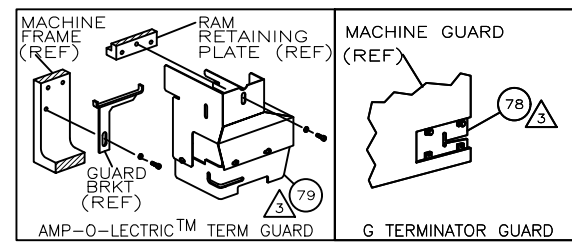


680414

THIS DRAWING IS A CONTROLLED DOCUMENT.

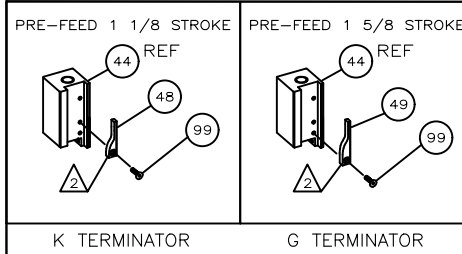
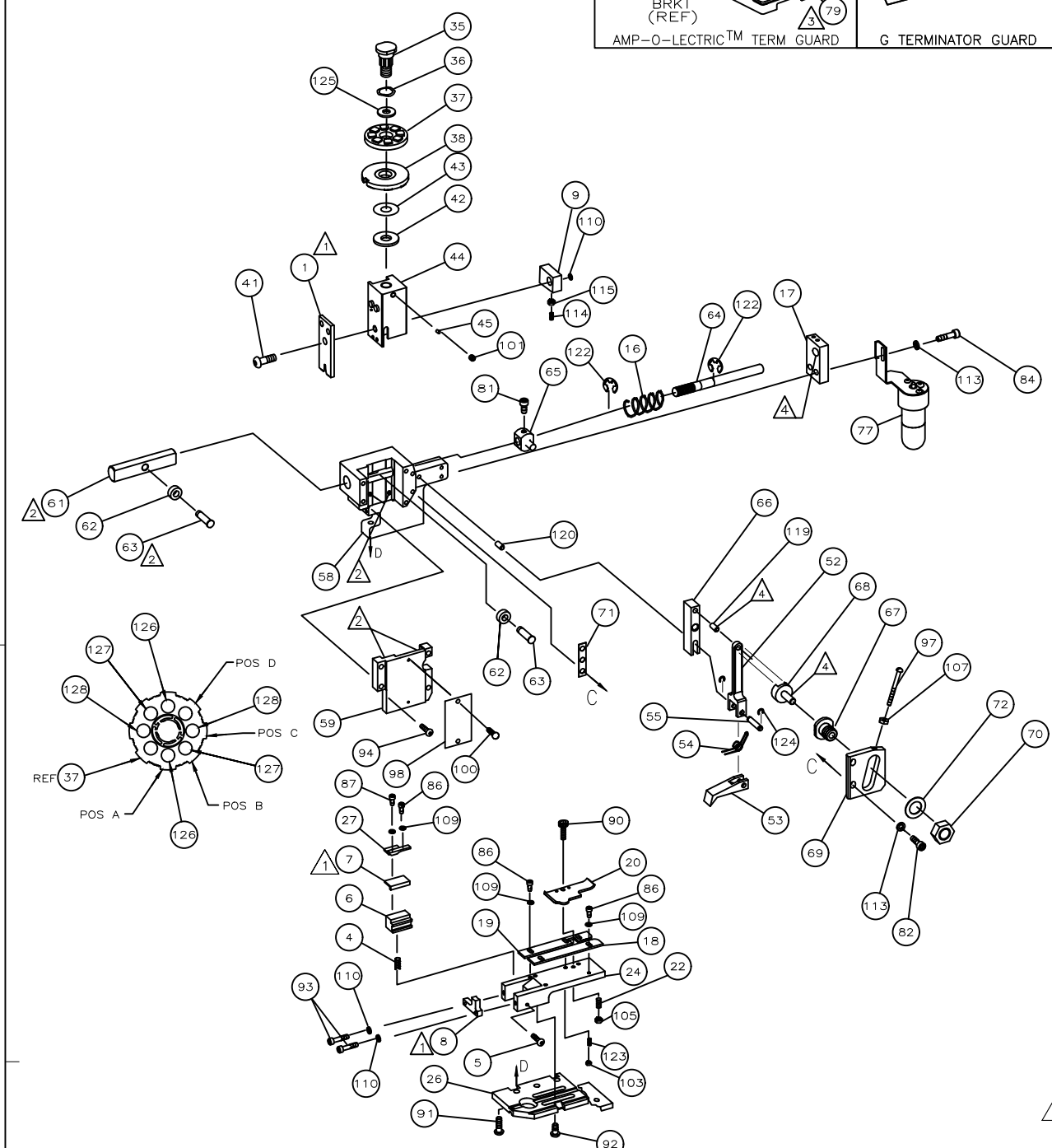
PART NUMBER	REV	FIRST USED
680414-1	H	854400-1
680414-2	H	565435-5
680414-3	H	354500-1



TYCO TERM PN		STOCKO TERM PN		CRIMPING DATA	
41215	N/A	PAD LTR	CRIMP HEIGHT	WIRE SIZE	
41459	N/A	A	.063 ±.002 [1.6 ±0.05mm]	16	
1572807	RSB7735.001V-1.5	B	.057 ±.002 [1.45 ±0.05mm]	18	
		C	.050 ±.002 [1.27 ±0.05mm]	20	
		D	NOT	USED	
		CRIMP	SIZE	TYPE	RANGE
		WIRE	.090 [2.29mm]	F	800-2500 CMA
		INSUL			
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
-	114-2088	.093	408-8039	458638-1	L1863

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

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
1	1	1	-	22594-8	NUT, HEX	70
1	1	1	-	240628-2	PLATE, ADJ	69
1	1	1	-	240626-1	SHAFT, PIVOT	68
1	1	1	-	240633-1	BUSHING	67
1	1	1	-	455680-1	LEVER, INTERMEDIATE	66
1	1	1	-	240629-1	BLOCK, PIVOT	65
1	1	1	-	240632-2	SCR, ADJ	64
1	1	1	-	240659-3	PIN, CAM ROLLER	63
1	1	1	-	240658-1	CAM, ROLLER	62
1	1	1	-	454398-1	ROD, FEED	61
						60
1	1	1	-	454220-1	CAP, RAM	59
1	1	1	-	453736-6	HOUSING	58
						57
						56
1	1	1	-	240624-1	PIN, FEED FINGER	55
1	1	1	-	691499-1	SPRING, FEED FINGER	54
1	1	1	-	240635-2	FINGER, FEED	53
1	1	1	-	240634-1	LEVER, TERMINAL	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
-	-	1	-	690501-4	CAM, POST-FEED 1 5/8 ST	47
						46
1	1	1	-	690191-1	PLUG, NYLON	45
1	1	1	-	455674-1	RAM	44
1	1	1	-	690125-1	WASHER, LAMINATED	43
1	1	1	-	690124-4	WASHER, RAM	42
1	1	1	-	7-21002-9	BOLT, CRIMPER(5/16-24x1.00)	41
						40
						39
1	1	1	-	690223-1	INSULATION SPACER	38
1	1	1	-	354777-1	WIRE DISC, PLASTIC	37
1	1	1	-	22480-5	WASHER, SPRING	36
1	1	1	-	690212-1	POST, RAM	35
						34
						33
						32
						31
						30
						29
						28
1	1	1	-	458405-1	STRIPPER, REAR	27
1	1	1	-	458411-1	PLATE, BASE	26
						25
1	1	1	-	458412-1	PLATE, STRIP GUIDE	24
						23
1	1	1	-	1-22282-9	SPRING, DRAG	22
						21
1	1	1	-	458403-1	DRAG, STOCK	20
1	1	1	-	458406-2	GUIDE, STRIP (REAR)	19
1	1	1	-	458404-2	GUIDE, STRIP (FRONT)	18
1	1	1	-	1804305-2	GUIDE, FEED ROD	17
1	1	1	-	4-22284-9	SPRING, FEED RETURN	16
						15
						14
						13
						12
						11
						10
1	1	1	-	904181-1	HOLDER, DEPRESSOR	9
1	1	1	-	462320-4	ANVIL	8
1	1	1	-	458410-6	SHEAR	7
1	1	1	-	458409-5	HOLDER, SHEAR	6
1	1	1	-	690461-4	SCR, SHEAR STOP	5
1	1	1	-	6-22282-8	SPRING, SHEAR RETURN	4
						3
						2
1	1	1	-	4-456406-9	CRIMPER, WIRE	1



- ▲ RECOMMENDED SPARE PARTS.
- ▲ GREASE LIGHTLY.
- ▲ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- ▲ LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- ▲ CUSTOMER USING A SINGLE LEAD APPLICATION

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
2	2	2	-	6-354778-9	PIN, WIRE DISC (.2840)C	129
2	2	2	-	5-354778-5	PIN, WIRE DISC (.2770)B	128
2	2	2	-	4-354778-2	PIN, WIRE DISC (.2705)A	126
1	1	1	-	986950-1	WASHER, FLAT PRECISION	125
2	2	2	-	21045-3	RING, RET "C" (Ø.187)FD PIN	124
2	2	2	-	5-21061-5	SCR, SKT, SET CONE PT(8-32x.88)DRAG	123
2	2	2	-	1-21046-6	RING, RETAINING, EXT(5/16)FD ADJ ROD	122
1	1	1	-	217238-1	GENERAL INSTRUCTION PACKAGE	121
1	1	1	-	1-21030-7	PIN, DOWEL(Ø.187x1.50)HSG	120
1	1	1	-	1-21030-1	PIN, DOWEL(Ø.187x.50)LEVER	119
						118
1	1	1	-	4088039	EF APPL INST 408-8039	117
						116
2	2	2	-	21018-7	HEX NUT	115
1	1	1	-	3-21000-5	SKT, CAP, SCR	114
4	4	4	-	21024-5	WASHER, LOCK(NO.10)FEED	113
						112
						111
3	3	3	-	21024-4	WASHER, LOCK(NO.8)SHEAR BL	110
6	6	6	-	21024-3	WASHER, LOCK(NO.6)STRIP&SHEAR	109
						108
1	1	1	-	21018-5	NUT, HEX(6-32)FD ADJ PL	107
						106
1	1	1	-	21022-4	NUT, HEX SL(8-32)DRAG STUD	105
						104
2	2	2	-	21018-6	NUT, HEX (8-32)DRAG	103
						102
1	1	1	-	21009-2	SCR, SKT SET(1/4-20x.25)RAM	101
2	2	2	-	21017-2	SCR, DRIVE(#2x.19)ID PLATE	100
1	1	1	-	1-21002-7	SCR, BHC(6-32x.38)CAM	99
1	1	1	-	461264-1	PLATE, IDENTIFICATION	98
1	1	1	-	6-23715-5	SCR, PAN HD(6-32x1.50)FEED ADJ	97
						96
						95
4	4	4	-	2-21002-9	SCR, BHC(10-32x.75)HSG CAP	94
2	2	2	-	2-21000-7	SCR, SHC(8-32x.50)ANVIL	93
4	4	4	-	3-21002-3	SCR, BHC(1/4-20x.50)ST GD PL	92
3	3	3	-	2-22733-8	SCR, BHC(1/4-20x.62)BASE PL	91
2	2	2	-	21001-7	SCR, SHC(1/4-20x1.25)DRAG&RAM	90
						89
						88
1	1	1	-	2-21000-0	SCR, SHC(6-32x.50)STRIPPER&SHEAR	87
5	5	5	-	1-21000-9	SCR, SHC(6-32x.38)STRIP GUIDE	86
						85
2	2	2	-	3-21000-7	SCR, SKT CAP(10-32x.75)FD GDE	84
1	1	1	-	3-21000-0	SCR, SKT 8-32x.88	83
2	2	2	-	3-21000-6	SCR, SKT CAP(10-32x.62)FD ADJ P	82
1	1	1	-	3-21000-4	SCR, SKT CAP(10-32x.38)PIVOT BL	81
2	2	2	-	3-21000-9	SCR, SKT CAP(10-32x1.00)SH PL	80
-	1	-	-	463924-1	GUARD, WINDOW	79
REF	-	-	-	679532-1	INSERT, GUARD	78
-	1	-	-	465184-9	LUBRICATOR ASSY	77
						76
						75
						74
						73
1	1	1	-	458109-1	WASHER, FLAT (SPECIAL)	72
1	1	1	-	690517-1	SPACER	71
-3	-2	-1	U/M			

LOC	DESCRIPTION
A	BENCH MACHINE

TE Connectivity

END FEED HDM APPLICATOR

SCALE: A1

DRAWING NO: 680414

SHEET 1 OF 1

REV: H

DATE: 7-2017

DESIGNER: ECR-17-009757

REVISION RECORD

CUSTOMER ACCESSIBLE PRODUCTION DRAWING