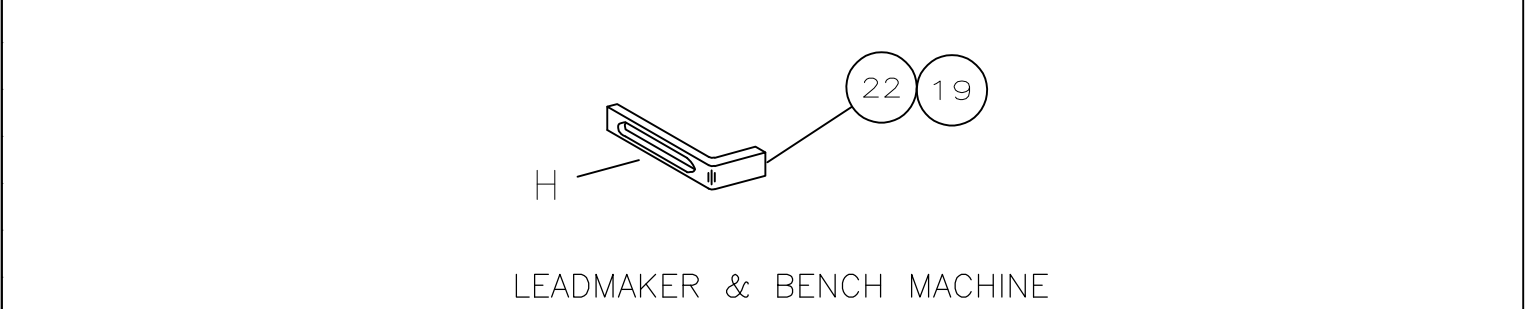
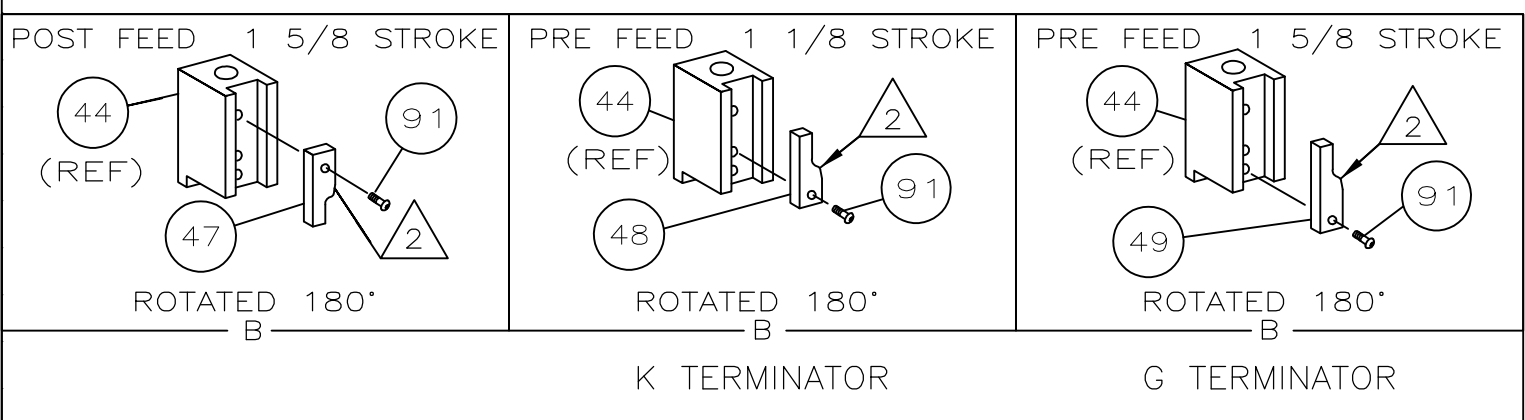
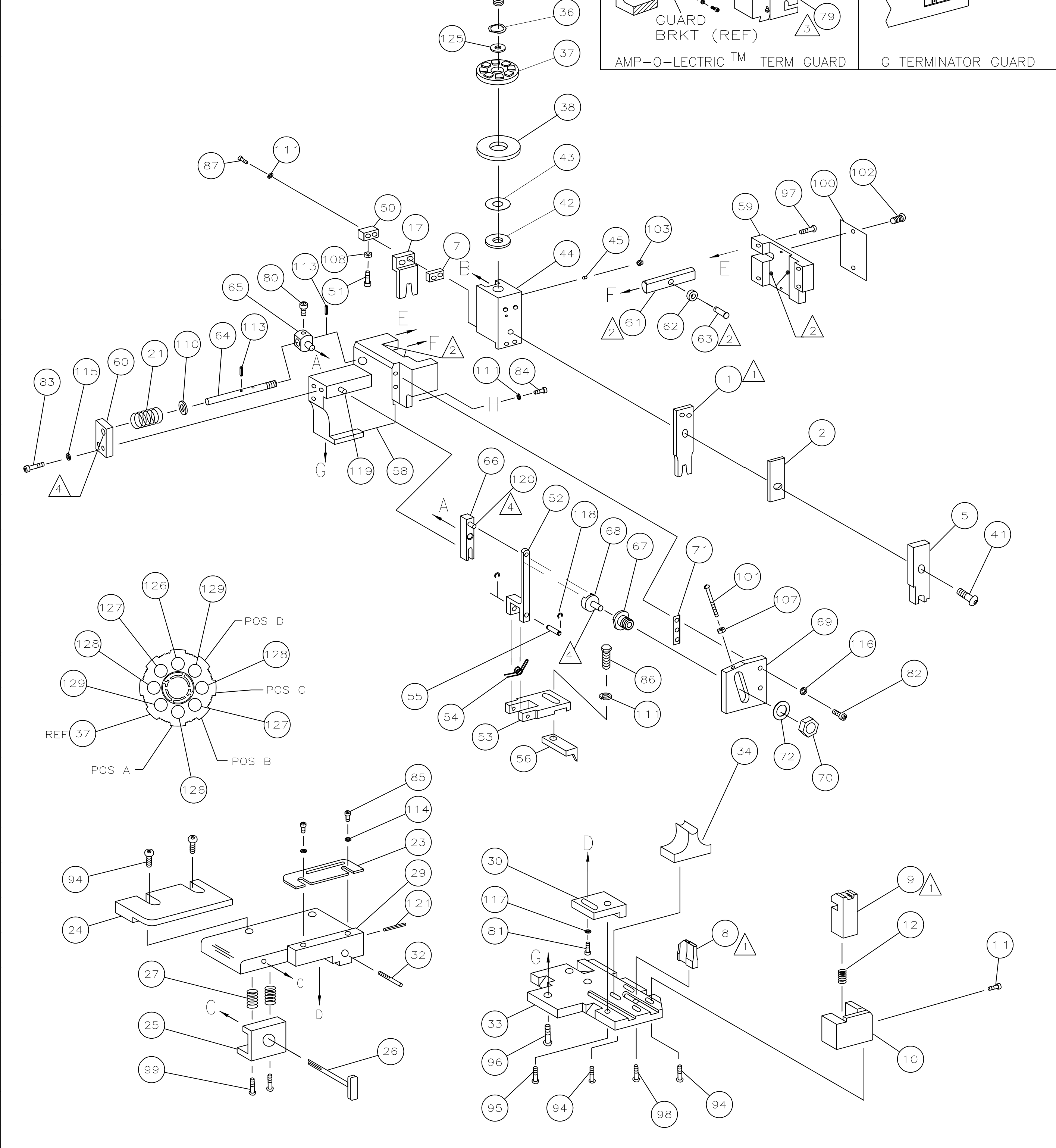
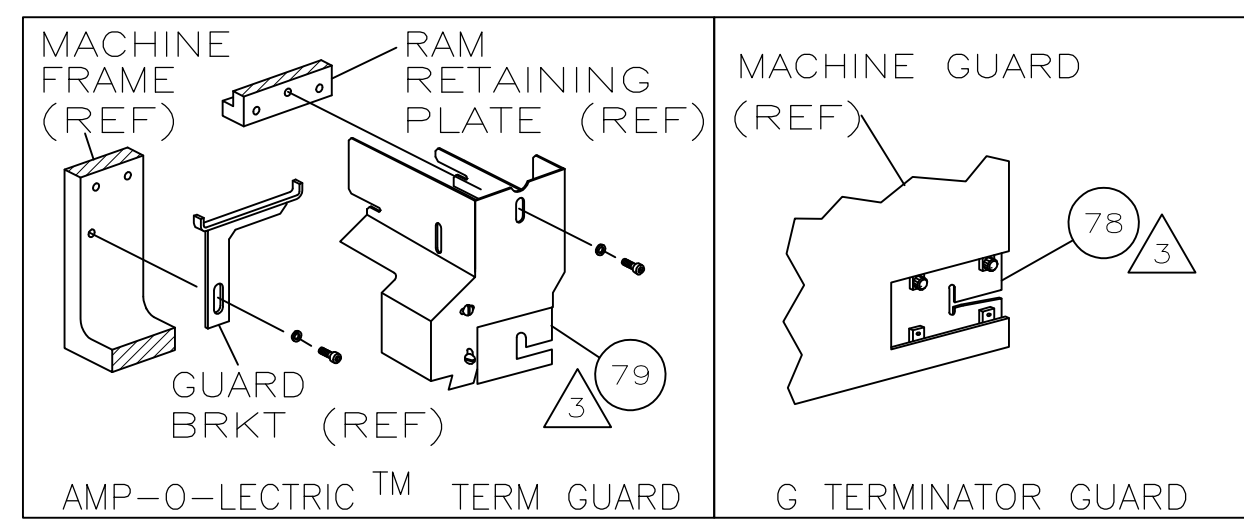


PART NUMBER	REV	FIRST USED
680638-1	C	122500-1
680638-2	C	565435-5
680638-3	C	354500-1



- 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. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
- 6 CUT TO LENGTH AT ASSY

TERMINAL NAME: .140 MATE-N-LOK™ PIN

770484		CRIMP DATA (TE TERMINAL)	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.100 ±.002 [2.54 ±0.05mm]	10	
B	.082 ±.002 [2.08 ±0.05mm]	12	
C	.070 ±.002 [1.78 ±0.05mm]	14	
D	NOT USED		
CRIMP	SIZE	TYPE	RANGE
WIRE	.140 [3.56mm]	F	14-10
INSUL	-	-	-

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.188-.219	114-49000	.590	408-8040	458637-1	L2074

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
129						
2	2	2	-	9-354778-9	PIN, WIRE DISC (.2990)C	128
2	2	2	-	7-354778-1	PIN, WIRE DISC (.2850)B	127
2	2	2	-	3-354778-5	PIN, WIRE DISC (.2670)A	126
1	1	1	-	986950-1	WASHER, FLAT PRECISION	125
1	1	1	-	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	1	-	4088040	SF APPL INST 408-8040	123
1	1	1	-	4-21028-0	PIN,SLT SPR(Ø.093x.75)ST GDE PL	121
REF	REF	REF	-	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	120
REF	REF	REF	-	1-21030-6	PIN,DOWEL(Ø.187x1.25)HOUSING	119
REF	REF	REF	-	21045-3	RING,RET "C"(Ø.187)FD FING PIN	118
1	1	1	-	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
REF	REF	REF	-	21024-5	WASHER,LOCK(#10)ADJ PLATE	116
REF	REF	REF	-	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115
2	2	2	-	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
REF	REF	REF	-	5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	113
4	4	4	-	21024-4	WASHER,LOCK(#8)STRIPPER	111
REF	REF	REF	-	21899-4	WASHER,FLAT(Ø5/16)SCREW ADJ	110
1	1	1	-	21018-5	NUT,HEX(NO.6)HOLDDOWN	108
REF	REF	REF	-	21068-5	NUT,HEX(6-32)FEED ADJ	107
1	1	1	-	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
2	2	2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
REF	REF	REF	-	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
1	1	1	-	461264-1	PLATE, IDENTIFICATION	100
2	2	2	-	5-21006-6	SCR,SET(10-32x.75)DRAG	99
1	1	1	-	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
REF	REF	REF	-	2-21002-9	SCR,BHC(10-32x.75)CAP	97
REF	REF	REF	-	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
REF	REF	REF	-	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
6	6	6	-	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
1	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	91
2	2	2	-	2-21000-8	SCR,SHC(8-32x.62)DEP-HOLD	87
1	1	1	-	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
2	2	2	-	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	85
1	1	1	-	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
REF	REF	REF	-	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
REF	REF	REF	-	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	82
1	1	1	-	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
REF	REF	REF	-	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	80
-	REF	-	-	455749-1	GUARD, WINDOW	79
REF	-	-	-	679532-1	INSERT, GUARD	78
						77
						76
						75
						74
						73
						72
REF	REF	REF	-	458109-1	WASHER, SPECIAL	71
REF	REF	REF	-	690517-1	SPACER	70
-3	-2	-1	U/M			

LOC	DIST	REV	DESCRIPTION	DATE	OWN	APVD
A	66	C	ECR-07-022125	9-2007	MY	GB

REV	DESCRIPTION
-1	LEADMAKER MECH POST FEED
-2	BENCH MODEL K MECH PRE FEED
-3	BENCH MODEL G MECH PRE FEED

REF	REF	REF	REF	REF	DESCRIPTION	ITEM NO
REF	REF	REF	REF	REF	22594-8 NUT,HEX(1/2-20)	70
REF	REF	REF	REF	REF	240628-1 PLATE, ADJUSTMENT	69
REF	REF	REF	REF	REF	240626-1 SHAFT, PIVOT	68
REF	REF	REF	REF	REF	240633-1 BUSHING	67
REF	REF	REF	REF	REF	455680-1 LEVER, INTERMEDIATE	66
REF	REF	REF	REF	REF	240629-1 BLOCK, PIVOT	65
REF	REF	REF	REF	REF	240632-2 SCREW, ADJ FEED ROD	64
REF	REF	REF	REF	REF	240659-3 PIN, CAM ROLLER	63
REF	REF	REF	REF	REF	240658-1 ROLLER, CAM	62
REF	REF	REF	REF	REF	454398-2 ROD, FEED	61
REF	REF	REF	REF	REF	454178-1 GUIDE, FEED ROD	60
REF	REF	REF	REF	REF	454220-1 CAP, RAM	59
REF	REF	REF	REF	REF	454485-1 HOUSING	58

REF	REF	REF	REF	REF	DESCRIPTION	ITEM NO
1	1	1	1	1	458537-2 PAWL, FEED	56
REF	REF	REF	REF	REF	240624-1 PIN, FEED FINGER	55
REF	REF	REF	REF	REF	691499-1 SPRING, FEED FINGER	54
REF	REF	REF	REF	REF	690541-1 HOLDER, FEED FINGER	53
REF	REF	REF	REF	REF	455679-1 LEVER, TERMINAL FEED ARM	52
1	1	1	1	1	811242-2 BUMPER, HOLDDOWN	51
1	1	1	1	1	690753-1 SPACER, TONKER	50
1	-	-	-	-	690602-6 CAM, PRE-FEED 1 5/8 ST	49
-	1	-	-	-	690602-5 CAM, PRE-FEED 1 1/8 ST	48
-	-	1	-	-	690501-4 CAM, POST-FEED 1 5/8 ST	47
1	1	1	1	1	459456-1 APPLICATOR, BASIC (SUBASSY)	46
1	1	1	1	1	690191-1 PLUG, NYLON	45
1	1	1	1	1	455673-1 RAM	44
1	1	1	1	1	690125-1 WASHER, LAMINATED	43
1	1	1	1	1	690124-1 WASHER, RAM	42
1	1	1	1	1	7-21002-9 BOLT, CRIMPER(5/16x1.00)	41

REF	REF	REF	REF	REF	DESCRIPTION	ITEM NO
1	1	1	1	1	690223-2 SPACER, INSULATION DISC	38
1	1	1	1	1	354777-1 WIRE DISC, PLASTIC	37
1	1	1	1	1	22480-5 WASHER, SPRING	36
1	1	1	1	1	690212-1 POST, RAM	35
1	1	1	1	1	457755-1 SUPPORT, TERMINAL	34
REF	REF	REF	REF	REF	455675-1 PLATE, BASE	33
1	1	1	1	1	690432-3 SCREW, ADJUSTMENT	32
REF	REF	REF	REF	REF	455689-1 BLOCK, STRIP GUIDE ADJ	30
1	1	1	1	1	455671-1 PLATE, STRIP GUIDE	29
2	2	2	2	2	1-22284-0 SPRING, DRAG	27
1	1	1	1	1	690546-1 LEVER, DRAG RELEASE	26
1	1	1	1	1	240792-1 DRAG, TERMINAL	25
1	1	1	1	1	8-690504-9 GUIDE, STRIP (REAR)	24
1	1	1	1	1	690438-4 GUIDE, STRIP (FRONT)	23
-	-	1	-	-	690472-5 STRIPPER	22
REF	REF	REF	REF	REF	4-22284-9 SPRING, FEED RETURN	21

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
1	1	1	-	691353-1	STRIPPER	20
1	1	1	-	691353-1	STRIPPER	19
1	1	1	-	457754-1	TOOL, SIZING	17
1	1	1	-	457754-1	TOOL, SIZING	16
1	1	1	-	3-22280-3	SPRING, SHEAR	12
1	1	1	-	690461-2	STOP, SHEAR	11
1	1	1	-	2-690459-0	HOLDER, SHEAR (FRONT)	10
1	1	1	-	2-454276-4	SHEAR, FLOAT (FRONT)	9
1	1	1	-	1-904717-5	ANVIL	8
1	1	1	-	3-240641-8	SPACER, DEPRESSOR (REAR)	7
1	1	1	-	2-455889-1	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	2-455888-7	SPACER, CRIMPER	2
1	1	1	-	6-458141-9	CRIMPER, WIRE	1
-3	-2	-1	U/M			

THIS DRAWING IS A CONTROLLED DOCUMENT.

DMN: P. MATHIAS 05/JUN/98  
 CHK: C. FERISMAN 05/JUN/98  
 APVD: J. ELBIN 05/JUN/98

Tyco Electronics Corporation  
 Harrisburg, PA 17105-3608

NAME: SIDE FEED HDM APPLICATOR

SIZE: A1  
 CAGE CODE: 00779  
 DRAWING NO: 680638

CUSTOMER DRAWING