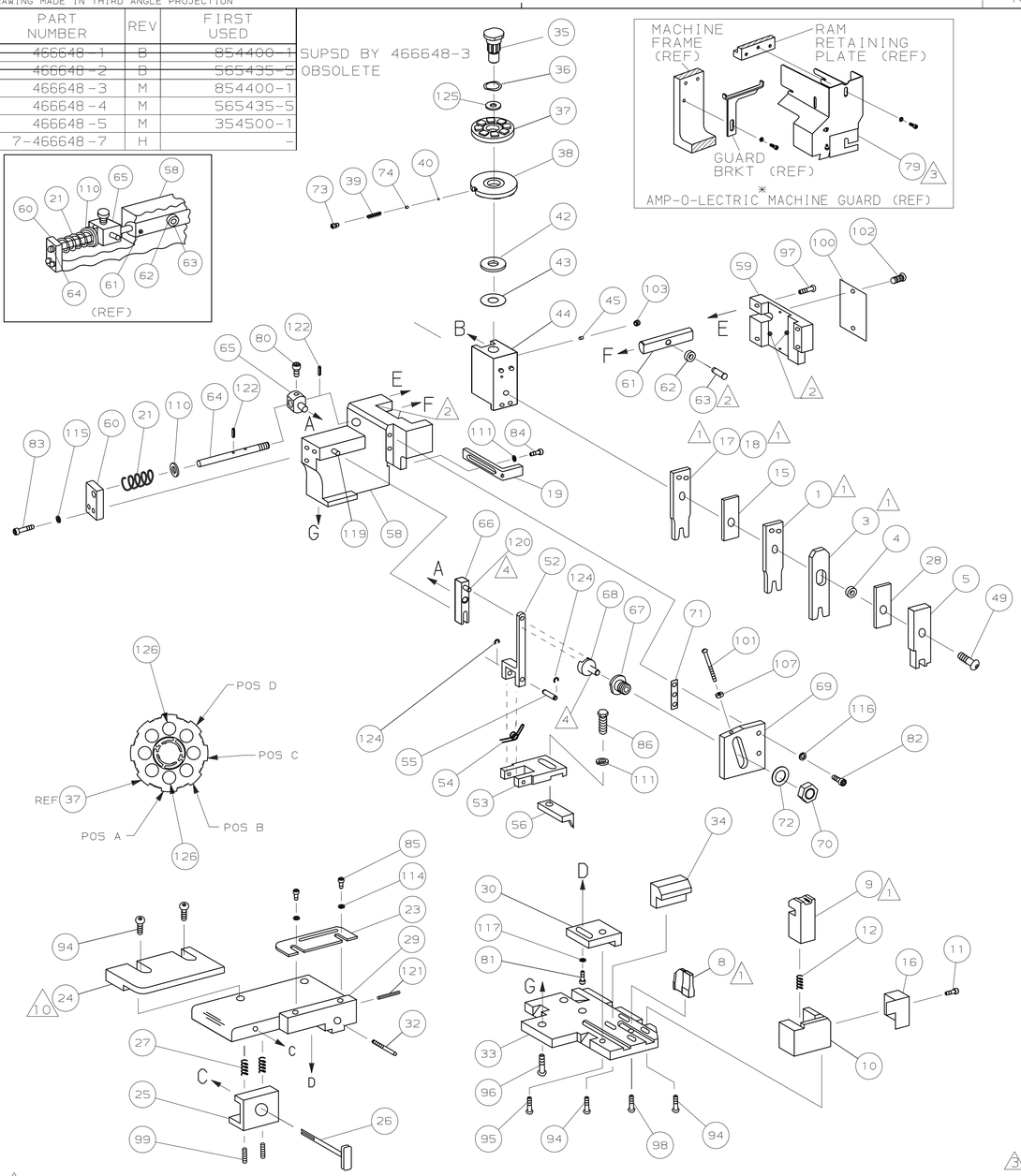
DRAWING MADE IN THIRD ANGLE PROJECTION

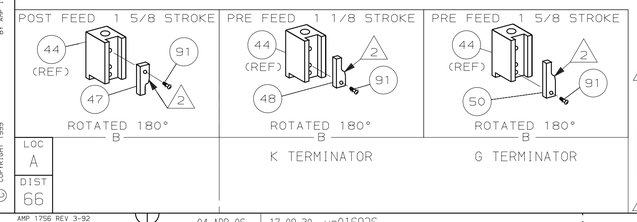
PART NUMBER	REV	FIRST USED	
~~466648-1~~	B	~~854400-1~~	SUPSD BY 466648-3
~~466648-2~~	B	~~565435-5~~	OBSOLETE
466648-3	M	854400-1	
466648-4	M	565435-5	
466648-5	M	354500-1	
7-466648-7	H	-	



1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-O-LECTRIC MACHINE.
4. LUBRICATE DAILY USING NO. 20 MACHINE OIL.
5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEM 79) ARE USED ON ITEM 46.
6. LOCATE ITEM 19 BETWEEN ITEMS 18 AND 1.
7. USED WITH BENCH TERMINATING UNITS ONLY.
8. UNLESS OTHERWISE SPECIFIED, SET UP APPL FOR 20 OR 22 GAGE WIRE, ITEM 18. ADDITIONAL WIRE CRIMPER, ITEM 17, SHOULD ALSO ACCOMPANY APPLICATOR.
9. STABILIZER CRIMP HEIGHT TO BE MEASURED OVER CENTER BARREL. WIRE CRIMP HEIGHT AS SPECIFIED IN CHART BELOW.

WIRE SIZE	WIRE CRIMP HEIGHT	ITEM
18	.037 ±.002 [0.94 ±0.05mm]	17
22 or 20	.030 ±.002 [0.76 ±0.05mm]	18

10. REAR STRIP GUIDE TO GUIDE ON INSULATION BARREL.



LOC A
DIST 66

TERMINAL NAME: MINI AMP-IN ✱ Trademark of AMP Incorporated

640311	PAD LTR	STABILIZER CRIMP HEIGHT	WIRE SIZE
	A	.055 ±.005 [1.40 ±0.13mm] 8 9	22, 20 or 18
	B	NOT	USED
	C	NOT	USED
	D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.062	F	22-18
STABILIZER	.062	F	22-18
INSULATION	.110	F	.060-.110

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.175-.205	114-1016	.330	408-8040	458637-1	936A

								ITEM NO
								129
								128
								127
-	2	2	2	-	C	1-354779-2	PIN, WIRE DISC (.3050) 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
-	2	2	2	-	A	21024-4	WASHER,LOCK (#8) STRIPPER	111
-	REF	REF	REF	-	A	21899-4	WASHER,FLAT (ø5/16) SCREW ADJ	110
								109
								108
-	REF	REF	REF	-	A	21018-5	NUT,HEX (6-32) FEED ADJ	107
								106
								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
-	REF	REF	REF	-	A	6-23715-4	SCR,PAN HD (6-32 X 1.25) FEED ADJ	101
-	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
-	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) SHEAR	94
								93
								92
-	1	1	1	-	A	1-21002-7	SCR,BHC (6-32x.38) CAM	91
								90
								89
								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.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
								78
								77
								76
								75
-	1	1	1	-	A	690603-1	SPRING, ASSIST	74
-	1	1	1	-	A	23030-1	SCR,SKT CAP (6-32x.25) CP DSC	73
-	REF	REF	REF	-	A	458109-1	WASHER, SPECIAL	72
-	REF	REF	REF	-	A	690517-1	SPACER	71
-77	-5	-4	-3	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

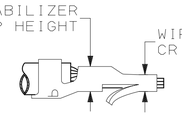
-3 LEADMAKER MECH-POST FEED
-4 AMP-O-LECTRIC MECH-PRE FEED
-5 BENCH MODEL G MECH-PRE FEED

-77 SPARE TOOLING KIT

-77	-5	-4	-3	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-	REF	REF	REF	-	B	22594-8	NUT,HEX (1/2-20)	70
-	REF	REF	REF	-	B	240628-1	PLATE, ADJUSTMENT	69
-	REF	REF	REF	-	B	240626-1	SHAFT, PIVOT	68
-	REF	REF	REF	-	B	240633-1	BUSHING	67
-	REF	REF	REF	-	A	455680-1	LEVER, INTERMEDIATE	66
-	REF	REF	REF	-	B	240629-1	BLOCK, PIVOT	65
-	REF	REF	REF	-	A	240632-2	SCREW, ADJ FEED ROD	64
-	REF	REF	REF	-	B	240659-3	PIN, CAM ROLLER	63
-	REF	REF	REF	-	B	240658-1	ROLLER, CAM	62
-	REF	REF	REF	-	B	454398-2	ROD, FEED	61
-	REF	REF	REF	-	A	454178-1	GUIDE, FEED ROD	60
-	REF	REF	REF	-	C	454220-1	CAP, RAM	59
-	REF	REF	REF	-	D	454485-1	HOUSING	58
								57
-	1	1	1	-	B	458537-2	PAWL, FEED	56
-	REF	REF	REF	-	B	240624-1	PIN, FEED FINGER	55
-	REF	REF	REF	-	B	691499-1	SPRING, FEED FINGER	54
-	REF	REF	REF	-	B	690541-1	HOLDER, FEED FINGER	53
-	REF	REF	REF	-	A	455679-1	LEVER, TERMINAL FEED ARM	52
								51
-	1	-	-	-	B	690602-6	CAM, PRE-FEED 1 5/8 ST	50
-	1	1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)	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	-	B	459456-1	APPLICATOR, BASIC (SUBASSY)	46
-	1	1	1	-	A	690191-1	PLUG, NYLON	45
-	1	1	1	-	C	455673-6	RAM	44
-	1	1	1	-	A	690125-1	WASHER, LAMINATED	43
-	1	1	1	-	A	690124-3	WASHER, RAM	42
								41
-	1	1	1	-	A	23241-6	BALL, STEEL	40
-	1	1	1	-	A	690170-1	SPRING, COMPRESSION	39
-	1	1	1	-	C	690142-5	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
-	1	1	-	-	B	469465-1	SUPPORT, TERMINAL	34
-	REF	REF	REF	-	D	455675-1	PLATE, BASE	33
-	1	1	1	-	A	690432-3	SCREW, ADJUSTMENT	32
								31
-	REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
-	1	1	1	-	C	1-455671-4	PLATE, STRIP GUIDE	29
-	1	1	1	-	C	455888-1	SPACER, FRONT SHEAR DEP	28
-	2	2	2	-	A	1-22284-0	SPRING, DRAG	27
-	1	1	1	-	B	690546-1	LEVER, DRAG RELEASE	26
-	1	1	1	-	B	240792-1	DRAG, TERMINAL	25
-	1	1	1	-	D	6-690504-3	GUIDE, STRIP (REAR)	24
-	1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
								22
-	REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	21
								20
-	1	1	1	-	B	1-690472-3	STRIPPER	19
1	1	1	1	-	B	1-458141-4	CRIMPER,WIRE 9	18
1	1	1	1	-	B	1-458141-5	CRIMPER,WIRE 9	17
-	1	1	1	-	B	318563-1	GUARD, CHIP (FRONT)	16
-	1	1	1	-	B	455888-7	SPACER,CRIMPER	15
								14
								13
-	1	1	1	-	A	3-22280-3	SPRING, SHEAR	12
-	1	1	1	-	B	690461-1	STOP, SHEAR	11
-	1	1	1	-	C	690459-1	HOLDER, SHEAR (FRONT)	10
-	1	1	1	-	C	454276-1	SHEAR, FLOAT (FRONT)	9
1	1	1	1	-	C	464962-3	ANVIL	8
								7
								6
-	1	1	1	-	C	455889-9	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	-	B	238011-7	SPACER, BLOCK CRIMPER	4
1	1	1	1	-	C	2-456134-2	CRIMPER, INSULATION	3
								2
1	1	1	1	-	C	1-456403-3	CRIMPER, WIRE	1

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

QTY REQD PER ASSY — PARTS LIST



P	F	LTR	REVISION RECORD	APP	DATE
		M	ECR-06-008230	GB	4-06
		L	ECR-06-002912	GB	2-06
		K	ECN 0150-0914-03	TE	8-03
		J1	0150-0467-03	RK	MAY03
		J	ECN 0150-0243-03	TE	3-03
		H4	ECN 0150-1455-02	TB	11-02
		H3	EC 0150-0366-01	CMR	APRIL01
		H2	ECN 0150-0307-01	TE	4-01
		H1	0150-0725-00	AA	10-00

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

MATL - | HT TR - | FIN -

DR D.SALTZER 8/5/93 | APP E.KOOTTE 9-17-93
CHK C.ERISMAN 9-17-93 | REL G. OCHENIS 10/20/93

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR | MACHINE REF MINI APPL

SCALE - | D | DWG NO 466648 | SHEET 1 of 1 | REV M

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO -

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