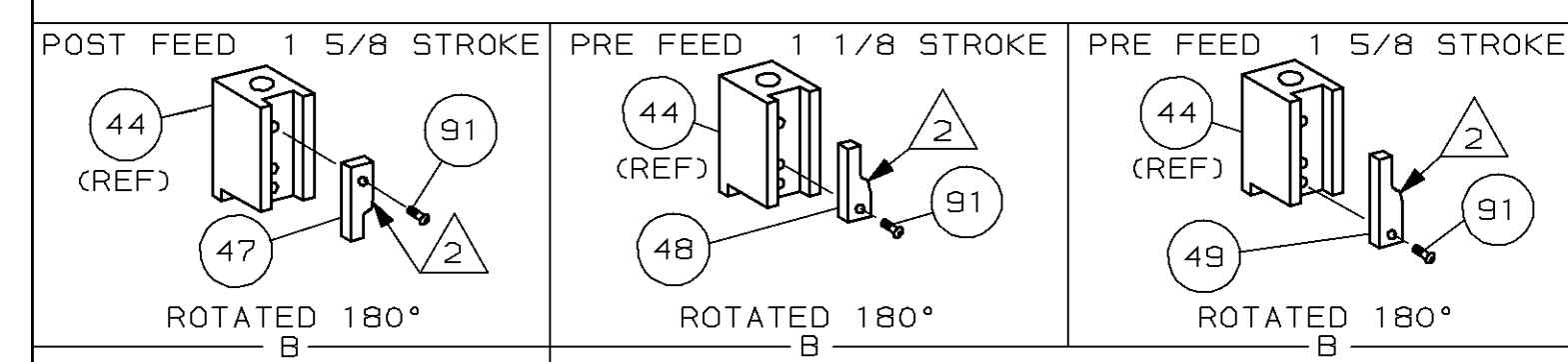
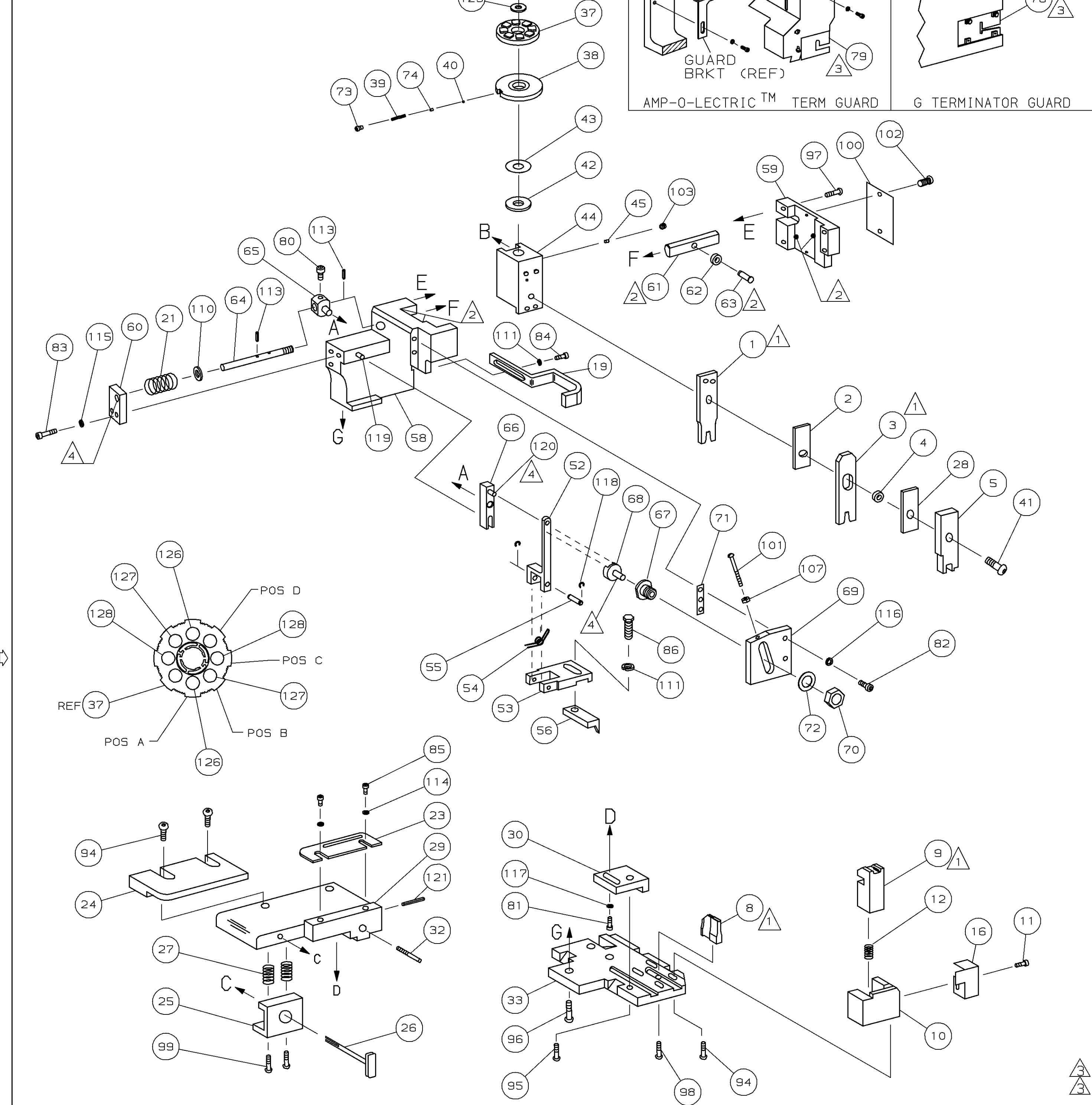


PART NUMBER	REV	FIRST USED
680328 -1	C	122500-1
680328 -2	C	565435-5
680328 -3	C	354500-1



- 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 46.
- 6 THIS APPLICATOR IS FOR SINGLE WIRE APPLICATION

TERMINAL NAME: SPLICE		CRIMPING DATA			
PAD LTR	680806	CRIMP HEIGHT	WIRE SIZE		
A		.073 ± .002 [1.85 ± 0.05mm]	14		
B		.062 ± .002 [1.57 ± 0.05mm]	16		
C		.055 ± .002 [1.4 ± 0.05mm]	18		
D		NOT	USED		
CRIMP	SIZE	TYPE	RANGE		
WIRE	.090 [2.29mm]	F	18-14		
INSUL	.155 [3.94mm]	F	.105-.145		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
-	114-2088	.410	408-8040	458637-1	L1786

QTY	REF	REF	REF	REF	REF	DESCRIPTION	ITEM NO
2	2	2	-	C	2-354779-2	PIN, WIRE DISC (.3100)C	129
2	2	2	-	C	354779-5	PIN, WIRE DISC (.3015)B	127
2	2	2	-	C	8-354778-1	PIN, WIRE DISC (.2900)A	126
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	1	-	-	4088040	SF APPL INST 408-8040	123
1	1	1	-	A	4-21028-0	PIN,SLT SPR(φ.093x.75)ST GDE PL	121
REF	REF	REF	-	A	1-21030-1	PIN,DOWEL(φ.187x.50)LEVER	120
REF	REF	REF	-	A	1-21030-6	PIN,DOWEL(φ.187x1.25)HOUSING	119
REF	REF	REF	-	A	21045-3	RING,RET "C"(φ.187)FD FING PIN	118
1	1	1	-	A	21024-5	WASHER, LOCK (#10)ADJ BLOCK	117
REF	REF	REF	-	A	21024-5	WASHER,LOCK(#10)ADJ PLATE	116
REF	REF	REF	-	A	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115
2	2	2	-	A	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
REF	REF	REF	-	A	5-21028-1	PIN,SLT SPR(φ.125x.50)ADJ ROD	113
2	2	2	-	A	21024-4	WASHER,LOCK(#8)STRIPPER	111
REF	REF	REF	-	A	21899-4	WASHER,FLAT(φ5/16)SCREW ADJ	110
REF	REF	REF	-	A	21018-5	NUT,HEX(6-32)FEED ADJ	107
1	1	1	-	A	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
2	2	2	-	A	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
REF	REF	REF	-	A	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
1	1	1	-	B	461264-1	PLATE, IDENTIFICATION	100
2	2	2	-	A	3-21002-0	SCR,BHC(10-32x.88)DRAG	99
1	1	1	-	A	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
REF	REF	REF	-	A	2-21002-9	SCR,BHC(10-32x.75)CAP	97
REF	REF	REF	-	A	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
REF	REF	REF	-	A	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
4	4	4	-	A	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
1	1	1	-	A	1-21002-7	SCR,BHC(6-32x.38)CAM	91
1	1	1	-	A	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
2	2	2	-	A	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	85
1	1	1	-	A	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
REF	REF	REF	-	A	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
REF	REF	REF	-	A	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	82
1	1	1	-	A	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
REF	REF	REF	-	A	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	80
-	REF	-	-	B	455749-1	GUARD, WINDOW	79
REF	-	-	-	B	679532-1	INSERT, GUARD	78
1	1	1	-	A	690603-1	SPRING, ASSIST	74
1	1	1	-	A	23030-1	SCR,SHC(6-32x.25 SL)INS DISC	73
REF	REF	REF	-	A	458109-1	WASHER, SPECIAL	72
REF	REF	REF	-	A	590517-1	SPACER	71

QTY	REF	REF	REF	REF	REF	DESCRIPTION	ITEM NO
-1						LEADMAKER	
-2						BENCH MODEL K	
-3						BENCH MODEL G	
REF	REF	REF	-	B	22594-8	NUT,HEX(1/2-20)	70
REF	REF	REF	-	B	240628-1	PLATE, ADJUSTMENT	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	SCREW, ADJ FEED ROD	64
REF	REF	REF	-	B	240659-3	PIN, CAM ROLLER	63
REF	REF	REF	-	B	240658-1	ROLLER, CAM	62
REF	REF	REF	-	B	454398-2	ROD, FEED	61
REF	REF	REF	-	A	454178-1	GUIDE, FEED ROD	60
REF	REF	REF	-	C	454220-1	CAP, RAM	59
REF	REF	REF	-	D	454485-1	HOUSING	58
1	1	1	-	B	1-694433-6	PAWL, FEED	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	690541-1	HOLDER, FEED FINGER	53
REF	REF	REF	-	A	455679-1	LEVER, TERMINAL FEED ARM	52
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
1	1	1	-	B	459456-1	APPLICATOR, BASIC (SUBASSY)	46
1	1	1	-	A	690191-1	PLUG, NYLON	45
1	1	1	-	C	455673-1	RAM	44
1	1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	1	-	A	690124-1	WASHER, RAM	42
1	1	1	-	A	690686-1	BOLT, CRIMPER(5/16x1.00)	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
REF	REF	REF	-	D	455675-1	PLATE, BASE	33
1	1	1	-	A	690432-3	SCREW, ADJUSTMENT	32
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	C	455671-1	PLATE, STRIP GUIDE	29
1	1	1	-	C	455888-4	SPACER, FRONT SHEAR DEP	28
2	2	2	-	A	1-22284-0	SPRING, DRAG	27
1	1	1	-	B	690546-1	LEVER, DRAG RELEASE	26
1	1	1	-	B	240792-1	DRAG, TERMINAL	25
1	1	1	-	D	6-690440-5	GUIDE, STRIP (REAR)	24
1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	21
1	1	1	-	B	456468-1	STRIPPER	19
1	1	1	-	B	318563-1	GUARD, CHIP, FRONT	16
1	1	1	-	A	6-22279-4	SPRING, SHEAR	12
1	1	1	-	B	690461-5	STOP, SHEAR	11
1	1	1	-	C	662966-1	HOLDER, SHEAR (FRONT)	10
1	1	1	-	C	1-462006-1	SHEAR, FLOAT (FRONT)	9
1	1	1	-	C	8-189717-6	ANVIL	8
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	3-238011-0	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	7-683453-5	CRIMPER, INSULATION	3
1	1	1	-	C	2-455888-1	SPACER, CRIMPER	2
1	1	1	-	C	4-458141-7	CRIMPER, WIRE	1

LOC
A
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REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

QTY	REF	REF	REF	REF	REF	DESCRIPTION	ITEM NO
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

REVISION RECORD

REV	DATE	BY	APP	DESCRIPTION
C	0150-8147-97	TB	12-97	
B	0150-7570-97	CE	2/97	
A	REVISED	CE	9-9	

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DR P. MATHIAS 7-9-96 APP T. ELBIN 7-6-96
CHK 7-9-96 REL 10/3/96
C. ERISMAN B. MORGAN

NAME: SIDE FEED HDM APPLICATOR MACHINE REF: MINI APPL
SCALE: D DWG NO: 680328 SHEET: 1 OF 1 REV: C