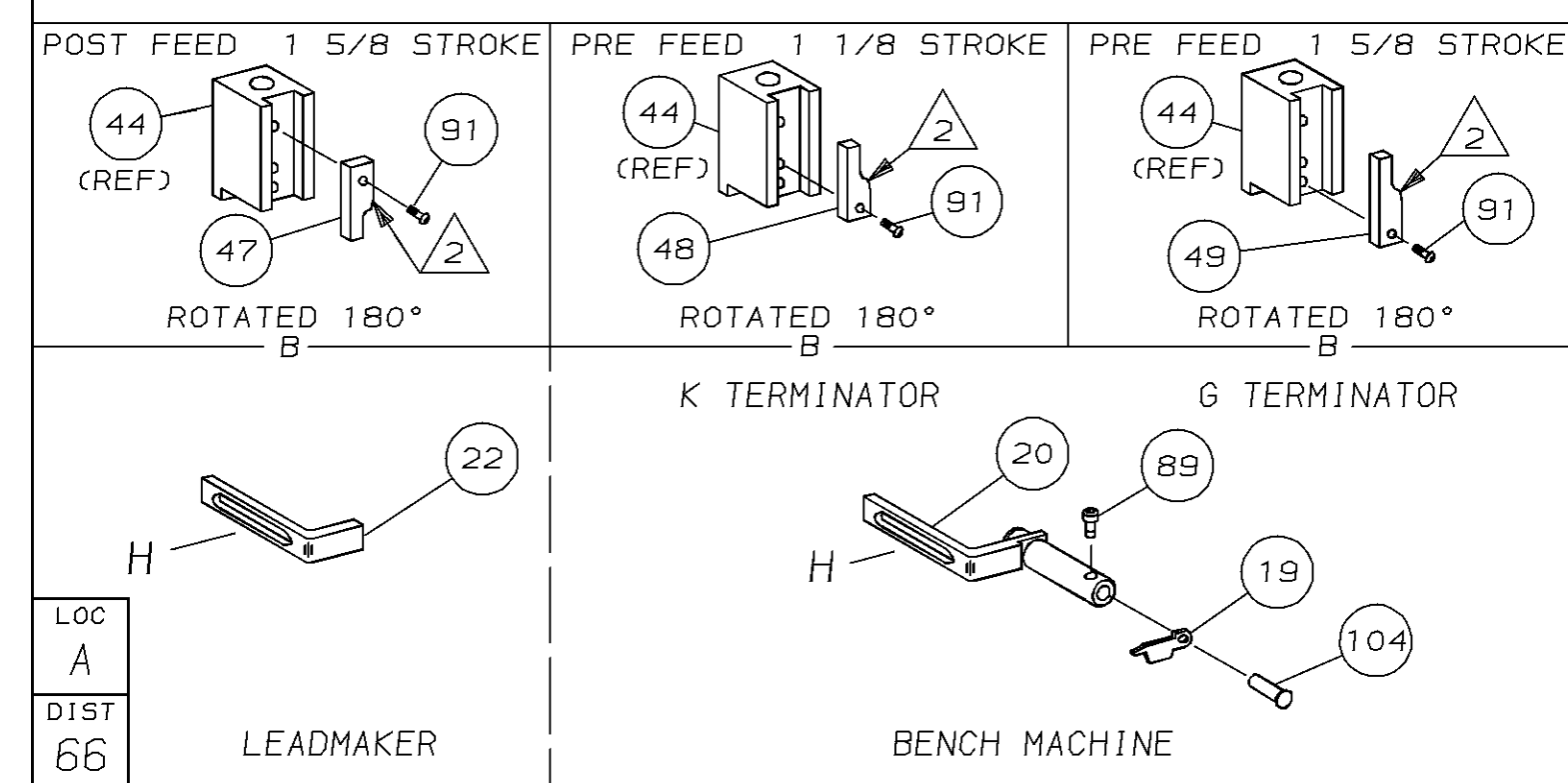
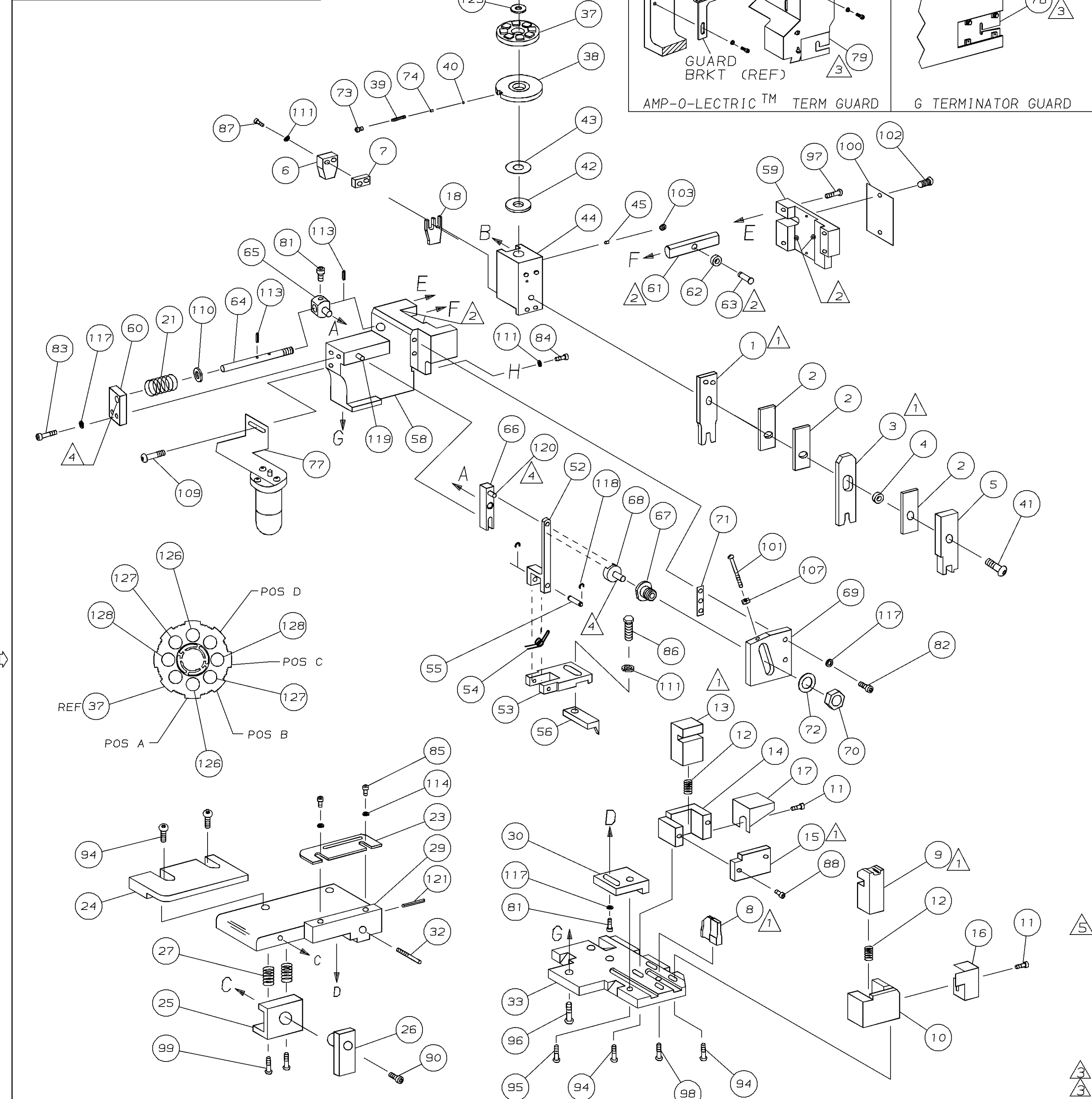


PART NUMBER	REV	FIRST USED
680461-1	B	122500-1
680461-2	B	565435-5
680461-3	B	354500-1



- 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 CUT TO LENGTH AT ASSY
- 6 GUIDE OFF INSULATION BARREL

PAD LTR		CRIMP HEIGHT	WIRE SIZE
A	.050 ±.002 [1.28 ±0.05mm]	1 mm <sup>2</sup>	
B	.043 ±.002 [1.10 ±0.05mm]	0.5 mm <sup>2</sup>	
C	NOT	USED	
D	NOT	USED	

CRIMP	SIZE	TYPE	RANGE
WIRE	.090 [2.29mm]	F	0.5 mm <sup>2</sup> -1 mm <sup>2</sup>
INSUL	.100 [2.54mm]	F	-

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.218-.250	NONE	.512	408-8040	458637-1	L1926

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO	
1	129		129	
1	128		128	
2	2	3-354779-6	PIN, WIRE DISC (.3170)B	127
2	2	2-354779-2	PIN, WIRE DISC (.3100)A	126
1	1	986950-1	WASHER, FLAT PRECISION	125
1	1	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	4088040	SF APPL INST 408-8040	123
1	1			122
1	1	4-21028-0	PIN, SLT SPR (Ø.093x.75) ST 6DF PL	121
1	1	1-21030-1	PIN, DOWEL (Ø.187x.50) LEVER	120
1	1	1-21030-6	PIN, DOWEL (Ø.187x1.25) HOUSING	119
2	2	21045-3	RING, RET "C" (Ø.187) FD FING PIN	118
5	5	21024-5	WASHER, LOCK (#10) ADJ BLOCK	117
				116
				115
2	2	21024-2	WASHER, LOCK (#4) FRONT STP GUIDE	114
2	2	5-21028-1	PIN, SLT SPR (Ø.125x.50) ADJ ROD	113
				112
4	4	21024-4	WASHER, LOCK (#8) STRIPPER	111
1	1	21899-4	WASHER, FLAT (Ø5/16) SCREW ADJ	110
-	1	2-21002-6	SCR, BHC (10-32x.38) LUBE ASSY	109
				108
1	1	21018-5	NUT, HEX (6-32) FEED ADJ	107
				106
				105
1	1	992031-1	PIN, CLEVIS	104
1	1	21009-2	SCR, SKT SET (1/4-20x.25 LW) RAM	103
2	2	21017-2	SCR, DRIVE (#2x.19) ID PLATE	102
1	1	6-23715-5	SCR, PAN HD (6-32x1.50) FEED ADJ	101
1	1	461264-1	PLATE, IDENTIFICATION	100
2	2	3-21002-0	SCR, BHC (10-32x.88) DRAG	99
1	1	22733-8	SCR, BHC (8-32x.38 LW) ANVIL	98
2	2	2-21002-9	SCR, BHC (10-32x.75) CAP	97
3	3	2-22733-8	SCR, BHC (1/4-20x.62) HOUSING	96
1	1	2-21002-7	SCR, BHC (10-32x.50) SG ADJ BLOCK	95
6	6	2-21002-2	SCR, BHC (8-32x.50) TERM H DWN	94
				93
				92
1	1	1-21002-7	SCR, BHC (6-32x.38) CAM	91
1	1	22353-8	SCR, SHLD (.187x.250L6) DRAG	90
1	1	7-21000-9	SCR, SHC (4-40x.19) STRIPPER	89
2	2	1-21000-8	SCR, SHC (6-32x.50) R SHEAR PLATE	88
2	2	3-21000-0	SCR, SHC (8-32x1.06) DEP-HOLD	87
1	1	2-22603-0	SCR, HEX HD (8-32x.31) FEED FINGER	86
2	2	1-21000-3	SCR, SHC (4-40x.25) F ST GUIDE	85
1	1	2-21000-7	SCR, SHC (8-32x.50) STRIPPER	84
2	2	3-21000-7	SCR, SHC (10-32x.75) FEED ROD 6D	83
2	2	3-21000-6	SCR, SHC (10-32x.62) FEED ADJ BLK	82
2	2	3-21000-4	SCR, SHC (10-32x.38) SG ADJ BL	81
				80
-	REF	455749-1	GUARD, WINDOW	79
REF	-	679532-1	INSERT, GUARD	78
-	1	1-465184-0	LUBRICATOR ASSY	77
				76
				75
1	1	690603-1	SPRING, ASSIST	74
1	1	23030-1	SCR, SHC (6-32x.25 SL) INS DISC	73
1	1	458109-1	WASHER, SPECIAL	72
1	1	690517-1	SPACER	71

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO	
1	1	22594-8	NUT, HEX (1/2-20)	70
1	1	240628-1	PLATE, ADJUSTMENT	69
1	1	240626-1	SHAFT, PIVOT	68
1	1	240633-1	BUSHING	67
1	1	455680-1	LEVER, INTERMEDIATE	66
1	1	240629-1	BLOCK, PIVOT	65
1	1	240632-2	SCREW, ADJ FEED ROD	64
1	1	240659-3	PIN, CAM ROLLER	63
1	1	240658-1	ROLLER, CAM	62
1	1	454398-2	ROD, FEED	61
1	1	454178-1	GUIDE, FEED ROD	60
1	1	454220-1	CAP, RAM	59
1	1	454485-1	HOUSING	58
				57
1	1	690542-2	PAWL, FEED	56
1	1	240624-1	PIN, FEED FINGER	55
1	1	691499-1	SPRING, FEED FINGER	54
1	1	690541-1	HOLDER, FEED FINGER	53
1	1	455679-1	LEVER, TERMINAL FEED ARM	52
				51
				50
1	-	690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	1	690602-5	CAM, PRE-FEED 1 1/8 ST	48
-	-	690501-4	CAM, POST-FEED 1 5/8 ST	47
				46
1	1	690191-1	PLUG, NYLON	45
1	1	455673-1	RAM	44
1	1	690125-1	WASHER, LAMINATED	43
1	1	690124-1	WASHER, RAM	42
1	1	690686-1	BOLT, CRIMPER (5/16x1.00)	41
1	1	23241-6	BALL, STEEL	40
1	1	690170-1	SPRING, COMPRESSION	39
1	1	690142-1	DISC, INSULATION	38
1	1	354777-1	WIRE DISC, PLASTIC	37
1	1	22480-5	WASHER, SPRING	36
1	1	690212-1	POST, RAM	35
				34
1	1	455675-9	PLATE, BASE	33
1	1	690432-3	SCREW, ADJUSTMENT	32
				31
1	1	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	458144-1	PLATE, STRIP GUIDE	29
				28
2	2	1-22284-0	SPRING, DRAG	27
1	1	240793-1	LEVER, DRAG RELEASE	26
1	1	240792-1	DRAG, TERMINAL	25
1	1	7-690504-8	GUIDE, STRIP (REAR)	24
1	1	690438-1	GUIDE, STRIP (FRONT)	23
-	-	690472-2	STRIPPER	22
1	1	4-22284-9	SPRING, FEED RETURN	21
1	1	679218-1	STRIPPER WIRE STOP ASSY	20
1	1	458949-1	STRIPPER	19
1	1	189369-3	HOLDER, TERMINAL	18
1	1	691668-1	GUARD, CHIP (REAR)	17
1	1	318563-1	GUARD, CHIP, FRONT	16
1	1	690464-4	PLATE, SHEAR (REAR)	15
1	1	690462-1	HOLDER, SHEAR (REAR)	14
1	1	690463-1	SHEAR, FLOAT (REAR)	13
2	2	5-22280-0	SPRING, SHEAR	12
2	2	690461-1	STOP, SHEAR	11
1	1	690459-1	HOLDER, SHEAR (FRONT)	10
1	1	454276-1	SHEAR, FLOAT (FRONT)	9
1	1	1-662187-1	ANVIL	8
1	1	7-240641-4	SPACER, DEPRESSOR (REAR)	7
1	1	453393-3	DEPRESSOR, SHEAR (REAR)	6
1	1	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
1	1	238011-7	SPACER, BLOCK CRIMPER	4
1	1	1213077-4	CRIMPER, INSULATION	3
3	3	1-455888-2	SPACER, CRIMPER	2
1	1	5-456406-0	CRIMPER, WIRE	1

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO				
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED.		MATERIAL		FINISH	
DR	5/13/97	APP	5/13/97	HT TR	-
P. MCCARTY	J. DODDS				
CHK	5/13/97	REL	11/4/97		
C. ERISMAN	B. MORGAN				

SCALE	DWG NO	REVISION RECORD	DATE
A	680461	CE	8/97