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PART NUMBER	REV	FIRST USED
680076–4	F	354500–1

TERMINAL NAME: .250 AMPLIVAR FASTON TAB (8)	
	63165
TERM APPL SPEC	114–2070

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.046 ±.002	19
B	.044 ±.002	20 OR 21
C	.042 ±.002	22 OR 23
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.090	F	23–19 MAG
INSUL	–	–	–

FEED	APPL INST	SET UP GAGE	LAYOUT
.430	408–8040	458637–1	L2218

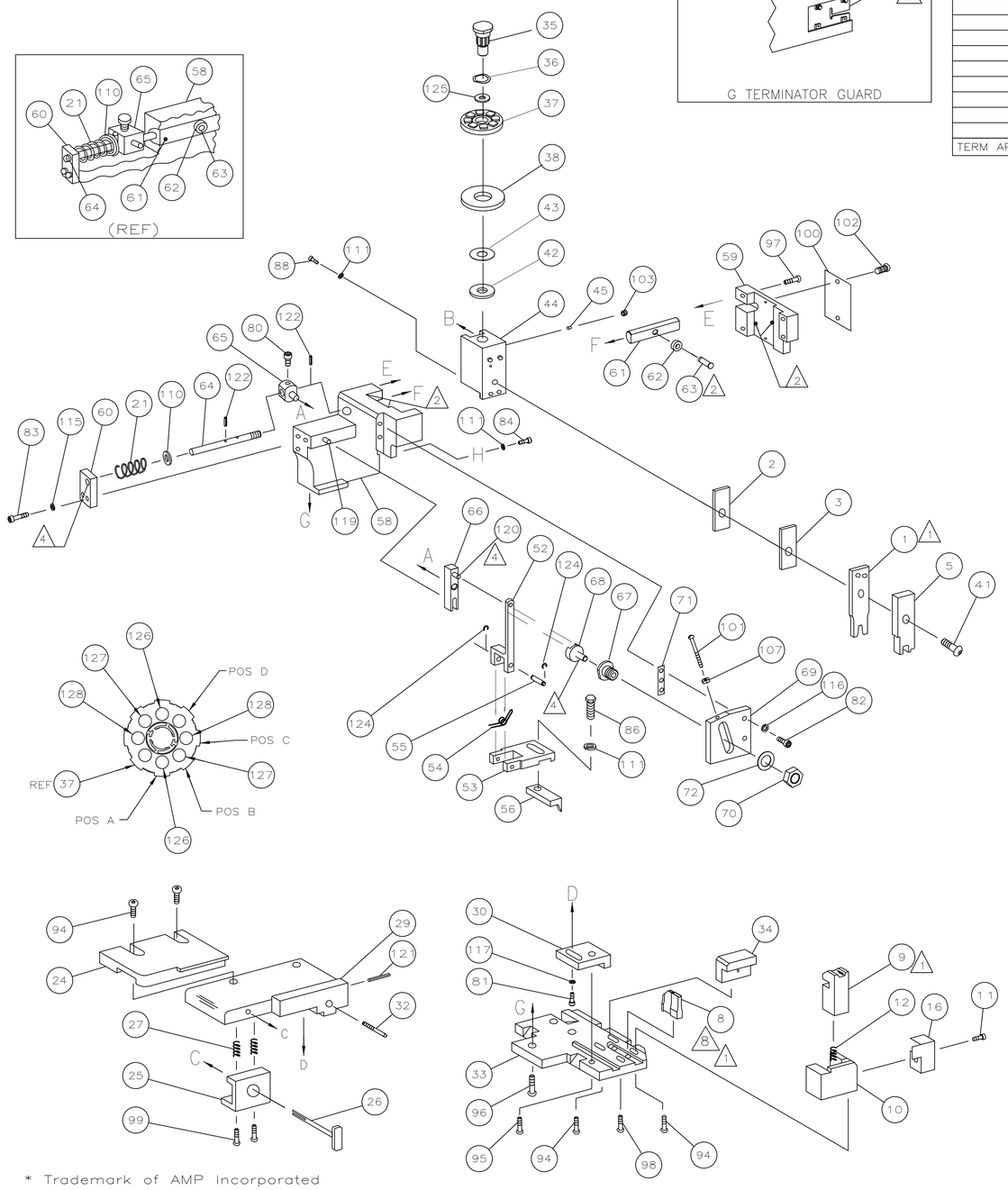
WIRE STRIP LENGTH –

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	F	ECR–09–013800	6–2009	MY	GB

–4	BENCH MODEL G	MECH PRE FEED



				129
2	–	8–354778–7	PIN, WIRE DISC (.2930)C	128
2	–	8–354778–3	PIN, WIRE DISC (.2910)B	127
2	–	8–354778–0	PIN, WIRE DISC (.2895)A	126
1	–	986950–1	WASHER, FLAT PRECISION	125
1	–	21045–3	RING,RET "C"(Ø.187)FD FING PIN	124
				123
1	–	5–21028–1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	122
1	–	4–21028–0	PIN,SLT SPR(Ø.093x.75)ST GDE PL	121
1	–	1–21030–1	PIN,DOWEL(Ø.187x.50)LEVER	120
1	–	1–21030–6	PIN,DOWEL(Ø.187x1.25)HOUSING	119
				118
				117
1	–	21024–5	WASHER,LOCK(#10)ADJ PLATE	116
1	–	21024–5	WASHER,LOCK(#10)FEED GDE ROD	115
				114
				113
				112
3	–	21024–4	WASHER,LOCK(#8)	111
1	–	21899–4	WASHER,FLAT(Ø5/16)SCREW ADJ	110
				109
				108
1	–	21018–5	NUT,HEX(6–32)FEED ADJ	107
				106
				105
				104
1	–	21009–2	SCR,SKT SET(1/4–20x.25 LW)RAM	103
2	–	21017–2	SCR,DRIVE(#2x.19)ID PLATE	102
1	–	6–23715–5	SCR,PAN HD(6–32x1.50)FEED ADJ	101
1	–	461264–1	PLATE, IDENTIFICATION	100
2	–	3–21002–0	SCR,BHC(10–32x.88)DRAG	99
1	–	22733–8	SCR,BHC(8–32x.38 LW)ANVIL	98
1	–	2–21002–9	SCR,BHC(10–32x.75)CAP	97
1	–	2–22733–8	SCR,BHC(1/4–20x.62)HOUSING	96
1	–	2–21002–7	SCR,BHC(10–32x.50)SG ADJ BLOCK	95
6	–	2–21002–2	SCR,BHC(8–32x.50)SHEAR	94
				93
				92
1	–	1–21002–7	SCR,BHC(6–32x.38)CAM	91
				90
3	–	1–21002–3	SCR, BHS (4–40x.19)GUARD	89
2	–	2–21000–5	SCR,SHC(8–32x.25)	88
1	–	3–21000–4	SCR,SHC(10–32x.38)PIVOT BLK	87
1	–	2–22603–0	SCR,HEX HD(8–32x.31)FEED FINGER	86
				85
1	–	2–21000–7	SCR,SHC(8–32x.50)STRIPPER	84
1	–	3–21000–7	SCR,SHC(10–32x.75)FEED ROD GD	83
1	–	3–21000–6	SCR,SHC(10–32x.62)FD ADJ BLK	82
				81
				80
				79
				78
				77
(3) 1	–	679532–9	GUARD	76
				75
				74
				73
1	–	458109–1	WASHER, SPECIAL	72
1	–	690517–1	SPACER	71

QTY REQD PER ASSY –1	U/M	PART NO	DESCRIPTION	ITEM NO
1	–	22594–8	NUT,HEX(1/2–20)	70
1	–	240628–1	PLATE, ADJUSTMENT	69
1	–	240626–1	SHAFT, PIVOT	68
1	–	240633–1	BUSHING	67
1	–	455680–1	LEVER, INTERMEDIATE	66
1	–	240629–1	BLOCK, PIVOT	65
1	–	240632–2	SCREW, ADJ FEED ROD	64
1	–	240659–3	PIN, CAM ROLLER	63
1	–	240658–1	ROLLER, CAM	62
1	–	454398–2	ROD, FEED	61
1	–	454178–1	GUIDE, FEED ROD	60
1	–	454220–1	CAP, RAM	59
1	–	454485–1	HOUSING	58
				57
1	–	458537–1	PAWL, FEED	56
1	–	240624–1	PIN, FEED FINGER	55
1	–	691499–1	SPRING, FEED FINGER	54
1	–	690541–1	HOLDER, FEED FINGER	53
1	–	455679–2	LEVER, TERMINAL FEED ARM	52
				51
				50
1	–	690602–6	CAM, PRE–FEED 1 5/8 ST	49
				48
				47
				46
1	–	690191–1	PLUG, NYLON	45
1	–	1–455673–2	RAM	44
1	–	690125–1	WASHER, LAMINATED	43
1	–	1–690124–1	WASHER, RAM	42
1	–	690686–2	BOLT, CRIMPER(5/16x1.00)	41
				40
				39
1	–	690223–2	SPACER, INSULATION DISC	38
1	–	354777–1	WIRE DISC, PLASTIC	37
1	–	22480–5	WASHER, SPRING	36
1	–	690212–1	POST, RAM	35
1	–	1338461–1	TOOL, BENDING	34
1	–	455675–6	PLATE, BASE	33
1	–	690432–3	SCREW, ADJUSTMENT	32
				31
1	–	455689–1	BLOCK, STRIP GUIDE ADJ	30
1	–	1320409–1	PLATE, STRIP GUIDE	29
				28
2	–	1–22284–0	SPRING, DRAG	27
1	–	690546–1	LEVER, DRAG RELEASE	26
1	–	240792–1	DRAG, TERMINAL	25
1	–	1320410–1	GUIDE, STRIP (REAR)	24
				23
1	–	690472–4	STRIPPER	22
1	–	4–22284–9	SPRING, FEED RETURN	21
				20
				19
				18
				17
1	–	318563–1	GUARD, CHIP, FRONT	16
				15
				14
				13
1	–	6–22279–4	SPRING, SHEAR	12
1	–	690461–1	STOP, SHEAR	11
1	–	2–690459–5	HOLDER, SHEAR (FRONT)	10
(1) 1	–	1–462006–1	SHEAR, FLOAT (FRONT)	9
(7)(1) 1	–	1–805840–7	ANVIL	8
				7
				6
1	–	1320411–1	DEPRESSOR, SHEAR (FRONT)	5
				4
1	–	1–455888–2	SPACER	3
1	–	2–455888–9	SPACER	2
(1) 1	–	462808–4	CRIMPER, WIRE	1

QTY REQD PER ASSY –1 | U/M | PART NO | DESCRIPTION | ITEM NO

PARTS LIST

* Trademark of AMP Incorporated

(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) INSTALL AFTER RAM IS IN HOUSING.~~

(7) INSTALL IN HOLE CLOSEST TO FRONT OF BASE PLATE.

(8) TERMINAL TO BE BENT UP 85°±5°.

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± – ; 1 PLC ± – ; 2 PLC ± – ; 3 PLC ± – ; 4 PLC ± – ; ANGLES ± –

MATERIAL – FINISH –

DWN R.HIGMAN 4–9–99
CHK T.ELBIN 4–9–99
APVD T.ELBIN 4–9–99

PRODUCT SPEC –
APPLICATION SPEC –
WEIGHT –

Tyco Electronics — Tyco Electronics Corporation, Harrisburg, PA 17105–3608

NAME: SIDE FEED HDM APPLICATOR – –

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C–680076–4	–

CUSTOMER DRAWING | SCALE – | SHEET 1 OF 1 | REV F

4805 (1/08)

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