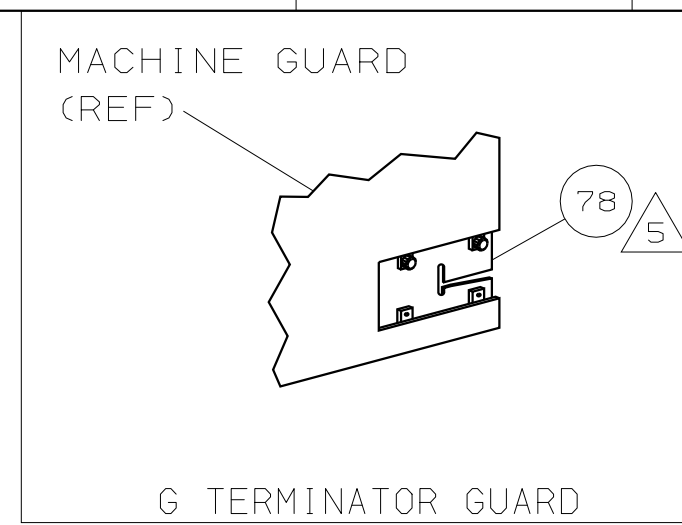


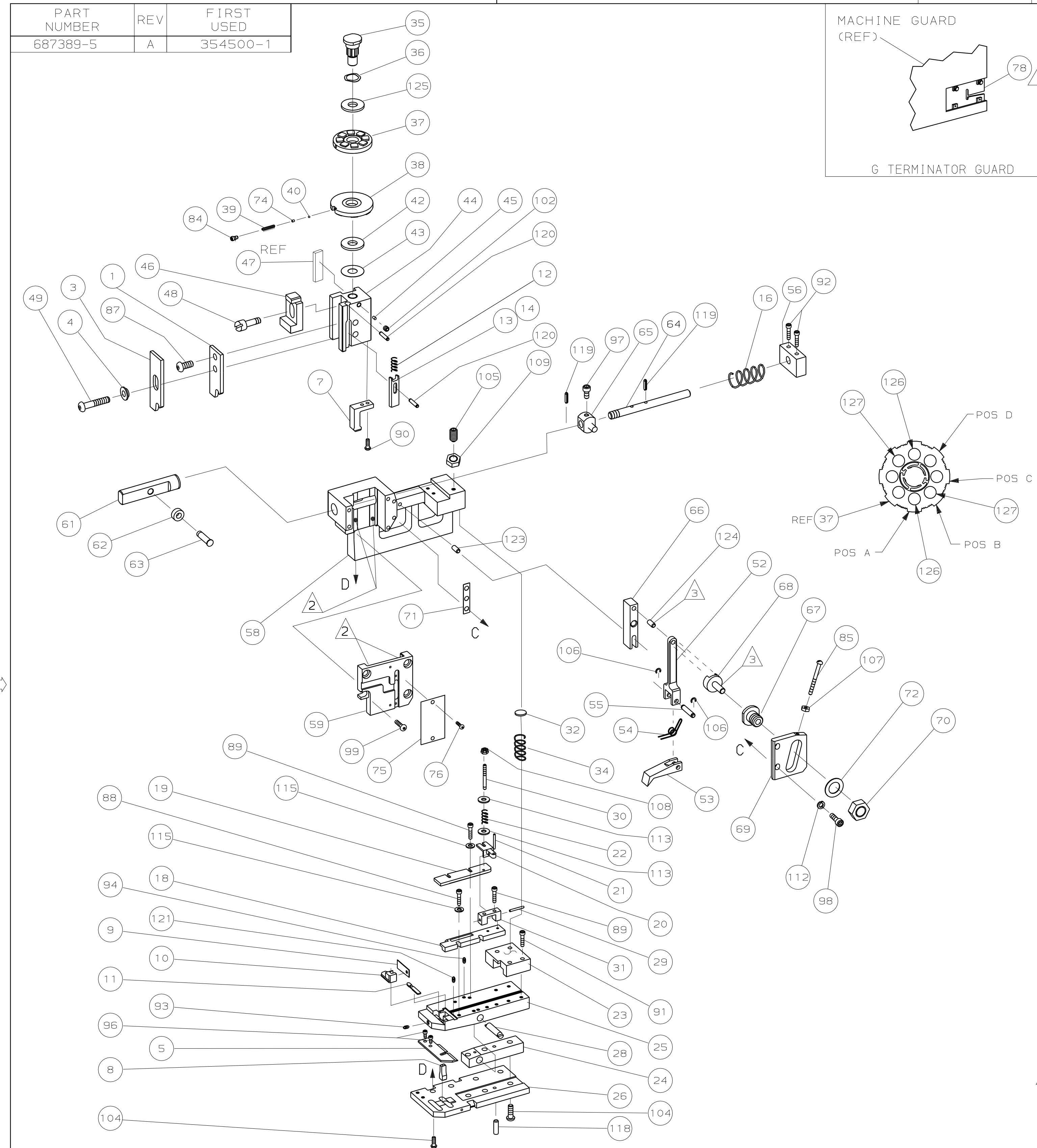
PART NUMBER	REV	FIRST USED
687389-5	A	354500-1



TERMINAL NAME:		CRIMPING DATA		
.250 FLAG FASTON RECEPTACLE		PAD LTR	CRIMP HEIGHT	WIRE SIZE
60851		A	.089±.002	10
42563		B	.075±.002	12
		C	NOT	USED
		D	NOT	USED
		CRIMP	SIZE	TYPE
		WIRE	.200	TAB LOCK
		INSUL	.220	0
		FEED	.770	APPL INST
			A1 8031	SET UP GAGE
				LAYOUT
				WIRE STRIP LENGTH

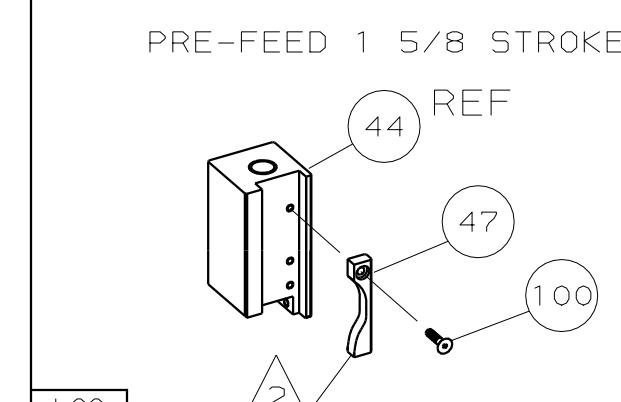
-5	BENCH MODEL	G	MECH	PRE FEED	
1	-	A	22594-8	NUT, HEX	70
1	-	B	240628-1	PLATE, ADJ	69
1	-	B	240626-1	SHAFT, PIVOT	68
1	-	B	240633-1	BUSHING	67
1	-	A	240630-1	LEVER, INTERMEDIATE	66
1	-	B	240629-1	BLOCK, PIVOT	65
1	-	A	240632-2	SCR, ADJ	64
1	-	B	240659-3	PIN, CAM ROLLER	63
1	-	B	240658-1	ROLLER, CAM	62
1	-	B	240631-1	ROD, FEED	61
					60
1	-	C	455164-1	CAP ASSEMBLY	59
1	-	D	455162-1	HOUSING	58
					57
1	-	B	458361-1	GUIDE, FEED ROD	56
1	-	B	240624-1	PIN, FEED FINGER	55
1	-	B	691499-1	SPRING, FEED FINGER	54
1	-	B	454568-1	FINGER, FEED	53
1	-	B	240634-1	LEVER, TERMINAL	52
					51
					50
1	-	A	3-21002-5	BOLT, CRIMPER	49
1	-	A	22353-8	SCREW, SHOULDER	48
1	-	B	453991-1	CAM, PRE-FEED 1 5/8 ST	47
1	-	A	690578-1	BLOCK, INSULATION ADJUST	46
1	-	A	690191-1	PLUG, NYLON	45
1	-	C	454574-1	RAM	44
1	-	A	690125-1	WASHER, LAMINATED	43
1	-	A	1-690124-1	WASHER, RAM	42
					41
1	-	A	23241-6	BALL, STEEL	40
1	-	A	690170-1	SPRING, COMPRESSION	39
1	-	C	690142-1	DISC, INSULATION	38
1	-	D	354777-1	WIRE DISC, PLASTIC	37
1	-	B	22480-5	WASHER, SPRING	36
1	-	B	690212-1	POST, RAM	35
1	-	A	3-23846-5	SPRING, HINGE BAR	34
					33
1	-	A	690573-1	SPACER, SPRING	32
1	-	C	454569-1	MOUNT, DRAG	31
1	-	A	1-22354-8	STUD, DRAG	30
1	-	A	21030-2	PIN, MOUNT, DRAG	29
1	-	B	690582-1	PIN, HINGE	28
					27
1	-	C	684905-1	PLATE, BASE	26
1	-	B	454579-2	HINGE BAR	25
1	-	B	690571-1	BLOCK, STABILIZER	24
1	-	C	690585-1	BLOCK, PRESSURE	23
1	-	A	8-22282-6	SPRING, DRAG	22
1	-	A	21030-6	LEVER, DRAG	21
1	-	A	454570-1	DRAG, STOCK	20
1	-	C	454573-1	GUIDE, STRIP (REAR)	19
1	-	C	454571-1	GUIDE, STRIP (FRONT)	18
					17
1	-	A	4-422284-9	SPRING, FEED RETURN	16
					15
1	-	C	1-692134-6	POSITIONER, TERMINAL	14
1	-	C	692134-6	POSITIONER, TERMINAL	13
1	-	A	5-22280-5	SPRING, TERM. POSITIONER	12
1	-	B	454711-1	PLATE, REAR SHEAR	11
1	-	C	454710-1	ANVIL INSERT	10
1	-	B	1-690569-1	PLATE, FRONT SHEAR	9
1	-	D	690761-1	ANVIL	8
1	-	B	454575-4	BLADE, SLUG	7
					6
1	-	B	684906-1	PLATE, ANVIL RETAINING	5
1	-	B	690574-1	SPACER, TUBULAR INSUL CRIMPER	4
1	-	C	690764-1	CRIMPER, INSULATION	3
					2
1	-	C	690763-2	CRIMPER, WIRE	1

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.



QTY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	-	C	7-354778-1	PIN, WIRE DISC (.2850)B	127
2	-	C	4-354778-3	PIN, WIRE DISC (.2710)A	126
1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	-	A	1-21030-2	PIN, DOWEL (Ø.187X.62)	124
1	-	A	1-21030-6	PIN, DOWEL (Ø.187X1.25)	123
					122
2	-	A	3-21028-2	PIN, SLOTTED SPRING (Ø.094X.25)	121
3	-	A	4-21028-9	PIN, SLOTTED SPRING (Ø.125X.38)	120
2	-	A	5-21028-1	PIN, SLOTTED SPRING (Ø.125X.50)	119
1	-	A	21029-5	PIN, SLOTTED SPRING (Ø.188X.75)	118
					117
					116
4	-	A	21024-4	WASHER, LOCK (#8)	115
2	-	A	21055-6	WASHER, FLAT (#8)	114
2	-	A	21899-2	WASHER, FLAT (#10)	113
2	-	A	21024-5	WASHER, LOCK (#10)	112
					111
					110
1	-	A	1-22202-7	NUT, HEX (5/16-24)	109
1	-	A	21022-3	NUT, HEX (LOCKING) (10-32)	108
1	-	A	21018-5	NUT, HEX (6-32)	107
2	-	A	21045-3	RING, RET "C" (Ø.187)FD PIN	106
1	-	A	8-21007-5	SCREW, SKT SET (5/16-24x.75)	105
7	-	A	2-22733-8	SCREW, BHC (1/4-20X.63)	104
					103
1	-	A	21009-2	SCREW, SKT SET (1/4-20x.25)	102
					101
1	-	A	1-21002-7	SCREW, BHC (6-32X.38)CAM	100
4	-	A	3-21000-8	SCREW, SHC (10-32X.88)	99
2	-	A	3-21000-6	SCREW, SHC (10-32X.62)	98
1	-	A	3-21000-4	SCREW, SHC (10-32X.38)	97
2	-	A	7-21000-6	SCREW, SHC (10-32X.31)	96
					95
2	-	A	4-21006-0	SCREW, SKT SET (8-32X.25)	94
1	-	A	21061-9	SCREW, SKT SET (8-32X.25)	93
2	-	A	3-21000-0	SCREW, SHC (8-32X.88)	92
4	-	A	2-21000-9	SCREW, SHC (8-32X.75)	91
2	-	A	1-23030-1	SCREW, SHC (NYLOK) (8-32X.62)	90
4	-	A	2-21000-8	SCREW, SHC (8-32X.62)	89
2	-	A	2-21000-7	SCREW, SHC (8-32X.50)	88
1	-	A	2-21002-1	SCREW, BHC (8-32X.38)	87
					86
1	-	A	6-23715-5	SCR, PAN HD (6-32x1.50)FEED ADJ	85
1	-	A	23030-1	SCREW, SHC (NYLOK) (6-32X.25)	84
					83
					82
					81
					80
					79
					78
REF	-	B	679532-1	INSERT, GUARD	77
					76
1	-	A	21017-2	SCR, DRIVE (2X .19)	75
1	-	B	461264-1	PLATE, IDENTIFICATION	74
1	-	A	690603-1	SPRING, ASSIST	73
					72
1	-	A	458109-1	WASHER, SPECIAL	71
1	-	A	690517-1	SPACER	70
					69
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- 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 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.

6 ITEMS 13 & 14 CAN BE CHANGED TO CENTER TAB IN SLOT WHILE CRIMPING.

LOC A
DIST 66
G TERMINATING UNIT BENCH MACHINE

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

DR	4-7-94	APP	4-7-94
M. O'BRINE		B. WOLFE	
CHK	4-7-94	REL	3/18/94
C. ERISMAN		B. MORGAN	

3 PLC DEC ±
4 PLC DEC ±
ANGLES ±
SURF TEXTURE: ✓
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

AMP INCORPORATED
HARRISBURG, PA 17105-3608

NAME: END FEED HINGE BAR APPLICATOR
MACHINE REF: MINI APPL
SCALE: -
DWG NO: 687389-5
SHEET: 1 OF 1
REV: A