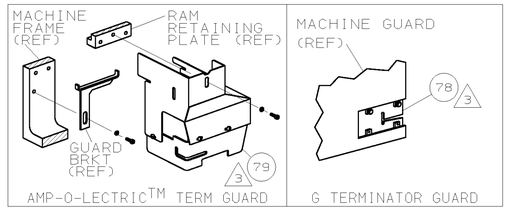
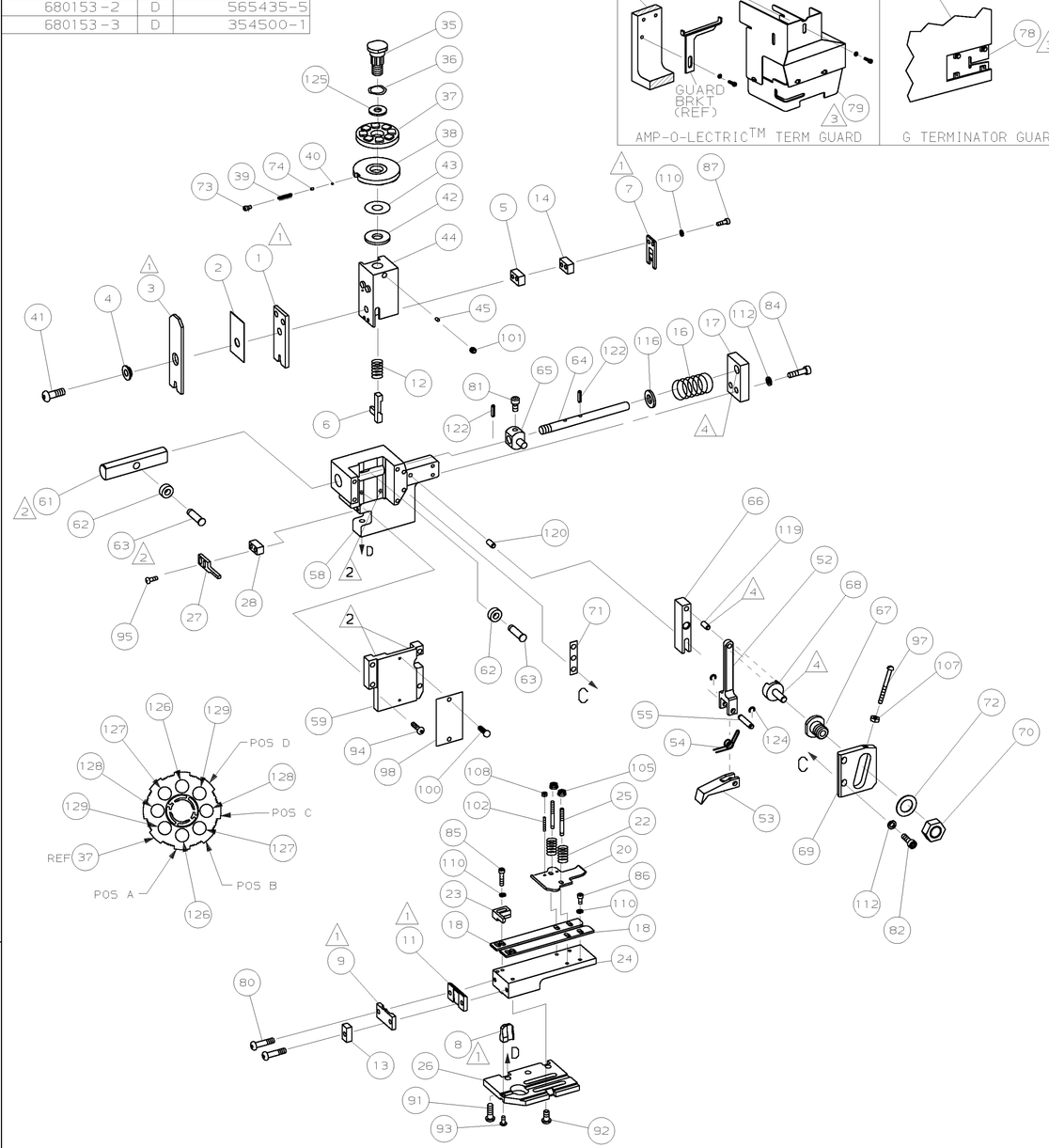
DRAWING MADE IN THIRD ANGLE PROJECTION

/home/us016926/DMTECmod

PART NUMBER	REV	FIRST USED
680153-1	D	122500-1
680153-2	D	565435-5
680153-3	D	354500-1





TERMINAL NAME: RECPT, FASTIN-FASTON,™ .187 SERIES

63833

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.063 ±.002 [1.6 ±0.05mm]	14
B	.058 ±.002 [1.47 ±0.05mm]	(2) 18
C	.054 ±.002 [1.37 ±0.05mm]	16
D	.048 ±.002 [1.22 ±0.05mm]	18

CRIMP	SIZE	TYPE	RANGE
WIRE	.110 [2.79mm]	F	18-14 OR (2) 18
INSUL	.220 [5.59mm]	F	.130-.190 OR (2) .110 MAX

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.141-.171	114-2065	.655	408-8039	458638-1	L1639

-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	2	2	-	C	2-354779-6	PIN, WIRE DISC (.3120)D	129
2	2	2	-	C	1-354779-4	PIN, WIRE DISC (.3060)C	128
2	2	2	-	C	354779-6	PIN, WIRE DISC (.3020)B	127
2	2	2	-	C	9-354778-5	PIN, WIRE DISC (.2970)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.187×1.50)HSG	120
REF	REF	REF	-	A	1-21030-1	PIN,DOWEL(ø.187×.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
7	7	7	-	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(4-40×.62)DRAG	102
1	1	1	-	A	21009-2	SCR,SKT SET(1/4-20×.25)RAM	101
2	2	2	-	A	21017-2	SCR,DRIVE(#2×.19)ID PLATE	100
1	1	1	-	A	1-21002-7	SCR,BHC(6-32×.38)CAM	99
1	1	1	-	B	461264-1	PLATE, IDENTIFICATION	98
REF	REF	REF	-	A	6-23715-5	SCR,PAN HD(6-32×1.50)FEED ADJ	97
							96
2	2	2	-	A	2-21002-2	SCR,BHC(8-32×.50)STRIPPER	95
REF	REF	REF	-	A	2-21002-9	SCR,BHC(10-32×.75)HSG CAP	94
1	1	1	-	A	22733-8	SCR,BHC(8-32×.38 LW)ANVIL	93
4	4	4	-	A	3-21002-3	SCR,BHC(1/4-20×.50)ST GD PL	92
REF	REF	REF	-	A	2-22733-8	SCR,BHC(1/4-20×.62)BASE PL	91
							90
							89
							88
2	2	2	-	A	1-21000-6	SCR,SHC(8-32×.38)SLUG BLADE	87
3	3	3	-	A	2-21000-6	SCR,SHC(8-32×.25)STRIP GUIDE	86
2	2	2	-	A	2-21000-8	SCR,SHC(8-32×.62)R STRIP GUIDE	85
REF	REF	REF	-	A	3-21000-7	SCR,SHC(10-32×.75)FEED ROD GDE	84
							83
REF	REF	REF	-	A	3-21000-6	SCR,SHC(10-32×.62)FEED ADJ PL	82
REF	REF	REF	-	A	3-21000-4	SCR,SHC(10-32×.38)PIVOT BLOCK	81
2	2	2	-	A	3-21002-0	SCR,BHC(10-32×.88)SHEAR PL	80
-	REF	-	-	A	455745-1	GUARD, WINDOW	79
REF	-	-	-	A	679532-1	INSERT, GUARD	78
							77
							76
							75
1	1	1	-	A	690603-1	SPRING, ASSIST	74
1	1	1	-	A	23030-1	SCR,SKT CAP(6-32×.25)CP DSC	73
REF	REF	REF	-	A	458109-1	WASHER, FLAT (SPECIAL)	72
REF	REF	REF	-	A	690517-1	SPACER	71

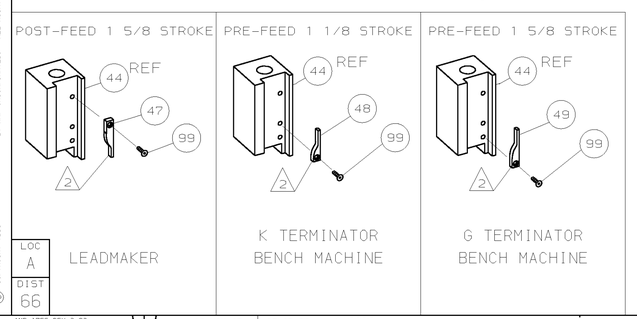
QTY REQD PER ASSY — PARTS LIST

-1	-2	-3	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
LEADMAKER	BENCH MODEL K	BENCH MODEL G			MECH POST FEED		
					MECH PRE FEED		
					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(5/16-24×1.00)	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	458803-5	PLATE, STRIP GUIDE	24
1	1	1	-	C	240825-2	PLATE, STRIP HOLD DOWN	23
2	2	2	-	A	4-22281-1	SPRING, DRAG	22
							21
1	1	1	-	A	454177-1	DRAG, STOCK	20
							19
2	2	2	-	C	454204-3	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
1	1	1	-	C	3-240641-8	SPACER, SLUG BLADE	14
1	1	1	-	C	690481-8	SPACER, HOLD DOWN	13
1	1	1	-	A	23846-1	SPRING, HOLD DOWN	12
1	1	1	-	B	240833-4	PLATE, REAR SHEAR	11
							10
1	1	1	-	B	1-690482-2	PLATE, FRONT SHEAR	9
1	1	1	-	D	9-683452-0	ANVIL	8
1	1	1	-	B	690474-5	BLADE, SLUG	7
1	1	1	-	D	5-455892-3	HOLD DOWN, TERMINAL	6
1	1	1	-	C	5-240641-9	SPACER, SLUG BLADE	5
1	1	1	-	B	1-238009-4	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	8-456134-9	CRIMPER, INSULATION	3
1	1	1	-	B	455888-9	SPACER, CRIMPER	2
1	1	1	-	C	456408-1	CRIMPER, WIRE	1

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

QTY REQD PER ASSY — PARTS LIST

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.



P	F	LTR	REVISION RECORD	APP	DATE
		D	ECN 0150-1227-03	TE	11-03
		C	0150-8707-98	TB	8-98
		B	0150-7793-97	TB	6-97
		A	REVISED	SF	8-95

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 P.MATHIAS 4/26/95 APP 4-27-95 S.FERRANTI
CHK 4-27-95 C.ERISMAN REL 8/16/95 B. MORGAN

AMP Incorporated Harrisburg, PA 17105-3608

NAME END FEED HDM APPLICATOR — MACHINE REF MINI APPL

SCALE – SIZE D DWG NO 680153 SHEET 1 OF 1 REV D

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