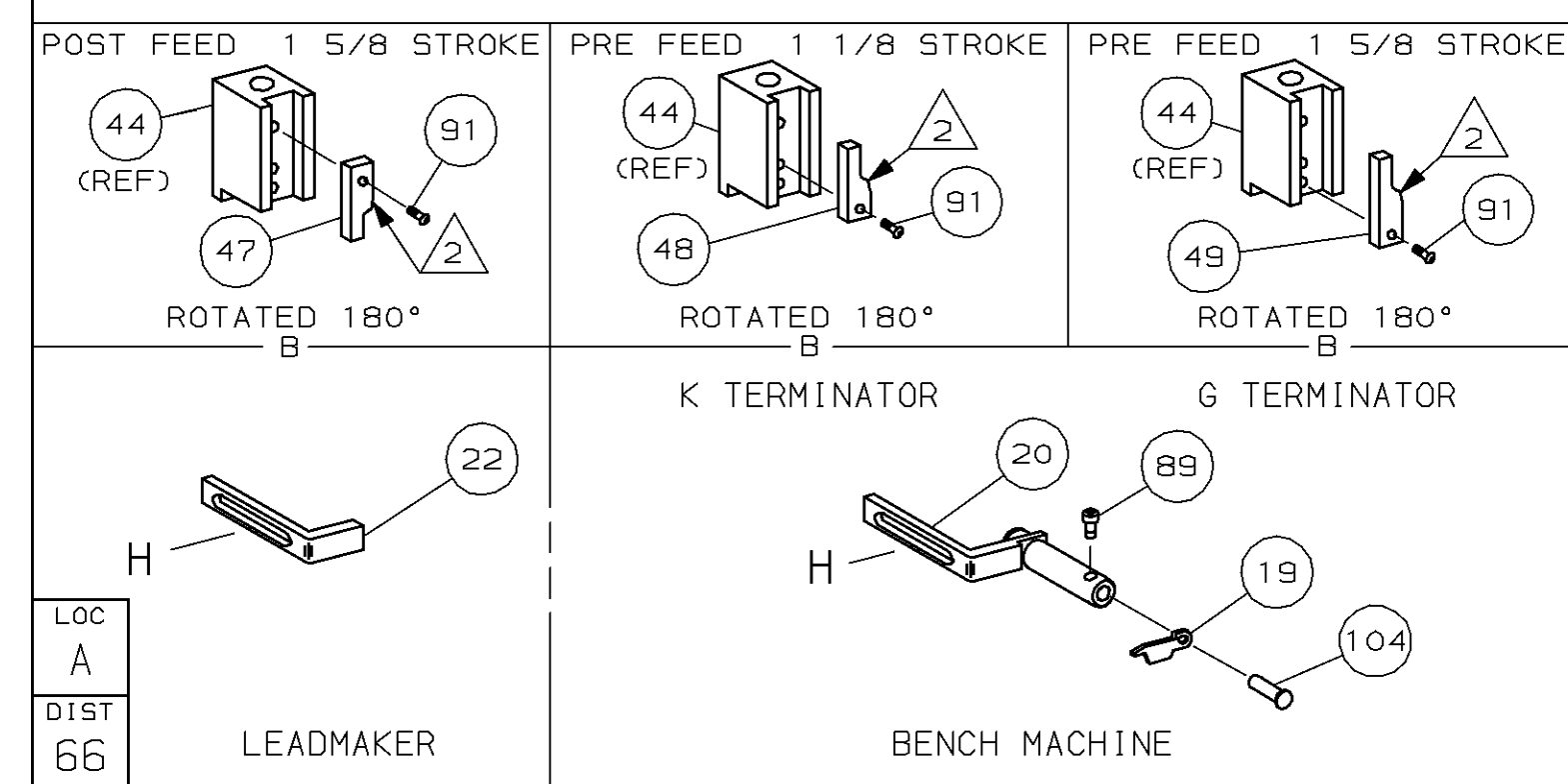
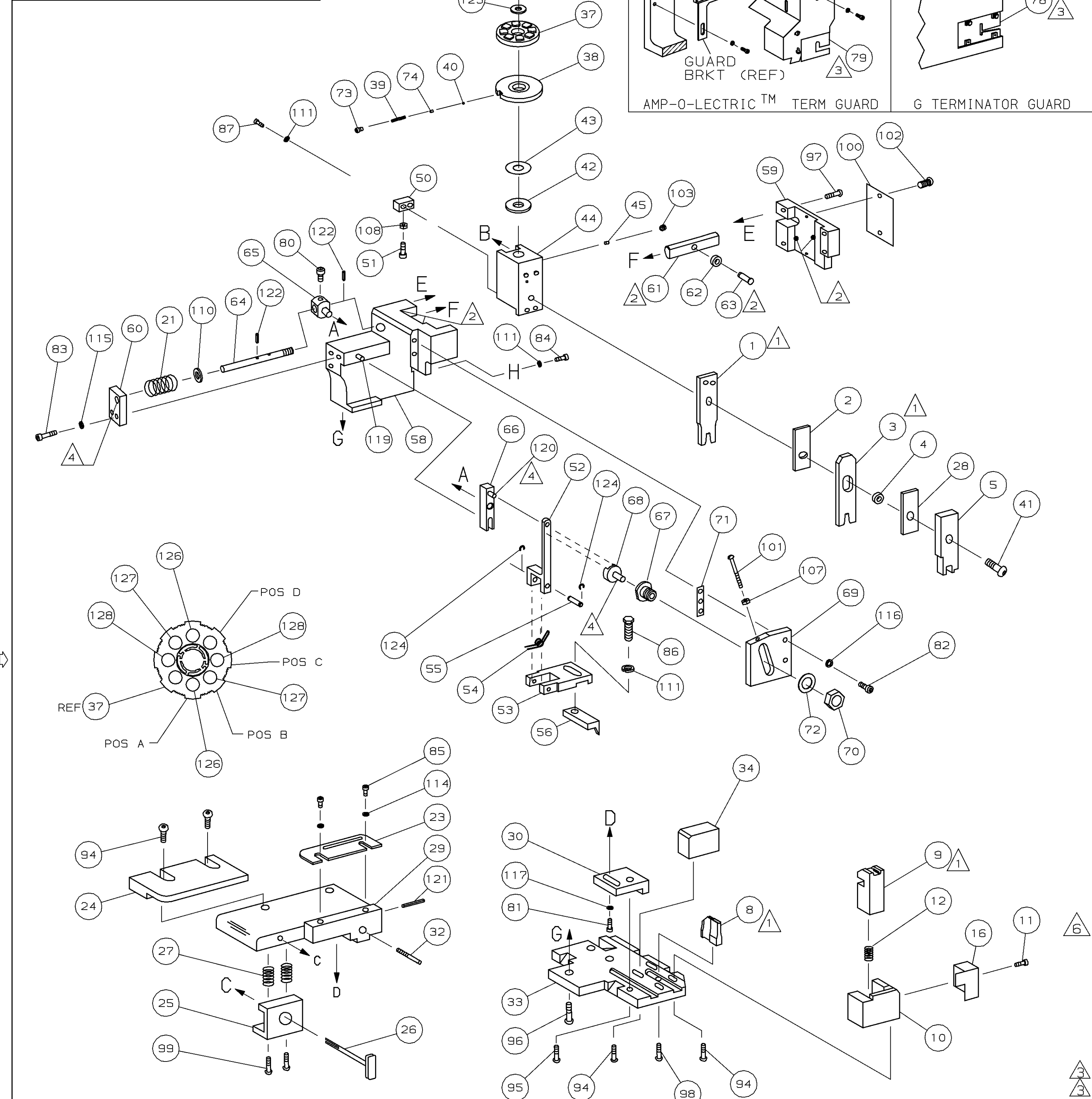


PART NUMBER	REV	FIRST USED
680187-1	B	122500-1
680187-2	B	565435-5
680187-3	B	354500-1



- 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 CUT TO LENGTH AT ASSY

CRIMPING DATA			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.061 ± .002 [1.56 ± 0.05mm]	1mm ²	
B	.058 ± .002 [1.47 ± 0.05mm]	0.75mm ²	
C	.054 ± .002 [1.38 ± 0.05mm]	0.5mm ²	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.080 [2.03mm]	F	.5 - 1mm ²
INSUL	.160 [4.06mm]	OV	∅3.6mm MAX

QTY REQD PER ASSY	TERMS	APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT	ITEM NO
2	2	2	-	C	1-354779-6	PIN, WIRE DISC (.3070)C	129
2	2	2	-	C	354779-8	PIN, WIRE DISC (.3030)B	127
2	2	2	-	C	354779-3	PIN, WIRE DISC (.3005)A	126
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
REF	REF	REF	-	A	21045-3	RING, RET "C" (∅.187)FD FING PIN	124
REF	REF	REF	-	A	5-21028-1	PIN, SLT SPR (∅.125x.50)ADJ ROD	122
1	1	1	-	A	4-21028-0	PIN, SLT SPR (∅.093x.75)ST GDE PL	121
REF	REF	REF	-	A	1-21030-1	PIN, DOWEL (∅.187x.50)LEVER	120
REF	REF	REF	-	A	1-21030-6	PIN, DOWEL (∅.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	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
4	4	4	-	A	21024-4	WASHER, LOCK (#8)STRIPPER	111
REF	REF	REF	-	A	21899-4	WASHER, FLAT (∅5/16)SCREW ADJ	110
1	1	1	-	A	21018-5	NUT, HEX (NO. 6)HOLDDOWN	108
REF	REF	REF	-	A	21018-5	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
6	6	6	-	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	91
1	1	1	-	A	7-21000-9	SCR, SHC (4-40x.19)STRIPPER	89
2	2	2	-	A	2-21000-7	SCR, SHC (8-32x.48)DEP-HOLD	87
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
1	1	1	-	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

QTY REQD PER ASSY	TERMS	APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT	ITEM NO
-1							
-2							
-3							
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	455679-1	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
-	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	459456-1	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	690142-1	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	690786-6	SUPPORT, TERMINAL	34
REF	REF	REF	-	D	455675-1	PLATE, BASE	33
1	1	1	-	A	690432-3	SCREW, ADJUSTMENT	32
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	C	224209-1	PLATE, STRIP GUIDE	29
1	1	1	-	C	1-455888-9	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	7-690504-6	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	691667-1	GUARD, CHIP (FRONT)	16
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	238011-7	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	854830-6	CRIMPER, INSULATION	3
1	1	1	-	C	455888-8	SPACER, CRIMPER	2
1	1	1	-	C	2-456405-7	CRIMPER, WIRE	1

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

QTY REQD PER ASSY	TERMS	APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT	ITEM NO
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

REVISION RECORD

REV	DATE	DESCRIPTION
B1	0150-7419-96	TB 12-96
B	0150-6588-96	TB 1/96
A	REVISED	MO 11-95

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED.

DR J. BAKER 7/5/95 APP A. BEDDICK 7/5/95
 CHK 7/5/95 C. ERISMAN REL 12/4/95 B. MORGAN

NAME: SIDE FEED HDM APPLICATOR MACHINE REF: MINI APPL
 SCALE: D DWG NO: 680187 SHEET: 1 OF 1 REV: B1

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