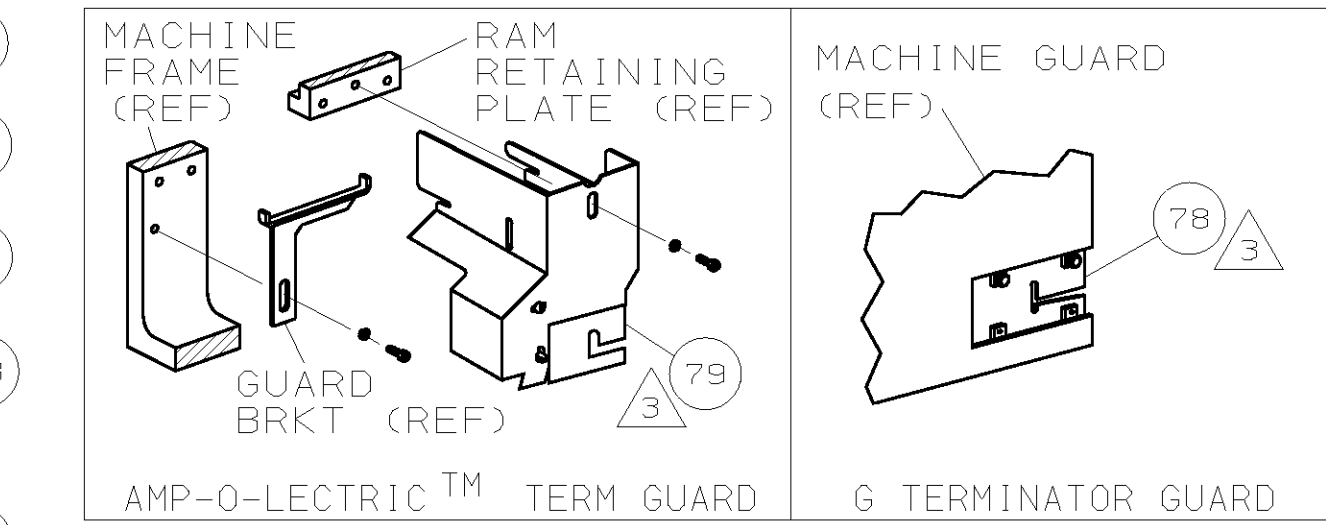
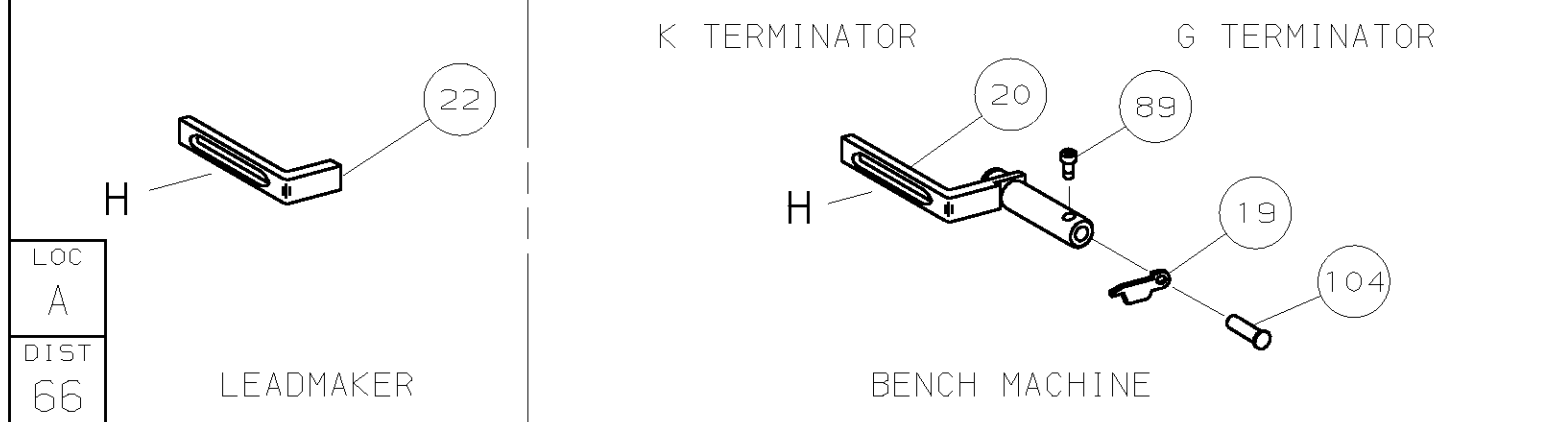
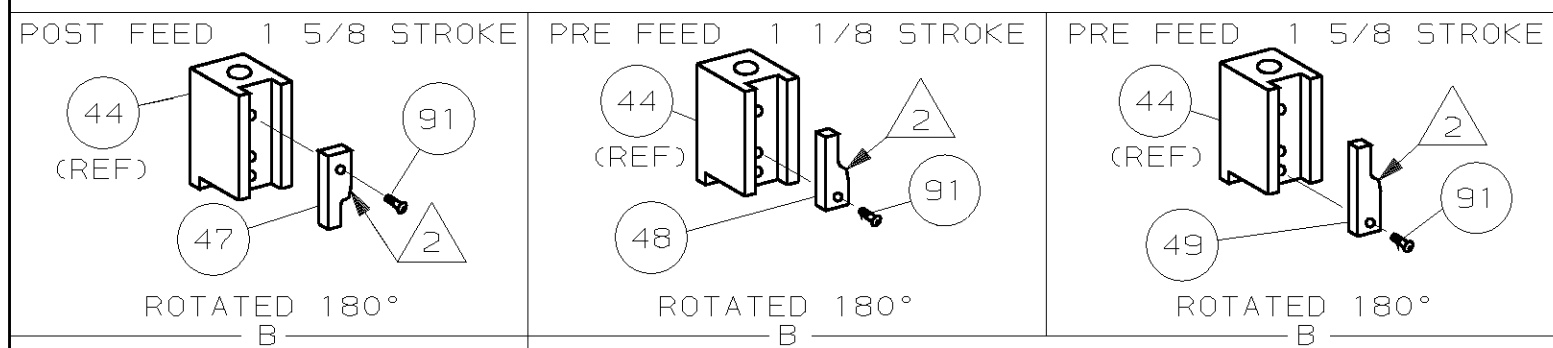
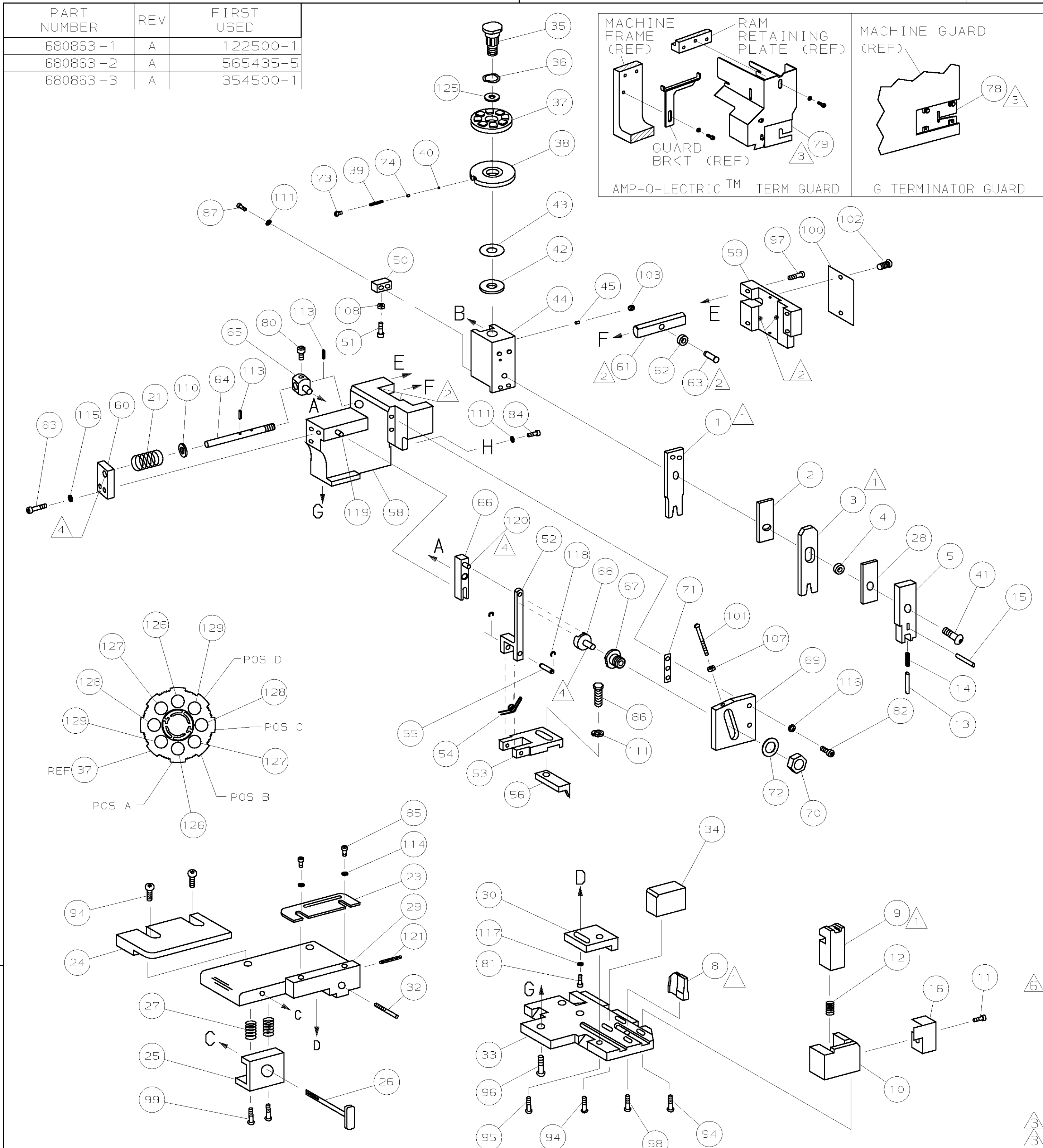


| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------|
| 680863-1    | A   | 122500-1   |
| 680863-2    | A   | 565435-5   |
| 680863-3    | A   | 354500-1   |



- 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: SOCKET |               |  |                           |
|-----------------------|---------------|--|---------------------------|
| AMP P/N               | MFG P/N       | CRIMP DATA (NON-AMP TERMINAL-AMP SPEC) |                           |
| 286826                | CTA118-0601   | PAD LTR                                | CRIMP HEIGHT              |
|                       |               | A                                      | .045 ±.002 [1.14 ±0.05mm] |
|                       |               | B                                      | .039 ±.002 [0.99 ±0.05mm] |
|                       |               | C                                      | .035 ±.002 [0.89 ±0.05mm] |
|                       |               | D                                      | .033 ±.002 [0.84 ±0.05mm] |
| WIRE                  | SIZE          | TYPE                                   | RANGE                     |
|                       | .070 [1.78mm] | F                                      | 24-18                     |
| INSUL                 | .070 [1.78mm] | F                                      | .080 MAX                  |

| QTY | WIRE STRIP LENGTH | TERM APPL | SPEC | FEED     | APPL INSTRUCTION | SET UP GAGE                        | LAYOUT  |
|-----|-------------------|-----------|------|----------|------------------|------------------------------------|---------|
| 2   | .125-.141         | NONE      |      | .396     | 408-8040         | 458637-1                           | L2267   |
| 2   | 2                 | 2         | -    | C        | 6-354779-0       | PIN, WIRE DISC (.3290)D            | 129     |
| 2   | 2                 | 2         | -    | C        | 5-354779-6       | PIN, WIRE DISC (.3270)C            | 128     |
| 2   | 2                 | 2         | -    | C        | 4-354779-8       | PIN, WIRE DISC (.3230)B            | 127     |
| 2   | 2                 | 2         | -    | C        | 3-354779-5       | PIN, WIRE DISC (.3165)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     |
|     |                   |           |      |          |                  |                                    | 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     |
| REF | REF               | REF       | -    | A        | 21045-3          | RING, RET "C" (Ø.187) FD FING PIN  | 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     |
| REF | REF               | REF       | -    | A        | 5-21028-1        | PIN, SLT SPR (Ø.125x.50) ADJ ROD   | 113     |
|     |                   |           |      |          |                  |                                    | 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     |
|     |                   |           |      |          |                  |                                    | 109     |
| 1   | 1                 | 1         | -    | A        | 21018-5          | NUT, HEX (NO. 6) HOLDDOWN          | 108     |
| REF | REF               | REF       | -    | A        | 21068-5          | NUT, HEX (6-32) FEED ADJ           | 107     |
|     |                   |           |      |          |                  |                                    | 106     |
|     |                   |           |      |          |                  |                                    | 105     |
| 1   | 1                 | -         | -    | A        | 992031-1         | PIN, CLEVIS                        | 104     |
| 1   | 1                 | 1         | -    | A        | 21009-2          | SCR, SKT 5ET (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) 56 ADJ BLOCK  | 95      |
| 6   | 6                 | 6         | -    | A        | 2-21002-2        | SCR, BHC (8-32x.50) TERM H DWN     | 94      |
|     |                   |           |      |          |                  |                                    | 93      |
|     |                   |           |      |          |                  |                                    | 92      |
|     |                   |           |      |          |                  |                                    | 91      |
| 1   | 1                 | 1         | -    | A        | 1-21002-7        | SCR, BHC (6-32x.38) CAM            | 90      |
|     |                   |           |      |          |                  |                                    | 89      |
| 2   | 2                 | 2         | -    | A        | 2-21000-7        | SCR, SHC (8-32x.48) DEP-HOLD       | 87      |
| 1   | 1                 | 1         | -    | A        | 2-22603-0        | SCR, HEX (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) 56 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      |
|     |                   |           |      |          |                  |                                    | 76      |
|     |                   |           |      |          |                  |                                    | 75      |
| 1   | 1                 | 1         | -    | A        | 690603-1         | SPRING, ASSIST                     | 74      |
| 1   | 1                 | 1         | -    | A        | 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 | WIRE STRIP LENGTH | TERM APPL | SPEC | FEED     | APPL INSTRUCTION | SET UP GAGE                 | LAYOUT  |
|-----|-------------------|-----------|------|----------|------------------|-----------------------------|---------|
| 2   | .125-.141         | NONE      |      | .396     | 408-8040         | 458637-1                    | L2267   |
| 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      |
| 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        | 455673-1         | 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         | -    | C        | 1-690142-0       | DISC, INSULATION            | 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        | 455671-3         | PLATE, STRIP GUIDE          | 29      |
| 1   | 1                 | 1         | -    | C        | 1-455888-5       | 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      |
| 1   | 1                 | 1         | -    | D        | 5-690504-9       | GUIDE, STRIP (REAR)         | 24      |
| 1   | 1                 | 1         | -    | A        | 690438-1         | GUIDE, STRIP (FRONT)        | 23      |
| -   | -                 | 1         | -    | B        | 690472-2         | STRIPPER                    | 22      |
| REF | REF               | REF       | -    | A        | 4-22284-9        | SPRING, FEED RETURN         | 21      |
| 1   | 1                 | -         | -    | A        | 679218-1         | STRIPPER WIRE STOP ASSY     | 20      |
| 1   | 1                 | -         | -    | B        | 458949-1         | STRIPPER                    | 19      |
|     |                   |           |      |          |                  |                             | 18      |
|     |                   |           |      |          |                  |                             | 17      |
| 1   | 1                 | 1         | -    | B        | 318563-1         | GUARD, CHIP, FRONT          | 16      |
| 1   | 1                 | 1         | -    | A        | 21028-2          | PIN, SLOTTED SPRING         | 15      |
| 1   | 1                 | 1         | -    | A        | 1-22278-0        | SPRING, COMPRESSION         | 14      |
| 1   | 1                 | 1         | -    | A        | 854769-1         | HOLDER, INSULATION          | 13      |
| 1   | 1                 | 1         | -    | A        | 5-22280-0        | SPRING, SHEAR               | 12      |
| 1   | 1                 | 1         | -    | B        | 690461-1         | STOP, SHEAR                 | 11      |
| 1   | 1                 | 1         | -    | C        | 690459-1         | HOLDER, SHEAR (FRONT)       | 10      |
| 1   | 1                 | 1         | -    | C        | 462006-1         | SHEAR, FLOAT (FRONT)        | 9       |
| 1   | 1                 | 1         | -    | C        | 2-662185-5       | ANVIL                       | 8       |
|     |                   |           |      |          |                  |                             | 7       |
|     |                   |           |      |          |                  |                             | 6       |
| 1   | 1                 | 1         | -    | C        | 854772-1         | DEPRESSOR, SHEAR (FRONT)    | 5       |
| 1   | 1                 | 1         | -    | B        | 238011-8         | SPACER, BLOCK CRIMPER       | 4       |
| 1   | 1                 | 1         | -    | C        | 9-456134-0       | CRIMPER, INSULATION         | 3       |
| 1   | 1                 | 1         | -    | C        | 455888-5         | SPACER, CRIMPER             | 2       |
| 1   | 1                 | 1         | -    | C        | 2-456404-5       | CRIMPER, WIRE               | 1       |
| -3  | -2                | -1        | U/M  | DWG SIZE | PART NO          | DESCRIPTION                 | ITEM NO |

| QTY | WIRE STRIP LENGTH | TERM APPL | SPEC | FEED     | APPL INSTRUCTION | SET UP GAGE                     | LAYOUT  |
|-----|-------------------|-----------|------|----------|------------------|---------------------------------|---------|
| 2   | .125-.141         | NONE      |      | .396     | 408-8040         | 458637-1                        | L2267   |
| 1   | 1                 | 1         | -    | A        | 690603-1         | SPRING, ASSIST                  | 74      |
| 1   | 1                 | 1         | -    | A        | 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 |

| REVISIONS |                  | PARTS LIST      |          |
|-----------|------------------|-----------------|----------|
| NO        | DATE             | DESCRIPTION     | BY       |
| A1        | ECN 0150-0723-04 |                 | TE 6-04  |
| A         | REVISED          |                 | BH 8/99  |
| P/F       | LTR              | REVISION RECORD | APP DATE |