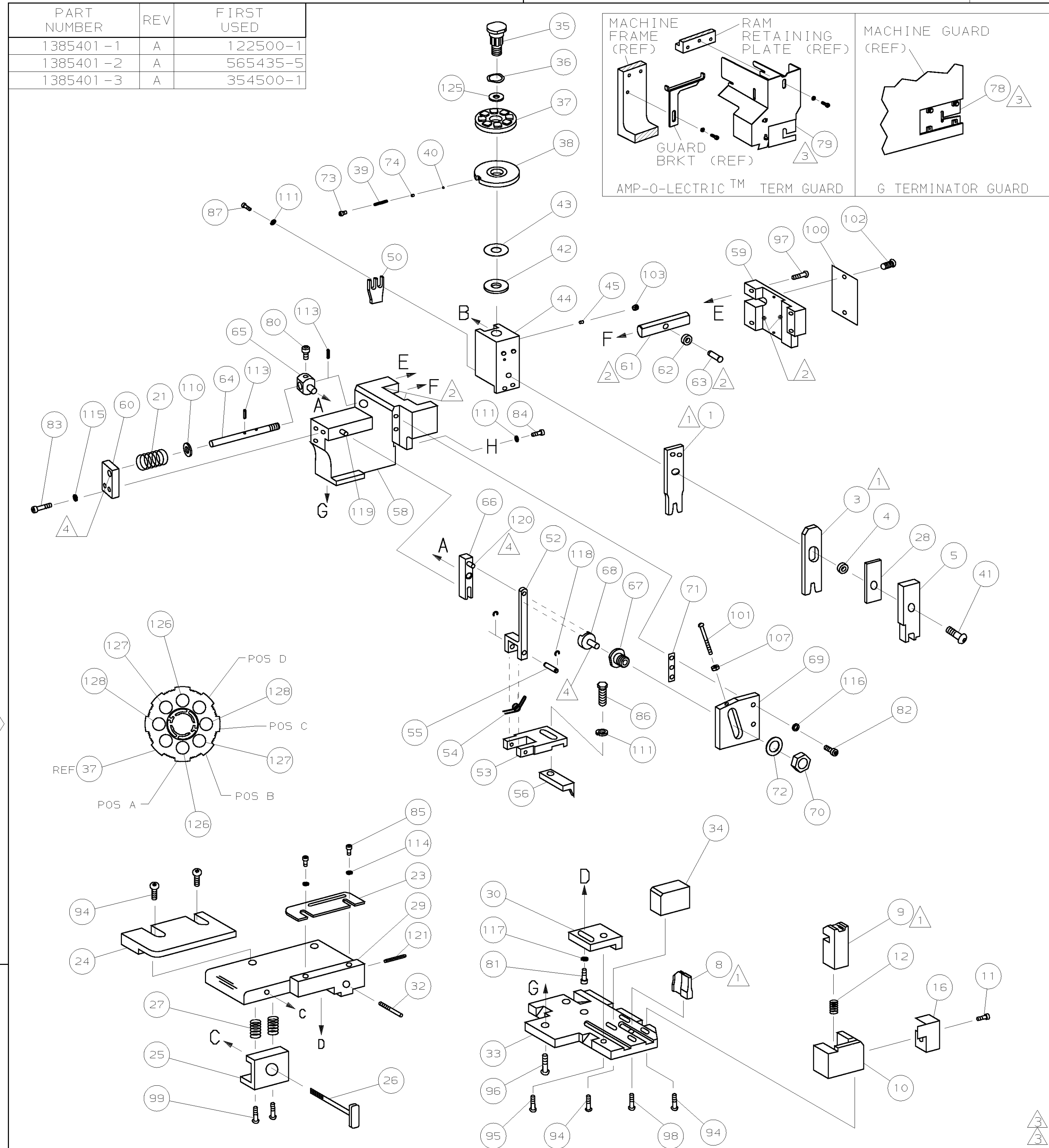
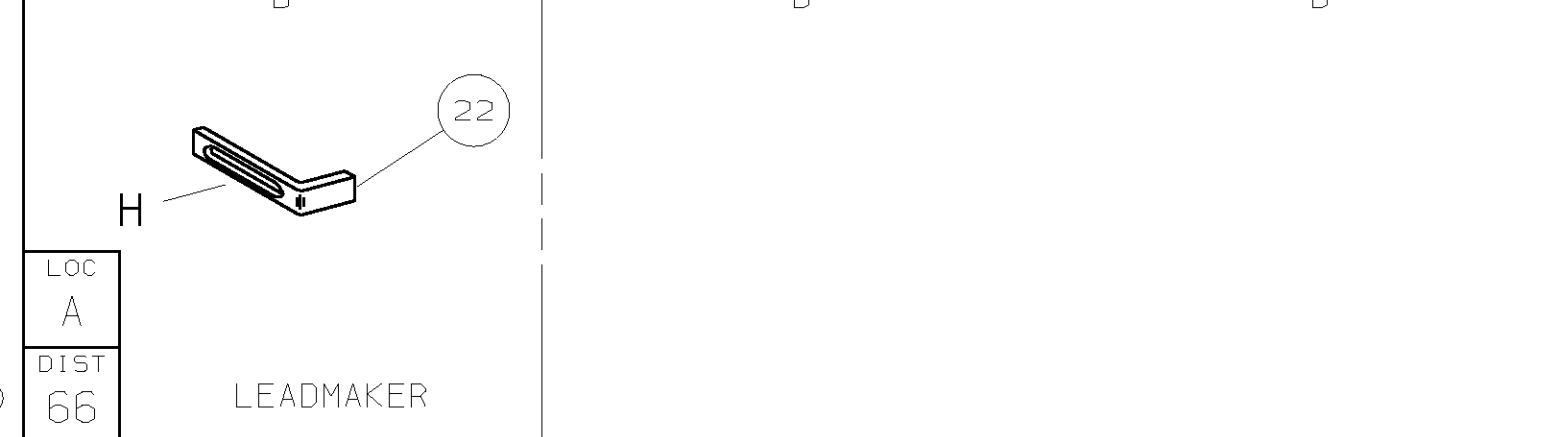


| PART<br>NUMBER | REV | FIRST<br>USED |
|----------------|-----|---------------|
| 1385401 -1     | A   | 122500-1      |
| 1385401 -2     | A   | 565435-5      |
| 1385401 -3     | A   | 354500-1      |



| POST FEED 1 5/8 STROKE | PRE FEED 1 1/8 STROKE | PRE FEED 1 5/8 STROKE |
|------------------------|-----------------------|-----------------------|
|                        |                       |                       |



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. RECOMMENDED MAX CMA 567.

| TERMINAL NAME: CRIMP CONTACT |  |                |  |                 |                           |                 |             |        |                                                                                     |
|------------------------------|--|----------------|--|-----------------|---------------------------|-----------------|-------------|--------|-------------------------------------------------------------------------------------|
| AMP TERM PN                  |  | MFR TERM PN    |  | PORTER TERMINAL |                           | AMP CRIMP SPECS |             |        |                                                                                     |
| 1572073                      |  | 76624-101      |  | PAD LTR         | CRIMP HEIGHT              |                 | WIRE SIZE   |        |                                                                                     |
|                              |  |                |  | A               | .033 ±.002 [0.84 ±0.05mm] |                 | 22          |        |  |
|                              |  |                |  | B               | .029 ±.002 [0.74 ±0.05mm] |                 | 24          |        |                                                                                     |
|                              |  |                |  | C               | .027 ±.002 [0.69 ±0.05mm] |                 | 26          |        |                                                                                     |
|                              |  |                |  | D               | NOT                       |                 | USED        |        |                                                                                     |
|                              |  |                |  | CRIMP           | SIZE                      | TYPE            | RANGE       |        |                                                                                     |
|                              |  |                |  | WIRE            | .042 [1.07mm]             | F               | 26-22       |        |                                                                                     |
|                              |  |                |  | INSUL           | .070 [1.78mm]             | F               | 1.2mm-1.7mm |        |                                                                                     |
| WIRE STRIP LENGTH            |  | TERM APPL SPEC |  | FEED            | APPL INSTRUCTION          |                 | SET UP GAGE | LAYOUT |                                                                                     |
| .079-.090                    |  | NONE           |  | .298            | 408-8040                  |                 | 458637-1    | L2640  |                                                                                     |

|                   |     |     |     |            |            |                                  |         |
|-------------------|-----|-----|-----|------------|------------|----------------------------------|---------|
| 2                 | 2   | 2   | -   | C          | 6-354779-5 | PIN, WIRE DISC (.3315)C          | 129     |
| 2                 | 2   | 2   | -   | C          | 6-354779-0 | PIN, WIRE DISC (.3290)B          | 127     |
| 2                 | 2   | 2   | -   | C          | 5-354779-0 | PIN, WIRE DISC (.3240)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     |
| 1                 | 1   | 1   | -   | A          | 4-21028-0  | PIN,SLT SPR(Ø.093x.75)ST GDE PL  | 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 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     |
|                   |     |     |     |            |            |                                  | 109     |
|                   |     |     |     |            |            |                                  | 108     |
| REF               | REF | REF | -   | A          | 21068-5    | NUT, HEX (6-32)FEED ADJ          | 107     |
|                   |     |     |     |            |            |                                  | 106     |
|                   |     |     |     |            |            |                                  | 105     |
|                   |     |     |     |            |            |                                  | 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      |
|                   |     |     |     |            |            |                                  | 93      |
|                   |     |     |     |            |            |                                  | 92      |
| 1                 | 1   | 1   | -   | A          | 1-21002-7  | SCR,BHC (6-32x.38)CAM            | 91      |
|                   |     |     |     |            |            |                                  | 90      |
|                   |     |     |     |            |            |                                  | 89      |
|                   |     |     |     |            |            |                                  | 88      |
| 2                 | 2   | 2   | -   | A          | 2-21000-5  | SCR,SHC (8-32x.44)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)FR 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 RECD PER ASSY |     |     |     | PARTS LIST |            |                                  |         |

| 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 |
|           |               |     |   |   |                |                             | 51 |
| 1         | 1             | 1   | - | A | 2-690518-4     | HOLDDOWN                    | 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 | 455673-3       | 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 | 690786-5       | SUPPORT, TERMINAL           | 34 |
| REF       | REF           | REF | - | D | 455675-1       | PLATE, BASE                 | 33 |
| 1         | 1             | 1   | - | A | 690432-3       | SCREW, ADJUSTMENT           | 32 |
|           |               |     |   |   |                |                             | 31 |
| REF       | REF           | REF | - | B | 455689-1       | BLOCK, STRIP GUIDE ADJ      | 30 |
| 1         | 1             | 1   | - | C | 1-455671-0     | PLATE, STRIP GUIDE          | 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 | 6-690504-4     | GUIDE, STRIP (REAR)         | 24 |
| 1         | 1             | 1   | - | A | 690438-1       | GUIDE, STRIP (FRONT)        | 23 |
| 1         | 1             | 1   | - | B | 690472-9       | STRIPPER                    | 22 |
| REF       | REF           | REF | - | A | 4-22284-9      | SPRING, FEED RETURN         | 21 |
|           |               |     |   |   |                |                             | 20 |
|           |               |     |   |   |                |                             | 19 |
|           |               |     |   |   |                |                             | 18 |
|           |               |     |   |   |                |                             | 17 |
| 1         | 1             | 1   | - | B | 318563-1       | GUARD, CHIP, FRONT          | 16 |
|           |               |     |   |   |                |                             | 1  |

|                                              |  |                               |  |                          |  |               |  |
|----------------------------------------------|--|-------------------------------|--|--------------------------|--|---------------|--|
| QTY REQD PER ASSY                            |  |                               |  | PARTS LIST               |  |               |  |
| DIMENSIONS IN INCHES.<br>DO NOT SCALE PRINT. |  | MATL                          |  | HT TR                    |  | FIN           |  |
|                                              |  | -                             |  | -                        |  | -             |  |
| TOLERANCES UNLESS<br>SPECIFIED:              |  | DR                            |  | 01APR02                  |  | APP           |  |
| 2 PLC DEC ±                                  |  | B.HIGMAN                      |  | T.ELBIN                  |  |               |  |
| 3 PLC DEC ±                                  |  | CHK                           |  | REL                      |  |               |  |
| 4 PLC DEC ±                                  |  | -                             |  | -                        |  |               |  |
| ANGLES ±                                     |  | NAME                          |  | SIDE FEED HDM APPLICATOR |  | MACHINE       |  |
| SURF TREATURE: ✓                             |  | SCALE                         |  | DWG NO                   |  | REF           |  |
|                                              |  | -                             |  | 1385401                  |  | MINI          |  |
| REMOVE BURRS, BREAK<br>SHARP EDGES R.015 MAX |  | D                             |  |                          |  | APPL          |  |
|                                              |  | SHEET                         |  | REV                      |  |               |  |
|                                              |  | 1 of 1                        |  | A                        |  |               |  |
| CAGE CODE<br>00779                           |  | CUSTOMER AND ASSEMBLY DRAWING |  |                          |  | RESTRICTED TO |  |
|                                              |  |                               |  |                          |  | -             |  |

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