THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION – ,– .
© COPYRIGHT – BY TYCO ELECTRONICS CORPORATION. ALL INTERNATIONAL RIGHTS RESERVED.

PART NUMBER	REV	FIRST USED
680176 – 1	E	122500–1
680176 – 2	E	565435–5

TERMINAL NAME: .187 FLAG FASTON ™ RECEPTACLE

60755
62435
63848

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.053 ±.002 [1.35 ±0.05mm]	16
B	.046 ±.002 [1.17 ±0.05mm]	18
C	.041 ±.002 [1.04 ±0.05mm]	20
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.090 [2.29mm]	F	20–16
INSUL	.140 [3.56mm]	F	.090–.130

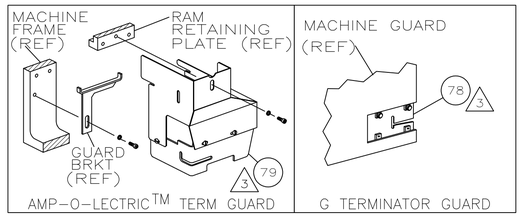
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.173–.203	114–2079	.525	408–8039	458638–1	L1656

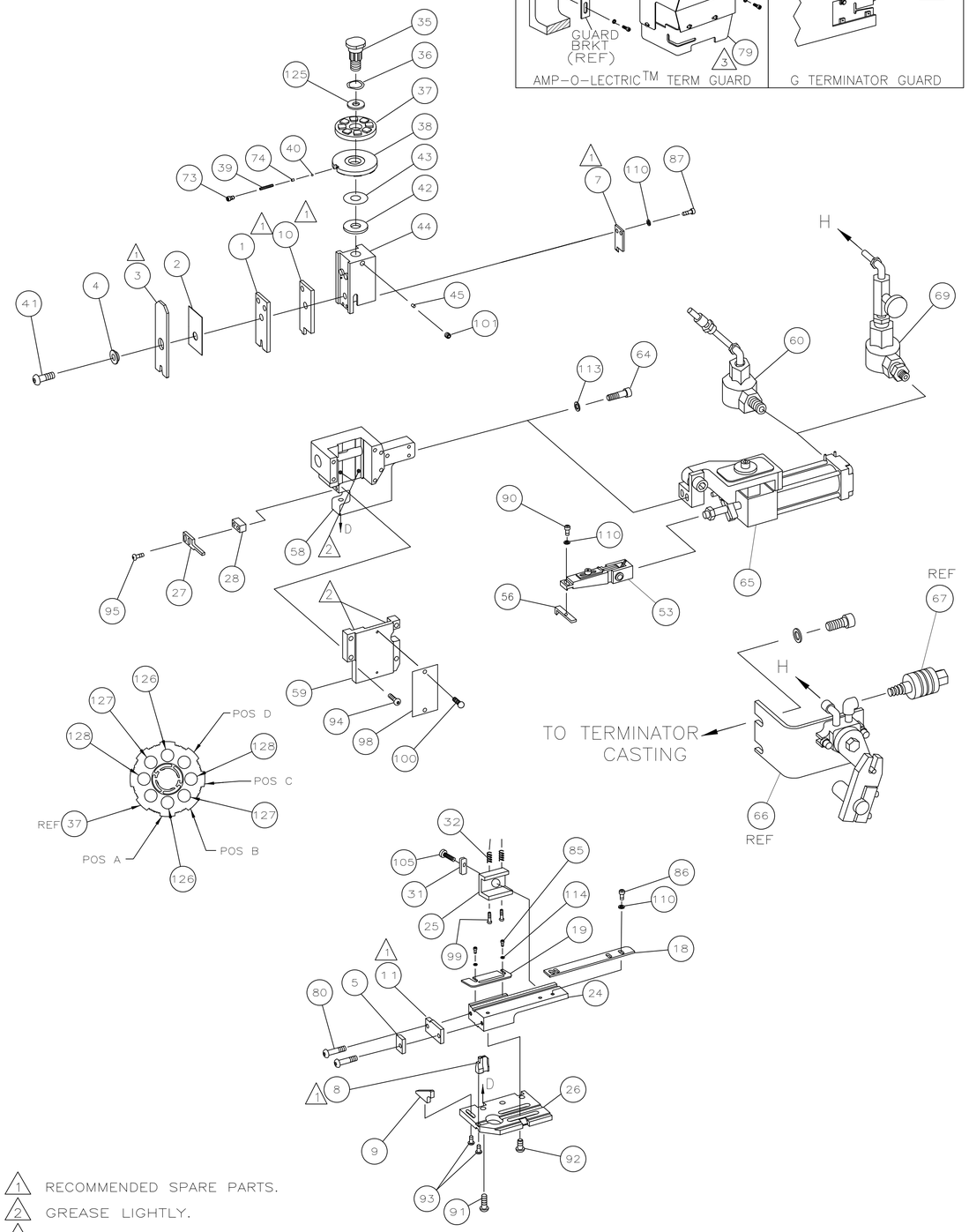
LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	E	ECR–09–011924	5–2009	MY	TE

–1	LEADMAKER OR BENCH MODEL G	AIRFEED
–2	BENCH MODEL K	AIRFEED





–2	–1	U/M	PART NO	DESCRIPTION	ITEM NO
					129
2	2	–	5–354779–2	PIN, WIRE DISC (.3250)C	128
2	2	–	4–354779–4	PIN, WIRE DISC (.3210)B	127
2	2	–	2–354779–6	PIN, WIRE DISC (.3120)A	126
1	1	–	986950–1	WASHER, FLAT PRECISION	125
					124
					123
					122
					121
					120
					119
					118
					117
					116
					115
2	2	–	21024–2	WASHER,LOCK(#4) REAR STR GUI	114
2	2	–	21024–5	WASHER,LOCK(#10)AIR ASSY	113
					112
					111
2	2	–	21024–4	WASHER,LOCK(NO.8)SHEAR BL	110
					109
					108
					107
					106
1	1	–	22353–8	SCR,SHLD(Ø.187x.25)DRAG LEVER	105
					104
					103
					102
1	1	–	21009–2	SCR,SKT SET(1/4–20x.25)RAM	101
2	2	–	21017–2	SCR,DRIVE(#2x.19)ID PLATE	100
2	2	–	3–21002–0	SCR,BHC(10–32x.88)DRAG	99
1	1	–	461264–1	PLATE, IDENTIFICATION	98
					97
					96
2	2	–	2–21002–3	SCR,BHC(8–32X.62)STRIPPER	95
4	4	–	2–21002–9	SCR,BHC(10–32x.75)CAP	94
3	3	–	22733–8	SCR,BHC(8–32x.38 LW)ANVIL	93
4	4	–	3–21002–3	SCR,BHC(1/4–20x.50)ST GD PL	92
3	3	–	2–22733–8	SCR,BHC(1/4–20x.62)HSG	91
1	1	–	2–22603–1	SCR,HEX HD(8–32x.38)FEED FINGER	90
					89
					88
2	2	–	2–21000–5	SCR,SHC(8–32x.25)SLUG BLADE	87
2	2	–	2–21000–7	SCR,SHC(8–32x.50)STRIP GUIDE	86
2	2	–	1–21000–3	SCR,SHC(4–40x.25)STRIP GUIDE	85
					84
					83
					82
					81
2	2	–	3–21002–0	SCR,BHC(10–32x.88)SHEAR PL	80
1	–	–	455750–8	GUARD ASSY	79
–	REF	–	679532–1	INSERT, GUARD	78
					77
					76
					75
1	1	–	690603–1	SPRING, ASSIST	74
1	1	–	23030–1	SCR,SKT CAP(6–32x.25)CP DSC	73
					72
					71

QTY REQD PER ASSY — PARTS LIST

–2	–1	U/M	PART NO	DESCRIPTION	ITEM NO
					70
1	–	–	692655–5	AIR FEED VALVE ASSY	69
					68
REF	–	–	24042–2	VALVE, SHUT OFF	67
REF	–	–	692655–6	AIR FEED VALVE ASSY	66
1	1	–	460277–1	AIR FEED ASSY (1 INCH)	65
2	2	–	3–21000–9	SCR,SHC(10–32x1.00)AIR ASSY	64
					63
					62
					61
–	1	–	692655–7	AIR FEED VALVE ASSY	60
1	1	–	454220–1	CAP, RAM	59
1	1	–	453736–8	HOUSING	58
					57
1	1	–	694433–8	PAWL, FEED	56
					55
					54
1	1	–	461062–1	FEED FINGER ASSY	53
					52
					51
					50
					49
					48
					47
					46
1	1	–	690191–1	PLUG, NYLON	45
1	1	–	819307–1	RAM	44
1	1	–	690125–1	WASHER, LAMINATED	43
1	1	–	690124–1	WASHER, RAM	42
1	1	–	7–21002–9	BOLT, CRIMPER(5/16–24x1.00)	41
1	1	–	23241–6	BALL, STEEL	40
1	1	–	690170–1	SPRING, COMPRESSION	39
1	1	–	690142–1	DISC, INSULATION	38
1	1	–	354777–1	WIRE DISC, PLASTIC	37
1	1	–	22480–5	WASHER, SPRING	36
1	1	–	690212–1	POST, RAM	35
					34
					33
2	2	–	1–22284–0	SPRING, DRAG	32
1	1	–	240793–1	LEVER, DRAG RELEASE	31
					30
					29
1	1	–	690451–1	SPACER, STRIPPER	28
1	1	–	240639–4	STRIPPER	27
1	1	–	318101–1	PLATE, BASE	26
1	1	–	240792–1	DRAG, TERMINAL	25
1	1	–	318163–1	PLATE, STRIP GUIDE	24
					23
					22
					21
					20
1	1	–	690438–8	GUIDE, STRIP (REAR)	19
1	1	–	690871–3	GUIDE, STRIP (FRONT)	18
					17
					16
					15
					14
					13
					12
1	1	–	318108–1	PLATE, REAR SHEAR	11
1	1	–	318120–1	SHEAR, SIDE	10
1	1	–	690551–2	BLOCK, SHEAR	9
1	1	–	240694–2	ANVIL	8
1	1	–	318109–1	BLADE, REAR SLUG	7
					6
1	1	–	318311–1	PLATE, RAMP	5
1	1	–	1–238009–2	SPACER, BLOCK CRIMPER	4
1	1	–	5–683453–1	CRIMPER, INSULATION	3
1	1	–	1–455888–9	SPACER, CRIMPER	2
1	1	–	4–458141–1	CRIMPER, WIRE	1

QTY REQD PER ASSY — PARTS LIST

1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
4. SEE DRAWING FOR COMPONENTS
5. ITEM 78 USED ON BENCH MODEL G ONLY.
6. FEED FINGER TO GUIDE OFF OF SIDE OF ITEM 19.

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ± –
1 PLC ± –
2 PLC ± .25
3 PLC ± –
4 PLC ± –
ANGLES ± –

MATERIAL –
FINISH –

DWN M.OBRINE 6/22/95
CHK C. ERISMAN 6–23–95
APVD S. FERRANTI 6–23–95

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

NAME: END FEED HDM APPLICATOR

PRODUCT SPEC —
APPLICATION SPEC —
WEIGHT —

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C–680176	—

CUSTOMER DRAWING — SCALE — SHEET 1 OF 1 — REV E

4805 (1/08)

27MAY2009 10:34am