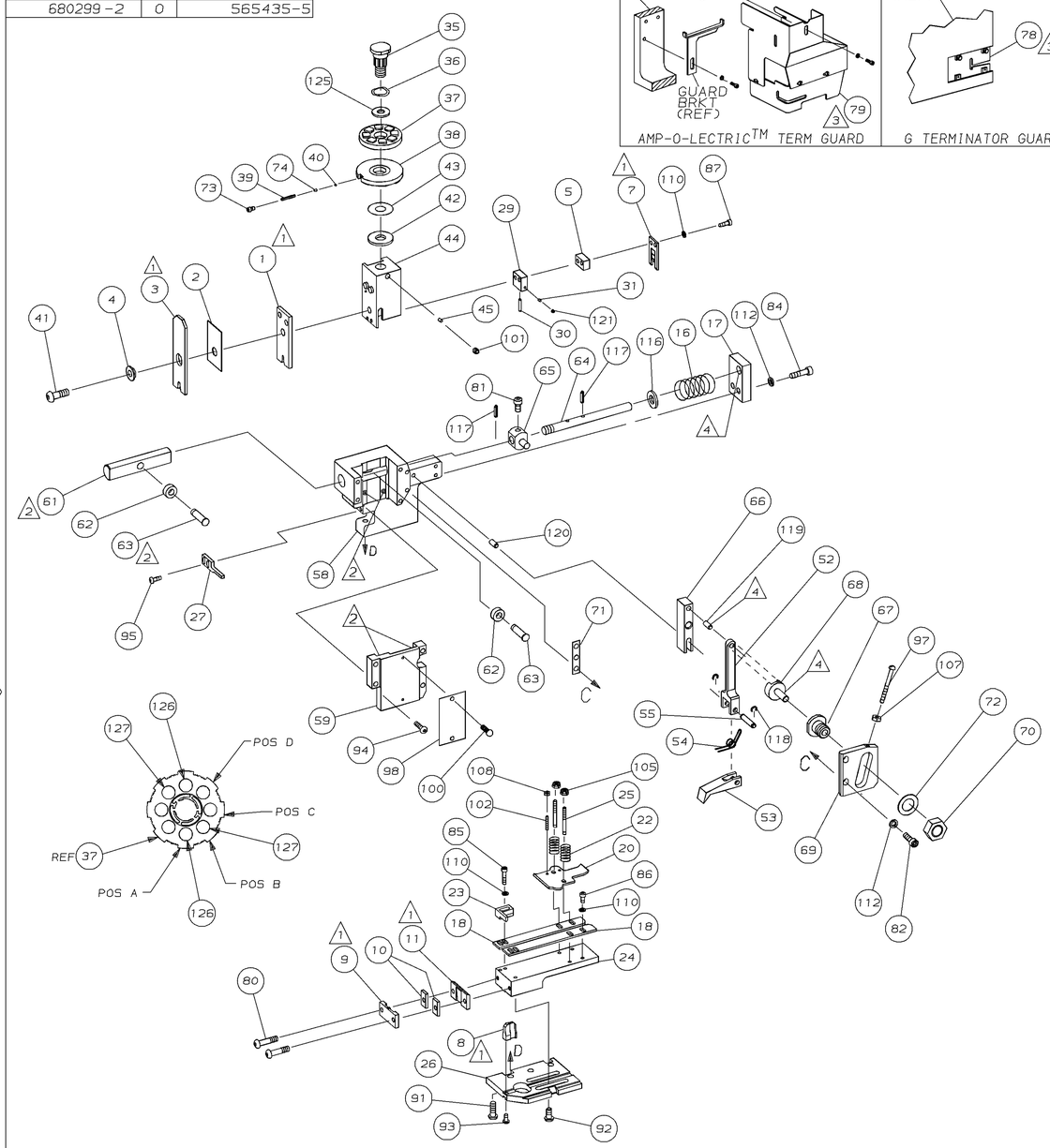
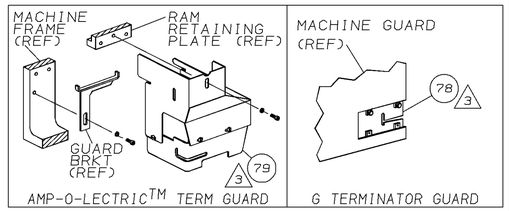
DRAWING MADE IN THIRD ANGLE PROJECTION

680299 ⇔ 680299

/home/amp06572/u.ftb

PART NUMBER	REV	FIRST USED
680299-1	0	122500-1
680299-2	0	565435-5





TERMINAL NAME: SNAP-IN CLUSTER RECEPATCLE △8

		160640
		180412

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.065 ±.002 [1.65 ±0.05mm]	16
B	.058 ±.002 [1.47 ±0.05mm]	18
C	NOT	USED
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.090 [2.29mm]	F	18-16
INSUL	.140 [3.56mm]	F	ø.135-.160

WIRE STRIP LENGTH	TERM APPL SPEC	FEED △7	APPL INSTRUCTION	SET UP GAGE	LAYOUT
–	114-2019	.810	408-8039	458638-1	L1761

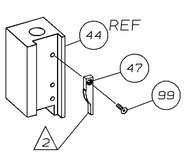
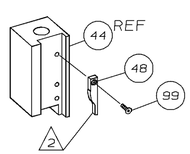
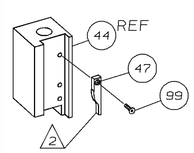
-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
						129
						128
2	2	–	C	354779-6	PIN, WIRE DISC (.3020)B	127
2	2	–	C	9-354778-1	PIN, WIRE DISC (.2950)A	126
1	1	–	A	986950-1	WASHER, FLAT PRECISION	125
1	1	–	A	217238-1	DOCUMENTATION PACKAGE	124
1	1	–	–	4088039	EF APPL INST 408-8039	123
						122
1	1	–	A	1-21006-7	SCR,SKT SET(2-56x.19)FORMING PIN	121
REF	REF	–	A	1-21030-7	PIN,DOWEL(ø.187x1.50)HSG	120
REF	REF	–	A	1-21030-1	PIN,DOWEL(ø.187x.50)LEVER	119
REF	REF	–	A	21045-3	RING,RET"C"(ø.187)FD PIN	118
REF	REF	–	A	5-21028-1	PIN,STD SPRING(ø.12)FD ADJ ROD	117
REF	REF	–	A	21899-4	WASHER,FLAT(ø5/16)SCR ADJ	116
						115
						114
						113
REF	REF	–	A	21024-5	WASHER,LOCK(NO.10)FD ROD GDE	112
						111
7	7	–	A	21024-4	WASHER,LOCK(NO.8)SHEAR BL	110
						109
2	2	–	A	21018-4	NUT,HEX(4-40)DRAG	108
REF	REF	–	A	21018-5	NUT,HEX(6-32)FD ADJ PL	107
						106
2	2	–	A	21022-2	NUT,HEX SL(8-32)DRAG STUD	105
						104
						103
2	2	–	A	2-21006-6	SCR,SKT SET(4-40x.62)DRAG	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
REF	REF	–	A	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	97
						96
2	2	–	A	2-21002-2	SCR,BHC(8-32x.50)STRIPPER	95
REF	REF	–	A	2-21002-9	SCR,BHC(10-32x.75)HSG CAP	94
1	1	–	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
REF	REF	–	A	2-22733-8	SCR,BHC(1/4-20x.62)BASE PL	91
						90
						89
						88
2	2	–	A	2-21000-7	SCR,SHC(8-32x.50)SLUG BLADE	87
3	3	–	A	2-21000-6	SCR,SHC(8-32x.38)STRIP GUIDE	86
2	2	–	A	2-21000-9	SCR,SHC(8-32x.75)R STRIP GUIDE	85
REF	REF	–	A	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GDE	84
						83
REF	REF	–	A	3-21000-6	SCR,SHC(10-32x.62)FEED ADJ PL	82
REF	REF	–	A	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLOCK	81
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
						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
REF	REF	–	A	458109-1	WASHER, FLAT (SPECIAL)	72
REF	REF	–	A	690517-1	SPACER	71

QTY REQD PER ASSY — PARTS LIST

-1	-2	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
LEADMAKER & BENCH MODEL G				MECH POST FEED		
BENCH MODEL K				MECH POST FEED		
REF	REF	–	A	22594-8	NUT, HEX	70
REF	REF	–	B	240628-1	PLATE, ADJ	69
REF	REF	–	B	240626-1	SHAFT, PIVOT	68
REF	REF	–	B	240633-1	BUSHING	67
REF	REF	–	A	455680-1	LEVER, INTERMEDIATE	66
REF	REF	–	B	240629-1	BLOCK, PIVOT	65
REF	REF	–	A	240632-2	SCR, ADJ	64
REF	REF	–	B	240659-3	PIN, CAM ROLLER	63
REF	REF	–	B	240658-1	CAM, ROLLER	62
REF	REF	–	B	454398-1	ROD, FEED	61
						60
REF	REF	–	C	454220-1	CAP, RAM	59
REF	REF	–	D	453736-1	HOUSING	58
						57
						56
REF	REF	–	B	240624-1	PIN, FEED FINGER	55
REF	REF	–	B	691499-1	SPRING, FEED FINGER	54
REF	REF	–	B	240635-1	FINGER, FEED	53
REF	REF	–	B	240634-3	LEVER, TERMINAL	52
						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	455674-2	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	–	D	458980-2	APPLICATOR, BASIC (SUB ASSY)	32
1	1	–	A	690191-3	PLUG, NYLON	31
1	1	–	A	692987-1	PIN, FORMING	30
1	1	–	B	692986-1	HOLDER, FORMING PIN	29
						28
1	1	–	A	690455-1	STRIPPER	27
REF	REF	–	C	455676-1	PLATE, BASE	26
2	2	–	A	22354-8	DRAG, STUD	25
1	1	–	B	455678-3	PLATE, STRIP GUIDE	24
1	1	–	C	240825-2	PLATE, STRIP HOLD DOWN	23
2	2	–	A	4-22281-1	SPRING, DRAG	22
						21
1	1	–	A	454177-1	DRAG, STOCK	20
						19
2	2	–	C	454204-4	GUIDE, STRIP (FRONT)	18
REF	REF	–	A	454178-1	GUIDE, FEED ROD	17
REF	REF	–	A	4-22284-9	SPRING, FEED RETURN	16
						15
						14
						13
						12
△1 1	1	–	B	240644-5	PLATE, REAR SHEAR	11
2	2	–	C	1-240645-0	SPACER, SHEAR PLATE	10
△1 1	1	–	B	690796-2	PLATE, FRONT SHEAR	9
△1 1	1	–	D	6-240655-0	ANVIL	8
△1 1	1	–	B	5-240651-2	BLADE, SLUG	7
						6
1	1	–	C	240641-7	SPACER, SLUG BLADE	5
1	1	–	B	238009-1	SPACER, BLOCK CRIMPER	4
△1 1	1	–	C	1-456134-4	CRIMPER, INSULATION	3
1	1	–	B	455888-7	SPACER, CRIMPER	2
△1 1	1	–	C	1-456406-9	CRIMPER, WIRE	1

QTY REQD PER ASSY — PARTS LIST

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

POST-FEED 1 5/8 STROKE	POST-FEED 1 1/8 STROKE	POST-FEED 1 5/8 STROKE
		
LEADMAKER	K TERMINATOR BENCH MACHINE	G TERMINATOR BENCH MACHINE

LOC A — DIST 66

△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.

△6 ITEM 78 USED WITH G TERMINATOR ONLY.

△7 FEED OFF OF RECEPTACLE.

△8 LANCE SUPPORT TO BE BENT DOWN .035-.045 IN APPLICATOR.

P	F	LTR	REVISION RECORD	APP	DATE
		–	–	.	.

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 4-8-96 M. OBRINE	APP 4-8-96 T. ELBIN	AMP Incorporated Harrisburg, PA 17105-3608	
CHK 4-8-96 C. ERISMAN	REL 5/8/96 B. MORGAN		
NAME END FEED HDM APPLICATOR		MACHINE REF MINI APPL	
SCALE –	D DWG NO 680299	SHEET 1 OF 1	REV 0

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