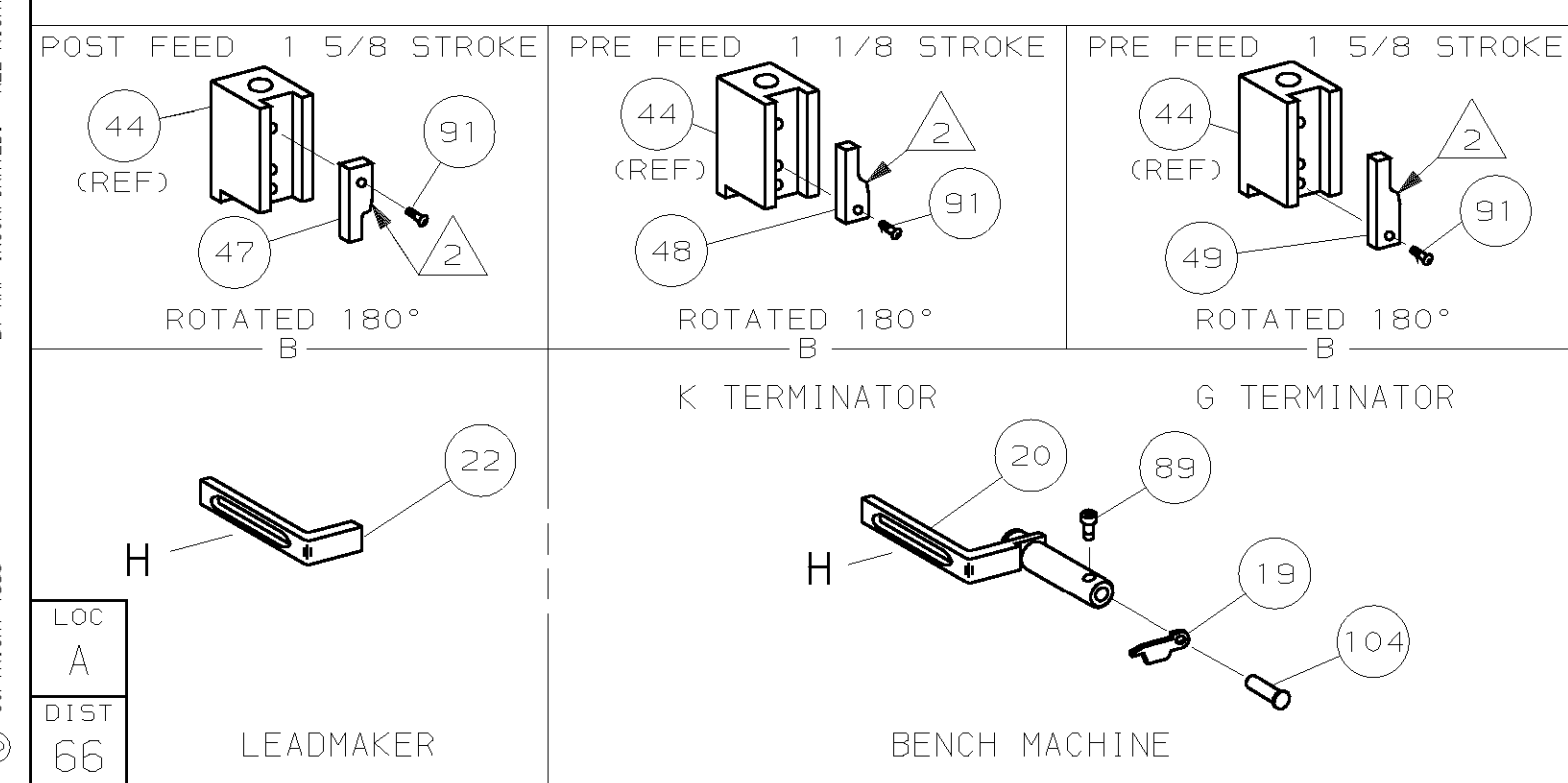
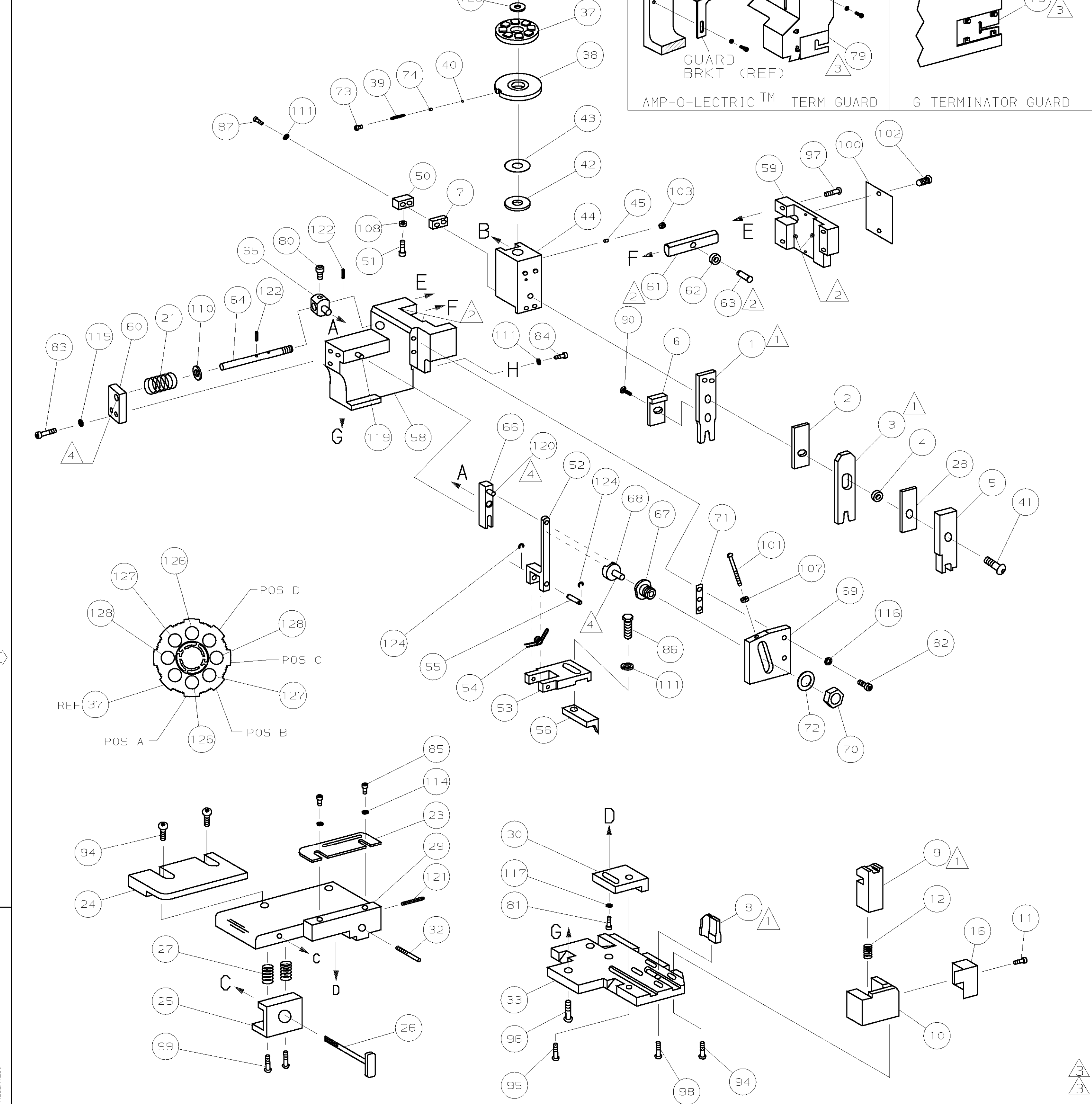


PART NUMBER	REV	FIRST USED
680044-1	G	122500-1
680044-2	G	565435-5
680044-3	G	354500-1



- 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.
- 6 APPLICATOR WILL APPLY ONLY THE DASH NUMBERS LISTED.

TERMINAL NAME: SOCKET CONTACT		CRIMPING DATA	
776235-4		PAD LTR	CRIMP HEIGHT
		A	.054 ±.002 (1.37 ±0.05mm)
		B	.053 ±.002 (1.35 ±0.05mm)
		C	.049 ±.002 (1.24 ±0.05mm)
		D	NOT USED
		CRIMP	SIZE
		WIRE	1.88mm [.074]
		INSUL	2.21mm [.087]
		FEED	8.10mm
		APPL INSTRUCTION	408-8040
		SET UP GAGE	458637-1
		LAYOUT	L1400

QTY	REF	REF	REF	REF	REF	DESCRIPTION	ITEM NO
2	2	2	-	C		2-354779-4	PIN, WIRE DISC (7.9mm)C 129
2	2	2	-	C		1-354779-6	PIN, WIRE DISC (7.8mm)B 127
2	2	2	-	C		1-354779-4	PIN, WIRE DISC (7.7mm)A 126
1	1	1	-	A		986950-1	WASHER, FLAT PRECISION 125
REF	REF	REF	-	A		21045-3	RING, RET "C" (Ø.187)FD FING PIN 124
REF	REF	REF	-	A		5-21028-1	PIN, SLT SPR (Ø.125x.50)ADJ ROD 123
1	1	1	-	A		4-21028-0	PIN, SLT SPR (Ø.093x.75)ST GDE PL 121
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
1	1	1	-	A		21024-5	WASHER, LOCK (#10)ADJ BLOCK 118
REF	REF	REF	-	A		21024-5	WASHER, LOCK (#10)ADJ PLATE 117
REF	REF	REF	-	A		21024-5	WASHER, LOCK (#10)FEED GDE ROD 116
2	2	2	-	A		21024-2	WASHER, LOCK (#4)FRONT STP GUIDE 115
4	4	4	-	A		21024-4	WASHER, LOCK (#8)STRIPPER 114
REF	REF	REF	-	A		21899-4	WASHER, FLAT (Ø5/16)SCREW ADJ 113
1	1	1	-	A		21018-5	NUT, HEX (NO. 6)HOLDDOWN 109
REF	REF	REF	-	A		21018-5	NUT, HEX (6-32)FEED ADJ 108
1	1	1	-	A		992031-1	PIN, CLEVIS 107
1	1	1	-	A		21009-2	SCR, 5KT SET (1/4-20x.25 LW)RAM 106
2	2	2	-	A		21017-2	SCR, DRIVE (#2x.19)ID PLATE 105
REF	REF	REF	-	A		6-23715-5	SCR, PAN HD (6-32x1.50)FEED ADJ 104
1	1	1	-	B		461264-1	PLATE, IDENTIFICATION 103
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)5G ADJ BLOCK 95
4	4	4	-	A		2-21002-2	SCR, BHC (8-32x.50)TERM H DWN 94
1	1	1	-	A		1-21002-7	SCR, BHC (6-32x.38)CAM 93
1	1	1	-	A		1-21003-8	SCR, FHC (6-32x.25)DEPRESSOR 92
1	1	1	-	A		7-21000-9	SCR, SHC (4-40x.19)STRIPPER 91
2	2	2	-	A		2-21000-8	SCR, SHC (8-32x.62)DEP-HOLD 88
1	1	1	-	A		2-22603-0	SCR, HEX HD (8-32x.31)FEED FINGER 87
2	2	2	-	A		1-21000-3	SCR, SHC (4-40x.25)F ST GUIDE 86
1	1	1	-	A		2-21000-7	SCR, SHC (8-32x.50)STRIPPER 85
REF	REF	REF	-	A		3-21000-7	SCR, SHC (10-32x.75)FEED ROD 6D 84
REF	REF	REF	-	A		3-21000-6	SCR, SHC (10-32x.62)ADJ BLK 83
1	1	1	-	A		3-21000-4	SCR, SHC (10-32x.38)5G ADJ BL 82
REF	REF	REF	-	A		3-21000-4	SCR, SHC (10-32x.38)PIVOT BLK 81
-	REF	-	-	B		455749-1	GUARD, WINDOW 80
REF	-	-	-	B		679532-1	INSERT, GUARD 79
1	1	1	-	A		690603-1	SPRING, ASSIST 78
1	1	1	-	A		23030-1	SCR, SHC (6-32x.25 SL)INS DISC 77
REF	REF	REF	-	A		458109-1	WASHER, SPECIAL 76
REF	REF	REF	-	A		690517-1	SPACER 75
-3	-2	-1	U/M	DWG SIZE		PART NO	DESCRIPTION
							ITEM NO

QTY	REF	REF	REF	REF	REF	DESCRIPTION	ITEM NO
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		455679-1	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
-	-	-	-	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		459456-1	APPLICATOR, BASIC (SUBASSY) 46
1	1	1	-	A		690191-1	PLUG, NYLON 45
1	1	1	-	C		455673-1	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, CRIMPER (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		690142-5	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
REF	REF	REF	-	D		455675-1	PLATE, BASE 34
1	1	1	-	A		690432-3	SCREW, ADJUSTMENT 33
REF	REF	REF	-	B		455689-1	BLOCK, STRIP GUIDE ADJ 30
1	1	1	-	C		455671-1	PLATE, STRIP GUIDE 29
1	1	1	-	C		455888-4	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		6-690504-8	GUIDE, STRIP (REAR) 24
1	1	1	-	A		690438-1	GUIDE, STRIP (FRONT) 23
-	-	-	-	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		691667-1	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		462006-2	SHEAR, FLOAT (FRONT) 9
1	1	1	-	C		1-854014-7	ANVIL 8
1	1	1	-	C		2-240641-4	SPACER, DEPRESSOR (REAR) 7
1	1	1	-	A		856692-1	DEPRESSOR, WIRE 6
1	1	1	-	C		2-455889-0	DEPRESSOR, SHEAR (FRONT) 5
1	1	1	-	B		238011-7	SPACER, BLOCK CRIMPER 4
1	1	1	-	C		4-683454-7	CRIMPER, INSULATION 3
1	1	1	-	C		1-455888-0	SPACER, CRIMPER 2
1	1	1	-	C		856313-1	CRIMPER, WIRE 1
-3	-2	-1	U/M	DWG SIZE		PART NO	DESCRIPTION
							ITEM NO

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680044

B

A

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED:  
 2 PLC DEC ±  
 3 PLC DEC ±  
 4 PLC DEC ±  
 ANGLES ±  
 SURF TEXTURE: ✓  
 REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL - HT TR - FIN -

DR L. COLLINS 5/25/95 APP T. BEDDICK 5-30-95  
 CHK 5-30-95 REL 6/21/95 B. MORGAN

NAME: SIDE FEED HDM APPLICATOR MACHINE REF: MINI APPL  
 SCALE: DWG NO: 680044 SHEET: 1 OF 1 REV: G1

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