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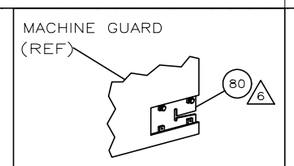
PART NUMBER	REV	FIRST USED
680194-3	B	354500-1



TERMINAL NAME: FLAG, RING & SPADE

RING	SPADE
42189	42187
42190	42188
42191	61902
42903	63053
63262	

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.072 ±.002 [1.83 ±0.05mm]	12
B	.062 ±.002 [1.57 ±0.05mm]	14
C	.056 ±.002 [1.42 ±0.05mm]	16
D	.052 ±.002 [1.32 ±0.05mm]	18

CRIMP	SIZE	TYPE	RANGE
WIRE	.160 [4.06mm]	TAB-LOCK	18-12
INSUL	.180 [4.57mm]	0	.110-.210

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.200-.231	114-2078	.480	408-8037	-	L1673

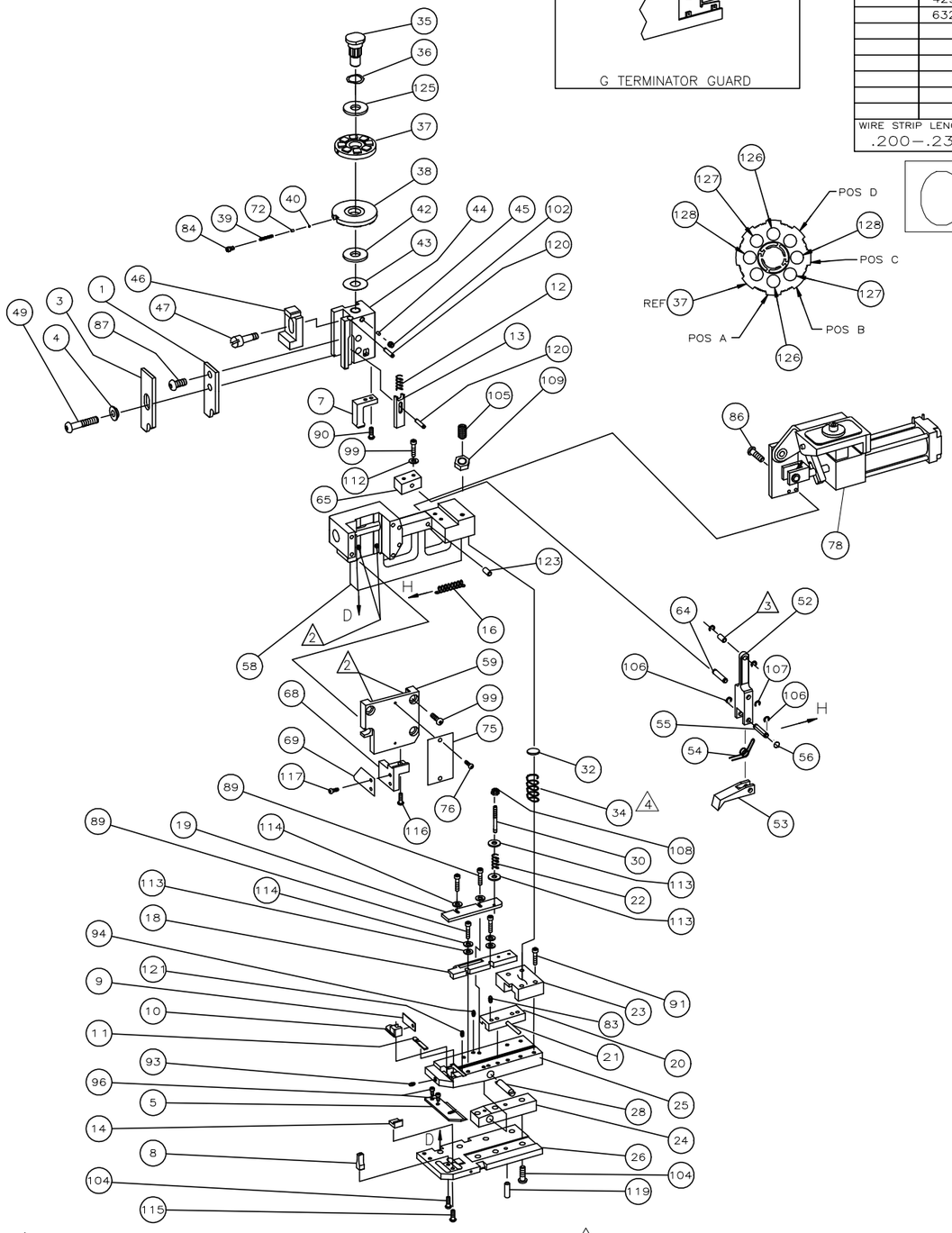
OBSOLETE

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	B	ECR-08-011943	5-2008	MY	GB
	B1	ECR-23-188833	060CT23	KPT	TE

-3 BENCH MODEL G AIR FEED



	-3	U/M	PART NO	DESCRIPTION	ITEM NO
					129
2	-		1-354779-8	PIN, WIRE DISC (.3080)D	129
2	-		1-354779-0	PIN, WIRE DISC (.3040)C	128
2	-		9-354778-8	PIN, WIRE DISC (.2985)B	127
2	-		7-354778-8	PIN, WIRE DISC (.2885)A	126
1	-		986950-1	WASHER, FLAT PRECISION	125
					124
1	-		3-22183-9	PIN, DOWEL (Ø.187X1.25)	123
					122
1	-		3-21028-2	PIN, SLOTTED SPRING (Ø.094X.25)	121
2	-		4-21028-9	PIN, SLOTTED SPRING (Ø.125X.38)	120
1	-		21029-5	PIN,SLOTTED SPRING (Ø.188X.75)	119
					118
2	-		1-21002-6	SCREW, SBHC (6-32 x .25) STOP	117
1	-		2-22603-1	SCREW, HEX (8-32 x .38) MTG	116
1	-		1-21000-4	SCREW, SHC (4-40 x .38) INSERT	115
2	-		21024-4	WASHER, LOCK (#4)	114
6	-		1-21899-3	WASHER,FLAT (8)	113
2	-		21024-5	WASHER, LOCK (#10)	112
					111
					110
1	-		1-22202-7	NUT, HEX (5/16-24)	109
2	-		21022-2	NUT,HEX (LOCKING) (8-32)	108
1	-		1-21986-2	RING,RET "E" Ø3/16	107
2	-		21045-3	RING,RET "C" Ø3/16	106
1	-		8-21007-5	SCREW,SKT SET(5/16-24x.75)	105
7	-		2-22733-8	SCREW, BHC (1/4-20X.63)	104
					103
1	-		21009-2	SCREW,SKT SET(1/4-20x.25)	102
					101
					100
6	-		3-21000-8	SCREW, SHC (10-32X.88)	99
					98
					97
2	-		7-21000-6	SCREW, SHC (10-32X.38)	96
					95
2	-		4-21006-0	SCREW, SKT SET (8-32X.25)	94
1	-		21061-9	SCREW, SKT SET (8-32X.25)	93
					92
4	-		2-21000-9	SCREW, SHC (8-32X.75)	91
2	-		1-23030-1	SCREW, SHC (NYLOK)(8-32X.62)	90
4	-		2-22603-3	SCREW, BHC (8-32X.62)	89
					88
1	-		2-21002-1	SCREW, BHC (8-32X.38)	87
2	-		21001-3	SCREW,SHC (1/4-20X.62)	86
					85
1	-		23030-1	SCREW, SHC(NYLOK)(6-32X.25)	84
2	-		3-21008-0	SCREW, SKT SET 6-32X.31,LOCWEL	83
					82
					81
REF	-		679532-1	INSERT, GUARD	80
					79
1	-		462622-2	AIR FEED ASSEMBLY	78
					77
2	-		21017-2	SCR,DRIVE(#2X.19)ID	76
1	-		461264-1	PLATE, IDENTIFICATION	75
					74
					73
1	-		690603-1	SPRING, ASSIST	72
					71

QTY REQD PER ASSY — PARTS LIST

	-3	U/M	PART NO	DESCRIPTION	ITEM NO
					70
1	-		318530-1	STOP, WIRE	69
1	-		318529-1	BLOCK, MOUNTING	68
					67
					66
1	-		456987-1	BLOCK, PIVOT	65
1	-		457058-1	PIN, PIVOT	64
					63
					62
					61
					60
1	-		318528-1	CAP, RAM	59
1	-		457079-1	HOUSING	58
					57
1	-		25745-1	RING, SPLIT	56
1	-		240624-1	PIN, FEED FINGER	55
1	-		691499-1	SPRING, FEED FINGER	54
1	-		454568-3	FINGER, FEED	53
1	-		457057-1	ARM, PIVOT	52
					51
					50
1	-		3-21002-5	BOLT, CRIMPER	49
					48
1	-		22353-8	SCREW, SHOULDER	47
1	-		690578-1	BLOCK, INSULATION ADJUST	46
1	-		690191-1	PLUG, NYLON	45
1	-		454574-1	RAM	44
1	-		690125-1	WASHER, LAMINATED	43
1	-		1-690124-1	WASHER, RAM	42
					41
1	-		23241-6	BALL, STEEL	40
1	-		690170-1	SPRING, COMPRESSION	39
1	-		690142-1	DISC, INSULATION	38
1	-		354777-1	WIRE DISC, PLASTIC	37
1	-		22480-5	WASHER, SPRING	36
1	-		690212-1	POST, RAM	35
1	-		3-23846-5	SPRING, HINGE BAR	34
					33
1	-		690573-1	SPACER, SPRING	32
					31
2	-		22354-8	STUD, DRAG	30
					29
1	-		690582-1	PIN, HINGE	28
-	-		-	-	27
1	-		684905-1	PLATE, BASE	26
1	-		354679-1	HINGE BAR	25
1	-		690571-1	BLOCK, STABILIZER	24
1	-		690585-1	BLOCK, PRESSURE	23
2	-		23470-8	SPRING, DRAG	22
1	-		21029-9	LEVER, DRAG	21
1	-		457093-4	DRAG, STOCK	20
1	-		454573-1	GUIDE, STRIP (REAR)	19
1	-		318739-1	GUIDE, STRIP (FRONT)	18
					17
1	-		2-22287-6	SPRING, FEED RETURN	16
					15
1	-		354678-1	INSERT, TERMINAL POSITIONER	14
1	-		455279-3	POSITIONER,TERMINAL	13
1	-		5-22280-5	SPRING,TERM. POSITIONER	12
1	-		454712-2	PLATE, REAR SHEAR	11
1	-		454709-1	ANVIL INSERT	10
1	-		690569-1	PLATE, FRONT SHEAR	9
1	-		690575-1	ANVIL	8
1	-		454572-1	BLADE, SLUG	7
-	-		-	-	6
1	-		684906-1	PLATE,ANVIL RETAINING	5
1	-		690574-1	SPACER,TUBULAR INSUL CRIMPER	4
1	-		690588-1	CRIMPER, INSULATION	3
-	-		-	-	2
1	-		690587-1	CRIMPER, WIRE	1

QTY REQD PER ASSY — PARTS LIST

1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. LUBRICATE DAILY USING NO. 20 MACHINE OIL.
4. 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.
5. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
6. ~~TO BE SHIPPED WITH ASSEMBLY.~~
7. POSITION ITEM 8 WITH BEVELED SIDE TO RECEPTACLE SIDE OF TERMINAL FOR WIRE SIZES 16 & 18 AWG. ROTATE ITEM 8 180 ° FOR WIRE SIZES 12 & 14 (REFER TO 6140-4).

THIS DRAWING IS A CONTROLLED DOCUMENT.

DRN	R O WILSON	9-20-95
CHK	C ERISMAN	9-21-95
APVD	A BEDDICK	9-22-95
PRODUCT SPEC	-	
APPLICATION SPEC	-	
WEIGHT	-	

DIMENSIONS: INCHES
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± - ; 1 PLC ± - ; 2 PLC ± - ; 3 PLC ± - ; 4 PLC ± - ; ANGLES ± -
MATERIAL -
FINISH -

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

NAME: END FEED HINGE BAR APPLICATOR - -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-680194	-

CUSTOMER DRAWING | SCALE - | SHEET 1 OF 1 | REV B1

4805 (1/08)

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