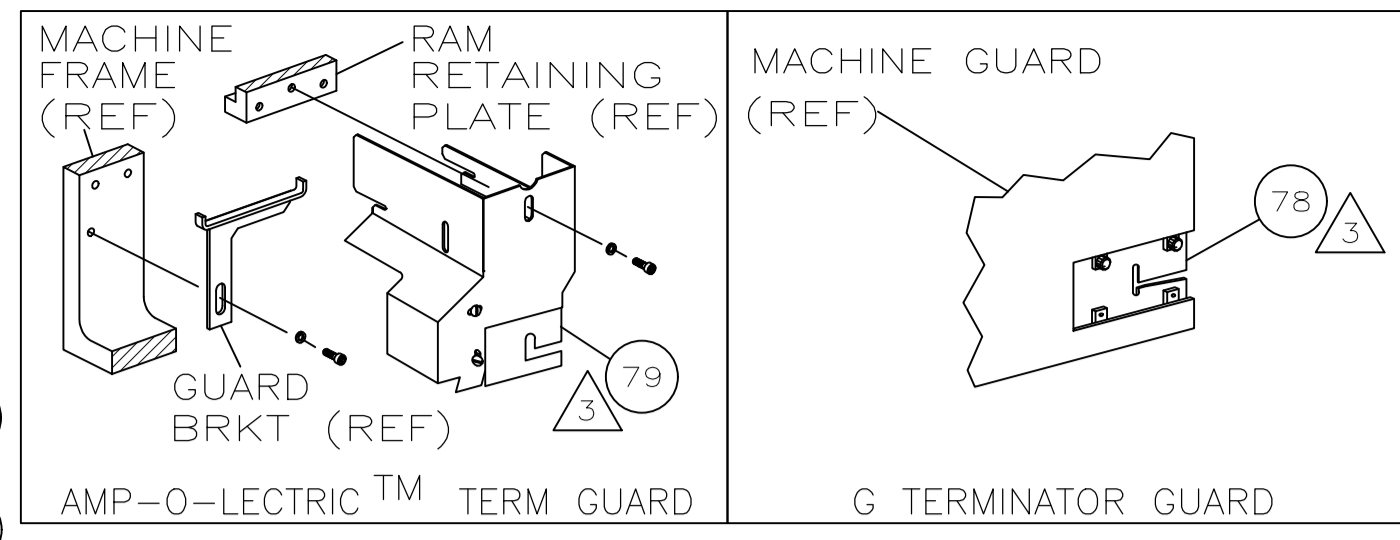


| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------|
| 466571-1 | U | 854400-1 |
| 466571-2 | U | 565435-5 |
| 466571-3 | | DUAL HDM |
| 466571-4 | U | 354500-1 |
| 7-466571-7 | T | |

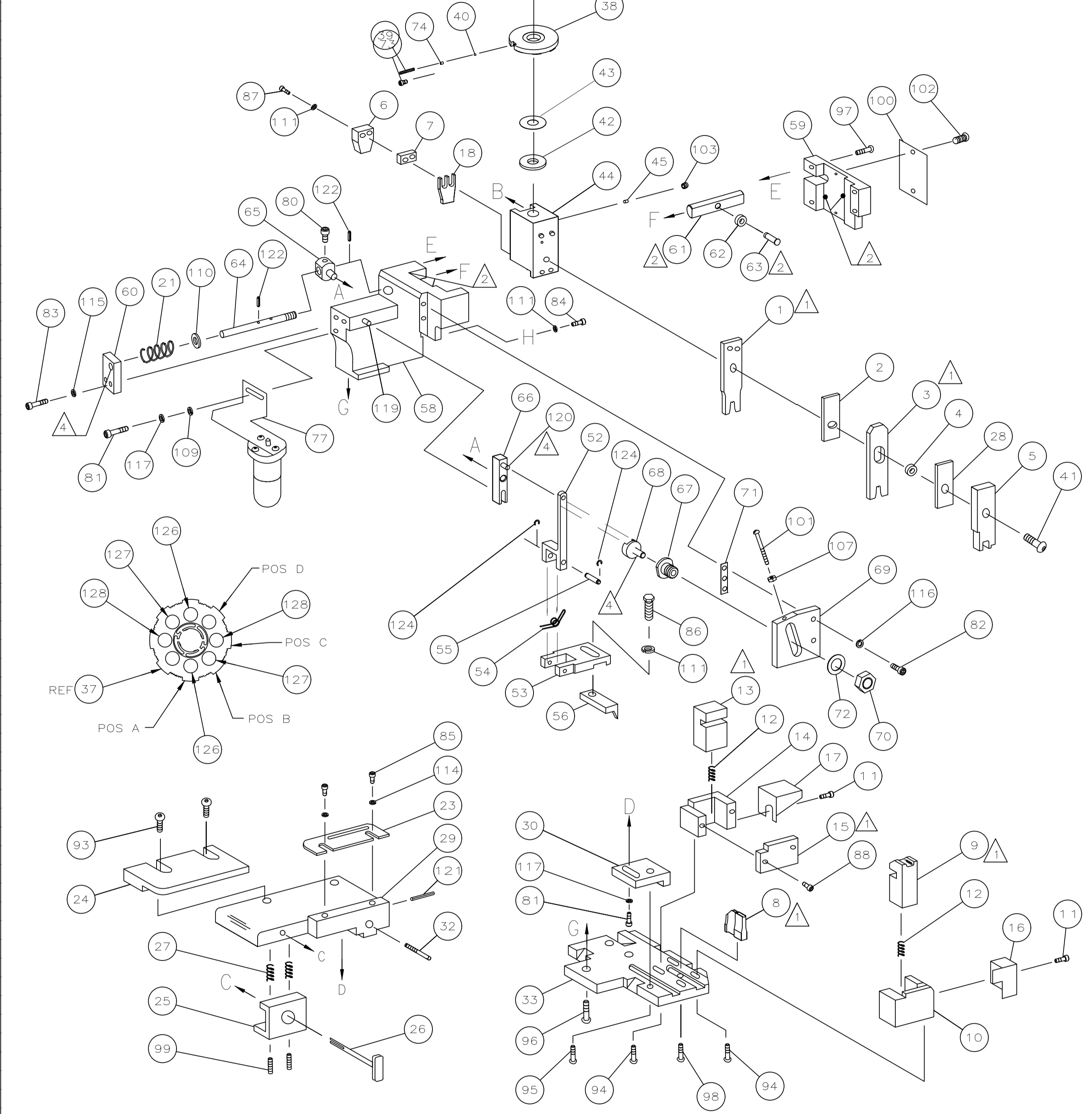
SUPERSEDED BY 2151307-1
 SEE DRAWING 466571-3
 SUPERSEDED BY 2151307-1



| TERMINAL NAME: MOD IV FEMALE CONTACT | | CRIMPING DATA | | | |
|---|--------|-----------------------------|--------------|-----------------------|------------------------------------|
| | 87666 | PAD LTR | CRIMP HEIGHT | WIRE SIZE | |
| | 87756 | A | .036 ±.002 | 22 | |
| | 87809 | B | .032 ±.002 | 24 | |
| | 102548 | C | .030 ±.002 | 26 | |
| | 103171 | D | NOT | USED | |
| | | CRIMP | SIZE | TYPE | RANGE |
| | | WIRE | .042 | F | 26-22 |
| | | FEED | .300 | APPL INST 408-8040 | SET UP GAGE LAYOUT 458637-1 893 |
| TERM APPL SPEC 114-25003 | | WIRE STRIP LENGTH .109-.172 | | | |

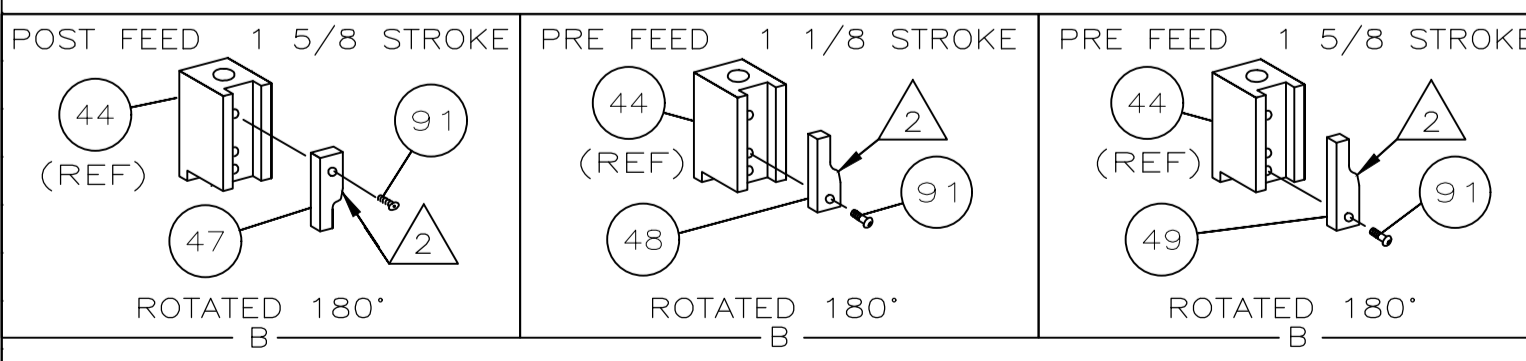
| REVISIONS | | | | | |
|-----------|-----|---------------------------|-----------|----|------|
| P | LTR | DESCRIPTION | DATE | DN | APVD |
| U2 | | REVISED PER ECR-20-012011 | 25AUG2020 | GK | GB |

| | | | | |
|----|---------------|----------------|-----|-------------------|
| -1 | LEADMAKER | MECH POST FEED | -77 | SPARE TOOLING KIT |
| -2 | BENCH MODEL K | MECH PRE FEED | | |
| -4 | BENCH MODEL G | MECH PRE FEED | | |

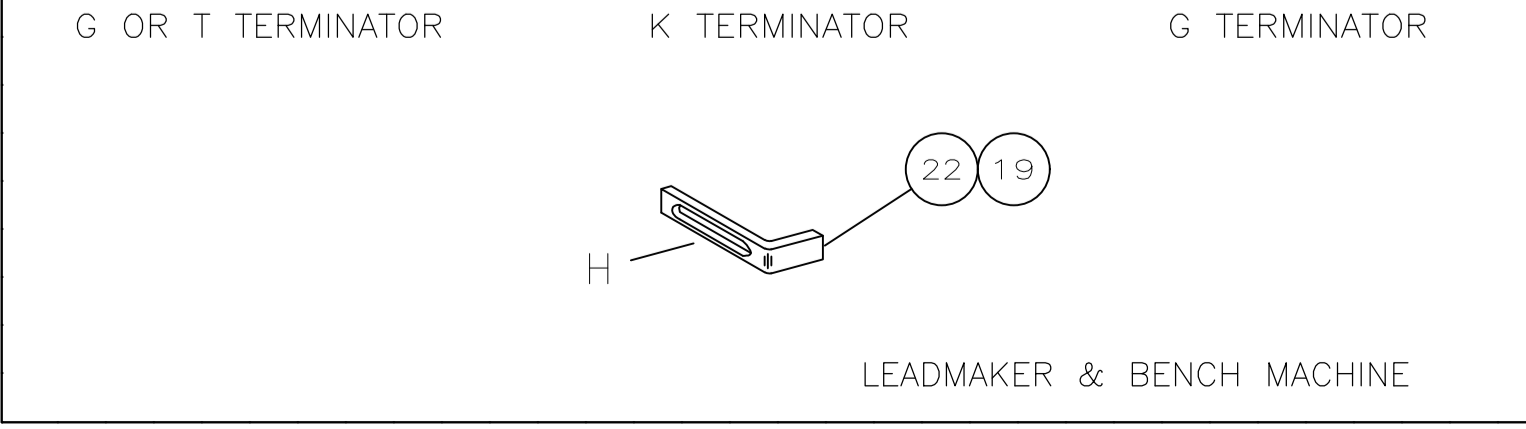


| | | | | | | | | | |
|-------------------|-----|------------|-----|----|------------|----------------------------------|---------|------------|--|
| - | 2 | 2 | 2 | - | 6-354779-2 | PIN, WIRE DISC (.3300)C | 129 | | |
| - | 2 | 2 | 2 | - | 6-354779-0 | PIN, WIRE DISC (.3290)B | 128 | | |
| - | 2 | 2 | 2 | - | 5-354779-0 | PIN, WIRE DISC (.3240)A | 126 | | |
| - | 1 | 1 | 1 | - | 986950-1 | WASHER, FLAT PRECISION | 125 | | |
| - | REF | REF | REF | - | 21045-3 | RING, RET "C"(Ø.187)FD FING PIN | 124 | | |
| - | REF | REF | REF | - | | | 123 | | |
| - | REF | REF | REF | - | 5-21028-1 | PIN, SLT SPR(Ø.125x.50)ADJ ROD | 122 | | |
| - | 1 | 1 | 1 | - | 4-21028-0 | PIN, SLT SPR(Ø.093x.75)ST GDE PL | 121 | | |
| - | REF | REF | REF | - | 1-21030-1 | PIN, DOWEL(Ø.187x.50)LEVER | 120 | | |
| - | REF | REF | REF | - | 1-21030-6 | PIN, DOWEL(Ø.187x1.25)HOUSING | 119 | | |
| - | | | | | | | 118 | | |
| - | 1 | 2 | 1 | - | 21024-5 | WASHER, LOCK(#10)ADJ BLOCK | 117 | | |
| - | REF | REF | REF | - | 21024-5 | WASHER, LOCK(#10)ADJ PLATE | 116 | | |
| - | REF | REF | REF | - | 21024-5 | WASHER, LOCK(#10)FEED GDE ROD | 115 | | |
| - | 2 | 2 | 2 | - | 21024-2 | WASHER, LOCK(#4)FRONT STP GUIDE | 114 | | |
| - | | | | | | | 113 | | |
| - | 4 | 4 | 4 | - | 21024-4 | WASHER, LOCK(#8)STRIPPER | 112 | | |
| - | REF | REF | REF | - | 21899-4 | WASHER, FLAT(Ø5/16)SCREW ADJ | 110 | | |
| - | | | | | 21899-2 | WASHER, FLAT(NO.10)LUB ASSY | 109 | | |
| - | | | | | | | 108 | | |
| - | REF | REF | REF | - | 21018-5 | NUT, HEX(6-32)FEED ADJ | 107 | | |
| - | | | | | | | 106 | | |
| - | | | | | | | 105 | | |
| - | | | | | | | 104 | | |
| - | 1 | 1 | 1 | - | 21009-2 | SCR, SKT SET(1/4-20x.25 LW)RAM | 103 | | |
| - | 2 | 2 | 2 | - | 21017-2 | SCR, DRIVE(#2x.19)ID PLATE | 102 | | |
| - | REF | REF | REF | - | 6-23715-5 | SCR, PAN HD(6-32x1.50)FEED ADJ | 101 | | |
| - | 1 | 1 | 1 | - | 461264-1 | PLATE, IDENTIFICATION | 100 | | |
| - | 2 | 2 | 2 | - | 5-21006-6 | SCR, SET(10-32x.75)DRAG | 99 | | |
| - | 1 | 1 | 1 | - | 22733-8 | SCR, BHC(8-32x.38 LW)ANVIL | 98 | | |
| - | REF | REF | REF | - | 2-21002-9 | SCR, BHC(10-32x.75)CAP | 97 | | |
| - | REF | REF | REF | - | 2-22733-8 | SCR, BHC(1/4-20x.62)HOUSING | 96 | | |
| - | REF | REF | REF | - | 2-21002-7 | SCR, BHC(10-32x.50)SG ADJ BLOCK | 95 | | |
| - | 4 | 4 | 4 | - | 2-21002-2 | SCR, BHC(8-32x.50)SHEAR | 94 | | |
| - | 2 | 2 | 2 | - | 2-21002-1 | SCR, BHC(8-32x.38)R STRIP GUIDE | 93 | | |
| - | | | | | | | 92 | | |
| - | 1 | 1 | 1 | - | 1-21002-7 | SCR, BHC(6-32x.38)CAM | 91 | | |
| - | | | | | | | 90 | | |
| - | | | | | | | 89 | | |
| - | 2 | 2 | 2 | - | 1-21000-8 | SCR, SHC(6-32x.25)R SHEAR PLATE | 88 | | |
| - | 2 | 2 | 2 | - | 2-21000-8 | SCR, SHC(8-32x.62)DEP-HOLD | 87 | | |
| - | 1 | 1 | 1 | - | 2-22603-0 | SCR, HEX HD(8-32x.31)FEED FINGER | 86 | | |
| - | 2 | 2 | 2 | - | 1-21000-3 | SCR, SHC(4-40x.25)F ST GUIDE | 85 | | |
| - | 1 | 1 | 1 | - | 2-21000-7 | SCR, SHC(8-32x.50)STRIPPER | 84 | | |
| - | REF | REF | REF | - | 3-21000-7 | SCR, SHC(10-32x.75)FEED ROD GD | 83 | | |
| - | REF | REF | REF | - | 3-21000-6 | SCR, SHC(10-32x.62)FD ADJ BLK | 82 | | |
| - | 1 | 2 | 1 | - | 3-21000-4 | SCR, SHC(10-32x.38)SG ADJ BL | 81 | | |
| - | REF | REF | REF | - | 3-21000-4 | SCR, SHC(10-32x.38)PIVOT BLK | 80 | | |
| - | REF | REF | REF | - | 455749-1 | GUARD, WINDOW | 79 | | |
| - | REF | REF | REF | - | 679532-1 | INSERT, GUARD | 78 | | |
| - | | | | | 1-465184-0 | LUBRICATOR ASSY | 77 | | |
| - | | | | | | | 76 | | |
| - | | | | | | | 75 | | |
| - | 1 | 1 | 1 | - | 690603-1 | SPRING, ASSIST | 74 | | |
| - | 1 | 1 | 1 | - | 23030-1 | SCR, SHC(6-32x.25 SL)INS DISC | 73 | | |
| - | REF | REF | REF | - | 458109-1 | WASHER, SPECIAL | 72 | | |
| - | REF | REF | REF | - | 690517-1 | SPACER | 71 | | |
| - | -77 | -4 | -2 | -1 | U/M | PART NO | ITEM NO | | |
| QTY REQD PER ASSY | | PARTS LIST | | | | QTY REQD PER ASSY | | PARTS LIST | |

| | | | | | | | | | |
|-------------------|-----|------------|-----|-----|------------|-----------------------------|---------|------------|--|
| - | REF | REF | REF | - | 22594-8 | NUT, HEX(1/2-20) | 70 | | |
| - | REF | REF | REF | - | 240628-1 | PLATE, ADJUSTMENT | 69 | | |
| - | REF | REF | REF | - | 240626-1 | SHAFT, PIVOT | 68 | | |
| - | REF | REF | REF | - | 240633-1 | BUSHING | 67 | | |
| - | REF | REF | REF | - | 455680-1 | LEVER, INTERMEDIATE | 66 | | |
| - | REF | REF | REF | - | 240629-1 | BLOCK, PIVOT | 65 | | |
| - | REF | REF | REF | - | 240632-2 | SCREW, ADJ FEED ROD | 64 | | |
| - | REF | REF | REF | - | 240659-3 | PIN, CAM ROLLER | 63 | | |
| - | REF | REF | REF | - | 240658-1 | ROLLER, CAM | 62 | | |
| - | REF | REF | REF | - | 454398-2 | ROD, FEED | 61 | | |
| - | REF | REF | REF | - | 454178-1 | GUIDE, FEED ROD | 60 | | |
| - | REF | REF | REF | - | 454220-1 | CAP, RAM | 59 | | |
| - | REF | REF | REF | - | 454485-1 | HOUSING | 58 | | |
| - | | | | | | | 57 | | |
| - | 1 | 1 | 1 | - | 458537-1 | PAWL, FEED | 56 | | |
| - | REF | REF | REF | - | 240624-1 | PIN, FEED FINGER | 55 | | |
| - | REF | REF | REF | - | 691499-1 | SPRING, FEED FINGER | 54 | | |
| - | REF | REF | REF | - | 690541-1 | HOLDER, FEED FINGER | 53 | | |
| - | REF | REF | REF | - | 455679-1 | LEVER, TERMINAL FEED ARM | 52 | | |
| - | | | | | | | 51 | | |
| - | | | | | | | 50 | | |
| - | 1 | - | - | - | 690602-6 | CAM, PRE-FEED 1 5/8 ST | 49 | | |
| - | - | 1 | - | - | 690602-5 | CAM, PRE-FEED 1 1/8 ST | 48 | | |
| - | - | - | 1 | - | 690501-4 | CAM, POST-FEED 1 5/8 ST | 47 | | |
| - | 1 | 1 | 1 | - | 459456-1 | APPLICATOR, BASIC (SUBASSY) | 46 | | |
| - | 1 | 1 | 1 | - | 690191-1 | PLUG, NYLON | 45 | | |
| - | 1 | 1 | 1 | - | 455673-1 | RAM | 44 | | |
| - | 1 | 1 | 1 | - | 690125-1 | WASHER, LAMINATED | 43 | | |
| - | 1 | 1 | 1 | - | 690124-1 | WASHER, RAM | 42 | | |
| - | 1 | 1 | 1 | - | 7-21002-9 | BOLT, CRIMPER(5/16x1.00) | 41 | | |
| - | 1 | 1 | 1 | - | 23241-6 | BALL, STEEL | 40 | | |
| - | 1 | 1 | 1 | - | 690170-1 | SPRING, COMPRESSION | 39 | | |
| - | 1 | 1 | 1 | - | 690142-3 | DISC, INSULATION | 38 | | |
| - | 1 | 1 | 1 | - | 354777-1 | WIRE DISC, PLASTIC | 37 | | |
| - | 1 | 1 | 1 | - | 22480-5 | WASHER, SPRING | 36 | | |
| - | 1 | 1 | 1 | - | 690212-1 | POST, RAM | 35 | | |
| - | | | | | | | 34 | | |
| - | REF | REF | REF | - | 455675-1 | PLATE, BASE | 33 | | |
| - | 1 | 1 | 1 | - | 690432-3 | SCREW, ADJUSTMENT | 32 | | |
| - | | | | | | | 31 | | |
| - | REF | REF | REF | - | 455689-1 | BLOCK, STRIP GUIDE ADJ | 30 | | |
| - | 1 | 1 | 1 | - | 455671-5 | PLATE, STRIP GUIDE | 29 | | |
| - | 1 | 1 | 1 | - | 1-455888-2 | SPACER, FRONT SHEAR DEP | 28 | | |
| - | 2 | 2 | 2 | - | 1-22284-0 | SPRING, DRAG | 27 | | |
| - | 1 | 1 | 1 | - | 690546-1 | LEVER, DRAG RELEASE | 26 | | |
| - | 1 | 1 | 1 | - | 240792-1 | DRAG, TERMINAL | 25 | | |
| - | 1 | 1 | 1 | - | 6-690504-4 | GUIDE, STRIP (REAR) | 24 | | |
| - | 1 | 1 | 1 | - | 690438-1 | GUIDE, STRIP (FRONT) | 23 | | |
| - | - | - | 1 | - | 690472-2 | STRIPPER | 22 | | |
| - | REF | REF | REF | - | 4-22284-9 | SPRING, FEED RETURN | 21 | | |
| - | | | | | | | 20 | | |
| - | 1 | 1 | - | - | 691353-1 | STRIPPER | 19 | | |
| - | 1 | 1 | 1 | - | 690518-2 | HOLDER, TERMINAL | 18 | | |
| - | 1 | 1 | 1 | - | 691668-1 | GUARD, CHIP (REAR) | 17 | | |
| - | 1 | 1 | 1 | - | 691667-1 | GUARD, CHIP (FRONT) | 16 | | |
| - | 1 | 1 | 1 | - | 1-690691-1 | PLATE, SHEAR (REAR) | 15 | | |
| - | 1 | 1 | 1 | - | 690462-1 | HOLDER, SHEAR (REAR) | 14 | | |
| - | 1 | 1 | 1 | - | 690463-1 | SHEAR, FLOAT (REAR) | 13 | | |
| - | 2 | 2 | 2 | - | 3-22280-3 | SPRING, SHEAR | 12 | | |
| - | 2 | 2 | 2 | - | 690461-1 | STOP, SHEAR | 11 | | |
| - | 1 | 1 | 1 | - | 690459-1 | HOLDER, SHEAR (FRONT) | 10 | | |
| - | 1 | 1 | 1 | - | 462006-1 | SHEAR, FLOAT (FRONT) | 9 | | |
| 1 | 1 | 1 | 1 | - | 4-690512-9 | ANVIL | 8 | | |
| - | 1 | 1 | 1 | - | 240641-5 | SPACER, DEPRESSOR (REAR) | 7 | | |
| - | 1 | 1 | 1 | - | 690468-1 | DEPRESSOR, SHEAR (REAR) | 6 | | |
| - | 1 | 1 | 1 | - | 2-455889-0 | DEPRESSOR, SHEAR (FRONT) | 5 | | |
| - | 1 | 1 | 1 | - | 238011-7 | SPACER, BLOCK CRIMPER | 4 | | |
| 1 | 1 | 1 | 1 | - | 8-456135-3 | CRIMPER, INSULATION | 3 | | |
| - | 1 | 1 | 1 | - | 455888-4 | SPACER, CRIMPER | 2 | | |
| 1 | 1 | 1 | 1 | - | 217885-6 | CRIMPER, WIRE | 1 | | |
| -77 | -4 | -2 | -1 | U/M | PART NO | DESCRIPTION | ITEM NO | | |
| QTY REQD PER ASSY | | PARTS LIST | | | | QTY REQD PER ASSY | | PARTS LIST | |



- 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.

THIS DRAWING IS A CONTROLLED DOCUMENT.

| | | | | | | | |
|--------------------|--|--------------|--------------|--------------|--------------|---------------|---------------|
| DIMENSIONS: INCHES | TOLERANCES UNLESS OTHERWISE SPECIFIED: | 0 PLC ± .005 | 1 PLC ± .003 | 2 PLC ± .002 | 3 PLC ± .001 | 4 PLC ± .0005 | ANGLES ± .005 |
| MATERIAL | FINISH | WEIGHT | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO | |
| | | | A1 | 00779 | 466571 | | |

CUSTOMER DRAWING SCALE - SHEET 1 of 1 REV U2

TE Connectivity
 SIDE FEED HDM APPLICATOR