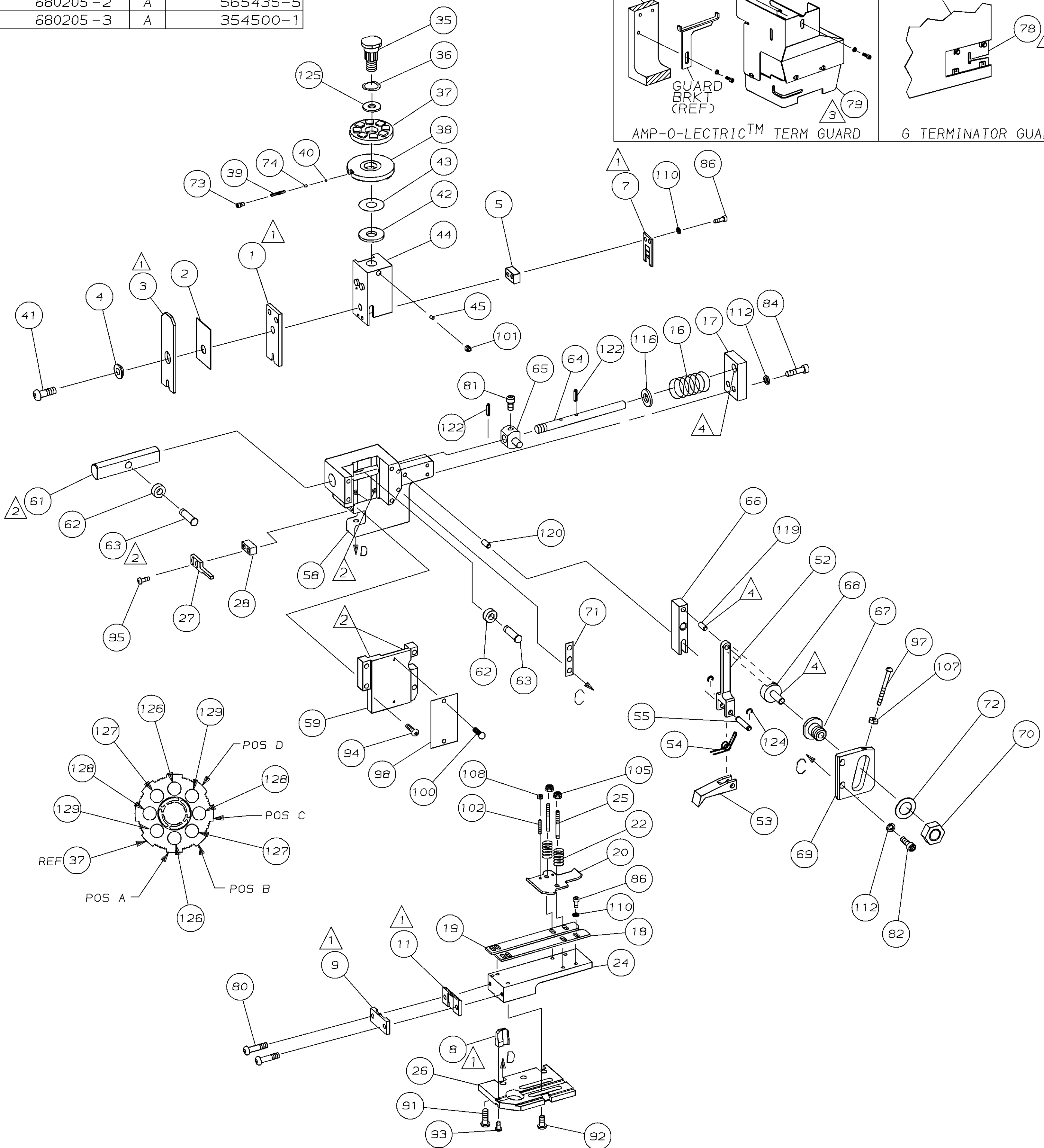
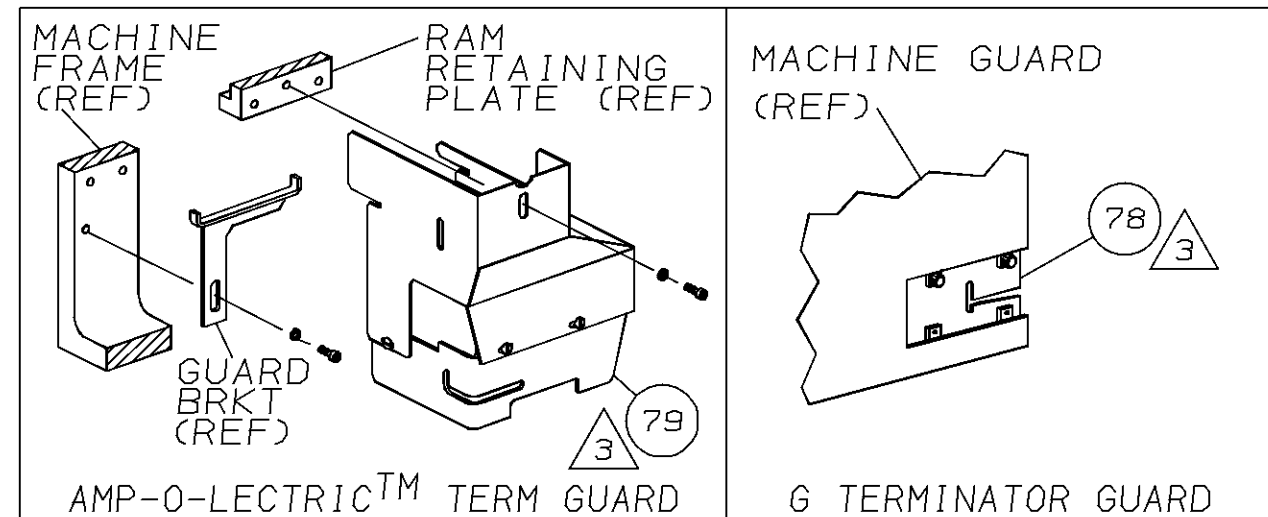


| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------|
| 680205-1 | A | 122500-1 |
| 680205-2 | A | 565435-5 |
| 680205-3 | A | 354500-1 |



| TERMINAL NAME: RING TONGUE | | 735097 | | CRIMPING DATA | |
|----------------------------|-----------------------------|---|--|---------------|--------|
| PAD LTR | CRIMP HEIGHT | WIRE SIZE | | | |
| A | .042 ± .002 [1.07 ± 0.05mm] | 0.2mm ² | | | |
| B | .044 ± .002 [1.12 ± 0.05mm] | 0.25mm ² or 0.3mm ² | | | |
| C | .046 ± .002 [1.14 ± 0.05mm] | 0.4mm ² | | | |
| D | .048 ± .002 [1.22 ± 0.05mm] | 0.5mm ² | | | |
| CRIMP | SIZE | TYPE | RANGE | | |
| WIRE | .070 [1.78mm] | F | 0.2mm ² -0.5mm ² | | |
| INSUL | .100 [2.54mm] | F | 1mm-1.9mm | | |
| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPL INSTRUCTION | SET UP GAGE | LAYOUT |
| - | 114-2084 | .465 | 408-8039 | 458638-1 | L1681 |

| | | | | | | | |
|-------------------|-----|-----|-----|----------|------------|---------------------------------|---------|
| 2 | 2 | 2 | - | C | 2-354779-9 | PIN, WIRE DISC (.3135)D | 129 |
| 2 | 2 | 2 | - | C | 3-354779-4 | PIN, WIRE DISC (.3160)C | 128 |
| 2 | 2 | 2 | - | C | 3-354779-8 | PIN, WIRE DISC (.3180)B | 127 |
| 2 | 2 | 2 | - | C | 4-354779-3 | PIN, WIRE DISC (.3205)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 |
| REF | REF | REF | - | A | 5-21028-1 | PIN, STD SPRING(Ø.12)FD ADJ ROD | 122 |
| REF | REF | REF | - | A | 1-21030-7 | PIN, DOWEL (Ø.187x1.50)HSG | 120 |
| REF | REF | REF | - | A | 1-21030-1 | PIN, DOWEL (Ø.187x.50)LEVER | 119 |
| REF | REF | REF | - | A | 21899-4 | WASHER, FLAT(Ø5/16)SCR ADJ | 116 |
| REF | REF | REF | - | A | 21024-5 | WASHER, LOCK (NO.10)FD ROD GDE | 112 |
| 7 | 7 | 7 | - | A | 21024-4 | WASHER, LOCK (NO.8)SHEAR BL | 110 |
| 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 |
| 2 | 2 | 2 | - | A | 21022-2 | NUT, HEX SL (8-32)DRAG STUD | 105 |
| 2 | 2 | 2 | - | A | 2-21006-6 | SCR, SKT SET (4-40x.62)DRAG | 102 |
| 1 | 1 | 1 | - | A | 21009-2 | SCR, SKT SET (1/4-20x.25)RAM | 101 |
| 2 | 2 | 2 | - | A | 21017-2 | SCR, DRIVE (#2x.19) ID PLATE | 100 |
| 1 | 1 | 1 | - | A | 1-21002-7 | SCR, BHC (6-32x.38) CAM | 99 |
| 1 | 1 | 1 | - | B | 461264-1 | PLATE, IDENTIFICATION | 98 |
| REF | REF | REF | - | A | 6-23715-5 | SCR, PAN HD (6-32x1.50)FEED ADJ | 97 |
| 2 | 2 | 2 | - | A | 2-21002-2 | SCR, BHC (8-32x.50)STRIPPER | 95 |
| REF | REF | REF | - | A | 2-21002-9 | SCR, BHC (10-32x.75)HSG CAP | 94 |
| 1 | 1 | 1 | - | A | 22733-8 | SCR, BHC (8-32x.38 LW) ANVIL | 93 |
| 4 | 4 | 4 | - | A | 3-21002-3 | SCR, BHC (1/4-20x.50)ST ØD PL | 92 |
| REF | REF | REF | - | A | 2-22733-8 | SCR, BHC (1/4-20x.62)BASE PL | 91 |
| REF | REF | REF | - | A | 3-21000-6 | SCR, SHC (10-32x.62)FEED ADJ PL | 82 |
| REF | REF | REF | - | A | 3-21000-4 | SCR, SHC (10-32x.38)PIVOT BLOCK | 81 |
| 2 | 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 |
| 1 | 1 | 1 | - | A | 690603-1 | SPRING, ASSIST | 74 |
| 1 | 1 | 1 | - | A | 23030-1 | SCR, SKT CAP (6-32x.25)CP DSC | 73 |
| REF | REF | REF | - | A | 458109-1 | WASHER, FLAT (SPECIAL) | 72 |
| REF | REF | REF | - | A | 690517-1 | SPACER | 71 |
| -3 | -2 | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
| QTY REQD PER ASSY | | | | | PARTS LIST | | |

| -1 LEADMAKER | | MECH POST FEED | | | | | |
|-------------------|---------------|----------------|-----|----------|------------|---------------------|---------|
| -2 | BENCH MODEL K | MECH PRE FEED | | | | | |
| -3 | BENCH MODEL G | 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 |
| | | | | | | | 59 |
| | | | | | | | 58 |
| | | | | | | | 57 |
| | | | | | | | 56 |
| | | | | | | | 55 |
| | | | | | | | 54 |
| | | | | | | | 53 |
| | | | | | | | 52 |
| | | | | | | | 51 |
| | | | | | | | 50 |
| | | | | | | | 49 |
| | | | | | | | 48 |
| | | | | | | | 47 |
| | | | | | | | 46 |
| | | | | | | | 45 |
| | | | | | | | 44 |
| | | | | | | | 43 |
| | | | | | | | 42 |
| | | | | | | | 41 |
| | | | | | | | 40 |
| | | | | | | | 39 |
| | | | | | | | 38 |
| | | | | | | | 37 |
| | | | | | | | 36 |
| | | | | | | | 35 |
| | | | | | | | 34 |
| | | | | | | | 33 |
| | | | | | | | 32 |
| | | | | | | | 31 |
| | | | | | | | 30 |
| | | | | | | | 29 |
| | | | | | | | 28 |
| | | | | | | | 27 |
| | | | | | | | 26 |
| | | | | | | | 25 |
| | | | | | | | 24 |
| | | | | | | | 23 |
| | | | | | | | 22 |
| | | | | | | | 21 |
| | | | | | | | 20 |
| | | | | | | | 19 |
| | | | | | | | 18 |
| | | | | | | | 17 |
| | | | | | | | 16 |
| | | | | | | | 15 |
| | | | | | | | 14 |
| | | | | | | | 13 |
| | | | | | | | 12 |
| | | | | | | | 11 |
| | | | | | | | 10 |
| | | | | | | | 9 |
| | | | | | | | 8 |
| | | | | | | | 7 |
| | | | | | | | 6 |
| | | | | | | | 5 |
| | | | | | | | 4 |
| | | | | | | | 3 |
| | | | | | | | 2 |
| | | | | | | | 1 |
| -3 | -2 | -1 | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
| 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.

| POST-FEED 1 5/8 STROKE | PRE-FEED 1 1/8 STROKE | PRE-FEED 1 5/8 STROKE |
|------------------------|----------------------------|----------------------------|
| | | |
| LOC A LEADMAKER | K TERMINATOR BENCH MACHINE | G TERMINATOR BENCH MACHINE |

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED.

DR M. O'BRINE 10-9-95 APP T. BEDDICK 10-9-95
 CHK 10-9-95 REL C. ERISMAN 12/11/95
 3 PLC DEC +-
 4 PLC DEC +-
 ANGLES +-
 SURF TEXTURE: ✓ REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL - HT TR - FIN -

AMP Incorporated Harrisburg, PA 17105-3608

NAME END FEED HDM APPLICATOR MACHINE REF MINI APPL

SCALE - DWG NO 680205 SHEET 1 OF 1 REV A

THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INCORPORATED. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

THIS INFORMATION IS CONFIDENTIAL AND IS DISCLOSED TO YOU ON CONDITION THAT NO FURTHER DISCLOSURE IS MADE BY YOU TO OTHER THAN AMP PERSONNEL WITHOUT WRITTEN AUTHORIZATION FROM AMP INCORPORATED, HARRISBURG, PA.

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[680205-1](#)