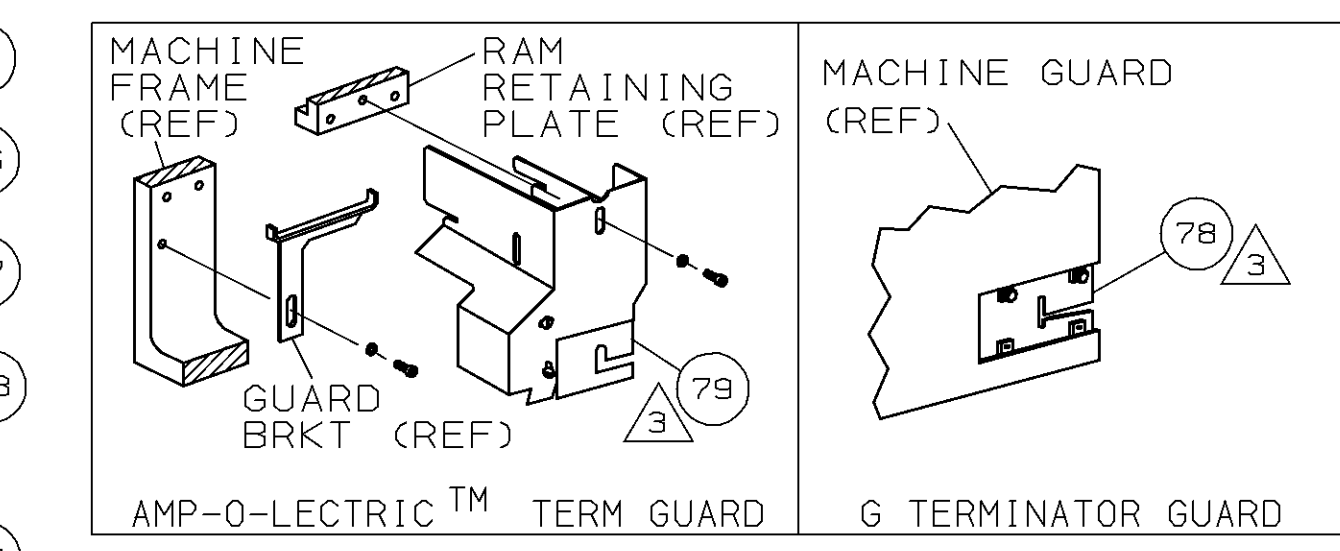
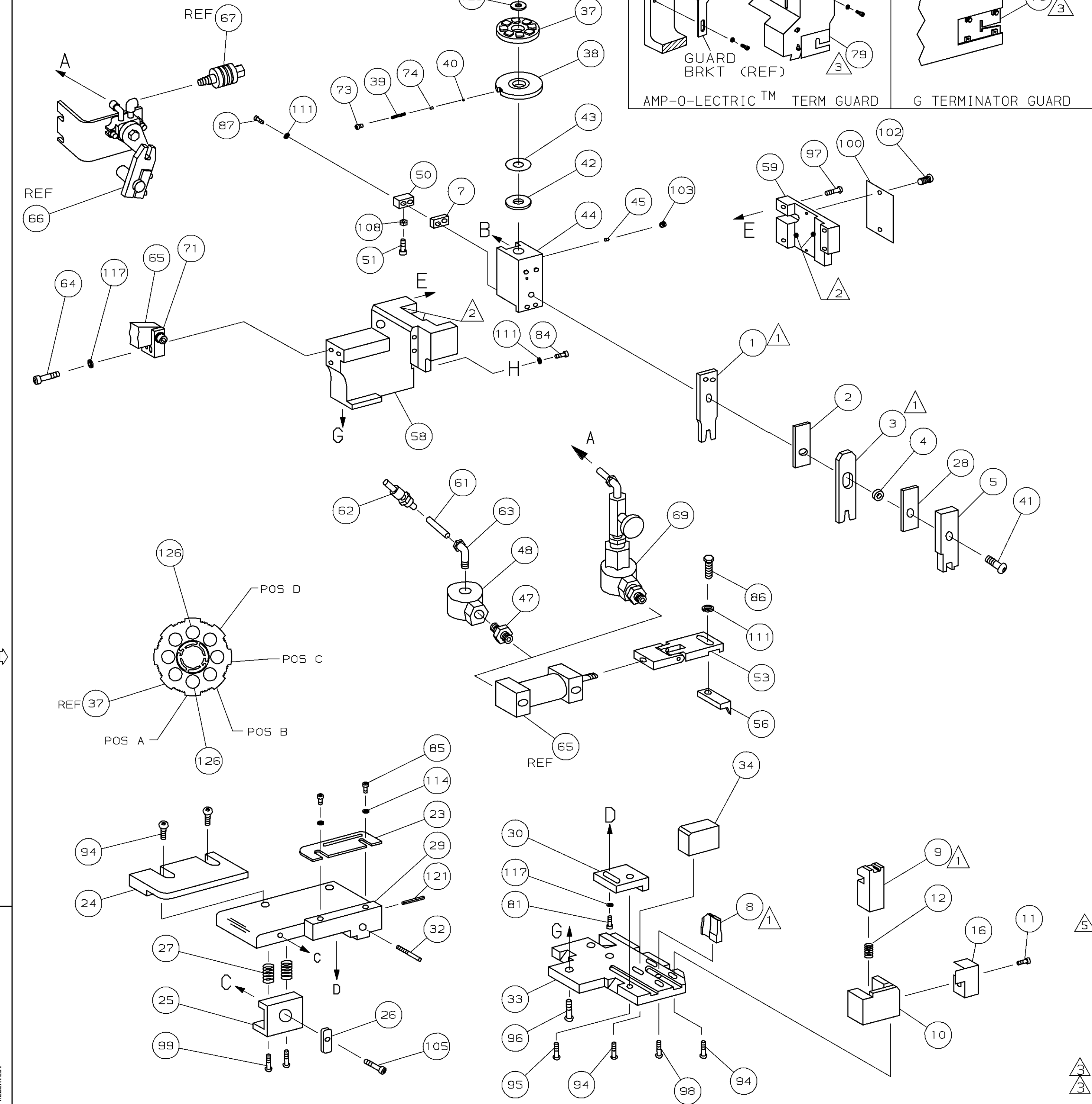


PART NUMBER	REV	FIRST USED
680754-1	A	122500-1
680754-2	A	565435-5
680754-3	A	354500-1



TERMINAL NAME: 4.8 MM TAB WITH DOUBLE LOCKING LANCE

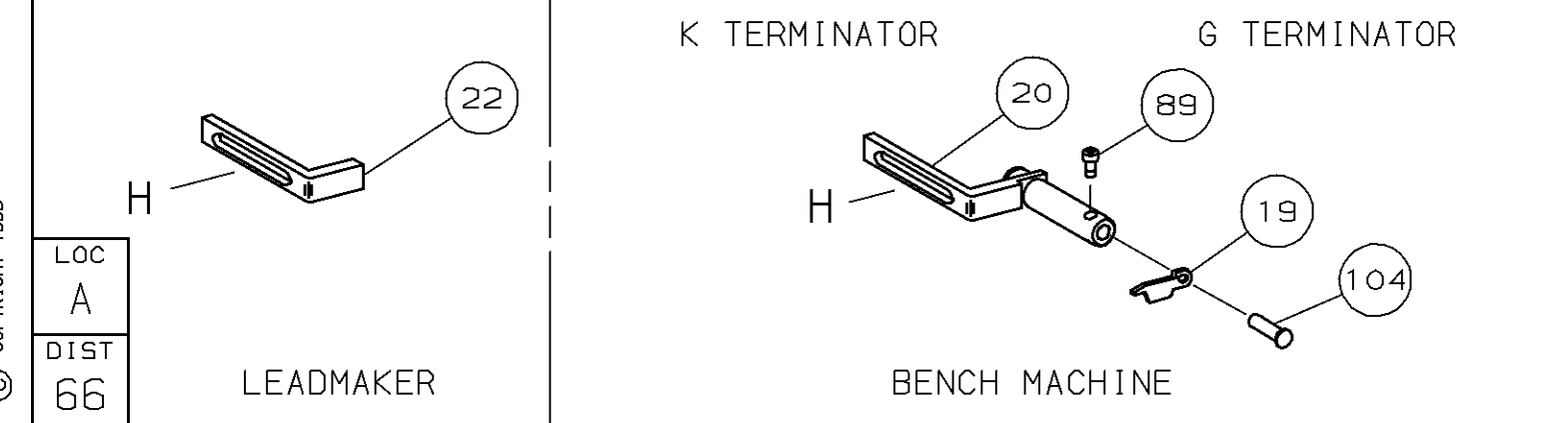
PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.092 ±.002 [2.33 ±0.05mm]	4.0 mm <sup>2</sup>
B	NOT	USED
C	NOT	USED
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.130 [3.30mm]	F	2.5-4.0 mm <sup>2</sup>
INSUL	.270 [6.86mm]	0	∅ 6 mm

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.219-.250	114-2065	.846	408-8040	458637-1	L2180

QTY	REQD	PER	ASSY	PARTS LIST	DESCRIPTION	ITEM NO	
1	1	1	-	A	22353-8	SCR, SHLD (∅.187x.25) DRAG LEVER	105
1	1	1	-	A	992031-1	PIN, CLEVIS	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
1	1	1	-	A	21018-5	NUT, HEX (NO. 6) HOLDDOWN	108
1	1	1	-	A	21024-5	WASHER, LOCK (#10) ADJ BLOCK	117
2	2	2	-	A	21024-2	WASHER, LOCK (#4) FRONT STP GUIDE	114
4	4	4	-	A	21024-4	WASHER, LOCK (#8) STRIPPER	111
1	1	1	-	A	21018-5	NUT, HEX (NO. 6) HOLDDOWN	108
1	1	1	-	A	22353-8	SCR, SHLD (∅.187x.25) DRAG LEVER	105
1	1	1	-	A	992031-1	PIN, CLEVIS	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
1	1	1	-	B	461264-1	PLATE, IDENTIFICATION	100
2	2	2	-	A	3-21002-0	SCR, BHC (10-32x.88) DRAG	99
1	1	1	-	A	22733-8	SCR, BHC (8-32x.38 LW) ANVIL	98
4	4	4	-	A	2-21002-9	SCR, BHC (10-32x.75) 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
6	6	6	-	A	2-21002-2	SCR, BHC (8-32x.50) TERM H DWN	94
1	1	1	-	A	7-21000-9	SCR, SHC (4-40x.19) STRIPPER	89
2	2	2	-	A	2-21000-9	SCR, SHC (8-32x.70) 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) F ST GUIDE	85
1	1	1	-	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
-	1	-	-	B	462992-7	GUARD ASSY	79
REF	-	-	-	B	679532-1	INSERT, GUARD	78
1	1	1	-	A	690603-1	SPRING, ASSIST	74
1	1	1	-	A	23030-1	SCR, SHC (6-32x.25 SL) INS DISC	73
1	1	1	-	B	459610-3	MOUNT, FEED BRACKET	71

- 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 CUT TO LENGTH AT ASSY



QTY	REQD	PER	ASSY	PARTS LIST	DESCRIPTION	ITEM NO	
-1	-	-	-	C	692655-5	AIR FEED VALVE ASSY	70
-2	-	-	-	C	24042-2	VALVE, SHUT OFF	67
-3	-	-	-	C	692655-6	AIR FEED VALVE ASSY	66
1	1	1	-	B	461065-1	AIR FEED ASSY (1 INCH)	65
2	2	2	-	A	3-21000-7	SCR, SHC (10-32x.75) AIR ASSY	64
1	-	1	-	A	980285-2	ELBOW, SWIVEL 1/8 NPT - 1/4 T	63
1	-	1	-	A	23238-1	QUICK DISCONNECT	62
21.00	-	21.00	IN	A	27319-4	TUBING, POLY-FLO ∅.25	61
1	1	1	-	C	454220-1	CAP, RAM	59
1	1	1	-	D	454485-1	HOUSING	58
1	1	1	-	B	1-694433-6	PAWL, FEED	56
1	1	1	-	B	461062-1	FEED FINGER ASSY	53
1	1	1	-	A	811242-2	BUMPER, HOLDDOWN	51
1	1	1	-	A	690753-1	SPACER, TONKER	50
1	-	1	-	A	22374-7	VALVE, QUICK EXHAUST	48
1	-	1	-	A	22304-1	NIPPLE, HEX 1/8 NPT	47
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	690124-1	WASHER, RAM	42
1	1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)	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
1	1	1	-	B	690786-3	SUPPORT, TERMINAL	34
1	1	1	-	D	455675-1	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	3-458144-4	PLATE, STRIP GUIDE	29
1	1	1	-	C	1-455888-2	SPACER, FRONT SHEAR DEP	28
2	2	2	-	A	1-22284-0	SPRING, DRAG	27
1	1	1	-	B	240793-1	LEVER, DRAG RELEASE	26
1	1	1	-	B	240792-1	DRAG, TERMINAL	25
1	1	1	-	D	1-90765-0	GUIDE, STRIP (REAR)	24
1	1	1	-	A	690438-2	GUIDE, STRIP (FRONT)	23
-	-	1	-	B	690472-2	STRIPPER	22
1	1	-	-	A	679218-1	STRIPPER WIRE STOP ASSY	20
1	1	-	-	B	458949-1	STRIPPER	19
1	1	1	-	B	318563-1	GUARD, CHIP, FRONT	16
1	1	1	-	A	5-22280-0	SPRING, SHEAR	12
1	1	1	-	B	690461-1	STOP, SHEAR	11
1	1	1	-	C	1-690459-0	HOLDER, SHEAR (FRONT)	10
1	1	1	-	C	318707-1	SHEAR, FLOAT (FRONT)	9
1	1	1	-	C	1-318088-4	ANVIL	8
1	1	1	-	C	4-240641-5	SPACER, DEPRESSOR (REAR)	7
1	1	1	-	C	2-455889-2	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	1-238011-9	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	904741-8	CRIMPER, INSULATION	3
1	1	1	-	C	1-455888-0	SPACER, CRIMPER	2
1	1	1	-	C	3-458141-3	CRIMPER, WIRE	1

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

QTY	REQD	PER	ASSY	PARTS LIST	DESCRIPTION	ITEM NO	
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED:  
 2 PLC DEC ±.25  
 3 PLC DEC ±.125  
 4 PLC DEC ±.0625  
 ANGLES ±.03125  
 SURF TEXTURE: ✓  
 REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL - HT TR - FIN -

DR P.Mathias 20NOV98 APP T.ELBIN 20NOV98  
 CHK C.ERISMAN 20NOV98 REL -

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL  
 SCALE - DWG NO 680754 SHEET 1 OF 1 REV A

CASE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO

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