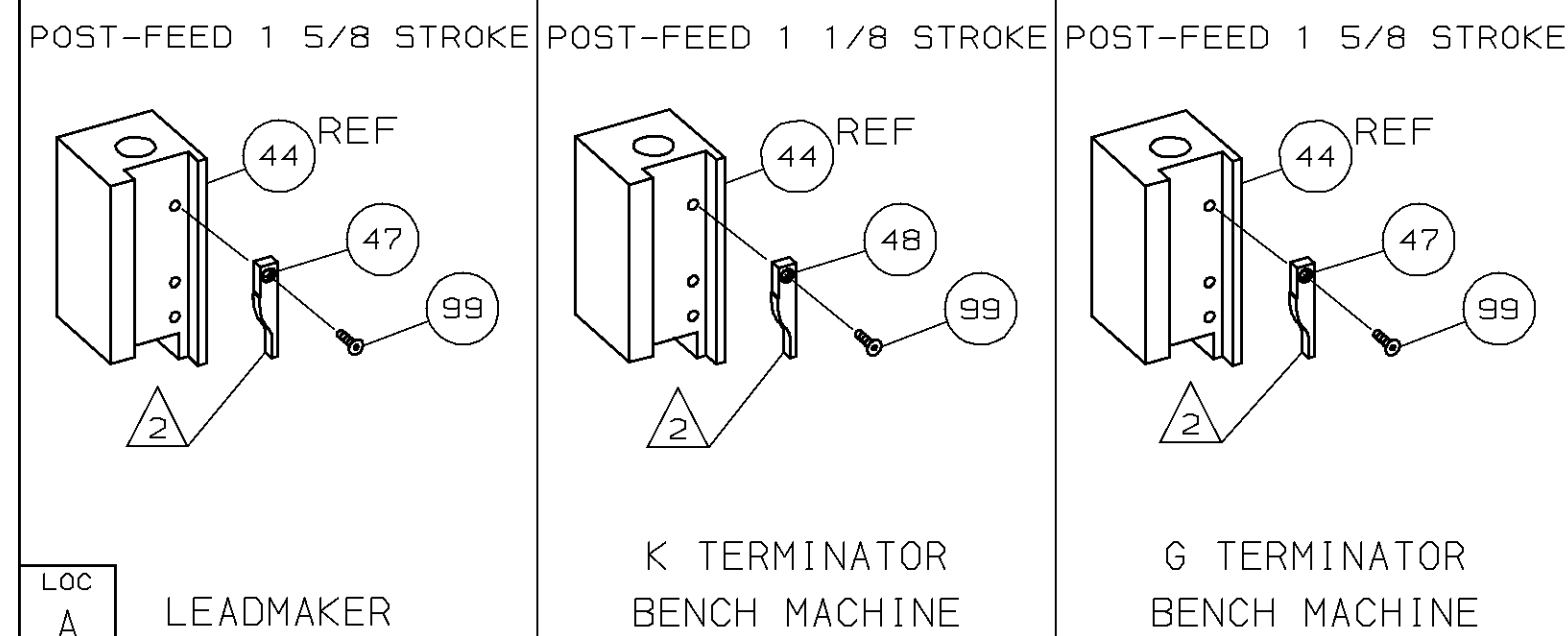
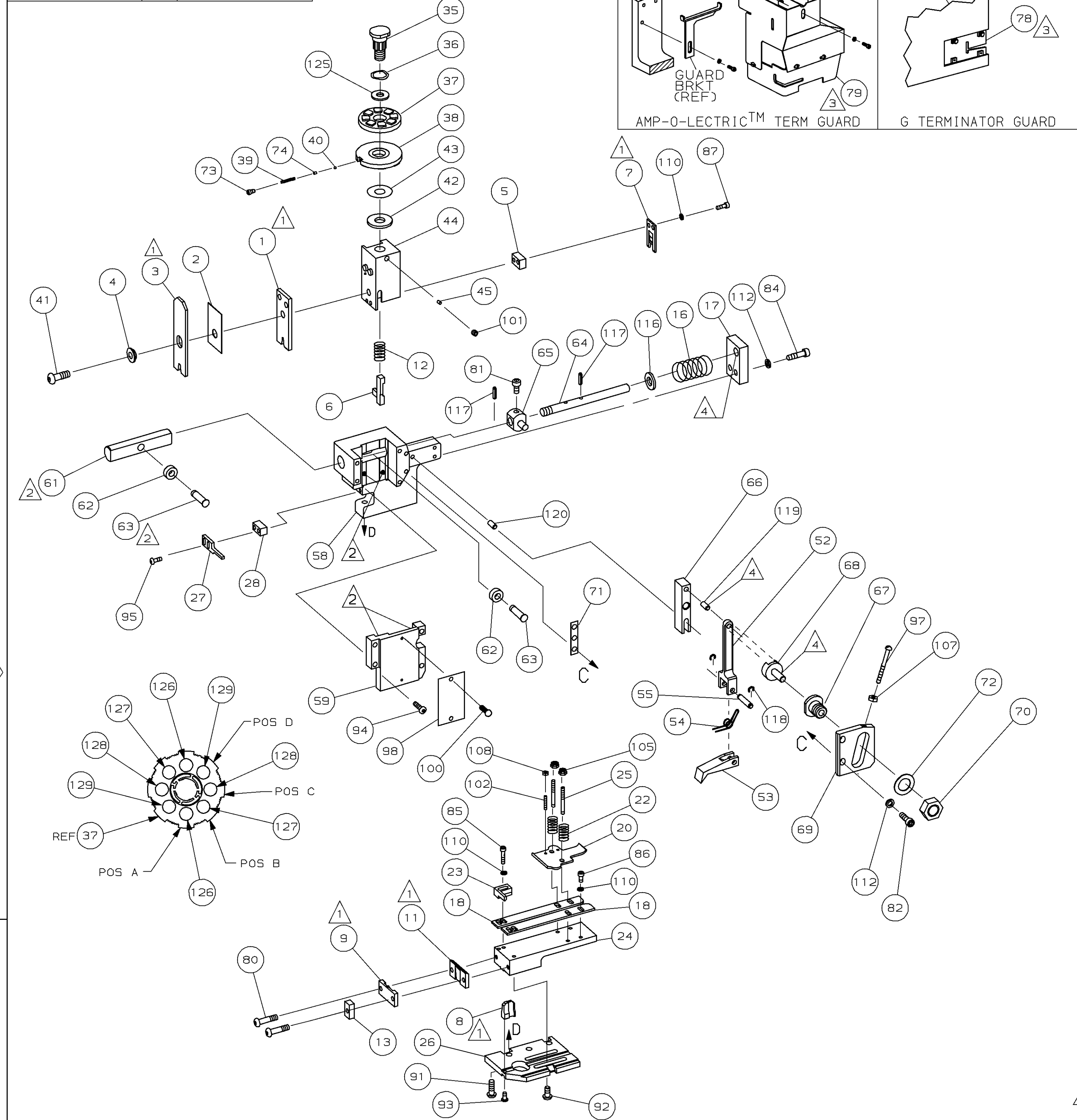
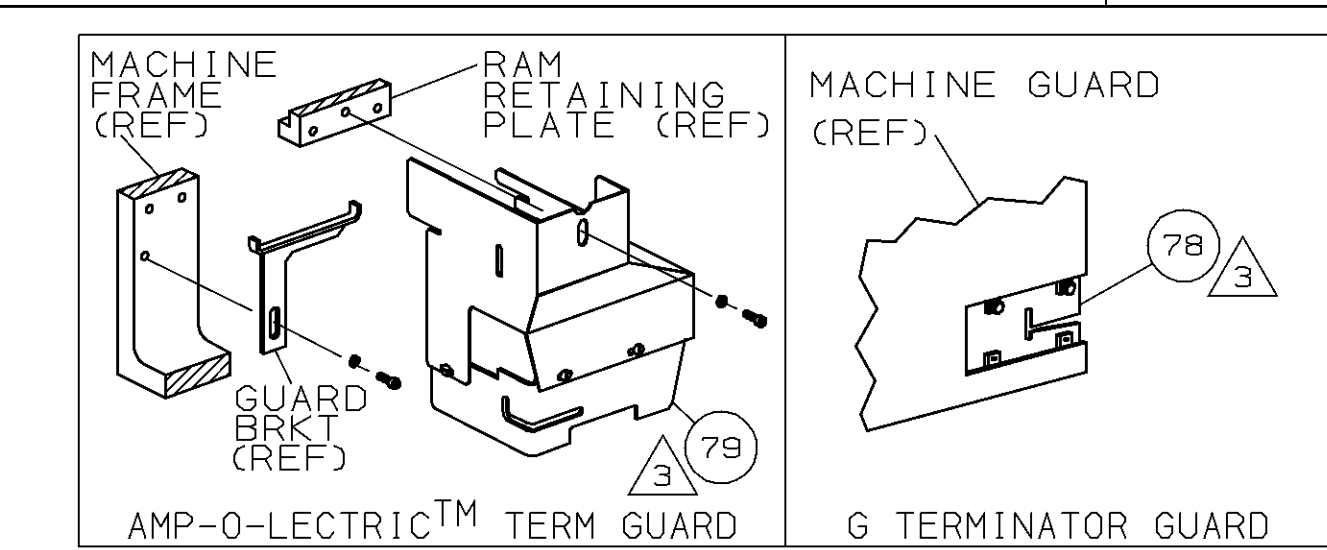


PART NUMBER	REV	FIRST USED
680577-1	A	122500-1
680577-2	A	565435-5



LOC A LEADMAKER
DIST 66
K TERMINATOR BENCH MACHINE
G TERMINATOR BENCH MACHINE



- 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.

680577 680577

TERMINAL NAME: LOW INSERTION FORCE FASTON™ TERMINAL					
346697					
CRIMP DATA (AMP TERMINAL)					
PAD LTR	CRIMP HEIGHT			WIRE SIZE	
A	.061 ±.002 [1.55 ±0.05mm]			16	
B	.058 ±.002 [1.47 ±0.05mm]			17	
C	.055 ±.002 [1.40 ±0.05mm]			18	
D	.051 ±.002 [1.30 ±0.05mm]			20	
CRIMP		SIZE	TYPE	RANGE	
WIRE		.100 [2.54mm]	F	20-16	
INSUL		.150 [3.81mm]	F	.087-.122	
WIRE STRIP LENGTH		TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE LAYOUT
.181-.200		114-3163	.845	408-8039	458638-1 L2030

2	2	-	C	2-354779-0	PIN, WIRE DISC (.3090)D	129
2	2	-	C	1-354779-2	PIN, WIRE DISC (.3050)C	128
2	2	-	C	354779-6	PIN, WIRE DISC (.3020)B	127
2	2	-	C	9-354778-9	PIN, WIRE DISC (.2990)A	126
1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	-	-	4088039	EF APPL INST 408-8039	123
						122
						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 6D 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	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
PARTS LIST					

-1	LEADMAKER & BENCH MODEL G			MECH POST FEED		
-2	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	240634-1	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	455674-1	RAM	44
1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	-	A	690124-9	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	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
						31
						30
						29
1	1	-	B	3-690451-2	SPACER, STRIPPER	28
1	1	-	A	240639-1	STRIPPER	27
REF	REF	-	C	455676-1	PLATE, BASE	26
2	2	-	A	22354-8	DRAG, STUD	25
1	1	-	B	455678-1	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	454204-3	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
1	1	-	C	690481-3	SPACER, HOLD DOWN	13
1	1	-	A	23846-1	SPRING, HOLD DOWN	12
1	1	-	B	240644-1	PLATE, REAR SHEAR	11
						10
1	1	-	B	690495-4	PLATE, FRONT SHEAR	9
1	1	-	D	9-683452-9	ANVIL	8
1	1	-	B	690474-3	BLADE, SLUG	7
1	1	-	D	2-455892-1	HOLD DOWN, TERMINAL	6
1	1	-	C	240641-4	SPACER, SLUG BLADE	5
1	1	-	B	238009-1	SPACER, BLOCK CRIMPER	4
1	1	-	C	1213077-5	CRIMPER, INSULATION	3
1	1	-	B	455888-8	SPACER, CRIMPER	2
1	1	-	C	456407-4	CRIMPER, WIRE	1

QTY REQD PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
PARTS LIST					
REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)					
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 CHARGE CODES R.015 MAX					
MATERIAL					
HT TR					
FIN					
DR L COLLINS 09JAN98 APP T.ELBIN 09JAN98					
CHK 09JAN98 REL - C. ERISMAN					
NAME END FEED HDM APPLICATOR MACHINE REF					
SCALE 1 OF 1					
DWG NO 680577					
SHEET 1 OF 1					
REV A					
CUSTOMER AND ASSEMBLY DRAWING					
RESTRICTED TO					

THIS DRAWING IS A CONTROLLED DOCUMENT.

THIS DRAWING IS UNPUBLISHED.
RELEASED FOR PUBLICATION
BY AMP INCORPORATED. ALL RIGHTS RESERVED.
COPYRIGHT 19
LOC A
DIST 66
AMP 3308 REV 3-92

680577

D

C

B

A

Mouser Electronics

Authorized Distributor

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

[TE Connectivity:](#)

[680577-2](#)