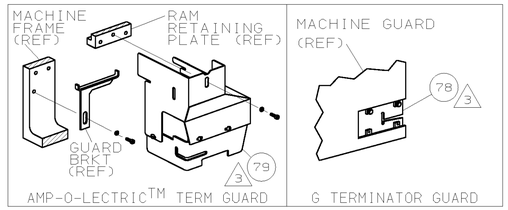
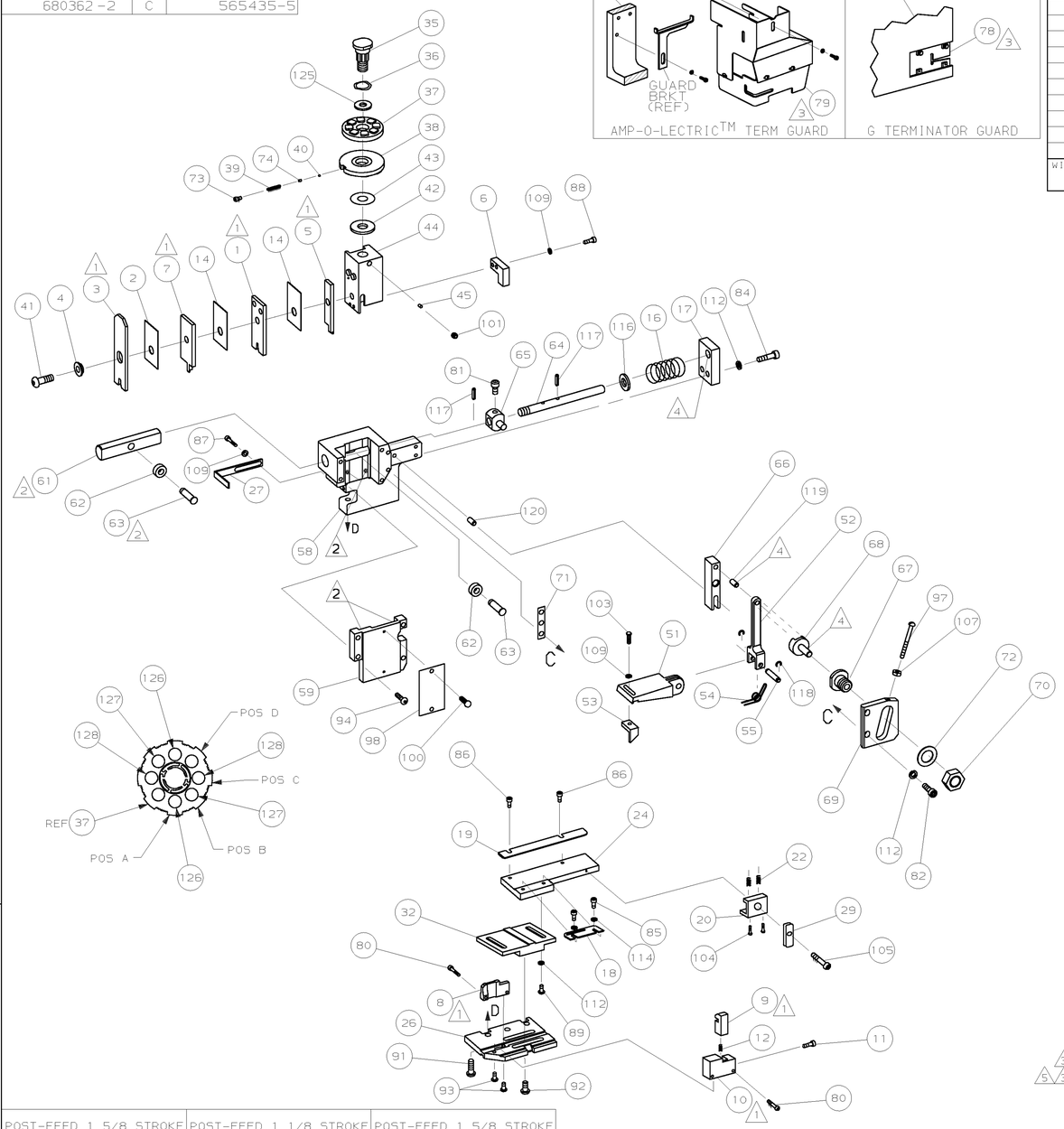
DRAWING MADE IN THIRD ANGLE PROJECTION

680362 ⇔ 680362

/home/amp16926/DMTECmod

PART NUMBER	REV	FIRST USED
680362 -1	C	122500-1
680362 -2	C	565435-5





TERMINAL NAME: .250(6,3) SERIES FLAG POSITIVE LOCK RECEPTACLE

965972
926790

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.076 ±.002 [1.93 ±0.05mm]	2.5mm²
B	.074 ±.002 [1.88 ±0.05mm]	2.0mm²
C	.065 ±.002 [1.65 ±0.05mm]	1.5mm²
D	.059 ±.002 [1.51 ±0.05mm]	1mm²

CRIMP	SIZE	TYPE	RANGE
WIRE	.110 [2.79mm]	F	1mm²-2.5mm²
INSUL	.160 [4.06mm]	F	3mm-4.3mm

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
–	NONE	.787	408-8039	–	L1820

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

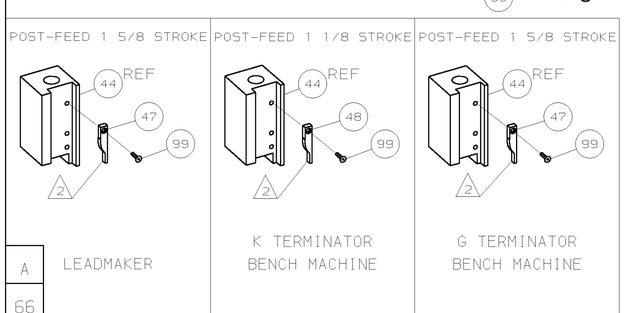
-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	2	–	C	9-354778-7	PIN, WIRE DISC (.2980)D	129
2	2	–	C	8-354778-3	PIN, WIRE DISC (.2910)C	128
2	2	–	C	6-354778-5	PIN, WIRE DISC (.2820)B	127
2	2	–	C	6-354778-1	PIN, WIRE DISC (.2800)A	126
1	1	–	A	986950-1	WASHER, FLAT PRECISION	125
1	1	–	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	–	–	4088039	EF APPL INST 408-8039	123
						122
						121
1	1	–	A	1-21030-7	PIN,DOWEL(ø.187×1.50)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
2	2	–	A	21024-2	WASHER,LOCK(NO.4)FT ST GDE	114
						113
6	6	–	A	21024-5	WASHER,LOCK(NO.10)FD ROD GDE	112
						111
						110
3	3	–	A	21024-4	WASHER,LOCK(NO.8)SHEAR BL	109
						108
1	1	–	A	21018-5	NUT,HEX(6-32)FD ADJ PL	107
						106
1	1	–	A	22353-8	SCR,SHLD(ø.187x.25)DRAG LEVER	105
2	2	–	A	3-21002-0	SCR,BHC(10-32x.88)DRAG	104
1	1	–	A	2-22603-0	SCR, HEX HD(8-32x.31)FD FINGER	103
						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
						95
4	4	–	A	2-21002-9	SCR,BHC(10-32x.75)HSG CAP	94
2	2	–	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
2	2	–	A	3-21000-4	SCR,SHC(10-32x.38)STRIP GUIDE	89
2	2	–	A	2-21000-6	SCR, SHC (8-32 x .50)	88
2	2	–	A	2-21000-5	SCR,SHC(8-32x.38)SLUG BLADE	87
2	2	–	A	2-21002-2	SCR,BHC(8-32x.50)R ST GUIDE	86
2	2	–	A	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	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	2-21000-2	SCR,SHC(6-32x.75)SHEAR PL	80
REF	–	–	A	455745-1	GUARD, WINDOW	79
–	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

-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	–	C	662633-1	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	224716-2	FINGER, FEED	53
1	1	–	B	240634-1	LEVER, TERMINAL	52
1	1	–	A	690541-1	HOLDER, FEED FINGER	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	662618-1	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(5/16-24×1.00)	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
1	1	–	B	662655-1	BLOCK, BASE	32
						31
						30
1	1	–	B	240793-1	LEVER, DRAG RELEASE	29
						28
1	1	–	A	662658-1	STRIPPER	27
1	1	–	C	662617-1	PLATE, BASE	26
						25
1	1	–	B	662656-1	PLATE, STRIP GUIDE	24
						23
2	2	–	A	1-22284-0	SPRING, DRAG	22
						21
1	1	–	A	240792-1	DRAG, STOCK	20
1	1	–	B	662657-1	GUIDE, STRIP (REAR)	19
1	1	–	C	690438-1	GUIDE, STRIP (FRONT)	18
1	1	–	A	454178-1	GUIDE, FEED ROD	17
1	1	–	A	4-22284-9	SPRING, FEED RETURN	16
						15
2	2	–	B	455888-4	SPACER, CRIMPER	14
						13
1	1	–	A	6-22279-2	SPRING, COMPRESSION	12
1	1	–	B	690461-1	STOP, SHEAR	11
1	1	–	C	662628-1	PLATE, SHEAR	10
1	1	–	C	662631-1	SHEAR.FLOATING	9
1	1	–	D	662626-1	ANVIL	8
1	1	–	B	662630-1	BLADE, SLUG	7
1	1	–	B	662632-1	DEPRESSOR, SHEAR	6
1	1	–	B	662629-1	BLADE, SLUG	5
1	1	–	B	238009-1	SPACER, BLOCK CRIMPER	4
1	1	–	C	8-683453-1	CRIMPER, INSULATION	3
1	1	–	B	455888-7	SPACER, CRIMPER	2
1	1	–	C	4-456408-2	CRIMPER, WIRE	1

QTY REQD PER ASSY — REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION) — PARTS LIST

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. ITEM 78 USED WITH G TERMINATOR ONLY.



P	F	LTR	REVISION RECORD	APP	DATE
		C1	ECN 0150-0880-02	TE	6-02
		C	0150-8177-97	TB	12-97
		B	0150-7595-97	TB	3/97
		A	RELEASED	CE	1-97

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 10-29-96 R.O.WILSON | APP 11-4-96 T.ELBIN
CHK 11-1-96 C.ERISMAN | REL – –

AMP Incorporated Harrisburg, PA 17105-3608

NAME END FEED HDM APPLICATOR | MACHINE REF MINI APPL
SCALE – | D | DWG NO 680362 | SHEET 1 OF 1 | REV C1

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO

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