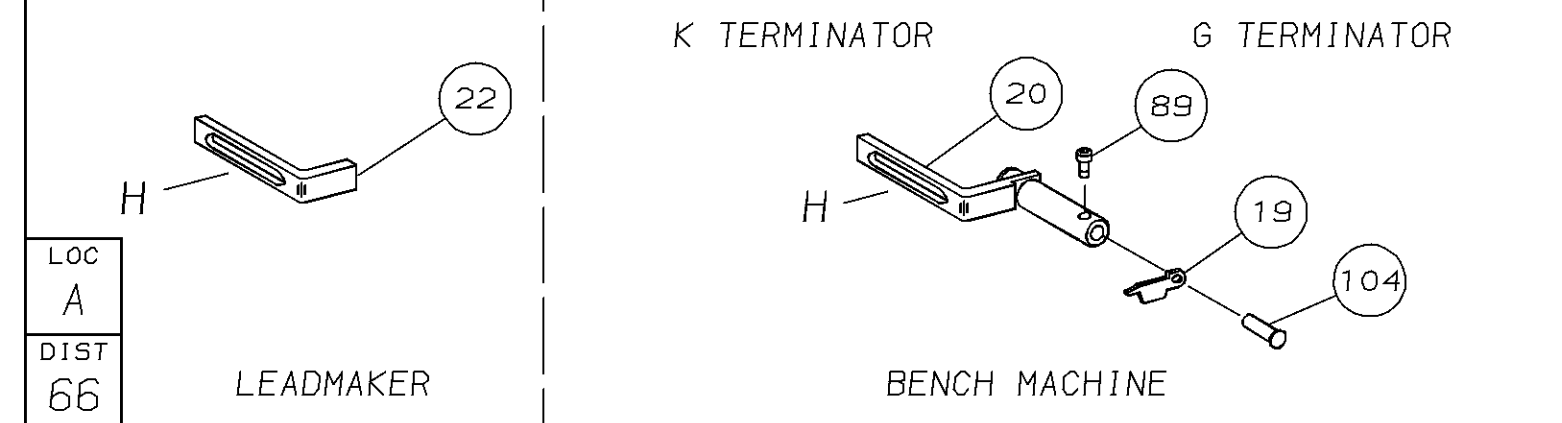
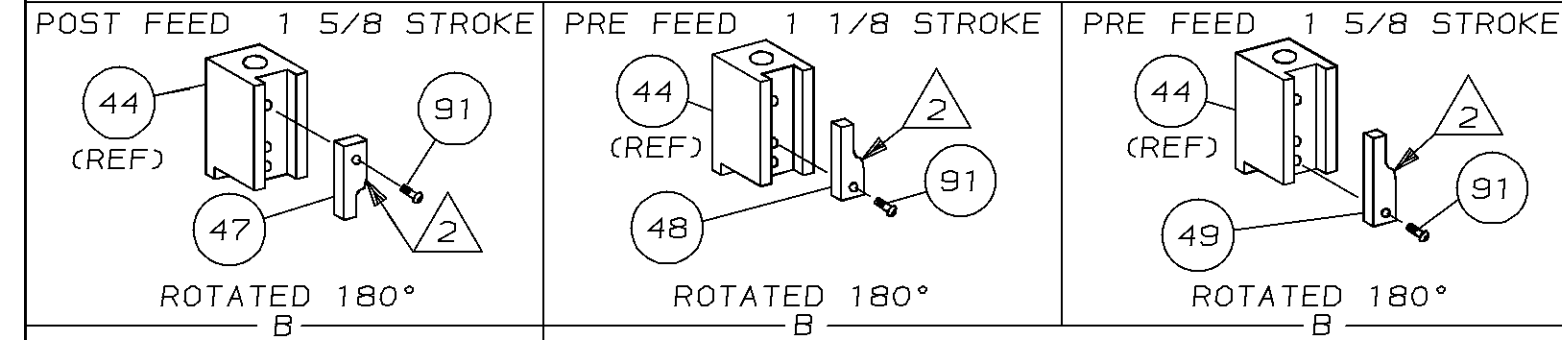
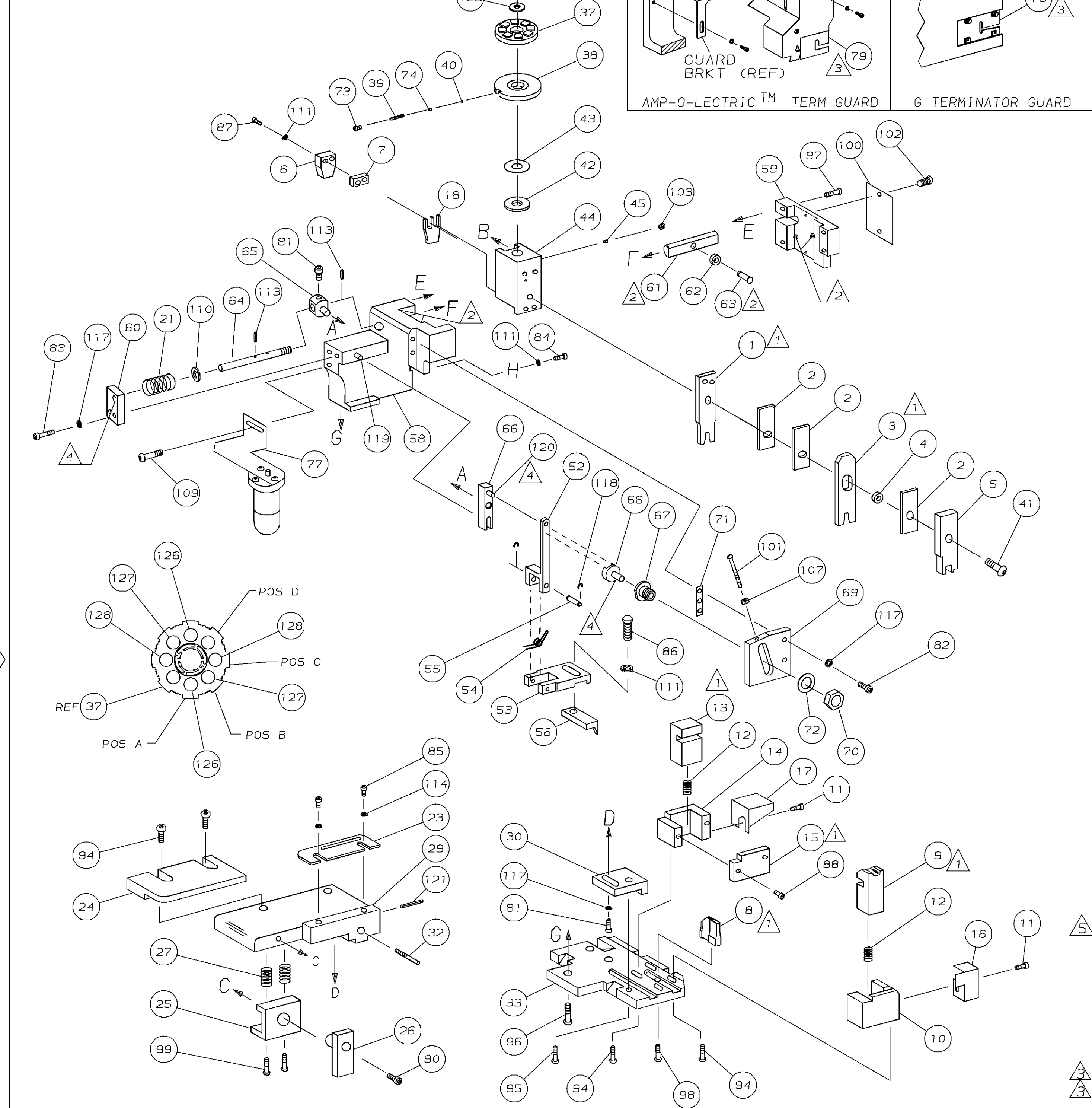


PART NUMBER	REV	FIRST USED
680461-1	B	122500-1
680461-2	B	565435-5
680461-3	B	354500-1



- 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 CUT TO LENGTH AT ASSY
- 6 GUIDE OFF INSULATION BARREL

PAD LTR		CRIMP HEIGHT		WIRE SIZE
A	.050 ± .002	[1.28 ± 0.05mm]		1 mm ²
B	.043 ± .002	[1.10 ± 0.05mm]		0.5 mm ²
C	NOT		USED	
D	NOT		USED	
CRIMP	SIZE	TYPE	RANGE	
WIRE	.090 [2.29mm]	F	0.5 mm ² -1 mm ²	
INSUL	.100 [2.54mm]	F	-	

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.218-.250	NONE	.512	408-8040	458637-1	L1926

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO	
1	1	1	-	-	-	129	
1	1	1	-	-	-	128	
2	2	2	-	C	3-354779-6	PIN, WIRE DISC (.3170)B	127
2	2	2	-	C	2-354779-2	PIN, WIRE DISC (.3100)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
1	1	1	-	-	-	-	122
1	1	1	-	A	4-21028-0	PIN, SLT SPR (Ø.093x.75) ST 6DF PL	121
1	1	1	-	A	1-21030-1	PIN, DOWEL (Ø.187x.50) LEVER	120
1	1	1	-	A	1-21030-6	PIN, DOWEL (Ø.187x1.25) HOUSING	119
2	2	2	-	A	21045-3	RING, RET "C" (Ø.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 (Ø.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 (Ø5/16) SCREW ADJ	110
-	1	-	-	A	2-21002-6	SCR, BHC (10-32x.38) LUBE ASSY	109
							108
1	1	1	-	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
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
1	1	1	-	A	22353-8	SCR, SHLD (.187x.250L6) DRAG	90
1	1	-	-	A	7-21000-9	SCR, SHC (4-40x.19) STRIPPER	89
2	2	2	-	A	1-21000-8	SCR, SHC (6-32x.50) R SHEAR PLATE	88
2	2	2	-	A	3-21000-0	SCR, SHC (8-32x1.06) 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
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
-	1	-	-	C	1-465184-0	LUBRICATOR ASSY	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

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	690542-2	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
							51
							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	690686-1	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
							34
1	1	1	-	D	455675-9	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	458144-1	PLATE, STRIP GUIDE	29
							28
2	2	2	-	A	1-22284-0	SPRING, DRAG	27
1	1	1	-	B	240793-1	LEVER, DRAG RELEASE	26
1	1	1	-	B	240792-1	DRAG, TERMINAL	25
1	1	1	-	D	7-690504-8	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
1	1	1	-	B	189369-3	HOLDER, TERMINAL	18
1	1	1	-	A	691668-1	GUARD, CHIP (REAR)	17
1	1	1	-	B	318563-1	GUARD, CHIP, FRONT	16
1	1	1	-	B	690464-4	PLATE, SHEAR (REAR)	15
1	1	1	-	B	690462-1	HOLDER, SHEAR (REAR)	14
1	1	1	-	C	690463-1	SHEAR, FLOAT (REAR)	13
2	2	2	-	A	5-22280-0	SPRING, SHEAR	12
2	2	2	-	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	1-662187-1	ANVIL	8
1	1	1	-	C	7-240641-4	SPACER, DEPRESSOR (REAR)	7
1	1	1	-	A	453393-3	DEPRESSOR, SHEAR (REAR)	6
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	238011-7	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	1213077-4	CRIMPER, INSULATION	3
3	3	3	-	C	1-455888-2	SPACER, CRIMPER	2
1	1	1	-	C	5-456406-0	CRIMPER, WIRE	1

QTY REQD PER ASSY		PARTS LIST	
DR	5/13/97	APP	5/13/97
P. MCCARTY	J. DODDS	REL	11/4/97
CHK 5/13/97	C. ERISMAN	B. MORGAN	
NAME: SIDE FEED HDM APPLICATOR			
SCALE: -		DWG NO: 680461	
MACHINE REF: MINI APPL		SHEET: 1 OF 1	
REVISION RECORD		DATE	
B	0150-8084-97	TB	10-97
A	REVISED	CE	8/97
P/F	LTR	APP	DATE

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.

THIS INFORMATION IS CONFIDENTIAL AND IS DISCLOSED TO YOU ON CONDITION THAT NO FURTHER DISCLOSURE IS MADE BY YOU TO OTHER THAN AMP PERSONNEL WITHOUT WRITTEN AUTHORIZATION FROM AMP INCORPORATED, HARRISBURG, PA.

Mouser Electronics

Authorized Distributor

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

[TE Connectivity:](#)

[680461-2](#)