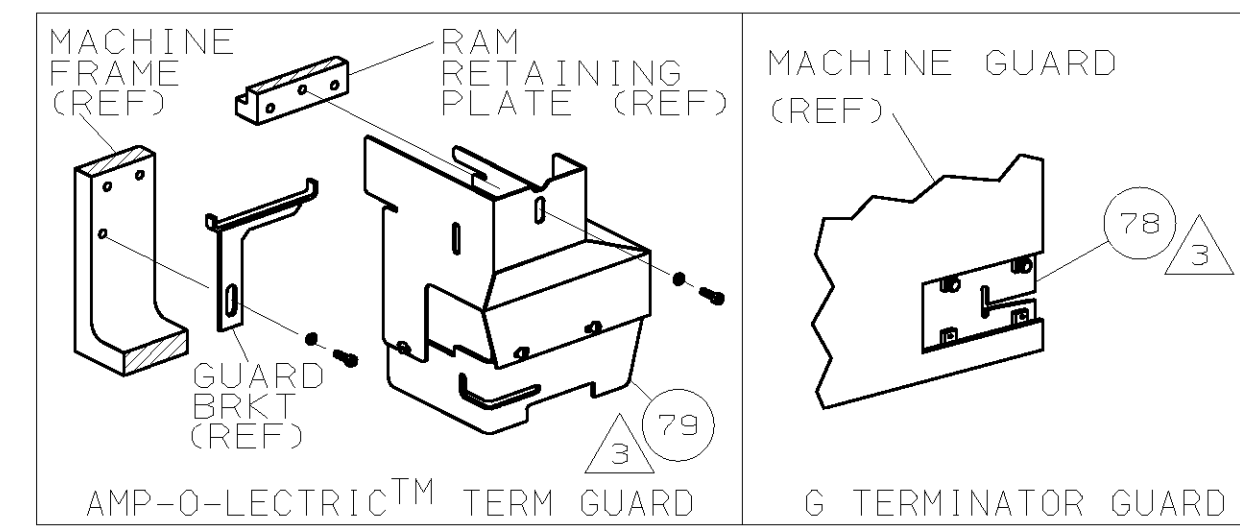
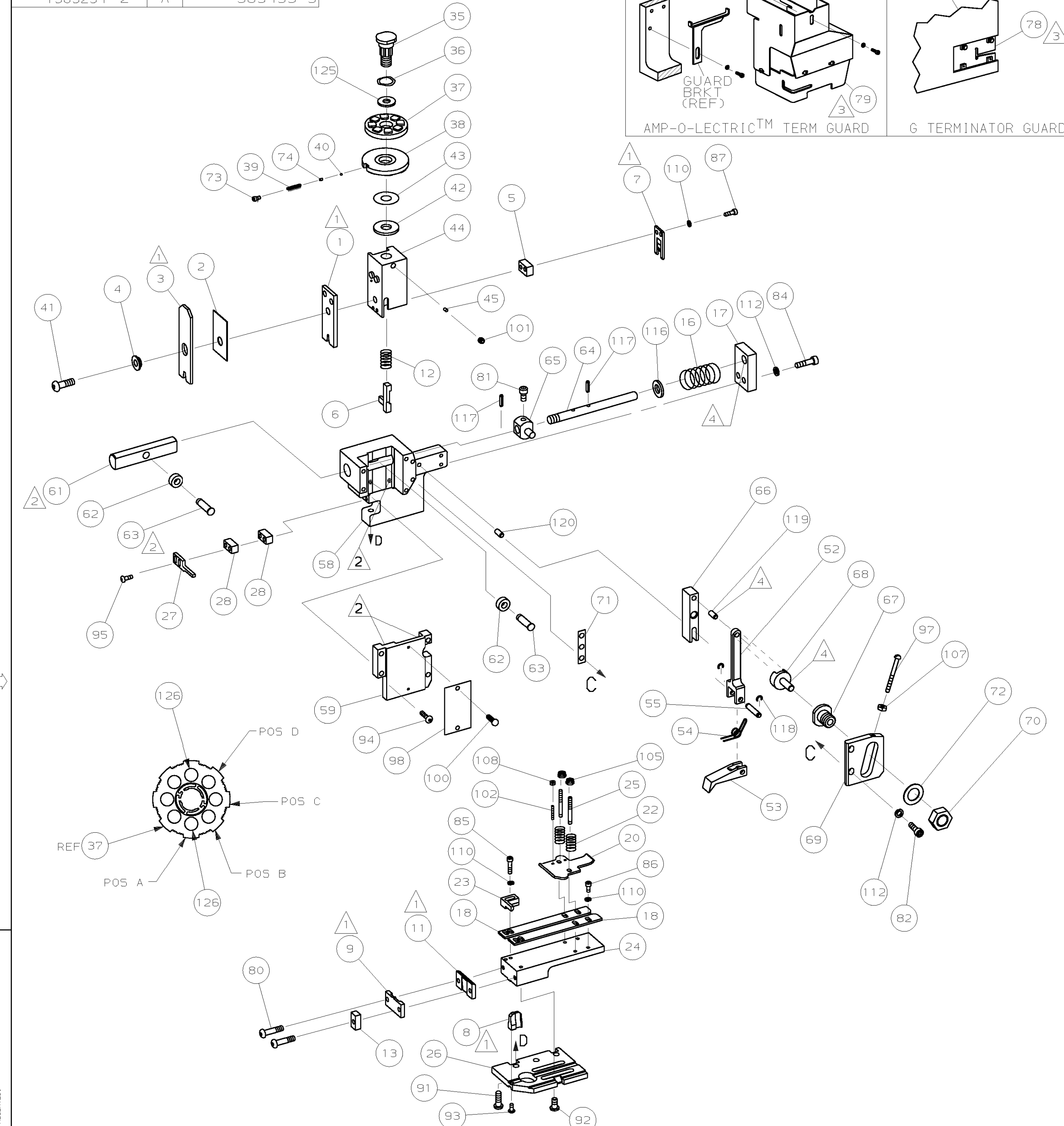


PART NUMBER	REV	FIRST USED
1385254-1	A	122500-1
1385254-2	A	565435-5

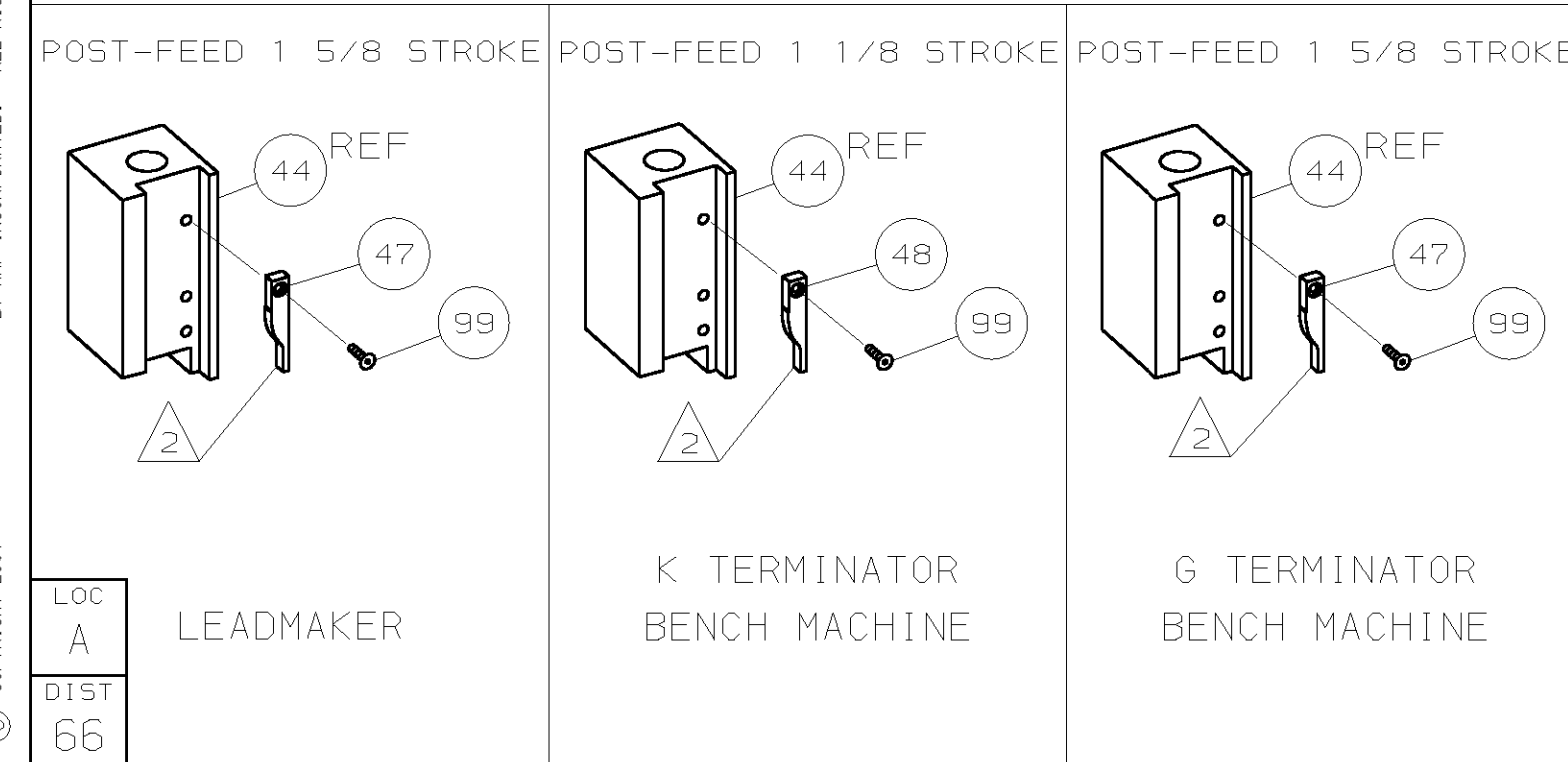


TERMINAL NAME: TERMINAL, FEMALE					
AMP PN	MFR PN	SUMIKO TERMINAL		CUST CRIMP SPECS	
PAD LTR	CRIMP HEIGHT	WIRE SIZE			
286944	425072-9	A	.051 ±.002 [1.30 ±0.05mm]	20	
		B	NOT	USED	
		C	NOT	USED	
		D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE		
WIRE	.100 [2.54mm]	F	20		
INSUL	.100 [2.54mm]	F	φ.090 MAX		
WIRE STRIP LENGTH	TERM APPL	SPEC	FEED	APPL INSTRUCTION	SET UP GAGE
.125-.141	NONE		.844	408-8039	458638-1
					L2523

-1	LEADMAKER & BENCH MODEL G	MECH POST FEED	
-2	BENCH MODEL K	MECH POST FEED	
REF	REF	- A	22594-8 NUT, HEX 70
REF	REF	- B	240628-1 PLATE, ADJ 69
REF	REF	- B	240626-1 SHAFT, PIVOT 68
REF	REF	- B	240633-1 BUSHING 67
REF	REF	- A	455680-1 LEVER, INTERMEDIATE 66
REF	REF	- B	240629-1 BLOCK, PIVOT 65
REF	REF	- A	240632-2 SCR, ADJ 64
REF	REF	- B	240659-3 PIN, CAM ROLLER 63
REF	REF	- B	240658-1 CAM, ROLLER 62
REF	REF	- B	454398-1 ROD, FEED 61
			60
REF	REF	- C	454220-1 CAP, RAM 59
REF	REF	- D	453736-1 HOUSING 58
			57
			56
REF	REF	- B	240624-1 PIN, FEED FINGER 55
REF	REF	- B	691499-1 SPRING, FEED FINGER 54
REF	REF	- B	240635-1 FINGER, FEED 53
REF	REF	- B	240634-1 LEVER, TERMINAL 52
			51
			50
			49
1	-	- B	690501-3 CAM, POST FEED 1 1/8 ST 48
-	1	- B	690501-4 CAM, POST-FEED 1 5/8 ST 47
			46
1	1	- A	690191-1 PLUG, NYLON 45
1	1	- C	455674-1 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 (5/16-24x1.00) 41
1	1	- A	23241-6 BALL, STEEL 40
1	1	- A	690170-1 SPRING, COMPRESSION 39
1	1	- C	1-690142-0 DISC, INSULATION 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
			34
			33
1	1	- D	458980-1 APPLICATOR, BASIC (SUB ASSY) 32
			31
			30
1	1	- B	3-690451-2 SPACER, STRIPPER 29
1	1	- B	1-690451-1 SPACER, STRIPPER 28
1	1	- A	240639-2 STRIPPER 27
REF	REF	- C	455676-1 PLATE, BASE 26
2	2	- A	22354-8 DRAG, STUD 25
1	1	- B	458803-5 PLATE, STRIP GUIDE 24
1	1	- C	240825-9 PLATE, STRIP HOLD DOWN 23
2	2	- A	4-22281-1 SPRING, DRAG 22
			21
1	1	- A	454177-1 DRAG, STOCK 20
1	1	- D	4-458030-2 GUIDE, STRIP (REAR) 19
1	1	- D	4-458031-2 GUIDE, STRIP (FRONT) 18
REF	REF	- A	454178-1 GUIDE, FEED ROD 17
REF	REF	- A	4-22284-9 SPRING, FEED RETURN 16
			15
			14
1	1	- C	690481-2 SPACER, HOLD DOWN 13
1	1	- A	23846-1 SPRING, HOLD DOWN 12
1	1	- B	240833-4 PLATE, REAR SHEAR 11
			10
1	1	- B	1-690496-3 PLATE, FRONT SHEAR 9
1	1	- D	8-240654-1 ANVIL 8
1	1	- B	1-690474-1 BLADE, SLUG 7
1	1	- D	2-455892-4 HOLD DOWN, TERMINAL 6
1	1	- C	1-240641-5 SPACER, SLUG BLADE 5
1	1	- B	1-238009-4 SPACER, BLOCK CRIMPER 4
1	1	- C	4-456134-8 CRIMPER, INSULATION 3
1	1	- B	455888-7 SPACER, CRIMPER 2
1	1	- C	456407-1 CRIMPER, WIRE 1



QTY	REF	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
							129
							128
							127
2	2	-	C		1-354779-9	PIN, WIRE DISC (.3085)A	126
1	1	-	A		986950-1	WASHER, FLAT PRECISION	125
1	1	-	A		217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	-	-		4088039	EF APPL INST 408-8039	123
							122
							121
REF	REF	-	A		1-21030-7	PIN, DOWEL (φ.187x1.50)H56	120
REF	REF	-	A		1-21030-1	PIN, DOWEL (φ.187x.50)LEVER	119
REF	REF	-	A		21045-3	RING, RET "C" (φ.187)FD PIN	118
REF	REF	-	A		5-21028-1	PIN, STD SPRING (φ.12)FD ADJ ROD	117
REF	REF	-	A		21899-4	WASHER, FLAT (φ5/16) SCR ADJ	116
							115
							114
							113
REF	REF	-	A		21024-5	WASHER, LOCK (NO.10)FD ROD GDE	112
							111
7	7	-	A		21024-4	WASHER, LOCK (NO.8)SHEAR BL	110
							109
2	2	-	A		21018-4	NUT, HEX (4-40)DRAG	108
REF	REF	-	A		21018-5	NUT, HEX (6-32)FD ADJ PL	107
							106
2	2	-	A		21022-2	NUT, HEX SL (8-32)DRAG STUD	105
							104
							103
2	2	-	A		2-21006-6	SCR, SKT SET (4-40x.62)DRAG	102
1	1	-	A		21009-2	SCR, SKT SET (1/4-20x.25)RAM	101
2	2	-	A		21017-2	SCR, DRIVE (#2x.19) ID PLATE	100
1	1	-	A		1-21002-7	SCR, BHC (6-32x.38) CAM	99
1	1	-	B		461264-1	PLATE, IDENTIFICATION	98
REF	REF	-	A		6-23715-5	SCR, PAN HD (6-32x1.50)FEED ADJ	97
							96
2	2	-	A		2-21002-2	SCR, BHC (8-32x.50)STRIPPER	95
REF	REF	-	A		2-21002-9	SCR, BHC (10-32x.75)H56 CAP	94
1	1	-	A		22733-8	SCR, BHC (8-32x.38 LW) ANVIL	93
4	4	-	A		3-21002-3	SCR, BHC (1/4-20x.50)ST 6D PL	92
REF	REF	-	A		2-22733-8	SCR, BHC (1/4-20x.62)BASE PL	91
							90
							89
							88
2	2	-	A		2-21000-8	SCR, 5HC (8-32x.62)SLUG BLADE	87
3	3	-	A		2-21000-6	SCR, 5HC (8-32x.38)STRIP GUIDE	86
2	2	-	A		2-21000-9	SCR, 5HC (8-32x.75)R STRIP GUIDE	85
REF	REF	-	A		3-21000-7	SCR, 5HC (10-32x.75)FEED ROD GDE	84
							83
REF	REF	-	A		3-21000-6	SCR, 5HC (10-32x.62)FEED ADJ PL	82
REF	REF	-	A		3-21000-4	SCR, 5HC (10-32x.38)PIVOT BLOCK	81
2	2	-	A		3-21002-0	SCR, BHC (10-32x.88)SHEAR PL	80
REF	-	-	A		455745-1	GUARD, WINDOW	79
-	REF	-	A		679532-1	INSERT, GUARD	78
							77
							76
							75
1	1	-	A		690603-1	SPRING, ASSIST	74
1	1	-	A		23030-1	SCR, SKT CAP (6-32x.25)CP DSC	73
REF	REF	-	A		458109-1	WASHER, FLAT (SPECIAL)	72
REF	REF	-	A		690517-1	SPACER	71



- 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 32.
- 6 ITEM 78 USED WITH G TERMINATOR ONLY.
- 7 FEED ON INSULATION BARREL.

QTY	REF	REV	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-2	-1						

-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

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1385254

B

A

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 R.O.WILSON 30MAR01 APP 30MAR01 T.ELBIN
 CHK - REL -
AMP AMP Incorporated Harrisburg, PA 17105-3608
 NAME END FEED HDM APPLICATOR MACHINE REF MINI APPL
 SCALE - DWG NO 1385254 SHEET 1 OF 1 REV A
 CASE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO