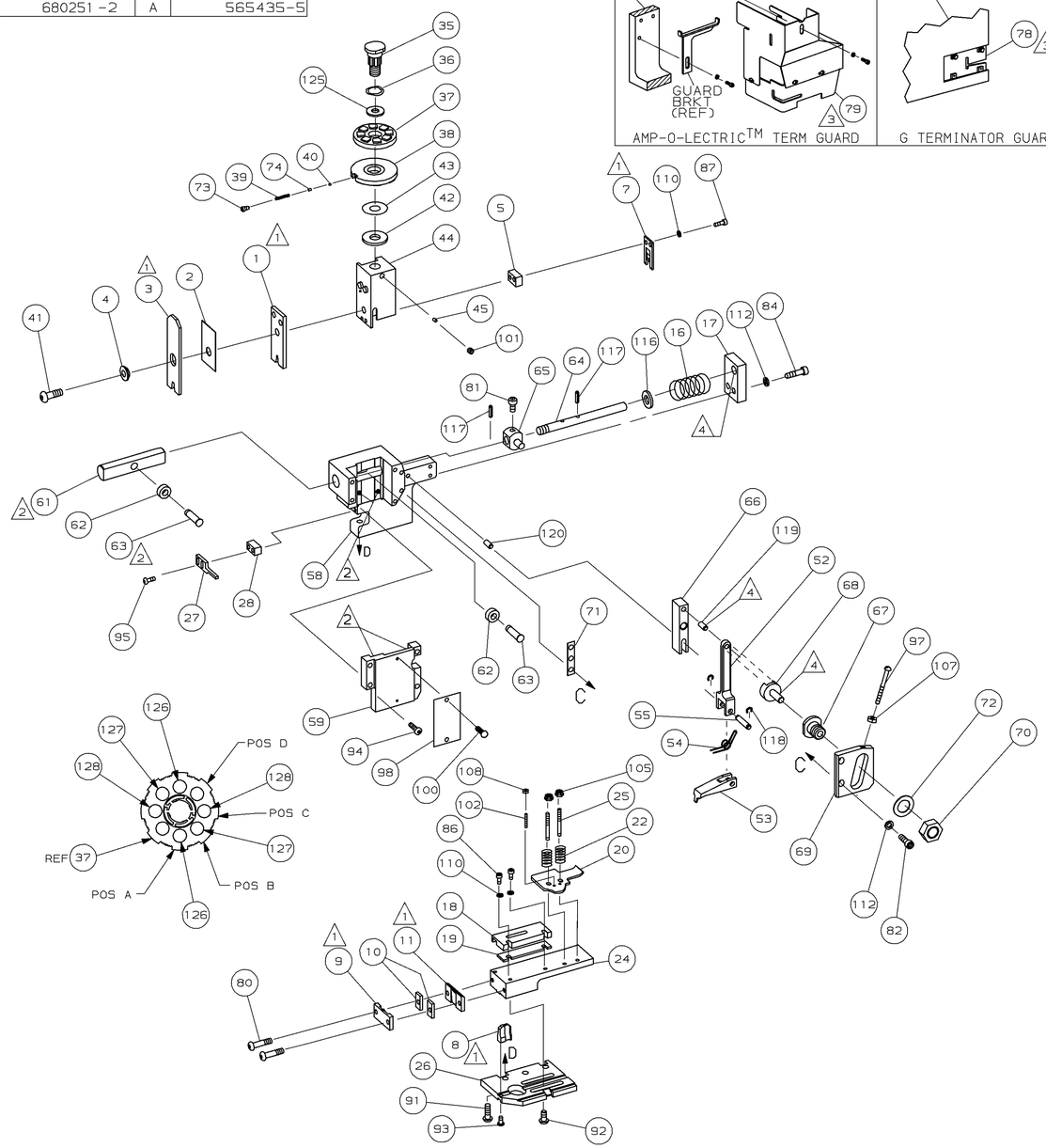
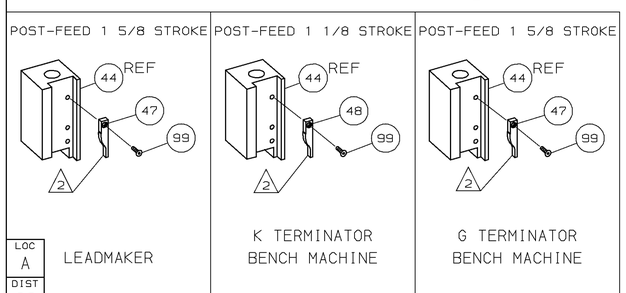
DRAWING MADE IN THIRD ANGLE PROJECTION

680251 ⇔ 680251

/home/amp18246

PART NUMBER	REV	FIRST USED
680251 -1	A	122500-1
680251 -2	A	565435-5





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.
6. ITEM 78 USED WITH G TERMINATOR ONLY.
7. CUT TO LENGTH AT ASSY.

TERMINAL NAME: P.C.B. FLAG CONNECTOR TERMINAL

280252

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.053 ±.002 [1.35 ±0.05mm]	1 mm²
B	.049 ±.002 [1.25 ±0.05mm]	0.75 mm²
C	.045 ±.002 [1.14 ±0.05mm]	0.5 mm²
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.080 [2.03mm]	F	0.5mm² - 1mm²
INSUL	.140 [3.56mm]	F	2 - 3mm

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
–	–	.600	408-8039	458638-1	L1721

	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
							129
	2	2	–	C	5-354779-6	PIN, WIRE DISC (.3270)C	128
	2	2	–	C	4-354779-8	PIN, WIRE DISC (.3230)B	127
	2	2	–	C	4-354779-0	PIN, WIRE DISC (.3190)A	126
	1	1	–	A	986950-1	WASHER, FLAT PRECISION	125
	1	1	–	A	217238-1	DOCUMENTATION PACKAGE	124
	1	1	–	–	4088039	EF APPL INST 408-8039	123
							122
							121
	1	1	–	A	1-21030-7	PIN,DOWEL(ø.187x1.50)HSG	120
	1	1	–	A	1-21030-1	PIN,DOWEL(ø.187x.50)LEVER	119
	2	2	–	A	21045-3	RING,RET"C"(ø.187)FD PIN	118
	2	2	–	A	5-21028-1	PIN,STD SPRING(ø.12)FD ADJ ROD	117
	1	1	–	A	21899-4	WASHER,FLAT(ø5/16)SCR ADJ	116
							115
							114
							113
	4	4	–	A	21024-5	WASHER,LOCK(NO.10)FD ROD GDE	112
							111
	6	6	–	A	21024-4	WASHER,LOCK(NO.8)SHEAR BL	110
							109
	2	2	–	A	21018-4	NUT,HEX(4-40)DRAG	108
	1	1	–	A	21018-5	NUT,HEX(6-32)FD ADJ PL	107
							106
	2	2	–	A	21022-2	NUT,HEX SL(8-32)DRAG STUD	105
							104
							103
	2	2	–	A	2-21006-6	SCR,SKT SET(4-40x.62)DRAG	102
	1	1	–	A	21009-2	SCR,SKT SET(1/4-20x.25)RAM	101
	2	2	–	A	21017-2	SCR,DRIVE(#2x.19)ID PLATE	100
	1	1	–	A	1-21002-7	SCR,BHC(6-32x.38)CAM	99
	1	1	–	B	461264-1	PLATE, IDENTIFICATION	98
	1	1	–	A	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	97
							96
	2	2	–	A	2-21002-2	SCR,BHC(8-32x.50)STRIPPER	95
	4	4	–	A	2-21002-9	SCR,BHC(10-32x.75)HSG CAP	94
	1	1	–	A	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	93
	4	4	–	A	3-21002-3	SCR,BHC(1/4-20x.50)ST GD PL	92
	3	3	–	A	2-22733-8	SCR,BHC(1/4-20x.62)BASE PL	91
							90
							89
							88
7	2	2	–	A	2-21000-6	SCR,SHC(8-32x.31)SLUG BLADE	87
	4	4	–	A	2-21000-7	SCR,SHC(8-32x.50)STRIP GUIDE	86
							85
	2	2	–	A	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GDE	84
							83
	2	2	–	A	3-21000-6	SCR,SHC(10-32x.62)FEED ADJ PL	82
	1	1	–	A	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLOCK	81
	2	2	–	A	3-21002-0	SCR,BHC(10-32x.88)SHEAR PL	80
3	REF	–	–	A	455745-1	GUARD, WINDOW	79
6 3	–	REF	–	A	679532-1	INSERT, GUARD	78
							77
							76
							75
	1	1	–	A	690603-1	SPRING, ASSIST	74
	1	1	–	A	23030-1	SCR,SKT CAP(6-32x.25)CP DSC	73
	1	1	–	A	458109-1	WASHER, FLAT (SPECIAL)	72
	1	1	–	A	690517-1	SPACER	71

QTY REQD PER ASSY — PARTS LIST

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

	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
	1	1	–	A	22594-8	NUT, HEX	70
	1	1	–	B	240628-1	PLATE, ADJ	69
	1	1	–	B	240626-1	SHAFT, PIVOT	68
	1	1	–	B	240633-1	BUSHING	67
	1	1	–	A	455680-1	LEVER, INTERMEDIATE	66
	1	1	–	B	240629-1	BLOCK, PIVOT	65
	1	1	–	A	240632-2	SCR, ADJ	64
	1	1	–	B	240659-3	PIN, CAM ROLLER	63
	1	1	–	B	240658-1	CAM, ROLLER	62
	1	1	–	B	454398-1	ROD, FEED	61
							60
	1	1	–	C	454220-1	CAP, RAM	59
	1	1	–	D	453736-1	HOUSING	58
							57
							56
	1	1	–	B	240624-1	PIN, FEED FINGER	55
	1	1	–	B	691499-1	SPRING, FEED FINGER	54
	1	1	–	B	694921-5	FINGER, FEED	53
	1	1	–	B	240634-1	LEVER, TERMINAL	52
							51
							50
							49
	1	–	–	B	690501-3	CAM, POST FEED 1 1/8 ST	48
	–	1	–	B	690501-4	CAM, POST-FEED 1 5/8 ST	47
							46
	1	1	–	A	690191-1	PLUG, NYLON	45
	1	1	–	C	455674-2	RAM	44
	1	1	–	A	690125-1	WASHER, LAMINATED	43
	1	1	–	A	690124-1	WASHER, RAM	42
	1	1	–	A	7-21002-9	BOLT, CRIMPER(5/16-24x1.00)	41
	1	1	–	A	23241-6	BALL, STEEL	40
	1	1	–	A	690170-1	SPRING, COMPRESSION	39
	1	1	–	C	690142-1	DISC, INSULATION	38
	1	1	–	D	354777-1	WIRE DISC, PLASTIC	37
	1	1	–	A	22480-5	WASHER, SPRING	36
	1	1	–	B	690212-1	POST, RAM	35
							34
							33
							32
							31
							30
							29
	1	1	–	B	2-690451-8	SPACER, STRIPPER	28
	1	1	–	A	240639-2	STRIPPER	27
	1	1	–	C	455676-1	PLATE, BASE	26
	2	2	–	A	22354-8	DRAG, STUD	25
	1	1	–	B	356037-1	PLATE, STRIP GUIDE	24
							23
	2	2	–	A	4-22281-1	SPRING, DRAG	22
							21
	1	1	–	A	356041-1	DRAG, STOCK	20
	1	1	–	B	356040-1	GUIDE, STRIP (REAR)	19
	1	1	–	C	356039-1	GUIDE, STRIP (FRONT)	18
	1	1	–	A	454178-1	GUIDE, FEED ROD	17
	1	1	–	A	4-22284-9	SPRING, FEED RETURN	16
							15
							14
							13
							12
1	1	1	–	B	240644-1	PLATE, REAR SHEAR	11
	2	2	–	C	1-240645-2	SPACER, SHEAR PLATE	10
1	1	1	–	B	240642-1	PLATE, FRONT SHEAR	9
1	1	1	–	D	4-461295-9	ANVIL	8
1	1	1	–	B	356117-1	BLADE, SLUG	7
							6
	1	1	–	C	3-240641-4	SPACER, SLUG BLADE	5
	1	1	–	B	238009-8	SPACER, BLOCK CRIMPER	4
1	1	1	–	C	456134-3	CRIMPER, INSULATION	3
	1	1	–	B	455888-6	SPACER, CRIMPER	2
1	1	1	–	C	2-456405-7	CRIMPER, WIRE	1

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

QTY REQD PER ASSY — PARTS LIST

P	F	LTR	REVISION RECORD	APP	DATE
		A	REVISED	CE	11/98

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 B.HIGMAN 2-20-96 | APP 2-20-96 T. ELBIN | CHK 2-20-96 C. ERISMAN | REL – –

AMP — AMP Incorporated, Harrisburg, PA 17105-3608

NAME END FEED HDM APPLICATOR | MACHINE REF MINI APPL

SCALE – | D | DWG NO 680251 | SHEET 1 OF 1 | REV A

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO –

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