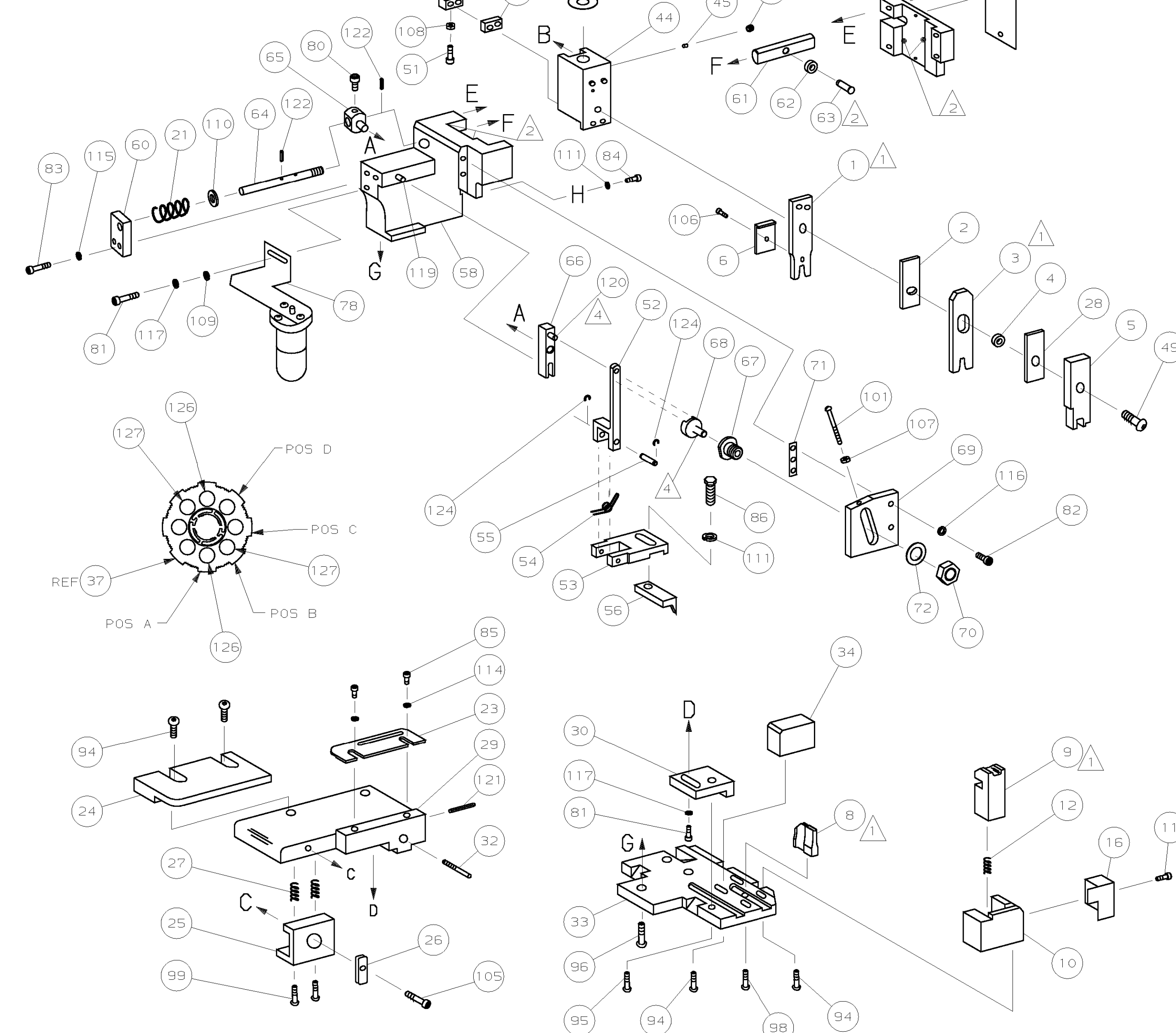
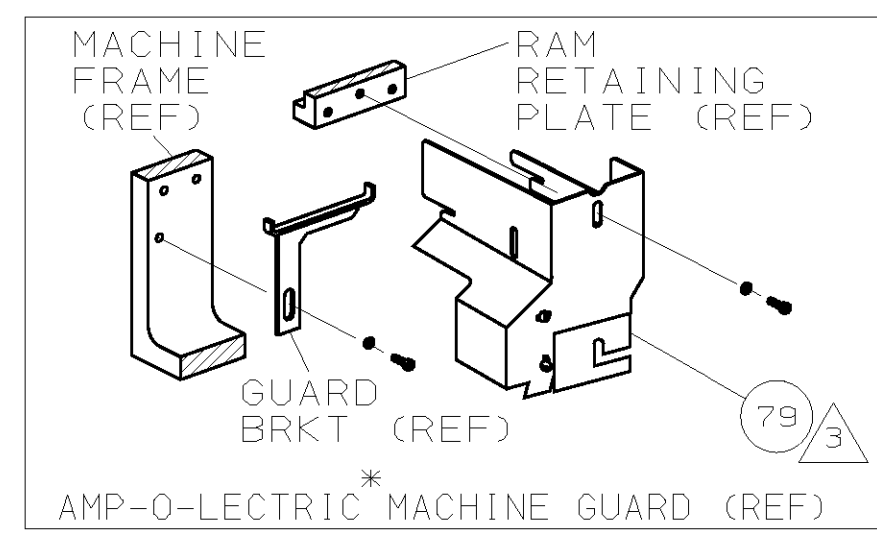
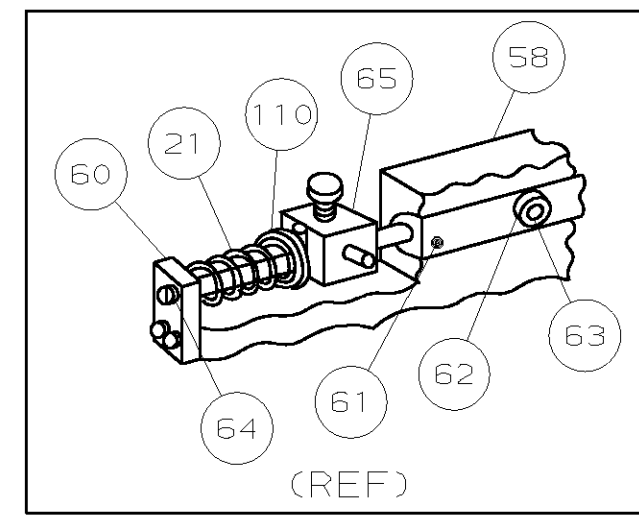
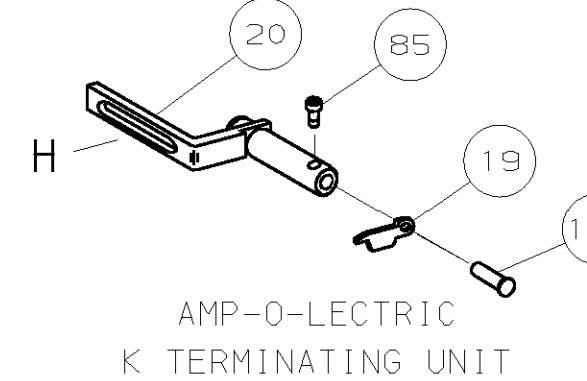
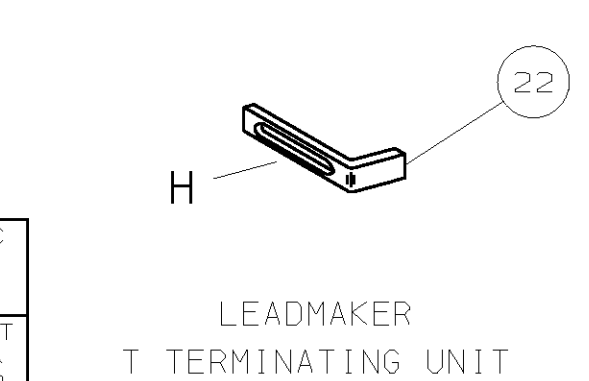
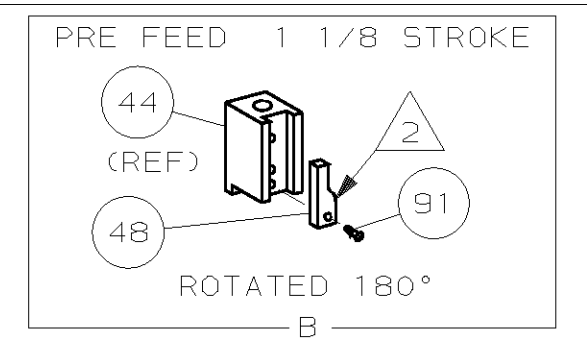
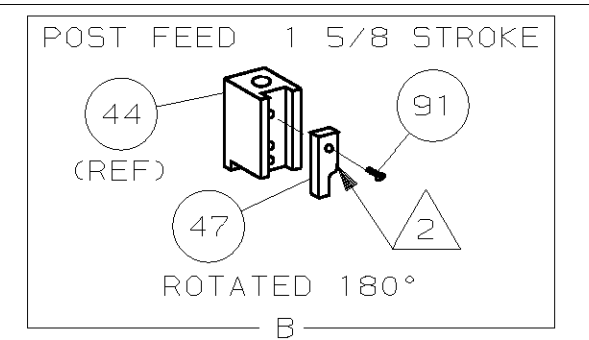


PART NUMBER	REV	FIRST USED
680046-1	A	854400-1
680046-2	A	565435-5



\* Trademark of AMP Incorporated



- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-0-ELECTRIC MACHINE.
- 4 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEM 79) ARE USED ON ITEM 46.
- 6 GOLD PLATED TERMINALS REQUIRE LUBRICATION.
- 7 CUT TO LENGTH AT ASSY.

TERMINAL NAME:		CONNECTOR ASSY-WIRE	
		776054	

CRIMPING DATA			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.047 ± .002	18	
B	.043 ± .002	20	
C	NOT	USED	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.074	F	20-18
INSUL	.087	0	.087-.095
FEED	APPL INST	SET UP GAGE	LAYOUT
.366		458637-1	L1526
WIRE STRIP LENGTH		-	

-1	LEADMAKER	MECH-POST FEED				
-2	AMP-0-ELECTRIC	MECH-PRE FEED				
REF	REF	-	B	22594-8	NUT, HEX (1/2-20)	70
REF	REF	-	B	240628-1	PLATE, ADJUSTMENT	69
REF	REF	-	B	240626-1	SHAFT, PIVOT	68
REF	REF	-	B	240633-1	BUSHING	67
REF	REF	-	A	455680-1	LEVER, INTERMEDIATE	66
REF	REF	-	B	240629-1	BLOCK, PIVOT	65
REF	REF	-	A	240632-2	SCREW, ADJ FEED ROD	64
REF	REF	-	B	240659-3	PIN, CAM ROLLER	63
REF	REF	-	B	240658-1	ROLLER, CAM	62
REF	REF	-	B	454398-2	ROD, FEED	61
REF	REF	-	A	454178-1	GUIDE, FEED ROD	60
REF	REF	-	C	454220-1	CAP, RAM	59
REF	REF	-	D	454485-1	HOUSING	58
						57
1	1	-	B	690542-2	PAWL, FEED	56
REF	REF	-	B	240624-1	PIN, FEED FINGER	55
REF	REF	-	B	691499-1	SPRING, FEED FINGER	54
REF	REF	-	B	690541-1	HOLDER, FEED FINGER	53
REF	REF	-	A	455679-1	LEVER, TERMINAL FEED ARM	52
1	1	-	A	811242-2	BUMPER, HOLDDOWN	51
1	1	-	A	690753-1	SPACER, TONKER	50
1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)	49
1	-	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST	48
-	-	-	B	690501-4	CAM, POST-FEED 1 5/8 ST	47
1	1	-	B	459456-1	APPLICATOR, BASIC (SUBASSY)	46
1	1	-	A	690191-1	PLUG, NYLON	45
1	1	-	C	455673-1	RAM	44
1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	-	A	690124-1	WASHER, RAM	42
						41
1	1	-	A	23241-6	BALL, STEEL	40
1	1	-	A	690170-1	SPRING, COMPRESSION	39
1	1	-	C	690142-1	DISC, INSULATION	38
1	1	-	D	354777-1	WIRE DISC, PLASTIC	37
1	1	-	A	22480-5	WASHER, SPRING	36
1	1	-	B	690212-1	POST, RAM	35
1	1	-	B	690786-2	SUPPORT, TERMINAL	34
REF	REF	-	D	455675-1	PLATE, BASE	33
1	1	-	A	690432-3	SCREW, ADJUSTMENT	32
						31
REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	-	C	458144-1	PLATE, STRIP GUIDE	29
1	1	-	C	2-455888-0	SPACER, FRONT SHEAR DEP	28
2	2	-	A	1-22284-0	SPRING, DRAG	27
1	1	-	B	240793-1	LEVER, DRAG RELEASE	26
1	1	-	B	240792-2	DRAG, TERMINAL	25
1	1	-	D	90765-8	GUIDE, STRIP (REAR)	24
1	1	-	A	690487-8	GUIDE, STRIP (FRONT)	23
-	-	-	B	690472-2	STRIPPER	22
REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	21
1	-	-	A	679218-1	STRIPPER WIRE STOP ASSY	20
1	-	-	B	458949-1	STRIPPER	19
						18
						17
1	1	-	B	691667-1	GUARD, CHIP (FRONT)	16
						15
						14
						13
1	1	-	A	5-22280-0	SPRING, SHEAR	12
1	1	-	B	690461-1	STOP, SHEAR	11
1	1	-	C	690459-1	HOLDER, SHEAR (FRONT)	10
1	1	-	C	1-454276-9	SHEAR, FLOAT (FRONT)	9
1	1	-	C	7-854014-6	ANVIL	8
1	1	-	C	4-240641-7	SPACER, DEPRESSOR (REAR)	7
1	1	-	B	856692-1	DEPRESSOR, WIRE	6
1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
1	1	-	B	238011-8	SPACER, BLOCK CRIMPER	4
1	1	-	C	6-683454-3	CRIMPER, INSULATION	3
1	1	-	C	1-455888-1	SPACER, CRIMPER	2
1	1	-	C	856313-1	CRIMPER, WIRE	1

QTY	REF	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
						129
						128
2	2	-	C	3-354779-6	PIN, WIRE DISC (.3170)B	127
2	2	-	C	2-354779-8	PIN, WIRE DISC (.3130)A	126
1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
REF	REF	-	A	21045-3	RING, RET "C" (Ø.187)FD FING PIN	124
						123
REF	REF	-	A	5-21028-1	PIN, SLT SPR (Ø.125x.50)ADJ ROD	122
1	1	-	A	4-21028-0	PIN, SLT SPR (Ø.093x.75)ST GDE PL	121
REF	REF	-	A	1-21030-1	PIN, DOWEL (Ø.187x.50)LEVER	120
REF	REF	-	A	1-21030-6	PIN, DOWEL (Ø.187x1.25)HOUSING	119
						118
2	1	-	A	21024-5	WASHER, LOCK (#10)ADJ BLOCK	117
REF	REF	-	A	21024-5	WASHER, LOCK (#10)ADJ PLATE	116
REF	REF	-	A	21024-5	WASHER, LOCK (#10)FEED GDE ROD	115
2	2	-	A	21024-2	WASHER, LOCK (#4)FRONT STP GUIDE	114
						113
						112
4	4	-	A	21024-4	WASHER, LOCK (#8)STRIPPER	111
REF	REF	-	A	21899-4	WASHER, FLAT (Ø5/16)SCREW ADJ	110
1	REF	-	A	21899-2	WASHER, FLAT (NO.10)LUB ASSY	109
1	1	-	A	21018-5	NUT, HEX (NO.6)HOLDDOWN	108
REF	REF	-	A	21018-5	NUT, HEX (6-32)FEED ADJ	107
1	1	-	A	1-21003-8	SCR, SKT FLAT (6-32x.25)WIRE DEP	106
1	1	-	A	22353-8	SCR, SHLD (Ø.187x.25)DRAG LEVER	105
1	-	-	A	992031-1	PIN, CLEVIS	104
1	1	-	A	21009-2	SCR, SKT SET (1/4-20x.25 LW)RAM	103
2	2	-	A	21017-2	SCR, DRIVE (#2x.19)ID PLATE	102
REF	REF	-	A	6-23715-5	SCR, PAN HD (6-32x1.50)FEED ADJ	101
1	1	-	B	461264-1	PLATE, IDENTIFICATION	100
2	2	-	A	3-21002-0	SCR, BHC (10-32x.88)DRAG	99
1	1	-	A	22733-8	SCR, BHC (8-32x.38 LW)ANVIL	98
REF	REF	-	A	2-21002-9	SCR, BHC (10-32x.75)CAP	97
REF	REF	-	A	2-22733-8	SCR, BHC (1/4-20x.62)HOUSING	96
REF	REF	-	A	2-21002-7	SCR, BHC (10-32x.50)56 ADJ BLOCK	95
6	6	-	A	2-21002-2	SCR, BHC (8-32x.50)SHEAR	94
						93
						92
1	1	-	A	1-21002-7	SCR, BHC (6-32x.38)CAM	91
						90
1	-	-	A	7-21000-9	SCR, SHC (4-40x.19)STRIPPER	89
						88
2	2	-	A	3-21000-0	SCR, SHC (8-32x.81)DEP-HOLD	87
1	1	-	A	2-22603-0	SCR, HEX HD (8-32x.31)FEED FINGER	86
2	2	-	A	1-21000-3	SCR, SHC (4-40x.25)F ST GUIDE	85
1	1	-	A	2-21000-7	SCR, SHC (8-32x.50)STRIPPER	84
REF	REF	-	A	3-21000-7	SCR, SHC (10-32x.75)FEED ROD GD	83
REF	REF	-	A	3-21000-6	SCR, SHC (10-32x.62)FD ADJ BLK	82
2	1	-	A	3-21000-4	SCR, SHC (10-32x.38)56 ADJ BL	81
REF	REF	-	A	3-21000-4	SCR, SHC (10-32x.38)PIVOT BLK	80
REF	-	-	B	455749-1	GUARD, WINDOW	79
1	REF	-	C	1-465184-0	LUBRICATOR ASSY	78
						77
						76
						75
1	1	-	A	690603-1	SPRING, ASSIST	74
1	1	-	A	23030-1	SCR, SKT CAP (6-32x.25)CP DSC	73
REF	REF	-	A	458109-1	WASHER, SPECIAL	72
REF	REF	-	A	690517-1	SPACER	71

QTY	REF	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)						
				PARTS LIST		

QTY	REF	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)						
				PARTS LIST		

LOC A  
DIST 66

LEADMAKER T TERMINATING UNIT  
AMP-0-ELECTRIC K TERMINATING UNIT

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 M. O'BRINE 10/7/93 APP 10-14-93 B. WOLFE  
 CHK 10-14-93 REL 10/26/93 C. ERISMAN B. MORGAN  
**AMP** AMP Incorporated Harrisburg, PA 17105-3608  
 NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL  
 SCALE - DWG NO 680046 SHEET 1 OF 1 REV A  
 CASE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING 1 RESTRICTED TO

THIS DRAWING IS A CONTROLLED DOCUMENT.

15-SEP-99 14:04:49 amp14442

680046