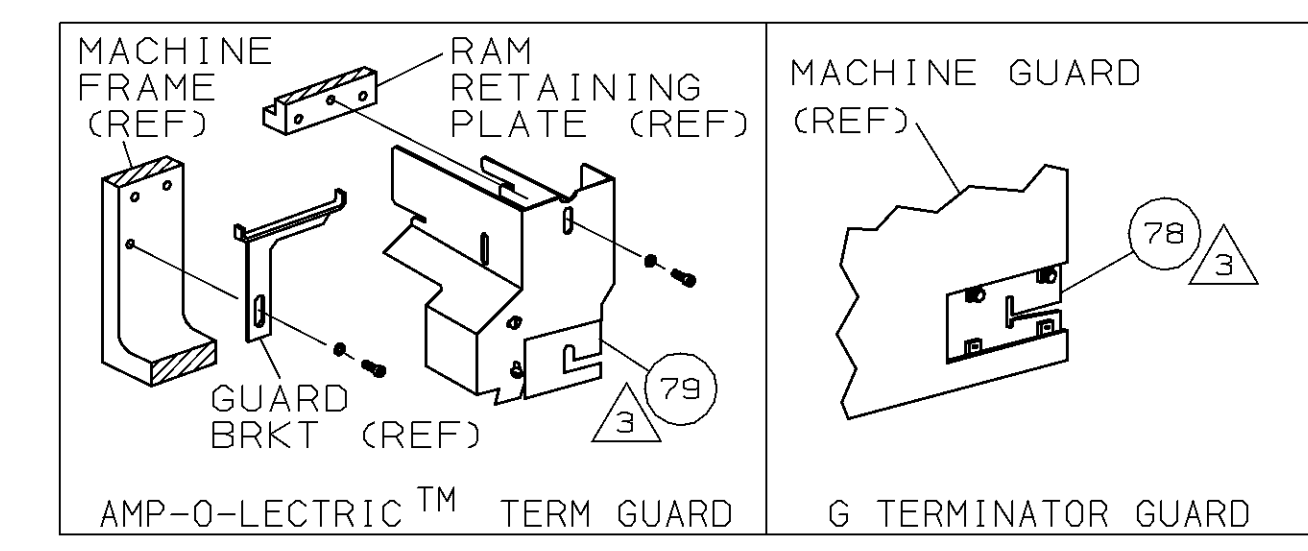
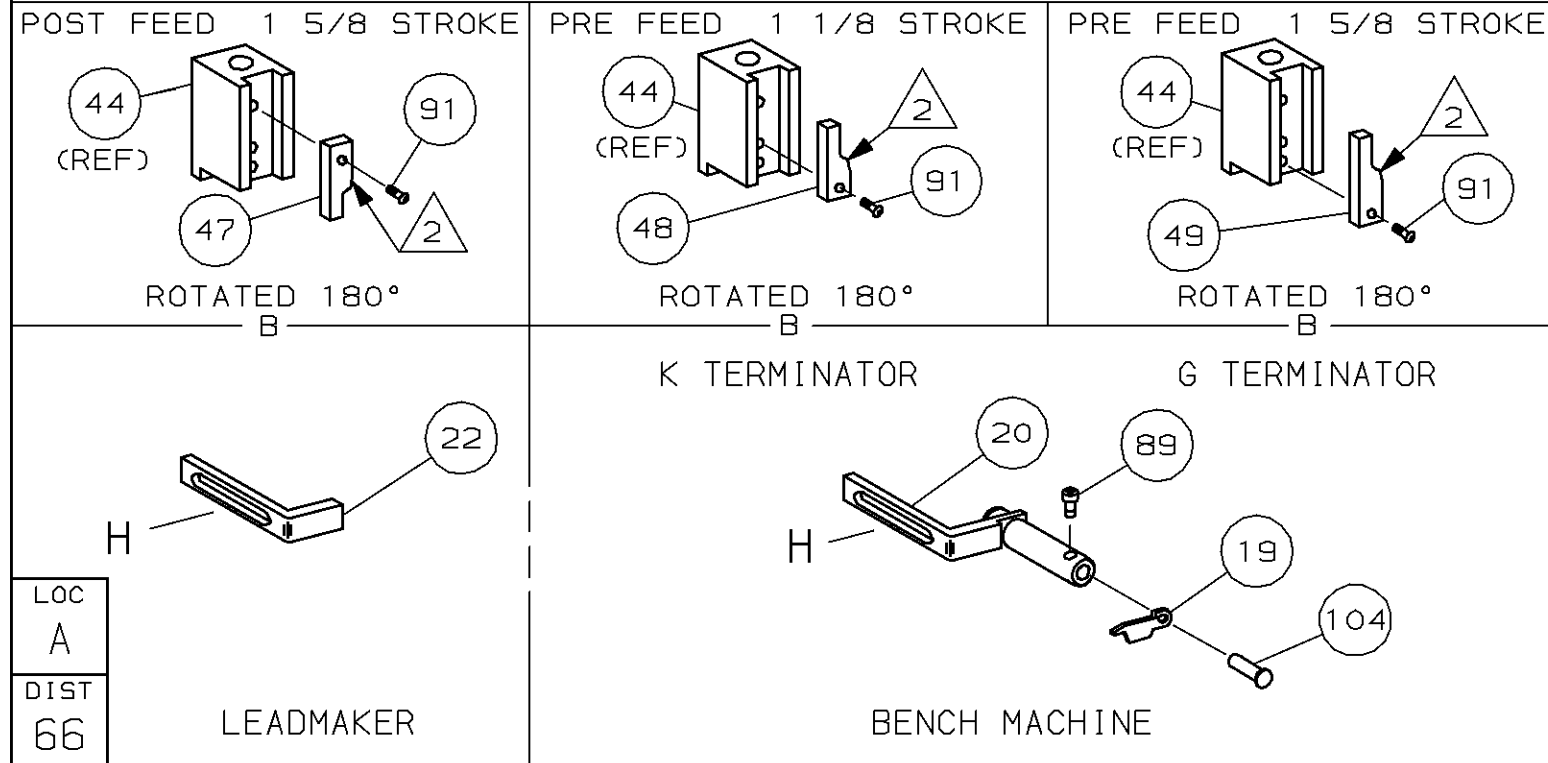
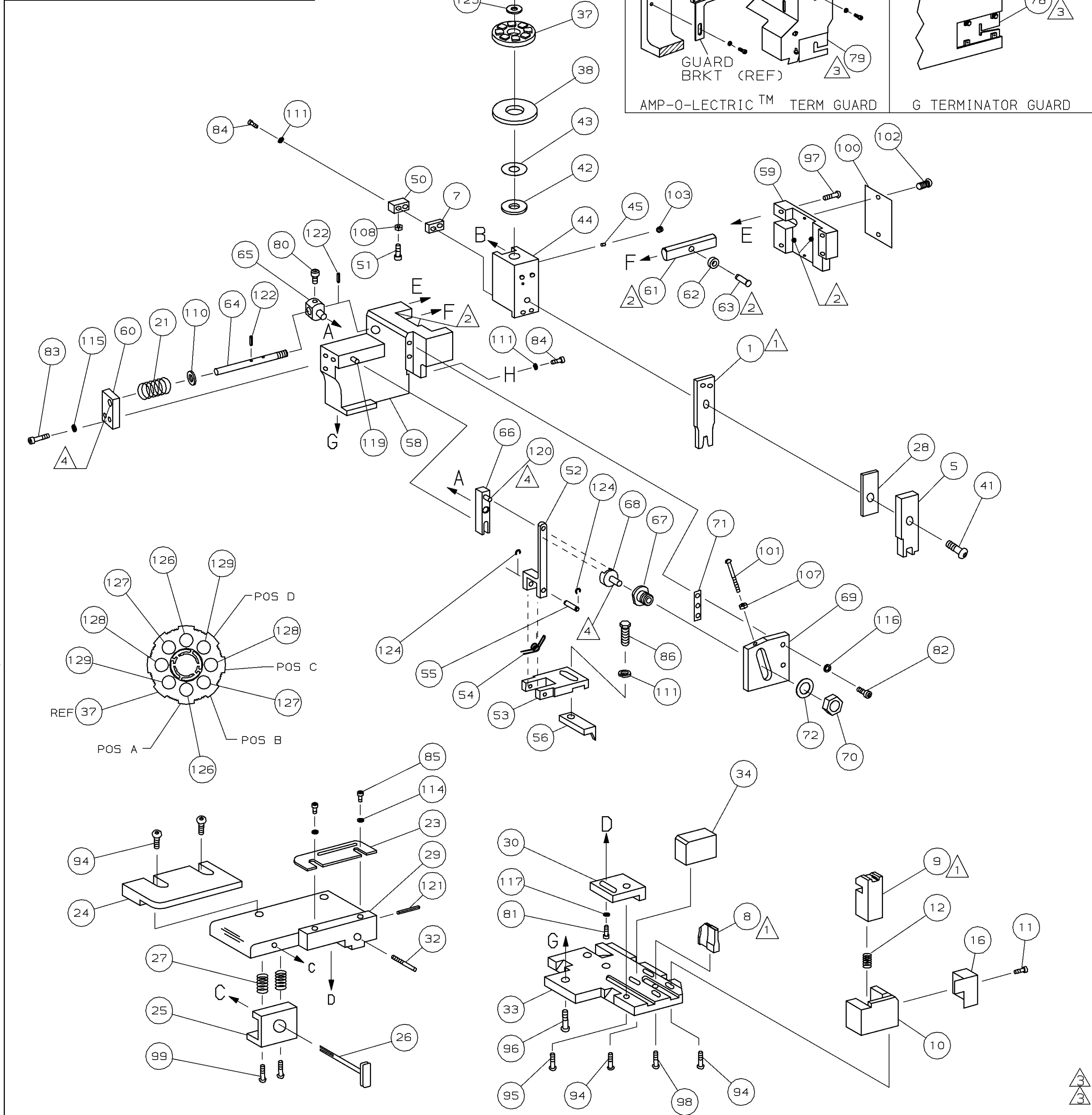


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DRAWING MADE IN THIRD ANGLE PROJECTION

PART NUMBER	REV	FIRST USED
680172-1	B	122500-1
680172-2	B	565435-5
680172-3	B	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.

680172 680172

TERMINAL NAME: .250 SERIES FASTON™ TAB, AMPLIVAR™					
63859		CRIMPING DATA			
PAD LTR	CRIMP HEIGHT		WIRE SIZE		
	A	.108 ±.002 [2.74 ±0.05mm]	9240 CMA		
	B	.103 ±.002 [2.62 ±0.05mm]	7700 CMA		
	C	.098 ±.002 [2.49 ±0.05mm]	6160 CMA		
CRIMP	SIZE		TYPE		RANGE
	WIRE		.180 [4.57mm]		F
	INSUL		-		-
	-		-		-
WIRE STRIP LENGTH		TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE
-		114-2070	.540	408-8040	458637-1
LAYOUT		L1653			

2	2	2	-	C	4-354778-2	PIN, WIRE DISC (.2705)D	129
2	2	2	-	C	3-354778-1	PIN, WIRE DISC (.2650)C	128
2	2	2	-	C	2-345778-3	PIN, WIRE DISC (.2610)B	127
2	2	2	-	C	1-354778-0	PIN, WIRE DISC (.2545)A	126
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
REF	REF	REF	-	A	21045-3	RING, RET "C" (Ø.187) FD FING PIN	124
REF	REF	REF	-	A			123
REF	REF	REF	-	A	5-21028-1	PIN, SLT SPR (Ø.125x.50) ADJ ROD	122
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, DOWEL (Ø.187x.50) LEVER	120
REF	REF	REF	-	A	1-21030-6	PIN, DOWEL (Ø.187x1.25) HOUSING	119
1	1	1	-	A	21024-5	WASHER, LOCK (#10) ADJ BLOCK	118
REF	REF	REF	-	A	21024-5	WASHER, LOCK (#10) ADJ PLATE	117
REF	REF	REF	-	A	21024-5	WASHER, LOCK (#10) FEED GDE ROD	116
2	2	2	-	A	21024-2	WASHER, LOCK (#4) FRONT STP GUIDE	115
4	4	4	-	A	21024-4	WASHER, LOCK (#8) STRIPPER	114
REF	REF	REF	-	A	21899-4	WASHER, FLAT (Ø5/16) SCREW ADJ	113
1	1	1	-	A	21018-5	NUT, HEX (NO. 6) HOLDDOWN	112
REF	REF	REF	-	A	21018-5	NUT, HEX (6-32) FEED ADJ	111
1	1	1	-	A	992031-1	PIN, CLEVIS	110
1	1	1	-	A	21009-2	SCR, SKT SET (1/4-20x.25 LW) RAM	109
2	2	2	-	A	21017-2	SCR, DRIVE (#2x.19) ID PLATE	108
REF	REF	REF	-	A	6-23715-5	SCR, PAN HD (6-32x1.50) FEED ADJ	107
1	1	1	-	B	461264-1	PLATE, IDENTIFICATION	106
2	2	2	-	A	3-21002-0	SCR, BHC (10-32x.88) DRAG	105
1	1	1	-	A	22733-8	SCR, BHC (8-32x.38 LW) ANVIL	104
REF	REF	REF	-	A	2-21002-9	SCR, BHC (10-32x.75) CAP	103
REF	REF	REF	-	A	2-22733-8	SCR, BHC (1/4-20x.62) HOUSING	102
REF	REF	REF	-	A	2-21002-7	SCR, BHC (10-32x.50) SG ADJ BLOCK	101
6	6	6	-	A	2-21002-2	SCR, BHC (8-32x.50) TERM H DWN	100
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38) CAM	99
1	1	1	-	A	7-21000-9	SCR, SHC (4-40x.19) STRIPPER	98
1	1	1	-	A	2-22603-0	SCR, HEX HD (8-32x.31) FEED FINGER	97
2	2	2	-	A	1-21000-3	SCR, SHC (4-40x.25) F ST GUIDE	96
3	3	3	-	A	2-21000-7	SCR, SHC (8-32x.50) STRIPPER	95
REF	REF	REF	-	A	3-21000-7	SCR, SHC (10-32x.75) FEED ROD GD	94
REF	REF	REF	-	A	3-21000-6	SCR, SHC (10-32x.62) FD ADJ BLK	93
1	1	1	-	A	3-21000-4	SCR, SHC (10-32x.38) SG ADJ BL	92
REF	REF	REF	-	A	3-21000-4	SCR, SHC (10-32x.38) PIVOT BLK	91
-	REF	-	-	B	455749-1	GUARD, WINDOW	90
REF	-	-	-	B	679532-1	INSERT, GUARD	89
REF	REF	REF	-	A	458109-1	WASHER, SPECIAL	88
REF	REF	REF	-	A	690517-1	SPACER	87
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY				PARTS LIST			

LEADMAKER					MECH POST FEED				
-2	BENCH MODEL K				MECH PRE FEED				
-3	BENCH MODEL G				MECH PRE FEED				
REF	REF	REF	-	B	22594-8	NUT, HEX (1/2-20)	70		
REF	REF	REF	-	B	240628-1	PLATE, ADJUSTMENT	69		
REF	REF	REF	-	B	240626-1	SHAFT, PIVOT	68		
REF	REF	REF	-	B	240633-1	BUSHING	67		
REF	REF	REF	-	A	455680-1	LEVER, INTERMEDIATE	66		
REF	REF	REF	-	B	240629-1	BLOCK, PIVOT	65		
REF	REF	REF	-	A	240632-2	SCREW, ADJ FEED ROD	64		
REF	REF	REF	-	B	240659-3	PIN, CAM ROLLER	63		
REF	REF	REF	-	B	240658-1	ROLLER, CAM	62		
REF	REF	REF	-	B	454398-2	ROD, FEED	61		
REF	REF	REF	-	A	454178-1	GUIDE, FEED ROD	60		
REF	REF	REF	-	C	454220-1	CAP, RAM	59		
REF	REF	REF	-	D	454485-1	HOUSING	58		
							57		
1	1	1	-	B	690542-2	PAWL, FEED	56		
REF	REF	REF	-	B	240624-1	PIN, FEED FINGER	55		
REF	REF	REF	-	B	691499-1	SPRING, FEED FINGER	54		
REF	REF	REF	-	B	690541-1	HOLDER, FEED FINGER	53		
REF	REF	REF	-	A	455679-2	LEVER, TERMINAL FEED ARM	52		
1	1	1	-	A	811242-2	BUMPER, HOLDDOWN	51		
1	1	1	-	A	690753-1	SPACER, TONKER	50		
1	-	-	-	B	690602-6	CAM, PRE-FEED 1 5/8 ST	49		
-	1	-	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST	48		
-	-	1	-	B	690501-4	CAM, POST-FEED 1 5/8 ST	47		
1	1	1	-	B	459456-2	APPLICATOR, BASIC (SUBASSY)	46		
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		
							40		
							39		
1	1	1	-	A	690223-2	SPACER, INSULATION DISC	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	690786-5	SUPPORT, TERMINAL	34		
REF	REF	REF	-	D	455675-1	PLATE, BASE	33		
1	1	1	-	A	690432-3	SCREW, ADJUSTMENT	32		
							31		
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30		
1	1	1	-	C	455671-1	PLATE, STRIP GUIDE	29		
1	1	1	-	C	2-455888-2	SPACER, FRONT SHEAR DEP	28		
2	2	2	-	A	1-22284-0	SPRING, DRAG	27		
1	1	1	-	B	690546-1	LEVER, DRAG RELEASE	26		
1	1	1	-	B	240792-1	DRAG, TERMINAL	25		
1	1	1	-	D	90765-1	GUIDE, STRIP (REAR)	24		
1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23		
-	-	1	-	B	690472-2	STRIPPER	22		
REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	21		
1	1	-	-	A	679218-1	STRIPPER WIRE STOP ASSY	20		
1	1	-	-	B	458949-1	STRIPPER	19		
							18		
							17		
1	1	1	-	B	691667-1	GUARD, CHIP (FRONT)	16		
							15		
							14		
							13		
1	1	1	-	A	5-22280-0	SPRING, SHEAR	12		
1	1	1	-	B	690461-1	STOP, SHEAR	11		
1	1	1	-	C	690459-1	HOLDER, SHEAR (FRONT)	10		
1	1	1	-	C	454276-1	SHEAR, FLOAT (FRONT)	9		
1	1	1	-	C	805840-7	ANVIL	8		
1	1	1	-	C	4-240641-8	SPACER, DEPRESSOR (REAR)	7		
							6		
1	1	1	-	C	2-455889-7	DEPRESSOR, SHEAR (FRONT)	5		
							4		
							3		
							2		
1	1	1	-	C	462808-9	CRIMPER, WIRE	1		
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO		
				← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)					
QTY REQD PER ASSY				PARTS LIST					
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 R.O.WILSON 6/5/95		APP T BEDDICK 6/7/95	AMP AMP Incorporated Harrisburg, PA 17105-3608		
				CHK 6/6/95 C ERISMAN		REL 11/10/95 B. MORGAN			
NAME				SIDE FEED HDM APPLICATOR		MACHINE REF	MINI APPL		
SCALE				- 1		DWG NO	680172	SHEET 1 OF 1	REV B

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