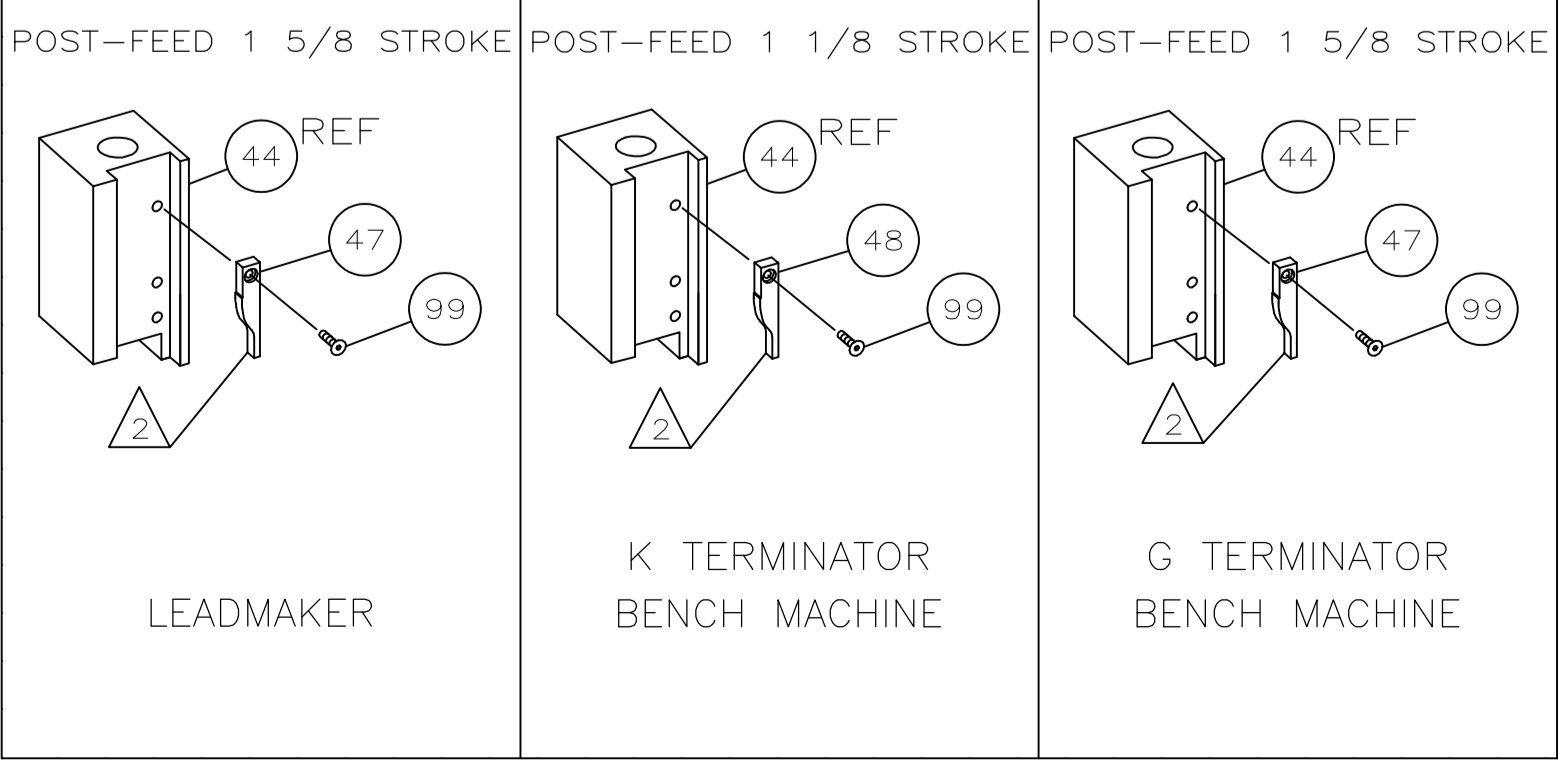
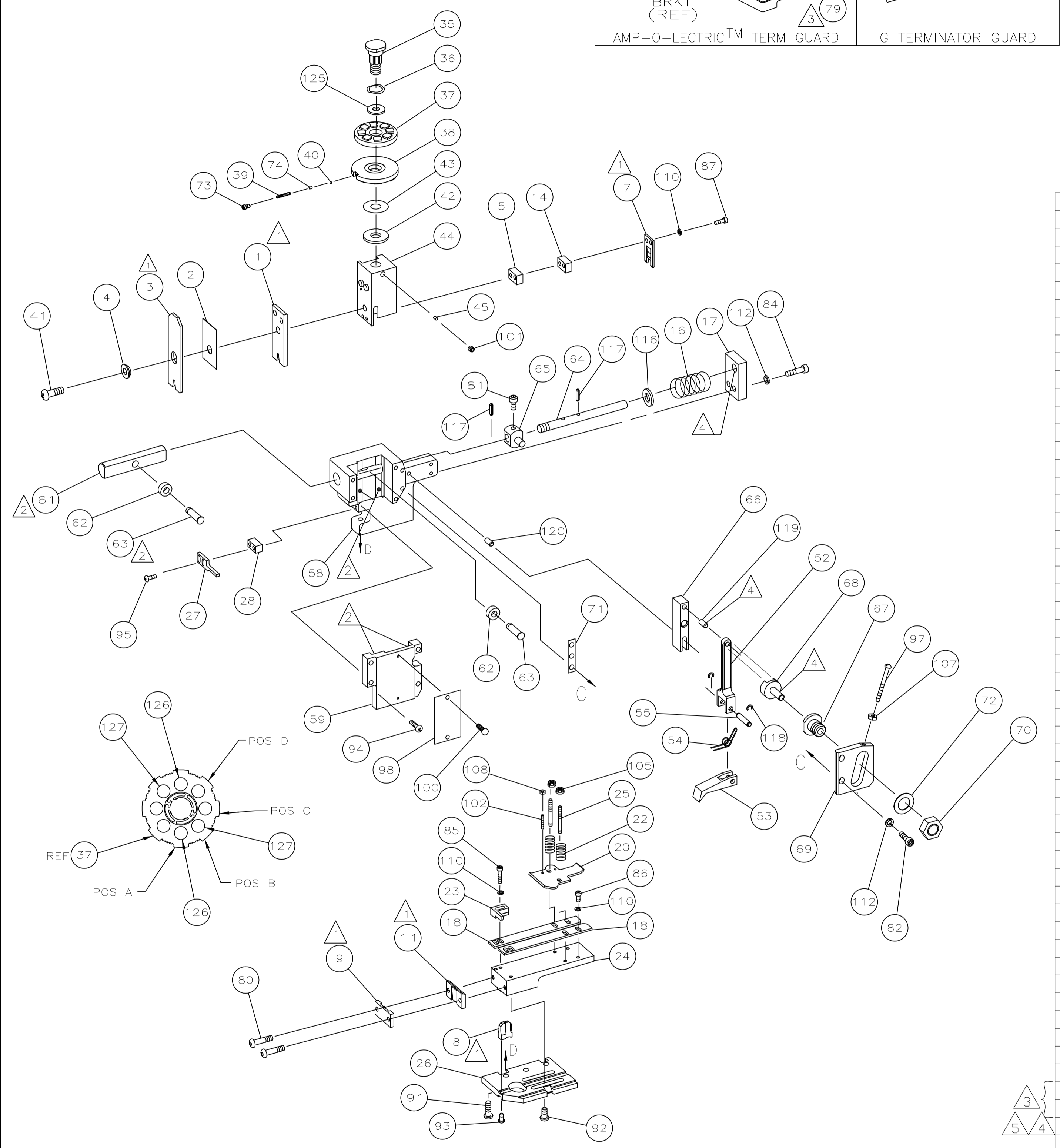
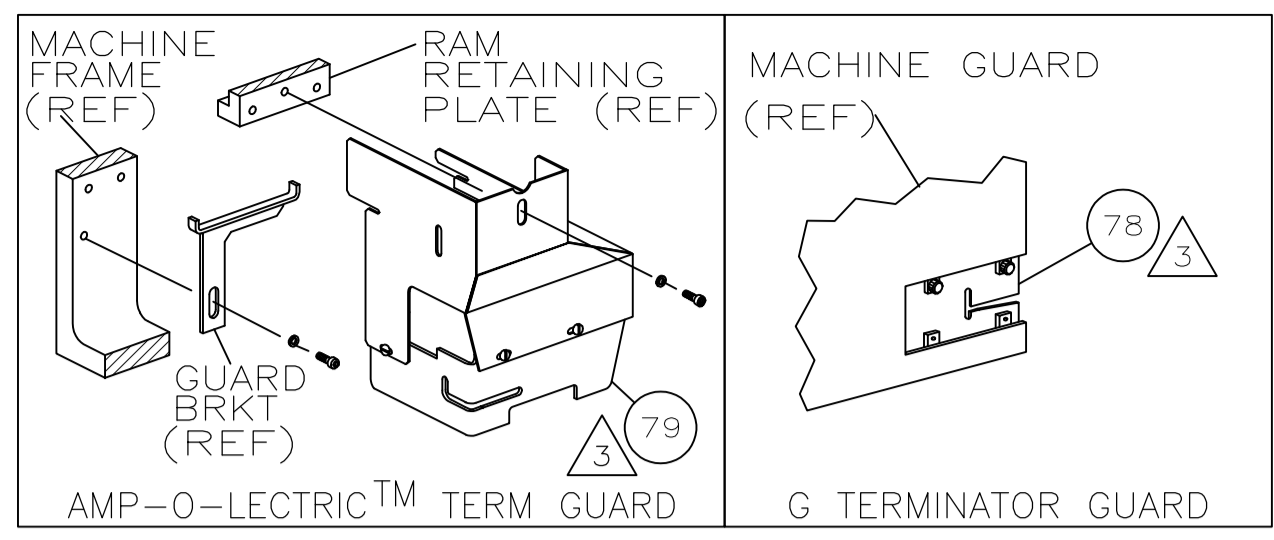


PART NUMBER	REV	FIRST USED
680586-1	A	122500-1
680586-2	A	565435-5
7-680586-7	A	-



- 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.
- 6 ITEM 78 USED WITH G TERMINATOR ONLY.



TERMINAL NAME: RING (COMP TERMINAL-AMP SPEC)		CRIMPING DATA	
AMP	MFG P/N	PAD LTR	CRIMP HEIGHT
286688	100920-E01	A	.143 ±.002 [3.63 ±.05mm]
		B	.131 ±.002 [3.33 ±.05mm]
		C	NOT USED
		D	NOT USED
		CRIMP	SIZE
		WIRE	.210 [5.33mm]
		INSUL	.280 [7.11mm]
			TYPE
			F
			RANGE
			12-10
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
.281-.312	NONE	1.230	408-8039
			SET UP GAGE
			458638-1
			LAYOUT
			L2040

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
-	2	2	-	3-354779-1	PIN, WIRE DISC (.3145)B	129
-	2	2	-	354779-6	PIN, WIRE DISC (.3020)A	128
-	1	1	-	986950-1	WASHER, FLAT PRECISION	127
-	1	1	-	217238-1	GENERAL INSTRUCTION PACKAGE	126
-	1	1	-	4088039	EF APPL INST 408-8039	125
-	REF	REF	-	1-21030-7	PIN, DOWEL (Ø.187x1.50)HSG	124
-	REF	REF	-	1-21030-1	PIN, DOWEL (Ø.187x.50)LEVER	123
-	REF	REF	-	21045-3	RING, RET "C" (Ø.187)FD PIN	122
-	REF	REF	-	5-21028-1	PIN, STD SPRING (Ø.12)FD ADJ ROD	121
-	REF	REF	-	21899-4	WASHER, FLAT (Ø5/16)SCR ADJ	120
-	REF	REF	-	21024-5	WASHER, LOCK (NO.10)FD ROD GDE	119
-	7	7	-	21024-4	WASHER, LOCK (NO.8)SHEAR BL	118
-	2	2	-	21018-4	NUT, HEX (4-40)DRAG	117
-	REF	REF	-	21018-5	NUT, HEX (6-32)FD ADJ PL	116
-	2	2	-	21022-2	NUT, HEX SL (8-32)DRAG STUD	115
-	2	2	-	2-21006-6	SCR, SKT SET (4-40x.62)DRAG	114
-	1	1	-	21009-2	SCR, SKT SET (1/4-20x.25)RAM	113
-	2	2	-	21017-2	SCR, DRIVE (#2x.19)ID PLATE	112
-	1	1	-	1-21002-7	SCR, BHC (6-32x.38)CAM	111
-	1	1	-	461264-1	PLATE, IDENTIFICATION	110
-	REF	REF	-	6-23715-5	SCR, PAN HD (6-32x1.50)FEED ADJ	109
-	2	2	-	2-21002-2	SCR, BHC (8-32x.50)STRIPPER	108
-	REF	REF	-	2-21002-9	SCR, BHC (10-32x.75)HSG CAP	107
-	1	1	-	22733-8	SCR, BHC (8-32x.38 LW)ANVIL	106
-	4	4	-	3-21002-3	SCR, BHC (1/4-20x.50)ST GD PL	105
-	REF	REF	-	2-22733-8	SCR, BHC (1/4-20x.62)BASE PL	104
-	2	2	-	2-21000-9	SCR, SHC (8-32x.75)SLUG BLADE	103
-	3	3	-	2-21000-7	SCR, SHC (8-32x.50)STRIP GUIDE	102
-	2	2	-	3-21000-0	SCR, SHC (8-32x.88)R STRIP GUIDE	101
-	REF	REF	-	3-21000-7	SCR, SHC (10-32x.75)FEED ROD GDE	100
-	REF	REF	-	3-21000-6	SCR, SHC (10-32x.62)FEED ADJ PL	99
-	REF	REF	-	3-21000-4	SCR, SHC (10-32x.38)PIVOT BLOCK	98
-	2	2	-	3-21002-0	SCR, BHC (10-32x.88)SHEAR PL	97
-	REF	REF	-	455745-1	GUARD, WINDOW	96
-	REF	REF	-	679532-1	INSERT, GUARD	95
-	1	1	-	690603-1	SPRING, ASSIST	94
-	1	1	-	23030-1	SCR, SKT CAP (6-32x.25)CP DSC	93
-	REF	REF	-	458109-1	WASHER, FLAT (SPECIAL)	92
-	REF	REF	-	690517-1	SPACER	91
-77	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

REV	DESCRIPTION	DATE	BY	APPV
A2	ECR-09-011624	5-2009	MY	GB

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
-	1	1	-	22594-8	NUT, HEX	70
-	REF	REF	-	240628-1	PLATE, ADJ	69
-	REF	REF	-	240626-1	SHAFT, PIVOT	68
-	REF	REF	-	240633-1	BUSHING	67
-	REF	REF	-	455680-1	LEVER, INTERMEDIATE	66
-	REF	REF	-	240629-1	BLOCK, PIVOT	65
-	REF	REF	-	240632-2	SCR, ADJ	64
-	REF	REF	-	240659-3	PIN, CAM ROLLER	63
-	REF	REF	-	240658-1	CAM, ROLLER	62
-	REF	REF	-	454398-1	ROD, FEED	61
-	REF	REF	-	454220-1	CAP, RAM	60
-	REF	REF	-	453736-1	HOUSING	59
-	REF	REF	-	240624-1	PIN, FEED FINGER	58
-	REF	REF	-	691499-1	SPRING, FEED FINGER	57
-	REF	REF	-	240635-1	FINGER, FEED	56
-	REF	REF	-	240634-1	LEVER, TERMINAL	55
-	1	-	-	690501-3	CAM, POST FEED 1 1/8 ST	54
-	-	1	-	690501-4	CAM, POST-FEED 1 5/8 ST	53
-	1	1	-	690191-1	PLUG, NYLON	52
-	1	1	-	455674-1	RAM	51
-	1	1	-	690125-1	WASHER, LAMINATED	50
-	1	1	-	690124-5	WASHER, RAM	49
-	1	1	-	690686-1	BOLT, CRIMPER (5/16-24x1.00)	48
-	1	1	-	23241-6	BALL, STEEL	47
-	1	1	-	690170-1	SPRING, COMPRESSION	46
-	1	1	-	690142-1	DISC, INSULATION	45
-	1	1	-	354777-1	WIRE DISC, PLASTIC	44
-	1	1	-	22480-5	WASHER, SPRING	43
-	1	1	-	690212-1	POST, RAM	42
-	1	1	-	458980-1	APPLICATOR, BASIC (SUB ASSY)	41
-	1	1	-	690455-2	STRIPPER	40
-	REF	REF	-	455676-1	PLATE, BASE	39
-	2	2	-	22354-8	DRAG, STUD	38
-	1	1	-	455678-1	PLATE, STRIP GUIDE	37
-	1	1	-	240825-1	PLATE, STRIP HOLD DOWN	36
-	2	2	-	4-22281-1	SPRING, DRAG	35
-	1	1	-	462925-1	DRAG, STOCK	34
-	2	2	-	454204-8	GUIDE, STRIP (FRONT)	33
-	REF	REF	-	454178-1	GUIDE, FEED ROD	32
-	REF	REF	-	4-22284-9	SPRING, FEED RETURN	31
-	1	1	-	5-240641-4	SPACER, SLUG BLADE	30
-	1	1	-	240644-1	PLATE, REAR SHEAR	29
-	1	1	-	690482-7	PLATE, FRONT SHEAR	28
-	1	1	-	5-461295-9	ANVIL	27
-	1	1	-	2-690474-0	BLADE, SLUG	26
-	1	1	-	5-240641-3	SPACER, SLUG BLADE	25
-	1	1	-	238009-7	SPACER, BLOCK CRIMPER	24
-	1	1	-	5-456134-6	CRIMPER, INSULATION	23
-	1	1	-	455888-9	SPACER, CRIMPER	22
-	1	1	-	6-458141-1	CRIMPER, WIRE	21
-77	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.

W: HOOVER 2/17/98
 C: FRISMAN 2/17/98
 T: ELBIN 2/17/98

Tyco Electronics
 Tyco Electronics Corporation
 Harrisburg, PA 17105-3608

END FEED HDM APPLICATOR

SIZE: A1
 CASE CODE: 00779
 DRAWING NO: 680586

CUSTOMER DRAWING

SCALE: - SHEET 1 OF 1 REV: A2