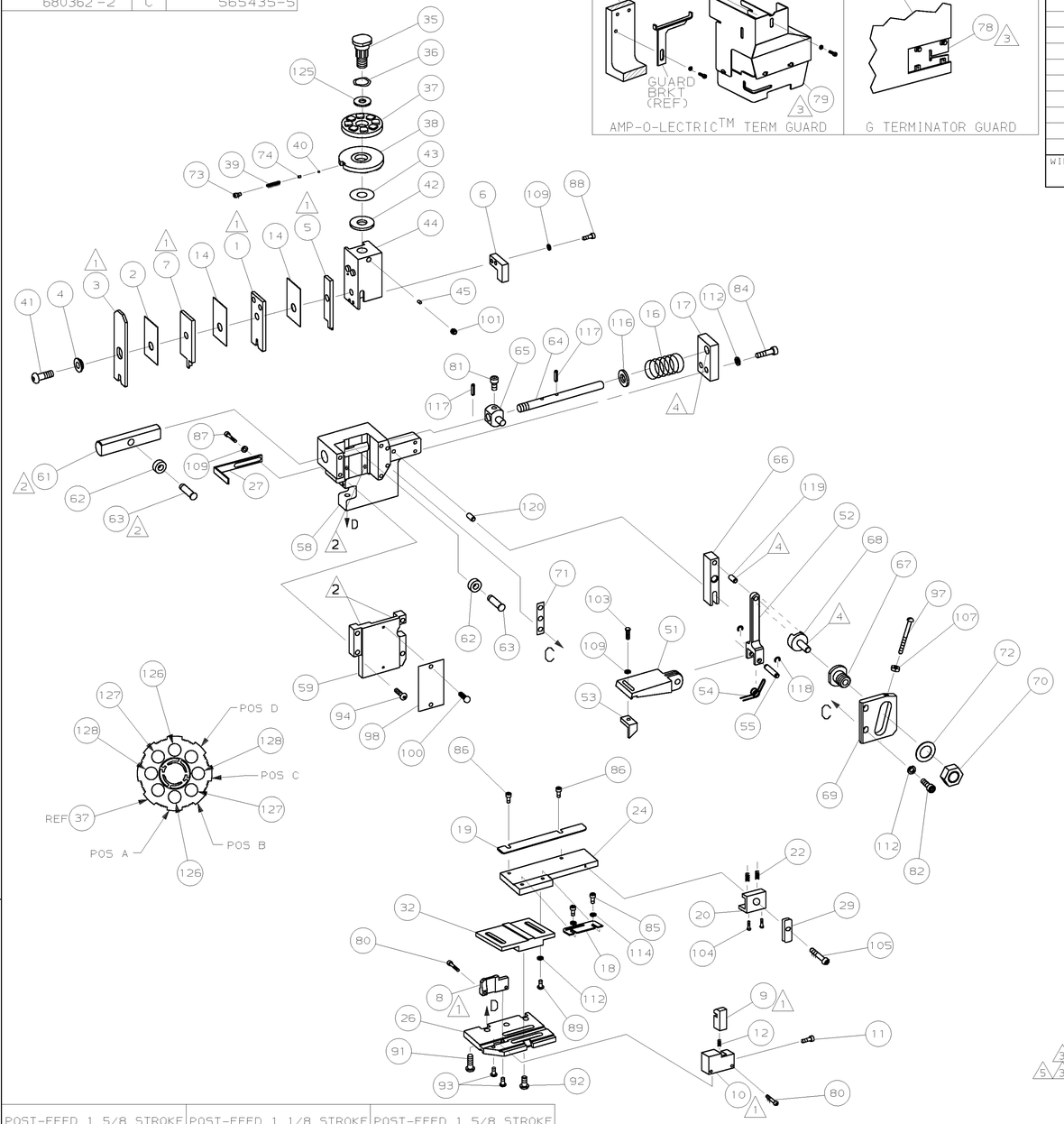
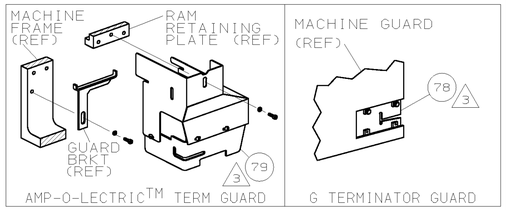
DRAWING MADE IN THIRD ANGLE PROJECTION

/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

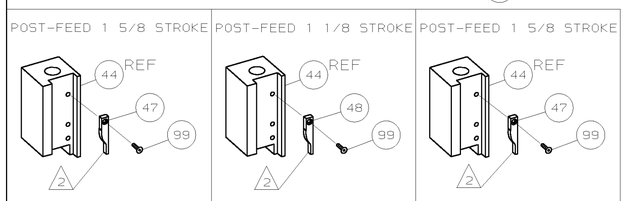
QTY REQD PER ASSY				PARTS LIST			
-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	2	–	C	9-354778-7	PIN, WIRE DISC (.2980)D	129
2	2	–	C	8-354778-3	PIN, WIRE DISC (.2910)C	128
2	2	–	C	6-354778-5	PIN, WIRE DISC (.2820)B	127
2	2	–	C	6-354778-1	PIN, WIRE DISC (.2800)A	126
1	1	–	A	986950-1	WASHER, FLAT PRECISION	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.187x1.50)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	LEADMAKER & BENCH MODEL G			MECH POST FEED		
-2	BENCH MODEL K			MECH POST FEED		
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(5/16-24x1.00)	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				PARTS LIST		
-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

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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24-JUN-02 13:13:16 amp16926

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