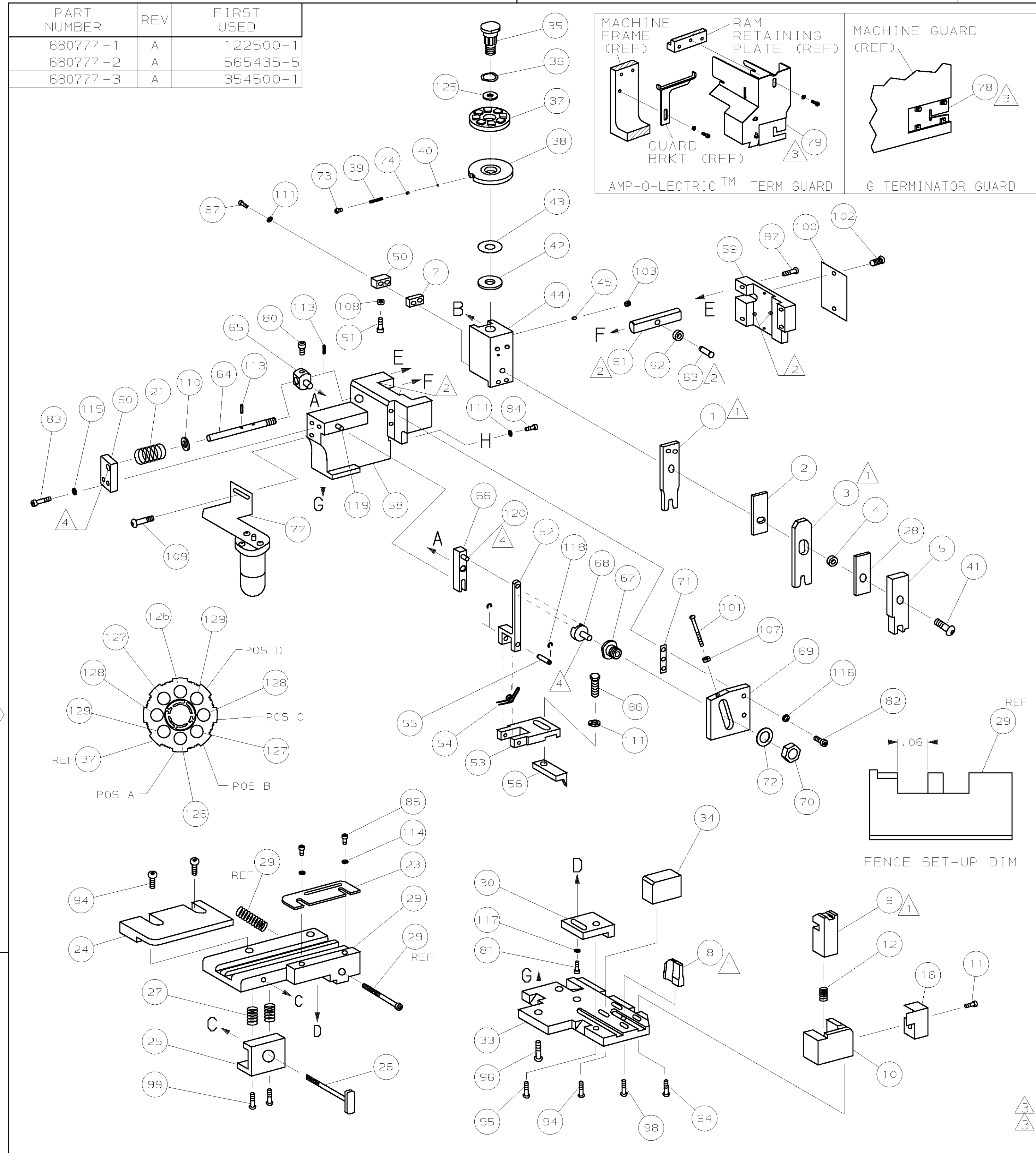


PART NUMBER	REV	FIRST USED
680777 -1	A	122500-1
680777 -2	A	565435-5
680777 -3	A	354500-1



POST FEED 1 5/8 STROKE

PRE FEED 1 5/8 STROKE

PRE FEED 1 5/8 STROKE

ROTATED 180°

ROTATED 180°

ROTATED 180°

K TERMINATOR

G TERMINATOR

LOC A

DIST 66

LEADMAKER

BENCH MACHINE

TERMINAL NAME: Ø 1mm PIN CONTACT									
		962818		CRIMP DATA (AMP TERMINAL)					
				PAD LTR	CRIMP HEIGHT			WIRE SIZE	
				A	.039 ±.002 [1.0 ±0.05mm]			0.5 mm ²	
				B	.036 ±.002 [0.91 ±0.05mm]			0.35 mm ²	
				C	.034 ±.002 [0.85 ±0.05mm]			0.25 mm ²	
				D	.033 ±.002 [0.83 ±0.05mm]			0.2 mm ²	
				CRIMP	SIZE		TYPE	RANGE	
				WIRE	.055 [1.40mm]		F	0.2mm ² –0.5mm ²	
				INSUL	.080 [2.03mm]		0	1 –1.6mm	
WIRE STRIP LENGTH			TERM APPL SPEC	FEED	APPL INSTRUCTION			SET UP GAGE	LAYOUT
.140–.156			NONE	.394	408–8040			458637–1	L2196

2	2	2	-	C	5-354779-1	PIN, WIRE DISC (.3245)D	129
2	2	2	-	C	5-354779-0	PIN, WIRE DISC (.3240)C	128
2	2	2	-	C	4-354779-4	PIN, WIRE DISC (.3210)B	127
2	2	2	-	C	3-354779-7	PIN, WIRE DISC (.3175)A	126
1	1	1	-	A	985950-1	WASHER, FLAT PRECISION	125
1	1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	1	-	-	4088040	SF APPLINST 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
							112
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	-	-	A	2-21002-6	SCR, BHC (10-32x.38) LUBE ASSY	109
1	1	1	-	A	21018-5	NUT, HEX (NO. 6) HOLDDOWN	108
REF	REF	REF	-	A	21068-5	NUT, HEX (6-32) FEED ADJ	107

							106
1	1	-	-	A	992031-1	PIN, CLEVIS	105
1	1	1	-	A	21009-2	SCR,SKT SET (1/4-20x.25 LW)RAM	104
2	2	2	-	A	21017-2	SCR, DRIVE (#2x.19) ID PLATE	103
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	98
1	1	1	-	A	8-22733-8	SCR, BHC (8-32x.38 LW) ANVIL	99
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) 56 ADJ BLOCK	95
6	6	6	-	A	2-21002-2	SCR, BHC (8-32x.50) TERM H DWN	94

							93
							92
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x. 38) CAM	91
							90
1	1	-	-	A	7-21000-9	SCR, SHC (4-40x. 19) STRIPPER	89

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
2	2	2	-	A	2-21000-7	SCR, SHC (8-32x.50) STRIPPER	84

REF	REF	REF	-	A	3-21000-7	SCR,5HC (10-32x.75)FED ROD GD	83
REF	REF	REF	-	A	3-21000-6	SCR,5HC (10-32x.62)FD ADJ BLK	82
1	1	1	-	A	3-21000-4	SCR,5HC (10-32x.38)5G ADJ BLK	81
REF	REF	REF	-	A	3-21000-4	SCR,5HC (10-32x.38)P1V0T BLK	80
-	REF	-	-	B	455749-1	GUARD, WINDOW	79
REF	-	-	-	B	670522-1	INSERT, GUARD	78

REF	-	-	-	B	675532-1	INSERT, GUARD	78
-	1	-	-	C	1-465184-0	LUBRICATOR ASSY	77
							76
							75
1	1	1	-	A	690603-1	SPRING, ASSIST	74
1	1	1	-	A	23030-1	SPR SHC (6-32) 25 SLIDING DISC	73

REF	REF	REF	-	A	25050-1	SCR, SH-32X.25 SCR NS 0100	75
REF	REF	REF	-	A	458109-1	WASHER, SPECIAL	72
REF	REF	REF	-	A	690517-1	SPACER	71
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY				PARTS LIST			

[illegible]

-1	LEADMAKER				MECH POST FEED			
-2	BENCH MODEL K				MECH PRE FEED			
-3	BENCH MODEL G				MECH PRE FEED			
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
								57
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
-	-	1	-	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	1-690786-4	SUPPORT, TERMINAL		34
REF	REF	REF	-	D	455675-1	PLATE, BASE		33
								32
								31
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ		30
1	1	1	-	C	318756-1	STRIP GUIDE PLATE ASSY		29
1	1	1	-	C	1-455888-0	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	5-690504-9	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
								18
								17
1	1	1	-	B	318563-1	GUARD, CHIP, FRONT		16
								15
								14
								13
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	462006-1	SHEAR, FLOAT (FRONT)		9
1	1	1	-	C	1-662183-0	ANVIL		8
1	1	1	-	C	2-240641-4	SPACER, DEPRESSOR (REAR)		7
								6
1	1	1	-	C	2-455889-0	DEPRESSOR, SHEAR (FRONT)		5
1	1	1	-	B	1-238011-0	SPACER, BLOCK CRIMPER		4
1	1	1	-	C	6-456135-5	CRIMPER, INSULATION		3
1	1	1	-	C	455888-6	SPACER, CRIMPER		2
1	1	1	-	C	456402-1	CRIMPER, WIRE		1
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO	
REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)								
QTY REQD PER ASSY				PARTS LIST				

DIMENSIONS IN INCHES. DO NOT SCALE PRINT.		MATL		HT TR		FIN	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		DR		19JAN99		APP	
2 PLC DEC ±.02		B.HIGMAN		19JAN99		1.ELBIN	
3 PLC DEC ±		CHK		19JAN99		REL	
4 PLC DEC ±		C.ERISMAN		-		-	
5 ANGLES ±		-		-		-	
6 SURF TEXTURE, ✓		NAME		SIDE FEED HDM APPLICATOR		MACHINE REF	
7 REMOVE BURRS, BREAK		SCALE		D		MINI	
8 SHARP EDGES R.015 MAX		-		DWG NO		APPL	
				680777		SHEET	
						1 of 1	
						REV	
						A	

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