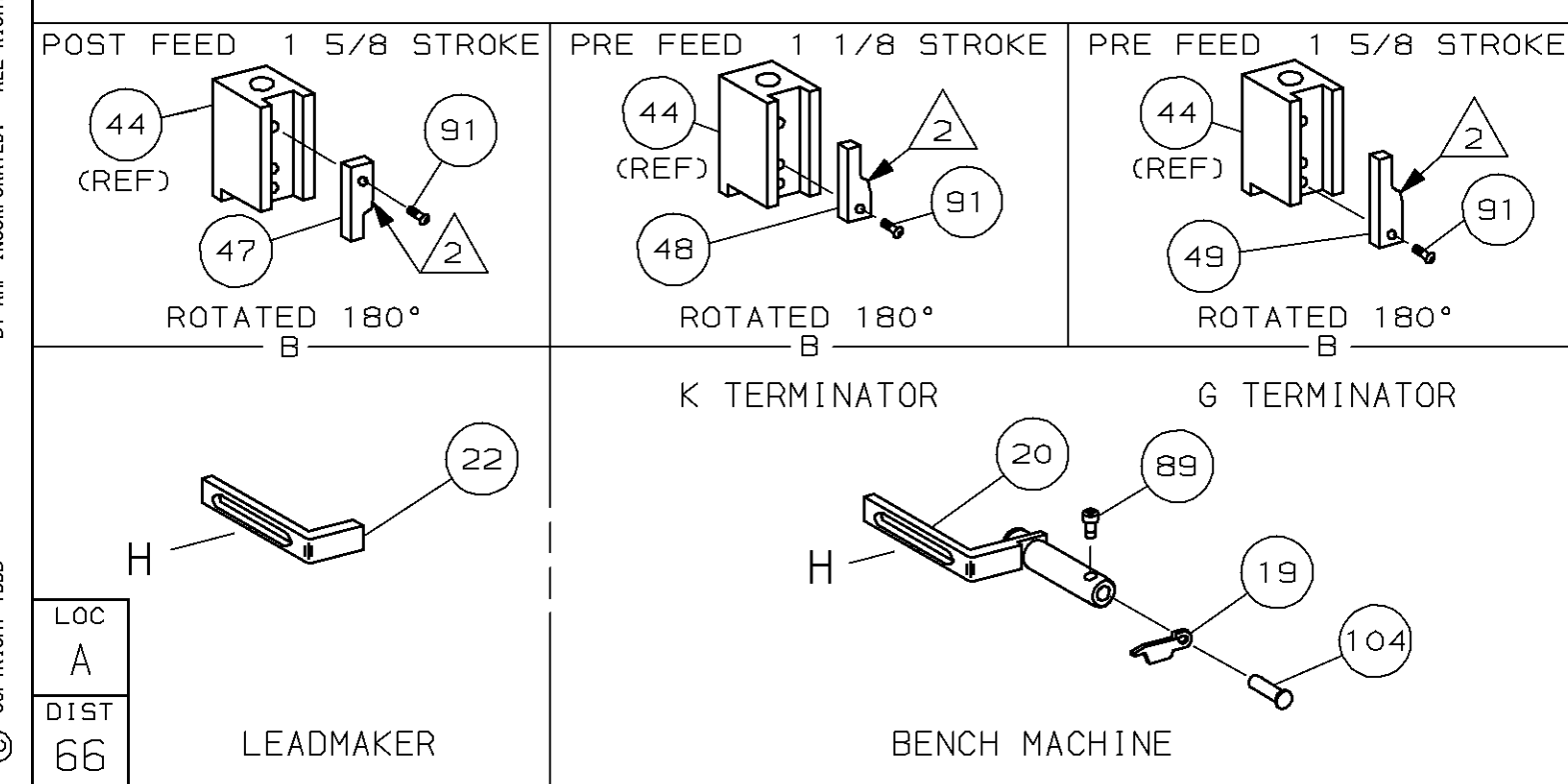
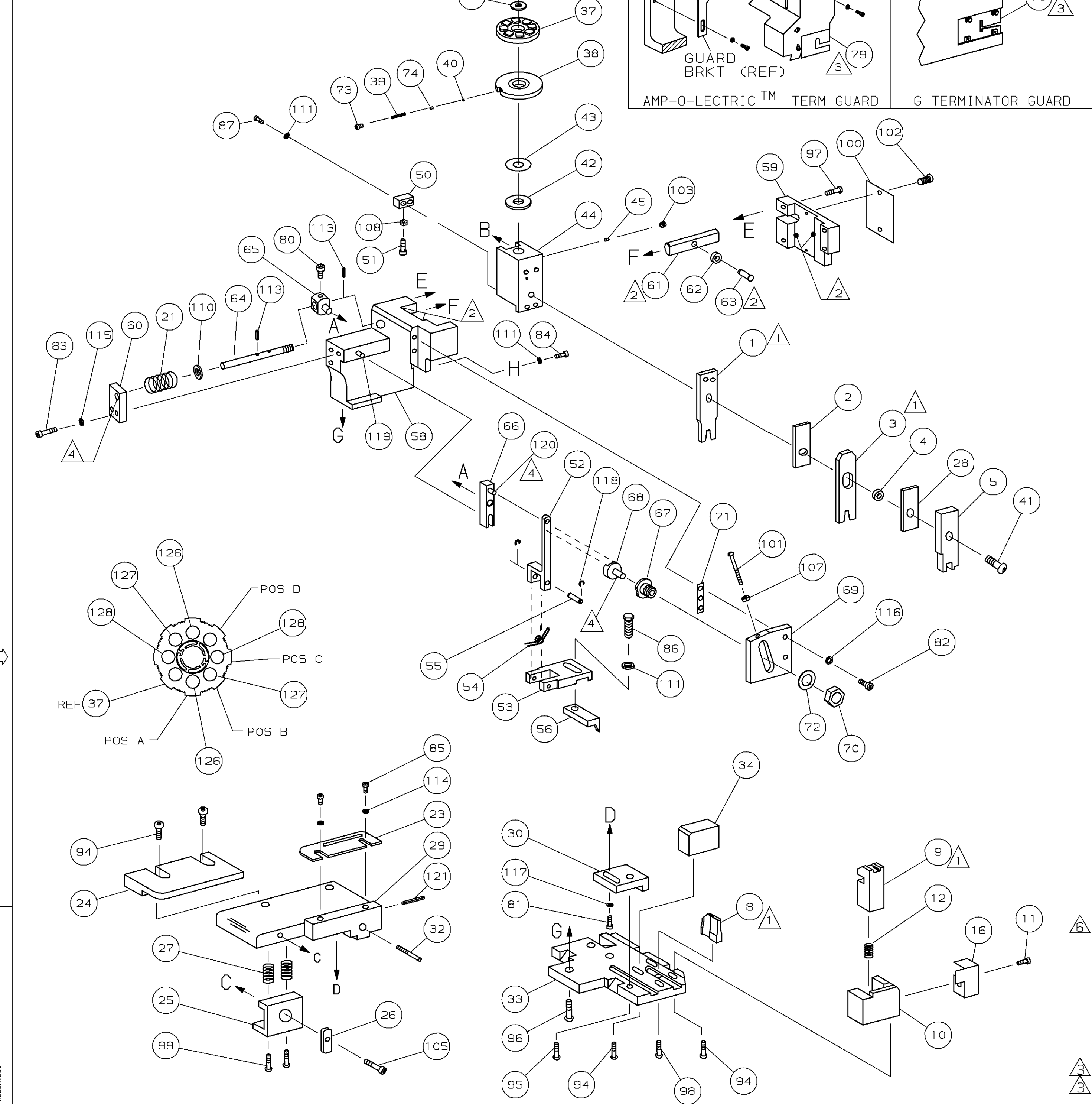


PART NUMBER	REV	FIRST USED
680753-1	A	122500-1
680753-2	A	565435-5
680753-3	A	354500-1



- 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 46.
- 6 CUT TO LENGTH AT ASSY

TERMINAL NAME: 4.8MM TAB W/DOUBLE LOCKING LANCE			
962905	CRIMP DATA	(AMP TERMINAL)	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.061 ± .002 [1.56 ± 0.05mm]	1mm <sup>2</sup>	
B	.058 ± .002 [1.47 ± 0.05mm]	.75mm <sup>2</sup>	
C	.054 ± .002 [1.38 ± 0.05mm]	.50mm <sup>2</sup>	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.080 [2.03mm]	F	0.5-1mm <sup>2</sup>
INSUL	.250 [6.35mm]	0	ø6mm

QTY REQD PER ASSY	TERM APPL	SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT	ITEM NO
.188-.219	NONE		.846	408-8040	458637-1	L2178	129
2	2	2	-	C	2-354779-0	PIN, WIRE DISC (.3090)C	128
2	2	2	-	C	1-345779-2	PIN, WIRE DISC (.3050)B	127
2	2	2	-	C	354779-6	PIN, WIRE DISC (.3020)A	126
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	1	-	-	4088040	SF APPL INST 408-8040	123
1	1	1	-	A	4-21028-0	PIN,SLT SPR(ø.093x.75)ST GDE PL	121
REF	REF	REF	-	A	1-21030-1	PIN,DOWL(ø.187x.50)LEVER	120
REF	REF	REF	-	A	1-21030-6	PIN,DOWL(ø.187x1.25)HOUSING	119
REF	REF	REF	-	A	21045-3	RING,RET "C"(ø.187)FD FING PIN	118
1	1	1	-	A	21024-5	WASHER, LOCK (#10)ADJ BLOCK	117
REF	REF	REF	-	A	21024-5	WASHER,LOCK(#10)ADJ PLATE	116
REF	REF	REF	-	A	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115
2	2	2	-	A	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
REF	REF	REF	-	A	5-21028-1	PIN,SLT SPR(ø.125x.50)ADJ ROD	113
4	4	4	-	A	21024-4	WASHER, LOCK(#8) STRIPPER	111
REF	REF	REF	-	A	21899-4	WASHER, FLAT(ø5/16) SCREW ADJ	110
1	1	1	-	A	21018-5	NUT, HEX (NO. 6) HOLDDOWN	109
REF	REF	REF	-	A	21068-5	NUT, HEX (6-32) FEED ADJ	107
1	1	1	-	A	22353-8	SCR,SHLD(ø.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
REF	REF	REF	-	A	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
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
REF	REF	REF	-	A	2-21002-9	SCR,BHC(10-32x.75)CAP	97
REF	REF	REF	-	A	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
REF	REF	REF	-	A	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
6	6	6	-	A	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
1	1	1	-	A	1-21002-7	SCR,BHC(6-32x.38)CAM	91
1	1	1	-	A	7-21000-9	SCR,SHC(4-40x.19)STRIPPER	89
2	2	2	-	A	2-21000-7	SCR,SHC(8-32x.48)DEP-HOLD	87
1	1	1	-	A	2-22603-0	SCR,HEX HD(8-32x.31)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
REF	REF	REF	-	A	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
REF	REF	REF	-	A	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	82
1	1	1	-	A	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
REF	REF	REF	-	A	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	80
-	REF	-	-	B	455749-1	GUARD, WINDOW	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
REF	REF	REF	-	A	458109-1	WASHER, SPECIAL	72
REF	REF	REF	-	A	690517-1	SPACER	71

QTY REQD PER ASSY	TERM APPL	SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT	ITEM NO
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
1	1	1	-	A	318563-1	GUARD, CHIP, FRONT	16
1	1	1	-	A	5-22280-0	SPRING, SHEAR	12
1	1	1	-	B	690461-2	STOP, SHEAR	11
1	1	1	-	C	1-690459-0	HOLDER, SHEAR (FRONT)	10
1	1	1	-	C	454276-5	SHEAR, FLOAT (FRONT)	9
1	1	1	-	C	2-662186-4	ANVIL	8
1	1	1	-	C	1-455889-8	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	3-238011-0	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	1-904741-0	CRIMPER, INSULATION	3
1	1	1	-	C	455888-5	SPACER, CRIMPER	2
1	1	1	-	C	1-456405-6	CRIMPER, WIRE	1

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AMP Incorporated Harrisburg, PA 17105-3608

DR L. COLLINS 18NOV98 APP T. ELBIN 18NOV98

CHK C. ERISMAN 18NOV98 REL -

NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL

SCALE 1:1 DWG NO 680753 SHEET 1 OF 1 REV A

REVISION RECORD

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