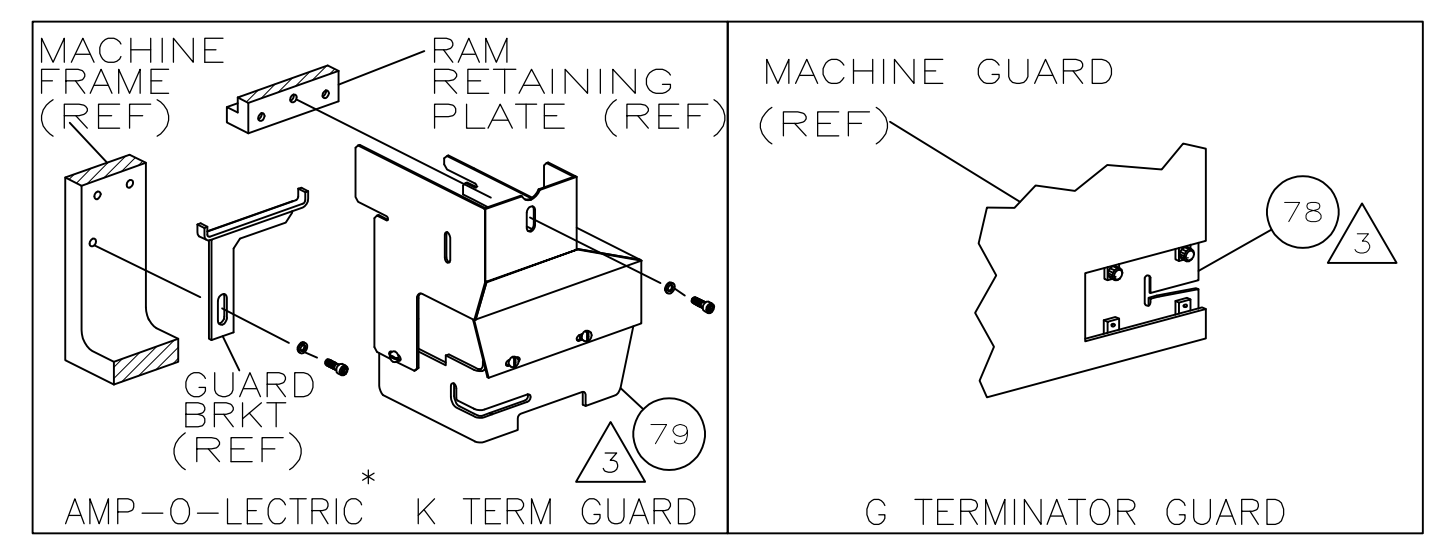


THIS DRAWING IS A CONTROLLED DOCUMENT.

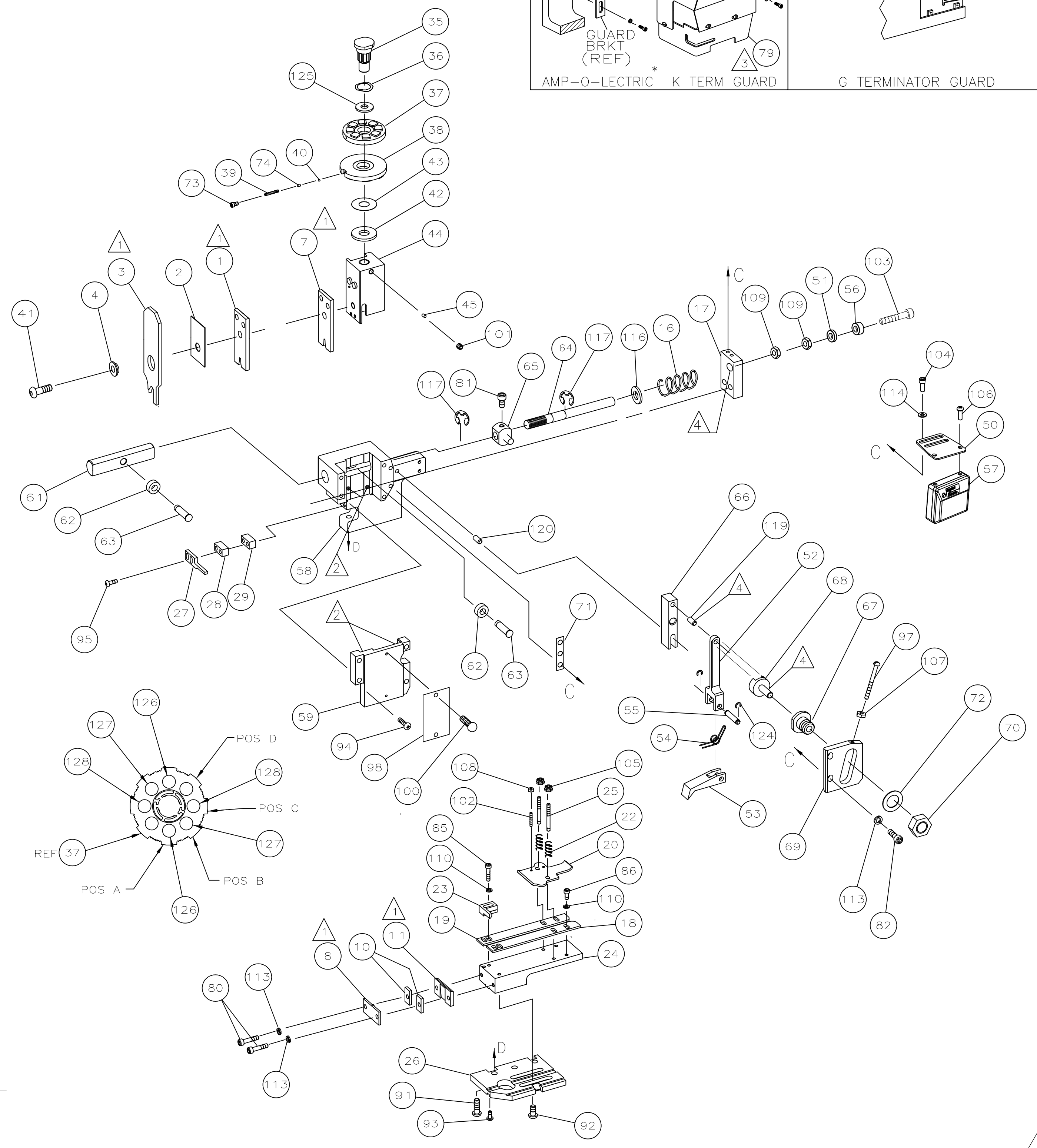
PART NUMBER	REV	FIRST USED
680074 -1	J	854400-1
680074 -2	J	565435-5
680074 -3	J	354500-1



TERMINAL NAME:	
TAB, FASTON, FLAG	42770
	1217324
TERM APPL SPEC	NONE

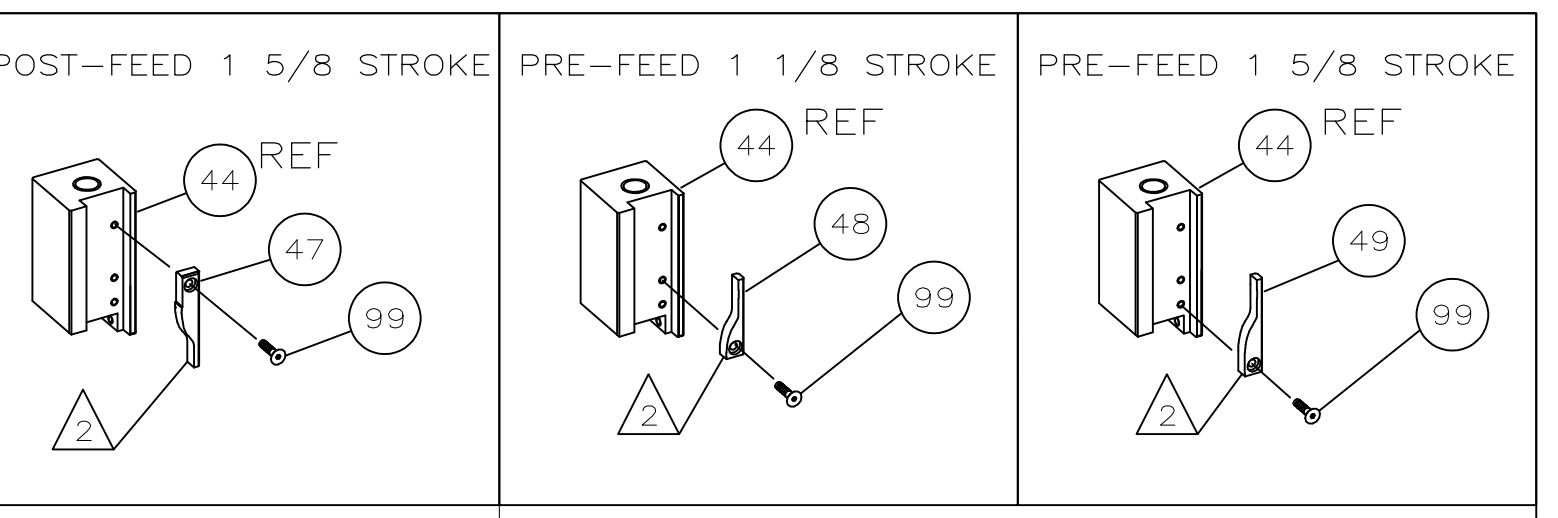
CRIMPING DATA			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.103 ±.002	14	
B	.096 ±.002	16	
C	.091 ±.002	18	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.130	F	18-14
INSUL	.180	0	.080-.160
FEED	APPL INST	SET UP GAGE	LAYOUT
	408-8039	458638-1	L1556
WIRE STRIP LENGTH .125-.155			

-1	LEADMAKER	MECH POST FEED
-2	BENCH MODEL K	MECH PRE FEED
-3	BENCH MODEL G	MECH PRE FEED



QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
2	2	2	-	8-354778-3	PIN, WIRE DISC (.2910)C	128
2	2	2	-	6-354778-8	PIN, WIRE DISC (.2835)B	127
2	2	2	-	5-354778-5	PIN, WIRE DISC (.2770)A	126
1	1	1	-	986950-1	WASHER, FLAT PRECISION	125
2	2	2	-	21045-3	RING,RET"C"(Ø.187)FD PIN	124
						123
2	2	2	-	5-21028-1	PIN,STD SPRING(Ø.12)FD ADJ ROD	122
						121
1	1	1	-	1-21030-7	PIN,DOWEL(Ø.187x1.50)HSG	120
1	1	1	-	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	119
						118
2	2	2	-	1-21046-6	RING,RETAINING,EXT(5/16)FD ADJ ROD	117
1	1	1	-	21899-4	WASHER,FLAT(Ø5/16)SCR ADJ	116
						115
2	2	2	-	18028-2	WASHER,FLAT(M4)COUNTER	114
6	6	6	-	21024-5	WASHER,LOCK(NO.10)SHEAR PL	113
						112
						111
5	5	5	-	21024-4	WASHER,LOCK(NO.8)SHEAR BL	110
2	2	2	-	22593-1	NUT,HEX(1/4-20)MAGNET	109
2	2	2	-	21018-4	NUT,HEX(4-40)DRAG	108
1	1	1	-	21018-5	NUT,HEX(6-32)FD ADJ PL	107
2	2	2	-	994991-5	SCR,OVAL HD(M4X12)COUNTER	106
2	2	2	-	21022-2	NUT,HEX SL(8-32)DRAG STUD	105
2	2	2	-	9-21000-9	SCR,SHC(8-32x.44)COUNTER	104
1	1	1	-	3-21081-3	SCR,SHC(1/4-20x1.25)MAGNET	103
2	2	2	-	4-21078-8	SKT SKT SET (4-40x.75)DRAG	102
1	1	1	-	21009-2	SCR,SKT SET(1/4-20x.25)RAM	101
2	2	2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE	100
1	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	99
1	1	1	-	461264-1	PLATE, IDENTIFICATION	98
1	1	1	-	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	97
						96
2	2	2	-	8-21002-9	SCR,SHC(8-32x1.00)STRIPPER	95
4	4	4	-	2-21002-9	SCR,BHC(10-32x.75)HSG CAP	94
						93
4	4	4	-	3-21002-3	SCR,BHC(1/4-20x.50)ST GD PL	92
3	3	3	-	2-22733-8	SCR,BHC(1/4-20x.62)BASE PL	91
						90
						89
						88
						87
3	3	3	-	2-21000-6	SCR,SHC(8-32x.38)STRIP GUIDE	86
2	2	2	-	2-21000-9	SCR,SHC(8-32x.75)R STRIP GUIDE	85
2	2	2	-	3-21000-7	SCR, SKT CAP(10-32x.75)FD GDE	84
						83
2	2	2	-	3-21000-6	SCR,SKT CAP(10-32x.62)FD ADJ P	82
1	1	1	-	3-21000-4	SCR,SKT CAP(10-32x.38)PIVOT BL	81
2	2	2	-	3-21000-9	SCR,SKT CAP(10-32x1.00)SH PL	80
-	REF	-	-	455745-1	GUARD, WINDOW	79
REF	-	-	-	679532-1	INSERT, GUARD	78
						77
						76
						75
1	1	1	-	690603-1	SPRING, ASSIST	74
1	1	1	-	23030-1	SCR,SKT CAP(6-32x.25)CP DSC	73
1	1	1	-	458109-1	WASHER, FLAT (SPECIAL)	72
1	1	1	-	690517-1	SPACER	71
-3	-2	-1	U/M			

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
1	1	1	-	22594-8	NUT, HEX	70
1	1	1	-	240628-1	PLATE, ADJ	69
1	1	1	-	240626-1	SHAFT, PIVOT	68
1	1	1	-	240633-1	BUSHING	67
1	1	1	-	455680-1	LEVER, INTERMEDIATE	66
1	1	1	-	240629-1	BLOCK, PIVOT	65
1	1	1	-	1804311-1	SCR, ADJ	64
1	1	1	-	240659-3	PIN, CAM ROLLER	63
1	1	1	-	240658-1	CAM, ROLLER	62
1	1	1	-	454398-1	ROD, FEED	61
						60
1	1	1	-	454220-1	CAP, RAM	59
1	1	1	-	453736-1	HOUSING	58
1	1	1	-	1804300-1	APPLICATOR COUNTER ASSEMBLY	57
1	1	1	-	1804299-1	SPACER, MAGNET	56
1	1	1	-	240624-1	PIN, FEED FINGER	55
1	1	1	-	691499-1	SPRING, FEED FINGER	54
1	1	1	-	240635-1	FINGER, FEED	53
1	1	1	-	240634-1	LEVER, TERMINAL	52
1	1	1	-	1804310-1	MAGNET, RING	51
1	1	1	-	1804303-1	BRACKET, COUNTER MOUNTING	50
1	-	-	-	690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	1	-	-	690602-5	CAM, PRE-FEED 1 1/8 ST	48
-	-	1	-	690501-4	CAM, POST-FEED 1 5/8 ST	47
						46
1	1	1	-	690191-1	PLUG, NYLON	45
1	1	1	-	455674-3	RAM	44
1	1	1	-	690125-1	WASHER, LAMINATED	43
1	1	1	-	690124-4	WASHER, RAM	42
1	1	1	-	690686-1	BOLT, CRIMPER(5/16-24x1.00)	41
1	1	1	-	23241-6	BALL, STEEL	40
1	1	1	-	690170-1	SPRING, COMPRESSION	39
1	1	1	-	690142-1	DISC, INSULATION	38
1	1	1	-	354777-1	WIRE DISC, PLASTIC	37
1	1	1	-	22480-5	WASHER, SPRING	36
1	1	1	-	690212-1	POST, RAM	35
						34
						33
						32
						31
						30
1	1	1	-	2-690451-7	SPACER, STRIPPER	29
1	1	1	-	1-690451-3	SPACER, STRIPPER	28
1	1	1	-	240639-1	STRIPPER	27
1	1	1	-	459717-1	PLATE, BASE	26
2	2	2	-	22354-8	DRAG, STUD	25
1	1	1	-	122913-1	PLATE, STRIP GUIDE	24
1	1	1	-	240825-3	PLATE, STRIP HOLD DOWN	23
2	2	2	-	4-22281-1	SPRING, DRAG	22
						21
1	1	1	-	454177-3	DRAG, STOCK	20
1	1	1	-	122912-1	GUIDE, STRIP (REAR)	19
1	1	1	-	1-454204-0	GUIDE, STRIP (FRONT)	18
1	1	1	-	1804305-2	GUIDE, FEED ROD	17
1	1	1	-	4-22284-9	SPRING, FEED RETURN	16
						15
						14
						13
						12
1	1	1	-	240644-3	PLATE, REAR SHEAR	11
2	2	2	-	240645-5	SPACER, SHEAR PLATE	10
						9
1	1	1	-	122911-1	ANVIL	8
1	1	1	-	459722-1	BLADE, SLUG	7
						6
						5
1	1	1	-	238009-6	SPACER, BLOCK CRIMPER	4
1	1	1	-	461296-4	CRIMPER, INSULATION	3
1	1	1	-	455888-5	SPACER, CRIMPER	2
1	1	1	-	1-456410-4	CRIMPER, WIRE	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 RUN -3 APPLICATOR ON SPLIT CYCLE MODE.
- 6 SET FEED ON TERMINAL INSULATION BARREL.

LOC	T TERMINATING UNIT	K TERMINATING UNIT	G TERMINATING UNIT
A	LEADMAKER	BENCH MACHINE	
DIST	66		

QTY	REQD	PER	ASSY	PARTS LIST

DIMENSIONS: INCHES 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±.	DWG: P.MATHIAS CHK: C.ERISMAN APVD: B.WOLFE NAME:	2/23/94 2-25-94 2-25-94	MATERIAL: - HEAT TREAT: -	TE Connectivity
SCALE: - SIZE: A1 DRAWING NO: 680074 SHEET 1 of 1 REV J3		END FEED HDM APPLICATOR			

CUSTOMER ACCESSIBLE PRODUCTION DRAWING