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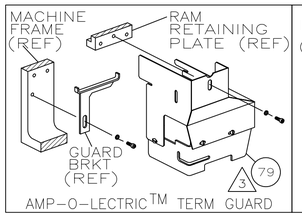
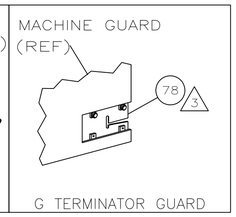
PART NUMBER	REV	FIRST USED
680411-1	D	122500-1
680411-2	D	565435-5
680411-3	E	354500-1



AMP-O-LECTRIC™ TERM GUARD

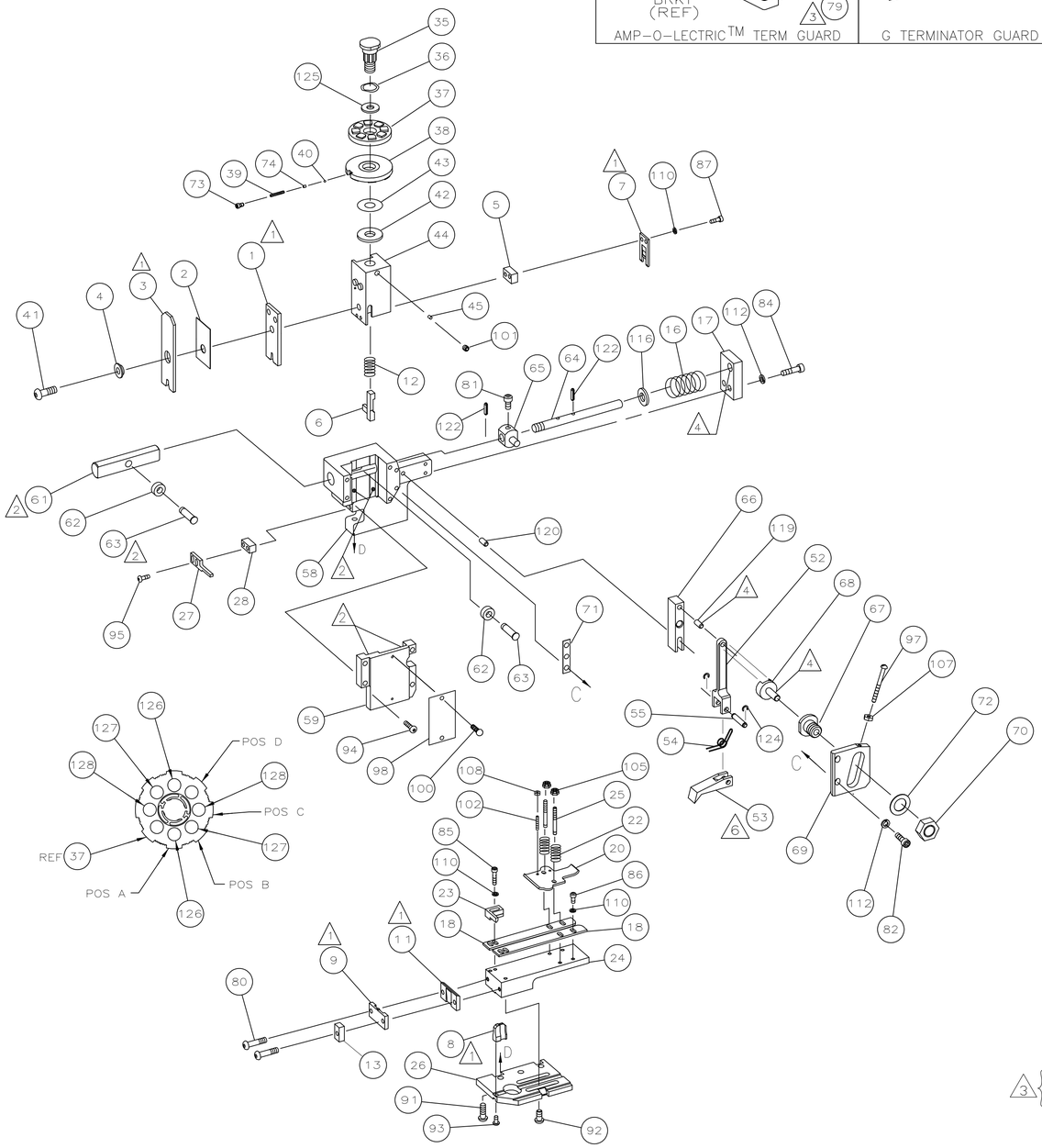


G TERMINATOR GUARD

TERMINAL NAME: POSITIVE LOCK RECEPTACLE 250 SERIES						
		63933	CRIMPING DATA			
			PAD LTR	CRIMP HEIGHT		WIRE SIZE
			A	.055 ±.002 [1.4 ±0.05mm]		18
			B	.053 ±.002 [1.35 ±0.05mm]		(2) 22
			C	.051 ±.002 [1.3 ±0.05mm]		20
			D	.048 ±.002 [1.22 ±0.05mm]		22
			CRIMP	SIZE	TYPE	RANGE
			WIRE	.090 [2.29mm]	F	22-18
			INSUL	.140 [3.56mm]	F	.060-.110
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT	
.173-.203	114-2074	.845	408-8039	458638-1	L1642	

LOC	DIST	P	LTR	REVISIONS DESCRIPTION	DATE	DWN	APVD
A	66		E1	ECR-09-009221	4-2009	MY	GB

-1	LEADMAKER	MECH POST FEED
-2	BENCH MODEL K	MECH PRE FEED
-3	BENCH MODEL G	MECH PRE FEED



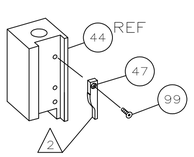
-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
2	2	2		3-354779-2	PIN, WIRE DISC (.3150)D	129
2	2	2	-	2-354779-6	PIN, WIRE DISC (.3120)C	128
2	2	2	-	2-354779-2	PIN, WIRE DISC (.3100)B	127
2	2	2	-	1-354779-8	PIN, WIRE DISC (.3080)A	126
1	1	1	-	986950-1	WASHER, FLAT PRECISION	125
REF	REF	REF	-	21045-3	RING,RET"C"(Ø.187)FD PIN	124
						123
REF	REF	REF	-	5-21028-1	PIN,STD SPRING(Ø.12)FD ADJ ROD	122
						121
REF	REF	REF	-	1-21030-7	PIN,DOWEL(Ø.187x1.50)HSG	120
REF	REF	REF	-	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	119
						118
						117
REF	REF	REF	-	21899-4	WASHER,FLAT(Ø5/16)SCR ADJ	116
						115
						114
						113
REF	REF	REF	-	21024-5	WASHER,LOCK(NO.10)FD ROD GDE	112
						111
7	7	7	-	21024-4	WASHER,LOCK(NO.8)SHEAR BL	110
						109
2	2	2	-	21018-4	NUT,HEX(4-40)DRAG	108
REF	REF	REF	-	21018-5	NUT,HEX(6-32)FD ADJ PL	107
						106
2	2	2	-	21022-2	NUT,HEX SL(8-32)DRAG STUD	105
						104
						103
2	2	2	-	2-21006-6	SCR,SKT SET(4-40x.62)DRAG	102
1	1	1	-	21009-2	SCR,SKT SET(1/4-20x.25)RAM	101
2	2	2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE	100
1	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	99
1	1	1	-	461264-1	PLATE, IDENTIFICATION	98
REF	REF	REF	-	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	97
						96
2	2	2	-	2-21002-2	SCR,BHC(8-32x.50)STRIPPER	95
REF	REF	REF	-	2-21002-9	SCR,BHC(10-32x.75)HSG CAP	94
1	1	1	-	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	93
4	4	4	-	3-21002-3	SCR,BHC(1/4-20x.50)ST GD PL	92
REF	REF	REF	-	2-22733-8	SCR,BHC(1/4-20x.62)BASE PL	91
						90
						89
						88
2	2	2	-	2-21000-7	SCR,SHC(8-32x.50)SLUG BLADE	87
3	3	3	-	2-21000-6	SCR,SHC(8-32x.38)STRIP GUIDE	86
2	2	2	-	2-21000-8	SCR,SHC(8-32x.62)R STRIP GUIDE	85
REF	REF	REF	-	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GDE	84
						83
REF	REF	REF	-	3-21000-6	SCR,SHC(10-32x.62)FEED ADJ PL	82
REF	REF	REF	-	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLOCK	81
2	2	2	-	3-21002-0	SCR,BHC(10-32x.88)SHEAR PL	80
-	REF	-	-	455745-1	GUARD, WINDOW	79
REF	-	-	-	679532-1	INSERT, GUARD	78
						77
						76
						75
1	1	1	-	690603-1	SPRING, ASSIST	74
1	1	1	-	23030-1	SCR,SKT CAP(6-32x.25)CP DSC	73
REF	REF	REF	-	458109-1	WASHER, FLAT (SPECIAL)	72
REF	REF	REF	-	690517-1	SPACER	71

QTY REQD PER ASSY — PARTS LIST

-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
REF	REF	REF	-	22594-8	NUT, HEX	70
REF	REF	REF	-	240628-1	PLATE, ADJ	69
REF	REF	REF	-	240626-1	SHAFT, PIVOT	68
REF	REF	REF	-	240633-1	BUSHING	67
REF	REF	REF	-	455680-1	LEVER, INTERMEDIATE	66
REF	REF	REF	-	240629-1	BLOCK, PIVOT	65
REF	REF	REF	-	240632-2	SCR, ADJ	64
REF	REF	REF	-	240659-3	PIN, CAM ROLLER	63
REF	REF	REF	-	240658-1	CAM, ROLLER	62
REF	REF	REF	-	454398-1	ROD, FEED	61
						60
REF	REF	REF	-	454220-1	CAP, RAM	59
REF	REF	REF	-	453736-1	HOUSING	58
						57
						56
REF	REF	REF	-	240624-1	PIN, FEED FINGER	55
REF	REF	REF	-	691499-1	SPRING, FEED FINGER	54
REF	REF	REF	-	240635-1	FINGER, FEED	53
REF	REF	REF	-	240634-1	LEVER, TERMINAL	52
						51
						50
1	-	-	-	690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	1	-	-	690602-5	CAM, PRE-FEED 1 1/8 ST	48
-	-	1	-	690501-4	CAM, POST-FEED 1 5/8 ST	47
						46
1	1	1	-	690191-1	PLUG, NYLON	45
1	1	1	-	455674-1	RAM	44
1	1	1	-	690125-1	WASHER, LAMINATED	43
1	1	1	-	690124-1	WASHER, RAM	42
1	1	1	-	7-21002-9	BOLT, CRIMPER(5/16-24x1.00)	41
1	1	1	-	23241-6	BALL, STEEL	40
1	1	1	-	690170-1	SPRING, COMPRESSION	39
1	1	1	-	690142-1	DISC, INSULATION	38
1	1	1	-	354777-1	WIRE DISC, PLASTIC	37
1	1	1	-	22480-5	WASHER, SPRING	36
1	1	1	-	690212-1	POST, RAM	35
						34
						33
1	1	1	-	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
						31
						30
						29
1	1	1	-	3-690451-2	SPACER, STRIPPER	28
1	1	1	-	240639-1	STRIPPER	27
REF	REF	REF	-	455676-1	PLATE, BASE	26
2	2	2	-	22354-8	DRAG, STUD	25
1	1	1	-	455678-1	PLATE, STRIP GUIDE	24
1	1	1	-	240825-7	PLATE, STRIP HOLD DOWN	23
2	2	2	-	4-22281-1	SPRING, DRAG	22
						21
1	1	1	-	454177-1	DRAG, STOCK	20
						19
2	2	2	-	454204-3	GUIDE, STRIP (FRONT)	18
REF	REF	REF	-	454178-1	GUIDE, FEED ROD	17
REF	REF	REF	-	4-22284-9	SPRING, FEED RETURN	16
						15
						14
1	1	1	-	1-690481-1	SPACER, HOLD DOWN	13
1	1	1	-	23846-1	SPRING, HOLD DOWN	12
1	1	1	-	240644-1	PLATE, REAR SHEAR	11
						10
1	1	1	-	690482-8	PLATE, FRONT SHEAR	9
1	1	1	-	1-356038-5	ANVIL	8
1	1	1	-	2-690474-1	BLADE, SLUG	7
1	1	1	-	2-455892-1	HOLD DOWN, TERMINAL	6
1	1	1	-	2-240641-9	SPACER, SLUG BLADE	5
1	1	1	-	238009-4	SPACER, BLOCK CRIMPER	4
1	1	1	-	3-683453-1	CRIMPER, INSULATION	3
1	1	1	-	1-455888-0	SPACER, CRIMPER	2
1	1	1	-	4-456406-4	CRIMPER, WIRE	1

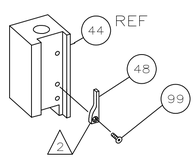
QTY REQD PER ASSY — PARTS LIST

POST-FEED 1 5/8 STROKE



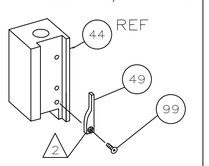
LEADMAKER

PRE-FEED 1 1/8 STROKE



K TERMINATOR BENCH MACHINE

PRE-FEED 1 5/8 STROKE



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. FEED TERMINAL ON INSULATION BARREL.

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± - ; 1 PLC ± - ; 2 PLC ± - ; 3 PLC ± - ; 4 PLC ± - ; ANGLES ± -

MATERIAL -

FINISH -

DWN P.MATHIAS 1-2-97
CHK C. ERISMAN 1-2-97
APVD T. ELBIN 1-2-97

PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

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

NAME: END FEED HDM APPLICATOR

SIZE A1 | CAGE CODE 00779 | DRAWING NO C-680411 | RESTRICTED TO -

CUSTOMER DRAWING | SCALE - | SHEET 1 OF 1 | REV E1

4805 (1/08)

23APR2009 11:14am