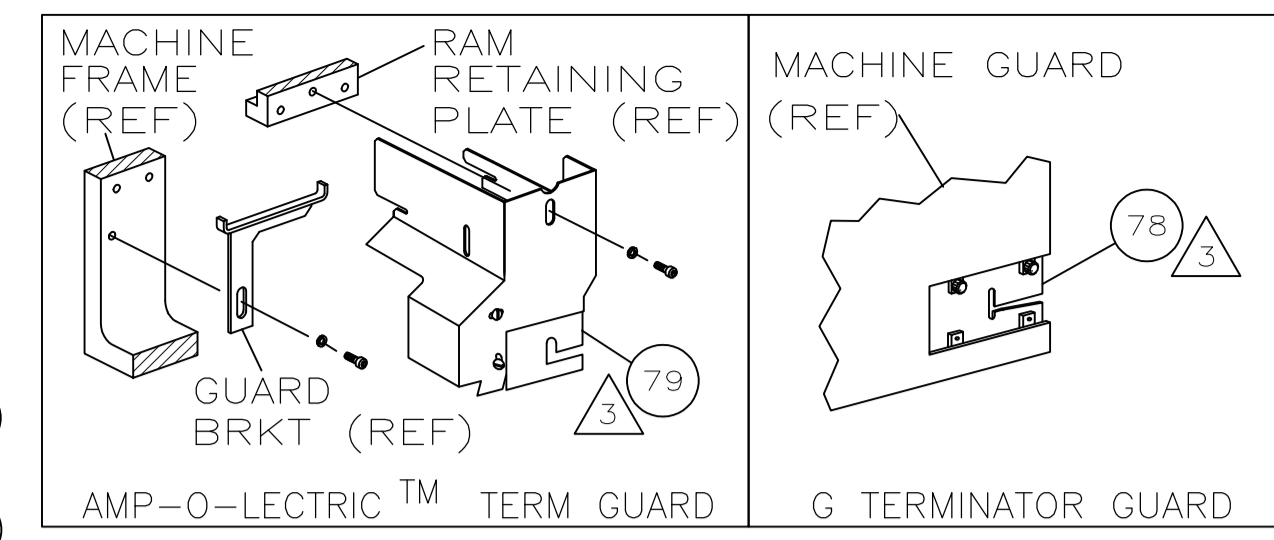


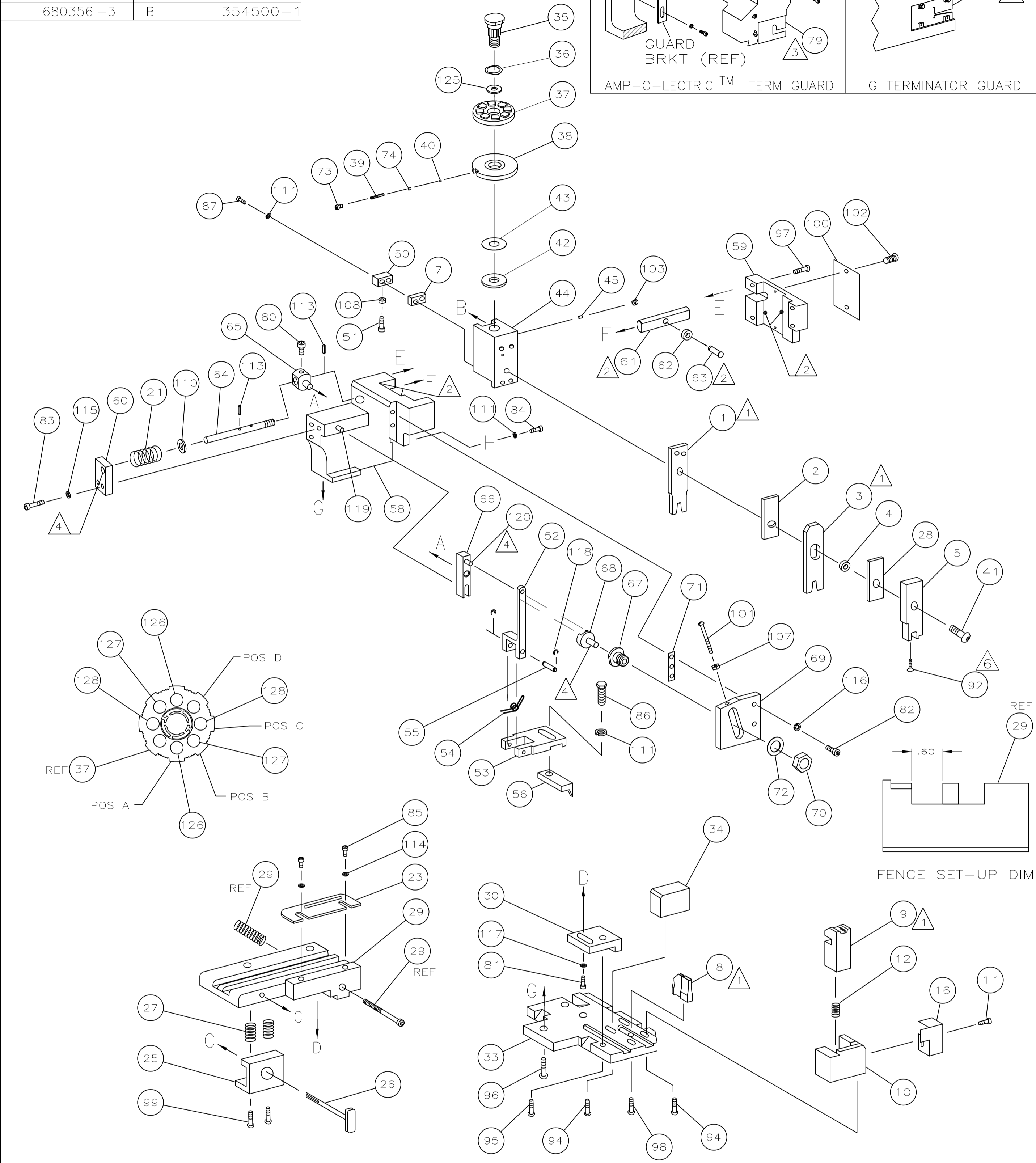
PART NUMBER	REV	FIRST USED
680356-1	B	122500-1
680356-2	B	565435-5
680356-3	B	354500-1



SEAL		TERMINAL		CRIMPING DATA	
963243		962952		PAD LTR	CRIMP HEIGHT
				A	.056 ±.002 [1.43 ±0.05mm]
				B	.053 ±.002 [1.34 ±0.05mm]
				C	.050 ±.002 [1.26 ±0.05mm]
				D	NOT USED
				CRIMP	SIZE
				WIRE	.080 [2.03mm]
				INSUL	.250 [6.35mm]
				FEED	.779
				APPL INSTRUCTION	408-8040
				SET UP GAGE	458637-1
				LAYOUT	L1813

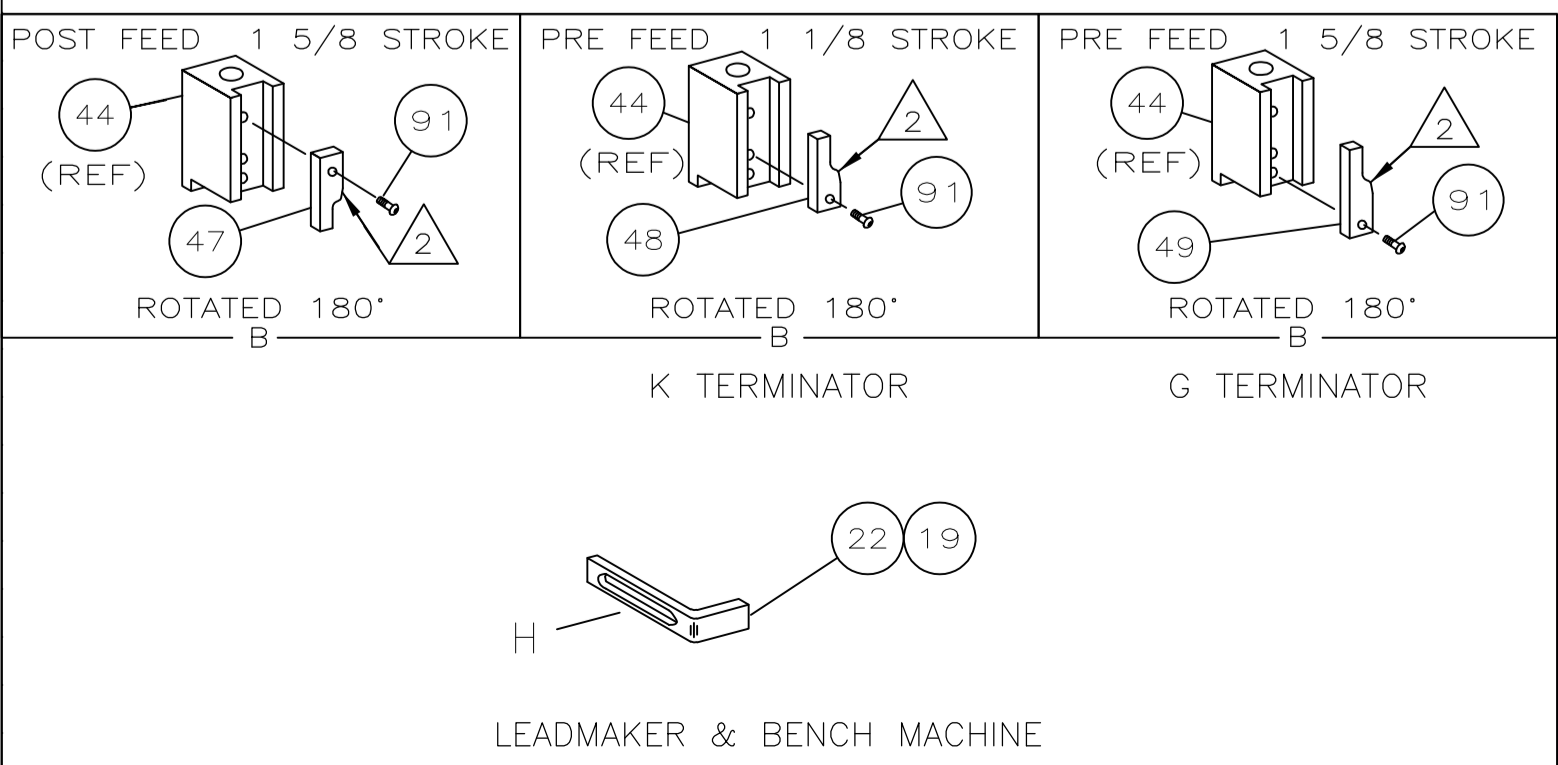
LOC	DIST	REVISIONS			
A	66	F	LTR	DESCRIPTION	DATE
		B	ECR-08-011505		5-2008

-1	LEADMAKER	MECH POST FEED
-2	BENCH MODEL K	MECH PRE FEED
-3	BENCH MODEL G	MECH PRE FEED



QTY REQD PER ASSY	REF	REF	REF	PART NO	DESCRIPTION	ITEM NO
						129
2	2	2	-	2-354779-8	PIN, WIRE DISC (.3130)C	128
2	2	2	-	2-354779-0	PIN, WIRE DISC (.3090)B	127
2	2	2	-	1-354779-6	PIN, WIRE DISC (.3070)A	126
1	1	1	-	986950-1	WASHER, FLAT PRECISION	125
1	1	1	-	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	1	-	4088040	SF APPL INST 408-8040	123
						122
						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
REF	REF	REF	-	21045-3	RING,RET "C"(Ø.187)FD FING PIN	118
1	1	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
REF	REF	REF	-	5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	113
						112
4	4	4	-	21024-4	WASHER,LOCK(#8)STRIPPER	111
REF	REF	REF	-	21899-4	WASHER,FLAT(Ø5/16)SCREW ADJ	110
						109
1	1	1	-	21018-5	NUT,HEX(NO.6)HOLDDOWN	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)TERM H DWN	94
						93
1	1	1	-	1-21003-9	SCR,FHC(6-32x.38)DEP	92
1	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	91
						90
						89
						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)ADJ BLK	82
1	1	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	-	-	455749-1	GUARD, WINDOW	79
REF	-	-	-	679532-1	INSERT, GUARD	78
						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
-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
						70

REF	REF	REF	REF	PART NO	DESCRIPTION	ITEM NO
						70
REF	REF	REF	-	22594-8	NUT,HEX(1/2-20)	69
REF	REF	REF	-	240628-1	PLATE, ADJUSTMENT	68
REF	REF	REF	-	240626-1	SHAFT, PIVOT	67
REF	REF	REF	-	240633-1	BUSHING	66
REF	REF	REF	-	455680-1	LEVER, INTERMEDIATE	65
REF	REF	REF	-	240629-1	BLOCK, PIVOT	64
REF	REF	REF	-	240632-2	SCREW, ADJ FEED ROD	63
REF	REF	REF	-	240659-3	PIN, CAM ROLLER	62
REF	REF	REF	-	240658-1	ROLLER, CAM	61
REF	REF	REF	-	454398-2	ROD, FEED	60
REF	REF	REF	-	454178-1	GUIDE, FEED ROD	59
REF	REF	REF	-	454220-1	CAP, RAM	58
REF	REF	REF	-	454485-1	HOUSING	57
						56
1	1	1	-	458537-2	PAWL, FEED	55
REF	REF	REF	-	240624-1	PIN, FEED FINGER	54
REF	REF	REF	-	691499-1	SPRING, FEED FINGER	53
REF	REF	REF	-	690541-1	HOLDER, FEED FINGER	52
REF	REF	REF	-	455679-2	LEVER, TERMINAL FEED ARM	51
1	1	1	-	811242-2	BUMPER, HOLDDOWN	50
1	1	1	-	690753-1	SPACER, TONKER	49
1	-	-	-	690602-6	CAM, PRE-FEED 1 5/8 ST	48
-	1	-	-	690602-5	CAM, PRE-FEED 1 1/8 ST	47
-	-	1	-	690501-4	CAM, POST-FEED 1 5/8 ST	46
1	1	1	-	459456-2	APPLICATOR, BASIC (SUBASSY)	45
1	1	1	-	690191-1	PLUG, NYLON	44
1	1	1	-	455673-1	RAM	43
1	1	1	-	690125-1	WASHER, LAMINATED	42
1	1	1	-	690124-1	WASHER, RAM	41
1	1	1	-	690686-1	BOLT, CRIMPER(5/16x1.00)	40
1	1	1	-	23241-6	BALL, STEEL	39
1	1	1	-	690170-1	SPRING, COMPRESSION	38
1	1	1	-	690142-1	DISC, INSULATION	37
1	1	1	-	354777-1	WIRE DISC, PLASTIC	36
1	1	1	-	22480-5	WASHER, SPRING	35
1	1	1	-	690212-1	POST, RAM	34
1	1	1	-	2-690786-3	SUPPORT, TERMINAL	33
REF	REF	REF	-	455675-1	PLATE, BASE	32
						31
REF	REF	REF	-	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	318756-1	STRIP GUIDE PLATE ASSY	29
1	1	1	-	455888-6	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
						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
						18
						17
1	1	1	-	318563-1	GUARD, CHIP, FRONT	16
						15
						14
						13
1	1	1	-	3-22280-3	SPRING, SHEAR	12
1	1	1	-	690461-2	STOP, SHEAR	11
1	1	1	-	1-690459-0	HOLDER, SHEAR (FRONT)	10
1	1	1	-	318707-1	SHEAR, FLOAT (FRONT)	9
1	1	1	-	662186-1	ANVIL	8
1	1	1	-	240641-5	SPACER, DEPRESSOR (REAR)	7
						6
1	1	1	-	318701-1	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	238011-1	SPACER, BLOCK CRIMPER	4
1	1	1	-	6-456135-7	CRIMPER, INSULATION	3
1	1	1	-	455888-9	SPACER, CRIMPER	2
1	1	1	-	1-456405-5	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 46.
- 6 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 7 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIN P. MATHIAS 8-28-96 Tyco Electronics Corporation  
 C. FERISMAN 8-28-96 Harrisburg, PA 17105-3608

APPROVED: J. DODDS 8-28-96 NAME: SIDE FEED HDM APPLICATOR

PRODUCT SPEC: -  
 APPLICATION SPEC: -  
 SIZE: A1 CASE CODE: 00779 DRAWING NO: 680356  
 WEIGHT: -  
 CUSTOMER DRAWING: - SCALE: - SHEET: 1 of 1 REV: B