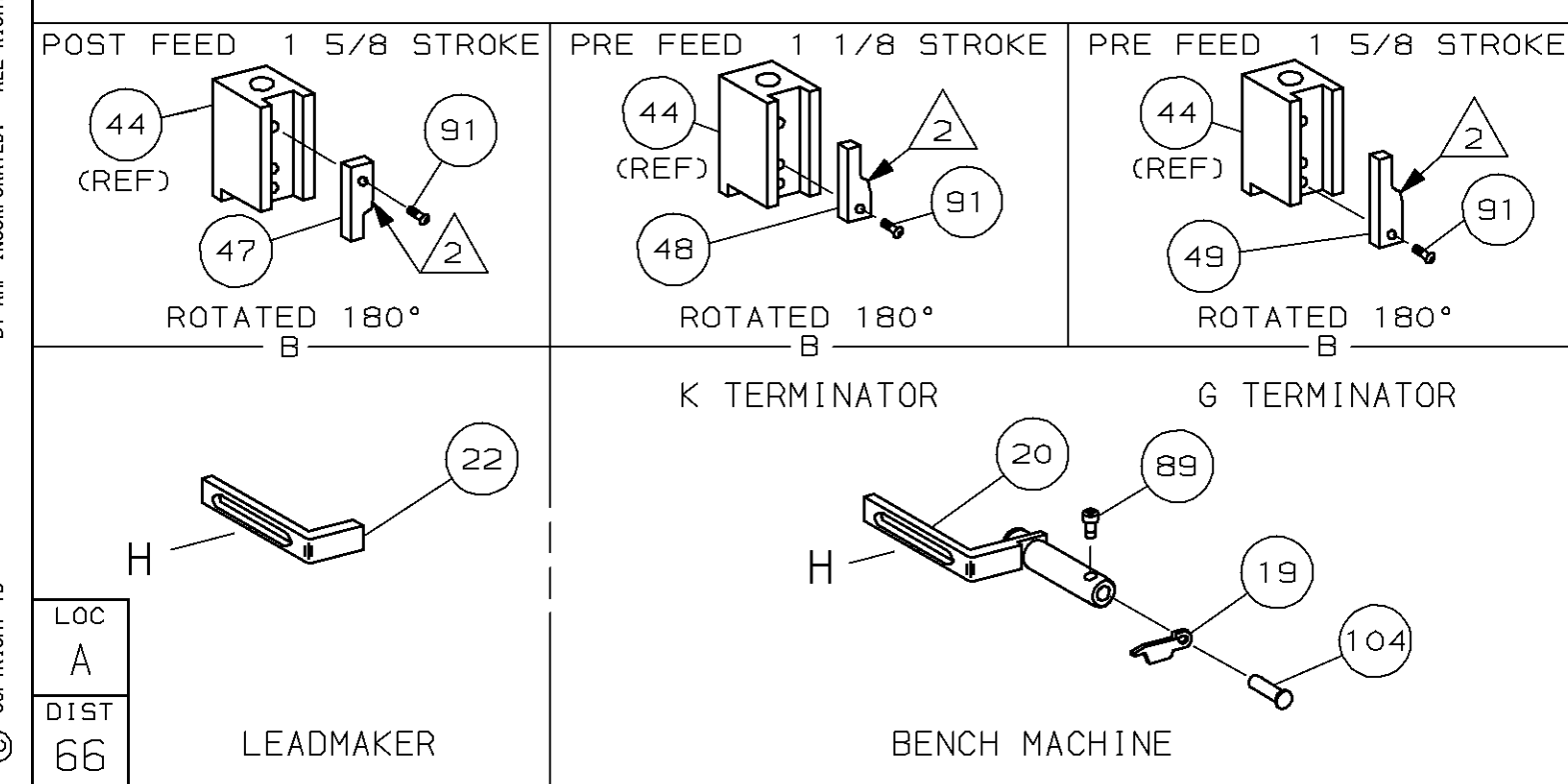
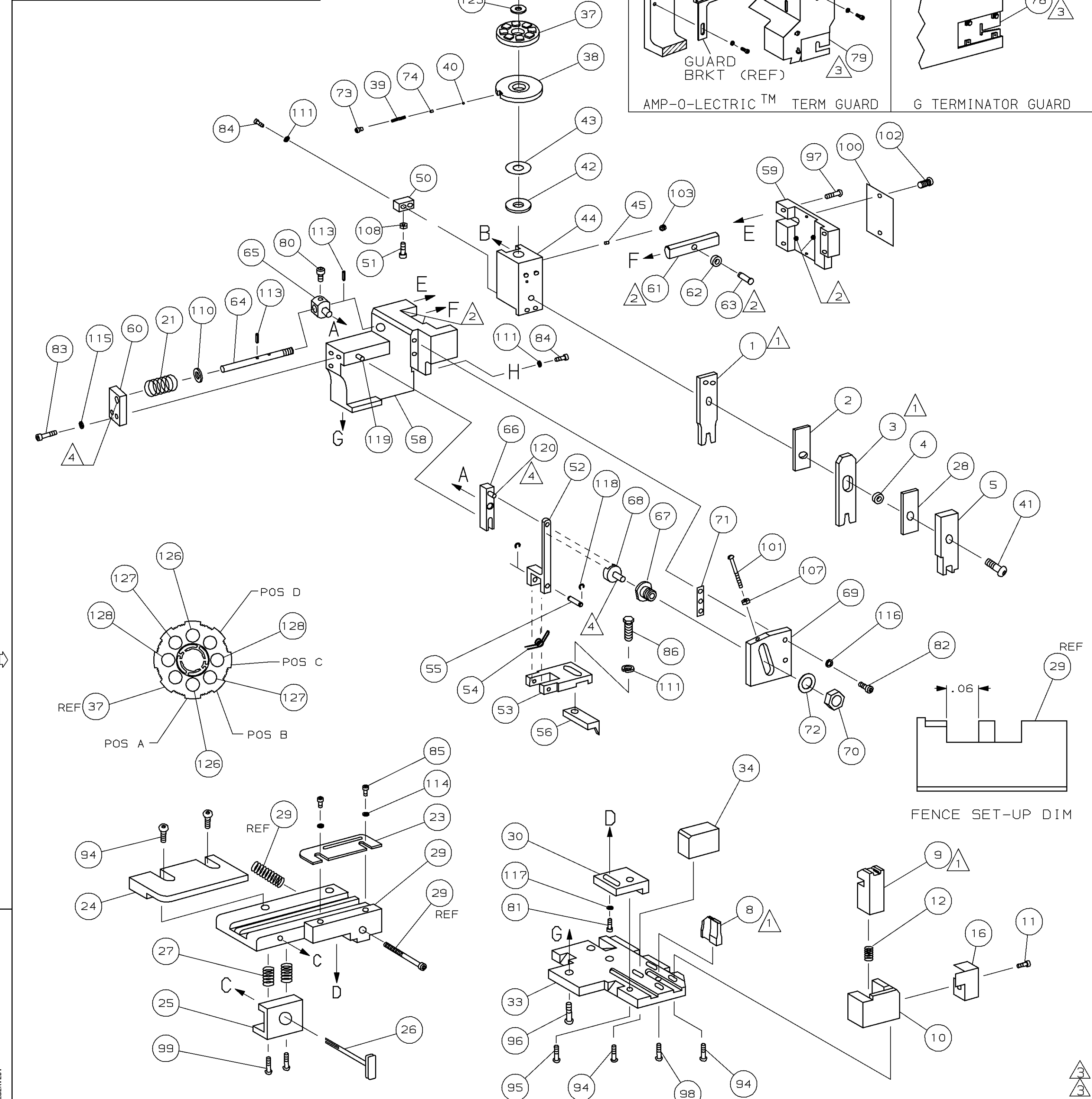


PART NUMBER	REV	FIRST USED
680698-1	A	122500-1
680698-2	A	565435-5
680698-3	A	354500-1



- 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.

CRIMP DATA (AMP TERMINAL)			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.054 ± .002 [1.36 ± 0.05mm]	1.00 mm ²	
B	.050 ± .002 [1.27 ± 0.05mm]	.75 mm ²	
C	.046 ± .002 [1.18 ± 0.05mm]	.50 mm ²	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.080 [2.03mm]	F	.50 mm ² -1.00 mm ²
INSUL	.130 [3.30mm]	F	2.00 MM-3.30 MM

QTY REQD PER ASSY	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT	ITEM NO
.156-.188	114-2020	.500	408-8040	458637-1	L2133	129
2	2	2	-	C	3-354779-3	PIN, WIRE DISC (.3155)C 128
2	2	2	-	C	2-354779-4	PIN, WIRE DISC (.3110)B 127
2	2	2	-	C	1-354779-5	PIN, WIRE DISC (.3065)A 126
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION 125
1	1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE 124
1	1	1	-	-	4088040	SF APPL INST 408-8040 123
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
REF	REF	REF	-	A	21045-3	RING, RET "C" (Ø.187) FD FING PIN 118
1	1	1	-	A	21024-5	WASHER, LOCK (#10) ADJ BLOCK 117
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
REF	REF	REF	-	A	5-21028-1	PIN, SLT SPR (Ø.125x.50) ADJ ROD 113
4	4	4	-	A	21024-4	WASHER, LOCK (#8) STRIPPER 111
REF	REF	REF	-	A	21899-4	WASHER, FLAT (Ø5/16) SCREW ADJ 110
1	1	1	-	A	21018-5	NUT, HEX (NO. 6) HOLDDOWN 109
REF	REF	REF	-	A	21068-5	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	-	-	A	7-21000-9	SCR, SHC (4-40x.19) STRIPPER 89
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
3	3	3	-	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	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT	ITEM NO
-1	LEADMAKER	MECH POST FEED				70
-2	BENCH MODEL K	MECH PRE FEED				69
-3	BENCH MODEL G	MECH PRE FEED				68
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	690542-6	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	690786-1	SUPPORT, TERMINAL 34
REF	REF	REF	-	D	455675-1	PLATE, BASE 33
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ 30
1	1	1	-	C	318042-1	STRIP GUIDE PLATE ASSY 29
1	1	1	-	C	2-455888-0	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	6-690504-2	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	-	-	A	679218-1	STRIPPER WIRE STOP ASSY 20
1	1	-	-	B	458949-1	STRIPPER 19
1	1	1	-	B	318563-1	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	454276-1	SHEAR, FLOAT (FRONT) 9
1	1	1	-	C	1-662186-6	ANVIL 8
1	1	1	-	C	1-455889-4	DEPRESSOR, SHEAR (FRONT) 5
1	1	1	-	B	1-238011-0	SPACER, BLOCK CRIMPER 4
1	1	1	-	C	4-456134-4	CRIMPER, INSULATION 3
1	1	1	-	C	455888-4	SPACER, CRIMPER 2
1	1	1	-	C	1-456405-5	CRIMPER, WIRE 1

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

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

REVISIONS:

- 1 SURF TEXTURE: ✓

REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL: - HT TR: - FIN: -

DR: W.HOOVER 18SEP98 APP: T.ELBIN 18SEP98

CHK: C.ERISMAN 18SEP98 REL: -

NAME: SIDE FEED HDM APPLICATOR MACHINE REF: MINI APPL

SCALE: - DWG NO: 680698 SHEET: 1 OF 1 REV: A

CUSTOMER AND ASSEMBLY DRAWING

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