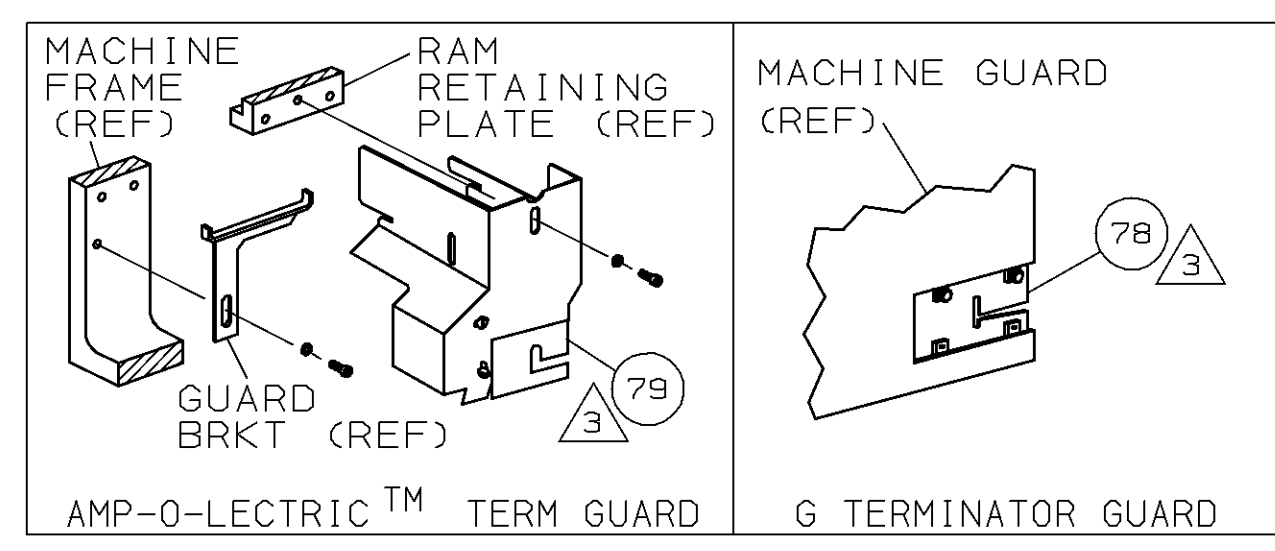
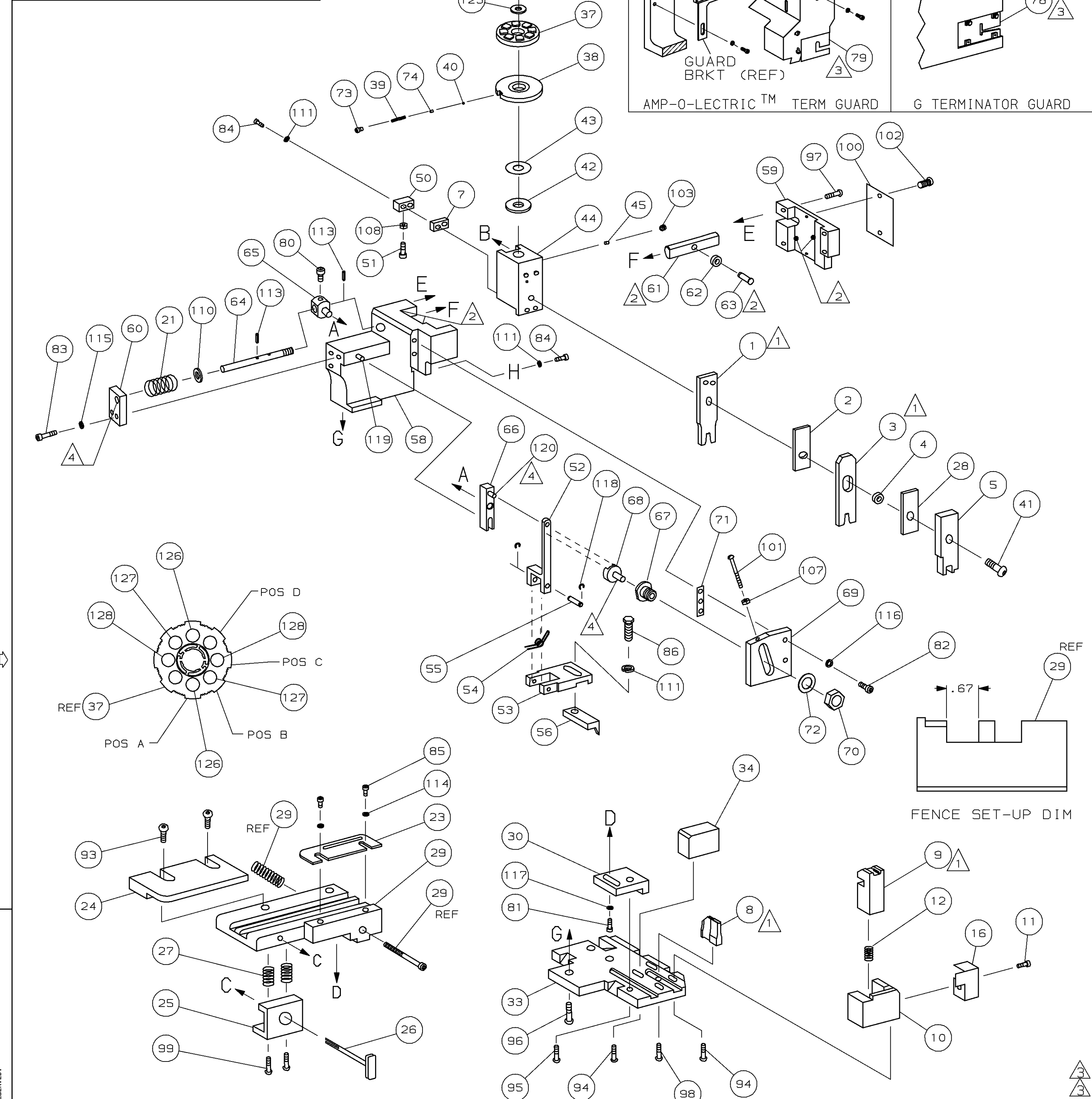


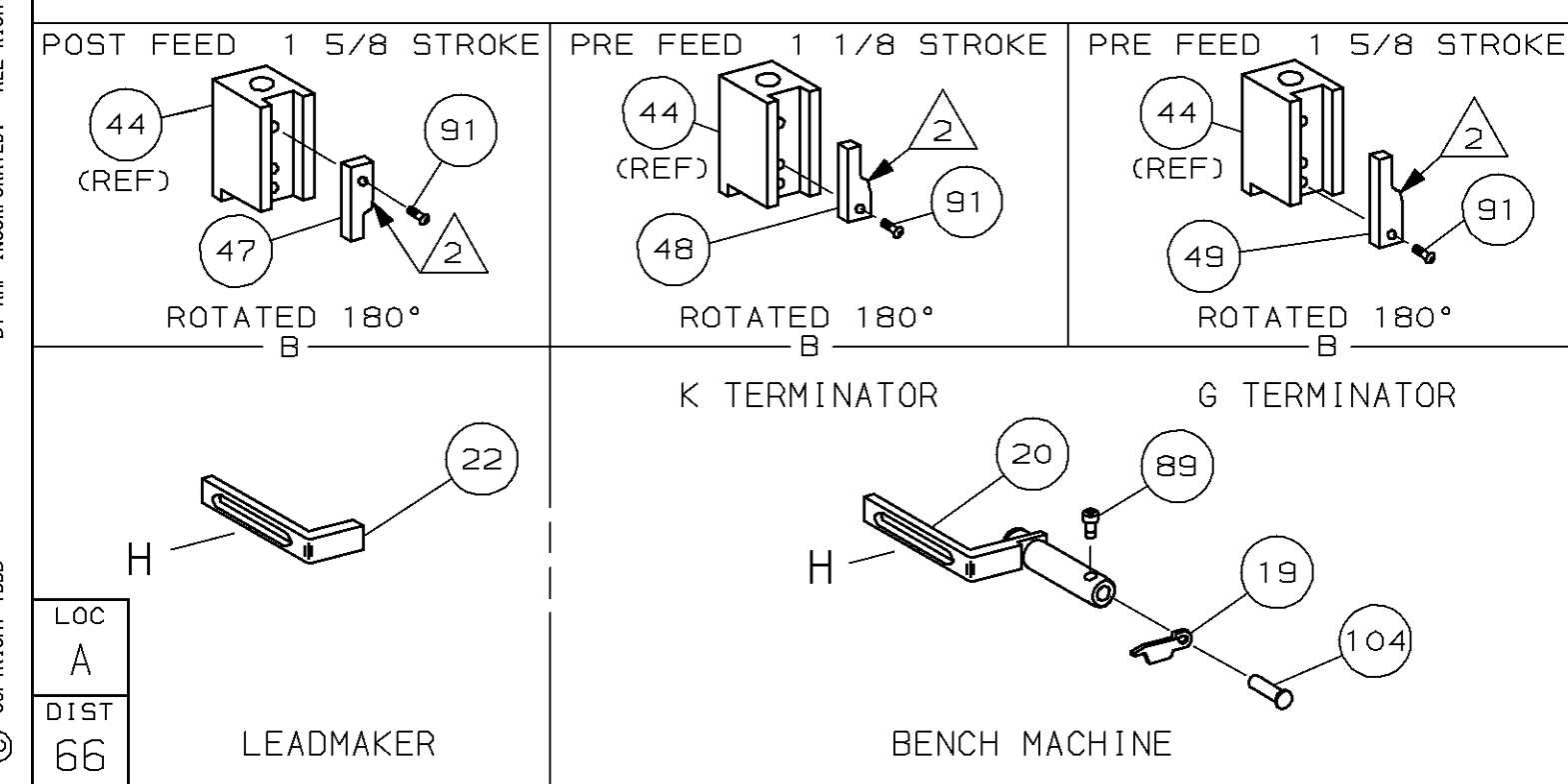
PART NUMBER	REV	FIRST USED
680752-1	A	122500-1
680752-2	A	565435-5
680752-3	A	354500-1



TERMINAL NAME: 2.8 MM TAB WITH DOUBLE LOCKING LANCE			
962881 CRIMP DATA (AMP TERMINAL)			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.077 ±.002 [1.96 ±0.05mm]	2.5mm ²	
B	.072 ±.002 [1.83 ±0.05mm]	2mm ²	
C	.066 ±.002 [1.68 ±0.05mm]	1.5mm ²	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.110 [2.79mm]	F	16-12
INSUL	.155 [3.94mm]	0	ø3.4mm

QTY REQD PER ASSY	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT	ITEM NO	
.188-.219	114-2065	.570	408-8040	458637-1	L2177	129	
2	2	2	-	C	354779-2	PIN, WIRE DISC (.3000)C 128	
2	2	2	-	C	8-354778-9	PIN, WIRE DISC (.2940)B 127	
2	2	2	-	C	7-354778-9	PIN, WIRE DISC (.2890)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	
REF	REF	REF	-	A	1-21030-1	PIN, DOWEL (ø.187x.50) LEVER 120	
REF	REF	REF	-	A	1-21030-6	PIN, DOWEL (ø.187x1.25) HOUSING 119	
REF	REF	REF	-	A	21045-3	RING, RET "C" (ø.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 (ø.125x.50) ADJ ROD 113	
4	4	4	-	A	21024-4	WASHER, LOCK (#8) STRIPPER 111	
REF	REF	REF	-	A	21899-4	WASHER, FLAT (ø5/16) SCREW ADJ 110	
1	1	1	-	A	21018-5	NUT, HEX (NO. 6) HOLDDOWN 109	
REF	REF	REF	-	A	21068-5	NUT, HEX (6-32) FEED ADJ 107	
1	1	1	-	A	992031-1	PIN, CLEVIS 104	
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	
2	2	2	-	A	2-21002-2	SCR, BHC (8-32x) R STP GDE 93	
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38) CAM 91	
1	1	1	-	A	7-21000-9	SCR, SHC (4-40x.19) STRIPPER 89	
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	
3	3	3	-	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	690517-1	SPACER 71	
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

- 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.



-1 LEADMAKER				MECH POST FEED			
-2 BENCH MODEL K				MECH PRE FEED			
-3 BENCH MODEL G				MECH PRE FEED			
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	690542-2	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	455679-2	LEVER, TERMINAL FEED ARM	52
1	1	1	-	A	811242-2	BUMPER, HOLDDOWN	51
1	1	1	-	A	690753-1	SPACER, TONKER	50
1	-	-	-	B	690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	1	-	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST	48
-	-	-	-	B	690501-4	CAM, POST-FEED 1 5/8 ST	47
1	1	1	-	B	459456-2	APPLICATOR, BASIC (SUBASSY)	46
1	1	1	-	A	690191-1	PLUG, NYLON	45
1	1	1	-	C	819307-5	RAM	44
1	1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	1	-	A	690124-1	WASHER, RAM	42
1	1	1	-	A	7-21002-9	BOLT, STRIPPER (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
1	1	1	-	B	690786-3	SUPPORT, TERMINAL	34
REF	REF	REF	-	D	455675-1	PLATE, BASE	33
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	C	318756-1	STRIP GUIDE PLATE ASSY	29
1	1	1	-	C	2-455888-1	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	8-690504-6	GUIDE, STRIP (REAR)	24
1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
-	-	1	-	B	690472-2	STRIPPER	22
REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	21
1	1	1	-	A	679218-1	STRIPPER WIRE STOP ASSY	20
1	1	1	-	B	458949-1	STRIPPER	19
1	1	1	-	B	318563-1	GUARD, CHIP, FRONT	16
1	1	1	-	A	5-22280-0	SPRING, SHEAR	12
1	1	1	-	B	690461-1	STOP, SHEAR	11
1	1	1	-	C	690459-1	HOLDER, SHEAR (FRONT)	10
1	1	1	-	C	454276-1	SHEAR, FLOAT (FRONT)	9
1	1	1	-	C	1-662189-3	ANVIL	8
1	1	1	-	C	1-240641-3	SPACER, DEPRESSOR (REAR)	7
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	238011-2	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	1-456135-0	CRIMPER, INSULATION	3
1	1	1	-	C	1-455888-8	SPACER, CRIMPER	2
1	1	1	-	C	456408-2	CRIMPER, WIRE	1
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED.		MATERIAL		FINISH	
DR	16NOV98	APP	16NOV98	HT TR	FIN
P. Mathias		T. ELBIN			
CHK	16NOV98	REL			
C. ERISMAN					
NAME: SIDE FEED HDM APPLICATOR MACHINE REF: MINI APPL					
SCALE:	DWG NO:	680752	SHEET:	1 OF 1	REV: A
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX					
CAGE CODE: 00779 CUSTOMER AND ASSEMBLY DRAWING					

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Jan 19, 1999

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