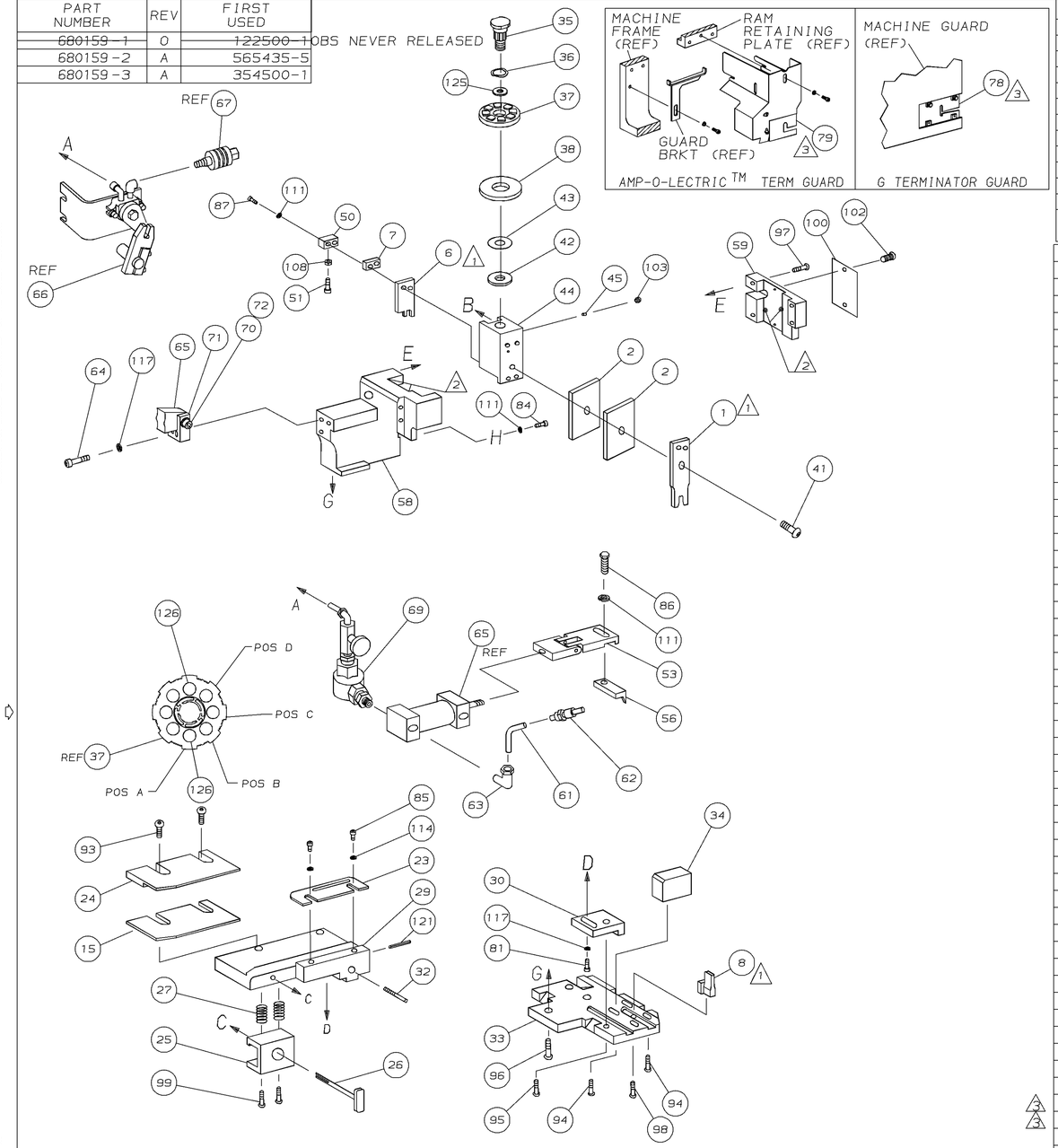
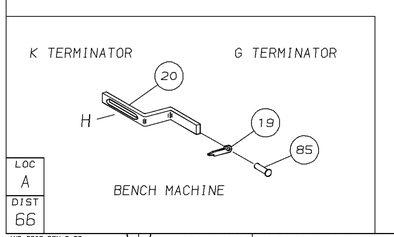
DRAWING MADE IN THIRD ANGLE PROJECTION

<US1618>DEPTPROJB>U.1618>U.FTB

PART NUMBER	REV	FIRST USED
~~680159-1~~	~~0~~	~~122500-1~~ OBS NEVER RELEASED
680159-2	A	565435-5
680159-3	A	354500-1



1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
4. SEE DRAWING FOR COMPONENTS



TERMINAL NAME: PIN CONTACT (ON BANDOLEER)

188634

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.061 ±.002 [1.55 ±0.05mm]	0.75mm²
B	NOT	USED
C	NOT	USED
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.099 [2.51mm]	0	0.75mm²
INSUL	-	-	-

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
–	114-10026	.217	408-8040	458637-1	L1636

							129
							128
							127
2	2	–	–	C	354779-6	PIN, WIRE DISC (.3020)A	126
1	1	–	–	A	986950-1	WASHER, FLAT PRECISION	125
							124
							123
							122
1	1	–	–	A	4-21028-0	PIN,SLT SPR(ø.093x.75)ST GDE PL	121
							120
							119
							118
1	3	–	–	A	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
							116
							115
2	2	–	–	A	21024-2	WASHER,LOCK(#4)SHEAR BLOCK	114
							113
							112
4	4	–	–	A	21024-4	WASHER,LOCK(#8)STRIPPER	111
1	1	–	–	A	1-21000-4	SCR,SHC(4-40x.38)SLUG BLADE	110
							109
1	1	–	–	A	21018-5	NUT,HEX(6-32)HOLDOWN	108
							107
							106
							105
							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
							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
4	4	–	–	A	2-21002-9	SCR,BHC(10-32x.75)CAP	97
3	3	–	–	A	2-22733-8	SCR,BHC(1/4-20x.62)HSG	96
1	1	–	–	A	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLK	95
4	4	–	–	A	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
2	2	–	–	A	2-21000-3	SCR,BHC(3-32x.25)R STP GDE	93
							92
							91
							90
							89
							88
2	2	–	–	A	2-21000-9	SCR,SHC(8-32x.75)SLUG BLADE	87
1	1	–	–	A	2-22603-1	SCR,HEX HD(8-32x.38)FEED FINGER	86
3	3	–	–	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
							83
							82
1	1	–	–	A	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
							80
–	1	–	–	B	462992-7	GUARD ASSY	79
REF	–	–	–	B	679532-1	INSERT, GUARD	78
							77
							76
							75
							74
							73
1	1	–	–	A	4-21002-8	SCR,BHC(3/8x1.00)FEED MT	72
1	1	–	–	B	459610-3	MOUNT, FEED BRACKET	71
–3	–2	–	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY					PARTS LIST		

–2	BENCH MODEL K				AIRFEED		
–3	BENCH MODEL G				AIRFEED		
1	1	–	–	A	21024-8	WASHER,LOCK(3/8)FEED BRKT	70
–	1	–	–	C	692655-5	AIR FEED VALVE ASSY	69
							68
–	REF	–	–	A	24042-2	VALVE, SHUT OFF	67
–	REF	–	–	C	692655-6	AIR FEED VALVE ASSY	66
1	1	–	–	B	461065-1	AIR FEED ASSEMBLY	65
2	2	–	–	A	3-21000-7	SCR,SHC 10-32x.75 AIR ASSY	64
1	–	–	–	A	22294-6	ELBOW, TUBING 1/8 NPT	63
1	–	–	–	A	23238-1	QUICK DISCONNECT	62
21.00	–	–	IN	A	27319-4	TUBING, POLY-FLO ø.25	61
							60
1	1	–	–	C	454220-1	CAP, RAM	59
1	1	–	–	D	454485-1	HOUSING	58
							57
1	1	–	–	B	694433-2	PAWL, FEED	56
							55
							54
1	1	–	–	B	461062-1	FEED FINGER ASSY	53
							52
1	1	–	–	A	811242-2	BUMPER, HOLDDOWN	51
1	1	–	–	A	690753-1	SPACER, TONKER	50
							49
							48
							47
							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
1	1	–	–	A	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41
							40
							39
1	1	–	–	A	690223-2	SPACER, INSULATION DISC	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	690786-1	SUPPORT, TERMINAL	34
1	1	–	–	D	455675-1	PLATE, BASE	33
1	1	–	–	A	690432-3	SCREW, ADJUSTMENT	32
							31
1	1	–	–	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	–	–	C	224809-1	PLATE, STRIP GUIDE	29
							28
2	2	–	–	A	1-22284-0	SPRING, DRAG	27
1	1	–	–	B	690546-1	LEVER, DRAG RELEASE	26
1	1	–	–	B	224815-1	DRAG, HOLDDOWN	25
1	1	–	–	D	690440-6	GUIDE, STRIP (REAR)	24
1	1	–	–	B	690438-6	GUIDE, STRIP (FRONT)	23
							22
							21
1	1	–	–	A	458950-1	BRACKET, WIRE STOP	20
1	1	–	–	A	217993-1	STRIPPER	19
							18
							17
							16
1	1	–	–	B	224810-1	GUIDE	15
							14
							13
							12
							11
							10
							9
1	1	–	–	C	224813-1	ANVIL	8
1	1	–	–	C	1-240641-7	SPACER, DEPRESSOR (REAR)	7
1	1	–	–	B	224814-1	BLADE, SLUG	6
							5
							4
							3
2	2	–	–	C	5-455888-6	SPACER, CRIMPER	2
1	1	–	–	C	224819-1	CRIMPER, WIRE	1
–3	–2	–	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY					PARTS LIST		

680159

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

P	F	LTR	REVISION RECORD	APP	DATE
		A	REVISED	CE	6/95

DIMENSIONS IN INCHES.
DO NOT SCALE PRINT.
TOLERANCES UNLESS OTHERWISE SPECIFIED,
2 PLC DEC ±.25
3 PLC DEC ±-
4 PLC DEC ±-
ANGLES ± -
SURF TEXTURE, √
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL – HT TR – – FIN – –

DR 4/26/95 M.OBRINE APP 4-26-95 T. BEDDICK
CHK 4-26-95 C. ERISMAN REL 8/7/95 B. MORGAN

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR MACHINE MINI REF APPL

SCALE – D DWG NO 680159 SHEET 1 OF 1 REV A

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