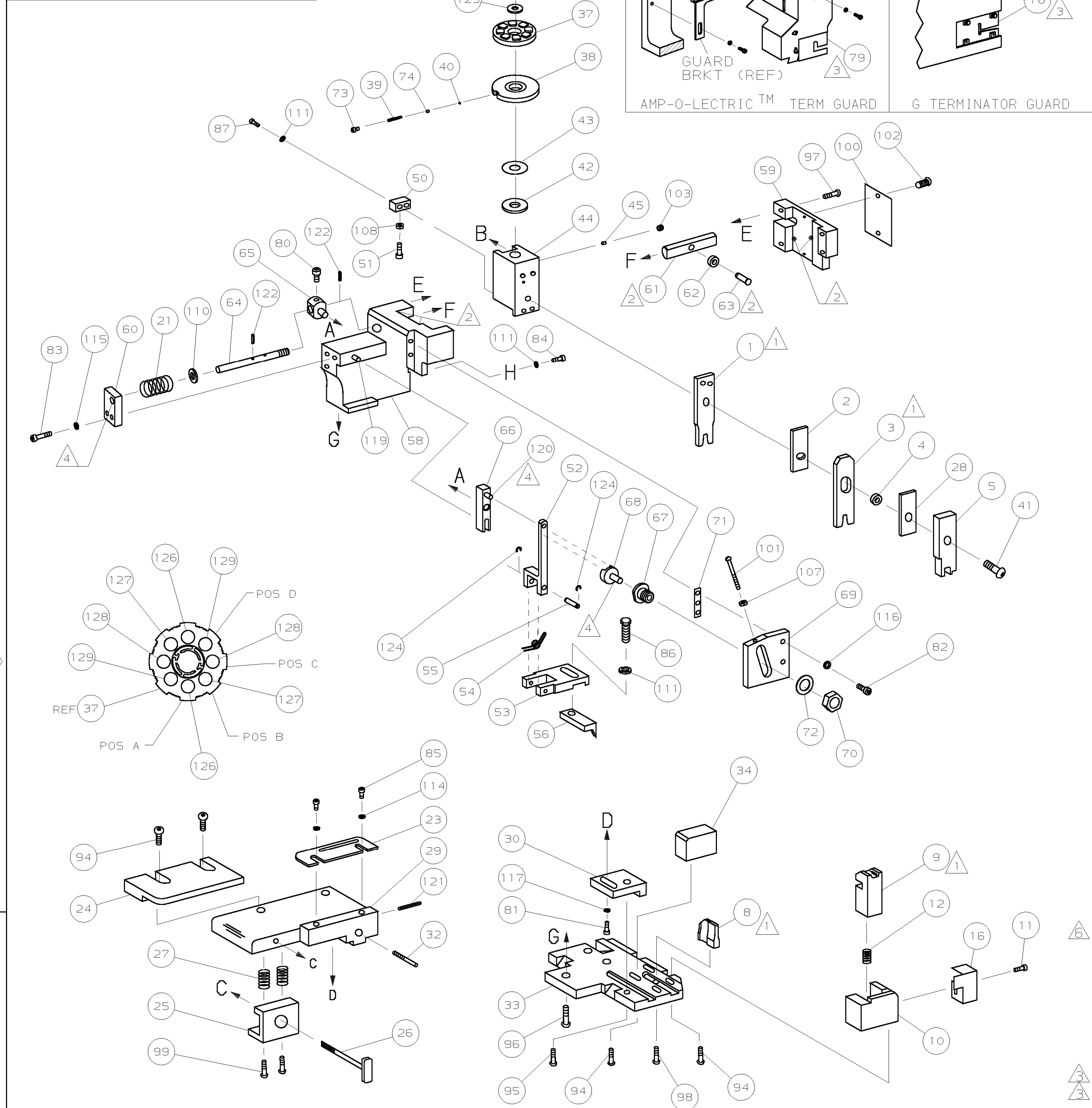


PART NUMBER	REV	FIRST USED
680206-1	C	122500-1
680206-2	C	565435-5
680206-3	C	354500-1



POST FEED 1 5/8 STROKE

PRE FEED 1 1/8 STROKE

PRE FEED 1 5/8 STROKE

ROTATED 180°

ROTATED 180°

ROTATED 180°

K TERMINATOR

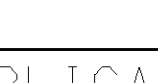
G TERMINATOR

LEADMAKER

BENCH MACHINE

- 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 CUT TO LENGTH AT ASSY

TERMINAL NAME: MAG-MATE™ POKE-IN TAB											
			281622		CRIMPING DATA						
			281623		PAD LTR	CRIMP HEIGHT		WIRE SIZE			
					A	.058 ±.002 [1.47 ±0.05mm]		1mm²			
					B	.054 ±.002 [1.37 ±0.05mm]		0.75mm²			
					C	.050 ±.002 [1.27 ±0.05mm]		0.5mm²			
					D	.048 ±.002 [1.22 ±0.05mm]		0.3mm²			
					CRIMP	SIZE	TYPE	RANGE			
					WIRE	.090 [2.29mm]	F	0.3mm²-1mm²			
					INSUL	.140 [3.56mm]	F	3mm MAX			
WIRE STRIP LENGTH				TERM APPL SPEC		FEED		APPL INSTRUCTION		SET UP GAGE	LAYOUT
-				114-2050		.400				458637-1	L1682
2	2	2	-	C	2-354779-7		PIN, WIRE DISC (.31250)D		129		
2	2	2	-	C	2-354779-4		PIN, WIRE DISC (.3110)C		128		
2	2	2	-	C	1-354779-5		PIN, WIRE DISC (.3065)B		127		
2	2	2	-	C	354779-6		PIN, WIRE DISC (.3020)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		
									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		
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		
									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)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		
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		
									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						

LEADMAKER					MECH POST FEED							
-2		BENCH MODEL K			MECH PRE FEED							
-3		BENCH MODEL G			MECH PRE FEED							
REF	REF	REF	REF	-	B	22594-8	NUT, HEX (1/2-20)			70		
REF	REF	REF	REF	-	B	240628-1	PLATE, ADJUSTMENT			69		
REF	REF	REF	REF	-	B	240626-1	SHAFT, PIVOT			68		
REF	REF	REF	REF	-	B	240633-1	BUSHING			67		
REF	REF	REF	REF	-	A	455680-1	LEVER, INTERMEDIATE			66		
REF	REF	REF	REF	-	B	240629-1	BLOCK, PIVOT			65		
REF	REF	REF	REF	-	A	240632-2	SCREW, ADJ FEED ROD			64		
REF	REF	REF	REF	-	B	240659-3	PIN, CAM ROLLER			63		
REF	REF	REF	REF	-	B	240658-1	ROLLER, CAM			62		
REF	REF	REF	REF	-	B	454398-2	ROD, FEED			61		
REF	REF	REF	REF	-	A	454178-1	GUIDE, FEED ROD			60		
REF	REF	REF	REF	-	C	454220-1	CAP, RAM			59		
REF	REF	REF	REF	-	D	454485-1	HOUSING			58		
										57		
1	1	1	1	-	B	690542-2	PAWL, FEED			56		
REF	REF	REF	REF	-	B	240624-1	PIN, FEED FINGER			55		
REF	REF	REF	REF	-	B	691499-1	SPRING, FEED FINGER			54		
REF	REF	REF	REF	-	B	690541-1	HOLDER, FEED FINGER			53		
REF	REF	REF	REF	-	A	455679-1	LEVER, TERMINAL FEED ARM			52		
1	1	1	1	-	A	811242-2	BUMPER, HOLDDOWN			51		
1	1	1	1	-	A	690753-1	SPACER, TONKER			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		
1	1	1	1	-	B	459456-1	APPLICATOR, BASIC (SUBASSY)			46		
1	1	1	1	-	A	690191-1	PLUG, NYLON			45		
1	1	1	1	-	C	455673-1	RAM			44		
1	1	1	1	-	A	690125-1	WASHER, LAMINATED			43		
1	1	1	1	-	A	690124-1	WASHER, RAM			42		
1	1	1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)			41		
1	1	1	1	-	A	23241-6	BALL, STEEL			40		
1	1	1	1	-	A	690170-1	SPRING, COMPRESSION			39		
1	1	1	1	-	C	690142-1	DISC, INSULATION			38		
1	1	1	1	-	D	354777-1	WIRE DISC, PLASTIC			37		
1	1	1	1	-	A	22480-5	WASHER, SPRING			36		
1	1	1	1	-	B	690212-1	POST, RAM			35		
1	1	1	1	-	B	690786-1	SUPPORT, TERMINAL			34		
REF	REF	REF	REF	-	D	455675-1	PLATE, BASE			33		
1	1	1	1	-	A	690432-3	SCREW, ADJUSTMENT			32		
										31		
REF	REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ			30		
1	1	1	1	-	C	455671-1	PLATE, STRIP GUIDE			29		
1	1	1	1	-	C	1-455888-8	SPACER, FRONT SHEAR DEP			28		
2	2	2	2	-	A	1-22284-0	SPRING, DRAG			27		
1	1	1	1	-	B	690546-1	LEVER, DRAG RELEASE			26		
1	1	1	1	-	B	240792-1	DRAG, TERMINAL			25		
1	1	1	1	-	D	5-690440-8	GUIDE, STRIP (REAR)			24		
1	1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)			23		
-	-	1	-	-	B	690472-2	STRIPPER			22		
REF	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	1	-	B	318563-1	GUARD, CHIP, FRONT			16		
										15		
										14		
										13		
1	1	1	1	-	A	5-22280-0	SPRING, SHEAR			12		
1	1	1	1	-	B	690461-1	STOP, SHEAR			11		
1	1	1	1	-	C	690459-1	HOLDER, SHEAR (FRONT)			10		
1	1	1	1	-	C	454276-1	SHEAR, FLOAT (FRONT)			9		
1	1	1	1	-	C	3-189717-5	ANVIL			8		
										7		
										6		
1	1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)			5		
1	1	1	1	-	B	1-238011-6	SPACER, BLOCK CRIMPER			4		
1	1	1	1	-	C	2-683453-7	CRIMPER, INSULATION			3		
1	1	1	1	-	C	455888-6	SPACER, CRIMPER			2		
1	1	1	1	-	C	3-456406-0	CRIMPER, WIRE			1		
-3	-2	-1	U/M	DWG SIZE	PART NO			DESCRIPTION		ITEM NO		
←					REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)							
QTY REQD PER ASSY					PARTS LIST							
DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±- 3 PLC DEC ±- 4 PLC DEC ±- ANGLES ±- SURF TEXTURE: REMOVE BURRS, BREAK SHARP EDGES R.015 MAX					MATL		HT TR		FIN			
					-		-		-			
					-		-		-			
					-		-		-			
DR 10-13-95 CHK 10-17-95 C ERISMAN					10/13/95 APP A BEDDOCK		10-18-95 REL 3/7/96 B. MORGAN		 AMP Incorporated Harrisburg, PA 17105-3608			
NAME					SIDE FEED HDM APPLICATOR				MACHINE REF			
SCALE					D				DWG NO		SHEET	
-					680206				1 OF 1		REV	
CASE CODE					CUSTOMER AND ASSEMBLY DRAWING 1				RESTRICTED TO			
00779												



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