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| PART NUMBER | REV | FIRST USED | CARRIER TYPE |
|-------------|-----|------------|--------------|
| 680832-1    | C   | 122500-1   | CUT          |
| 680832-2    | C   | 565435-5   | CUT          |
| 680832-3    | C   | 354500-1   | CUT          |
| 680832-4    | C   | 354500-1   | NON-CUT      |

MACHINE FRAME (REF)

RAM RETAINING PLATE (REF)

GUARD BRKT (REF)

AMP-O-LECTRIC™ TERM GUARD

MACHINE GUARD (REF)

G TERMINATOR GUARD

| LOC | DIST | REVISIONS   |               |        |      |    |
|-----|------|-------------|---------------|--------|------|----|
| F   | LTR  | DESCRIPTION | DATE          | DWN    | APVD |    |
| A   | 66   | C           | ECR-07-008457 | 4-2007 | MY   | GB |

TERMINAL NAME: 1.5 SYSTEM SEALED CONNECTOR

SEAL

286814

TERMINAL

286813

CRIMP DATA (NON-AMP TERMINAL-MFR SPEC)

| PAD LTR | CRIMP HEIGHT              | WIRE SIZE |
|---------|---------------------------|-----------|
| A       | .051 ±.002 [1.30 ±0.05mm] | 1.25 mm   |
| B       | .049 ±.002 [1.24 ±0.05mm] | 1 mm      |
| C       | .045 ±.002 [1.14 ±0.05mm] | 0.85 mm   |
| D       | .043 ±.002 [1.09 ±0.05mm] | 0.6 mm    |

| CRIMP | SIZE          | TYPE | RANGE      |
|-------|---------------|------|------------|
| WIRE  | .080 [2.03mm] | F    | 0.6-1.25mm |
| INSUL | .140 [3.56mm] | 0    | 1.6-2.34mm |

| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPL INSTRUCTION | SET UP GAGE | LAYOUT |
|-------------------|----------------|------|------------------|-------------|--------|
| .203-.234         | NONE           | .450 | 408-8040         | 458637-1    | L2245  |

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

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL

7

APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

8

CUT TO LENGTH AT ASSY

POST FEED 1 5/8 STROKE

PRE FEED 1 1/8 STROKE

PRE FEED 1 5/8 STROKE

44

(REF)

47

ROTATED 180°

B

44

(REF)

48

ROTATED 180°

B

44

(REF)

49

ROTATED 180°

B

K TERMINATOR

G TERMINATOR

H

22

19

LEADMAKER & BENCH MACHINE

|     |     |     |     |     |                   |                                 |         |
|-----|-----|-----|-----|-----|-------------------|---------------------------------|---------|
| 2   | 2   | 2   | 2   | -   | 4-354779-5        | PIN, WIRE DISC (.3215)D         | 129     |
| 2   | 2   | 2   | 2   | -   | 4-354779-2        | PIN, WIRE DISC (.3200)C         | 128     |
| 2   | 2   | 2   | 2   | -   | 3-354779-2        | PIN, WIRE DISC (.3150)B         | 127     |
| 2   | 2   | 2   | 2   | -   | 3-354779-0        | PIN, WIRE DISC (.3140)A         | 126     |
| 1   | 1   | 1   | 1   | -   | 986950-1          | WASHER, FLAT PRECISION          | 125     |
| 1   | 1   | 1   | 1   | -   | 217238-1          | GENERAL INSTRUCTION PACKAGE     | 124     |
| 1   | 1   | 1   | 1   | -   | 4088040           | SF APPL INST 408-8040           | 123     |
|     |     |     |     |     |                   |                                 | 122     |
|     |     |     |     |     |                   |                                 | 121     |
| REF | REF | REF | REF | -   | 1-21030-1         | PIN,DOWEL(Ø.187x.50)LEVER       | 120     |
| REF | REF | REF | REF | -   | 1-21030-6         | PIN,DOWEL(Ø.187x1.25)HOUSING    | 119     |
| REF | REF | REF | REF | -   | 21045-3           | RING,RET "C"(Ø.187)FD FING PIN  | 118     |
| 1   | 1   | 1   | 1   | -   | 21024-5           | WASHER, LOCK(#10)ADJ BLOCK      | 117     |
| REF | REF | REF | REF | -   | 21024-5           | WASHER,LOCK(#10)ADJ PLATE       | 116     |
| REF | REF | REF | REF | -   | 21024-5           | WASHER,LOCK(#10)FEED GDE ROD    | 115     |
| 2   | 2   | 2   | 2   | -   | 21024-2           | WASHER,LOCK(#4)FRONT STP GUIDE  | 114     |
| REF | REF | REF | REF | -   | 5-21028-1         | PIN,SLT SPR(Ø.125x.50)ADJ ROD   | 113     |
|     |     |     |     |     |                   |                                 | 112     |
| 4   | 4   | 4   | 4   | -   | 21024-4           | WASHER,LOCK(#8)STRIPPER         | 111     |
| REF | REF | REF | REF | -   | 21899-4           | WASHER,FLAT(Ø5/16)SCREW ADJ     | 110     |
|     |     |     |     |     |                   |                                 | 109     |
| 1   | 1   | 1   | 1   | -   | 21018-5           | NUT,HEX(NO.6)HOLDDOWN           | 108     |
| REF | REF | REF | REF | -   | 21068-5           | NUT,HEX(6-32)FEED ADJ           | 107     |
|     |     |     |     |     |                   |                                 | 106     |
|     |     |     |     |     |                   |                                 | 105     |
|     |     |     |     |     |                   |                                 | 104     |
| 1   | 1   | 1   | 1   | -   | 21009-2           | SCR,SKT SET(1/4-20x.25 LW)RAM   | 103     |
| 2   | 2   | 2   | 2   | -   | 21017-2           | SCR,DRIVE(#2x.19)ID PLATE       | 102     |
| REF | REF | REF | REF | -   | 6-23715-5         | SCR,PAN HD(6-32x1.50)FEED ADJ   | 101     |
| 1   | 1   | 1   | 1   | -   | 461264-1          | PLATE, IDENTIFICATION           | 100     |
| 2   | 2   | 2   | 2   | -   | 5-21006-6         | SCR,SET(10-32x.75)DRAG          | 99      |
| 1   | 1   | 1   | 1   | -   | 22733-8           | SCR,BHC(8-32x.38 LW)ANVIL       | 98      |
| REF | REF | REF | REF | -   | 2-21002-9         | SCR,BHC(10-32x.75)CAP           | 97      |
| REF | REF | REF | REF | -   | 2-22733-8         | SCR,BHC(1/4-20x.62)HOUSING      | 96      |
| REF | REF | REF | REF | -   | 2-21002-7         | SCR,BHC(10-32x.50)SG ADJ BLOCK  | 95      |
| 6   | 6   | 6   | 6   | -   | 2-21002-2         | SCR,BHC(8-32x.50)TERM H DWN     | 94      |
|     |     |     |     |     |                   |                                 | 93      |
| 1   | 1   | 1   | 1   | -   | 1-21003-9         | SCR,FHC(6-32x.38)DEP            | 92      |
| 1   | 1   | 1   | 1   | -   | 1-21002-7         | SCR,BHC(6-32x.38)CAM            | 91      |
|     |     |     |     |     |                   |                                 | 90      |
|     |     |     |     |     |                   |                                 | 89      |
|     |     |     |     |     |                   |                                 | 88      |
| 2   | 2   | 2   | 2   | -   | 2-21000-7         | SCR,SHC(8-32x.48)DEP-HOLD       | 87      |
| 1   | 1   | 1   | 1   | -   | 2-22603-0         | SCR,HEX HD(8-32x.31)FEED FINGER | 86      |
| 2   | 2   | 2   | 2   | -   | 1-21000-3         | SCR,SHC(4-40x.25)F ST GUIDE     | 85      |
| 1   | 1   | 1   | 1   | -   | 2-21000-7         | SCR,SHC(8-32x.50)STRIPPER       | 84      |
| REF | REF | REF | REF | -   | 3-21000-7         | SCR,SHC(10-32x.75)FEED ROD GD   | 83      |
| REF | REF | REF | REF | -   | 3-21000-6         | SCR,SHC(10-32x.62)FD ADJ BLK    | 82      |
| 1   | 1   | 1   | 1   | -   | 3-21000-4         | SCR,SHC(10-32x.38)SG ADJ BL     | 81      |
| REF | REF | REF | REF | -   | 3-21000-4         | SCR,SHC(10-32x.38)PIVOT BLK     | 80      |
| -   | -   | REF | -   | -   | 455749-1          | GUARD, WINDOW                   | 79      |
| -   | REF | -   | -   | -   | 679532-1          | INSERT, GUARD                   | 78      |
|     |     |     |     |     |                   |                                 | 77      |
|     |     |     |     |     |                   |                                 | 76      |
|     |     |     |     |     |                   |                                 | 75      |
| 1   | 1   | 1   | 1   | -   | 690603-1          | SPRING, ASSIST                  | 74      |
| 1   | 1   | 1   | 1   | -   | 23030-1           | SCR,SHC(6-32x.25 SL)INS DISC    | 73      |
| REF | REF | REF | REF | -   | 458109-1          | WASHER, SPECIAL                 | 72      |
| REF | REF | REF | REF | -   | 690517-1          | SPACER                          | 71      |
| -4  | -3  | -2  | -1  | U/M | PART NO           | DESCRIPTION                     | ITEM NO |
|     |     |     |     |     | QTY REQD PER ASSY | PARTS LIST                      |         |

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70

REF

REF

REF

REF

-

22594-8

NUT,HEX(1/2-20)

70

REF

REF

REF

REF

-

240628-1

PLATE, ADJUSTMENT

69

REF

REF

REF

REF

-

240626-1

SHAFT, PIVOT

68

REF

REF

REF

REF

-

240633-1

BUSHING

67

REF

REF

REF

REF

-

455680-1

LEVER, INTERMEDIATE

66

REF

REF

REF

REF

-

240629-1

BLOCK, PIVOT

65

REF

REF

REF

REF

-

240632-2

SCREW, ADJ FEED ROD

64

REF

REF

REF

REF

-

240659-3

PIN, CAM ROLLER

63

REF

REF

REF

REF

-

240658-1

ROLLER, CAM

62

REF

REF

REF

REF

-

454398-2

ROD, FEED

61

REF

REF

REF

REF

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454178-1

GUIDE, FEED ROD

60

REF

REF

REF

REF

-

454220-1

CAP, RAM

59

REF

REF

REF

REF

-

454485-1

HOUSING

58

1

1

1

1

-

458537-2

PAWL, FEED

57

REF

REF

REF

REF

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240624-1

PIN, FEED FINGER

56

REF

REF

REF

REF

-

691499-1

SPRING, FEED FINGER

55

REF

REF

REF

REF

-

690541-1

HOLDER, FEED FINGER

54

REF

REF

REF

REF

-

455679-1

LEVER, TERMINAL FEED ARM

53

1

1

1

1

-

811242-2

BUMPER, HOLDDOWN

52

1

1

1

1

-

690753-1

SPACER, TONKER

51

-

1

-

-

-

690602-6

CAM, PRE-FEED 1 5/8 ST

50

-

-

1

-

-

690602-5

CAM, PRE-FEED 1 1/8 ST

49

1

-

-

1

-

690501-4

CAM, POST-FEED 1 5/8 ST

48

1

1

1

 1 | - | 459456-1 | APPLICATOR, BASIC (SUBASSY) | 47 || 1 | 1 | 1 | 1 | - | 690191-1 | PLUG, NYLON | 46 |
| 1 | 1 | 1 | 1 | - | 455673-1 | RAM | 45 |
| 1 | 1 | 1 | 1 | - | 690125-1 | WASHER, LAMINATED | 44 |
| 1 | 1 | 1 | 1 | - | 690124-1 | WASHER, RAM | 43 |
| 1 | 1 | 1 | 1 | - | 7-21002-9 | BOLT, CRIMPER(5/16x1.00) | 42 |
| 1 | 1 | 1 | 1 | - | 23241-6 | BALL, STEEL | 41 |
| 1 | 1 | 1 | 1 | - | 690170-1 | SPRING, COMPRESSION | 40 |
| 1 | 1 | 1 | 1 | - | 1-690142-0 | DISC, INSULATION | 39 |
| 1 | 1 | 1 | 1 | - | 354777-1 | WIRE DISC, PLASTIC | 38 |
| 1 | 1 | 1 | 1 | - | 22480-5 | WASHER, SPRING | 37 |
| 1 | 1 | 1 | 1 | - | 690212-1 | POST, RAM | 36 |
| 1 | 1 | 1 | 1 | - | 690786-1 | SUPPORT, TERMINAL | 35 |
| REF | REF | REF | REF | - | 455675-1 | PLATE, BASE | 34 |
|  |  |  |  |  |  |  | 33 |
|  |  |  |  |  |  |  | 32 |
|  |  |  |  |  |  |  | 31 |
| REF | REF | REF | REF | - | 455689-1 | BLOCK, STRIP GUIDE ADJ | 30 |
| 1 | 1 | 1 | 1 | - | 318756-5 | STRIP GUIDE PLATE ASSY | 29 |
| 1 | 1 | 1 | 1 | - | 1-455888-9 | SPACER, FRONT SHEAR DEP | 28 |
| 2 | 2 | 2 | 2 | - | 1-22284-0 | SPRING, DRAG | 27 |
| 1 | 1 | 1 | 1 | - | 690546-1 | LEVER, DRAG RELEASE | 26 |
| 1 | 1 | 1 | 1 | - | 217233-1 | DRAG, TERMINAL | 25 |
| 1 | 1 | 1 | 1 | - | 7-690504-6 | GUIDE, STRIP (REAR) | 24 |
| 1 | 1 | 1 | 1 | - | 1-690438-1 | GUIDE, STRIP (FRONT) | 23 |
| 1 | - | - | 1 | - | 690472-2 | STRIPPER | 22 |
| REF | REF | REF | REF | - | 4-22284-9 | SPRING, FEED RETURN | 21 |
|  |  |  |  |  |  |  | 20 |
| - | 1 | 1 | - | - | 691353-1 | STRIPPER | 19 |
|  |  |  |  |  |  |  | 18 |
|  |  |  |  |  |  |  | 17 |
| 1 | 1 | 1 | 1 | - | 318563-1 | GUARD, CHIP, FRONT | 16 |
|  |  |  |  |  |  |  | 15 |
| 1 | - | - | - | - | 679625-2 | SHEAR HOLDER (NON-CUT) | 14 |
|  |  |  |  |  |  |  | 13 |
| 1 | 1 | 1 | 1 | - | 3-22280-3 | SPRING, SHEAR | 12 |
| 1 | 1 | 1 | 1 | - | 690461-2 | STOP, SHEAR | 11 |
| - | 1 | 1 | 1 | - | 1-690459-0 | HOLDER, SHEAR (FRONT) | 10 |
| 1 | 1 | 1 | 1 | - | 318707-3 | SHEAR, FLOAT (FRONT) | 9 |
| 1 | 1 | 1 | 1 | - | 3-662186-4 | ANVIL | 8 |
|  |  |  |  |  |  |  | 7 |
|  |  |  |  |  |  |  | 6 |
| 1 | 1 | 1 | 1 | - | 318701-1 | DEPRESSOR, SHEAR (FRONT) | 5 |
| 1 | 1 | 1 | 1 | - | 1-238011-0 | SPACER, BLOCK CRIMPER | 4 |
| 1 | 1 | 1 | 1 | - | 5-683454-0 | CRIMPER, INSULATION | 3 |
| 1 | 1 | 1 | 1 | - | 1-455888-2 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 1 | - | 2-456405-9 | CRIMPER, WIRE | 1 |
| -4 | -3 | -2 | -1 | U/M | PART NO | DESCRIPTION | ITEM NO |
|  |  |  |  |  | QTY REQD PER ASSY | PARTS LIST |  |

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ± .001

1 PLC ± .002

2 PLC ± .003

3 PLC ± .004

4 PLC ± .005

ANGLES ± .001

MATERIAL -

FINISH -

DWN B.HIGMAN 19MAY99

CHK B.HIGMAN 19MAY99

APVD T.ELBIN 19MAY99

PRODUCT SPEC -

APPLICATION SPEC -

WEIGHT -

CUSTOMER DRAWING

tyco Electronics

Tyco Electronics Corporation

Harrisburg, PA 17105-3608

NAME

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

100779

680832

SCALE -

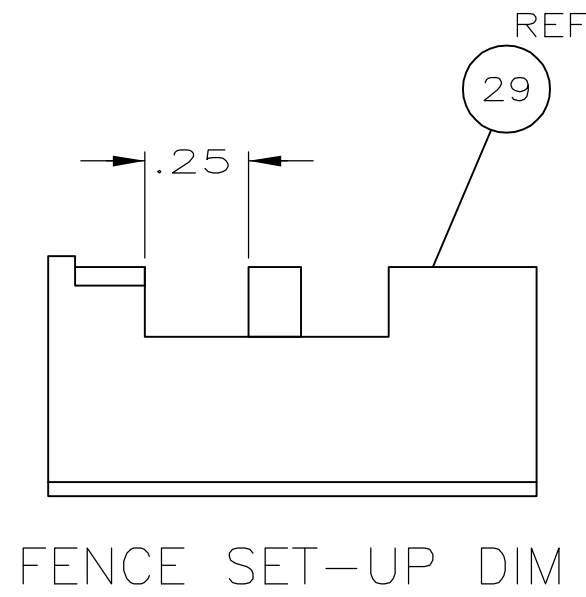
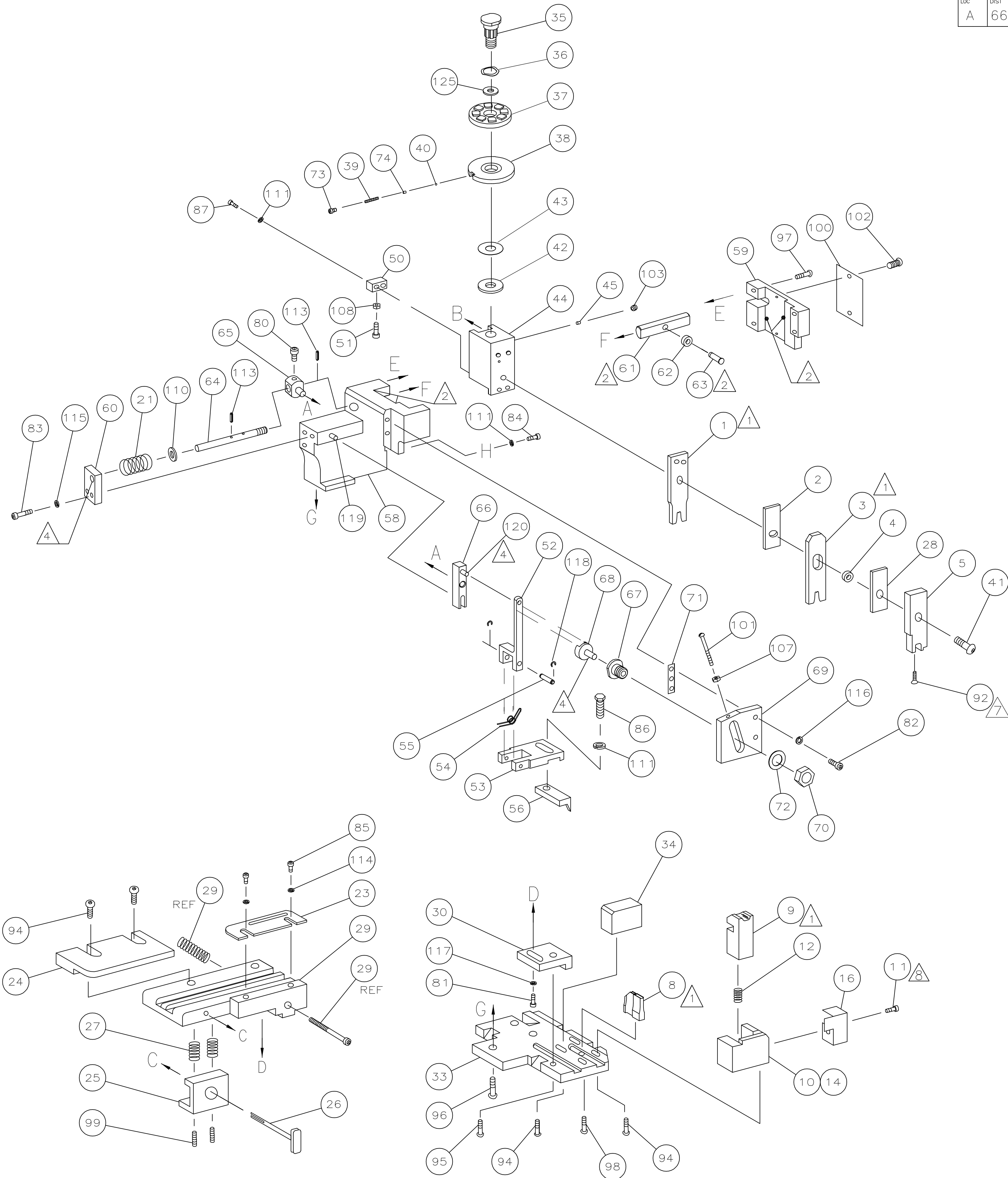
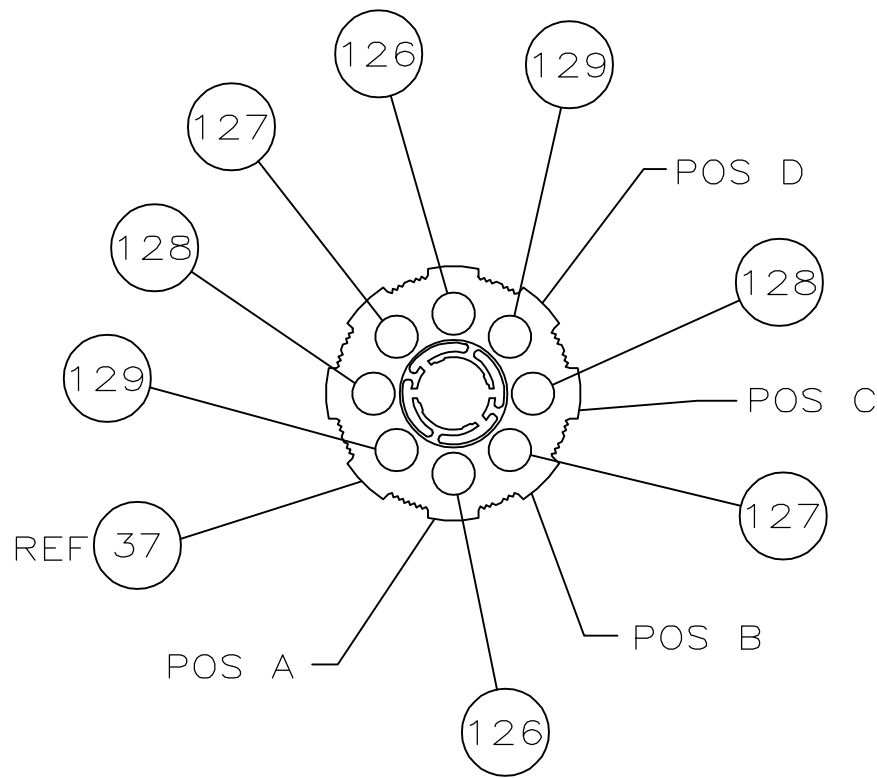
SHEET 1 of 2

REV C

AMP 4805 REV 31MAR2000

18APR2007 7:05am

| LOC | DIST | REVISIONS |     |             |      |     |      |
|-----|------|-----------|-----|-------------|------|-----|------|
| A   | 66   | P         | LTR | DESCRIPTION | DATE | DWN | APVD |
|     |      | —         |     | SEE SHEET 1 | —    | —   | —    |



|                                        |  |                                        |         |                                                           |        |               |
|----------------------------------------|--|----------------------------------------|---------|-----------------------------------------------------------|--------|---------------|
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|                                        |  | CHK<br>B. HIGMAN                       | 19MAY99 |                                                           |        |               |
|                                        |  | APVD<br>T. ELBIN                       | 19MAY99 | NAME<br>SIDE FEED HDM APPLICATOR                          |        |               |
| DIMENSIONS:<br>INCHES                  |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | PRODUCT SPEC                                              |        |               |
|                                        |  | 0. PLC                                 | ± .     | APPLICATION SPEC                                          |        |               |
|                                        |  | 1. PLC                                 | ± .     |                                                           |        |               |
|                                        |  | 2. PLC                                 | ± .02   |                                                           |        |               |
|                                        |  | 3. PLC                                 | ± .     |                                                           |        |               |
|                                        |  | 4. PLC                                 | ± .     |                                                           |        |               |
|                                        |  | ANGLES                                 | ± .     |                                                           |        |               |
| MATERIAL                               |  | FINISH                                 | —       | WEIGHT                                                    | F      | RESTRICTED TO |
|                                        |  |                                        |         | SIZE                                                      | A1     |               |
|                                        |  |                                        |         | CAGE CODE                                                 | 00779  |               |
|                                        |  |                                        |         | DRAWING NO                                                | 680832 |               |
|                                        |  |                                        |         | SCALE                                                     | —      |               |
|                                        |  |                                        |         | SHEET                                                     | 2      |               |
|                                        |  |                                        |         | OF                                                        | 2      |               |
|                                        |  |                                        |         | REV                                                       | C      |               |

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