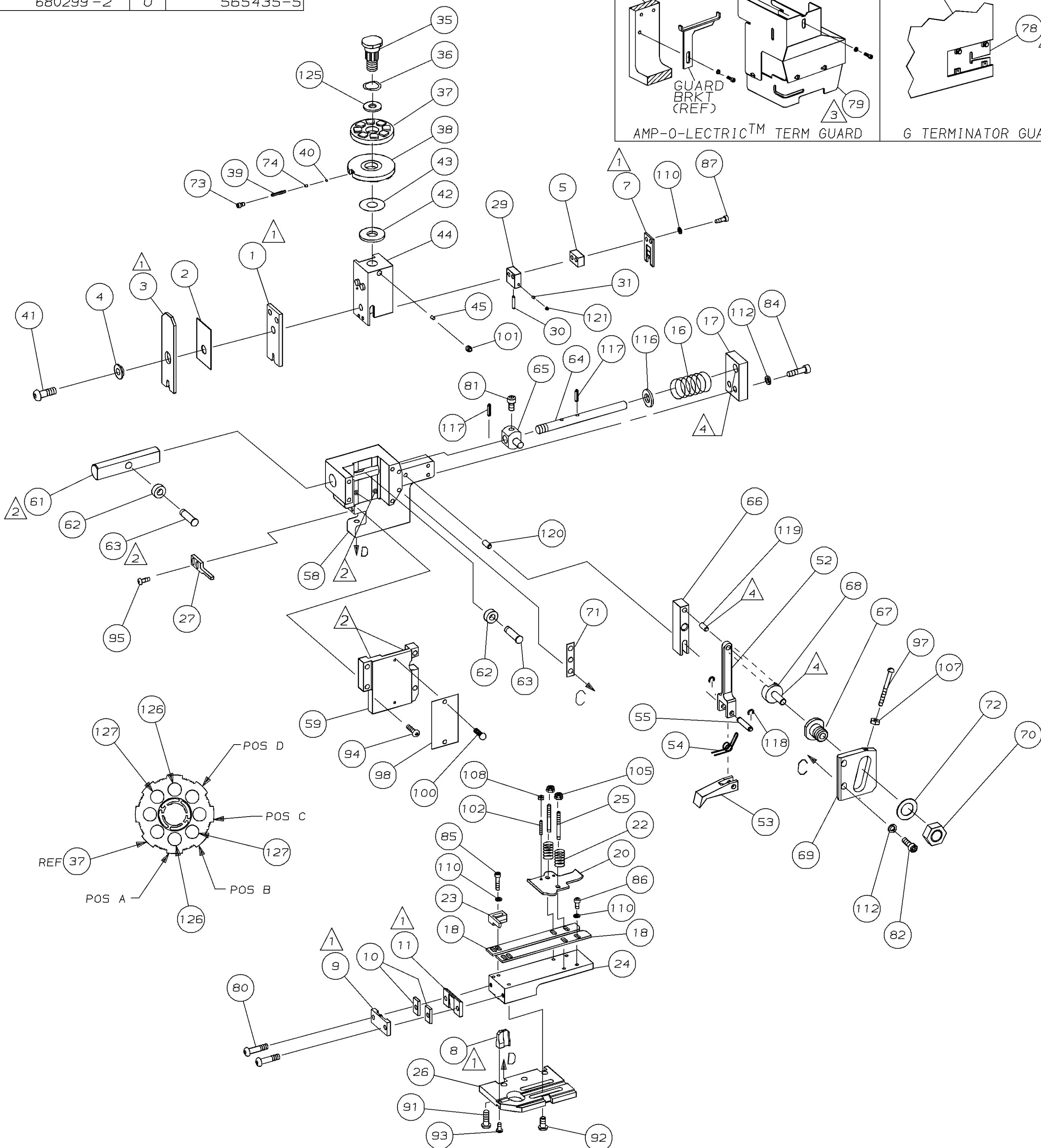
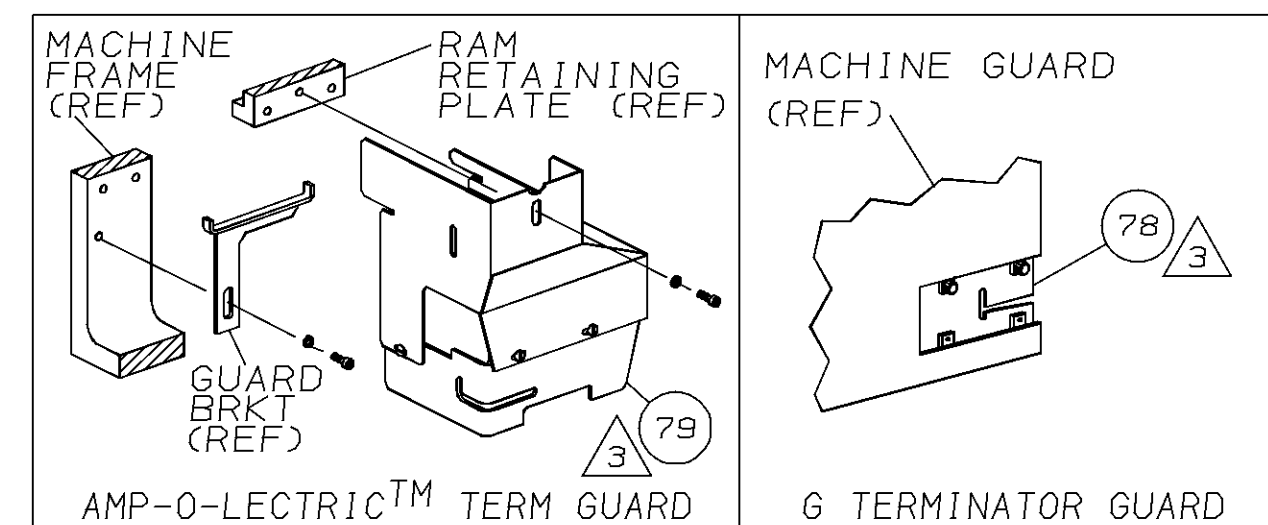


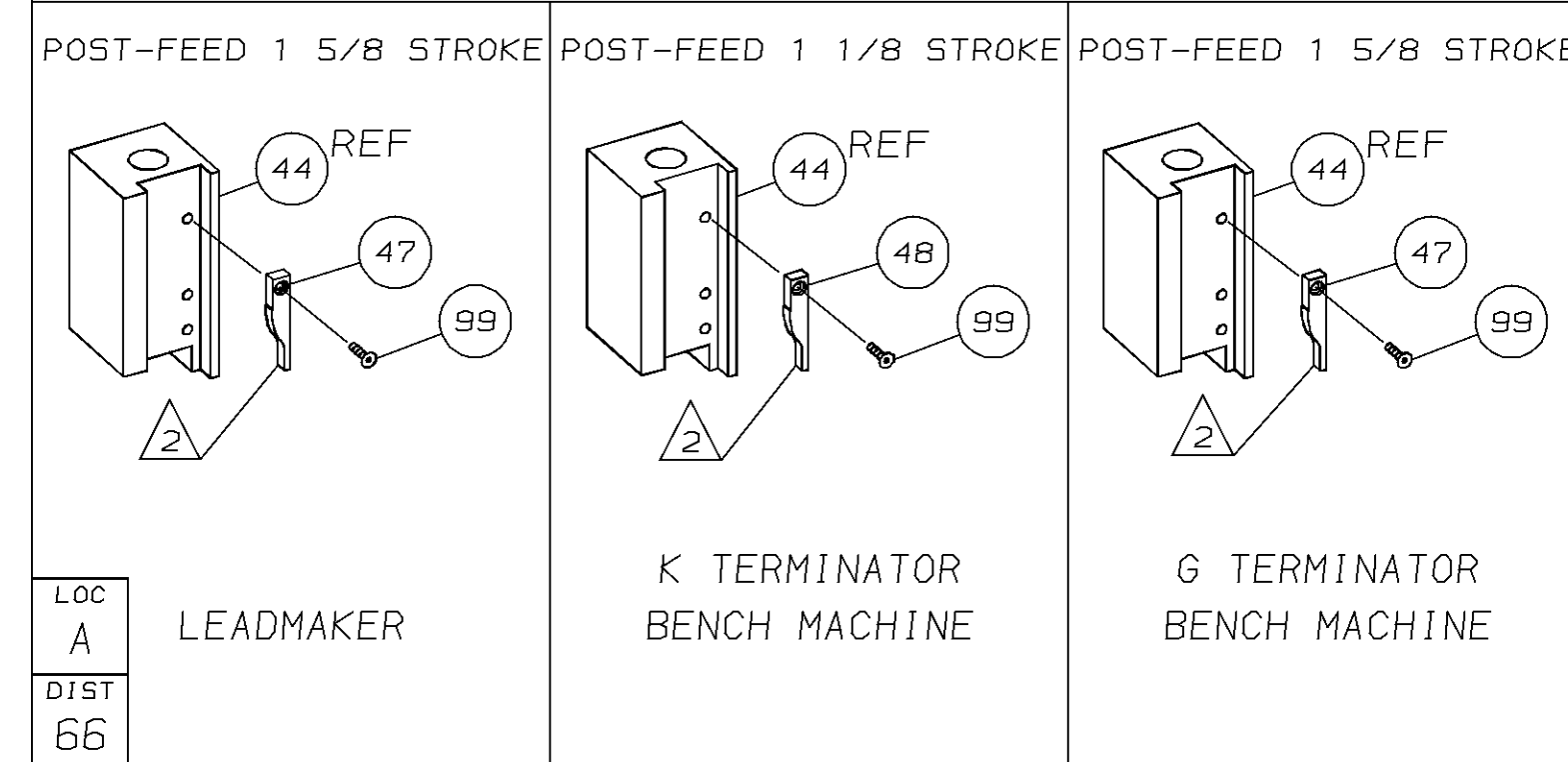
| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------|
| 680299-1 | 0 | 122500-1 |
| 680299-2 | 0 | 565435-5 |



| TERMINAL NAME: SNAP-IN CLUSTER RECEPTACLE | | CRIMPING DATA | |
|---|---------------------------|---------------|------------|
| PAD LTR | CRIMP HEIGHT | WIRE SIZE | |
| A | .065 ±.002 [1.65 ±0.05mm] | 16 | |
| B | .058 ±.002 [1.47 ±0.05mm] | 18 | |
| C | NOT | USED | |
| D | NOT | USED | |
| CRIMP | SIZE | TYPE | RANGE |
| WIRE | .090 [2.29mm] | F | 18-16 |
| INSUL | .140 [3.56mm] | F | ∅.135-.160 |

| QTY | REF | REV | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|-----|-----|-----|----------|------------|-------------------------------------|---------|
| 129 | | | | | | | 129 |
| 128 | | | | | | | 128 |
| 2 | 2 | - | C | | 354779-6 | PIN, WIRE DISC (.3020)B | 127 |
| 2 | 2 | - | C | | 9-354778-1 | PIN, WIRE DISC (.2950)A | 126 |
| 1 | 1 | - | A | | 986950-1 | WASHER, FLAT PRECISION | 125 |
| 1 | 1 | - | A | | 217238-1 | DOCUMENTATION PACKAGE | 124 |
| 1 | 1 | - | - | | 4088039 | EF APPL INST 408-8039 | 123 |
| | | | | | | | 122 |
| 1 | 1 | - | A | | 1-21006-7 | SCR, SKT SET (2-56x.19) FORMING PIN | 121 |
| REF | REF | - | A | | 1-21030-7 | PIN, DOWEL (∅.187x1.50) HSG | 120 |
| REF | REF | - | A | | 1-21030-1 | PIN, DOWEL (∅.187x.50) LEVER | 119 |
| REF | REF | - | A | | 21045-3 | RING, RET "C" (∅.187) FD PIN | 118 |
| REF | REF | - | A | | 5-21028-1 | PIN, STD SPRING (∅.12) FD ADJ ROD | 117 |
| REF | REF | - | A | | 21899-4 | WASHER, FLAT (∅5/16) SCR ADJ | 116 |
| | | | | | | | 115 |
| | | | | | | | 114 |
| | | | | | | | 113 |
| REF | REF | - | A | | 21024-5 | WASHER, LOCK (NO. 10) FD ROD GDE | 112 |
| 7 | 7 | - | A | | 21024-4 | WASHER, LOCK (NO. 8) SHEAR BL | 110 |
| | | | | | | | 109 |
| 2 | 2 | - | A | | 21018-4 | NUT, HEX (4-40) DRAG | 108 |
| REF | REF | - | A | | 21018-5 | NUT, HEX (6-32) FD ADJ PL | 107 |
| | | | | | | | 106 |
| 2 | 2 | - | A | | 21022-2 | NUT, HEX SL (8-32) DRAG STUD | 105 |
| | | | | | | | 104 |
| | | | | | | | 103 |
| 2 | 2 | - | A | | 2-21006-6 | SCR, SKT SET (4-40x.62) DRAG | 102 |
| 1 | 1 | - | A | | 21009-2 | SCR, SKT SET (1/4-20x.25) RAM | 101 |
| 2 | 2 | - | A | | 21017-2 | SCR, DRIVE (#2x.19) ID PLATE | 100 |
| 1 | 1 | - | A | | 1-21002-7 | SCR, BHC (6-32x.38) CAM | 99 |
| 1 | 1 | - | B | | 461264-1 | PLATE, IDENTIFICATION | 98 |
| REF | REF | - | A | | 6-23715-5 | SCR, PAN HD (6-32x1.50) FEED ADJ | 97 |
| | | | | | | | 96 |
| 2 | 2 | - | A | | 2-21002-2 | SCR, BHC (8-32x.50) STRIPPER | 95 |
| REF | REF | - | A | | 2-21002-9 | SCR, BHC (10-32x.75) HSG CAP | 94 |
| 1 | 1 | - | A | | 22733-8 | SCR, BHC (8-32x.38 LW) ANVIL | 93 |
| 4 | 4 | - | A | | 3-21002-3 | SCR, BHC (1/4-20x.50) ST 6D PL | 92 |
| REF | REF | - | A | | 2-22733-8 | SCR, BHC (1/4-20x.62) BASE PL | 91 |
| | | | | | | | 90 |
| | | | | | | | 89 |
| | | | | | | | 88 |
| 2 | 2 | - | A | | 2-21000-7 | SCR, SHC (8-32x.50) SLUG BLADE | 87 |
| 3 | 3 | - | A | | 2-21000-6 | SCR, SHC (8-32x.38) STRIP GUIDE | 86 |
| 2 | 2 | - | A | | 2-21000-9 | SCR, SHC (8-32x.75) R STRIP GUIDE | 85 |
| REF | REF | - | A | | 3-21000-7 | SCR, SHC (10-32x.75) FEED ROD GDE | 84 |
| | | | | | | | 83 |
| REF | REF | - | A | | 3-21000-6 | SCR, SHC (10-32x.62) FEED ADJ PL | 82 |
| REF | REF | - | A | | 3-21000-4 | SCR, SHC (10-32x.38) PIVOT BLOCK | 81 |
| 2 | 2 | - | A | | 3-21002-0 | SCR, BHC (10-32x.88) SHEAR PL | 80 |
| REF | - | - | A | | 455745-1 | GUARD, WINDOW | 79 |
| - | REF | - | A | | 679532-1 | INSERT, GUARD | 78 |
| | | | | | | | 77 |
| | | | | | | | 76 |
| | | | | | | | 75 |
| 1 | 1 | - | A | | 690603-1 | SPRING, ASSIST | 74 |
| 1 | 1 | - | A | | 23030-1 | SCR, SKT CAP (6-32x.25) CP DSC | 73 |
| REF | REF | - | A | | 458109-1 | WASHER, FLAT (SPECIAL) | 72 |
| REF | REF | - | A | | 690517-1 | SPACER | 71 |

| QTY | REF | REV | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|-----|-----|-----|----------|------------|------------------------------|---------|
| | | | | | | | 70 |
| | | | | | | | 69 |
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| | | | | | | | 49 |
| 1 | - | - | B | | 690501-3 | CAM, POST FEED 1 1/8 ST | 48 |
| - | 1 | - | B | | 690501-4 | CAM, POST-FEED 1 5/8 ST | 47 |
| | | | | | | | 46 |
| 1 | 1 | - | A | | 690191-1 | PLUG, NYLON | 45 |
| 1 | 1 | - | C | | 455674-2 | RAM | 44 |
| 1 | 1 | - | A | | 690125-1 | WASHER, LAMINATED | 43 |
| 1 | 1 | - | A | | 690124-1 | WASHER, RAM | 42 |
| 1 | 1 | - | A | | 7-21002-9 | BOLT, CRIMPER (5/16-24x1.00) | 41 |
| 1 | 1 | - | A | | 23241-6 | BALL, STEEL | 40 |
| 1 | 1 | - | A | | 690170-1 | SPRING, COMPRESSION | 39 |
| 1 | 1 | - | C | | 690142-1 | DISC, INSULATION | 38 |
| 1 | 1 | - | D | | 354777-1 | WIRE DISC, PLASTIC | 37 |
| 1 | 1 | - | A | | 22480-5 | WASHER, SPRING | 36 |
| 1 | 1 | - | B | | 690212-1 | POST, RAM | 35 |
| | | | | | | | 34 |
| | | | | | | | 33 |
| 1 | 1 | - | D | | 458980-2 | APPLICATOR, BASIC (SUB ASSY) | 32 |
| 1 | 1 | - | A | | 690191-3 | PLUG, NYLON | 31 |
| 1 | 1 | - | A | | 692987-1 | PIN, FORMING | 30 |
| 1 | 1 | - | B | | 692986-1 | HOLDER, FORMING PIN | 29 |
| | | | | | | | 28 |
| 1 | 1 | - | A | | 690455-1 | STRIPPER | 27 |
| REF | REF | - | C | | 455676-1 | PLATE, BASE | 26 |
| 2 | 2 | - | A | | 22354-8 | DRAG, STUD | 25 |
| 1 | 1 | - | B | | 455678-3 | PLATE, STRIP GUIDE | 24 |
| 1 | 1 | - | C | | 240825-2 | PLATE, STRIP HOLD DOWN | 23 |
| 2 | 2 | - | A | | 4-22281-1 | SPRING, DRAG | 22 |
| | | | | | | | 21 |
| 1 | 1 | - | A | | 454177-1 | DRAG, STOCK | 20 |
| | | | | | | | 19 |
| 2 | 2 | - | C | | 454204-4 | GUIDE, STRIP (FRONT) | 18 |
| REF | REF | - | A | | 454178-1 | GUIDE, FEED ROD | 17 |
| REF | REF | - | A | | 4-22284-9 | SPRING, FEED RETURN | 16 |
| | | | | | | | 15 |
| | | | | | | | 14 |
| | | | | | | | 13 |
| | | | | | | | 12 |
| 1 | 1 | - | B | | 240644-5 | PLATE, REAR SHEAR | 11 |
| 2 | 2 | - | C | | 1-240645-0 | SPACER, SHEAR PLATE | 10 |
| 1 | 1 | - | B | | 690796-2 | PLATE, FRONT SHEAR | 9 |
| 1 | 1 | - | D | | 6-240655-0 | ANVIL | 8 |
| 1 | 1 | - | B | | 5-240651-2 | BLADE, SLUG | 7 |
| | | | | | | | 6 |
| 1 | 1 | - | C | | 240641-7 | SPACER, SLUG BLADE | 5 |
| 1 | 1 | - | B | | 238009-1 | SPACER, BLOCK CRIMPER | 4 |
| 1 | 1 | - | C | | 1-456134-4 | CRIMPER, INSULATION | 3 |
| 1 | 1 | - | B | | 455888-7 | SPACER, CRIMPER | 2 |
| 1 | 1 | - | C | | 1-456406-9 | CRIMPER, WIRE | 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 32.
- 6 ITEM 78 USED WITH G TERMINATOR ONLY.
- 7 FEED OFF OF RECEPTACLE.
- 8 LANCE SUPPORT TO BE BENT DOWN .035-.045 IN APPLICATOR.

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DR M. OBRINE 4-8-96 APP T. ELBIN 4-8-96
 CHK 4-8-96 REL 5/8/96
 C. ERISMAN B. MORGAN

NAME: END FEED HDM APPLICATOR MACHINE REF: MINI APPL
 SCALE: 1 OF 1 REV: 0

REVISION RECORD: P/F LTR REV DATE