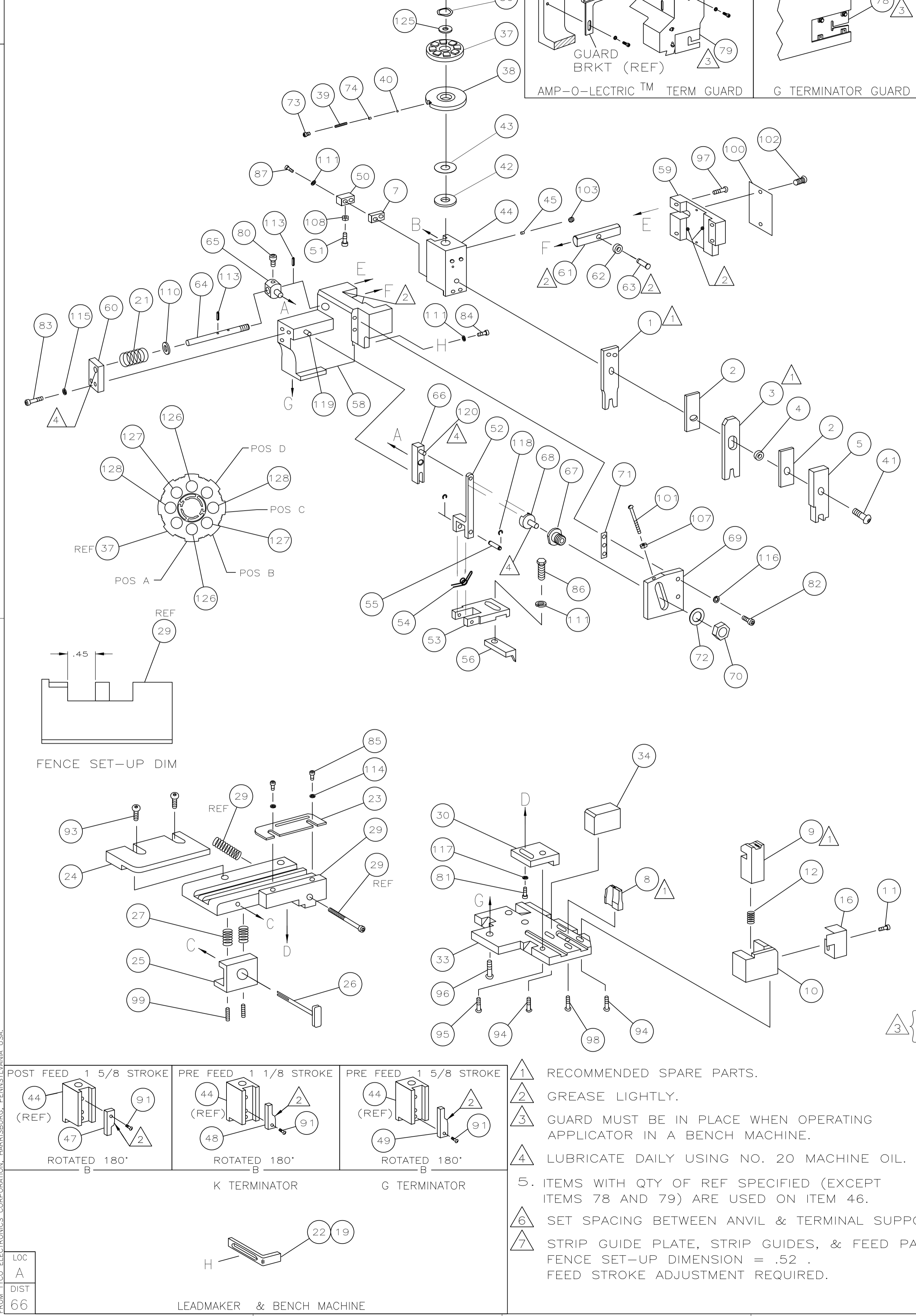


THIS DRAWING IS A CONTROLLED DOCUMENT.

PART NUMBER	REV	FIRST USED
680327-1	C	122500-1
680327-2	C	565435-5
680327-3	C	354500-1

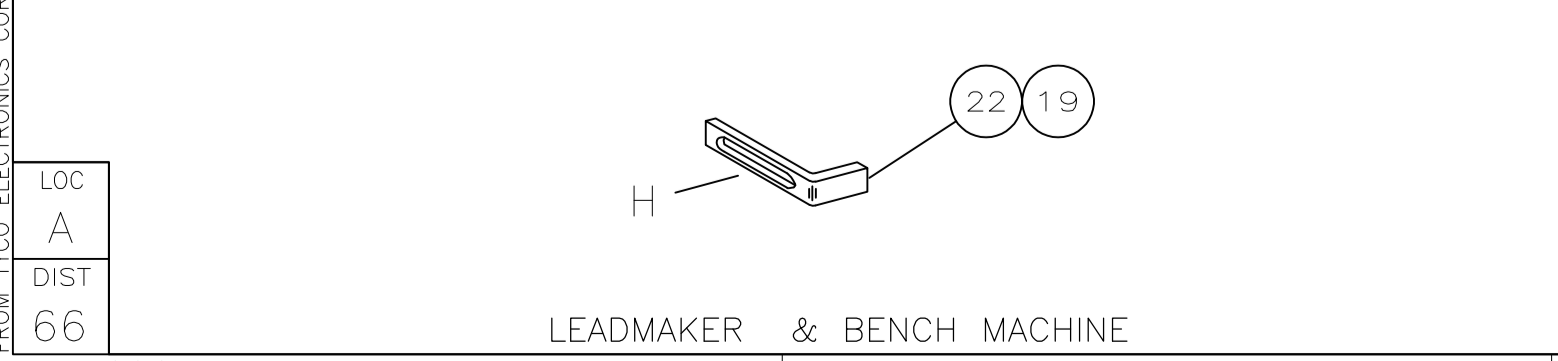
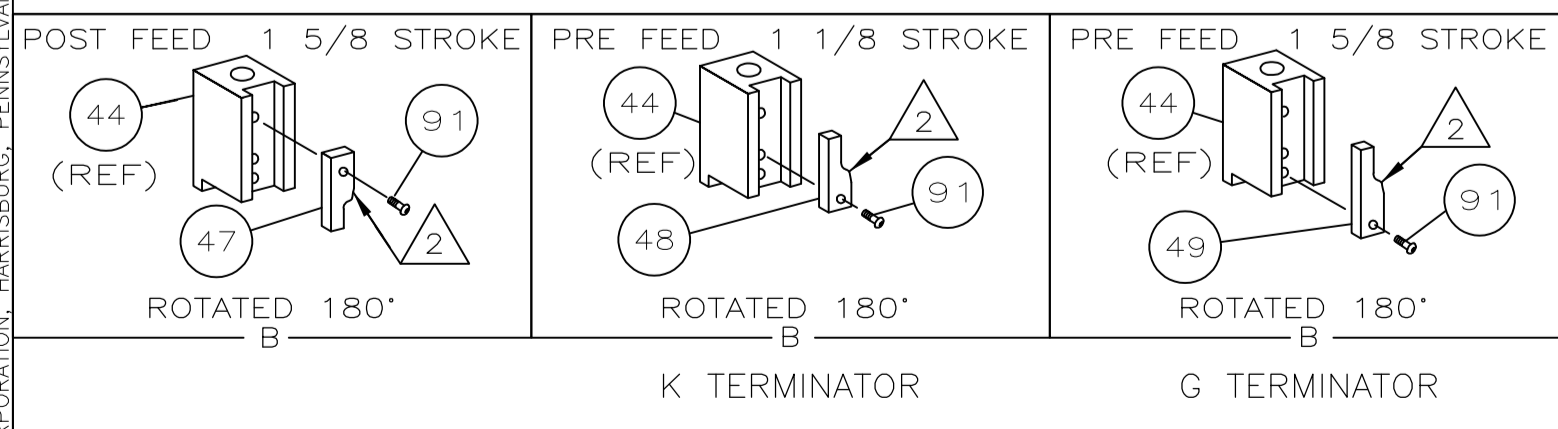


AMP P/N		MFG P/N		CRIMPING DATA	
170382				CRIMP HEIGHT	
286501	P82404050	PAD LTR		WIRE SIZE	
		A	.054 ±.002 [1.38 ±.05mm]	16	
		B	.048 ±.002 [1.22 ±.05mm]	18	
		C	.043 ±.002 [1.10 ±.05mm]	20	
		D	NOT	USED	
		CRIMP		SIZE	TYPE
		WIRE		.080 [2.03mm]	F
		INSUL		.140 [3.56mm]	F
		WIRE STRIP LENGTH		SET UP GAGE	LAYOUT
		TERM APPL SPEC		458637-1	L1789
		FEED		408-8040	
		APPL INSTRUCTION		408-8040	

QTY	REF	PART NO	DESCRIPTION	ITEM NO
2	2	2		129
2	2	2		128
2	2	2		127
1	1	1		126
1	1	1		125
1	1	1		124
1	1	1		123
				122
				121
REF	REF	REF		120
REF	REF	REF		119
REF	REF	REF		118
1	1	1		117
REF	REF	REF		116
REF	REF	REF		115
2	2	2		114
REF	REF	REF		113
				112
4	4	4		111
REF	REF	REF		110
				109
1	1	1		108
REF	REF	REF		107
				106
				105
				104
1	1	1		103
2	2	2		102
REF	REF	REF		101
1	1	1		100
2	2	2		99
1	1	1		98
REF	REF	REF		97
REF	REF	REF		96
REF	REF	REF		95
4	4	4		94
2	2	2		93
				92
1	1	1		91
				90
				89
				88
2	2	2		87
1	1	1		86
2	2	2		85
1	1	1		84
REF	REF	REF		83
REF	REF	REF		82
1	1	1		81
REF	REF	REF		80
-	REF	-		79
REF	-	-		78
				77
				76
				75
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1	1	1		73
REF	REF	REF		72
REF	REF	REF		71
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QTY	REF	PART NO	DESCRIPTION	ITEM NO
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				4
				3
				2
				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 SET SPACING BETWEEN ANVIL & TERMINAL SUPPORT TO .13 .
- 7 STRIP GUIDE PLATE, STRIP GUIDES, & FEED PAWL REPOSITIONING REQUIRED. FENCE SET-UP DIMENSION = .52 . FEED STROKE ADJUSTMENT REQUIRED.



DRW	R.O. WILSON	6-21-96	MATERIAL	-	HEAT TREAT	-
CHK	C. ERISMAN	6-25-96				
APVD	T. ELBIN	6-26-96				
NAME			SIDE FEED HDM APPLICATOR			
SCALE	SIZE	DRAWING NO	SHEET	OF	REV	
-	A1	680327	1	of	1	C