1	A	122500-1
680581-2	A	565435-5
680581-3	A	354500-1



- 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 46.
- 6 CUT TO LENGTH AT ASSY.

TERMINAL NAME: BOX RECEPTACLE		COMP TERMINAL-AMP SPEC	
CRIMPING DATA			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.074 ±.002 [1.88 ±0.05mm]	14	
B	.065 ±.002 [1.65 ±0.05mm]	16	
C	.058 ±.002 [1.47 ±0.05mm]	18	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.100 [2.54mm]	F	18-14
INSUL	-	-	-
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
.219-.250	NONE	.713	408-8040
SET UP GAGE	LAYOUT		
458637-1	L2037		

QTY	REF	REF	REF	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	2	2	-	C		9-354778-3	PIN, WIRE DISC (.2960)C	129
2	2	2	-	C		7-354778-7	PIN, WIRE DISC (.2880)B	127
2	2	2	-	C		5-354778-5	PIN, WIRE DISC (.2770)A	126
1	1	1	-	A		986950-1	WASHER, FLAT PRECISION	125
1	1	1	-	A		217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	1	-	-		4088040	SF APPL INST 408-8040	123
1	1	1	-	A		4-21028-0	PIN,SLT SPR(φ.093x.75)ST GDE PL	122
REF	REF	REF	-	A		1-21030-1	PIN,DOWEL(φ.187x.50)LEVER	120
REF	REF	REF	-	A		1-21030-6	PIN,DOWEL(φ.187x1.25)HOUSING	119
REF	REF	REF	-	A		21045-3	RING,RET "C"(φ.187)FD FING PIN	118
1	1	1	-	A		21024-5	WASHER, LOCK (#10)ADJ BLK	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 ST GUIDE	114
REF	REF	REF	-	A		5-21028-1	PIN,SLT SPR(φ.125x.50)ADJ ROD	113
4	4	4	-	A		21024-4	WASHER,LOCK(#8)STRIPPER	111
REF	REF	REF	-	A		21899-4	WASHER,FLAT(φ5/16)SCREW ADJ	110
1	1	1	-	A		21018-5	NUT,HEX(NO.6)HOLDDOWN	108
REF	REF	REF	-	A		21018-5	NUT,HEX(6-32)FEED ADJ	107
1	1	1	-	A		992031-1	PIN, CLEVIS	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)TERM H DWN	94
1	1	1	-	A		1-21002-7	SCR,BHC(6-32x.38)CAM	91
1	1	1	-	A		7-21000-9	SCR,SHC(4-40x.19)STRIPPER	89
2	2	2	-	A		2-21000-7	SCR,SHC(8-32 X 4.48) HOLD DOWN	87
1	1	1	-	A		2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
2	2	2	-	A		1-21000-4	SCR,SHC(4-40x.38)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
-	REF	-	-	B		455749-1	GUARD, WINDOW	79
REF	-	-	-	B		679532-1	INSERT, GUARD	78
77								77
76								76
75								75
74								74
73								73
72								72
71								71
-3	-2	-1	U/M	DWG SIZE		PART NO	DESCRIPTION	ITEM NO
QTY REOD PER ASSY PARTS LIST								

QTY	REF	REF	REF	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
1	1	1	-	B		1-694433-1	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
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		459456-1	APPLICATOR, BASIC (SUBASSY)	46
1	1	1	-	A		690191-1	PLUG, NYLON	45
1	1	1	-	C		455673-4	RAM	44
1	1	1	-	A		690125-1	WASHER, LAMINATED	43
1	1	1	-	A		690124-1	WASHER, RAM	42
1	1	1	-	A		690686-1	BOLT, CRIMPER(5/16x1.00)	41
								40
								39
1	1	1	-	A		690223-2	SPACER, INSULATION DISC	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		455888-7	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
								24
1	1	1	-	A		1-679651-3	GUIDE, STRIP (FRONT)	23
-	-	1	-	B		690472-2	STRIPPER	22
REF	REF	REF	-	A		4-22284-9	SPRING, FEED RETURN	21
1	1	1	-	A		679218-1	STRIPPER WIRE STOP ASSY	20
1	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		6-22279-4	SPRING, SHEAR	12
1	1	1	-	B		690461-1	STOP, SHEAR	11
1	1	1	-	C		468798-1	HOLDER, SHEAR (FRONT)	10
1	1	1	-	C		462006-3	SHEAR, FLOAT (FRONT)	9
1	1	1	-	C		1-904717-4	ANVIL	8
								7
								6
1	1	1	-	C		1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
								4
1	1	1	-	C		1-455888-2	SPACER, CRIMPER	3
1	1	1	-	C		2-455888-2	SPACER, CRIMPER	2
1	1	1	-	C		2-456407-5	CRIMPER, WIRE	1
-3	-2	-1	U/M	DWG SIZE		PART NO	DESCRIPTION	ITEM NO
QTY REOD PER ASSY PARTS LIST								

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REVISION RECORD

REV	DATE	DESCRIPTION
A1	ECN 0150-0459-04	TE 4-04
A	REVISED	CE 3-98

REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

SCALE: D DWG NO: 680581 SHEET 1 OF 1 REV A1

CUSTOMER AND ASSEMBLY DRAWING

AMP Incorporated Harrisburg, PA 17105-3608

NAME: SIDE FEED HDM APPLICATOR MACHINE REF: MINI APPL