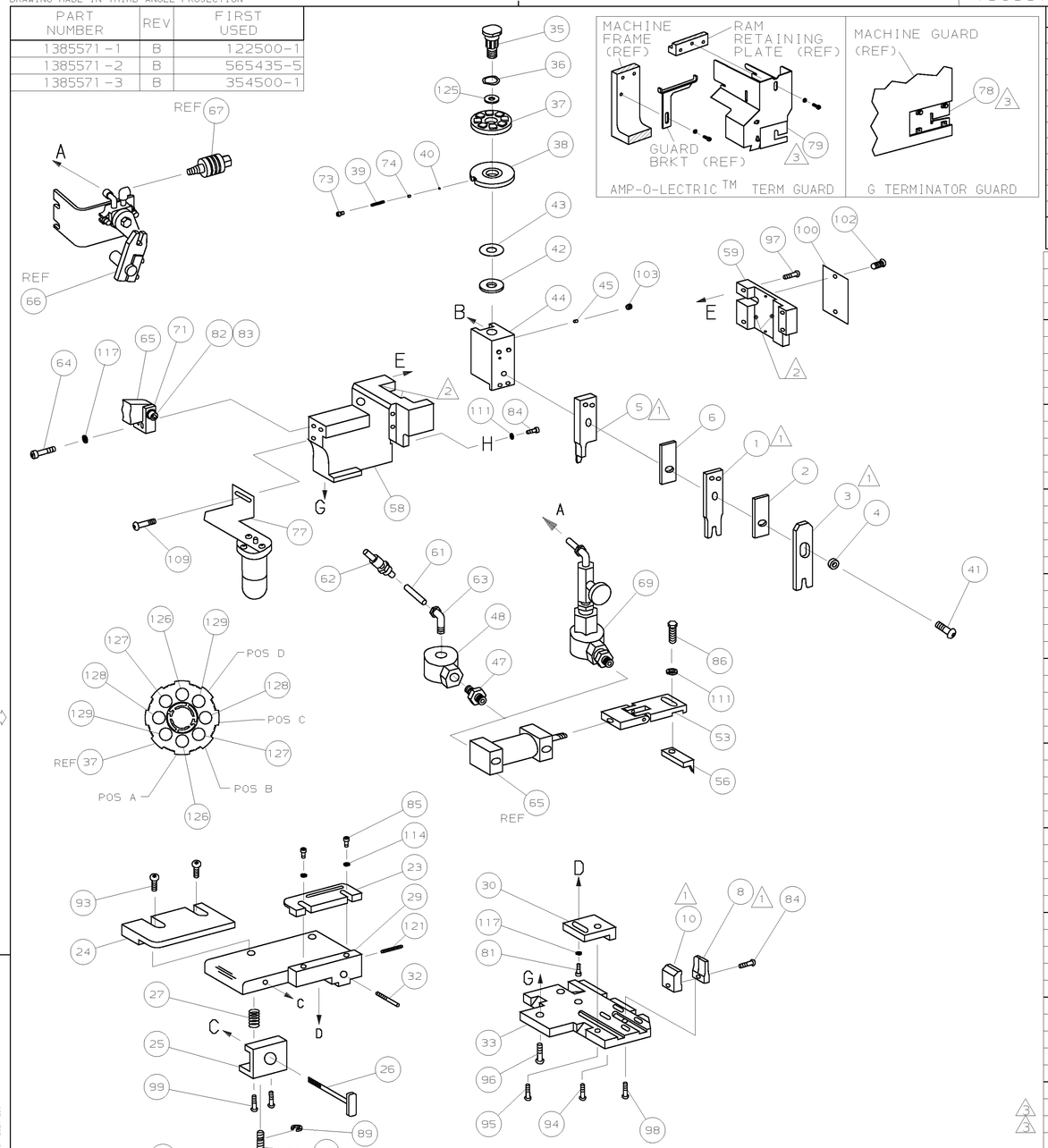
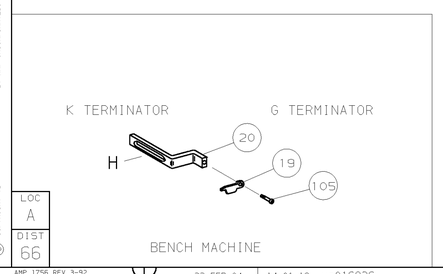
DRAWING MADE IN THIRD ANGLE PROJECTION

/home/us016926/DMTECmod

| PART NUMBER | REV | FIRST USED |
|---|---|---|
| 1385571-1 | B | 122500-1 |
| 1385571-2 | B | 565435-5 |
| 1385571-3 | B | 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: MOLEX PIN

| AMP PN | MFR PN |
|---|---|
| 1642095 | 08-65-0150 |
| | 97-00-0225 |

CRIMP DATA (NON-AMP TERMINAL-AMP SPEC)

| PAD LTR | CRIMP HEIGHT | WIRE SIZE |
|---|---|---|
| A | .031 ±.001 [0.78 ±0.03mm] | 22 |
| B | .028 ±.001 [0.71 ±0.03mm] | 24 |
| C | .027 ±.001 [0.68 ±0.03mm] | 26 |
| D | .025 ±.001 [0.64 ±0.03mm] | 28 |

| CRIMP | SIZE | TYPE | RANGE |
|---|---|---|---|
| WIRE | .062 [1.57mm] | F | 28-22 |
| INSUL | .070 [1.78mm] | O | ø.047-.067 |

| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPL INSTRUCTION | SET UP GAGE | LAYOUT |
|---|---|---|---|---|---|
| .110-.134 | NONE | .280 | 408-8040 | 458637-1 | L2809 |

| -3 | -2 | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|---|---|---|---|
| 2 | 2 | 2 | - | C | 7-354779-9 | PIN, WIRE DISC (.3385)D | 129 |
| 2 | 2 | 2 | - | C | 7-354779-3 | PIN, WIRE DISC (.3355)C | 128 |
| 2 | 2 | 2 | - | C | 7-354779-2 | PIN, WIRE DISC (.3350)B | 127 |
| 2 | 2 | 2 | - | C | 6-354779-6 | PIN, WIRE DISC (.3315)A | 126 |
| 1 | 1 | 1 | - | A | 986950-1 | WASHER, FLAT PRECISION | 125 |
| 1 | 1 | 1 | - | A | 217238-1 | GENERAL INSTRUCTION PACKAGE | 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 |
| 1 | 1 | 1 | - | 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 |
| - | 1 | - | - | A | 2-21002-6 | SCR,BHC(10-32x.38)LUBE ASSY | 109 |
| | | | | | | | 108 |
| | | | | | | | 107 |
| | | | | | | | 106 |
| 1 | 1 | 1 | - | A | 1-21002-3 | SCR,SHC(4-40x.25) | 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 | 461264-1 | 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 |
| | | | | | | | 97 |
| 3 | 3 | 3 | - | A | 2-22733-8 | SCR, BHC (1/4-20x.62) | 96 |
| 1 | 1 | 1 | - | A | 2-21002-7 | SCR,BHC(10-32x.50) | 95 |
| 2 | 2 | 2 | - | A | 2-21002-2 | SCR,BHC(8-32x.50)TERM H DWN | 94 |
| 2 | 2 | 2 | - | A | 2-21002-1 | SCR,BHC(8-32x.38)TERM H DWN | 93 |
| | | | | | | | 92 |
| | | | | | | | 91 |
| 1 | 1 | 1 | - | A | 22202-1 | NUT, JAM, 1/4-20 | 90 |
| 1 | 1 | 1 | - | A | 1-21986-3 | CLIP, E-RING | 89 |
| 1 | 1 | 1 | - | A | 1490895-1 | SCR,SKT SET(1/4-20x.75)MOD | 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.38)F ST GUIDE | 85 |
| 2 | 2 | 2 | - | A | 2-21000-7 | SCR,SHC(8-32x.50)STRIPPER | 84 |
| 1 | 1 | 1 | - | A | 3-21001-5 | SCR,SHC(3/8-16x.88) | 83 |
| 1 | 1 | 1 | - | A | 21024-8 | WASHER,LOCK(3/8) | 82 |
| 1 | 1 | 1 | - | A | 3-21000-4 | SCR,SHC(10-32x.38)SG ADJ BL | 81 |
| | | | | | | | 80 |
| - | REF | - | - | B | 455749-1 | GUARD, WINDOW | 79 |
| REF | - | - | - | B | 679532-1 | INSERT, GUARD | 78 |
| - | 1 | - | - | C | 1-465184-0 | LUBRICATOR ASSY | 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 |
| | | | | | | | 72 |
| 1 | 1 | 1 | - | B | 459610-1 | MOUNT, FEED BRACKET | 71 |

QTY REQD PER ASSY — PARTS LIST

| -1 | LEADMAKER | AIRFEED |
|---|---|---|
| -2 | BENCH MODEL K | AIRFEED |
| -3 | BENCH MODEL G | AIRFEED |

| -3 | -2 | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|---|---|---|---|
| | | | | | | | 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 | 1 | - | B | 461065-1 | AIR FEED ASSY (1 INCH) | 65 |
| 2 | 2 | 2 | - | A | 3-21000-8 | SCR,SHC(10-32x1.25)AIR ASSY | 64 |
| 1 | - | 1 | - | A | 980285-2 | ELBOW, SWIVEL 1/8 NPT - 1/4 T | 63 |
| 1 | - | 1 | - | A | 23238-1 | QUICK DISCONNECT | 62 |
| 21.00 | - | 21.00 | IN | A | 27319-4 | TUBING, POLY-FLO ø.25 | 61 |
| | | | | | | | 60 |
| 1 | 1 | 1 | - | C | 454220-1 | CAP, RAM | 59 |
| 1 | 1 | 1 | - | C | 454485-1 | HOUSING | 58 |
| | | | | | | | 57 |
| 1 | 1 | 1 | - | B | 3-694433-2 | PAWL, FEED | 56 |
| | | | | | | | 55 |
| | | | | | | | 54 |
| 1 | 1 | 1 | - | B | 461062-1 | FEED FINGER ASSY | 53 |
| | | | | | | | 52 |
| | | | | | | | 51 |
| | | | | | | | 50 |
| | | | | | | | 49 |
| 1 | - | 1 | - | A | 22374-7 | VALVE, QUICK EXHAUST | 48 |
| 1 | - | 1 | - | A | 22304-1 | NIPPLE, HEX 1/8 NPT | 47 |
| | | | | | | | 46 |
| 1 | 1 | 1 | - | A | 690191-1 | PLUG, NYLON | 45 |
| 1 | 1 | 1 | - | C | 455673-8 | RAM | 44 |
| 1 | 1 | 1 | - | A | 690125-1 | WASHER, LAMINATED | 43 |
| 1 | 1 | 1 | - | A | 690124-1 | WASHER, RAM | 42 |
| 1 | 1 | 1 | - | A | 7-21002-9 | BOLT, CRIMPER(5/16x1.00) | 41 |
| 1 | 1 | 1 | - | A | 23241-6 | BALL, STEEL | 40 |
| 1 | 1 | 1 | - | A | 690170-1 | SPRING, COMPRESSION | 39 |
| 1 | 1 | 1 | - | C | 690142-4 | DISC, INSULATION | 38 |
| 1 | 1 | 1 | - | D | 354777-1 | WIRE DISC, PLASTIC | 37 |
| 1 | 1 | 1 | - | A | 22480-5 | WASHER, SPRING | 36 |
| 1 | 1 | 1 | - | B | 690212-1 | POST, RAM | 35 |
| | | | | | | | 34 |
| 1 | 1 | 1 | - | A | 455675-1 | PLATE, BASE | 33 |
| 1 | 1 | 1 | - | A | 690432-3 | SCREW, ADJUSTMENT | 32 |
| | | | | | | | 31 |
| 1 | 1 | 1 | - | C | 455689-1 | BLOCK, STRIP GUIDE ADJ | 30 |
| 1 | 1 | 1 | - | C | 4-455671-1 | STRIP GUIDE PLATE | 29 |
| | | | | | | | 28 |
| 1 | 1 | 1 | - | A | 8-22281-7 | SPRING, DRAG | 27 |
| 1 | 1 | 1 | - | B | 690546-1 | LEVER, DRAG RELEASE | 26 |
| 1 | 1 | 1 | - | B | 1633076-1 | DRAG, TERMINAL | 25 |
| 1 | 1 | 1 | - | D | 217817-2 | GUIDE, STRIP (REAR) | 24 |
| 1 | 1 | 1 | - | A | 2-690487-6 | GUIDE, STRIP (FRONT) | 23 |
| 1 | 1 | 1 | - | B | 4-690754-0 | DRAG, TERMINAL | 22 |
| | | | | | | | 21 |
| 1 | 1 | 1 | - | A | 458950-1 | BRACKET, WIRE STOP | 20 |
| 1 | 1 | 1 | - | B | 1424353-1 | STRIPPER | 19 |
| | | | | | | | 18 |
| | | | | | | | 17 |
| | | | | | | | 16 |
| | | | | | | | 15 |
| | | | | | | | 14 |
| | | | | | | | 13 |
| | | | | | | | 12 |
| | | | | | | | 11 |
| 1 | 1 | 1 | - | A | 2-853714-2 | PLATE, REAR SHEAR | 10 |
| | | | | | | | 9 |
| 1 | 1 | 1 | - | C | 1424333-2 | ANVIL | 8 |
| | | | | | | | 7 |
| 1 | 1 | 1 | - | C | 1-455888-9 | SPACER, CRIMPER | 6 |
| 2 | 2 | 2 | - | C | 1-853720-6 | BLADE, SHEAR | 5 |
| 1 | 1 | 1 | - | B | 238009-8 | SPACER, BLOCK CRIMPER | 4 |
| 1 | 1 | 1 | - | C | 904741-4 | CRIMPER, INSULATION | 3 |
| 1 | 1 | 1 | - | C | 455888-1 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | - | C | 4-456403-2 | CRIMPER, WIRE | 1 |

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

| P | F | LTR | REVISION RECORD | APP | DATE |
|---|---|---|---|---|---|
| | | B | ECN 0150-0210-04 | TE | 2-04 |
| | | A | REVISED | BH | MAY03 |

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±.02, 3 PLC DEC ±.005, 4 PLC DEC ±-, ANGLES ± -. SURF TEXTURE, √. REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL – HT TR – FIN –

DR B.HIGMAN 06MAR01 APP T.ELBIN 06MAR01

CHK B.HIGMAN 06MAR01 REL – –

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR — MACHINE REF MINI APPL

SCALE – DWG NO 1385571 SHEET 1 of 1 REV B

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LOC A DIST 66

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