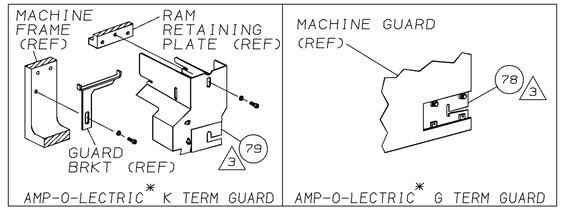
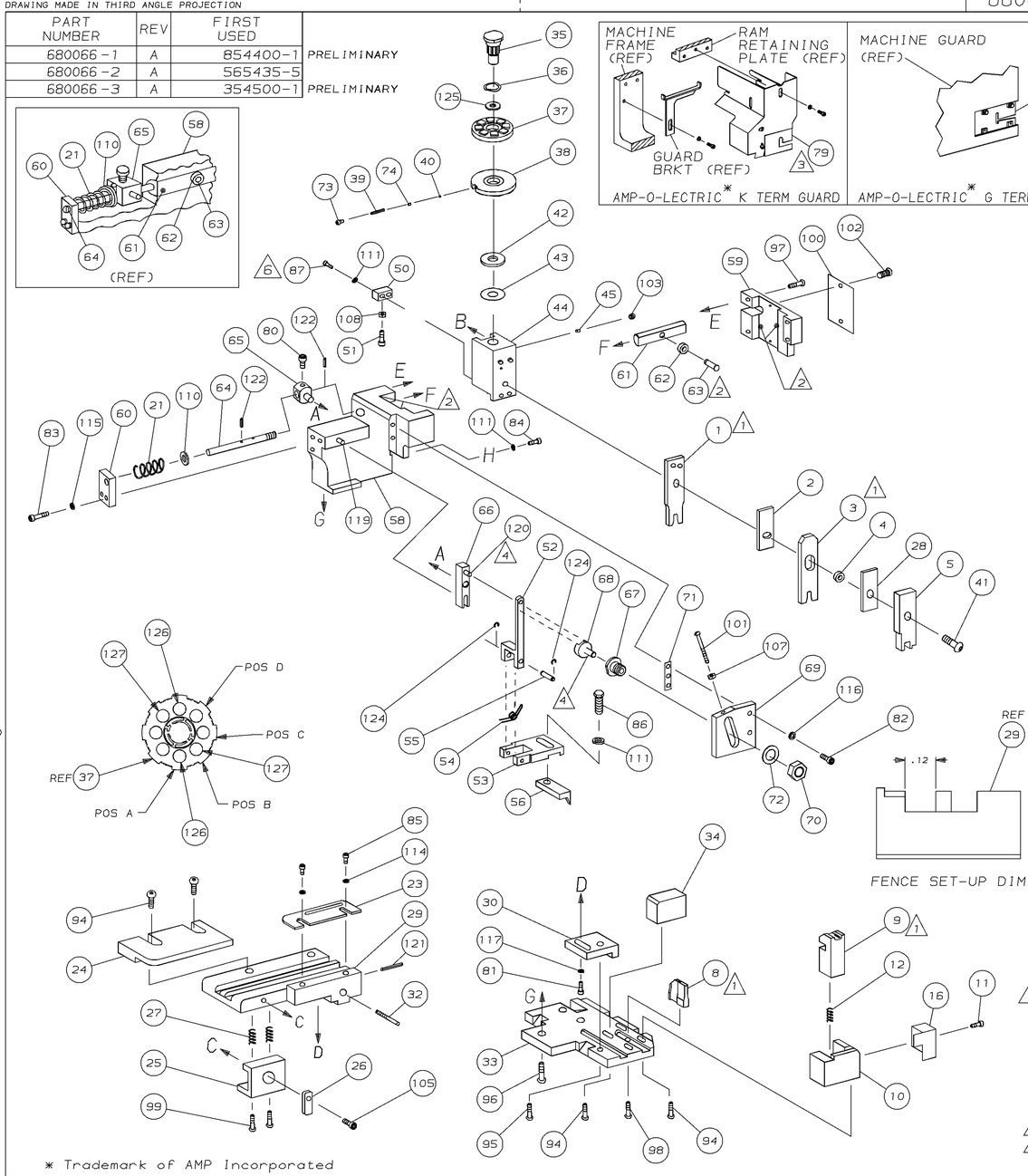
DRAWING MADE IN THIRD ANGLE PROJECTION

PART NUMBER	REV	FIRST USED	
680066-1	A	854400-1	PRELIMINARY
680066-2	A	565435-5	
680066-3	A	354500-1	PRELIMINARY

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.





* Trademark of AMP Incorporated

TERMINAL NAME: TERM, .090 II, NON SEALED		
RECPT △7		TAB
63766		63763
TERM APPL SPEC 114-2036		

CRIMPING DATA			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	STOCK THICKNESS
A	.065 ±.002	2 mm²	0.3mm
B △7	.059 ±.002	2 mm²	0.25mm
C	NOT USED		
D	NOT USED		
CRIMP	SIZE	TYPE	RANGE
WIRE	.110	F	2 mm²
INSUL	.120	F	1.40-2.54mm
△7 FEED .394 .492	APPL INST 408-8040	SET UP GAGE 458637-1	LAYOUT SIM TO L1549
WIRE STRIP LENGTH –			

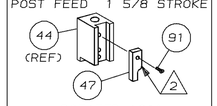
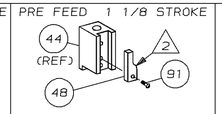
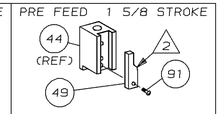
-1	LEADMAKER	MECH POST FEED
-2	BENCH MODEL K	MECH PRE FEED
-3	BENCH MODEL G	MECH PRE FEED

-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO	
							129	
							128	
2	2	2	–	C	354779-4	PIN, WIRE DISC (.3010) B	127	
2	2	2	–	C	9-354778-1	PIN, WIRE DISC (.2950) A	126	
1	1	1	–	A	986950-1	WASHER, FLAT PRECISION	125	
REF	REF	REF	–	A	21045-3	RING, RET "C" (ø.187) FD FING PIN	124	
							123	
REF	REF	REF	–	A	5-21028-1	PIN, SLT SPR (ø.125x.50) ADJ ROD	122	
1	1	1	–	A	4-21028-0	PIN, SLT SPR (ø.093x.75) ST GDE PL	121	
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	
							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	
							113	
							112	
4	4	4	–	A	21024-4	WASHER, LOCK (#8) STRIPPER	111	
REF	REF	REF	–	A	21899-4	WASHER, FLAT (ø5/16) SCREW ADJ	110	
							109	
1	1	1	–	A	21018-5	NUT, HEX (NO.6) HOLDDOWN	108	
REF	REF	REF	–	A	21018-5	NUT, HEX (6-32) FEED ADJ	107	
							106	
1	1	1	–	A	22353-8	SCR, SHLD (ø.187X.25) DRAG LEVER	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	
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	
4	4	4	–	A	2-21002-2	SCR, BHC (8-32x.50) SHEAR	94	
							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	
2	2	2	–	A	2-21000-7	SCR, SHC (8-32x.48) HOLDDOWN	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	
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	△3
REF	–	–	–	B	679532-1	INSERT, GUARD	78	△3
							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	
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 — PARTS LIST — REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO	
1	1	1	–	A	22480-5	WASHER, SPRING	36	
1	1	1	–	B	690212-1	POST, RAM	35	
1	1	1	–	B	690786-4	SUPPORT, TERMINAL	34	
REF	REF	REF	–	D	455675-1	PLATE, BASE	33	
1	1	1	–	A	690432-3	SCREW, ADJUSTMENT	32	
							31	
REF	REF	REF	–	B	455689-1	BLOCK, STRIP GUIDE ADJ	30	
1	1	1	–	C	843869-1	PLATE, STRIP GUIDE	29	
1	1	1	–	C	1-455888-9	SPACER, FRONT SHEAR DEP	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	6-690504-6	GUIDE, STRIP (REAR)	24	△8
1	1	1	–	A	690438-1	GUIDE, STRIP (FRONT)	23	
–	–	1	–	B	690472-2	STRIPPER	22	
REF	REF	REF	–	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	691667-1	GUARD, CHIP (FRONT)	16	
							15	
							14	
							13	
1	1	1	–	A	5-22280-0	SPRING, SHEAR	12	
1	1	1	–	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	1	–	C	6-683403-4	ANVIL	8	△1
							7	
							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	7-456134-3	CRIMPER, INSULATION	3	△1
1	1	1	–	C	455888-9	SPACER, CRIMPER	2	
1	1	1	–	C	3-456408-3	CRIMPER, WIRE	1	△1

QTY REQD PER ASSY — PARTS LIST — REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

POST FEED 1 5/8 STROKE	PRE FEED 1 1/8 STROKE	PRE FEED 1 5/8 STROKE
		
ROTATED 180°	ROTATED 180°	ROTATED 180°

T TERMINATING UNIT

LEADMAKER

K TERMINATING UNIT

BENCH MACHINE

G TERMINATING UNIT

△1 RECOMMENDED SPARE PARTS.

△2 GREASE LIGHTLY.

△3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-O-LECTRIC 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 CUT TO LENGTH AT ASSY

△7 TO RUN RECEPTACLE, FEED MUST BE .492

△8 GUIDES ON INSULATION BARREL

P F	LTR	REVISION RECORD	CE APP	DATE
	A	0150-5237-94		2-94

DIMENSIONS IN INCHES.
DO NOT SCALE PRINT.
TOLERANCES UNLESS OTHERWISE SPECIFIED,
2 PLC DEC ±.02
3 PLC DEC ±-
4 PLC DEC ±-
ANGLES ±-
SURF TEXTURE: √
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL	HT TR	FIN
–	–	–
–	–	–

DR JC BAKER 12/15/93	APP BA WOLFE 12/20/93	AMP Incorporated Harrisburg, PA 17105-3608
CHK C.ERISMAN 12/20/93	REL B. MORGAN 1/10/94	

NAME SIDE FEED HDM APPLICATOR — MACHINE REF MINI APPL

SCALE	DWG NO	SHEET	REV
–	680066	1 OF 1	A

LOC A — DIST 66

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.