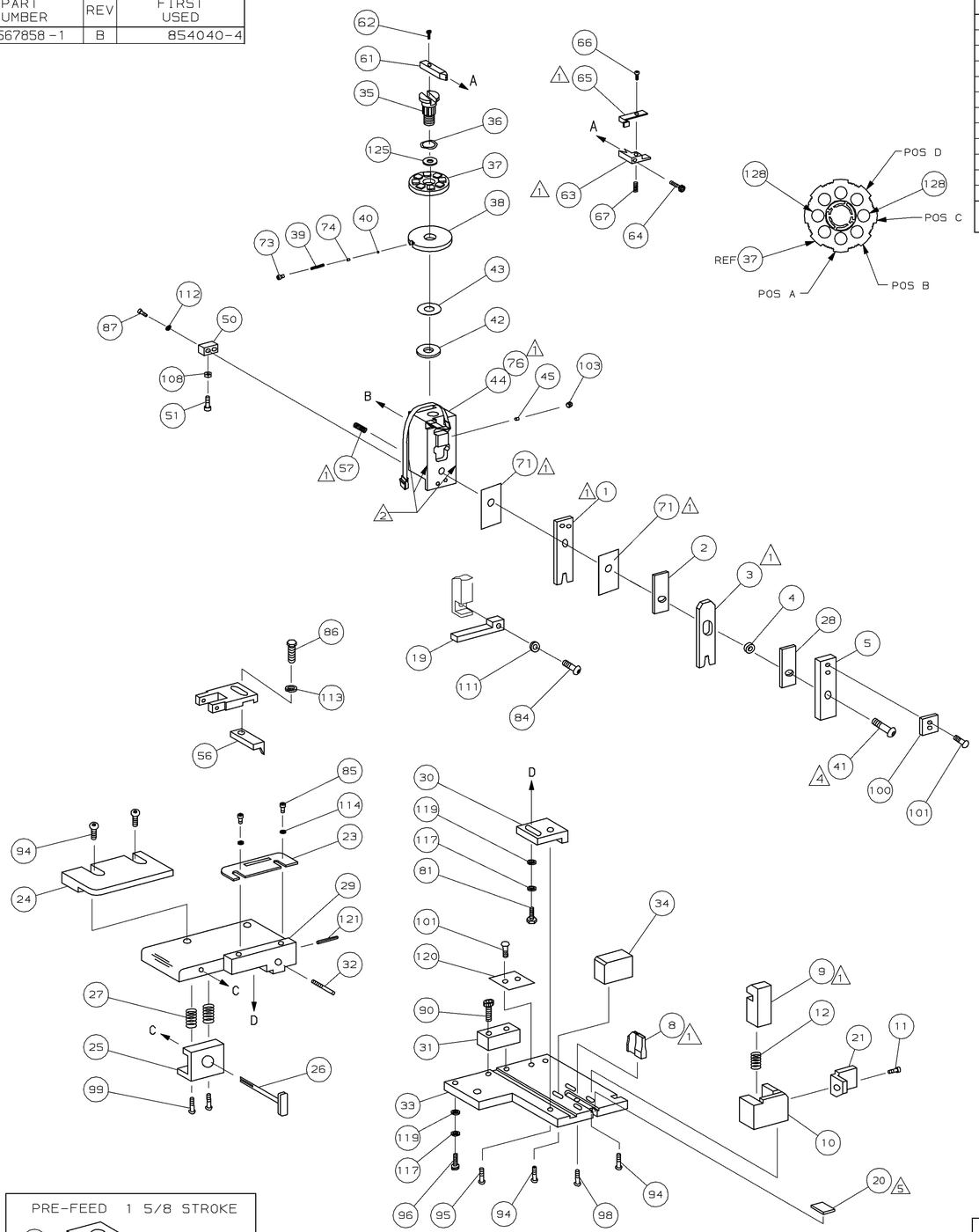
DRAWING MADE IN THIRD ANGLE PROJECTION

PART NUMBER	REV	FIRST USED
567858-1	B	854040-4



TERMINAL NAME: DDC TYPE CONNECTOR

318368

VISIBLE PAD LTR	CRIMPING DATA: CRIMP HEIGHT	WIRE SIZE
A	.047 ±.002 [1.19 ±0.05mm]	18
B	NOT	USED
C	NOT	USED
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.076 [1.93mm]	F	18
INSUL	.115 (2.92mm)	O	ø.090 MAX

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.217-.236	NONE	.575	SEE CUSTOMER MANUAL	NONE	L1668

	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
						129
	2	-	C	5-354779-0	PIN, WIRE DISC (.3240)C	128
						127
						126
	1	-	A	986950-1	WASHER, FLAT PRECISION	125
	1	-	A	217238-4	DOCUMENTATION PACKAGE	124
						123
						122
	1	-	A	4-21028-0	PIN,SLT SPR(ø.093x.75)ST GDE PL	121
	1	-	B	690701-2	PLATE, SERIAL NO.	120
	2	-	A	21899-2	WASHER,FLAT(#10)S G ADJ BLK	119
						118
	2	-	A	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
						116
						115
	2	-	A	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
	REF	-	A	21024-4	WASHER,LOCK(#8)FEED FINGER	113
	2	-	A	21024-4	WASHER,LOCK(#8)DEP-HOLD	112
	REF	-	A	21024-4	WASHER,LOCK(#8)STRIPPER	111
						110
						109
	1	-	A	21018-5	NUT,HEX(#6)HOLD DOWN	108
						107
						106
						105
						104
	1	-	A	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
						102
	4	-	A	21017-2	SCR,DRIVE(#2x.19)ID PLATE	101
	1	-	B	819347-1	PLATE, IDENTIFICATION	100
	2	-	A	3-21002-0	SCR,BHC(10-32x.88)DRAG	99
	1	-	A	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
						97
	1	-	A	3-21000-8	SCR,SHC(10-32x.88)MOUNTING	96
	1	-	A	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLK	95
	6	-	A	2-21002-2	SCR,BHC(8-32x.50)SHEAR-TERM SUP	94
						93
						92
	1	-	A	1-21002-7	SCR,SHC(6-32x.50)CAM	91
	2	-	A	2-21000-7	SCR,SHC(8-32x.50)SCR BLK	90
						89
						88
5	2	-	A	2-21000-7	SCR,SHC(8-32x.48)HLD DWN	87
	REF	-	A	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
	2	-	A	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	85
	REF	-	A	22733-9	SCR,BHC(8-32x.50 SL)STRIPPER	84
						83
						82
	1	-	A	3-22603-1	SCR,HEX(10-32x.38)SG ADJ BL	81
						80
						79
						78
3 1	2	-	B	463310-4	BLADE, STRIPPING (#18)	77
1	-	-	D	354440-3	FFC LOOP ASSY	76
						75
	1	-	A	690603-1	SPRING, ASSIST	74
	1	-	A	23030-1	SCR,SKT CAP(6-32x.25)CP DSC	73
						72
1	2	-	B	853495-1	GASKET	71

QTY REQD PER ASSY — PARTS LIST

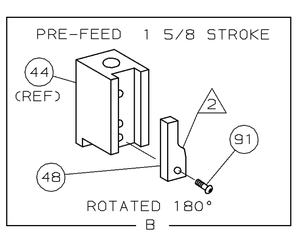
STANDARD FORCE CRIMP QUALITY MONITOR APPLICATOR
SIM TO HDM 680191

	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
						70
						69
						68
	1	-	A	2-21010-7	SCR,SET(6-32x.12)LIFT ARM	67
	1	-	B	1-21002-6	SCR,BHC(6-32x.25)LEVER	66
1	1	-	B	856044-1	LEVER, SLIDE LOCK	65
	1	-	A	2-21000-0	SCR,SHC(6-32x.50)LIFT ARM	64
1	1	-	B	856043-1	ARM, LIFT	63
	1	-	A	2-21000-6	SCR,SHC(8-32x.38)EXT ARM	62
	1	-	B	856042-1	ARM, EXTENSION	61
						60
						59
						58
1	1	-	A	7-21013-3	SCR,SET(5/16x.38)CR BOLT	57
	REF	-	B	694433-8	PAWL, FEED	56
						55
						54
						53
						52
	1	-	A	811242-2	BUMPER, HOLDDOWN	51
	1	-	A	690753-1	SPACER, TONKER	50
						49
	1	-	A	690602-6	CAM, PRE-FEED 1.62 STROKE	48
						47
						46
	1	-	A	690191-1	PLUG, NYLON	45
	1	-	C	853493-4	SIDE FEED RAM ASSY	44
	1	-	A	690125-1	WASHER, LAMINATED	43
	1	-	A	690124-1	WASHER, RAM	42
4	1	-	A	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41
	1	-	A	23241-6	BALL, STEEL	40
	1	-	A	690170-1	SPRING, COMPRESSION	39
	1	-	C	690142-1	DISC, INSULATION	38
	1	-	D	354777-1	WIRE DISC, PLASTIC	37
	1	-	A	22480-5	WASHER, SPRING	36
	1	-	B	856041-1	POST, RAM	35
	1	-	B	690786-1	SUPPORT, TERMINAL	34
	1	-	C	462544-1	PLATE, BASE SPECIAL	33
	1	-	A	690432-3	SCREW, ADJUSTMENT	32
	1	-	B	462543-1	BLOCK, SCREW SPECIAL	31
	1	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
	1	-	C	455671-1	PLATE, STRIP GUIDE	29
	1	-	C	455888-4	SPACER, FRONT SHEAR DEP	28
	2	-	A	1-22284-0	SPRING, DRAG	27
	1	-	B	690546-1	LEVER, DRAG RELEASE	26
	1	-	B	240792-1	DRAG, TERMINAL	25
	1	-	D	9-690504-2	GUIDE, STRIP (REAR)	24
	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
						22
	1	-	A	463756-1	GUIDE, SCRAP	21
6	1	-	A	904275-1	SUPPORT, SPRING	20
	REF	-	C	462615-1	STRIPPER	19
						18
						17
						16
						15
						14
						13
	1	-	A	6-22279-4	SPRING, SHEAR	12
	1	-	B	690461-2	STOP, SHEAR (FRONT)	11
	1	-	B	462548-3	HOLDER, SHEAR (FRONT) SP	10
1	1	-	B	462547-3	SHEAR, FLOAT (FRONT) SP	9
1	1	-	C	662520-8	ANVIL	8
						7
						6
	1	-	A	462838-3	DEPRESSOR, SHEAR (FRONT) SP	5
	1	-	B	238011-6	SPACER, BLOCK CRIMPER	4
1	1	-	C	904741-1	CRIMPER, INSULATION	3
	1	-	C	455888-9	SPACER, CRIMPER	2
1	1	-	C	3-568176-0	CRIMPER, WIRE	1

QTY REQD PER ASSY — PARTS LIST

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

1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. ITEM NOT SHOWN
4. TORQUE ITEM 41 TO 60 INCH POUNDS
5. CUT TO LENGTH AT ASSEMBLY.
6. ATTACH ITEM 20 TO ITEM 33 USING ADHESIVE PART NUMBER 28998-6.



P	F	LTR	REVISION RECORD	APP	DATE
		B	0150-7810-97	TB	6-97
		A	RELEASED	CE	4-97

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 20FEB97	APP J.HIRNEISEN 21FEB97	AMP Incorporated Harrisburg, PA 17105-3608	
CHK C.ERISMAN 21FEB97	REL - -		
NAME CQM STRIPPER CRIMPER APPLICATOR		MACHINE REF STRIPPER CRIMPER	
SCALE -	D	DWG NO 567858	SHEET 1 OF 1 REV B

LOC A
DIST 66

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