

THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		2007	
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PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	
680588-3	E	354500-1	BENCH MODEL G	AIR FEED	

- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 LUBRICATE DAILY USING NO.20 MACHINE OIL.
- 4. DO NOT EXCEED 80 C.P.M. WITH THIS APPLICATOR.
- 5 AFTER ASSEMBLY OF APPLICATOR, PROPER SPRING PRESSURE (ITEM 34) CAN BE OBTAINED BY TIGHTENING SET SCREW (ITEM 105) UNTIL CONTACT IS MADE WITH SPACER (ITEM 32) THEN TIGHTEN AN ADDITIONAL 5 1/2 - 6 REVOLUTIONS.
- 6 SELECT TERMINAL POSITIONER AS REQUIRED TO KEEP TERMINAL ON CENTER OF ANVIL. FASTEN EXTRA TERMINAL POSITIONER TO APPLICATOR. (REFER TO AMP FORM 6140-4)
- 7 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 8 APPLY LOCKTITE P/N 1-23419-5 TO ITEM 93 AT ASSEMBLY.

TERMINAL NAME: RECEPTACLE, FLAG, FASTON, .250 SERIES					
-	42234	AMP TERMINAL - AMP CRIMP SPECS			
-	42459				
-	60195	PAD LTR	CRIMP HEIGHT	WIRE SIZE	Ø SOLDER
-	60643	A	.065±.002	14	-
-	62354	B	.061±.002	16	-
-	63635	C	.058±.002	18	-
-	1742595-1	D	.056±.002	20	-
-	-	CRIMP	SIZE	TYPE	RANGE
-	-	WIRE	.140	TAB LOC	20-14
-	-	INSUL	.170	O	.110-.170
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTIONS	SET UP GAGE	LAYOUT
.205-.235	114-2078	.650	408-8031	-	-

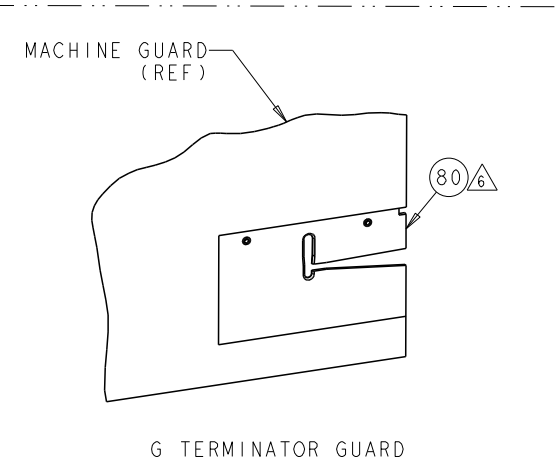
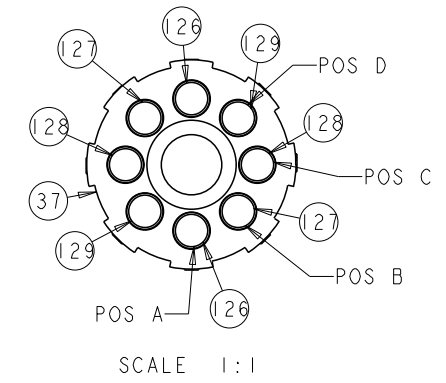
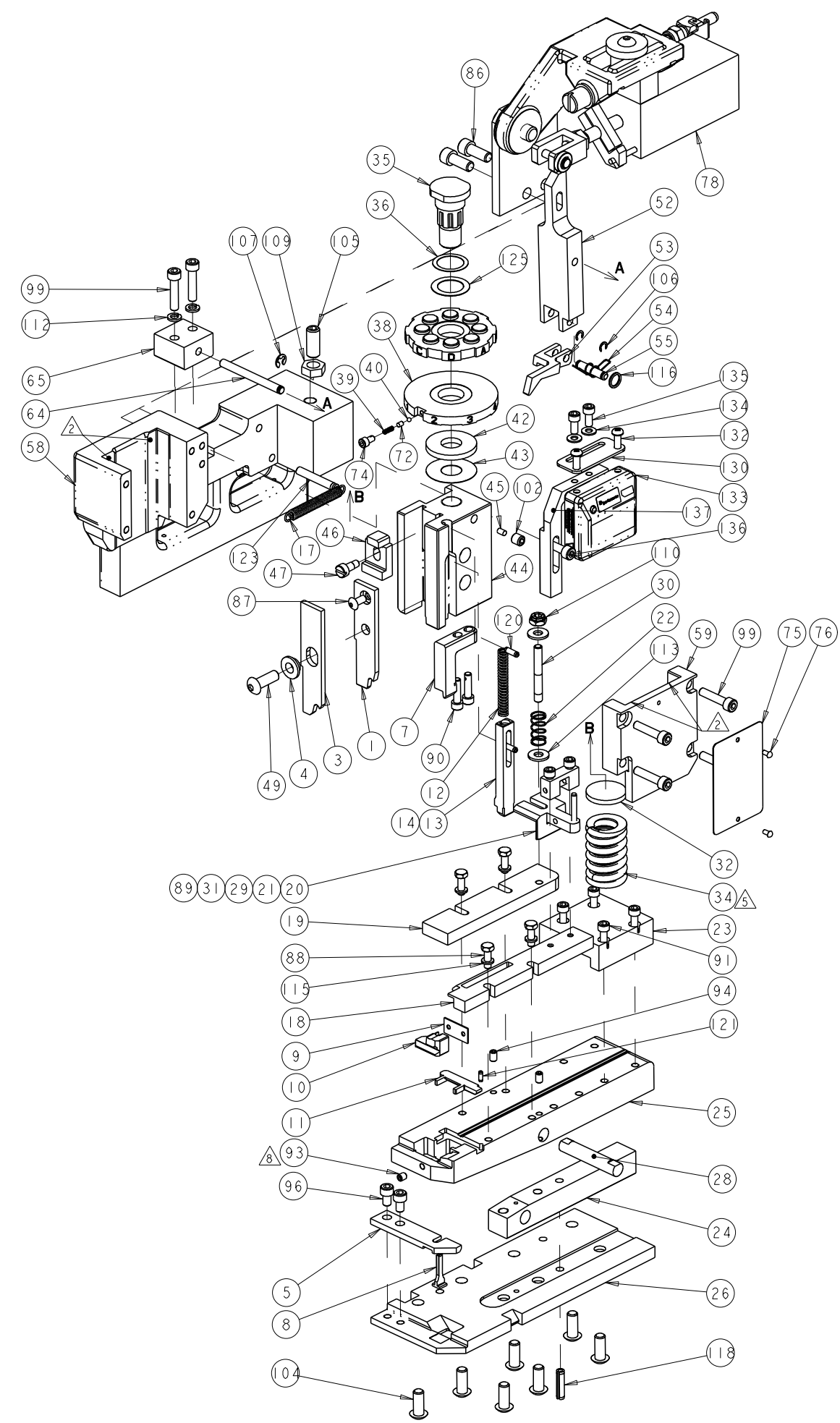
LOC	DIST	REVISIONS					
A	66	#	LTR	DESCRIPTION	DATE	OWN	APVD
		E		ECR-07-006533	27MAR2007	BW	TE
		E1		ECR-07-017988	01AUG2007	MY	TM
		E2		ECR-14-002580	24FEB2014	YY	UG

4	-	2-22603-3	SCR, HEX HD CAP, 1IN	88
1	-	2-21002-1	SCR, BTN SKT HD CAP 8-32 X .375	87
2	-	21001-3	SCR, SKT HD CAP 1/4-20 X .625	86
REF	...	679532-1	INSERT, GUARD	80
1	-	462622-3	AIR FEED ASSEMBLY	78
2	-	21017-2	SCREW, DRIVE	76
1	-	461264-1	PLATE, IDENTIFICATION	75
1	-	23030-1	SCR, SKT HD CAP, S-LOCK, 6-32 X .25	74
1	-	690603-1	SPRING ASSIST AMP-O-MATOR APPLICATOR	72
1	-	456987-1	BLOCK, PIVOT	65
1	-	457058-1	PIN, PIVOT	64
1	-	455164-1	CAP, RAM	59
1	-	457079-1	HOUSING, MACHINING	58
1	-	240624-1	PIN, FEED FINGER	55
1	-	691499-1	SPRING-FEED FINGER	54
1	-	454568-2	FINGER, FEED	53
1	-	457057-1	PIVOT ARM	52
1	-	3-21002-5	SCR, BTN SKT HD CAP 1/4-20 X .750	49
1	-	22353-8	SCR, SHLD, SLOT HD, 3/16 DIA	47
1	-	690578-1	INSULATION ADJUST BLOCK	46
1	-	690191-1	PLUG, NYLON	45
1	-	454574-1	RAM, SPECIAL	44
1	-	690125-1	SHIM SUB-ASSY	43
1	-	690124-4	WASHER, RAM (.135)	42
1	-	23241-6	BALL, STEEL	40
1	-	690170-1	SPRING, COMPRESSION	39
1	-	690142-1	DISC, INSULATION	38
1	-	354777-1	WIRE DISC, ASSEMBLY	37
1	-	22480-5	WASHER, WAVE SPRING	36
1	-	690212-1	POST, RAM	35
1	-	3-23846-5	SPRING, DIE	34
1	-	690573-1	SPACER, SPRING	32
1	-	454569-1	MOUNT, DRAG	31
1	-	1-22354-8	STUD, THREADED	30
1	-	21030-2	PIN, DOWEL .1250 X .500	29
1	-	690582-1	PIN, HINGE	28
1	-	684905-1	PLATE, BASE	26
1	-	454579-2	BAR, HINGE	25
1	-	690571-1	STABILIZER	24
1	-	690585-1	BLOCK, SPRING PRESSURE	23
1	-	22282-5	SPRING, COMPRESSION	22
1	-	21030-6	PIN, DOWEL .1250 X 1.000	21
1	-	454570-1	DRAG, STOCK	20
1	-	454573-1	GUIDE, STRIP, REAR	19
1	-	454571-2	GUIDE, FRONT STRIP	18
1	-	2-22287-6	SPRING, EXTENSION	17
1	-	692134-7	POSITIONER, TERMINAL	14
1	-	692134-2	TERMINAL POSITIONER	13
1	-	5-22280-5	SPRING, COMPRESSION	12
1	-	454712-4	PLATE, REAR SHEAR	11
1	-	454578-1	ANVIL INSERT	10
1	-	690569-3	PLATE, SHEAR, FRONT	9
1	-	690718-1	ANVIL, REVERSIBLE	8
1	-	454575-3	BLADE, SHEAR	7
1	-	684906-1	ANVIL RETAINING	5
1	-	690574-1	SPACER, TUBULAR	4
1	-	690588-1	CRIMPER, INSULATION PREMIUM	3
1	-	690716-3	CRIMPER, WIRE PREMIUM	1
-3	U/M	PART NO	DESCRIPTION	ITEM NO

1	-	1976348-1	L-BRACKET, COUNTER	137
1	-	3-21000-6	SCR, SKT HD CAP 10-32 X .625	136
2	-	2-21000-6	SCR, SKT HD CAP 8-32 X .375	135
2	-	18028-2	WASHER, FLAT, REG M4	134
1	-	1804300-1	ASSEMBLY, APPLICATOR COUNTER	133
2	-	994991-5	SCREW, OVL HD, M4X12	132
1	-	1976349-1	BRACKET, COUNTER	130
2	-	2-354779-9	PIN, WIRE DISC (.3135)	129
2	-	2-354779-8	PIN, WIRE DISC (.3130)	128
2	-	2-354779-4	PIN, WIRE DISC (.3110)	127
2	-	1-354779-8	PIN, WIRE DISC (.3080)	126
1	-	986950-1	WASHER, FLAT PRECISION	125
1	-	4-22183-0	PIN, GROOVED, TYPE 67	123
1	-	3-21028-2	PIN, SLOTTED SPRING .094 X .250	121
2	-	4-21028-9	PIN, SLOTTED SPRING .125 X .375	120
1	-	21029-5	PIN, SLOTTED SPRING .188 X .750	118
1	-	25745-1	RING, SPLIT	116
4	-	21024-4	WASHER, SPRG LOCK, REG NO 8	115
2	-	21899-2	WASHER, FLAT	113
2	-	21024-5	WASHER, SPRG LOCK, REG NO 10	112
1	-	21022-3	NUT, HEX, SELF-LOCKING, THIN, 10-32	110
1	-	1-22202-7	NUT, HEX, JAM 5/16-24/UNF	109
1	-	1-21986-2	RING, RETAIN, EXTERN, 3/16 E-RING	107
2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	106
1	-	8-21007-5	SCR, SET, CUP POINT 5/16-24 X .750	105
7	-	2-22733-8	SCR, BHSC, SELF-LOCKING, 1/4-20 X .625	104
1	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	102
6	-	3-21000-8	SCR, SKT HD CAP 10-32 X .875	99
2	-	7-21000-6	SCR, SKT HD CAP 10-32 X .312	96
2	-	4-21008-0	SCR, SET, SELF LOCKING 1/4-20 X .250	94
1	-	21061-9	SCR, SET, CONE POINT 8-32 X .250	93
4	-	2-21000-9	SCR, SKT HD CAP 8-32 X .750	91
2	-	1-23030-1	SCR, SKT HD CAP, S-LOCK, 8-32 X .625	90
2	-	2-21000-8	SCR, SKT HD CAP 8-32 X .625	89

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN B. WEAVER 07FEB2007	
IN		0 PLC ±		CHK T. ELBIN 07FEB2007	
1		1 PLC ±		APVD T. ELBIN 07FEB2007	
2		2 PLC ±		NAME	
3		3 PLC ±		APPLICATOR, HINGE BAR, .205 FLAG FASTON	
4		4 PLC ±		PRODUCT SPEC	
ANGLES		FINISH		APPLICATION SPEC	
MATERIAL		WEIGHT		SIZE CAGE CODE DRAWING NO	
				A 100779 680588	
				RESTRICTED TO	
				Customer Accessible Production Drawing SCALE 1:1 SHEET 1 OF 2 REV E2	

LOC		DIST		REVISIONS			
#	LYR	DESCRIPTION	DATE	DWN	APVD		
A	66	SEE SHEET 1					



<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN B. WEAVER 07FEB2007 CHK T. ELBIN 07FEB2007 APVD T. ELBIN 07FEB2007	TE TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: IN		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	NAME: APPLICATOR, HINGE BAR, .205 FLAG FASTON SIZE: CAGE CODE: DRAWING NO: A100779 ©=680588 RESTRICTED TO:
MATERIAL:		FINISH:	WEIGHT: Customer Accessible Production Drawing SCALE: 3:5 SHEET 2 OF 2 REV E2

CUSTOMER VIEWABLE ASSEMBLY