

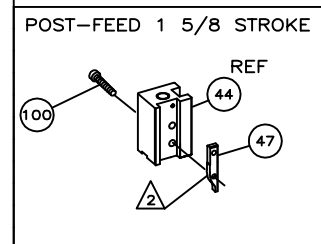
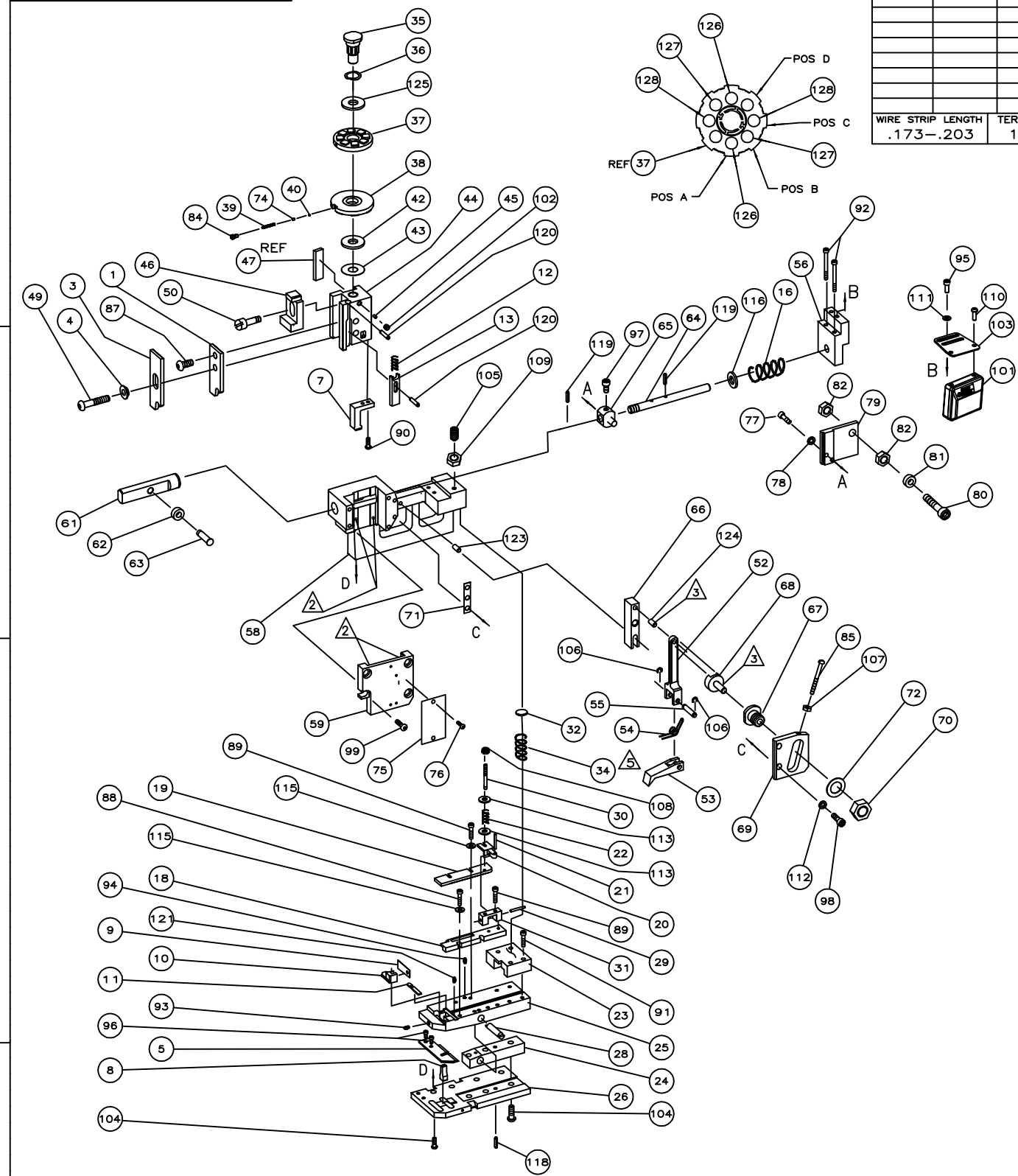
PART NUMBER	REV	FIRST USED
680563-1	F	854400-1

TERM		CRIMPING DATA	
1217027	1742422	CRIMP HEIGHT	
A	.051±.002 [1.29±0.05mm]	WIRE SIZE	
B	.046±.002 [1.17±0.05mm]	14	
C	.043±.002 [1.09±0.05mm]	16	
D	NOT USED	18	
CRIMP		SIZE	TYPE
WIRE		.140 [3.56mm]	TAB LOCK
INSUL		.170 [3.56mm]	0
WIRE STRIP LENGTH		TERM APPL SPEC	FEED
.173-.203		114-2078	.650
		APPL INSTRUCTION	SET UP GAGE
		408-8037	-
		LAYOUT	-

-1 LEADMAKER MECH POST FEED

QTY	U/M	PART NO	DESCRIPTION	ITEM NO
1	-	22594-8	NUT, HEX	70
1	-	240628-1	PLATE, ADJ	69
1	-	240626-1	SHAFT, PIVOT	68
1	-	240633-1	BUSHING	67
1	-	240630-1	LEVER, INTERMEDIATE	66
1	-	1804317-1	BLOCK, PIVOT	65
1	-	1633286-1	SCR, ADJ	64
1	-	240659-3	PIN, CAM ROLLER	63
1	-	240658-1	ROLER, CAM	62
1	-	240631-1	ROD, FEED	61
1	-	2217626-1	CAP ASSEMBLY	60
1	-	2217625-1	HOUSING	59
1	-	1804319-1	GUIDE, FEED ROD	56
1	-	240624-1	PIN, FEED FINGER	55
1	-	691499-1	SPRING, FEED FINGER	54
1	-	454568-2	FINGER, FEED	53
1	-	240634-1	LEVER, TERMINAL	52
1	-	2256119-1	SCREW, SHOULDER	50
1	-	3-21002-5	BOLT, CRIMPER	49
1	-	238015-1	CAM, POST-FEED 1 5/8 ST	47
1	-	690578-3	BLOCK, INSULATION ADJUST	46
1	-	690191-1	PLUG, NYLON	45
1	-	2217624-1	RAM	44
1	-	690125-1	WASHER, LAMINATED	43
1	-	1-690124-1	WASHER, RAM	42
1	-	18028-2	WASHER, FLAT (M4) COUNTER	41
1	-	994991-5	SCR, OVAL HD (M4X12) COUNTER	40
1	-	1-22202-7	NUT, HEX (5/16-24)	39
1	-	21022-3	NUT, HEX (LOCKING) (10-32)	38
1	-	21018-5	NUT, HEX (6-32)	37
2	-	21045-3	RING, RET "C" (Ø.187) FD PIN	36
1	-	8-21007-5	SCREW, SKT SET (5/16-24x.75)	35
7	-	2-22733-8	SCREW, BHC (1/4-20X.63)	34
1	-	1804303-1	BRACKET, COUNTER MTG	33
1	-	21009-2	SCREW, SKT SET (1/4-20x.25)	32
1	-	1804300-1	APPLICATOR COUNTER ASSY	31
1	-	3-21000-9	SCREW, SHC (10-32X1.00)	30
4	-	3-21000-8	SCREW, SHC (10-32X.88)	29
2	-	3-21000-6	SCREW, SHC (10-32X.62)	28
1	-	3-21000-4	SCREW, SHC (10-32X.38)	27
2	-	7-21000-6	SCREW, SHC (10-32X.38)	26
2	-	2-21000-6	SCR, SHC (8-32X.38) COUNTER	25
2	-	4-21006-0	SCREW, SKT SET (8-32X.25)	24
1	-	21061-9	SCREW, SKT SET (8-32X.25)	23
2	-	9-21000-3	SCREW, SHC (8-32X2.00)	22
4	-	2-21000-9	SCREW, SHC (8-32X.75)	21
2	-	1-23030-1	SCREW, SHC (NYLOK) (8-32X.62)	20
4	-	2-21000-8	SCREW, SHC (8-32X.62)	19
2	-	2-21000-8	SCREW, SHC (8-32X.62)	18
1	-	2-21002-1	SCREW, SBHC (8-32X.38)	17
1	-	6-23715-5	SCR, PAN HD (6-32x1.50) FEED ADJ	16
1	-	23030-1	SCREW, SHC (NYLOK) (6-32X.25)	15
2	-	22593-1	NUT, HEX JAM (1/4-20) BRACKET	14
1	-	1804310-1	MAGNET, RING	13
1	-	3-21081-2	SCR, SHC (1/4-20X1.00) BRACKET	12
1	-	1804318-1	BRACKET, MAGNET HOLDER	11
2	-	21024-3	WASHER, LOCK (#6) BRACKET	10
2	-	2-21000-0	SCR, SHC (6-32X.50) BRACKET	9
2	-	21017-2	SCR, DRIVE (#2X.19) ID	8
1	-	461264-1	PLATE, IDENTIFICATION	7
1	-	690603-1	SPRING, ASSIST	6
1	-	458109-1	WASHER, SPECIAL	5
1	-	690517-1	SPACER	4
1	-	690588-1	CRIMPER, INSULATION	3
1	-	690716-3	CRIMPER, WIRE	2
1	-	692134-7	POSITIONER, TERMINAL	1

QTY	U/M	PART NO	DESCRIPTION	ITEM NO
2	-	3-354779-5	PIN, WIRE DISC (.3165)C	129
2	-	3-354779-0	PIN, WIRE DISC (.3140)B	128
2	-	2-354779-2	PIN, WIRE DISC (.3100)A	126
1	-	986950-1	WASHER, FLAT PRECISION	125
1	-	1-21030-2	PIN, DOWEL (Ø.187X.62)	124
1	-	1-21030-6	PIN, DOWEL (Ø.187X1.25)	123
1	-	217238-1	GENERAL INST PACKAGE	122
2	-	3-21028-2	PIN, SLOTTED SPRING (Ø.094X.25)	121
2	-	4-21028-9	PIN, SLOTTED SPRING (Ø.125X.38)	120
2	-	5-21028-1	PIN, SLOTTED SPRING (Ø.125X.50)	119
1	-	21029-5	PIN, SLOTTED SPRING (Ø.187X.75)	118
1	-	4088037	TAB-LOC™ INST 408-8037	117
1	-	21899-4	WASHER, FLAT (5/16)	116
4	-	21024-4	WASHER, LOCK (#8)	115
2	-	21055-6	WASHER, FLAT (#8)	114
2	-	1-21899-3	WASHER, FLAT (#10)	113
2	-	21024-5	WASHER, LOCK (#10)	112
2	-	18028-2	WASHER, FLAT (M4) COUNTER	111
2	-	994991-5	SCR, OVAL HD (M4X12) COUNTER	110
1	-	1-22202-7	NUT, HEX (5/16-24)	109
1	-	21022-3	NUT, HEX (LOCKING) (10-32)	108
1	-	21018-5	NUT, HEX (6-32)	107
2	-	21045-3	RING, RET "C" (Ø.187) FD PIN	106
1	-	8-21007-5	SCREW, SKT SET (5/16-24x.75)	105
7	-	2-22733-8	SCREW, BHC (1/4-20X.63)	104
1	-	1804303-1	BRACKET, COUNTER MTG	103
1	-	21009-2	SCREW, SKT SET (1/4-20x.25)	102
1	-	1804300-1	APPLICATOR COUNTER ASSY	101
1	-	3-21000-9	SCREW, SHC (10-32X1.00)	100
4	-	3-21000-8	SCREW, SHC (10-32X.88)	99
2	-	3-21000-6	SCREW, SHC (10-32X.62)	98
1	-	3-21000-4	SCREW, SHC (10-32X.38)	97
2	-	7-21000-6	SCREW, SHC (10-32X.38)	96
2	-	2-21000-6	SCR, SHC (8-32X.38) COUNTER	95
2	-	4-21006-0	SCREW, SKT SET (8-32X.25)	94
1	-	21061-9	SCREW, SKT SET (8-32X.25)	93
2	-	9-21000-3	SCREW, SHC (8-32X2.00)	92
4	-	2-21000-9	SCREW, SHC (8-32X.75)	91
2	-	1-23030-1	SCREW, SHC (NYLOK) (8-32X.62)	90
4	-	2-21000-8	SCREW, SHC (8-32X.62)	89
2	-	2-21000-8	SCREW, SHC (8-32X.62)	88
1	-	2-21002-1	SCREW, SBHC (8-32X.38)	87
1	-	6-23715-5	SCR, PAN HD (6-32x1.50) FEED ADJ	86
1	-	23030-1	SCREW, SHC (NYLOK) (6-32X.25)	85
2	-	22593-1	NUT, HEX JAM (1/4-20) BRACKET	84
1	-	1804310-1	MAGNET, RING	83
1	-	3-21081-2	SCR, SHC (1/4-20X1.00) BRACKET	82
1	-	1804318-1	BRACKET, MAGNET HOLDER	81
2	-	21024-3	WASHER, LOCK (#6) BRACKET	80
2	-	2-21000-0	SCR, SHC (6-32X.50) BRACKET	79
2	-	21017-2	SCR, DRIVE (#2X.19) ID	78
1	-	461264-1	PLATE, IDENTIFICATION	77
1	-	690603-1	SPRING, ASSIST	76
1	-	458109-1	WASHER, SPECIAL	75
1	-	690517-1	SPACER	74
1	-	690588-1	CRIMPER, INSULATION	73
1	-	690716-3	CRIMPER, WIRE	72
1	-	692134-7	POSITIONER, TERMINAL	71



- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 4. DO NOT EXCEED 80 C.P.M. WITH THIS APPLICATOR.
- 5. 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.

THIS DRAWING IS A CONTROLLED DOCUMENT.

TE Connectivity
 Harrisburg, PA 17105-3608

END FEED HINGE BAR APPLICATOR

SCALE: NTS SHEET 1 OF 1