

PART NUMBER	REV	FIRST USED	
680834-1	H	122500-1	T-UNIT
680834-2	J	680017-4	K-UNIT
680834-3	H	354500-1	G-UNIT

REVISIONS					
P	LTR	DESCRIPTION	DATE	DRN	APVD
J		REVISED -2, ECR-22-143319	22JUN2022	GK	GB

- 1 RECOMMENDED SPARE PARTS
- 2 ITEMS NOT SHOWN
- 3 TOL ±.25
- 4 TO RUN THIS APPLICATOR ON THE AMPOMATOR SEE DOC. PACKAGE ITEM 146.
- 5 USE SEALANT PN 1-23419-5 AS SHOWN
- 6 CANNOT RUN 2 WIRES ON LEADMAKER.
- 7. SPRING LOADED TONKER (P/N 354853-1) MUST BE USED WHEN RUNNING THE APPLICATOR ON A LEADMAKER.
- 8 FOR INSULATION DIAMETER OF .108"-.118" REPLACE ITEM #98 WITH OVERLAP INSULATION CRIMPER PN 3-318903-4

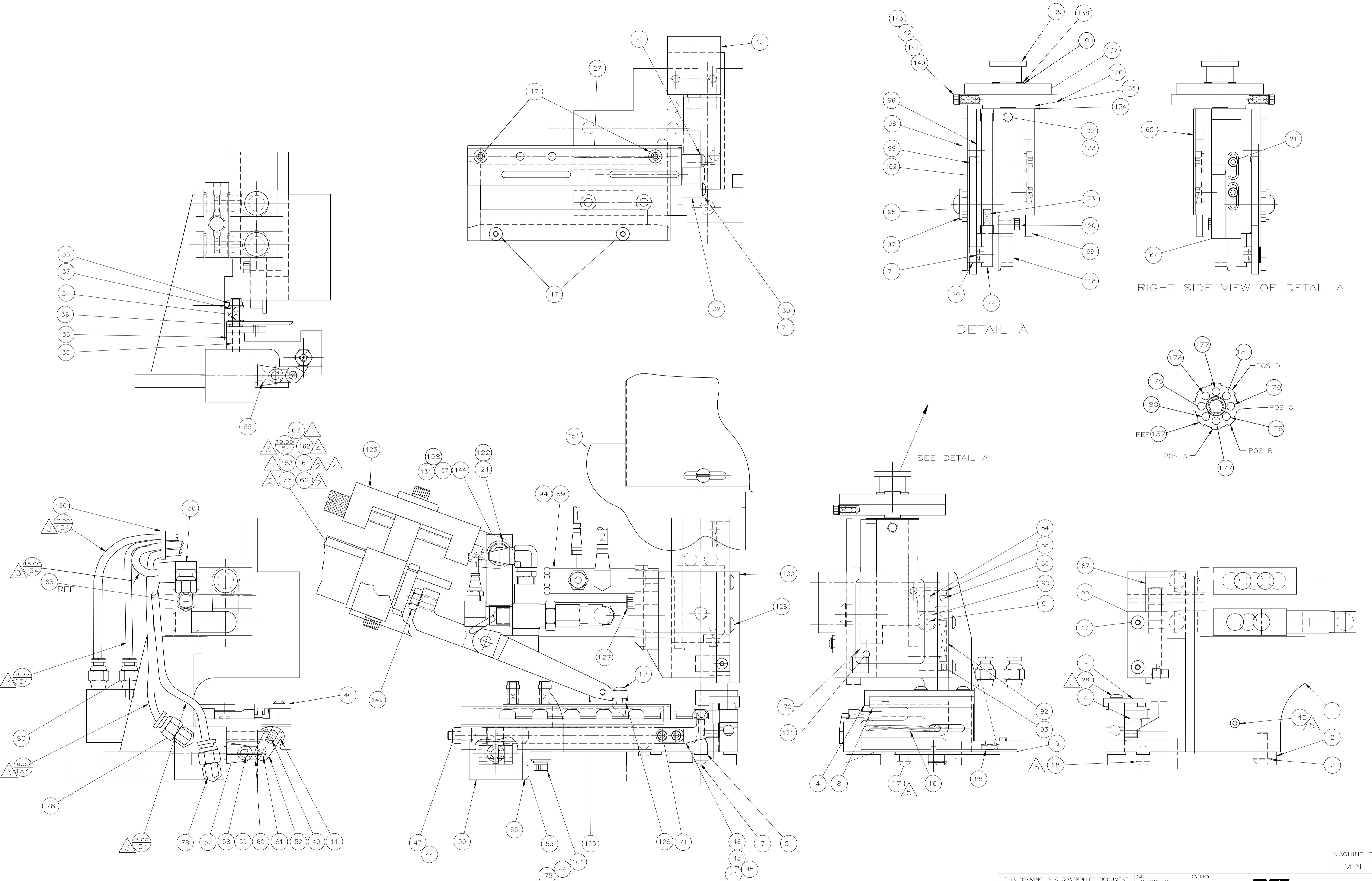
CRIMPING DATA				THIS APPLICATOR WILL APPLY
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	STRIP LENGTH	TERMINAL P/N
A	.073	#14	.231-.234	521217
B	.068	2 #18	.231-.234	521451
C	.064	#16	.231-.234	521747
D	.058	#18/20	.231-.234	
CRIMP	SIZE TYPE	FEED		
WIRE	.110 F	.770		
INS.	.210 F			
INSULATION RANGE	WIRE RANGE	TERM APPL SPEC		
.130-.180	18-14	AI SHEET 8095 & 8098		

QTY	REQD	PER	ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
1	1	1	-	A		986950-1	WASHER, FLAT PRECISION	181
2	2	2	-	C		2-354779-6	PIN, WIRE DISC (.3120)D	180
2	2	2	-	C		1-354779-1	PIN, WIRE DISC (3045)C	179
2	2	2	-	C		354779-3	PIN, WIRE DISC (.3005)B	178
2	2	2	-	C		9-354778-1	PIN, WIRE DISC (.2950)A	177
								176
2	2	2	-	A		21026-4	WASHER, STAR	175
								174
								173
REF	-	-	-	A		679532-1	INSERT, GUARD	172
2	2	2	-	A		21017-2	SCR., DRIVE 2 X .19	171
1	1	1	-	A		461264-1	TAG, IDENTIFICATION	170
								169
								168
								167
								166
								165
								164
								163
								162
								161
								160
								159
2	2	2	-	A		21024-5	WASHER, LOCK, #10	158
2	2	2	-	C		4-21000-3	SHCS, 10-32 X 2.00	157
								156
								155
80	68	68	IN	A		27319-4	TUBING,NYLON .250 DIA	154
2	1	2	-	A		23238-1	INSERT,COUPLING	153
								152
								151
								150
								149
1	1	1	-	A		1-21018-6	NUT, HEX, 5/16-24	148
								147
								146
1	1	1	-	A		21007-8	SCR,SOC,SET(1/4-20X.63)	145
1	1	1	-	B		459610-3	MOUNT,FEED BRACKET	144
1	1	1	-	A		23241-6	BALL,STEEL	143
1	1	1	-	A		690603-1	SPRING,ASSIST	142
1	1	1	-	A		690170-1	SPRING, COMPRESSION	141
-3	-2	-1	U/M					

QTY	REQD	PER	ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
1	1	1	-	A		23030-1	SCR,SOC HD CAP 6-32 X .25 LG	140
1	1	1	-	B		690212-1	POST, RAM	139
1	1	1	-	A		22480-5	WASHER, SPRING	138
1	1	1	-	C		354777-1	DISC,WIRE	137
1	1	1	-	C		690142-1	DISC, INSULATION	136
1	1	1	-	A		690124-9	WASHER, RAM	135
1	1	1	-	A		690125-1	WASHER,LAMINATED	134
1	1	1	-	A		21009-2	SCR,SOC SET 1/4-20 X .25 LG	133
1	1	1	-	A		690191-1	PLUG,NYLON	132
1	1	1	-	A		461690-1	SPACER	131
								130
								129
								128
								127
								126
								125
								124
								123
								122
								121
2	2	2	-	A		1-23030-2	SCR,SOC,HD.8-32X.75 LOK-WEL	120
								119
								118
								117
								116
								115
								114
								113
								112
								111
								110
								109
								108
								107
								106
								105
								104
								103
1	1	1	-	C		455888-8	SPACER,CRIMPER	102
2	2	2	-	A		3-21000-5	SCR. SOC HD 10-32 X .50	101
1	1	1	-	B		454220-1	CAP, RAM	100
1	1	1	-	C		3-456408-3	CRIMPER, WIRE	99
1	1	1	-	C		6-456134-7	CRIMPER,INS "F"	98
1	1	1	-	A		238009-1	BLOCK, CRIMPER SPACER	97
1	1	1	-	C		1-455888-6	SPACER,CRIMPER	96
1	1	1	-	A		7-21002-7	SCR.,BUT. HD.5/16 UNF-24 X .75	95
								94
1	1	1	-	A		1-22183-7	PIN, GROOVE TYP 67 .125 DIA X .63	93
1	1	1	-	A		2-22286-2	SPRING, EXT. LE-031B-2	92
1	1	1	-	A		1-21919-1	PIN,DOWEL .094 DIA X .375	91
1	1	1	-	A		852281-2	ROLLER	90
1	1	1	-	D		354385-2	PNEUMATIC ASSY	89
1	1	1	-	B		852287-1	PLATE, RETAINER	88
1	1	1	-	B		852286-1	LATCH, INSERT	87
2	2	2	-	A		852521-1	PIN, DOWEL MOD. .094 DIA X .49	86
1	1	1	-	B		852284-1	ARM, LATCH	85
1	1	1	-	A		1-21030-7	PIN, DOWEL .188 DIA X 1.50	84
								83
								82
								81
2	2	2	-	A		980282-3	CONNECTOR,MALE 1/8NPTX.25	80
								79
3	2	3	-	A		980285-2	ELBOW,MALE,SWIVEL 1/8 X .25T	78
								77
								76
								75
1	1	1	-	B		852247-1	SLIDE,STRIPPER	74
1	1	1	-	A		4-22279-9	SPRING, COMP. LC-026B-9	73
								72
5	5	5	-	A		22733-3	SCR,BUT HD CP 6-32 X .25 LOK-WEL	71
-3	-2	-1	U/M					

QTY	REQD	PER	ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
1	1	1	-	A		852248-1	STRIPPER	70
1	1	1	-	B		852245-2	CAM, INSERT	69
								68
1	1	1	-	B		852246-1	CAM,VALVE	67
								66
1	1	1	-	D		856287-1	RAM	65
								64
								63
								62
								61
								60
4	4	4	-	A		21045-3	CRESCENT RING	59
1	1	1	-	A		4-23619-0	PIN,GROOVED, .188 DIA	58
1	1	1	-	B		852296-1	CLEVIS	57
								56
5	5	5	-	A		6-21002-1	SCR,BHC (10-24X.25)AIR CYL	55
								54
1	1	1	-	B		852323-2	MOUNT,AIR CYL.	53
1	1	1	-	B		852297-1	ARM,PIVOT	52
1	1	1	-	C		856265-2	ANVIL	51
1	1	1	-	A		985314-1	AIR CYL., 3/4 BORE X 7/16 ST.	50
1	1	1	-	C		852295-1	ROD,BACKUP	49
								48
1	1	1	-	A		21021-4	NUT,FLEXLOC 10-32	47
1	1	1	-	C		1-852294-0	BACKUP, TERMINAL .160	46
1	1	1	-	C		1-852294-1	BACKUP, TERMINAL .140	45
3	3	3	-	A		21899-2	WASHER, FLAT	44
1	1	1	-	C		1-852294-2	BACKUP, TERMINAL .120	43
								42
1	1	1	-	C		1-852294-3	BACKUP, TERMINAL .187	41
1	1	1	-	C		852250-5	GUIDE,FRONT STRIP	40
2	2	2	-	A		22354-6	STUD,8-32	39
1	1	1	-	B		852251-3	DRAG	38
2	2	2	-	A		2-22280-5	SPRING, COMP. LC-032C-6	37
2	2	2	-	A		21022-2	NUT,FLEXLOC 8-32	36
1	1	1	-	B		90594-1	GUIDE, REAR STRIP	35
4	4	4	-	A		1-21899-3	WASHER FLAT #8	34
								33
1	1	1	-	B		90591-2	SHEAR, LEFT	32
								31
1	1	1	-	B		853981-2	SHEAR, RIGHT	30
								29
4	4	4	-	A		2-21002-2	SCR., BUT.HD. 8-32X.50	28
1	1	1	-	D		856231-2	PLATE, STRIP GUIDE	27
								26
								25
								24
								23
								22
3	4	3	-	A		23030-2	SCR. SOC.HD. 6-32X.38 LOK-WEL	21
								20
								19
								18
13	13	13	-	A		2-21002-1	SCR, BHC 8-32 x .38	17
								16
								15
								14
1	1	1	-	A		354993-1	AIR CYL 1 1/8 X .63	13
								12
1	1	1	-	A		5-21028-1	PIN, SPRING .125 DIA x .50	11
1	1	1	-	A		1-23470-7	SPRING, COMP. LC-035C-19	10
1	1	1	-	B		90777-1	GIB, HOUSING	9
1	1	1	-	D		318198-2	INSERTOR, POD	8
1	1	1	-	A		22733-8	SCR.,BUT.HD.8-32X.38	7
1	1	1	-	D		90775-2	HOUSING, INSERT SLIDE	6
								5
1	1	1	-	B		1338955-4	HOLDDOWN, FIXED	4
3	3	3	-	A		2-22733-8	SCR. BUT HD 1/4-20 X .62	3
1	1	1	-	D		314866-3	PLATE, BASE	2
1	1	1	-	D		852221-2	HOUSING, APPLICATOR	1
-3	-2	-						

REVISIONS				
P	LTR	DESCRIPTION	DATE	APPV
-	SEE SHEET 1		-	-



THIS DRAWING IS A CONTROLLED DOCUMENT.		DIN C. ERISMAN 22JUN99												
DIMENSIONS: INCHES		CHK C. ERISMAN 22JUN99												
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPV T. ELBIN 22JUN99	NAME ULTRA-POD APPLICATOR .250 STRAIGHT											
<table border="1"> <tr> <td>0. PLC</td> <td>± .0005</td> </tr> <tr> <td>1. PLC</td> <td>± .001</td> </tr> <tr> <td>2. PLC</td> <td>± .002</td> </tr> <tr> <td>3. PLC</td> <td>± .005</td> </tr> <tr> <td>4. PLC</td> <td>± .010</td> </tr> </table>		0. PLC	± .0005	1. PLC	± .001	2. PLC	± .002	3. PLC	± .005	4. PLC	± .010	APPLICATION SPEC		RESTRICTED TO
0. PLC	± .0005													
1. PLC	± .001													
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3. PLC	± .005													
4. PLC	± .010													
MATERIAL		WEIGHT	SIZE A1	CAGE CODE 00779										
FINISH		DRAWING NO. C=680834		SCALE 1:1										
CUSTOMER DRAWING		SHEET 2 OF 2		REV J										

CUSTOMER AND ASSEMBLY DRAWING