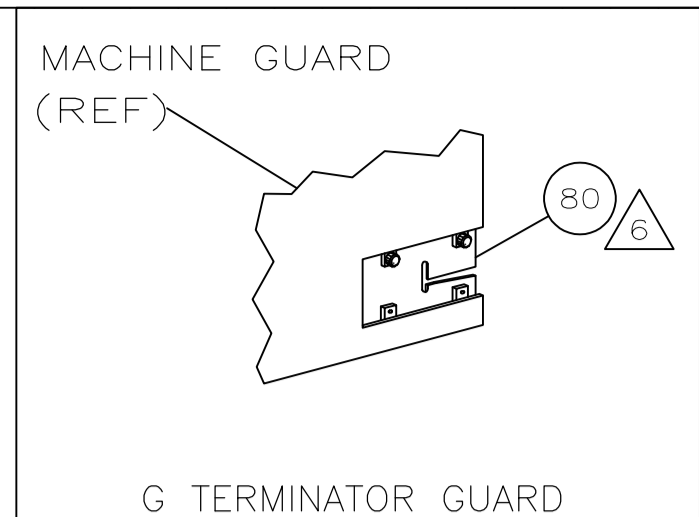


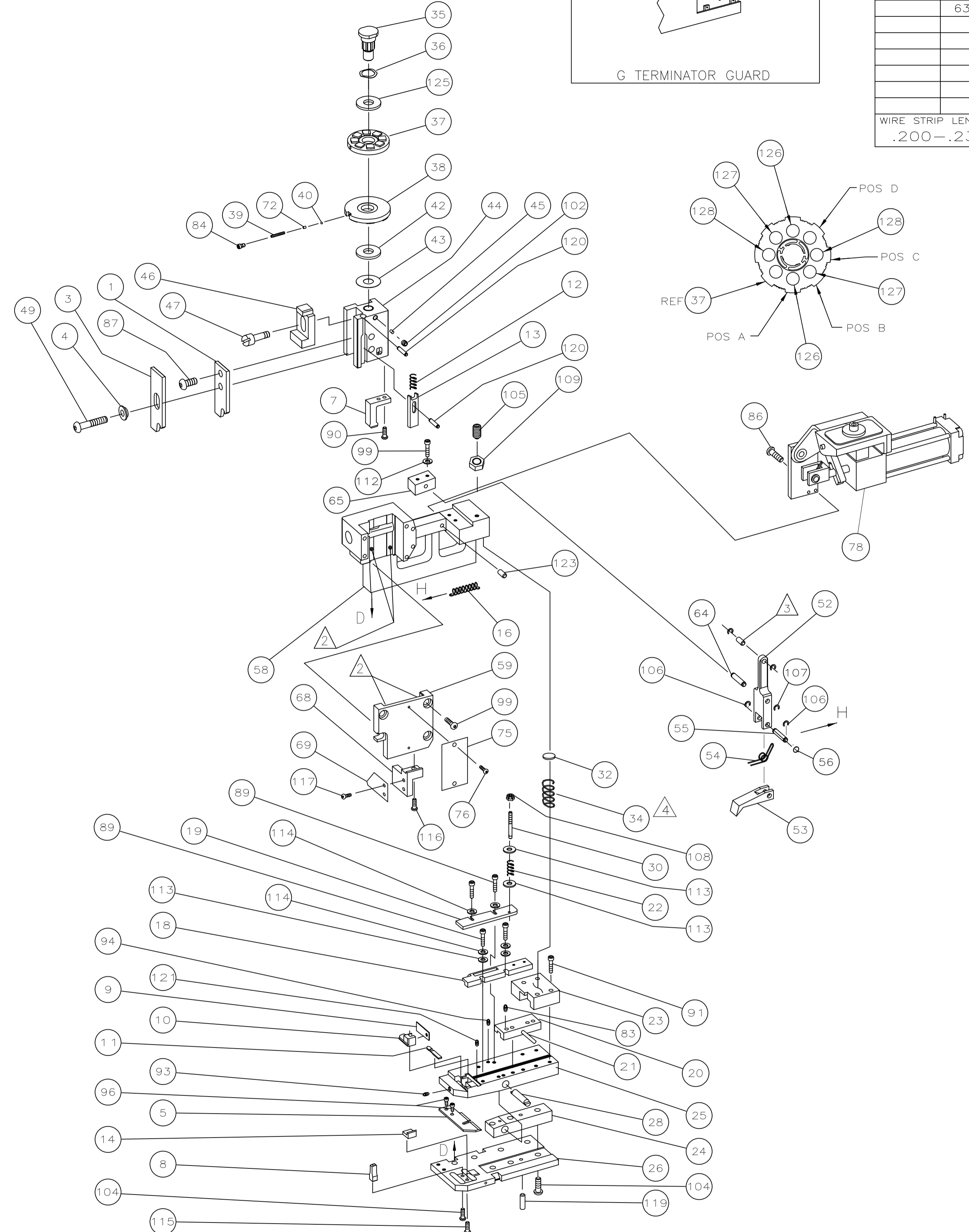
PART NUMBER	REV	FIRST USED
680194-3	B	354500-1



RING		SPADE		CRIMPING DATA		
42189	42187	42189	42187	CRIMP HEIGHT		WIRE SIZE
42190	42188	42190	42188	A	.072 ±.002 [1.83 ±0.05mm]	12
42191	61902	42191	61902	B	.062 ±.002 [1.57 ±0.05mm]	14
42903	63053	42903	63053	C	.056 ±.002 [1.42 ±0.05mm]	16
63262		63262		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	

LOC	DIST	REVISIONS			
A	66	REV	DESCRIPTION	DATE	BY
		B	ECR-08-011943	5-2008	MY

-3 BENCH MODEL G AIR FEED



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
5	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

					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

- 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.
- 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).

QTY REQD PER ASSY	U/M	PART NO	DESCRIPTION	ITEM NO
			PARTS LIST	

QTY REQD PER ASSY	U/M	PART NO	DESCRIPTION	ITEM NO
			PARTS LIST	

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES	TOLERANCES UNLESS OTHERWISE SPECIFIED:	REV	DATE	BY
0. PLC ±.005	1. PLC ±.002	1	9-20-95	R O WILSON
2. PLC ±.001	3. PLC ±.0005	2	9-21-95	C FRISMAN
4. PLC ±.0002	ANGLES ±.005	3	9-22-95	A BEDDICK

APPROVED: A BEDDICK

TYCO ELECTRONICS CORPORATION, HARRISBURG, PA 17105-3608

END FEED HINGE BAR APPLICATOR

SIZE: A1, CASE CODE: 00779, DRAWING NO: 680194

CUSTOMER DRAWING, SCALE: 1:1, SHEET 1 OF 1, REV B