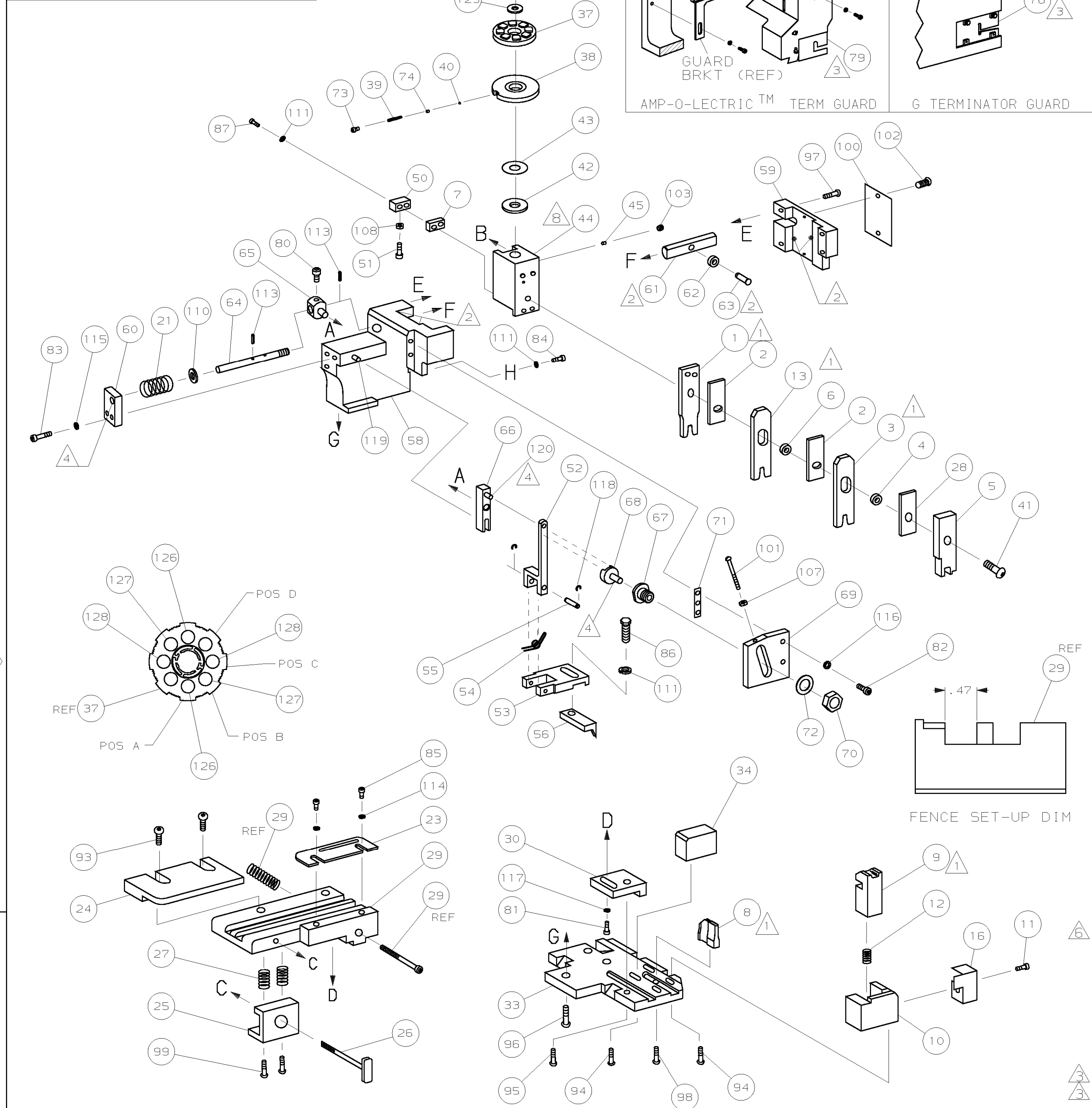


| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------|
| 680709-1    | B   | 122500-1   |
| 680709-2    | B   | 565435-5   |
| 680709-3    | B   | 354500-1   |



POST FEED 1 5/8 STROKE

ROTATED 180°

PRE FEED 1 1/8 STROKE

ROTATED 180°

PRE FEED 1 5/8 STROKE

ROTATED 180°

LOC A

DIST 66

LEADMAKER

K TERMINATOR

G TERMINATOR

- 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
- 7 GUIDE OFF STABILIZER BARREL.
- 8 PRESS SPRING PIN INTO RAM, FLUSH WITH WIRE CRIMPER, AT ASSEMBLY.

| TERMINAL NAME: .140 Ø SOCKET |     |     |                |                           |                           |                  |                                    |                     |         |
|------------------------------|-----|-----|----------------|---------------------------|---------------------------|------------------|------------------------------------|---------------------|---------|
|                              |     |     | 927873         | CRIMP DATA (AMP TERMINAL) |                           |                  |                                    |                     |         |
|                              |     |     | 927875         | PAD LTR                   | CRIMP HEIGHT              |                  |                                    | WIRE SIZE           |         |
|                              |     |     |                | A                         | .073 ±.002 [1.86 ±0.05mm] |                  |                                    | 2.5 mm <sup>2</sup> |         |
|                              |     |     |                | B                         | .068 ±.002 [1.72 ±0.05mm] |                  |                                    | 2 mm <sup>2</sup>   |         |
|                              |     |     |                | C                         | .062 ±.002 [1.58 ±0.05mm] |                  |                                    | 1.5 mm <sup>2</sup> |         |
|                              |     |     |                | D                         | NOT                       |                  |                                    | USED                |         |
|                              |     |     |                | CRIMP                     | SIZE                      |                  | TYPE                               | RANGE               |         |
|                              |     |     |                | WIRE                      | .110 [2.79mm]             |                  | F                                  | 1.5mm-2.5mm         |         |
|                              |     |     |                | INSUL                     | .155 [3.94mm]             |                  | F                                  | 2.7mm-3.7mm         |         |
| WIRE STRIP LENGTH            |     |     | TERM APPL SPEC |                           | FEED                      | APPL INSTRUCTION |                                    | SET UP GAGE         | LAYOUT  |
| .171-.188                    |     |     | NONE           |                           | .590                      | 408-8040         |                                    | 458637-1            | L2143   |
|                              |     |     |                |                           |                           |                  |                                    |                     | 129     |
| 2                            | 2   | 2   | -              | C                         | 1-354779-0                |                  | PIN, WIRE DISC (.3040)C            |                     | 128     |
| 2                            | 2   | 2   | -              | C                         | 9-354778-5                |                  | PIN, WIRE DISC (.2970)B            |                     | 127     |
| 2                            | 2   | 2   | -              | C                         | 8-354778-7                |                  | PIN, WIRE DISC (.2930)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     |
|                              |     |     |                |                           |                           |                  |                                    |                     | 122     |
|                              |     |     |                |                           |                           |                  |                                    |                     | 121     |
| 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 5PR (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     |
|                              |     |     |                |                           |                           |                  |                                    |                     | 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     |
|                              |     |     |                |                           |                           |                  |                                    |                     | 105     |
| 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      |
| 4                            | 4   | 4   | -              | A                         | 2-21002-2                 |                  | SCR, BHC (8-32x.50) TERM H DWN     |                     | 94      |
| 2                            | 2   | 2   | -              | A                         | 2-21002-3                 |                  | SCR, BHC (8-32x.62) R STP GDE      |                     | 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      |
|                              |     |     |                |                           |                           |                  |                                    |                     | 88      |
| 2                            | 2   | 2   | -              | A                         | 2-21000-8                 |                  | SCR, SHC (8-32x.54) 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      |
|                              |     |     |                |                           |                           |                  |                                    |                     | 77      |
|                              |     |     |                |                           |                           |                  |                                    |                     | 76      |
|                              |     |     |                |                           |                           |                  |                                    |                     | 75      |
| 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      |
| -3                           | -2  | -1  | U/M            | DWG SIZE                  | PART NO                   |                  | DESCRIPTION                        |                     | ITEM NO |
| QTY REQD PER ASSY PARTS LIST |     |     |                |                           |                           |                  |                                    |                     |         |

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