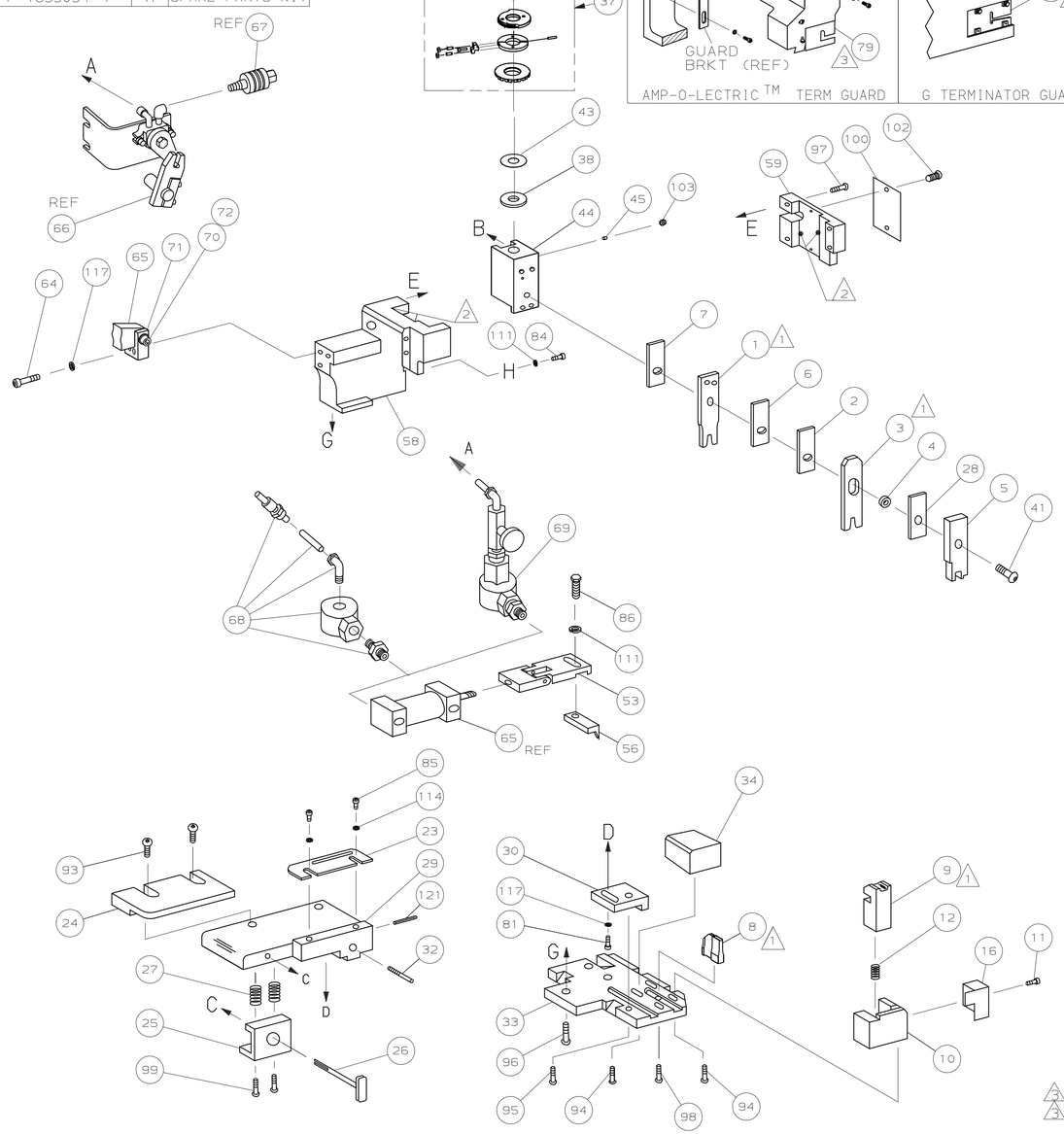
DRAWING MADE IN THIRD ANGLE PROJECTION

/home/us014442/dm.tecmod

PART NUMBER	REV	FIRST USED
1855054-1	A	122500-1
1855054-2	A	565435-5
1855054-3	A	354500-1
7-1855054-7	A	SPARE PARTS KIT



TERMINAL NAME: .312 SERIES LOCK RECPT FLAG TYPE (L) & (R)

172795-1
172796-1

CRIMPING DATA

REF SETTING	CRIMP HEIGHT ✳	WIRE SIZE
B1	1.78 ±0.05 [.070 ±.005IN]	14
D2	1.5 ±0.05 [.059 ±.002IN]	16
E2	1.34 ±0.05 [.053 ±.002IN]	18
E5	1.3 ±0.05 [.051 ±.002IN]	20

CRIMP	SIZE	TYPE	RANGE
WIRE	2.29 [.090 IN]	F	20-14
INSUL	3.56 [.140 IN]	F	2.16-3.43

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
6.5-7.5mm	114-5079	23.21	408-8040,408-8490	458637-1	L1429

-77	-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
								129
								128
								127
								126
								125
-	1	1	1	-	-	4088490	FINE ADJUST INST 408-8490	124
-	1	1	1	-	-	4088040	SF APPL INST 408-8040	123
								122
-	1	1	1	-	A	4-21028-0	PIN,SLT SPR(ø.093x.75)ST GDE PL	121
								120
								119
								118
-	3	3	3	-	A	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
								116
								115
-	2	2	2	-	A	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
								113
								112
-	2	2	2	-	A	21024-4	WASHER,LOCK(#8)STRIPPER	111
								110
								109
								108
								107
								106
								105
								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
								101
-	1	1	1	-	B	461264-5	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
-	4	4	4	-	A	2-21002-9	SCR,BHC(10-32x.75)CAP	97
-	3	3	3	-	A	2-22733-8	SCR,BHC(1/4-20x.62)HSG	96
-	1	1	1	-	A	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLK	95
-	4	4	4	-	A	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
-	2	2	2	-	A	2-21002-1	SCR,BHC(3-32x.38)R STP GDE	93
								92
								91
								90
								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
-	1	1	1	-	A	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
								83
								82
-	1	1	1	-	A	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
								80
-	-	1	-	-	B	462992-5	GUARD ASSY	79
-	REF	-	-	-	B	679532-1	INSERT, GUARD	78
								77
								76
								75
								74
								73
-	1	1	1	-	A	4-21002-8	SCR,BHC(3/8x1.00)FEED MT	72
-	1	1	1	-	B	459610-1	MOUNT, FEED BRACKET	71
-77	-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY — PARTS LIST

	-1	LEADMAKER	AIRFEED	-77	SPARE PARTS KIT
	-2	BENCH MODEL K	AIRFEED		
	-3	BENCH MODEL G	AIRFEED		

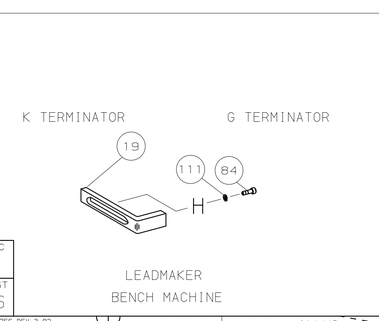
-77	-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-	1	1	1	-	A	21024-8	WASHER,LOCK(3/8)FEED BRKT	70
-	-	1	-	-	C	692655-5	AIR FEED VALVE ASSY	69
-	1	-	1	-	C	692655-7	AIR FEED VALVE ASSY	68
-	-	REF	-	-	A	24042-2	VALVE, SHUT OFF	67
-	-	REF	-	-	C	692655-6	AIR FEED VALVE ASSY	66
-	1	1	1	-	B	461065-1	AIR FEED ASSY (1 INCH)	65
-	2	2	2	-	A	3-21000-8	SCR,SHC(10-32x.88)AIR ASSY	64
								63
								62
								61
								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
								55
								54
-	1	1	1	-	B	461062-1	FEED FINGER ASSY	53
								52
								51
								50
								49
								48
								47
								46
-	1	1	1	-	A	690191-1	PLUG, NYLON	45
-	1	1	1	-	C	819307-4	RAM	44
-	1	1	1	-	A	690125-1	WASHER, LAMINATED	43
								42
-	1	1	1	-	A	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41
								40
								39
-	1	1	1	-	C	469367-1	SPACER, FINE ADJUST	38
-	1	1	1	-	D	879103-2	FINE ADJUST HEAD SUBASSY	37
								36
								35
-	1	1	1	-	B	856661-1	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	455671-1	PLATE, STRIP GUIDE	29
-	1	1	1	-	C	1-455888-4	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	856682-1	GUIDE, STRIP (REAR)	24
-	1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
								22
								21
								20
-	1	1	1	-	B	690472-1	STRIPPER	19
								18
								17
-	1	1	1	-	B	318563-2	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	690459-5	HOLDER, SHEAR (FRONT)	10
-	1	1	1	-	C	454276-8	SHEAR, FLOAT (FRONT)	9
1	1	1	1	-	C	5-683403-1	ANVIL	8
-	1	1	1	-	C	455888-5	SPACER, CRIMPER	7
-	1	1	1	-	C	1-455888-2	SPACER, CRIMPER	6
-	1	1	1	-	C	1-455889-3	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	-	B	1-238011-0	SPACER, BLOCK CRIMPER	4
1	1	1	1	-	C	7-456134-7	CRIMPER, INSULATION	3
-	1	1	1	-	C	2-455888-1	SPACER, CRIMPER	2
1	1	1	1	-	C	4-456406-1	CRIMPER, WIRE	1

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

QTY REQD PER ASSY — PARTS LIST

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

✳ WARNING:
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN REQ'D CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



LOC A
DIST 66

P	F	LTR	REVISION RECORD	APP	DATE
		A1	ECR-06-011154	CE	MAY06

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 C.ERISMAN 20MAR06 | APP T.ELBIN 20MAR06
CHK C.ERISMAN 20MAR06 | REL - -

AMP Incorporated, Harrisburg, PA 17105-3608

NAME FINE ADJUST SIDE FD HDM APPL | MACHINE REF MINI APPL
SCALE - | D | DWG NO 1855054 | SHEET 1 OF 1 | REV A1

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO -

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