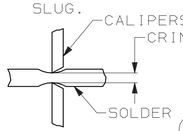
DRAWING MADE IN THIRD ANGLE PROJECTION

567112 ⇔ 567112

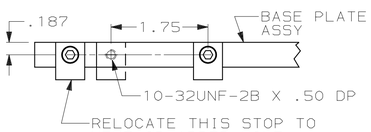
/home/us016926/DMTECmod

PART NUMBER	REV	FIRST USED
567112-1	Z	122500-1
567112-2	Z	565435-5
567112-3	Z	354500-1
7-567112-7	T	–

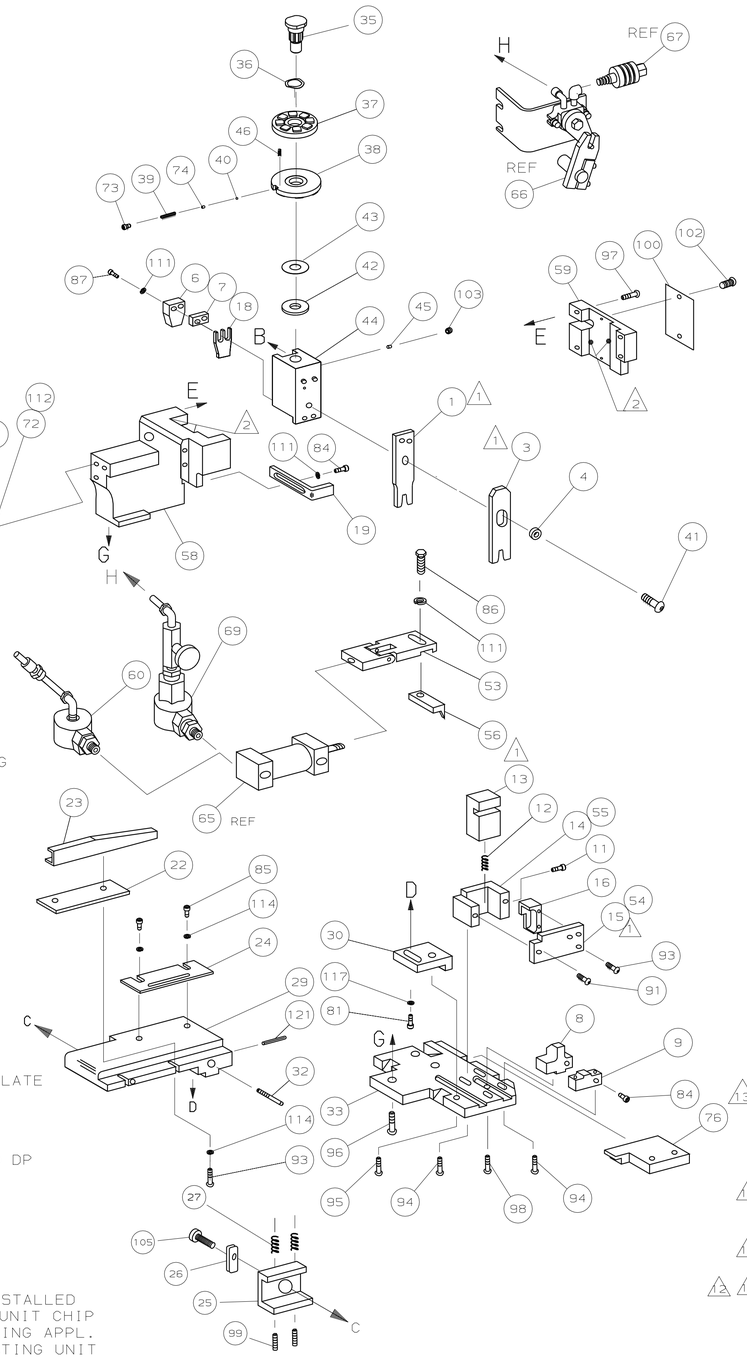
1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
4. SEE DRAWING FOR COMPONENTS.
5. TO CHECK CRIMP HEIGHT, CRIMP SOLDER (ø .19 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.

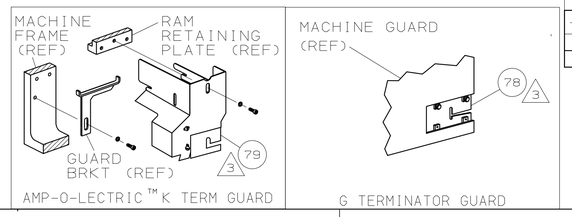


6. ITEM 16 MUST BE REMOVED IF APPLICATOR IS REMOVED FROM LEADMAKER AND PLACED IN A BENCH TERMINATOR.
7. ITEM 76 REQUIRED WHEN APPLICATOR IS REMOVED FROM LEADMAKER AND PLACED IN A BENCH MODEL K TERMINATING UNIT.
8. ~~INSTALL ITEM 75 IN CHIP RELIEF HOLE OF T-TERM UNIT BEFORE INSTALLING APPLICATOR.~~
9. IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING UNIT'S BASE PLATE BEFORE INSTALLING THIS APPLICATOR BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN:



10. FEED ADJ MAY BE REQUIRED WHEN SWITCHING TERMINALS.
11. ITEMS 75 AND 77 MUST BE INSTALLED IN THE G-TERMINATING OR T UNIT CHIP RELIEF HOLE BEFORE INSTALLING APPL. LEADMAKER WITH A T TERMINATING UNIT ONLY REQUIRE ITEM 75.
12. ITEM NOT SHOWN.
13. LOCATE HOLD DOWN BRACKET ON RIGHT SIDE OF APPLICATOR AND FASTEN TO BASEPLATE OF TERMINATING UNIT.





TERMINAL NAME: FULLY INSULATED FASTON™	
	520402
	520404
	520406
	521057
TERM APPL SPEC	114-2123

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE	SOLDER ø 5
A	.080±.002	14	ø.19
B	.075±.002	16	ø.19
C	NOT	USED	–
D	NOT	USED	–

CRIMP	SIZE	TYPE	RANGE
WIRE	.205	D	16-14
INSUL	–	–	.160 MAX

FEED	APPL INST	SET UP GAGE	LAYOUT
.785-.940 10	8051	458637-1	L1213

WIRE STRIP LENGTH .265-.297

-77	-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
–	1	1	1	–	A	4-21028-0	PIN,SLT SPR(ø.093x.75)ST GDE PL	121
–	3	3	3	–	A	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
–	4	4	4	–	A	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
–	1	1	1	–	A	21024-8	WASHER,LOCK 3/8	112
–	4	4	4	–	A	21024-4	WASHER,LOCK(#8)STRIPPER	111
–	1	1	1	–	A	22353-8	SCR,SHLD(ø.187x.25)DRAG LEVER	105
–	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
–	1	1	1	–	B	461264-1	PLATE, IDENTIFICATION	100
–	2	2	2	–	A	5-21006-6	SCR,SET(10-32x.75)DRAG	99
–	1	1	1	–	A	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
–	4	4	4	–	A	3-21002-0	SCR,BHC(10-32X.88)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
–	2	2	2	–	A	2-21002-2	SCR,BHC(8-32x.50)SHEAR	94
–	2	2	4	–	A	1-21000-4	SCR,BHC(4-40X.38)F STRIP GUIDE	93
–	2	2	2	–	A	1-21002-3	SCR,BHC(4-40x.25)SHEAR PLATE	91
–	2	2	2	–	A	3-21000-0	SCR,SHC(8-32x.88)DEP-HOLD	87
–	1	1	1	–	A	2-22603-1	SCR,HEX HD(8-32x.38)FEED FINGER	86
–	2	2	2	–	A	1-21000-3	SCR,SHC(4-40X.25)R ST GUIDE	85
–	2	2	2	–	A	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
–	1	1	1	–	A	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
12 11 –	–	–	1	–	A	1-18023-1	SCR, SHC, M4 X 10 LG	80
3 –	–	1	–	–	B	462992-7	GUARD ASSY	79
3 –	REF	–	–	–	B	679532-1	INSERT, GUARD	78
12 11 –	–	–	1	–	B	189728-1	BRACKET, SPACER	77
7 –	REF	1	REF	–	B	803931-1	BRACKET, HOLD DOWN	76
12 11 8 –	–	–	1	–	B	568681-1	SPACER, BASE PLATE	75
–	2	2	2	–	A	690603-1	SPRING, ASSIST	74
–	2	2	2	–	A	23030-1	SCR,SHC(6-32x.25 SL)INS DISC	73
–	1	1	1	–	A	3-21001-5	SCR,SHC(3/8x1.00)FEED MT	72
1	1	1	1	–	C	808830-1	CRIMPER, WIRE	1

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

-1	LEADMAKER	AIRFEED	-77	SPARE TOOLING 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	–	–	C	692655-5	AIR FEED VALVE ASSY	69
–	–	REF	–	–	A	24042-2	VALVE, SHUT OFF	67
4 –	–	REF	–	–	C	692655-6	AIR FEED VALVE ASSY	66
4 –	1	1	1	–	B	461065-1	AIR FEED ASSEMBLY	65
–	2	2	2	–	A	4-21000-0	SCR,SHC 10-32x1.25 AIR ASSY	64
–	1	–	1	–	C	692655-7	AIR FEED VALVE ASSY	60
–	1	1	1	–	C	454220-1	CAP, RAM	59
–	1	1	1	–	D	454485-1	HOUSING	58
–	1	1	1	–	B	462427-1	PAWL, FEED	56
–	1	1	–	–	B	467590-1	HOLDER, SHEAR(REAR)	55
–	1	1	–	–	B	469366-2	PLATE, SHEAR(REAR)	54
4 –	1	1	1	–	B	461062-2	FEED FINGER ASSY	53
–	1	1	1	–	B	459610-3	MOUNT,FEED BRACKET	51
–	8	8	8	–	A	1-22280-2	SPRING, WIRE DISC	46
–	1	1	1	–	A	690191-1	PLUG, NYLON	45
–	1	1	1	–	C	455673-1	RAM	44
–	1	1	1	–	A	690125-1	WASHER, LAMINATED	43
–	1	1	1	–	A	690124-3	WASHER, RAM	42
–	1	1	1	–	A	690686-2	BOLT, CRIMPER(5/16x1.00)	41
–	2	2	2	–	A	23241-6	BALL, STEEL	40
–	2	2	2	–	A	690170-1	SPRING, COMPRESSION	39
–	1	1	1	–	C	690142-1	DISC,INSULATION	38
–	1	1	1	–	D	808834-1	DISC, WIRE	37
–	1	1	1	–	A	22480-5	WASHER,SPRING	36
–	1	1	1	–	B	690212-1	POST, RAM	35
–	1	1	1	–	D	808835-1	PLATE, BASE	33
–	1	1	1	–	A	690432-3	SCREW, ADJUSTMENT	32
–	1	1	1	–	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
–	1	1	1	–	C	684045-2	PLATE, STRIP GUIDE	29
–	2	2	2	–	A	22281-9	SPRING, DRAG	27
–	1	1	1	–	B	240793-4	LEVER, DRAG RELEASE	26
–	1	1	1	–	B	240792-6	DRAG, TERMINAL	25
–	1	1	1	–	D	690438-1	GUIDE, STRIP (REAR)	24
–	1	1	1	–	A	684042-2	GUIDE, STRIP (FRONT)	23
–	1	1	1	–	A	817682-1	SPACER,FRONT STRIP GUIDE	22
–	1	1	1	–	B	690472-2	STRIPPER	19
–	1	1	1	–	B	463460-3	HOLDER, TERMINAL	18
6 –	–	–	1	–	B	803925-1	GUIDE, CARRIER STRIP	16
1 –	–	–	1	–	B	803926-1	PLATE, SHEAR (REAR)	15
–	–	–	1	–	B	467590-2	HOLDER, SHEAR (REAR)	14
1 –	1	1	1	–	C	469542-3	SHEAR, FLOAT (REAR)	13
–	1	1	1	–	A	3-22280-3	SPRING, SHEAR	12
–	1	1	1	–	B	1-690461-1	STOP, SHEAR	11
1	1	1	1	–	C	1-454766-3	ANVIL,INSULATION	9
1 1	1	1	1	–	C	808025-1	ANVIL, WIRE	8
–	1	1	1	–	C	240641-9	SPACER, DEPRESSOR (REAR)	7
–	1	1	1	–	A	690468-6	DEPRESSOR, SHEAR (REAR)	6
–	1	1	1	–	B	238009-1	SPACER, TUBULAR	4
1 1	1	1	1	–	C	2-454765-1	CRIMPER,INSULATION	3
1 1	1	1	1	–	C	808830-1	CRIMPER, WIRE	1

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

P	F	LTR	REVISION RECORD	APP	DATE
		Z	ECR-06-021427	TE	9-06
		Y	ECN 0150-1075-04	TE	8-04
		W	ECN 0150-0955-04	TE	7-04
		V	ECN 0150-0194-04	TE	2-04
		U1	ECN 0150-1181-02	TE	9-02
		U	ECN 0150-1005-01	TE	10-01
		T1	ECN 0150-0307-01	TE	4-01
		T	ECN 0150-0074-01	TE	1-01
		S1	0150-0830-00	CE	NOV00

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±.25, 3 PLC DEC ±.005, 4 PLC DEC ±-, ANGLES ± -, SURF TEXTURE, √. REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

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DR 5-17-95 M. O'BRINE | APP 5-17-95 T.BEDDICK | CHK 5-17-95 C.ERISMAN | REL 5/25/95 B. MORGAN

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR | MACHINE REF MINI APPL

SCALE – | D | DWG NO 567112 | SHEET 1 OF 1 | REV Z

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