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| PART NUMBER | REV | FIRST USED | POWER UNIT | FEED TYPE | |
| 680588-3 | F | 354500-1 | BENCH MODEL G | AIR FEED | |

- 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 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.
- 6 SELECT TERMINAL POSITIONER AS REQUIRED TO KEEP TERMINAL ON CENTER OF ANVIL. FASTEN EXTRA TERMINAL POSITIONER TO APPLICATOR. (REFER TO AMP FORM 6140-4)
- 7 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 8 APPLY LOCKTITE P/N 1-23419-5 TO ITEM 93 AT ASSEMBLY.

| TERMINAL NAME: RECEPTACLE, FLAG, FASTON, .250 SERIES | | | | | | |
|--|-----------|--------------------------------|--------------|-----------|-----------|--------|
| - | 42234 | AMP TERMINAL - AMP CRIMP SPECS | | | | |
| - | 42459 | | | | | |
| - | 60195 | PAD LTR | CRIMP HEIGHT | WIRE SIZE | Ø | SOLDER |
| - | 60643 | A | .065±.002 | 14 | - | - |
| - | 62354 | B | .061±.002 | 16 | - | - |
| - | 63635 | C | .058±.002 | 18 | - | - |
| - | 1742595-1 | D | .056±.002 | 20 | - | - |
| - | - | CRIMP | SIZE | TYPE | RANGE | |
| - | - | WIRE | .140 | TAB LOC | 20-14 | |
| - | - | INSUL | .170 | O | .110-.170 | |
| WIRE STRIP LENGTH .205-.235 | | | | | | |
| TERM APPL SPEC 114-2078 | | | | | | |
| FEED .650 | | | | | | |
| APPL INSTRUCTIONS 408-8031 | | | | | | |
| SET UP GAGE - | | | | | | |
| LAYOUT - | | | | | | |

| LOC | DIST | REVISIONS | | | | | |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | E | | ECR-07-006533 | 27MAR2007 | BW | TE |
| | | E1 | | ECR-07-017988 | 01AUG2007 | MY | TM |
| | | E2 | | ECR-14-002580 | 24FEB2014 | YY | UG |
| | | F | | ECR-17-015089 | 12OCT2017 | RS | LZ |

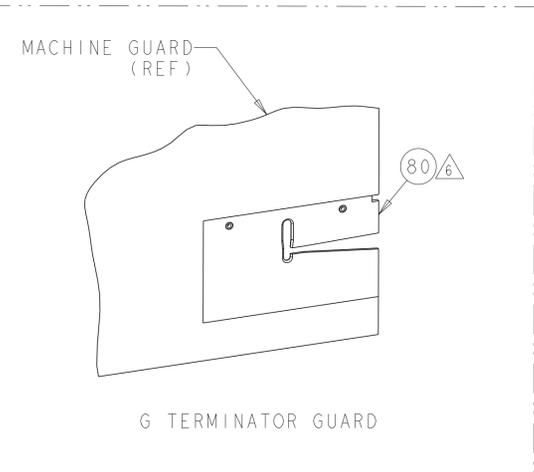
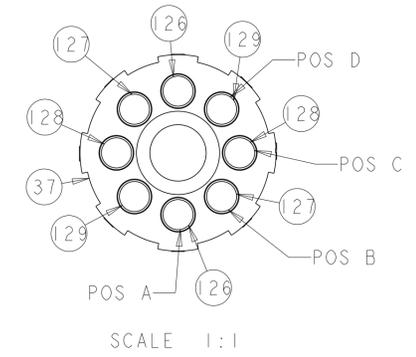
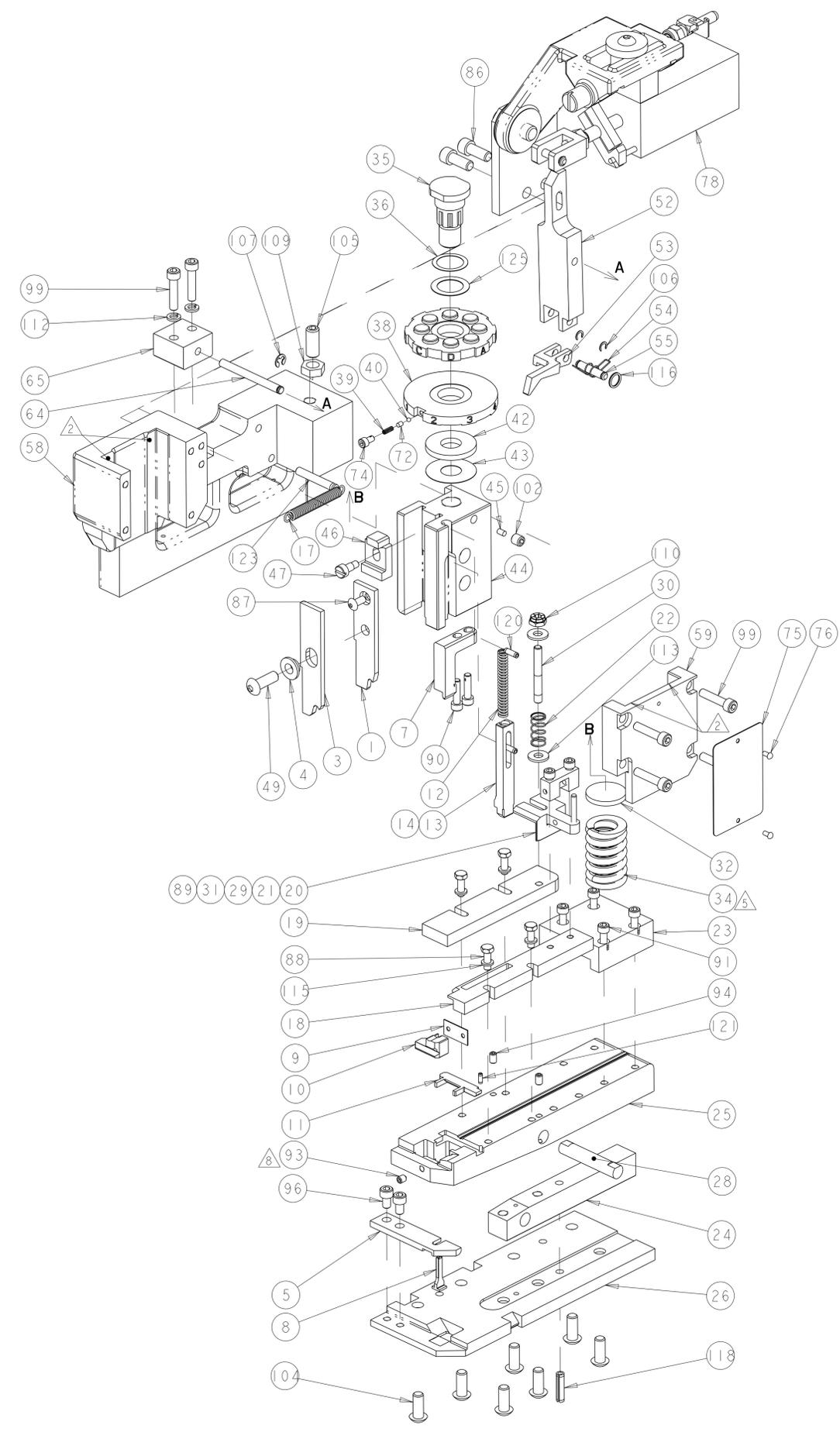
| | | | | |
|-----|-----|-----------|--------------------------------------|---------|
| 4 | - | 2-22603-3 | SCR, HEX HD CAP, 1IN | 88 |
| 1 | - | 2-21002-1 | SCR, BTN SKT HD CAP 8-32 X .375 | 87 |
| 2 | - | 21001-3 | SCR, SKT HD CAP 1/4-20 X .625 | 86 |
| REF | ... | 679532-1 | INSERT, GUARD | 80 |
| 1 | - | 462622-2 | AIR FEED ASSEMBLY | 78 |
| 2 | - | 21017-2 | SCREW, DRIVE | 76 |
| 1 | - | 461264-1 | PLATE, IDENTIFICATION | 75 |
| 1 | - | 23030-1 | SCR, SKT HD CAP, S-LOCK, 6-32 X .25 | 74 |
| 1 | - | 690603-1 | SPRING ASSIST AMP-O-MATOR APPLICATOR | 72 |
| 1 | - | 456987-1 | BLOCK, PIVOT | 65 |
| 1 | - | 457058-1 | PIN, PIVOT | 64 |
| 1 | - | 455164-1 | CAP, RAM | 59 |
| 1 | - | 457079-1 | HOUSING, MACHINING | 58 |
| 1 | - | 240624-1 | PIN, FEED FINGER | 55 |
| 1 | - | 691499-1 | SPRING-FEED FINGER | 54 |
| 1 | - | 454568-2 | FINGER, FEED | 53 |
| 1 | - | 457057-1 | PIVOT ARM | 52 |
| 1 | - | 3-21002-5 | SCR, BTN SKT HD CAP 1/4-20 X .750 | 49 |
| 1 | - | 22353-8 | SCR, SHLD, SLOT HD, 3/16 DIA | 47 |
| 1 | - | 690578-1 | INSULATION ADJUST BLOCK | 46 |
| 1 | - | 690191-1 | PLUG, NYLON | 45 |
| 1 | - | 454574-1 | RAM, SPECIAL | 44 |
| 1 | - | 690125-1 | SHIM SUB-ASSY | 43 |
| 1 | - | 690124-4 | WASHER, RAM (.135) | 42 |
| 1 | - | 23241-6 | BALL, STEEL | 40 |
| 1 | - | 690170-1 | SPRING, COMPRESSION | 39 |
| 1 | - | 690142-1 | DISC, INSULATION | 38 |
| 1 | - | 354777-1 | WIRE DISC, ASSEMBLY | 37 |
| 1 | - | 22480-5 | WASHER, WAVE SPRING | 36 |
| 1 | - | 690212-1 | POST, RAM | 35 |
| 1 | - | 3-23846-5 | SPRING, DIE | 34 |
| 1 | - | 690573-1 | SPACER, SPRING | 32 |
| 1 | - | 454569-1 | MOUNT, DRAG | 31 |
| 1 | - | 1-22354-8 | STUD, THREADED | 30 |
| 1 | - | 21030-2 | PIN, DOWEL .1250 X .500 | 29 |
| 1 | - | 690582-1 | PIN, HINGE | 28 |
| 1 | - | 684905-1 | PLATE, BASE | 26 |
| 1 | - | 454579-2 | BAR, HINGE | 25 |
| 1 | - | 690571-1 | STABILIZER | 24 |
| 1 | - | 690585-1 | BLOCK, SPRING PRESSURE | 23 |
| 1 | - | 22282-5 | SPRING, COMPRESSION | 22 |
| 1 | - | 21030-6 | PIN, DOWEL .1250 X 1.000 | 21 |
| 1 | - | 454570-1 | DRAG, STOCK | 20 |
| 1 | - | 454573-1 | GUIDE, STRIP, REAR | 19 |
| 1 | - | 454571-2 | GUIDE, FRONT STRIP | 18 |
| 1 | - | 2-22287-6 | SPRING, EXTENSION | 17 |
| 1 | - | 692134-7 | POSITIONER, TERMINAL | 14 |
| 1 | - | 692134-2 | TERMINAL POSITIONER | 13 |
| 1 | - | 5-22280-5 | SPRING, COMPRESSION | 12 |
| 1 | - | 454712-4 | PLATE, REAR SHEAR | 11 |
| 1 | - | 454578-1 | ANVIL INSERT | 10 |
| 1 | - | 690569-3 | PLATE, SHEAR, FRONT | 9 |
| 1 | - | 690718-1 | ANVIL, REVERSIBLE | 8 |
| 1 | - | 454575-3 | BLADE, SHEAR | 7 |
| 1 | - | 684906-1 | ANVIL RETAINING | 5 |
| 1 | - | 690574-1 | SPACER, TUBULAR | 4 |
| 1 | - | 690588-1 | CRIMPER, INSULATION PREMIUM | 3 |
| 1 | - | 690716-3 | CRIMPER, WIRE PREMIUM | 1 |
| -3 | U/M | PART NO | DESCRIPTION | ITEM NO |

| | | | | |
|---|---|------------|--|-----|
| 2 | - | 2-354779-9 | PIN, WIRE DISC (.3135) | 129 |
| 2 | - | 2-354779-8 | PIN, WIRE DISC (.3130) | 128 |
| 2 | - | 2-354779-4 | PIN, WIRE DISC (.3110) | 127 |
| 2 | - | 1-354779-8 | PIN, WIRE DISC (.3080) | 126 |
| 1 | - | 986950-1 | WASHER, FLAT PRECISION | 125 |
| 1 | - | 4-22183-0 | PIN, GROOVED, TYPE 67 | 123 |
| 1 | - | 3-21028-2 | PIN, SLOTTED SPRING .094 X .250 | 121 |
| 2 | - | 4-21028-9 | PIN, SLOTTED SPRING .125 X .375 | 120 |
| 1 | - | 21029-5 | PIN, SLOTTED SPRING .188 X .750 | 118 |
| 1 | - | 25745-1 | RING, SPLIT | 116 |
| 4 | - | 21024-4 | WASHER, SPRG LOCK, REG NO 8 | 115 |
| 2 | - | 21899-2 | WASHER, FLAT | 113 |
| 2 | - | 21024-5 | WASHER, SPRG LOCK, REG NO 10 | 112 |
| 1 | - | 21022-3 | NUT, HEX, SELF-LOCKING, THIN, 10-32 | 110 |
| 1 | - | 1-22202-7 | NUT, HEX, JAM 5/16-24/UNF | 109 |
| 1 | - | 1-21986-2 | RING, RETAIN, EXTERN, 3/16 E-RING | 107 |
| 2 | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 106 |
| 1 | - | 8-21007-5 | SCR, SET, CUP POINT 5/16-24 X .750 | 105 |
| 7 | - | 2-22733-8 | SCR, BHSC, SELF-LOCKING, 1/4-20 X .625 | 104 |
| 1 | - | 21009-2 | SCR, SET, SELF LOCKING 1/4-20 X .250 | 102 |
| 6 | - | 3-21000-8 | SCR, SKT HD CAP 10-32 X .875 | 99 |
| 2 | - | 7-21000-6 | SCR, SKT HD CAP 10-32 X .312 | 96 |
| 2 | - | 4-21008-0 | SCR, SET, SELF LOCKING 1/4-20 X .250 | 94 |
| 1 | - | 21061-9 | SCR, SET, CONE POINT 8-32 X .250 | 93 |
| 4 | - | 2-21000-9 | SCR, SKT HD CAP 8-32 X .750 | 91 |
| 2 | - | 1-23030-1 | SCR, SKT HD CAP, S-LOCK, 8-32 X .625 | 90 |
| 2 | - | 2-21000-8 | SCR, SKT HD CAP 8-32 X .625 | 89 |

| | | | | | | | | | | | |
|-------------|--|--|--|--------------------------|--|-------------------------|--|--------------------------|--|---|--|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: B. WEAVER 07FEB2007 | | CHK: T. ELBIN 07FEB2007 | | APVD: T. ELBIN 07FEB2007 | | NAME: APPLICATOR, HINGE BAR, .205 FLAG FASTON | |
| IN | | 0 PLC ± | | APPLICATOR SPEC | | SIZE: A100779 | | CAGE CODE: C=680588 | | DRAWING NO: 680588 | |
| MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: 1:1 | | SHEET: 1 OF 2 | | REV: F | |

Customer Accessible Production Drawing

| LOC | | DIST | | REVISIONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LTH | DESCRIPTION | DATE | DWN | APVD |
| | | - | | SEE SHEET 1 | | | |
| | | | | | | | |
| | | | | | | | |



| | | | | | | | | | | | |
|-------------------|--|---|--|--|--|--|--|--|--|--------------------|--|
| DIMENSIONS: IN | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±. FINISH | | DWN B. WEAVER 07FEB2007 CHK T. ELBIN 07FEB2007 APVD T. ELBIN 07FEB2007 | | NAME APPLICATOR, HINGE BAR, .205 FLAG FASTON | | SIZE CAGE CODE DRAWING NO A 100779 C=680588 | | RESTRICTED TO - | |
| MATERIAL: | | FINISH: | | WEIGHT: | | SCALE 3:5 | | SHEET 2 OF 2 | | REV F | |

CUSTOMER VIEWABLE ASSEMBLY

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- Техническую поддержку проекта.
- Защиту от снятия компонента с производства.
- Оценку стоимости проекта по компонентам.
- Изготовление тестовой платы монтаж и пусконаладочные работы.



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