

1. INSTRUCTION SHEET A18044 MUST ACCOMPANY THIS APPLICATOR.

ITEM 24 459655-2 IS REQUIRED TO APPLY FASTON PRODUCTS.

USE ITEM 20 PN 459655-3 TO APPLY BUTT SPLICES. THIS ITEM NOT SUPPLIED WITH APPLICATOR.

THESE FUNNELS ARE AVAILABLE TO AID WIRE INSERTION WHEN USED ON THE AOM CLS MACHINE. USE 815459-1 FOR 22-18 AWG PRODUCT AND 815459-2 FOR 16-14 AWG PRODUCT.

CUT TUBING TO 16 & 12 INCH SECTIONS.

INSTALL SPACERS, ITEM 76, AS REQUIRED AT ASSEMBLY BETWEEN ITEMS 39 AND 44 TO LIMIT PLAY IN LOWER SLIDE ASSEMBLY TO .006 MAX.

INSTALL ITEM 126 WHEN RUNNING 12-10 AWG SOLISTRAND PRODUCT.

WHEN RUNNING 12-10 BUTT SPLICES, REMOVE ITEM 20, PN 459655-3, AND INSTALL ITEMS 127 AND 128 INTO ITEM 55. THE 2ND 6-32 HEX NUT IS TO SECURE THE URETHANE PAD TO THE HEAD OF THE SCREW.

WHEN RUNNING 16-14 PIDG FASTON, P/N 640905-2, REMOVE ITEMS 9, 24, 25, 121, AND 122 AND INSTALL ITEMS 126, 127, 128. ADJUST HEIGHT OF 127 AND LOCK WITH 128. THESE ARE USED TO REDUCE TERMINAL TWISTING.

ITEM 127 MAY NEED TO BE ADJUSTED WHEN SWITCHING TERMINALS.

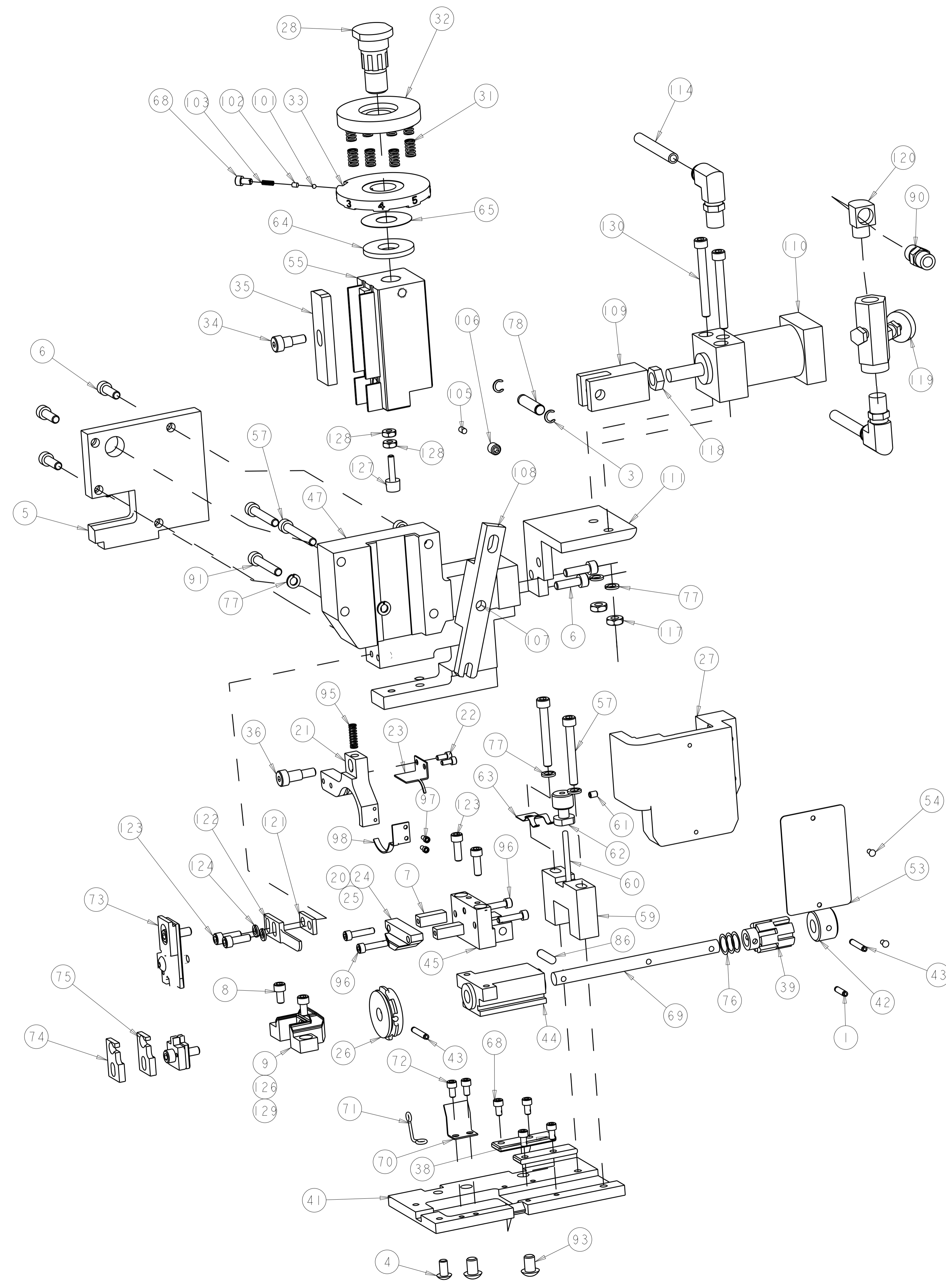
2	-	4-21000-2	SCR, SKT HD CAP 10-32 X 1.750	130
REF	-	318318-3	TOOL HOLDER, LOWER	129
2	-	21018-5	NUT, HEX, REG 6-32	128
1	-	811242-2	BUMPER, HOLD DOWN	127
REF	-	318318-2	TOOL HOLDER, LOWER	126
2	-	21024-4	WASHER, SPRG LOCK, REG NO 8	124
4	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	123
1	-	240639-3	STRIPPER (MACHINING)	122
1	-	1-690451-8	SPACER, STRIPPER	121
1	-	22306-1	ELBOW, STREET, 90° 1/8 NPT	120
1	-	23054-1	VALVE, FLOW CONTROL	119
1	-	22202-3	NUT, HEX, JAM 5/16-18UNC	118
2	-	21018-7	NUT, HEX, REG 10-32	117
28	IN	27319-4	TUBING, POLY-FLO, NATURAL	114
2	-	23238-1	INSERT, COUPLING	113
2	-	980285-2	CONNECTOR, ELBOW, 90°, MINI	112
1	-	257434-1	SUPPORT, AIR CYLINDER	111
1	-	28560-1	AIR CYLINDER DOUBLE ACTING	110
1	-	818317-1	CLEVIS	109
1	-	257435-1	ARM	108
1	-	2-21030-6	PIN, DOWEL .2500 X 1.500	107
1	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	106
1	-	690191-1	PLUG, NYLON	105
1	-	690170-1	SPRING, COMPRESSION	103
1	-	690603-1	SPRING ASSIST AMP-O-MATOR APPLICATOR	102
1	-	23241-6	BALL, STEEL	101
1	-	459647-1	GUIDE, TAPE	98
2	-	21000-9	SCR, SKT HD CAP 2-56 X .188	97
4	-	23030-4	SCR, SKT HD CAP, S-LOCK, 6-32 X .625	96
1	-	3-22279-2	SPRING, COMPRESSION	95
2	-	3-21002-2	SCR, BTN SKT HD CAP 1/4-20 X .375	93
3	-	4-21000-0	SCR, SKT HD CAP 10-32 X 1.250	91
1	-	22304-1	NIPPLE, HEX, PIPE FITTING	90

LOC	DIST	REV	DATE	BY	APPV
A	66				
AR	ECR-08-016422		28JUN2008	MY	GB
AS	ECR-09-010088		04MAY2009	MY	GB
AS1	ECR-12-016502		20SEP2012	L.Z	S.X
AS2	ECR-19-000483		11JAN2019	FZ	KZ

1	-	1-21030-3	PIN, DOWEL .1875 X .750	86
1	-	4-23620-3	PIN, RETAIN, GRVD, 1/4 X 1.050	78
8	-	21024-5	WASHER, SPRG LOCK, REG NO 10	77
3	-	1-24954-2	SPACER, SHIM	76
REF	-	815459-2	FUNNEL, WIRE	75
REF	-	815459-1	FUNNEL, WIRE	74
1	-	SEE CHART	DIE, ASSEMBLY	73
2	-	1-21000-8	SCR, SKT HD CAP 6-32 X .250	72
1	-	459648-1	SPRING, TERM. EJECT	71
1	-	459645-1	PLATE, TERMINAL EJECT	70
1	-	459650-1	SHAFT	69
5	-	23030-1	SCR, SKT HD CAP, S-LOCK, 6-32 X .25	68
1	-	690125-1	SHIM SUB-ASSY	65
1	-	690124-1	WASHER, RAM (.115)	64
1	-	459667-1	SPRING	63
1	-	459658-1	KNOB, TERMINAL, FEED	62
1	-	2-21006-8	SCR, SET, CUP POINT 6-32 X .188	61
1	-	21030-8	PIN, DOWEL .1250 X 1.500	60
1	-	459657-1	BLOCK, PIN, MOUNTING	59
3	-	4-21000-1	SCR, SKT HD CAP 10-32 X 1.500	57
1	-	459672-1	RAM	55
2	-	21017-2	SCREW, DRIVE	54
1	-	461264-1	PLATE, IDENTIFICATION	53
1	-	459674-1	HOUSING APPLICATOR	47
1	-	459649-1	BLOCK, PIVOT MOUNT	45
1	-	459646-1	BLOCK, SLIDE	44
2	-	5-21028-5	PIN, SLOTTED SPRING .125 X .750	43
1	-	459651-1	KNOB, HAND	42
1	-	459670-1	BASE PLATE, APPLICATOR (CLOSED BARREL MINI-APPLICATOR)	41
1	-	459652-1	CAM, BARREL	39
2	-	459656-1	GIB	38
1	-	21004-1	SCR, SKT HD SHLDR 1/4 DIA X .375	36
1	-	459662-1	SLIDE, INSULATION CRIMPER	35
1	-	5-21004-7	SCR, SKT HD SHLDR 1/4 DIA X .250	34
1	-	690142-1	DISC, INSULATION	33
1	-	459663-1	DISC, WIRE CRIMP	32
8	-	2-22280-5	SPRING, COMPRESSION	31
1	-	690212-1	POST, RAM	28
1	-	459666-1	CAP, RAM	27
1	-	459668-1	WHEEL, TAPE FEED	26
1	-	459655-1	STOP, TERMINAL	25
1	-	459655-2	STOP, TERMINAL	24
1	-	459644-1	STRIPPER, TAPE	23
2	-	1-21000-3	SCR, SKT HD CAP 4-40 X .250	22
1	-	459671-1	RETAINER, TAPE CLOSED BARREL MINI-APPLICATOR	21
REF	-	459655-3	STOP, TERMINAL	20
1	-	318318-1	TOOL HOLDER, LOWER	9
2	-	7-21000-4	SCR, SKT HD CAP 8-32 X .312	8
2	-	459654-1	SPACER	7
6	-	3-21000-6	SCR, SKT HD CAP 10-32 X .625	6
1	-	459659-1	PLATE, SUPPORT	5
1	-	2-21002-6	SCR, BTN SKT HD CAP 10-32 X .375	4
2	-	21045-6	RING, RETAIN, EXTERN, 1/4 CRESCENT	3
1	-	5-21028-1	PIN, SLOTTED SPRING .125 X .500	1
-1	U/M	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: IN 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWG: STAKEM 23FEB2007 CHK: T. ELBIN 23FEB2007 APPV: T. ELBIN 23FEB2007	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		PRODUCT SPEC: APPLICATION SPEC: 114-2157	NAME: CLOSED BARREL MINI APPLICATOR CLOSED BARREL
WEIGHT:		SCALE: 7:60		SHEET 1 OF 2	REV: AS2

LOC	DIST	REVISIONS				
A	66	P. LTH	DESCRIPTION	DATE	OWN	APVD
-	-	SEE SHEET 1				



APPLICATORS SET UPS						
PRODUCT TYPE	DIE SET NO	DIE MARK	TERMINAL STOP	ACCESSORIES	REMARKS	
RING SPADES AND PIDG BUTT SPLICE PIDG PLASTI-GRIP	26-22 YELLOW	69877	YELLOW	459655-1 (SUPPLIED W/687658-1) **459655-3	FUNNELS 815459-1(22-18) 815459-2(16-14)	
	24-20 WHITE	69878	WHITE			
	22-16 RED	59826-1*/69872	RED			
	16-14 BLUE	59827-1*/69873	BLUE			
	12-10 YELLOW	59828-1*/69874	YELLOW			
FASTON PIDG	26-24 YELLOW	69877-2	YELLOW	459655-2 (SUPPLIED W/687658-1)	FUNNELS 815459-1(22-18) 815459-2(16-14)	
	22-18 CLEAR	90248-2				
	22-18 RED	59826-1*	RED			
	16-14 BLUE	59827-1*	BLUE			
	14-12 GREEN	90240-2				
BUTT SPLICES PLASTI-GRIP	26-22 YELLOW	69877	YELLOW	459655-3	FUNNELS 815459-1(22-18) 815459-2(16-14)	
	24-20 WHITE	69878	WHITE			
	22-16 RED	69872	RED			
	16-14 BLUE	69873	BLUE			
LARGE EXPANSION PLASTI-GRIP AND PIDG	12-10 YELLOW	69874	YELLOW	459655-4	904438-1 GUIDE 904707-1 HOLDER	
	12-10 YELLOW	69897	BLACK/ YELLOW			
RING SPADES SOLISTRAND	22-18	68240-1		459655-1 (SUPPLIED W/687658-1)	FUNNELS 852426-3(22-18) 852426-1(16-14) 852426-2(12-10)	
	16-14	68241-1				
	12-10	68242-1				
RING SPADES BUDGET	22-18	68259-1		459655-1 (SUPPLIED W/687658-1)	FUNNELS 852426-3(22-18) 852426-1(16-14) 852426-2(12-10)	
	16-14	68094				
	12-10	68260-2				
.156 SERIES, SHUR PLUG, RECEPTACLE, FULLY INSULATED	16-14 BLUE	59827-2	BLUE	REMOVE TERMINAL STOP	690455-2 STRIPPER	REMOVE 240639-1 AND REPLACE WITH 690455-2

* TETRI-CRIMP DIE CONFIGURATION.
 ** REQUIRED FOR PIDG BUTT SPLICES ONLY.

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DIMENSIONS: IN	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±. FINISH	NAME: CLOSED BARREL MINI APPLICATOR CLOSED BARREL SIZE: 114-2157 WEIGHT: A100779C=687658 Customer Drawing	RESTRICTED TO: AS2
SCALE: 7:10		SHEET 2 OF 2	