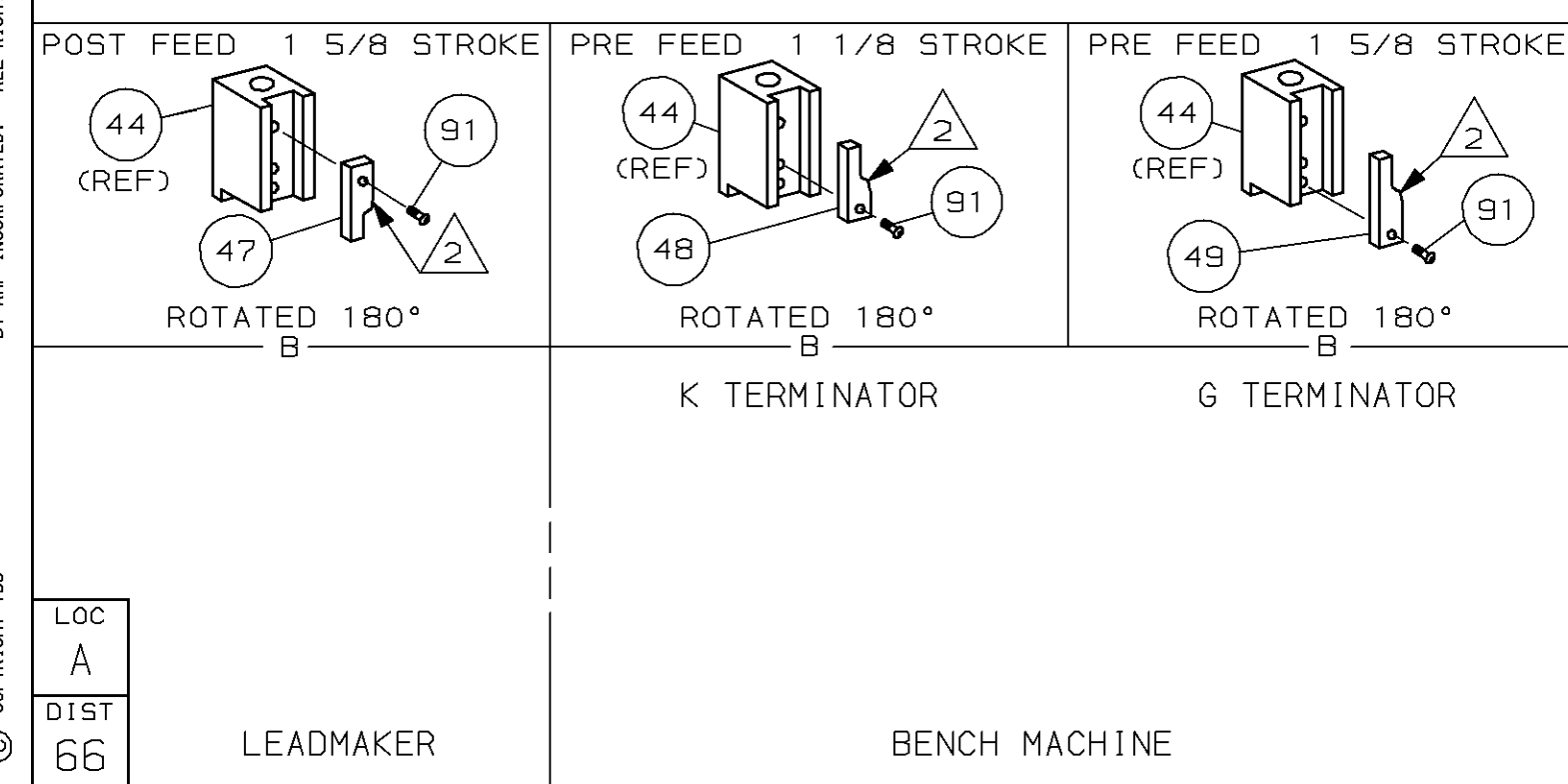
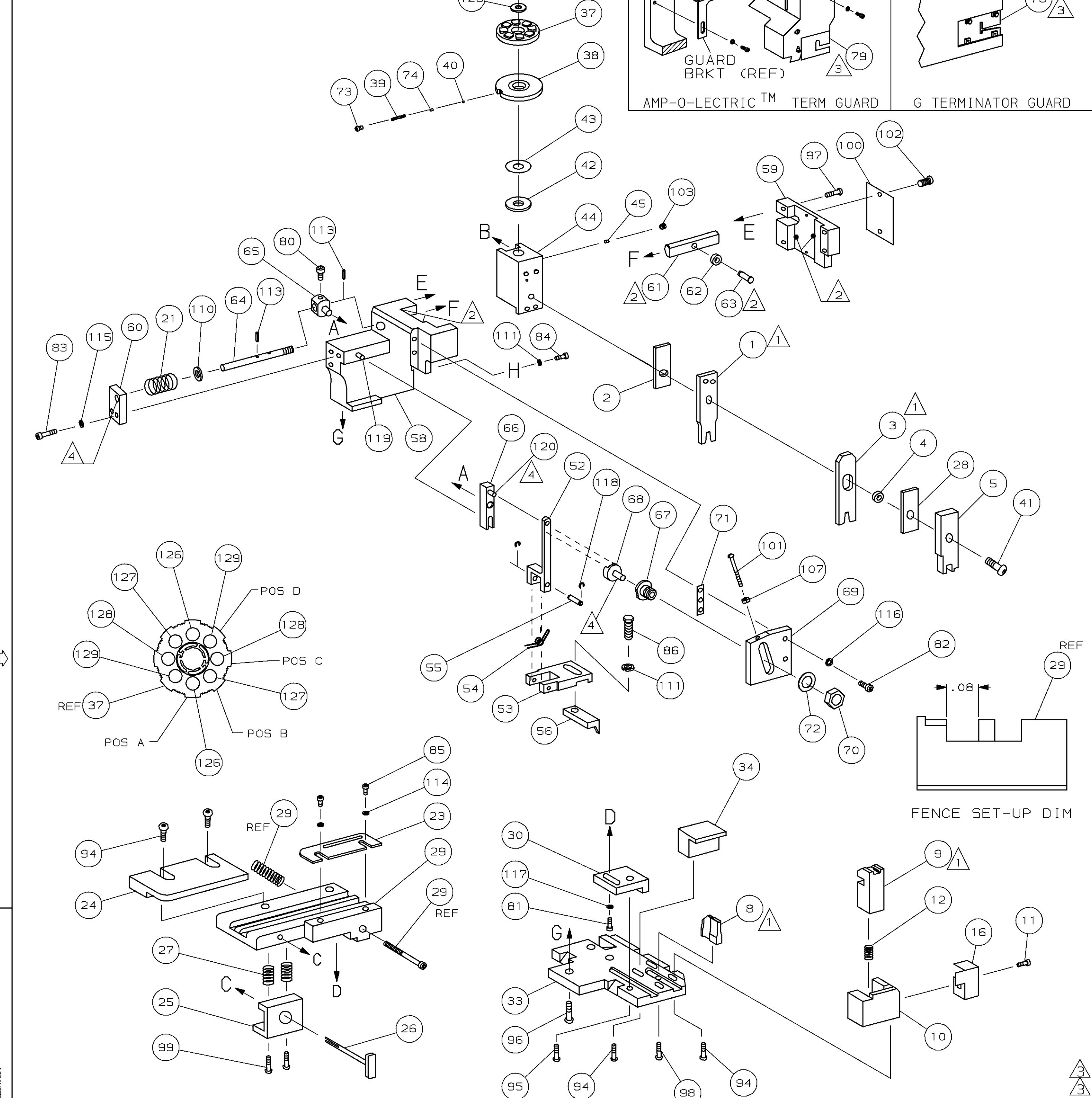


PART NUMBER	REV	FIRST USED
680572-1	A	122500-1
680572-2	A	565435-5
680572-3	A	354500-1



- 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. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
- 6 567 MAX CMA FOR 24 GA WIRE

TERMINAL NAME: RECEPTACLE			
286679	CRIMP DATA (COMP TERMINAL-AMP SPEC)		
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.035 ± .002 [0.89 ± 0.05mm]	22	
B	.031 ± .002 [0.79 ± 0.05mm]	24	
C	.029 ± .002 [0.74 ± 0.05mm]	26	
D	.027 ± .002 [0.69 ± 0.05mm]	28	
CRIMP	SIZE	TYPE	RANGE
WIRE	.042 [1.07mm]	F	28-22
INSUL	.062 [1.57mm]	F	.063-.094

QTY REQD PER ASSY	TERM	APPL	SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.063-.094	NONE			.275	408-8040	458637-1	L2031
2	2	2	-	C	6-354779-2	PIN, WIRE DISC (.3300)D	129
2	2	2	-	C	5-354779-8	PIN, WIRE DISC (.3280)C	128
2	2	2	-	C	5-354779-4	PIN, WIRE DISC (.3260)B	127
2	2	2	-	C	4-354779-6	PIN, WIRE DISC (.3220)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
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
2	2	2	-	A	21024-4	WASHER, LOCK (#8) STRIPPER	111
REF	REF	REF	-	A	21899-4	WASHER, FLAT (Ø5/16) SCREW ADJ	110
REF	REF	REF	-	A	21068-5	NUT, HEX (6-32) FEED ADJ	107
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
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
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38) CAM	91
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
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 REQD PER ASSY	TERM	APPL	SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
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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
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1	1	1	-	A	23030-1	SCR, SHC (6-32x.25 SL) INS DISC	73
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REF	REF	REF	-	A	690517-1	SPACER	71
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY PARTS LIST

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED.

DR C.ERISMAN 02JAN98 APP T.ELBIN 02JAN98

CHK 02JAN98 REL -

C.ERISMAN

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL

SCALE - DWG NO 680572 SHEET 1 OF 1 REV A

REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

CUSTOMER AND ASSEMBLY DRAWING

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