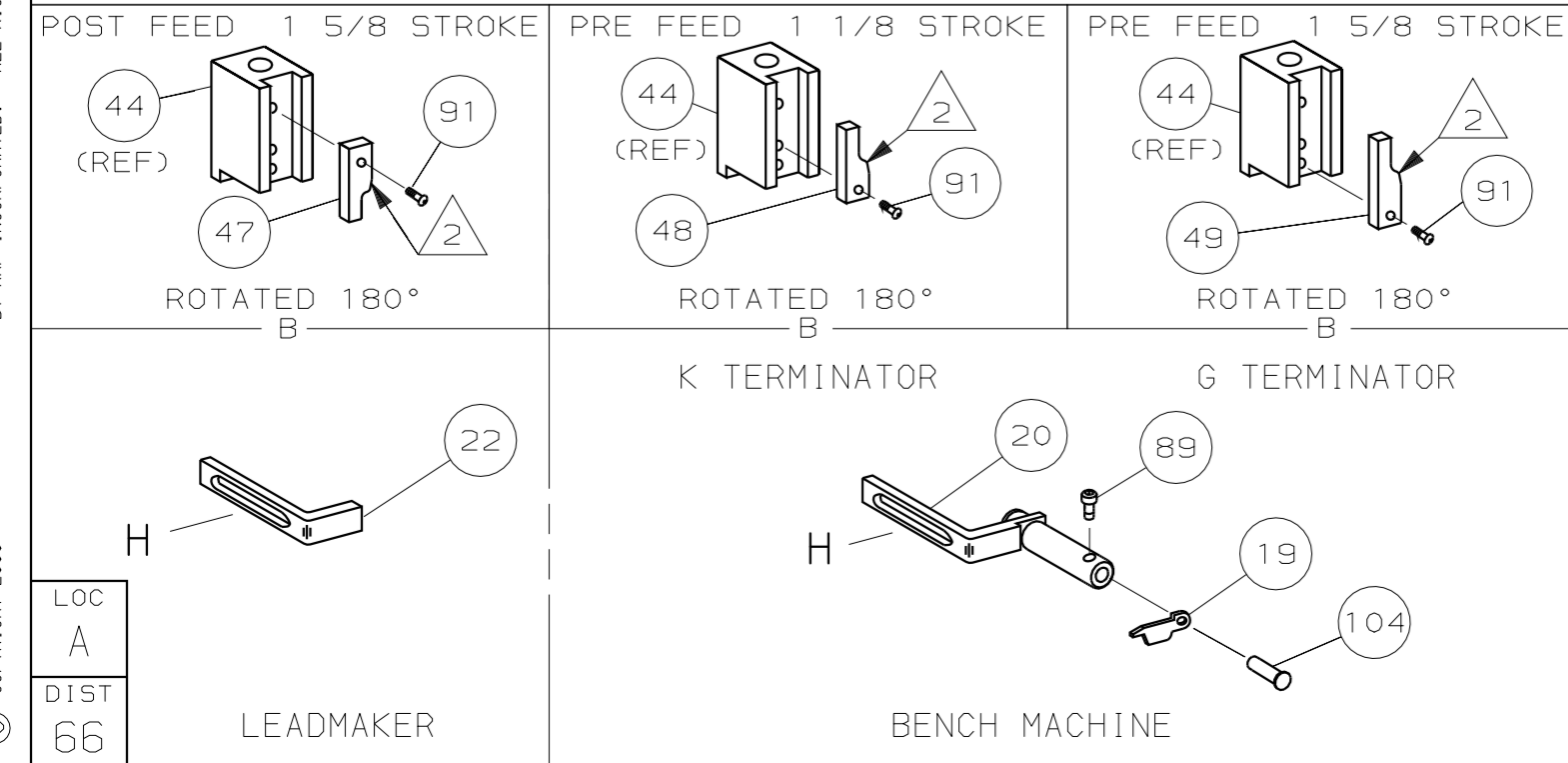
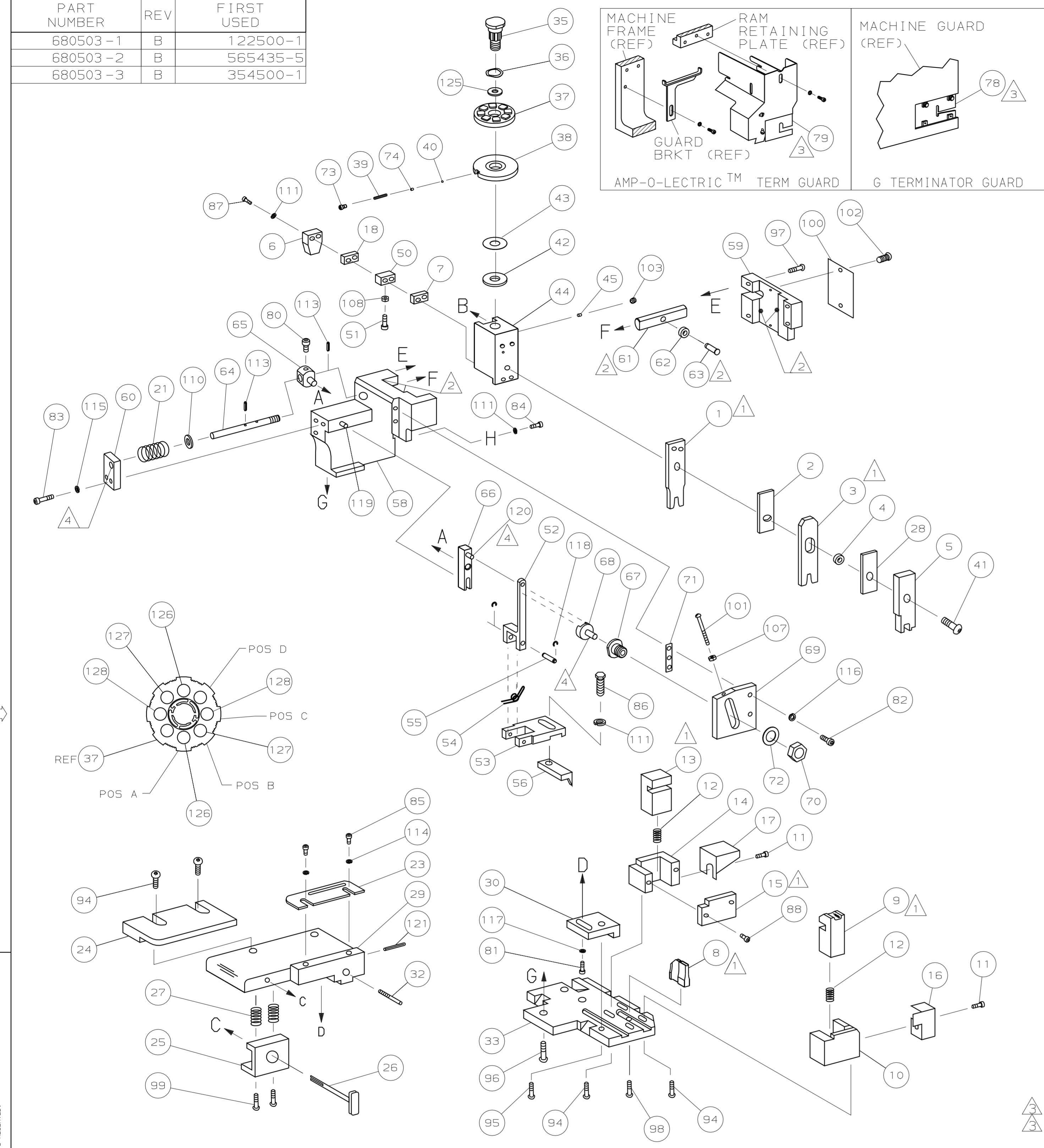


| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------|
| 680503-1 | B | 122500-1 |
| 680503-2 | B | 565435-5 |
| 680503-3 | B | 354500-1 |



- 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 GUIDE FEED FINGER ON END OF PLATE (NOT IN FEED FINGER SLOT)

| TERMINAL NAME: BULLET RECEPTACLE | | CRIMPING DATA | | | | |
|----------------------------------|---------------|---------------|-----------------------------|------------------|-------------|--------|
| AMP P/N | MFG P/N | PAD LTR | CRIMP HEIGHT | WIRE SIZE | | |
| 286613 | 541617A12 | A | .066 ± .002 [1.68 ± 0.05mm] | 16 | | |
| | | B | .062 ± .002 [1.57 ± 0.05mm] | 18 | | |
| | | C | .057 ± .002 [1.45 ± 0.05mm] | 20 | | |
| | | D | NOT | USED | | |
| CRIMP | SIZE | TYPE | RANGE | | | |
| WIRE | .090 [2.29mm] | F | 20-16 | | | |
| INSUL | .180 [4.57mm] | F | .088-.128 | | | |
| WIRE STRIP LENGTH | TERM APPL | SPEC | FEED | APPL INSTRUCTION | SET UP GAGE | LAYOUT |
| .203-.234 | NONE | | .657 | 408-8040 | 458637-1 | L1963 |

| QTY | REF | REF | REF | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|-----|-----|-----|----------|----------|------------|---------------------------------|---------|
| 2 | | | | | | 1-354779-9 | PIN, WIRE DISC (.3085)C | 129 |
| 2 | | | | | | 354779-9 | PIN, WIRE DISC (.3035)B | 127 |
| 2 | | | | | | 354779-1 | PIN, WIRE DISC (.2995)A | 126 |
| 1 | | | | | | 986950-1 | WASHER, FLAT PRECISION | 125 |
| 1 | | | | | | 217238-1 | GENERAL INSTRUCTION PACKAGE | 124 |
| 1 | | | | | | 4088040 | SF APPL INST 408-8040 | 123 |
| 1 | | | | | | 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 | | | | | | 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 | | | | | | 21024-2 | WASHER,LOCK (#4)FRONT STP GUIDE | 114 |
| REF | REF | REF | - | A | | 5-21028-1 | PIN,SLT SPR(φ.125x.50)ADJ ROD | 113 |
| 4 | | | | | | 21024-4 | WASHER,LOCK (#8)STRIPPER | 112 |
| REF | REF | REF | - | A | | 21899-4 | WASHER,FLAT (φ5/16)SCREW ADJ | 110 |
| 1 | | | | | | 21018-5 | NUT,HEX (NO. 6)HOLDDOWN | 108 |
| REF | REF | REF | - | A | | 21018-5 | NUT,HEX (6-32)FEED ADJ | 107 |
| 1 | | | | | | 992031-1 | PIN, CLEVIS | 105 |
| 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 | - | A | | 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 | - | 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 |
| 6 | | | | | | 2-21002-2 | SCR,BHC (8-32x.50) TERM H DWN | 94 |
| 1 | | | | | | 7-21000-9 | SCR,SHC (4-40x.19)STRIPPER | 90 |
| 2 | | | | | | 1-21002-7 | SCR,SHC (6-32x.38)R SHEAR PLATE | 88 |
| 2 | | | | | | 3-21000-1 | SCR,SHC (8-32x1.00)DEP-HOLD | 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 |
| 1 | | | | | | 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 | | | | | | 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 |
| 1 | | | | | | 690603-1 | SPRING, ASSIST | 74 |
| 1 | | | | | | 23030-1 | SCR,SHC (6-32x.25 SL) INS 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 REOD PER ASSY | | PARTS LIST | |
|-------------------|-----|------------|------------------|
| P/F | LTR | REVISION | RECORD |
| | | B2 | ECR-06-011494 |
| | | B1 | ECN 0150-0459-04 |
| | | B | 0150-0058-00 |
| A | | RELEASED | CE 8-97 |

| | | | 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 | | |
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| -3 | -2 | -1 | U/M | DWG SIZE | | PART NO | DESCRIPTION | ITEM NO | |
| QTY REOD PER ASSY | | PARTS LIST | | | | | | | |
| DIMENSIONS IN INCHES. DO NOT SCALE PRINT. | | | MATL | | HT TR | | FIN | | |
| TOLERANCES UNLESS OTHERWISE SPECIFIED: | | | DR | | APP | | MACHINE REF | | |
| 2 PLC DEC ± | | | C.ERISMAN | | 16JUL97 | | T.ELBIN | | |
| 3 PLC DEC ± | | | CHK | | REL | | AMP Incorporated | | |
| 4 PLC DEC ± | | | C.ERISMAN | | 16JUL97 | | Harrisburg, PA 17105-3608 | | |
| ANGLES ± | | | NAME | | | | | | |
| SURF TEXTURE: ✓ | | | SIDE FEED HDM APPLICATOR | | | | | | |
| REMOVE BURRS, BREAK SHARP EDGES R.015 MAX | | | SCALE | | | DWG NO | | 680503 | |
| CAGE CODE | | | 00779 | | | CUSTOMER AND ASSEMBLY DRAWING | | 1 | |
| RESTRICTED TO | | | | | | | | | |

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21 JAN 2000

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