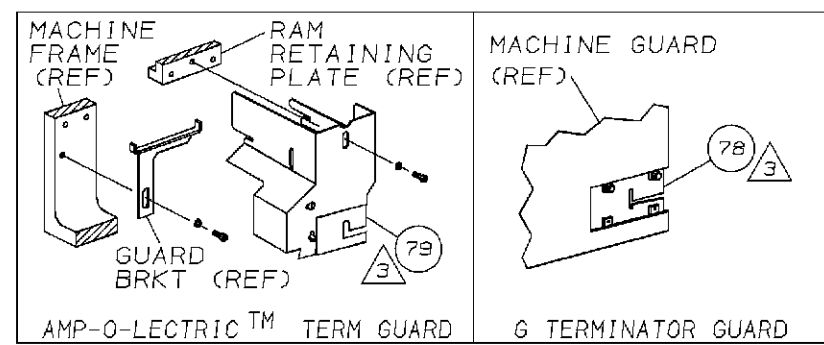


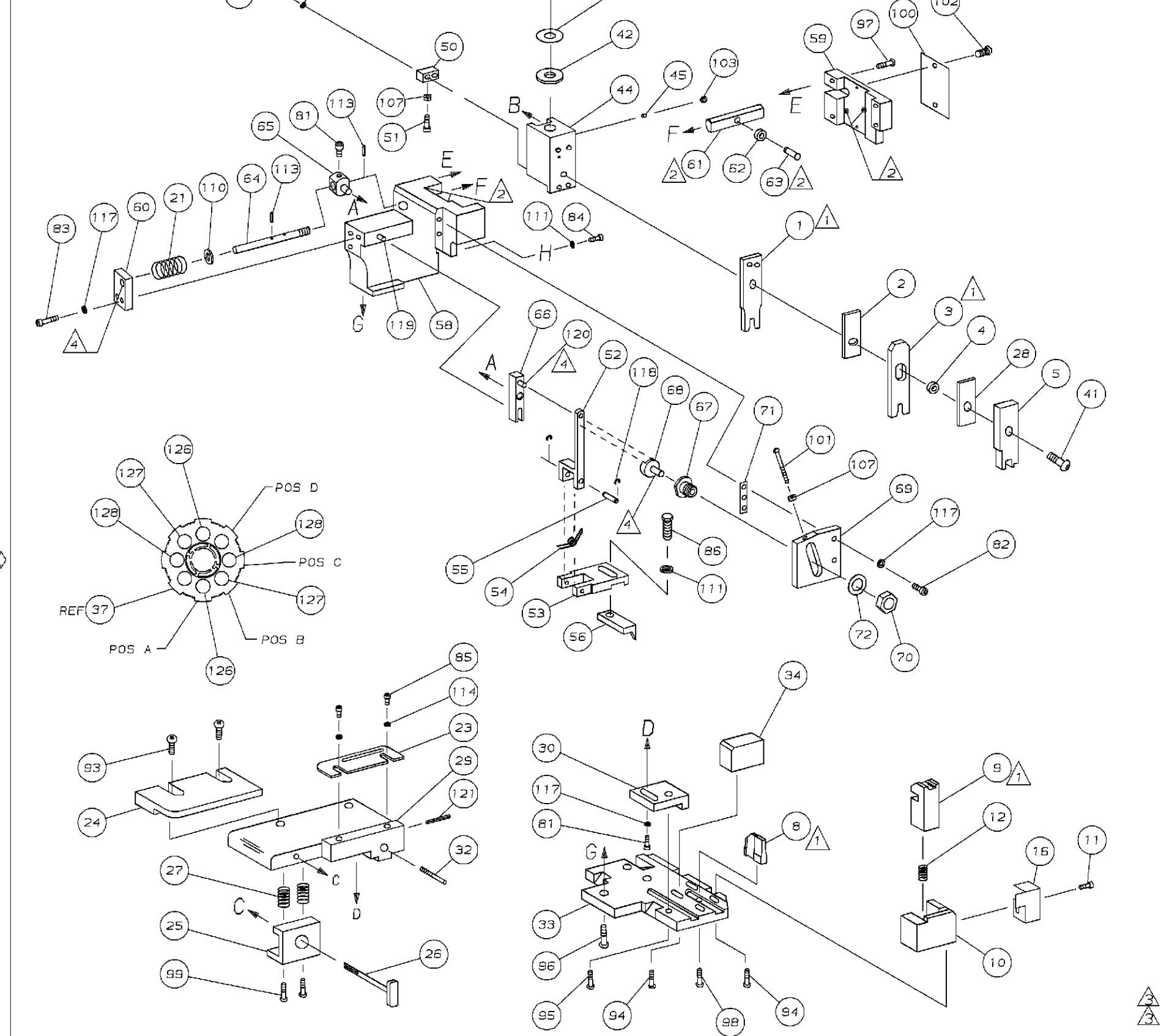
PART NUMBER	REV	FIRST USED
466791-1	D	122500-1
466791-2	D	565435-5
466791-3	D	354500-1



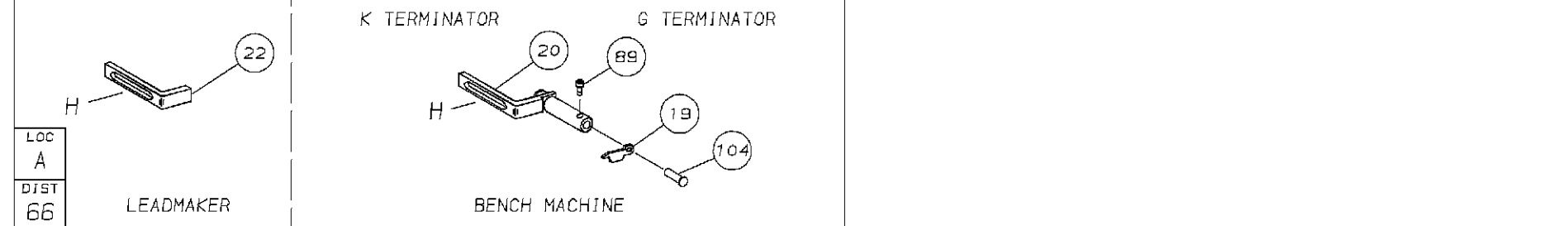
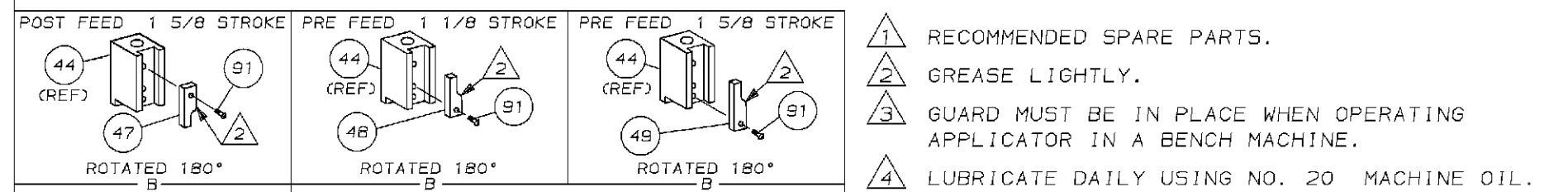
TERMINAL NAME: .250 BLADE RECEPACLE				
640841				
CRIMPING DATA				
PAD LTR	CRIMP HEIGHT	WIRE SIZE		
A	.072 ±.002 [1.83 ±0.05mm]	16		
B	.064 ±.002 [1.63 ±0.05mm]	18		
C	.061 ±.002 [1.55 ±0.05mm]	20		
D	NOT	USED		
CRIMP	SIZE	TYPE	RANGE	
WIRE	.090 [2.29mm]	F	20 - 16	
INSUL	.180 [4.57mm]	0	.145 MAX	
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE LAYOUT
-	114-1026	.690	408-8040	458637-1 1044

LEADMAKER		MECH POST FEED		
BENCH MODEL	K	MECH PRE FEED		
BENCH MODEL	G	MECH PRE FEED		
1	1	1	- B 22594-8 NUT, HEX (1/2-20) 70	
1	1	1	- B 240628-1 PLATE, ADJUSTMENT 69	
1	1	1	- B 240626-1 SHAFT, PIVOT 68	
1	1	1	- B 240633-1 BUSHING 67	
1	1	1	- A 455680-1 LEVER, INTERMEDIATE 66	
1	1	1	- B 240629-1 BLOCK, PIVOT 65	
1	1	1	- A 240632-2 SCREW, ADJ FEED ROD 64	
1	1	1	- B 240659-3 PIN, CAM ROLLER 63	
1	1	1	- B 240658-1 ROLLER, CAM 62	
1	1	1	- B 454398-2 ROD, FEED 61	
1	1	1	- A 454178-1 GUIDE, FEED ROD 60	
1	1	1	- C 454220-1 CAP, RAM 59	
1	1	1	- D 454485-1 HOUSING 58	
				57
1	1	1	- B 458537-2 PAWL, FEED 56	
1	1	1	- B 240624-1 PIN, FEED FINGER 55	
1	1	1	- B 691499-1 SPRING, FEED FINGER 54	
1	1	1	- A 690541-1 HOLDER, FEED FINGER 53	
1	1	1	- B 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	
				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 690142-1 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	
1	1	1	- D 455675-1 PLATE, BASE 33	
1	1	1	- A 690432-3 SCREW, ADJUSTMENT 32	
				31
1	1	1	- B 455689-1 BLOCK, STRIP GUIDE ADJ 30	
1	1	1	- C 455671-2 PLATE, STRIP GUIDE 29	
1	1	1	- C 1-455688-0 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 4-690504-4 GUIDE, STRIP (REAR) 24	
1	1	1	- A 690438-1 GUIDE, STRIP (FRONT) 23	
-	-	1	- B 690472-2 STRIPPER 22	
1	1	1	- 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 690461-7 STOP, SHEAR 11	
1	1	1	- C 1-690459-0 HOLDER, SHEAR (FRONT) 10	
1	1	1	- C 454276-5 SHEAR, FLOAT (FRONT) 9	
1	1	1	- C 8-458834-3 ANVIL 8	
				7
				6
1	1	1	- C 1-455889-8 DEPRESSOR, SHEAR (FRONT) 5	
1	1	1	- B 238011-8 SPACER, BLOCK CRIMPER 4	
1	1	1	- C 456135-3 CRIMPER, INSULATION 3	
1	1	1	- C 1-455888-0 SPACER, CRIMPER 2	
1	1	1	- C 1-456406-5 CRIMPER, WIRE 1	

THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INCORPORATED. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.



QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO	
2	2	2	-	C	9-354778-9	PIN, WIRE DISC (.2990)C 129	
2	2	2	-	C	9-354778-3	PIN, WIRE DISC (.2960)B 128	
2	2	2	-	C	7-354778-7	PIN, WIRE DISC (.2880)A 126	
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION 125	
1	1	1	-	A	217238-1	DOCUMENTATION PACKAGE 124	
1	1	1	-	-	4088040	SF APPL INST 408-8040 123	
						122	
1	1	1	-	A	4-21028-0	PIN, SLT SPR (#.093x.75)ST 6DE PL 121	
1	1	1	-	A	1-21030-1	PIN, DOWEL (#.187x.50)LEVER 120	
1	1	1	-	A	1-21030-6	PIN, DOWEL (#.187x1.25)HOUSING 119	
2	2	2	-	A	21045-3	RING, RET "C" (#.187)FD FING PIN 118	
5	5	5	-	A	21024-5	WASHER, LOCK (#10)ADJ BLOCK 117	
						116	
						115	
2	2	2	-	A	21024-2	WASHER, LOCK (#4)FRONT STP GUIDE 114	
2	2	2	-	A	5-21028-1	PIN, SLT SPR (#.125x.50)ADJ ROD 113	
						112	
4	4	4	-	A	21024-4	WASHER, LOCK (#8)STRIPPER 111	
1	1	1	-	A	21899-4	WASHER, FLAT (#5/16)SCREW ADJ 110	
						109	
						108	
1	2	2	-	A	21018-5	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 SET (1/4-20x.25 LW)RAM 103	
2	2	2	-	A	21017-2	SCR, DRIVE (#2x.19)ID PLATE 102	
1	1	1	-	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	
2	2	2	-	A	2-21002-9	SCR, BHC (10-32x.75)CAP 97	
3	3	3	-	A	2-22733-8	SCR, BHC (1/4-20x.62)HOUSING 96	
1	1	1	-	A	2-21002-7	SCR, BHC (10-32x.50)SG ADJ BLOCK 95	
4	4	4	-	A	2-21002-2	SCR, BHC (8-32x.50)TERM H DWN 94	
2	2	2	-	A	2-21002-3	SCR, BHC (8-32x.62)R STP GDE 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	
						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	
3	3	3	-	A	2-21000-7	SCR, SHC (8-32x.50)STRIPPER 84	
2	2	2	-	A	3-21000-7	SCR, SHC (10-32x.75)FEED ROD 6D 83	
2	2	2	-	A	3-21000-6	SCR, SHC (10-32x.62)FEED ADJ BLK 82	
2	2	2	-	A	3-21000-4	SCR, SHC (10-32x.38)SG ADJ BL 81	
						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	
1	1	1	-	A	458109-1	WASHER, SPECIAL 72	
1	1	1	-	A	690517-1	SPACER 71	
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO



DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED.			REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)		
MATL	HT TR	FIN	PARTS LIST		
-	-	-	QTY REQD PER ASSY		
DR J. BAKER 3/25/96 APP T. ELBIN 3/25/96			MACHINE REF MINI APPL		
CHK 3/25/96 REL 4/11/96 B. MORGAN			SCALE - D DWG NO 466791 SHEET 1 OF 1 REV D		
NAME SIDE FEED HDM APPLICATOR			REMOVE BURRS, BREAK SHARP EDGES R.015 MAX		

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