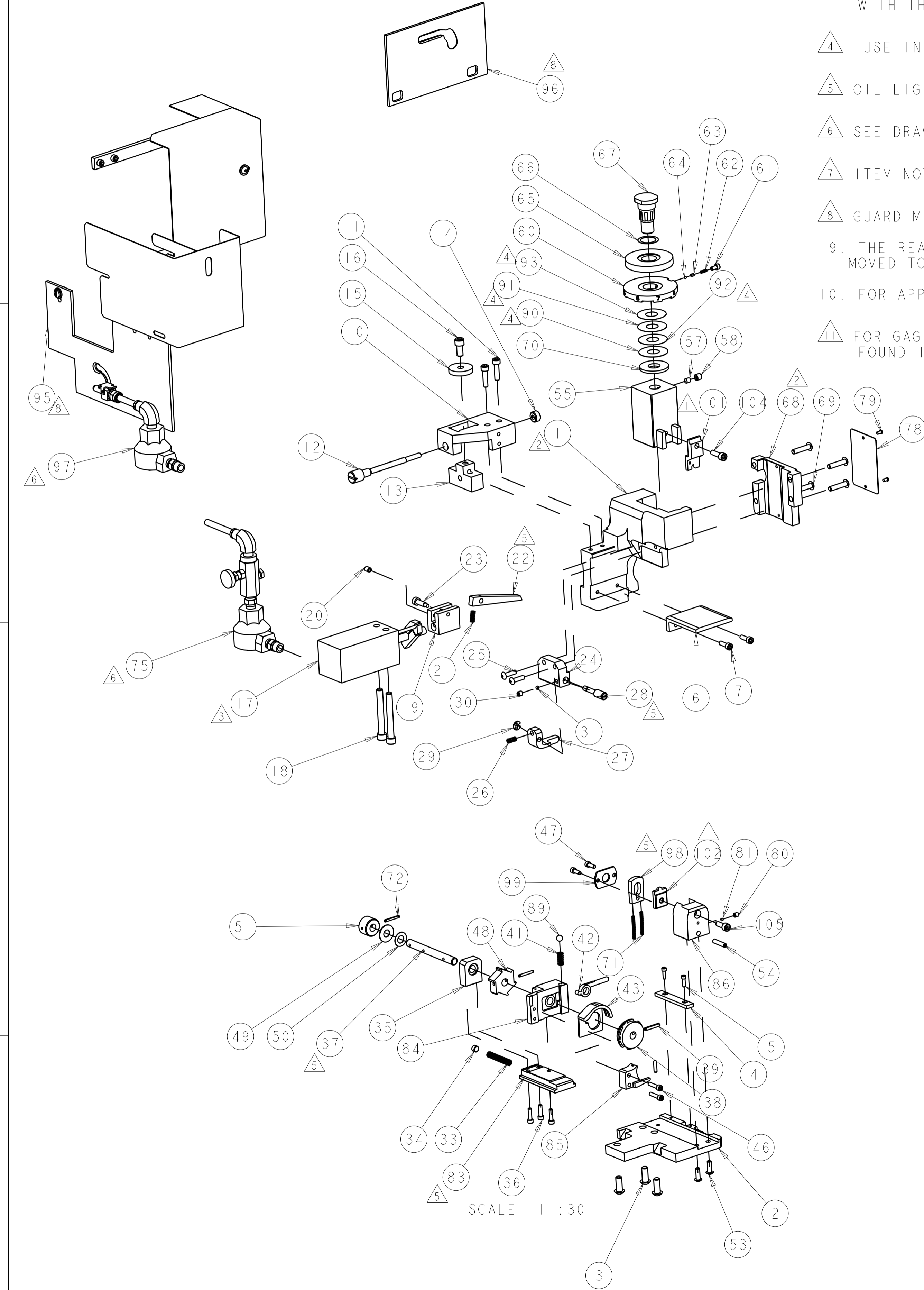


PART NUMBER	REV	FIRST USED	MACHINE	FEED
680643-2	G	565435-5	BENCH MODEL K	AIR FEED
680643-3	G	354500-1	BENCH MODEL G	AIR FEED



- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 ITEM 17, AIR CYLINDER, SHOULD BE ROTATED 90 DEG. WITH THE PORT UP FOR -3 ONLY.
- 4 USE IN COMBINATION TO ACHIEVE PROPER CRIMP HEIGHT.
- 5 OIL LIGHTLY.
- 6 SEE DRAWING FOR COMPONENTS.
- 7 ITEM NOT SHOWN ON ASSEMBLY.
- 8 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR.
- 9. THE REAR HOLD-DOWN ON THE TERMINATING UNIT MUST BE MOVED TO THE FRONT OF THE BASE PLATE. FOR (-3) ONLY.
- 10. FOR APPLICATION TO INSULATION .080-.115 DIA. (UNSTRIPPED).
- 11 FOR GAGING OF THE CRIMPING CHAMBER, REFER TO DIE NUMBER 68166-1 FOUND IN FIGURE 11-2.

TERMINAL NAME, SPARE WIRE CAP
2-324485-1
APPL INSTRUCTION 408-8082 408-2254
LAYOUT L2086
APPL SPECIFICATION

LOC	DIST	REV	DATE	BY	CHK	APPV
A	66					

QTY	UNIT	DESCRIPTION	ITEM NO
1	1	- 459663-5 DISC, WIRE CRIMP	65
1	1	- 23241-6 BALL, STEEL	64
1	1	- 690603-1 SPRING ASSIST AMP-O-MATOR APPLICATOR	63
1	1	- 690170-1 SPRING, COMPRESSION	62
1	1	- 1-21000-8 SCR, SKT HD CAP 6-32 X .250	61
1	1	- 690142-1 DISC, INSULATION	60
1	1	- 21007-2 SCR, SET, CUP POINT 1/4-20 X .250	58
1	1	- 690191-4 PLUG, NYLON	57
1	1	- 356249-1 RAM	55
1	1	- 4-21006-6 SCR, SET, CUP POINT 8-32 X .750	54
2	2	- 2-21002-2 SCR, BTN SKT HD CAP 8-32 X .500	53
1	1	- 809701-1 KNOB, INDEX	51
1	1	- 1-24088-6 WASHER, CURVED	50
1	1	- 1-24001-1 RACE, THRUST BEARING	49
1	1	- 809702-1 WHEEL, INDEX	48
2	2	- 1-21000-9 SCR, SKT HD CAP 6-32 X .375	47
2	2	- 2-21000-1 SCR, SKT HD CAP 6-32 X .625	46
1	1	- 809693-1 DRAG, TAPE	43
1	1	- 809695-1 LIFTER, DRAG	42
1	1	- 2-22280-7 SPRING, COMPRESSION	41
1	1	- 5-21028-5 PIN, SLOTTED SPRING .125 X .750	39
1	1	- 459668-1 WHEEL, TAPE FEED	38
1	1	- 809697-1 SHAFT, INDEX	37
3	3	- 2-21000-0 SCR, SKT HD CAP 6-32 X .500	36
1	1	- 809698-1 SUPPORT, BEARING	35
1	1	- 809700-1 RETAINER, SPRING	34
1	1	- 3-22280-7 SPRING, COMPRESSION	33
1	1	- 690191-3 PLUG, NYLON	31
1	1	- 4-21006-9 SCR, SET, CUP POINT 10-32 X .188	30
1	1	- 1-21986-1 RING, RETAIN, EXTERN, 3/16 E-RING	29
1	1	- 809704-1 SCREW, ADJ.	28
1	1	- 356251-1 STRIPPER, UPPER	27
1	1	- 1-22279-6 SPRING, COMPRESSION	26
2	2	- 2-21002-3 SCR, BTN SKT HD CAP 8-32 X .625	25
1	1	- 809686-1 MOUNT, STRIPPER	24
1	1	- 5-21005-8 SCREW, SHLD, SOC HD SELF-LOCKING, PATCH TYPE	23
1	1	- 809688-1 PAWL, INDEX	22
1	1	- 4-22279-4 SPRING, COMPRESSION	21
1	1	- 5-21006-0 SCR, SET, CUP POINT 10-32 X .250	20
1	1	- 809687-1 CLEVIS, CYLINDER	19
2	2	- 1-21001-0 SCR, SKT HD CAP 1/4-20 X 2.000	18
1	1	- 1490794-1 CYLINDER, AIR, 1" STROKE, S.A.	17
1	1	- 21001-2 SCR, SKT HD CAP 1/4-20 X .500	16
1	1	- 376165 CLAMP WASHER	15
1	1	- 22292-2 COLLAR, SHAFT	14
1	1	- 376166 FEED ADJUSTMENT BLOCK	13
1	1	- 376169 FEED ADJUSTING SCREW, AIR FEED	12
2	2	- 3-21000-7 SCR, SKT HD CAP 10-32 X .750	11
1	1	- 809689-1 MOUNT, CYLINDER (CAST COMPLETE)	10
2	2	- 2-21000-7 SCR, SKT HD CAP 8-32 X .500	7
1	1	- 809690-1 GUIDE, TERMINAL	6
2	2	- 1-21000-4 SCR, SKT HD CAP 4-40 X .375	5
1	1	- 809696-1 RETAINER, SLIDE	4
3	3	- 2-22733-8 SCR, BHSC, SELF-LOCKING, 1/4-20 X .625	3
1	1	- 809684-1 PLATE, BASE	2
1	1	- 809707-1 HOUSING	1

1	1	- 3-21000-5 SCR, SKT HD CAP 10-32 X .500	105
1	1	- 3-21000-6 SCR, SKT HD CAP 10-32 X .625	104
1	1	- 307924-2 ANVIL	102
1	1	- 307923-2 INDENTER	101
1	1	- 356253-1 PLATE, RETAINER	99
1	1	- 356252-1 STRIPPER, LOWER	98
1	-	- 692655-7 AIR FEED VALVE ASSEMBLY	97
1	-	- 318708-1 CLEAR POLYCARBONATE	96
1	-	- 1-462992-5 GUARD, ASSY, SIDE FEED DUAL	95
1	-	- 854061-2 DOCUMENTATION PACKAGE	94
1	1	- 469367-4 SHIM	93
1	1	- 469367-3 SHIM	92
1	1	- 469367-2 SHIM	91
1	1	- 469367-1 SHIM	90
1	1	- 23241-3 BALL, STEEL	89
1	1	- 356250-4 HOLDER, LOWER TOOL	86
1	1	- 820840-1 GUIDE, TAPE	85
1	1	- 820839-1 HOUSING, TAPE DRAG	84
1	1	- 820838-1 SLIDE, RETRACT	83
1	1	- 690191-5 PLUG, NYLON	81
1	1	- 3-21006-9 SCR, SET, CUP POINT 8-32 X .188	80
2	2	- 21017-2 SCREW, DRIVE	79
1	1	- 461264-1 PLATE, IDENTIFICATION	78
1	1	- 692655-5 AIR FEED VALVE ASSEMBLY	75
2	2	- 4-21028-0 PIN, SLOTTED SPRING .094 X .750	72
2	2	- 4-22278-6 SPRING, COMPRESSION	71
1	1	- 690124-3 WASHER, RAM (.110)	70
4	4	- 3-21002-0 SCR, BTN SKT HD CAP 10-32 X .875	69
1	1	- 454220-7 CAP, RAM	68
1	1	- 690212-1 POST, RAM	67
1	1	- 22480-5 WASHER, WAVE SPRING	66

SCALE 11:30

DIMENSIONS: IN 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.02 2 PLC ±.005 3 PLC ±.005 4 PLC ±.005 ANGLES ±.005	DWG. STAKEM 18JAN2007 CHK. T. ELBIN 18JAN2007 APVD. T. ELBIN 18JAN2007	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009		NAME: TAPE FEED HDM APPLICATOR	
MATERIAL:		SIZE: CAGE CODE: DRAWING NO: A100779C=680643	
FINISH:		WEIGHT:	
RESTRICTED TO:		SCALE: 2:5 SHEET 1 OF 1 REV G	