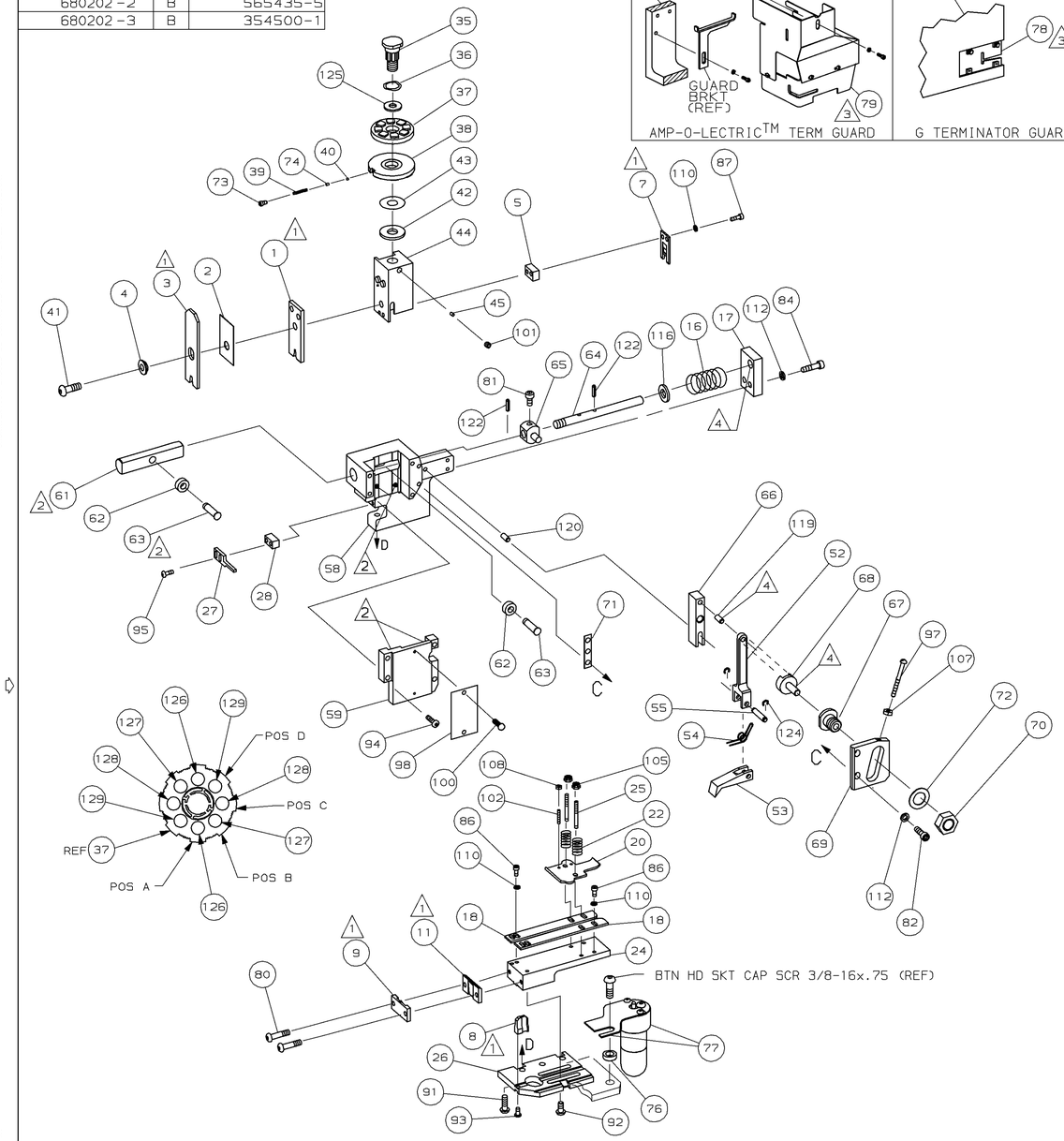
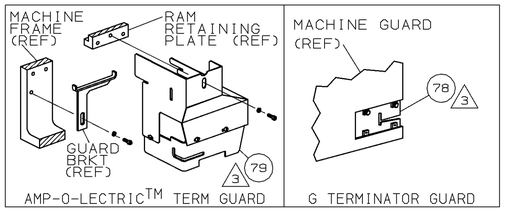
DRAWING MADE IN THIRD ANGLE PROJECTION

THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INCORPORATED. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

PART NUMBER	REV	FIRST USED
680202-1	B	122500-1
680202-2	B	565435-5
680202-3	B	354500-1





TERMINAL NAME: RING TONGUE

626030
626416

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.080 ±.002 [2.03 ±0.05mm]	1.5mm²
B	.074 ±.002 [1.88 ±0.05mm]	1mm²
C	.070 ±.002 [1.78 ±0.05mm]	0.75mm²
D	.068 ±.002 [1.73 ±0.05mm]	0.5mm²

CRIMP	SIZE	TYPE	RANGE
WIRE	.110 [2.79mm]	F	0.5mm²-1.5mm²
INSUL	.160 [4.06mm]	F	1.78mm-3.05mm

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
–	114-2084	1.090	408-8039	458638-1	L1678

-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	2	2	–	C	9-354778-1	PIN, WIRE DISC (.2950)D	129
2	2	2	–	C	8-354778-9	PIN, WIRE DISC (.2940)C	128
2	2	2	–	C	7-354778-9	PIN, WIRE DISC (.2890)B	127
2	2	2	–	C	6-354778-8	PIN, WIRE DISC (.2835)A	126
1	1	1	–	A	986950-1	WASHER, FLAT PRECISION	125
REF	REF	REF	–	A	21045-3	RING,RET"C" (ø.187)FD PIN	124
							123
REF	REF	REF	–	A	5-21028-1	PIN,STD SPRING(ø.12)FD ADJ ROD	122
							121
REF	REF	REF	–	A	1-21030-7	PIN,DOWEL(ø.187x1.50)HSG	120
REF	REF	REF	–	A	1-21030-1	PIN,DOWEL(ø.187x.50)LEVER	119
							118
							117
REF	REF	REF	–	A	21899-4	WASHER,FLAT(ø5/16)SCR ADJ	116
							115
							114
							113
REF	REF	REF	–	A	21024-5	WASHER,LOCK(NO.10)FD ROD GDE	112
							111
6	6	6	–	A	21024-4	WASHER,LOCK(NO.8)SHEAR BL	110
							109
2	2	2	–	A	21018-4	NUT,HEX(4-40)DRAG	108
REF	REF	REF	–	A	21018-5	NUT,HEX(6-32)FD ADJ PL	107
							106
2	2	2	–	A	21022-2	NUT,HEX SL(8-32)DRAG STUD	105
							104
							103
2	2	2	–	A	2-21006-6	SCR,SKT SET(4-40x.62)DRAG	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
REF	REF	REF	–	A	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	97
							96
2	2	2	–	A	2-21002-2	SCR,BHC(8-32x.50)STRIPPER	95
REF	REF	REF	–	A	2-21002-9	SCR,BHC(10-32x.75)HSG CAP	94
1	1	1	–	A	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	93
4	4	4	–	A	3-21002-3	SCR,BHC(1/4-20x.50)ST GD PL	92
REF	REF	REF	–	A	2-22733-8	SCR,BHC(1/4-20x.62)BASE PL	91
							90
							89
							88
2	2	2	–	A	2-21000-9	SCR,SHC(8-32x.75)SLUG BLADE	87
4	4	4	–	A	2-21000-6	SCR,SHC(8-32x.38)STRIP GUIDE	86
							85
REF	REF	REF	–	A	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GDE	84
							83
REF	REF	REF	–	A	3-21000-6	SCR,SHC(10-32x.62)FEED ADJ PL	82
REF	REF	REF	–	A	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLOCK	81
2	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
–	1	–	–	C	465184-9	LUBRICATOR ASSY	77
–	1	–	–	A	454406-1	SPACER, LUB BRACKET	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, FLAT (SPECIAL)	72
REF	REF	REF	–	A	690517-1	SPACER	71
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

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
REF	REF	REF	–	A	22594-8	NUT, HEX	70
REF	REF	REF	–	B	240628-1	PLATE, ADJ	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	SCR, ADJ	64
REF	REF	REF	–	B	240659-3	PIN, CAM ROLLER	63
REF	REF	REF	–	B	240658-1	CAM, ROLLER	62
REF	REF	REF	–	B	454398-1	ROD, FEED	61
							60
REF	REF	REF	–	C	454220-1	CAP, RAM	59
REF	REF	REF	–	D	453736-1	HOUSING	58
							57
							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	240635-1	FINGER, FEED	53
REF	REF	REF	–	B	240634-1	LEVER, TERMINAL	52
							51
							50
1	–	–	–	B	690602-6	CAM, PRE-FEED 1 5/8 ST	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
							46
1	1	1	–	A	690191-1	PLUG, NYLON	45
1	1	1	–	C	455674-1	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(5/16-24x1.00)	41
1	1	1	–	A	23241-6	BALL, STEEL	40
1	1	1	–	A	690170-1	SPRING, COMPRESSION	39
1	1	1	–	C	690142-1	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
1	1	1	–	D	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
							31
							30
							29
1	1	1	–	B	3-690451-2	SPACER, STRIPPER	28
1	1	1	–	A	240639-1	STRIPPER	27
REF	REF	REF	–	C	455676-1	PLATE, BASE	26
2	2	2	–	A	22354-8	DRAG, STUD	25
1	1	1	–	B	455678-1	PLATE, STRIP GUIDE	24
							23
2	2	2	–	A	4-22281-1	SPRING, DRAG	22
							21
1	1	1	–	A	454177-1	DRAG, STOCK	20
1	1	1	–	C	4-458030-2	GUIDE, STRIP (REAR)	19
1	1	1	–	C	4-458031-2	GUIDE, STRIP (FRONT)	18
REF	REF	REF	–	A	454178-1	GUIDE, FEED ROD	17
REF	REF	REF	–	A	4-22284-9	SPRING, FEED RETURN	16
							15
							14
							13
							12
1	1	1	–	B	240644-1	PLATE, REAR SHEAR	11
							10
1	1	1	–	B	690482-4	PLATE, FRONT SHEAR	9
1	1	1	–	D	9-683452-6	ANVIL	8
1	1	1	–	B	690474-4	BLADE, SLUG	7
							6
1	1	1	–	C	6-240641-1	SPACER, SLUG BLADE	5
1	1	1	–	B	238009-1	SPACER, BLOCK CRIMPER	4
1	1	1	–	C	456134-9	CRIMPER, INSULATION	3
1	1	1	–	B	455888-8	SPACER, CRIMPER	2
1	1	1	–	C	456408-6	CRIMPER, WIRE	1
-3	-2	-1	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

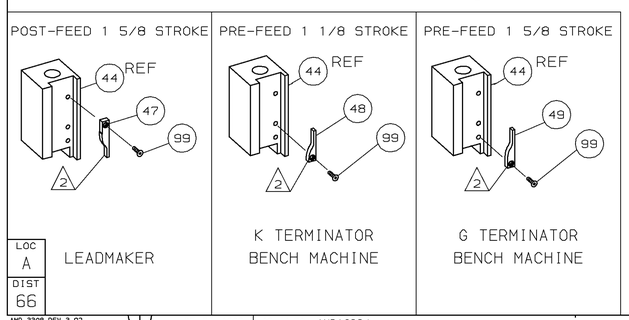
1 RECOMMENDED SPARE PARTS.

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.



LOC A DIST 66

B	0150-6987-96	TB	7-96	
A	REVISED	MO	11/95	
P F	LTR REVISION RECORD	APP	DATE	

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 10/4/95 R.O.WILSON
APP 10-5-95 A BEDDICK
CHK 10-4-95 C ERISMAN
REL 1/5/96 B. MORGAN

AMP Incorporated Harrisburg, PA 17105-3608

NAME END FEED HDM APPLICATOR
MACHINE REF MINI APPL
SCALE – DWG NO 680202 SHEET 1 OF 1 REV B

THIS INFORMATION IS CONFIDENTIAL AND IS DISCLOSED TO YOU ON CONDITION THAT NO FURTHER DISCLOSURE IS MADE BY YOU TO OTHER THAN AMP PERSONNEL WITHOUT WRITTEN AUTHORIZATION FROM AMP INCORPORATED, HARRISBURG, PA.