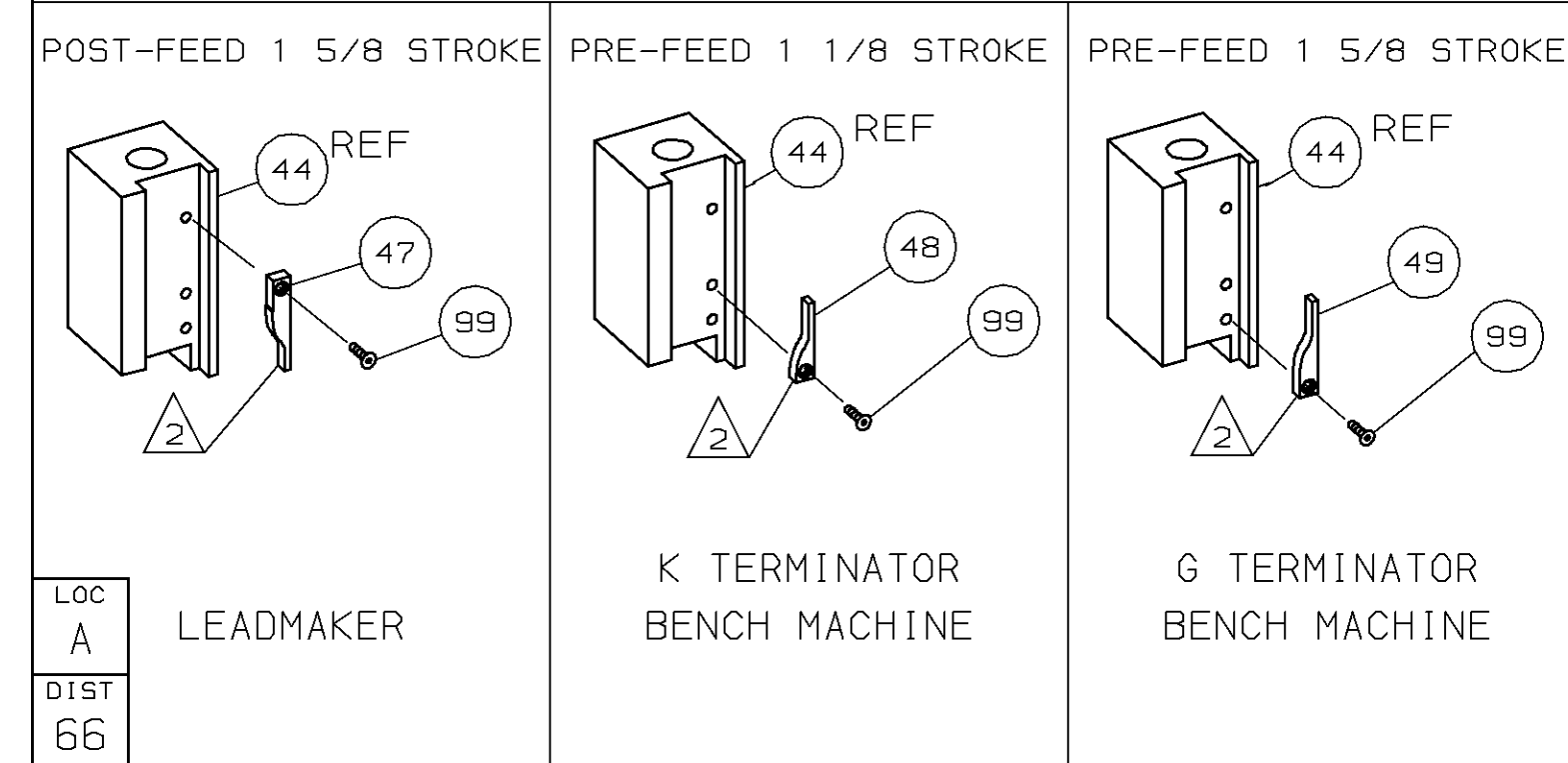
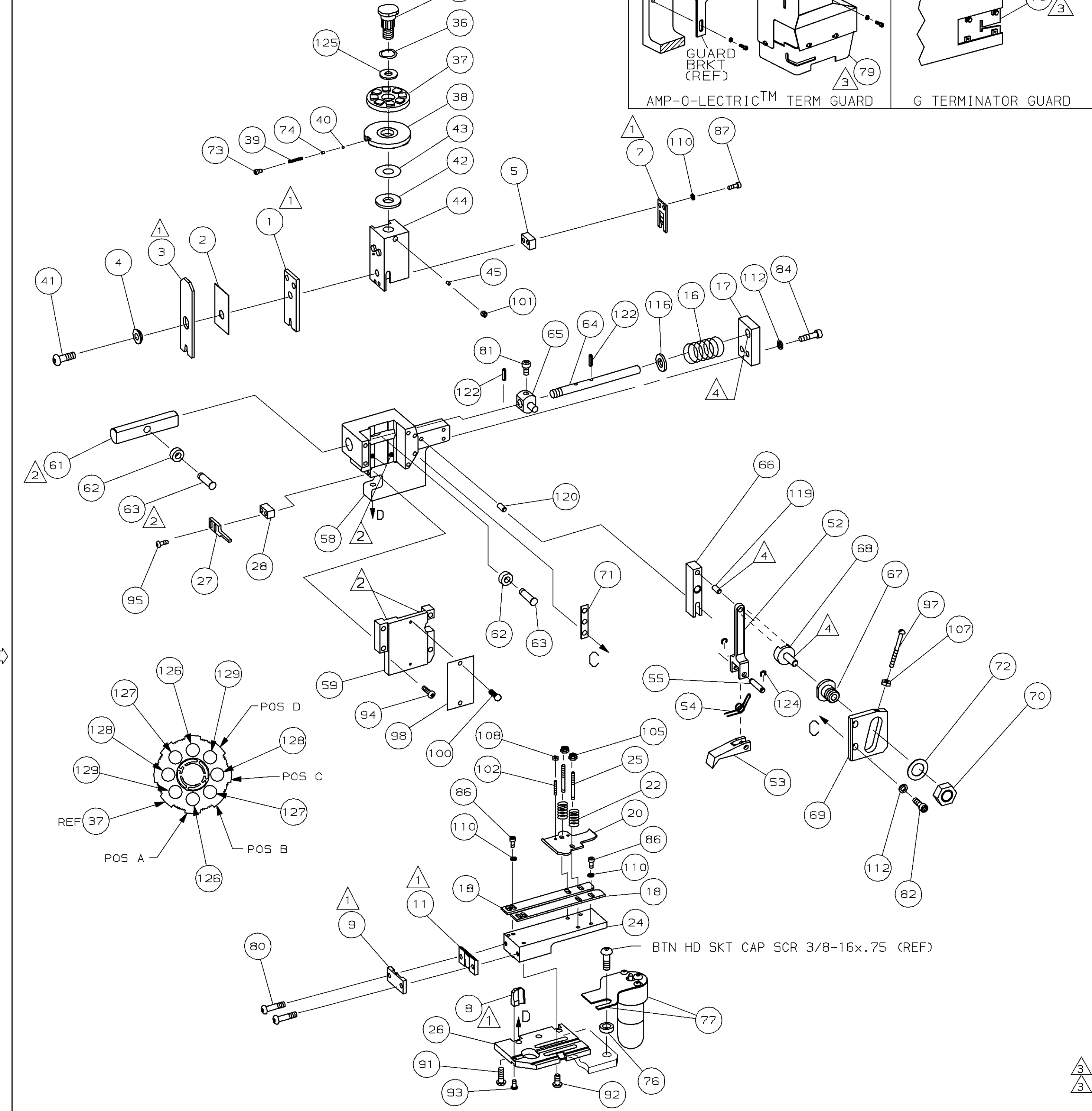


PART NUMBER	REV	FIRST USED
680202-1	B	122500-1
680202-2	B	565435-5
680202-3	B	354500-1



- 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.

TERMINAL NAME: RING TONGUE									
CRIMPING DATA									
PAD LTR		CRIMP HEIGHT				WIRE SIZE			
A		.080 ± .002 [2.03 ± 0.05mm]				1.5mm ²			
B		.074 ± .002 [1.88 ± 0.05mm]				1mm ²			
C		.070 ± .002 [1.78 ± 0.05mm]				0.75mm ²			
D		.068 ± .002 [1.73 ± 0.05mm]				0.5mm ²			
CRIMP	SIZE	TYPE		RANGE					
WIRE	.110 [2.79mm]	F		0.5mm ² -1.5mm ²					
INSUL	.160 [4.06mm]	F		1.78mm-3.05mm					
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT				
-	114-2084	1.090	408-8039	458638-1	L1678				

QTY REQD PER ASSY	TERMINAL	APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT	DESCRIPTION	ITEM NO	
2	2	-	C	9-354778-1			PIN, WIRE DISC (.2950)D	129	
2	2	2	-	C	8-354778-9		PIN, WIRE DISC (.2940)C	128	
2	2	2	-	C	7-354778-9		PIN, WIRE DISC (.2890)B	127	
2	2	2	-	C	6-354778-8		PIN, WIRE DISC (.2835)A	126	
1	1	1	-	A	986950-1		WASHER, FLAT PRECISION	125	
REF	REF	REF	-	A	21045-3		RING, RET "C" (Ø.187)FD PIN	124	
								123	
REF	REF	REF	-	A	5-21028-1		PIN, STD SPRING (Ø.12)FD ADJ ROD	122	
								121	
REF	REF	REF	-	A	1-21030-7		PIN, DOWEL (Ø.187x1.50)HSG	120	
REF	REF	REF	-	A	1-21030-1		PIN, DOWEL (Ø.187x.50)LEVER	119	
								118	
								117	
REF	REF	REF	-	A	21899-4		WASHER, FLAT (Ø5/16)SCR ADJ	116	
								115	
								114	
								113	
REF	REF	REF	-	A	21024-5		WASHER, LOCK (NO.10)FD ROD GDE	112	
								111	
6	6	6	-	A	21024-4		WASHER, LOCK (NO.8)SHEAR BL	110	
								109	
2	2	2	-	A	21018-4		NUT, HEX (4-40)DRAG	108	
REF	REF	REF	-	A	21018-5		NUT, HEX (6-32)FD ADJ PL	107	
								106	
2	2	2	-	A	21022-2		NUT, HEX SL (8-32)DRAG STUD	105	
								104	
								103	
2	2	2	-	A	2-21006-6		SCR, SKT SET (4-40x.62)DRAG	102	
1	1	1	-	A	21009-2		SCR, SKT SET (1/4-20x.25)RAM	101	
2	2	2	-	A	21017-2		SCR, DRIVE (#2x.19)ID PLATE	100	
1	1	1	-	A	1-21002-7		SCR, BHC (6-32x.38)CAM	99	
1	1	1	-	B	461264-1		PLATE, IDENTIFICATION	98	
REF	REF	REF	-	A	6-23715-5		SCR, PAN HD (6-32x1.50)FEED ADJ	97	
								96	
2	2	2	-	A	2-21002-2		SCR, BHC (8-32x.50)STRIPPER	95	
REF	REF	REF	-	A	2-21002-9		SCR, BHC (10-32x.75)HSG CAP	94	
1	1	1	-	A	22733-8		SCR, BHC (8-32x.38 LW)ANVIL	93	
4	4	4	-	A	3-21002-3		SCR, BHC (1/4-20x.50)ST GD PL	92	
REF	REF	REF	-	A	2-22733-8		SCR, BHC (1/4-20x.62)BASE PL	91	
								90	
								89	
								88	
2	2	2	-	A	2-21000-9		SCR, SHC (8-32x.75)SLUG BLADE	87	
4	4	4	-	A	2-21000-6		SCR, SHC (8-32x.38)STRIP GUIDE	86	
								85	
REF	REF	REF	-	A	3-21000-7		SCR, SHC (10-32x.75)FEED ROD GDE	84	
								83	
REF	REF	REF	-	A	3-21000-6		SCR, SHC (10-32x.62)FEED ADJ PL	82	
REF	REF	REF	-	A	3-21000-4		SCR, SHC (10-32x.38)PIVOT BLOCK	81	
2	2	2	-	A	3-21002-0		SCR, BHC (10-32x.88)SHEAR PL	80	
-	REF	-	-	A	455745-1		GUARD, WINDOW	79	
REF	-	-	-	A	679532-1		INSERT, GUARD	78	
-	1	-	-	C	465184-9		LUBRICATOR ASSY	77	
-	1	-	-	A	454406-1		SPACER, LUB BRACKET	76	
								75	
1	1	1	-	A	690603-1		SPRING, ASSIST	74	
1	1	1	-	A	23030-1		SCR, SKT CAP (6-32x.25)CP DSC	73	
REF	REF	REF	-	A	458109-1		WASHER, FLAT (SPECIAL)	72	
REF	REF	REF	-	A	690517-1		SPACER	71	
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO		
QTY REQD PER ASSY									

REV	LEADMAKER	MECH POST FEED							
-1	LEADMAKER	MECH POST FEED							
-2	BENCH MODEL K	MECH PRE FEED							
-3	BENCH MODEL G	MECH PRE FEED							
REF	REF	REF	-	A	22594-8	NUT, HEX	70		
REF	REF	REF	-	B	240628-1	PLATE, ADJ	69		
REF	REF	REF	-	B	240626-1	SHAFT, PIVOT	68		
REF	REF	REF	-	B	240633-1	BUSHING	67		
REF	REF	REF	-	A	455680-1	LEVER, INTERMEDIATE	66		
REF	REF	REF	-	B	240629-1	BLOCK, PIVOT	65		
REF	REF	REF	-	A	240632-2	SCR, ADJ	64		
REF	REF	REF	-	B	240659-3	PIN, CAM ROLLER	63		
REF	REF	REF	-	B	240658-1	CAM, ROLLER	62		
REF	REF	REF	-	B	454398-1	ROD, FEED	61		
							60		
REF	REF	REF	-	C	454220-1	CAP, RAM	59		
REF	REF	REF	-	D	453736-1	HOUSING	58		
							57		
							56		
REF	REF	REF	-	B	240624-1	PIN, FEED FINGER	55		
REF	REF	REF	-	B	691499-1	SPRING, FEED FINGER	54		
REF	REF	REF	-	B	240635-1	FINGER, FEED	53		
REF	REF	REF	-	B	240634-1	LEVER, TERMINAL	52		
							51		
							50		
1	-	-	-	B	690602-6	CAM, PRE-FEED 1 5/8 ST	49		
-	1	-	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST	48		
-	-	1	-	B	690501-4	CAM, POST-FEED 1 5/8 ST	47		
							46		
1	1	1	-	A	690191-1	PLUG, NYLON	45		
1	1	1	-	C	455674-1	RAM	44		
1	1	1	-	A	690125-1	WASHER, LAMINATED	43		
1	1	1	-	A	690124-1	WASHER, RAM	42		
1	1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16-24x1.00)	41		
1	1	1	-	A	23241-6	BALL, STEEL	40		
1	1	1	-	A	690170-1	SPRING, COMPRESSION	39		
1	1	1	-	C	690142-1	DISC, INSULATION	38		
1	1	1	-	D	354777-1	WIRE DISC, PLASTIC	37		
1	1	1	-	A	22480-5	WASHER, SPRING	36		
1	1	1	-	B	690212-1	POST, RAM	35		
							34		
							33		
1	1	1	-	D	458980-1	APPLICATOR, BASIC (SUB ASSY)	32		
							31		
							30		
							29		
1	1	1	-	B	3-690451-2	SPACER, STRIPPER	28		
1	1	1	-	A	240639-1	STRIPPER	27		
REF	REF	REF	-	C	455676-1	PLATE, BASE	26		
2	2	2	-	A	22354-8	DRAG, STUD	25		
1	1	1	-	B	455678-1	PLATE, STRIP GUIDE	24		
							23		
2	2	2	-	A	4-22281-1	SPRING, DRAG	22		
							21		
1	1	1	-	A	454177-1	DRAG, STOCK	20		
1	1	1	-	C	4-458030-2	GUIDE, STRIP (REAR)	19		
1	1	1	-	C	4-458031-2	GUIDE, STRIP (FRONT)	18		
REF	REF	REF	-	A	454178-1	GUIDE, FEED ROD	17		
REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	16		
							15		
							14		
							13		
							12		
1	1	1	-	B	240644-1	PLATE, REAR SHEAR	11		
							10		
1	1	1	-	B	690482-4	PLATE, FRONT SHEAR	9		
1	1	1	-	D	9-683452-6	ANVIL	8		
1	1	1	-	B	690474-4	BLADE, SLUG	7		
							6		
1	1	1	-	C	6-240641-1	SPACER, SLUG BLADE	5		
1	1	1	-	B	238009-1	SPACER, BLOCK CRIMPER	4		
1	1	1	-	C	456134-9	CRIMPER, INSULATION	3		
1	1	1	-	B	455888-8	SPACER, CRIMPER	2		
1	1	1	-	C	456408-6	CRIMPER, WIRE	1		
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO		
QTY REQD PER ASSY									

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