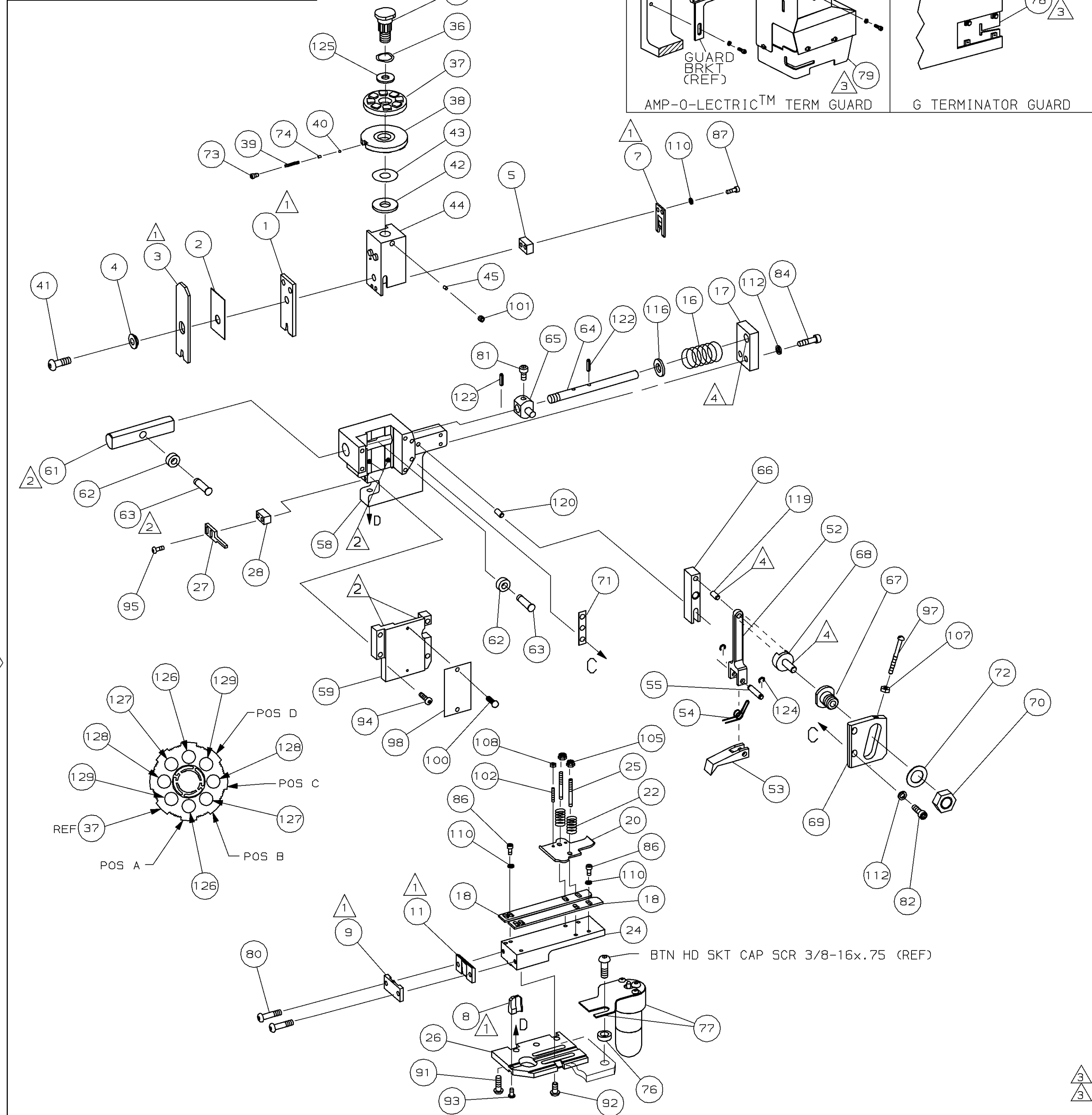


THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INCORPORATED.
IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING
ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

THIS INFORMATION IS CONFIDENTIAL AND IS DISCLOSED TO YOU ON CONDITION THAT
NO FURTHER DISCLOSURE IS MADE BY YOU TO OTHER THAN AMP PERSONNEL WITHOUT
WRITTEN AUTHORIZATION FROM AMP INCORPORATED, HARRISBURG, PA.

DRAWING MADE IN THIRD ANGLE PROJECTION

PART NUMBER	REV	FIRST USED
680202-1	B	122500-1
680202-2	B	565435-5
680202-3	B	354500-1



POST-FEED 1 5/8 STROKE	PRE-FEED 1 1/8 STROKE	PRE-FEED 1 5/8 STROKE
LOC A DIST 66 LEADMAKER	K TERMINATOR BENCH MACHINE	G TERMINATOR BENCH MACHINE

- 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.

680202 680202

TERMINAL NAME: RING TONGUE										
			626030		CRIMPING DATA					
			626416		PAD LTR	CRIMP HEIGHT		WIRE SIZE		
					A	.080 ±.002 [2.03 ±0.05mm]		1.5mm ²		
					B	.074 ±.002 [1.88 ±0.05mm]		1mm ²		
					C	.070 ±.002 [1.78 ±0.05mm]		0.75mm ²		
					D	.068 ±.002 [1.73 ±0.05mm]		0.5mm ²		
					CRIMP	SIZE	TYPE	RANGE		
					WIRE	.110 [2.79mm]	F	0.5mm ² - 1.5mm ²		
					INSUL	.160 [4.06mm]	F	1.78mm - 3.05mm		
WIRE STRIP LENGTH			TERM APPL SPEC		FEED	APPL INSTRUCTION		SET UP GAGE	LAYOUT	
-			114-2084		1.090	408-8039		458638-1	L1678	
2	2	2	-	C	9-354778-1	PIN, WIRE DISC (.2950)D			129	
2	2	2	-	C	8-354778-9	PIN, WIRE DISC (.2940)C			128	
2	2	2	-	C	7-354778-9	PIN, WIRE DISC (.2890)B			127	
2	2	2	-	C	6-354778-8	PIN, WIRE DISC (.2835)A			126	
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION			125	
REF	REF	REF	-	A	21045-3	RING, RET "C" (Ø.187)FD PIN			124	
									123	
REF	REF	REF	-	A	5-21028-1	PIN, STD SPRING (Ø.12)FD ADJ ROD			122	
									121	
REF	REF	REF	-	A	1-21030-7	PIN, DOWEL (Ø.187x1.50)HSG			120	
REF	REF	REF	-	A	1-21030-1	PIN, DOWEL (Ø.187x.50)LEVER			119	
									118	
									117	
REF	REF	REF	-	A	21899-4	WASHER, FLAT (Ø5/16)SCR ADJ			116	
									115	
									114	
									113	
REF	REF	REF	-	A	21024-5	WASHER, LOCK (NO.10)FD ROD GDE			112	
									111	
6	6	6	-	A	21024-4	WASHER, LOCK (NO.8)SHEAR BL			110	
									109	
2	2	2	-	A	21018-4	NUT, HEX (4-40)DRAG			108	
REF	REF	REF	-	A	21018-5	NUT, HEX (6-32)FD ADJ PL			107	
									106	
2	2	2	-	A	21022-2	NUT, HEX SL (8-32)DRAG STUD			105	
									104	
									103	
2	2	2	-	A	2-21006-6	SCR, SKT SET (4-40x.62)DRAG			102	
1	1	1	-	A	21009-2	SCR, SKT SET (1/4-20x.25)RAM			101	
2	2	2	-	A	21017-2	SCR, DRIVE (#2x.19)ID PLATE			100	
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38)CAM			99	
1	1	1	-	B	461264-1	PLATE, IDENTIFICATION			98	
REF	REF	REF	-	A	6-23715-5	SCR, PAN HD (6-32x1.50)FEED ADJ			97	
									96	
2	2	2	-	A	2-21002-2	SCR, BHC (8-32x.50)STRIPPER			95	
REF	REF	REF	-	A	2-21002-9	SCR, BHC (10-32x.75)HSG CAP			94	
1	1	1	-	A	22733-8	SCR, BHC (8-32x.38) LW ANVIL			93	
4	4	4	-	A	3-21002-3	SCR, BHC (1/4-20x.50)ST 6D PL			92	
REF	REF	REF	-	A	2-22733-8	SCR, BHC (1/4-20x.62)BASE PL			91	
									90	
									89	
									88	
2	2	2	-	A	2-21000-9	SCR, SHC (8-32x.75)SLUG BLADE			87	
4	4	4	-	A	2-21000-6	SCR, SHC (8-32x.38)STRIP GUIDE			86	
									85	
REF	REF	REF	-	A	3-21000-7	SCR, SHC (10-32x.75)FEED ROD GDE			84	
									83	
REF	REF	REF	-	A	3-21000-6	SCR, SHC (10-32x.62)FEED ADJ PL			82	
REF	REF	REF	-	A	3-21000-4	SCR, SHC (10-32x.38)PIVOT BLOCK			81	
2	2	2	-	A	3-21002-0	SCR, BHC (10-32x.88)SHEAR PL			80	
-	REF	-	-	A	455745-1	GUARD, WINDOW			79	
REF	-	-	-	A	679532-1	INSERT, GUARD			78	
-	1	-	-	C	465184-9	LUBRICATOR ASSY			77	
-	1	-	-	A	454406-1	SPACER, LUB BRACKET			76	
									75	
1	1	1	-	A	690603-1	SPRING, ASSIST			74	
1	1	1	-	A	23030-1	SCR, SKT CAP (6-32x.25)CP DSC			73	
REF	REF	REF	-	A	458109-1	WASHER, FLAT (SPECIAL)			72	
REF	REF	REF	-	A	690517-1	SPACER			71	
-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	-	A	22594-8	NUT, HEX	70
REF	REF	REF	-	B	240628-1	PLATE, ADJ	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	SCR, ADJ	64
REF	REF	REF	-	B	240659-3	PIN, CAM ROLLER	63
REF	REF	REF	-	B	240658-1	CAM, ROLLER	62
REF	REF	REF	-	B	454398-1	ROD, FEED	61
							60
REF	REF	REF	-	C	454220-1	CAP, RAM	59
REF	REF	REF	-	D	453736-1	HOUSING	58
							57
							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	240635-1	FINGER, FEED	53
REF	REF	REF	-	B	240634-1	LEVER, TERMINAL	52
							51
							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
							46
1	1	1	-	A	690191-1	PLUG, NYLON	45
1	1	1	-	C	455674-1	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 (5/16-24x1.00)	41
1	1	1	-	A	23241-6	BALL, STEEL	40
1	1	1	-	A	690170-1	SPRING, COMPRESSION	39
1	1	1	-	C	690142-1	DISC, INSULATION	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
							34
							33
1	1	1	-	D	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
							31
							30
							29
1	1	1	-	B	3-690451-2	SPACER, STRIPPER	28
1	1	1	-	A	240639-1	STRIPPER	27
REF	REF	REF	-	C	455676-1	PLATE, BASE	26
2	2	2	-	A	22354-8	DRAG, STUD	25
1	1	1	-	B	455678-1	PLATE, STRIP GUIDE	24
							23
2	2	2	-	A	4-22281-1	SPRING, DRAG	22
							21
1	1	1	-	A	454177-1	DRAG, STOCK	20
1	1	1	-	C	4-458030-2	GUIDE, STRIP (REAR)	19
1	1	1	-	C	4-458031-2	GUIDE, STRIP (FRONT)	18
REF	REF	REF	-	A	454178-1	GUIDE, FEED ROD	17
REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	16
							15
							14
							13
							12
1	1	1	-	B	240644-1	PLATE, REAR SHEAR	11
							10
1	1	1	-	B	690482-4	PLATE, FRONT SHEAR	9
1	1	1	-	D	9-683452-6	ANVIL	8
1	1	1	-	B	690474-4	BLADE, SLUG	7
							6
1	1	1	-	C	6-240641-1	SPACER, SLUG BLADE	5
1	1	1	-	B	238009-1	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	456134-9	CRIMPER, INSULATION	3
1	1	1	-	B	455888-8	SPACER, CRIMPER	2
1	1	1	-	C	456408-6	CRIMPER, WIRE	1
-3	-2	-	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			

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[680202-3](#)