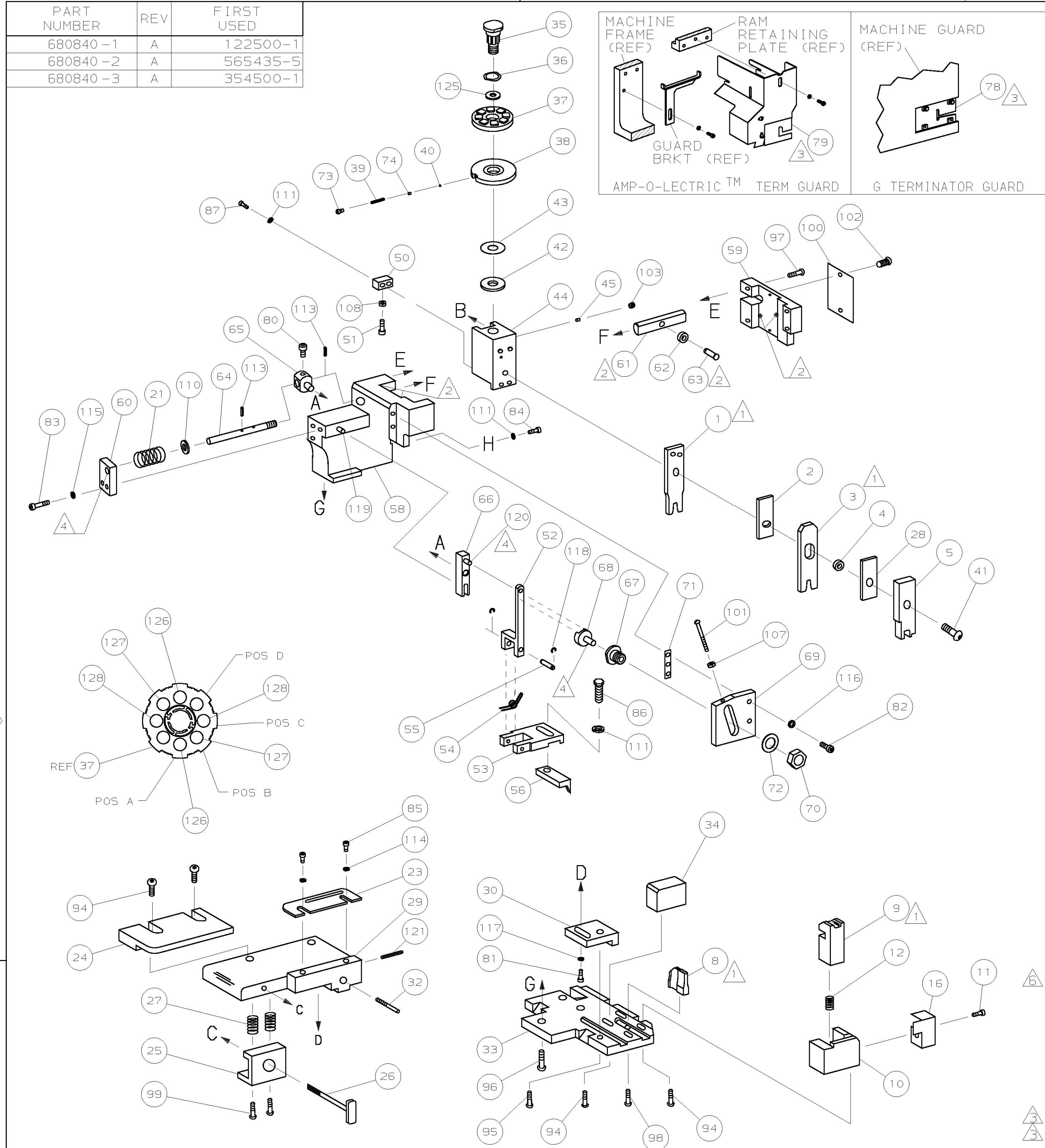
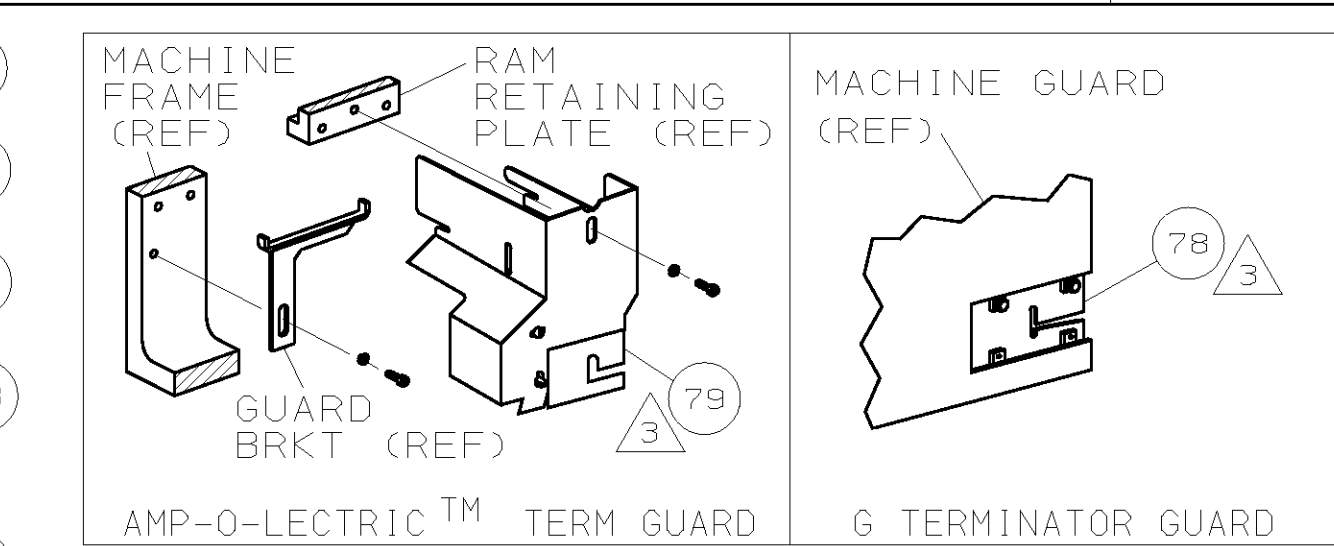


PART NUMBER	REV	FIRST USED
680840-1	A	122500-1
680840-2	A	565435-5
680840-3	A	354500-1



POST FEED 1 5/8 STROKE	PRE FEED 1 1/8 STROKE	PRE FEED 1 5/8 STROKE
LOC A DIST 66 LEADMAKER	K TERMINATOR BENCH MACHINE	G TERMINATOR BENCH MACHINE



- 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: POWER CORD RECEPTICAL CONTACT									
			353439		CRIMP DATA (AMP TERMINAL)				
					PAD LTR	CRIMP HEIGHT		WIRE SIZE	
					A	.057 ±.002 [1.46 ±0.05mm]		1.25 mm ²	
					B	.048 ±.002 [1.23 ±0.05mm]		0.75 mm ²	
					C	.043 ±.002 [1.1 ±0.05mm]		0.5 mm ²	
					D	NOT		USED	
					CRIMP	SIZE	TYPE	RANGE	
					WIRE	.070 [1.78mm]	F	0.5mm ² - 1.25mm ²	
					INSUL	.170 [4.32mm]	F	2.0-3.8mm	
WIRE STRIP LENGTH			TERM APPL SPEC		FEED	APPL INSTRUCTION		SET UP GAGE	LAYOUT
.198-.218			114-05232		.512	408-8040		458637-1	L2253
									129
2	2	2	-	C	3-354779-6	PIN, WIRE DISC (.3170)C			128
2	2	2	-	C	2-354779-6	PIN, WIRE DISC (.3120)B			127
2	2	2	-	C	354779-8	PIN, WIRE DISC (.3030)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)SG ADJ BLOCK			95
6	6	6	-	A	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN			94
									93
									92
1	1	1	-	A	1-21002-7	SCR,BHC(6-32x.38)CAM			91
									90
1	1	-	-	A	7-21000-9	SCR,SHC(4-40x.19)STRIPPER			89
									88
2	2	2	-	A	2-21000-7	SCR,SHC(8-32x.48)DEP-HOLD			87
1	1	1	-	A	2-22603-0	SCR,HEX HD(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)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
									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 REOD PER ASSY					PARTS LIST				

LEADMAKER					MECH POST FEED			
-2	BENCH MODEL K				MECH PRE FEED			
-3	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	
							57	
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	690142-3	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	690786-6	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	2-455888-2	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	7-690504-6	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	
							15	
							14	
							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	454276-1	SHEAR, FLOAT (FRONT)	9	
1	1	1	-	C	2-662185-3	ANVIL	8	
							7	
							6	
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5	
1	1	1	-	B	2-238011-2	SPACER, BLOCK CRIMPER	4	
1	1	1	-	C	8-456134-6	CRIMPER, INSULATION	3	
1	1	1	-	C	455888-9	SPACER, CRIMPER	2	
1	1	1	-	C	1-456404-1	CRIMPER, WIRE	1	
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO	
				← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)				
QTY REQD PER ASSY				PARTS LIST				
DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±- 3 PLC DEC ±- 4 PLC DEC ±- ANGLES ±- SURF TEXTURE: ✓ REMOVE BURRS, BREAK SHARP EDGES R.015 MAX				MATL		HT TR	FIN	
				-		-	-	
				DR B.HIGMAN 28JUN99		APP T.ELBIN 28JUN99	 AMP Incorporated Morrisburg, PA 17105-3608	
				CHK 28JUN99 B.HIGMAN		REL -		
				NAME		SIDE FEED HDM APPLICATOR		
SCALE		680840			MINI APPL			
-		D NO			SHEET 1 OF 1	REV A		
CASE CODE 00779		CUSTOMER AND ASSEMBLY DRAWING					RESTRICTED TO	

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[680840-2](#)