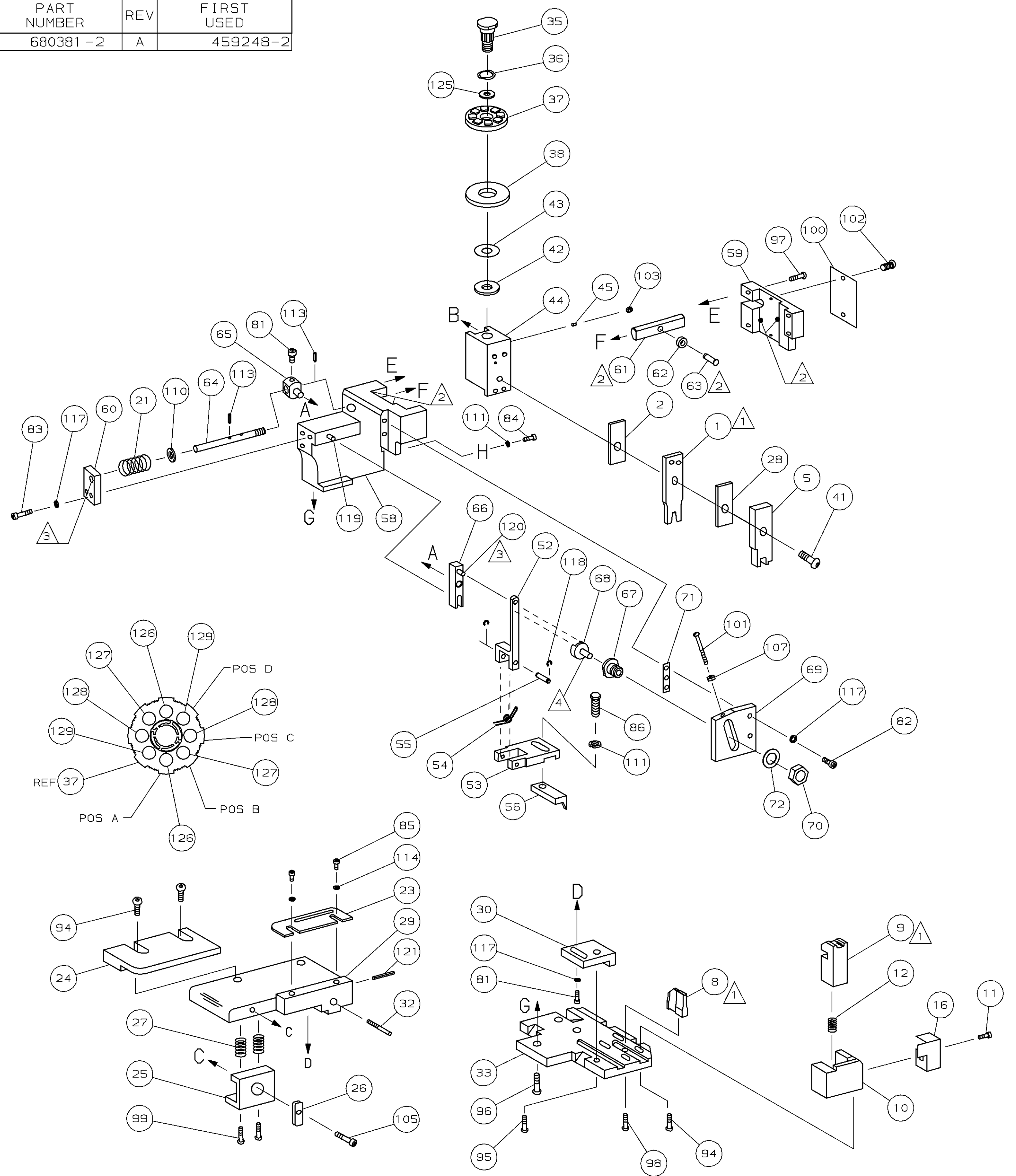


PART NUMBER	REV	FIRST USED
680381-2	A	459248-2

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.

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- △ 1 RECOMMENDED SPARE PARTS.
- △ 2 GREASE LIGHTLY.
- △ 3 LUBRICATE DAILY USING NO. 20 MACHINE OIL.

TERMINAL NAME: BRUSH CONTACT					
63930					
CRIMPING DATA					
PAD LTR	CRIMP HEIGHT		WIRE SIZE		
A	.071 ± 0.002 [1.80 ± 0.05mm]		16		
B	.068 ± 0.002 [1.73 ± 0.05mm]		(1)22 & (1)18		
C	.064 ± 0.002 [1.63 ± 0.05mm]		18		
D	.057 ± 0.002 [1.45 ± 0.05mm]		(1)20 OR (1)22		
CRIMP	SIZE	TYPE	RANGE		
WIRE	.090 [2.29mm]	F	22-16		
INSUL	-	-	-		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
-	114-2093	.420	408-8040	458637-1	L1838

QTY	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	-	C		6-354779-4	PIN, WIRE DISC (.3310)D	129
2	-	C		4-354779-8	PIN, WIRE DISC (.3230)C	128
2	-	C		4-354779-1	PIN, WIRE DISC (.3195)B	127
2	-	C		3-354779-3	PIN, WIRE DISC (.3155)A	126
1	-	A		986950-1	WASHER, FLAT PRECISION	125
1	-	A		217238-1	GENERAL INSTRUCTION PACKAGE	124
1	-	-		4088040	SF APPL INST 408-8040	123
						122
1	-	A		4-21028-0	PIN,SLT SPR(φ.093x.75)ST 6DE PL	121
1	-	A		1-21030-1	PIN,DOWEL (φ.187x.50)LEVER	120
1	-	A		1-21030-6	PIN,DOWEL (φ.187x1.25)HOUSING	119
2	-	A		21045-3	RING,RET *C*(φ.187)FD FING PIN	118
5	-	A		21024-5	WASHER, LOCK (φ#10)ADJ BLOCK	117
						116
						115
2	-	A		21024-2	WASHER,LOCK (#4)FRONT STP GUIDE	114
2	-	A		5-21028-1	PIN,SLT SPR(φ.125x.50)ADJ ROD	113
						112
2	-	A		21024-4	WASHER,LOCK (#8)STRIPPER	111
1	-	A		21899-4	WASHER,FLAT (φ5/16)SCREW ADJ	110
						109
						108
1	-	A		21018-5	NUT,HEX (6-32)FEED ADJ	107
						106
1	-	A		22353-8	SCR,SHLD (φ.187x.25)DRAG LEVER	105
						104
1	-	A		21009-2	SCR,SKT SET (1/4-20x.25 LW)RAM	103
2	-	A		21017-2	SCR,DRIVE (#2x.19)ID PLATE	102
1	-	A		6-23715-5	SCR,PAN HD (6-32x1.50)FEED ADJ	101
1	-	B		461264-1	PLATE, IDENTIFICATION	100
2	-	A		2-21002-4	SCR,BHC (10-32x.88)DRAG	99
1	-	A		22733-8	SCR,BHC (8-32x.38 LW)ANVIL	98
2	-	A		2-21002-9	SCR,BHC (10-32x.75)CAP	97
3	-	A		2-22733-8	SCR,BHC (1/4-20x.62)HOUSING	96
1	-	A		2-21002-6	SCR,BHC (10-32x.50)SG ADJ BLOCK	95
4	-	A		2-21002-3	SCR,BHC (8-32x.50)TERM H DWN	94
						93
						92
1	-	A		1-21002-7	SCR,BHC (6-32x.38)CAM	91
						90
						89
						88
						87
1	-	A		2-22603-0	SCR,HEX HD (8-32x.31)FEED FINGER	86
2	-	A		1-21000-3	SCR,SHC (4-40x.25)F ST GUIDE	85
1	-	A		2-21000-7	SCR,SHC (8-32x.50)STRIPPER	84
2	-	A		3-21000-7	SCR,SHC (10-32x.75)FEED ROD 6D	83
2	-	A		3-21000-6	SCR,SHC (10-32x.62)FEED ADJ BLK	82
2	-	A		3-21000-4	SCR,SHC (10-32x.38)SG ADJ BL	81
						80
						79
						78
						77
						76
						75
						74
						73
1	-	A		458109-1	WASHER, SPECIAL	72
1	-	A		690517-1	SPACER	71

QTY REQD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
PARTS LIST					

QTY REQD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-2	BENCH	CARBON BRUSH		MECH PRE FEED	
1	-	B	22594-8	NUT,HEX (1/2-20)	70
1	-	B	240628-1	PLATE, ADJUSTMENT	69
1	-	B	240626-1	SHAFT, PIVOT	68
1	-	B	240633-1	BUSHING	67
1	-	A	455680-1	LEVER, INTERMEDIATE	66
1	-	B	240629-1	BLOCK, PIVOT	65
1	-	A	240632-2	SCREW, ADJ FEED ROD	64
1	-	B	240659-3	PIN, CAM ROLLER	63
1	-	B	240658-1	ROLLER, CAM	62
1	-	B	454398-2	ROD, FEED	61
1	-	A	454178-1	GUIDE, FEED ROD	60
1	-	C	454220-1	CAP, RAM	59
1	-	D	454485-1	HOUSING	58
					57
1	-	B	1-694433-6	PAWL, FEED	56
1	-	B	240624-1	PIN, FEED FINGER	55
1	-	B	691499-1	SPRING, FEED FINGER	54
1	-	A	690541-1	HOLDER, FEED FINGER	53
1	-	B	455679-1	LEVER, TERMINAL FEED ARM	52
					51
					50
					49
1	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST	48
					47
					46
1	-	A	690191-1	PLUG, NYLON	45
1	-	C	455673-6	RAM	44
1	-	A	690125-1	WASHER, LAMINATED	43
1	-	A	1-690124-1	WASHER, RAM	42
1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)	41
					40
					39
1	-	A	690223-2	SPACER, INSULATION DISC	38
1	-	D	354777-1	WIRE DISC, PLASTIC	37
1	-	A	22480-5	WASHER, SPRING	36
1	-	B	690212-1	POST, RAM	35
					34
1	-	D	610874-3	PLATE, BASE	33
1	-	A	690432-3	SCREW, ADJUSTMENT	32
					31
1	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	-	C	3-458144-5	PLATE, STRIP GUIDE	29
1	-	C	2-455888-0	SPACER, FRONT SHEAR DEP	28
2	-	A	1-22284-0	SPRING, DRAG	27
1	-	B	240793-1	LEVER, DRAG RELEASE	26
1	-	B	240792-1	DRAG, TERMINAL	25
1	-	D	9-690504-7	GUIDE, STRIP (REAR)	24
1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
					22
1	-	A	4-22284-9	SPRING, FEED RETURN	21
					20
1	-	B	456468-1	STRIPPER	19
					18
					17
1	-	B	318563-1	GUARD, CHIP, FRONT	16
					15
					14
					13
1	-	A	5-22280-0	SPRING, SHEAR	12
1	-	B	690461-1	STOP, SHEAR	11
1	-	C	690459-1	HOLDER, SHEAR (FRONT)	10
1	-	C	454276-1	SHEAR, FLOAT (FRONT)	9
1	-	C	610196-9	ANVIL	8
					7
					6
1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
					4
					3
1	-	C	1-455888-0	SPACER, CRIMPER	2
1	-	C	2-456406-9	CRIMPER, WIRE	1

QTY REQD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)					
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	300CT96	APP	10-29-96	J. DODDS	
CHK	10-29-96	REL	-	C. ERISMAN	
NAME: SIDE FEED HDM APPLICATOR				MACHINE REF	MINI APPL
SCALE	-	DWG NO	680381	SHEET	1 OF 1