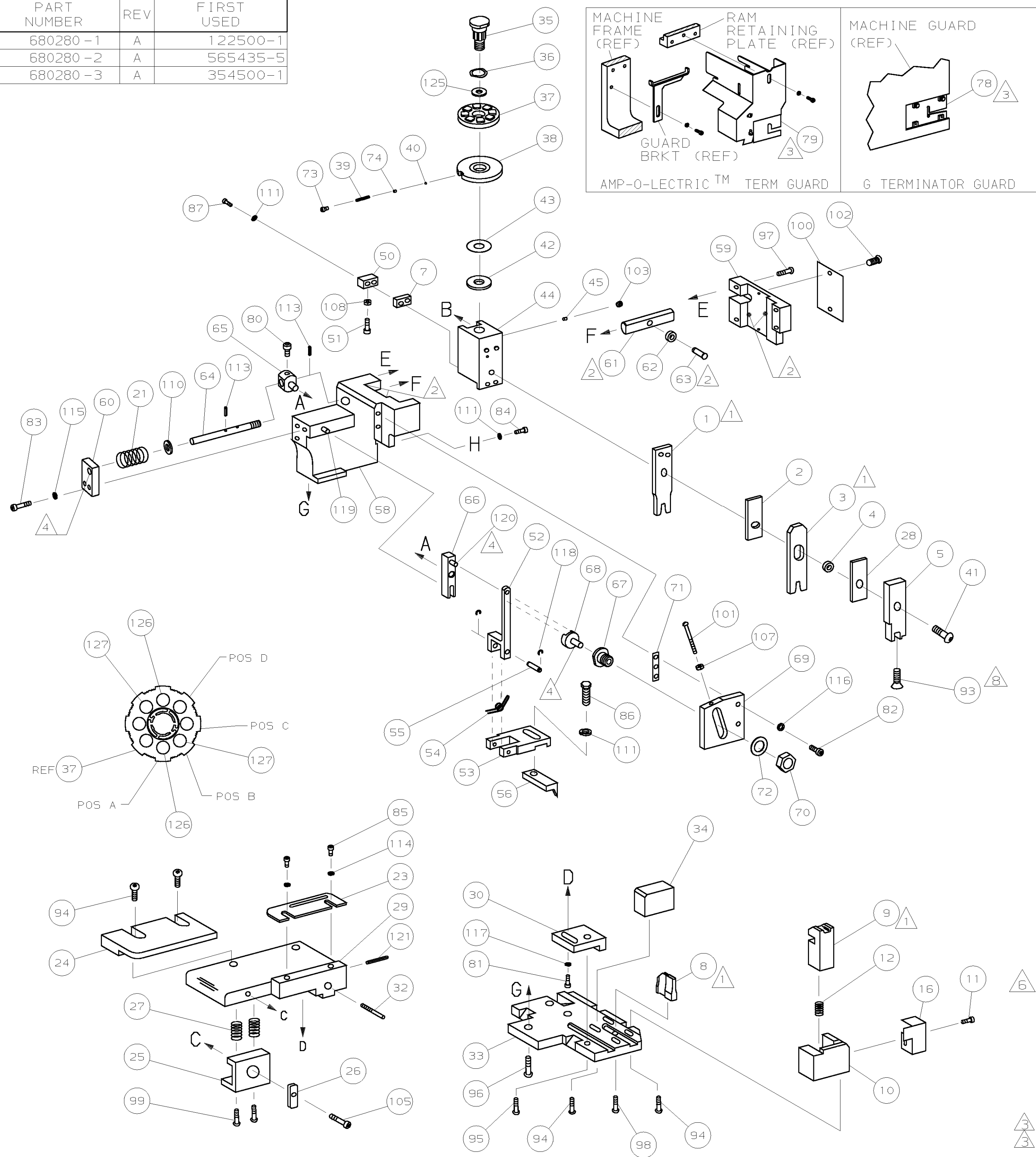
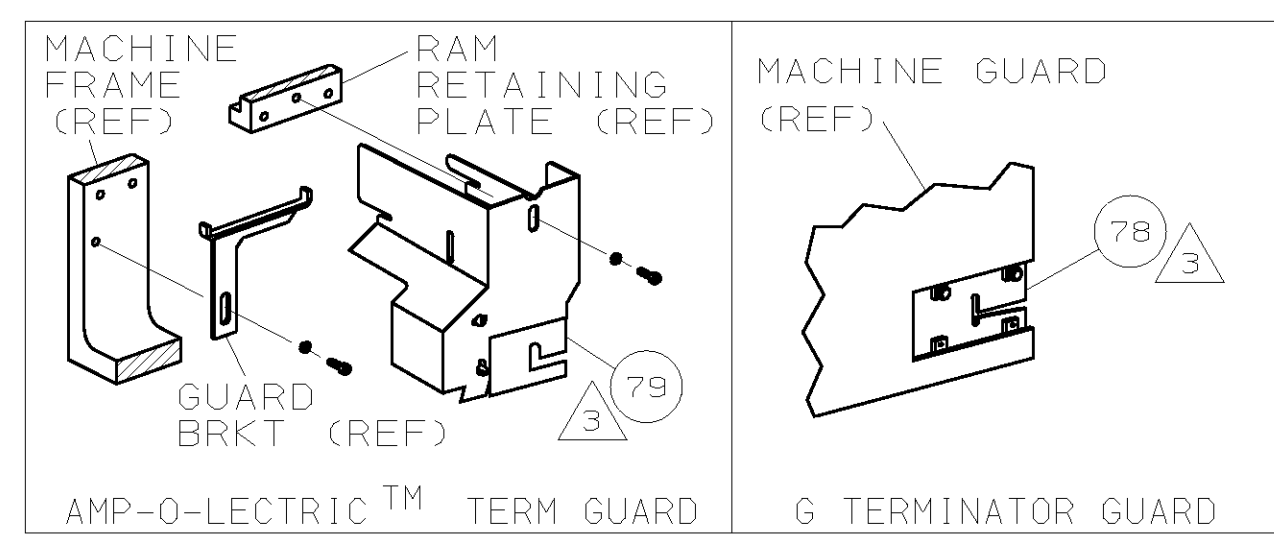


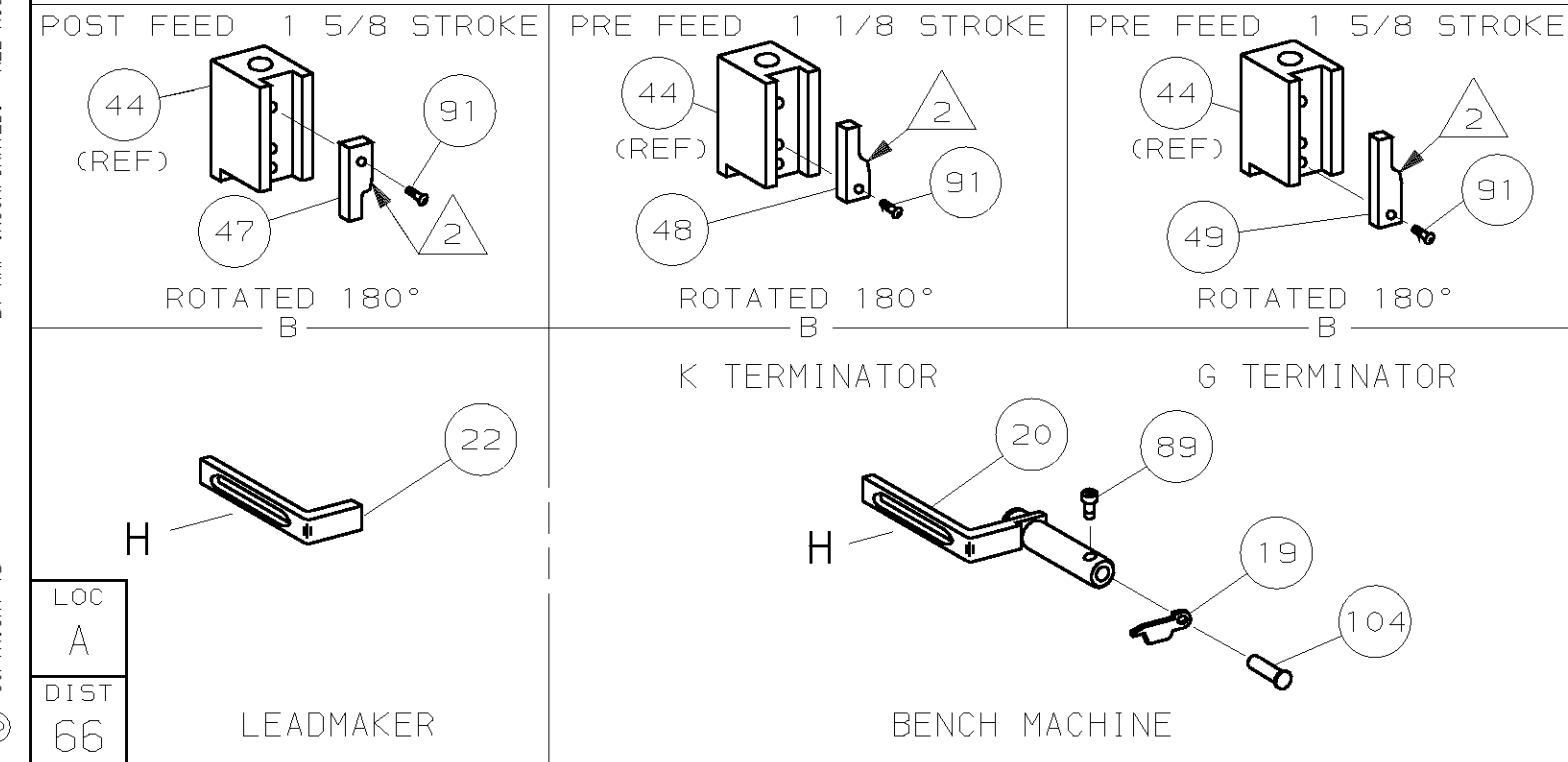
PART NUMBER	REV	FIRST USED
680280-1	A	122500-1
680280-2	A	565435-5
680280-3	A	354500-1



SEAL		TERMINAL		CRIMPING DATA	
356147-1		356137-1		PAD LTR	CRIMP HEIGHT
				A	.083 ±.002 [2.11 ±0.05mm]
				B	.063 ±.002 [1.6 ±0.05mm]
				C	NOT USED
				D	NOT USED
AMP P/N		MFG P/N		CRIMP	
356137-1		12040559		SIZE	TYPE
				.110 [2.79mm]	F
				INSUL	0
				RANGE	1mm ² - 2.5mm ²
				WIRE STRIP LENGTH	TERM APPL SPEC
				-	NONE
				FEED	.600
				APPL INSTRUCTION	408-8040
				SET UP GAGE	458637-1
				LAYOUT	L1748

QTY	REQD	PER	ASSY	TERMINAL	DESCRIPTION	ITEM NO	
2	2	2	-	C	354779-9	PIN, WIRE DISC (.3035)B	127
2	2	2	-	C	6-354778-5	PIN, WIRE DISC (.2820)A	126
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	1	1	-	A	217238-1	DOCUMENTATION 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
1	1	1	-	A	21018-5	NUT, HEX (NO. 6) HOLDDOWN	108
REF	REF	REF	-	A	21018-5	NUT, HEX (6-32) FEED ADJ	107
							106
1	1	1	-	A	22353-8	SCR, SHLD (Ø.187x.25) DRAG LEVER	105
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) 56 ADJ BLOCK	95
6	6	6	-	A	2-21002-2	SCR, BHC (8-32x.50) TERM H DWN	94
1	1	1	-	A	1-21003-9	SCR, FLAT HD (6-32x.38)	93
							92
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38) CAM	91
							90
1	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.60) 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) 56 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

QTY	REQD	PER	ASSY	LEADMAKER	MECH POST FEED	DESCRIPTION	ITEM NO
-1				B	MECH PRE FEED	NUT, HEX (1/2-20)	70
-2				B	MECH PRE FEED	PLATE, ADJUSTMENT	69
-3				B	MECH PRE FEED	SHAFT, PIVOT	68
REF	REF	REF	-	B		BUSHING	67
REF	REF	REF	-	B		LEVER, INTERMEDIATE	66
REF	REF	REF	-	B		BLOCK, PIVOT	65
REF	REF	REF	-	A		SCREW, ADJ FEED ROD	64
REF	REF	REF	-	B		PIN, CAM ROLLER	63
REF	REF	REF	-	B		ROLLER, CAM	62
REF	REF	REF	-	B		ROD, FEED	61
REF	REF	REF	-	A		GUIDE, FEED ROD	60
REF	REF	REF	-	C		CAP, RAM	59
REF	REF	REF	-	D		HOUSING	58
							57
1	1	1	-	B		PAWL, FEED	56
REF	REF	REF	-	B		PIN, FEED FINGER	55
REF	REF	REF	-	B		SPRING, FEED FINGER	54
REF	REF	REF	-	B		HOLDER, FEED FINGER	53
REF	REF	REF	-	A		LEVER, TERMINAL FEED ARM	52
1	1	1	-	A		BUMPER, HOLDDOWN	51
1	1	1	-	A		SPACER, TONKER	50
1	-	-	-	B		CAM, PRE-FEED 1 5/8 ST	49
-	1	-	-	B		CAM, PRE-FEED 1 1/8 ST	48
-	-	1	-	B		CAM, POST-FEED 1 5/8 ST	47
1	1	1	-	B		APPLICATOR, BASIC (SUBASSY)	46
1	1	1	-	A		PLUG, NYLON	45
1	1	1	-	C		RAM	44
1	1	1	-	A		WASHER, LAMINATED	43
1	1	1	-	A		WASHER, RAM	42
1	1	1	-	A		BOLT, CRIMPER (5/16x1.00)	41
1	1	1	-	A		BALL, STEEL	40
1	1	1	-	A		SPRING, COMPRESSION	39
1	1	1	-	C		DISC, INSULATION	38
1	1	1	-	D		WIRE DISC, PLASTIC	37
1	1	1	-	A		WASHER, SPRING	36
1	1	1	-	B		POST, RAM	35
1	1	1	-	B		SUPPORT, TERMINAL	34
REF	REF	REF	-	D		PLATE, BASE	33
1	1	1	-	A		SCREW, ADJUSTMENT	32
							31
REF	REF	REF	-	B		BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	C		STRIP GUIDE PLATE ASSY	29
1	1	1	-	C		SPACER, FRONT SHEAR DEP	28
2	2	2	-	A		SPRING, DRAG	27
1	1	1	-	B		LEVER, DRAG RELEASE	26
1	1	1	-	B		DRAG, TERMINAL	25
1	1	1	-	D		GUIDE, STRIP (REAR)	24
1	1	1	-	A		GUIDE, STRIP (FRONT)	23
-	-	1	-	B		STRIPPER	22
REF	REF	REF	-	A		SPRING, FEED RETURN	21
1	1	1	-	A		STRIPPER WIRE STOP ASSY	20
1	1	1	-	B		STRIPPER	19
							18
							17
1	1	1	-	B		GUARD, CHIP, FRONT	16
							15
							14
							13
1	1	1	-	A		SPRING, SHEAR	12
1	1	1	-	B		STOP, SHEAR	11
1	1	1	-	C		HOLDER, SHEAR (FRONT)	10
1	1	1	-	C		SHEAR, FLOAT (FRONT)	9
1	1	1	-	C		ANVIL	8
1	1	1	-	C		SPACER, DEPRESSOR (REAR)	7
							6
1	1	1	-	C		DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B		SPACER, BLOCK CRIMPER	4
1	1	1	-	C		CRIMPER, INSULATION	3
1	1	1	-	C		SPACER, CRIMPER	2
1	1	1	-	C		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 CUT TO LENGTH AT ASSY
- 7 THIS APPLICATOR CRIMPS TERMINAL WITH A SEAL
- 8 FILL ALLEN SOCKET WITH TORQ-SEAL AFTER APPLICATOR HAS BEEN QUALIFIED. APPLY #1-23419-5 LOC-TITE TO THREADS.

LOC	DIST	QTY	REQD	PER	ASSY	U/M	DWG	SIZE	PART NO	DESCRIPTION	ITEM NO
A	66										

MATL	HT TR	FIN	DR	APP	REL	CHK	REL	APP	DATE
			J.BAKER	3/8/96	T ELBIN	C.HERISMAN	B. MORGAN		