

DIMENSIONING AND TOLERANCING PER ASME Y14.5M (ISO STANDARDS)

PART NUMBER	REV	FIRST USED	TYPE
680017-1	P	122500-1	T-UNIT
680017-2	P	680017-4	K-UNIT
680017-3	P	354500-1	G-UNIT
680017-4	P	122500-1	T-UNIT

CRIMPING DATA			THIS APPLICATOR WILL APPLY
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	TERMINAL P/N
A	.115±.002	10	520974
B	.094±.002	12	521366
C	.093±.002	(1)16 + (1)14	-
D	.081±.002	14	-
CRIMP SIZE	TYPE	FEED	-
WIRE	.130 F	.760	-
INS.	8	-	-
INSULATION RANGE	WIRE RANGE	TERM SPEC.	-
8	14-10	AI 408-8095 & 8098	-

- 1 RECOMMENDED SPARE PARTS
- 2 ITEMS NOT SHOWN
- 3 TOL ±.25
- 4 TO RUN THIS APPLICATOR ON THE AMPOMATOR SEE DOC. PACKAGE ITEM 146
- 5 USE SEALANT PN 1-23419-5 AS SHOWN
- 6 WHEN TERMINATING #12 OR #14 WIRE, ITEMS 163 & 164 MUST BE USED

- 7 SET APPLICATOR UP FOR #10 WIRE USING ITEMS 51 & 98, SEND ITEMS 163 & 164 ALONG WITH APPLICATOR
- 8 INSUL CRIMP SIZE INSUL RANGE
 #10- .250F (BLUNT) Ø.200 MAX
 #12 & #14- .220F (BLUNT) Ø.130-Ø.180
- 9 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.

- 1 AFTER QUALIFICATION, DRILL AND PIN ITEM 2 TO ITEM 1 USING ITEM 169, 2 PLACES (-4 ONLY)
- 2 ITEM 56 TO BE INSTALLED AT ASSEMBLY; ITEMS 62,63 AND 64 TO BE SHIPPED ALONG WITH APPLICATOR AS SPARE PARTS.
- 13. CANNOT RUN 2 WIRES ON LEADMAKER.
- 14. SPRING LOADED TONKER (P/N 354853-1) MUST BE USED WHEN RUNNING THE APPLICATOR ON A LEADMAKER.

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
2	8-354778-9	PIN, WIRE DISC (.2940)D	178
2	6-354778-5	PIN, WIRE DISC (.2820)C	177
2	6-354778-3	PIN, WIRE DISC (.2810)B	176
2	2-354778-1	PIN, WIRE DISC (.2600)A	175
1	986950-1	WASHER, FLAT PRECISION	174
2	21026-4	WASHER, STAR	173
2	21017-2	SCR., DRIVE 2 X .19	172
1	461264-1	TAG, IDENTIFICATION	170
2	21029-5	PIN, SLOTTED SPRING	169
1	28582-1	LUBRICATOR	168
1	22311-2	NIPPLE	167
1	28580-1	FILTER, MINITURE	166
1	23791-2	TEE, FEMALE	165
1	856179-1	ANVIL	164
1	463692-3	CRIMPER,INSULATION	163
2	26108-1	BODY, QUICK CONNECT	162
2	19832-1	TIE,WIRE	160
1	22307-1	BUSHING, PIPE FITTING	159
2	21024-5	WASHER, LOCK, #10	158
2	4-21000-3	SHCS 10-32 X 2.00	157
1	27319-4	TUBING,NYLON .250 DIA	154
2	23238-1	INSERT,COUPLING	153
1	455755-8	GUARD ASSY	151
1	679532-1	GUARD, INSERT	150
1	1-21018-6	NUT, HEX, 5/16-24	149
1	21007-8	SCR,SOC SET(1/4-20X.63)	145
1	459610-3	MOUNT,FEED BRACKET	144
1	23241-6	BALL,STEEL	143
1	690603-1	SPRING,ASSIST	142
1	690170-1	SPRING, COMPRESSION	141

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
1	23030-1	SCR,SOC HD CAP 6-32 X .25 LG	140
1	690212-1	POST, RAM	139
1	22480-5	WASHER, SPRING	138
1	354777-1	DISC,WIRE	137
1	690142-1	DISC, INSULATION	136
1	690124-9	WASHER, RAM	135
1	690125-1	WASHER,LAMINATED	134
1	21009-2	SCR,SOC SET 1/4-20 X .25 LG	133
1	690191-1	PLUG,NYLON	132
1	461690-1	SPACER	131
1	692655-1	VALVE ASSEMBLY	129
4	2-21002-9	SCR. BUT HD 10-32 X .75	128
2	3-21000-7	SCR. SOC HD 10-32 X .75	127
1	853521-1	PAWL, FEED	126
1	461062-6	FEED FINGER ASSY	125
1	3-21001-4	SCREW, SOC HD CP 3/8-16 X .88 LG	124
1	852289-1	AIR FEED ASSY	123
1	21024-8	WASHER, LOCK, .38	122
2	1-23030-2	SCR., SOC.HD. 8-32X.75 LOK-WEL	120
1	852253-1	BLADE,SLUG	118
1	1-455888-3	SPACER, CRIMPER	102
2	3-21000-5	SCR. SOC HD 10-32 X .50	101
1	454220-1	CAP, RAM	100
1	1-456410-2	CRIMPER, WIRE	99
1	463692-4	CRIMPER,INS "F"	98
1	238009-1	BLOCK, CRIMPER SPACER	97
1	455888-6	SPACER,CRIMPER	96
1	7-21002-7	SCR.,BUT. HD.5/16 UNF-24 X .75	95
1	1-22183-7	PIN, GROOVE TYP 67 .125 DIA X .63	94
1	2-22286-2	SPRING, EXT. LE-031B-2	92
1	1-21919-1	PIN,DOWEL .094 DIA X .375	91
1	852281-2	ROLLER	90
1	354385-2	PNEUMATIC ASSY	89
1	852287-1	PLATE, RETAINER	88
1	852286-1	LATCH, INSERT	87
2	852521-1	PIN, DOWEL MOD. .094 DIA X .49	86
1	852284-1	ARM, LATCH	85
1	1-21030-7	PIN, DOWEL .188 DIA X 1.50	84
1	980282-3	CONNECTOR,MALE 1/8 X .25	80
3	980285-2	ELBOW,MALE,SWIVEL 1/8 X .25T	78
1	852247-1	SLIDE,STRIPPER	75
1	4-22279-9	SPRING, COMP. LC-026B-9	73
5	22733-3	SCR,BUT HD CP 6-32 X .25 LOK-WEL	71

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
1	852248-1	STRIPPER	70
1	852245-1	CAM, INSERT	69
1	22374-7	EXHAUST, QUICK	68
1	852246-1	CAM,VALVE	67
1	22304-1	NIPPLE, HEX 1/8NPT	66
1	856287-1	RAM	65
1	852294-4	BACKUP, TERMINAL	64
1	852294-2	BACKUP, TERMINAL	63
1	852294-1	BACKUP, TERMINAL	62
1	1-23619-6	PIN,GROOVED .188 DIA	61
1	852298-1	LINK	60
4	21045-3	CRESCENT RING	59
1	4-23619-0	PIN,GROOVED, .188 DIA	58
1	852296-1	CLEVIS	57
1	852294-9	BACKUP, TERMINAL	56
5	6-21002-1	SCR.BHC(10-24x.25)AIR CL	55
1	852323-1	MOUNT,AIR CYL.	53
1	852297-1	ARM,PIVOT	52
1	856179-2	ANVIL	51
1	985314-1	AIR CYL., 3/4 BORE X 7/16 ST.	50
1	852295-1	ROD,BACKUP	49
1	21021-4	NUT,FLEXLOC 10-32	47
3	21899-2	WASHER, FLAT	44
1	852250-2	GUIDE,FRONT STRIP	40
2	22354-7	STUD,8-32	39
1	852251-2	DRAG	38
2	2-22280-9	SPRING, COMP. LC-032C-6	37
2	21021-3	NUT,FLEXLOC 8-32	36
1	90594-1	GUIDE, REAR STRIP	35
4	1-21899-3	WASHER, FLAT #8	34
1	90591-1	SHEAR, LEFT	32
1	853981-1	SHEAR, RIGHT	30
4	2-21002-2	SCR., BUT.HD. 8-32X.50	28
1	856231-1	PLATE, STRIP GUIDE	27
4	23030-2	SCR. SOC.HD. 6-32X.38 LOK-WEL	21
13	2-21002-1	SCR.,BUT.HD. 8-32X.38	17
1	354993-1	AIR CYL 1 1/8 BORE X 5/8 ST	13
1	5-21028-1	PIN, SPRING .125 DIA x .50	11
1	1-23470-7	SPRING, COMP. LC-035C-19	10
1	90777-1	GIB, HOUSING	9
1	318198-1	INSERTOR, POD	8
1	22733-8	SCR.,BUT.HD.8-32X.38	7
1	90775-1	HOUSING, INSERT SLIDE	6
1	1338955-1	HOLDDOWN, SPRING	4
3	2-22733-8	SCR. BUT HD 1/4-20 X .62	3
1	314866-2	PLATE, BASE	2
1	852221-1	HOUSING, APPLICATOR	1

REVISIONS				
#	DATE	BY	DESCRIPTION	APPROVED
1	22AUG2024	GK	TE	

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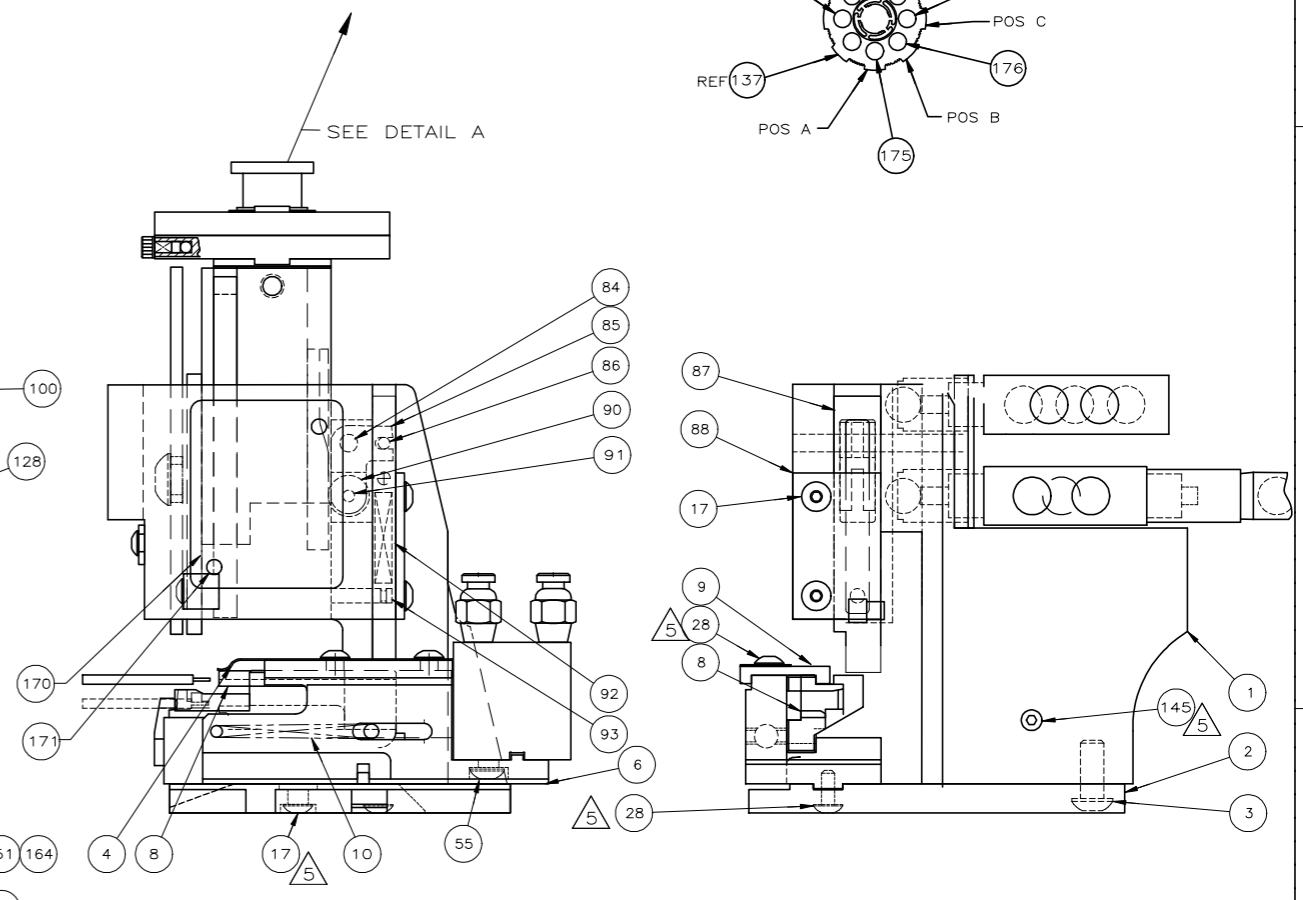
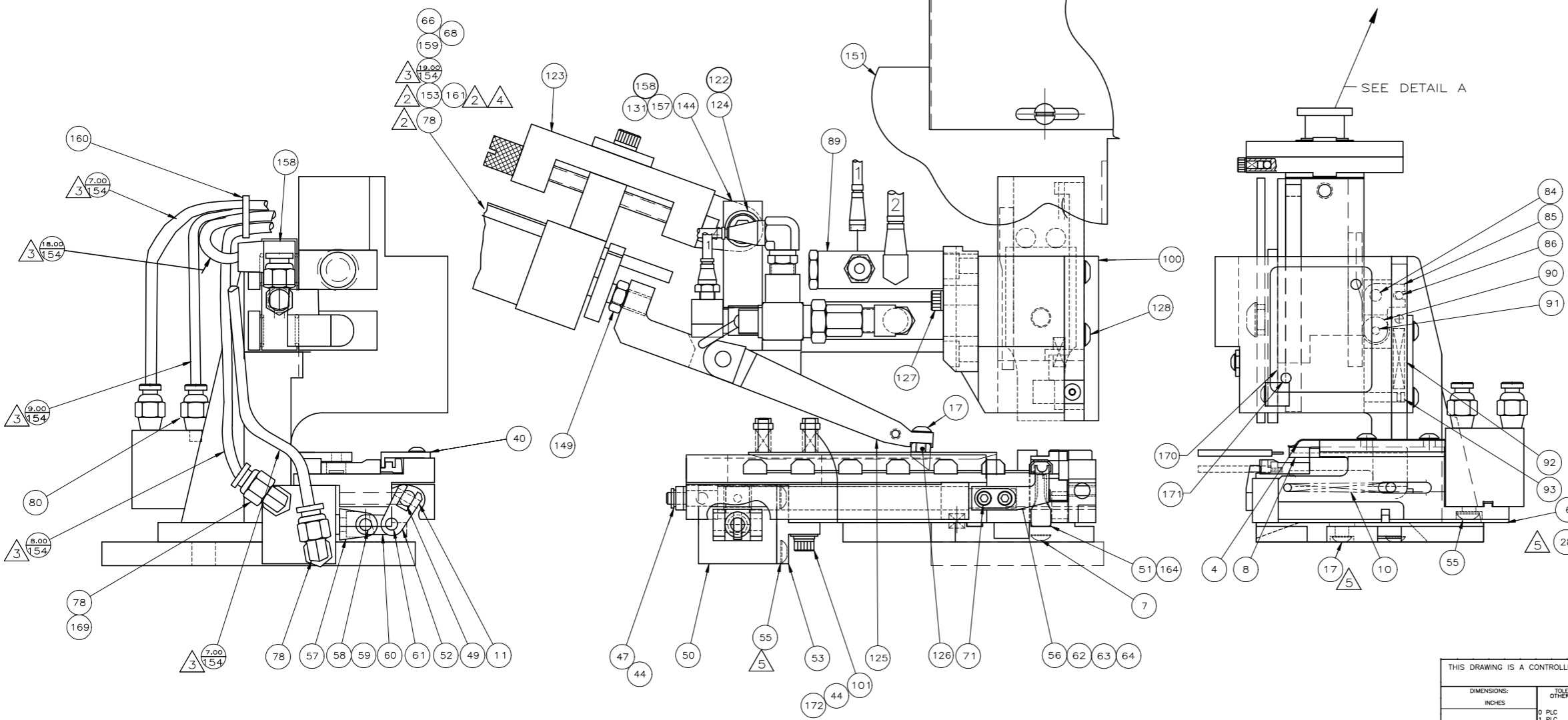
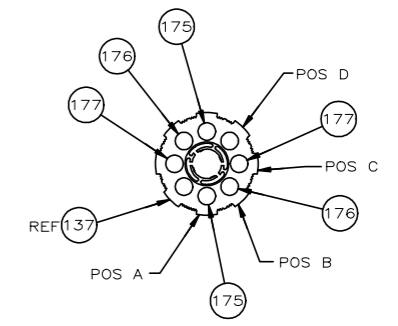
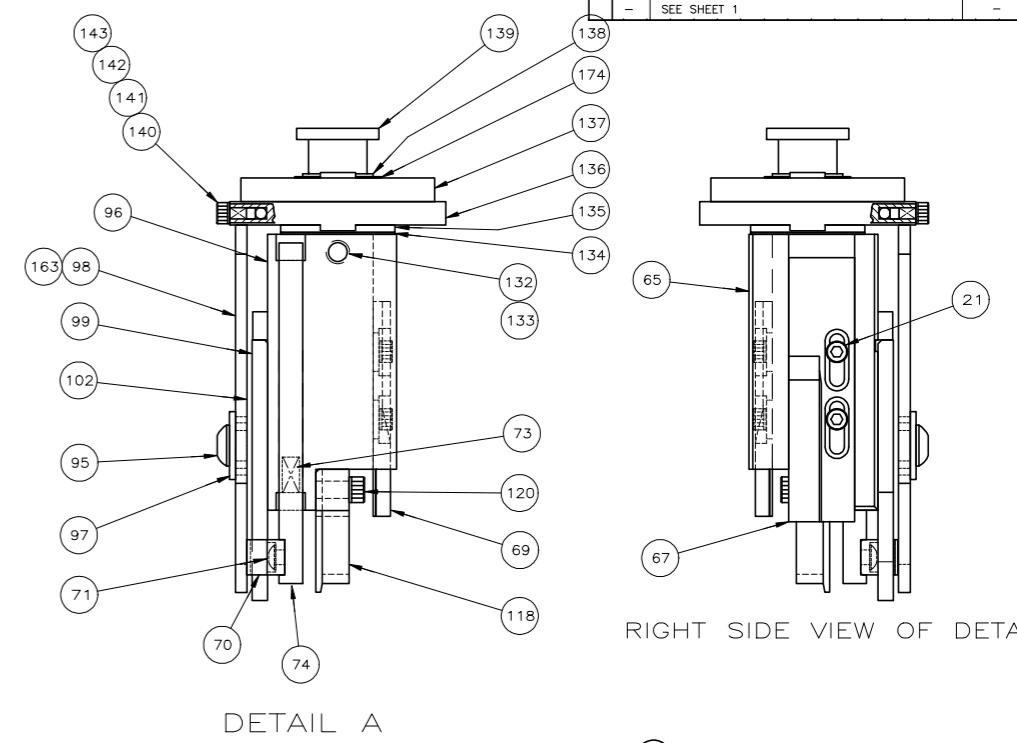
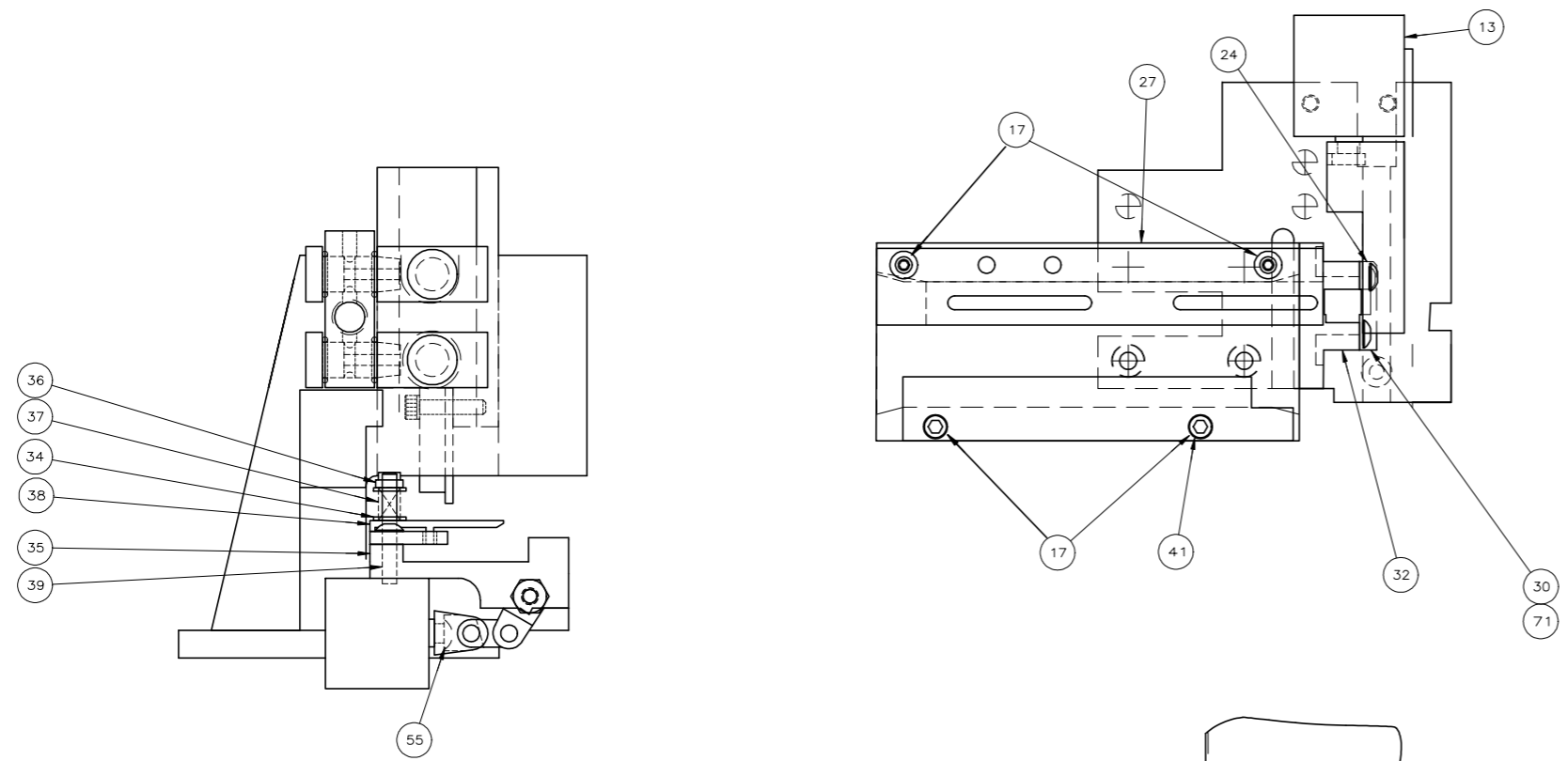
APPROVED: M. O'BRINE, C. ERISMAN, B. WOLFF

TE Connectivity Ltd. ULTRA-POD APPLICATOR .250 10 GA

SIZE: A1, CASE CODE: 00779, DRAWING NO: 680017, SHEET 1 OF 2

SCALE: 1:1, REV: P1

REVISIONS				
#	LTR	DESCRIPTION	DATE	BY
1		SEE SHEET 1		



DIMENSIONING AND TOLERANCING PER ASME Y14.5M (ASME STANDARDS)

B

A

D

C

B

A

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWG: M. O'BRINE 7-6-93 CHK: C. ERISMAN 7-8-93 APVD: B. WOLFE 7-8-93	NAME: ULTRA-POD APPLICATOR .250 10 GA SIZE: A1 CAGE CODE: 00779 DRAWING NO: 680017 SHEET: 2 OF 2 REV: P1
DIMENSIONS: INCHES 0 PLC ± .000 1 PLC ± .001 2 PLC ± .002 3 PLC ± .003 4 PLC ± .004 ANGLES ± .001	TOLERANCES UNLESS OTHERWISE SPECIFIED: FINISH: -	MATERIAL: - WEIGHT: -	RESTRICTED TO: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:1