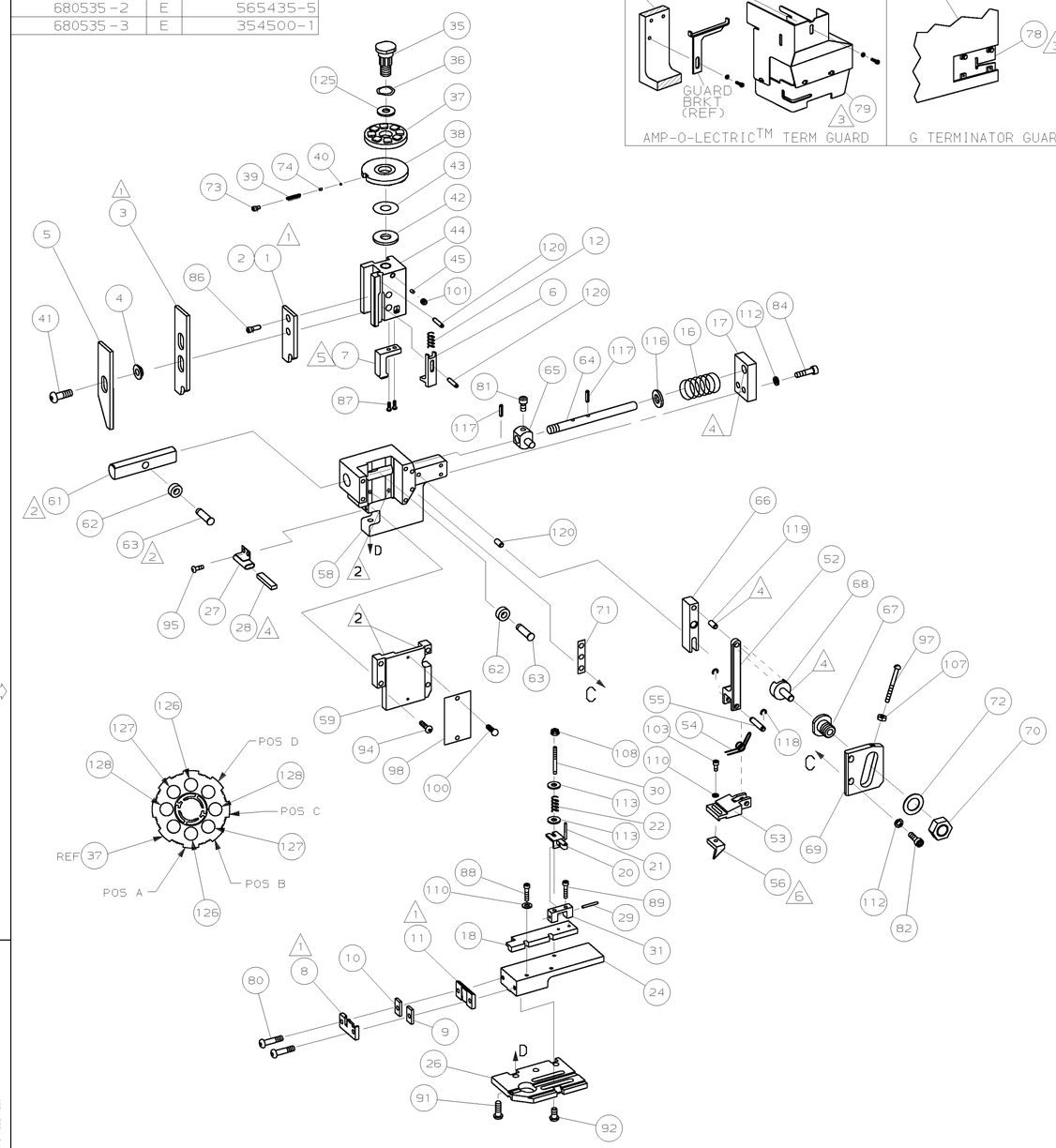
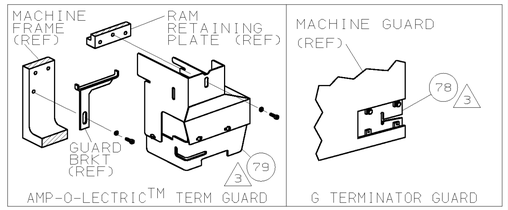
DRAWING MADE IN THIRD ANGLE PROJECTION

680535 ⇔ 680535

/home/us016926/DMTECmod

PART NUMBER	REV	FIRST USED
680535-1	E	122500-1
680535-2	E	565435-5
680535-3	E	354500-1





TERMINAL NAME: RECEPTACLE, FASTON™ FLAG, .187 SERIES

1217009
1217010

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.063 ±.002 [1.60 ±0.05mm]	16
B	.059 ±.002 [1.50 ±0.05mm]	18
C	.057 ±.002 [1.45 ±0.05mm]	20
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.090 [2.29mm]	C	20-16
INSUL	.130 [3.30mm]	C	ø.090-.130

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.156-.188	114-2155	.650	408-8039	NONE	L2051

-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
							129
2	2	2	-	C	1-354779-4	PIN, WIRE DISC (.3060)C	128
2	2	2	-	C	1-354779-0	PIN, WIRE DISC (.3040)B	127
2	2	2	-	C	354779-2	PIN, WIRE DISC (.3000)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	-	-	4088039	EF APPL INST 408-8039	123
							122
							121
2	2	2	-	A	4-21028-9	PIN,SLTD SPRING(ø.125x.375)	120
1	1	1	-	A	1-21030-1	PIN,DOWEL(ø.187x.50)LEVER	119
2	2	2	-	A	21045-3	RING,RET"C"(ø.187)FD PIN	118
2	2	2	-	A	5-21028-1	PIN,STD SPRING(ø.12)FD ADJ ROD	117
1	1	1	-	A	21899-4	WASHER,FLAT(ø5/16)SCR ADJ	116
							115
							114
2	2	2	-	A	21899-2	WASHER, FLAT(#10)	113
4	4	4	-	A	21024-5	WASHER,LOCK(NO.10)FD ROD GDE	112
							111
3	3	3	-	A	21024-4	WASHER,LOCK(NO.8)ST GDE	110
							109
1	1	1	-	A	21022-3	NUT,HEX SL(10-32)DRAG STUD	108
1	1	1	-	A	21018-5	NUT,HEX(6-32)FD ADJ PL	107
							106
							105
							104
1	1	1	-	A	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	103
1	1	1	-	A	3-21000-9	SCR,SHC(10-32x1.00)CAM	102
1	1	1	-	A	21009-2	SCR,SKT SET(1/4-20x.25)RAM	101
2	2	2	-	A	21017-2	SCR,DRIVE(#2x.19)ID PLATE	100
1	1	1	-	A	1-21002-7	SCR,BHC(6-32x.38)CAM	99
1	1	1	-	B	461264-1	PLATE, IDENTIFICATION	98
1	1	1	-	A	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	97
							96
2	2	2	-	A	2-21002-1	SCR,BHC(8-32x.38)HOLDER	95
4	4	4	-	A	2-21002-9	SCR,BHC(10-32x.75)HSG CAP	94
							93
4	4	4	-	A	3-21002-3	SCR,BHC(1/4-20x.50)ST GD PL	92
3	3	3	-	A	2-22733-8	SCR,BHC(1/4-20x.62)BASE PL	91
							90
2	2	2	-	A	2-21000-8	SCR,SHC(8-32x.62)DRAG MOUNT	89
2	2	2	-	A	2-21000-9	SCR,SHC(8-32x.75)STRIP GUIDE	88
2	2	2	-	A	1-21002-8	SCR,BSHC(6-32x.50)SLUG BLADE	87
1	1	1	-	A	2-21000-6	SCR,SHC(8-32x.38)CRIMPER	86
							85
2	2	2	-	A	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GDE	84
							83
2	2	2	-	A	3-21000-6	SCR,SHC(10-32x.62)FEED ADJ PL	82
1	1	1	-	A	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLOCK	81
2	2	2	-	A	4-21000-1	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	1	-	A	690603-1	SPRING, ASSIST	74
1	1	1	-	A	23030-1	SCR,SKT CAP(6-32x.25)CP DSC	73
1	1	1	-	A	458109-1	WASHER, FLAT (SPECIAL)	72
1	1	1	-	A	690517-1	SPACER	71

QTY REQD PER ASSY — PARTS LIST

-1	LEADMAKER &	MECH POST FEED
-2	BENCH MODEL K	MECH PRE FEED
-3	BENCH MODEL G	MECH PRE FEED

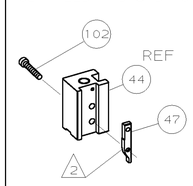
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
1	1	1	-	A	22594-8	NUT, HEX	70
1	1	1	-	B	240628-1	PLATE, ADJ	69
1	1	1	-	B	240626-1	SHAFT, PIVOT	68
1	1	1	-	B	240633-1	BUSHING	67
1	1	1	-	A	455680-1	LEVER, INTERMEDIATE	66
1	1	1	-	B	240629-1	BLOCK, PIVOT	65
1	1	1	-	A	240632-2	SCR, ADJ	64
1	1	1	-	B	240659-3	PIN, CAM ROLLER	63
1	1	1	-	B	240658-1	CAM, ROLLER	62
1	1	1	-	B	454398-1	ROD, FEED	61
							60
1	1	1	-	C	454220-9	CAP, RAM	59
1	1	1	-	D	453736-5	HOUSING	58
							57
1	1	1	-	B	224716-1	PAWL, FEED	56
1	1	1	-	B	240624-1	PIN, FEED FINGER	55
1	1	1	-	B	691499-1	SPRING, FEED FINGER	54
1	1	1	-	B	690541-1	HOLDER, FEED FINGER	53
1	1	1	-	B	455679-2	LEVER, TERMINAL	52
							51
							50
1	-	-	-	B	453991-1	CAM, PRE-FEED 1 5/8 ST	49
-	1	-	-	B	690696-1	CAM, PRE-FEED 1 1/8 ST	48
-	-	1	-	B	238015-1	CAM, POST-FEED 1 5/8 ST	47
							46
1	1	1	-	A	690191-1	PLUG, NYLON	45
1	1	1	-	C	691533-2	RAM	44
1	1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	1	-	A	690124-1	WASHER, RAM	42
1	1	1	-	A	3-21002-6	BOLT, CRIMPER(1/4-20x.88)	41
1	1	1	-	A	23241-6	BALL, STEEL	40
1	1	1	-	A	690170-1	SPRING, COMPRESSION	39
1	1	1	-	C	690142-1	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
							33
							32
1	1	1	-	C	454569-1	MOUNT, DRAG	31
1	1	1	-	A	1-22354-9	DRAG, STUD	30
1	1	1	-	A	21030-2	PIN, MOUNT, DRAG	29
1	1	1	-	A	1424238-1	WICK, LUBRICATING	28
1	1	1	-	B	1338776-1	HOLDER, WICK	27
1	1	1	-	C	455676-1	PLATE, BASE	26
							25
1	1	1	-	B	1213071-1	PLATE, STRIP GUIDE	24
							23
1	1	1	-	A	8-22282-6	SPRING, DRAG	22
1	1	1	-	A	21030-6	LEVER, DRAG	21
1	1	1	-	A	454570-1	DRAG, STOCK	20
							19
1	1	1	-	C	1213072-1	GUIDE, STRIP (FRONT)	18
1	1	1	-	A	454178-1	GUIDE, FEED ROD	17
1	1	1	-	A	4-22284-9	SPRING, FEED RETURN	16
							15
							14
							13
1	1	1	-	A	5-22280-5	SPRING, HOLD DOWN	12
1	1	1	-	B	240644-5	PLATE, REAR SHEAR	11
1	1	1	-	C	6-240645-9	SPACER, SHEAR PLATE	10
1	1	1	-	B	1320330-1	SPACER, SHEAR PLATE	9
1	1	1	-	D	1213070-1	ANVIL	8
1	1	1	-	B	1214683-1	BLADE, SLUG	7
1	1	1	-	D	2-692134-1	POSITIONER, TERMINAL	6
-	-	1	-	B	1424913-1	GUIDE, WIRE	5
1	1	1	-	B	690574-4	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	1213069-1	CRIMPER, INSULATION	3
							2
1	1	1	-	C	1213068-1	CRIMPER, WIRE	1

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

QTY REQD PER ASSY — PARTS LIST

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. SPACE ITEM 7 .008" FROM ITEM 1.
6. POSITION FEED FINGER TO FEED TERMINAL BETWEEN RECEPTICAL AND EDGE OF CARRIER.

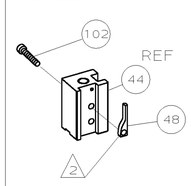
POST-FEED 1 5/8 STROKE



ROTATED 180°

LEADMAKER

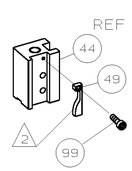
PRE-FEED 1 1/8 STROKE



ROTATED 180°

K TERMINATOR BENCH MACHINE

PRE-FEED 1 5/8 STROKE



ROTATED 180°

G TERMINATOR BENCH MACHINE

LOC A
DIST 66

P	F	LTR	REVISION RECORD	APP	DATE
		E	ECN 0150-0926-03	TE	8-03
		D1	0150-0338-03	BH	MAR03
		D	0150-0233-02	GB	2-02
		C	ECN 0150-9448-99	DS	7-99
		B	RELEASED	CE	1-99
		A	REVISED	RW	3-98

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 22SEP97 R.O.WILSON | APP 22SEP97 T.ELBIN
CHK 15JAN99 C.ERISMAN | REL - -

AMP Incorporated Harrisburg, PA 17105-3608

NAME END FEED HDM APPLICATOR | MACHINE REF MINI APPL
SCALE - | D | DWG NO 680535 | SHEET 1 OF 1 | REV E

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

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