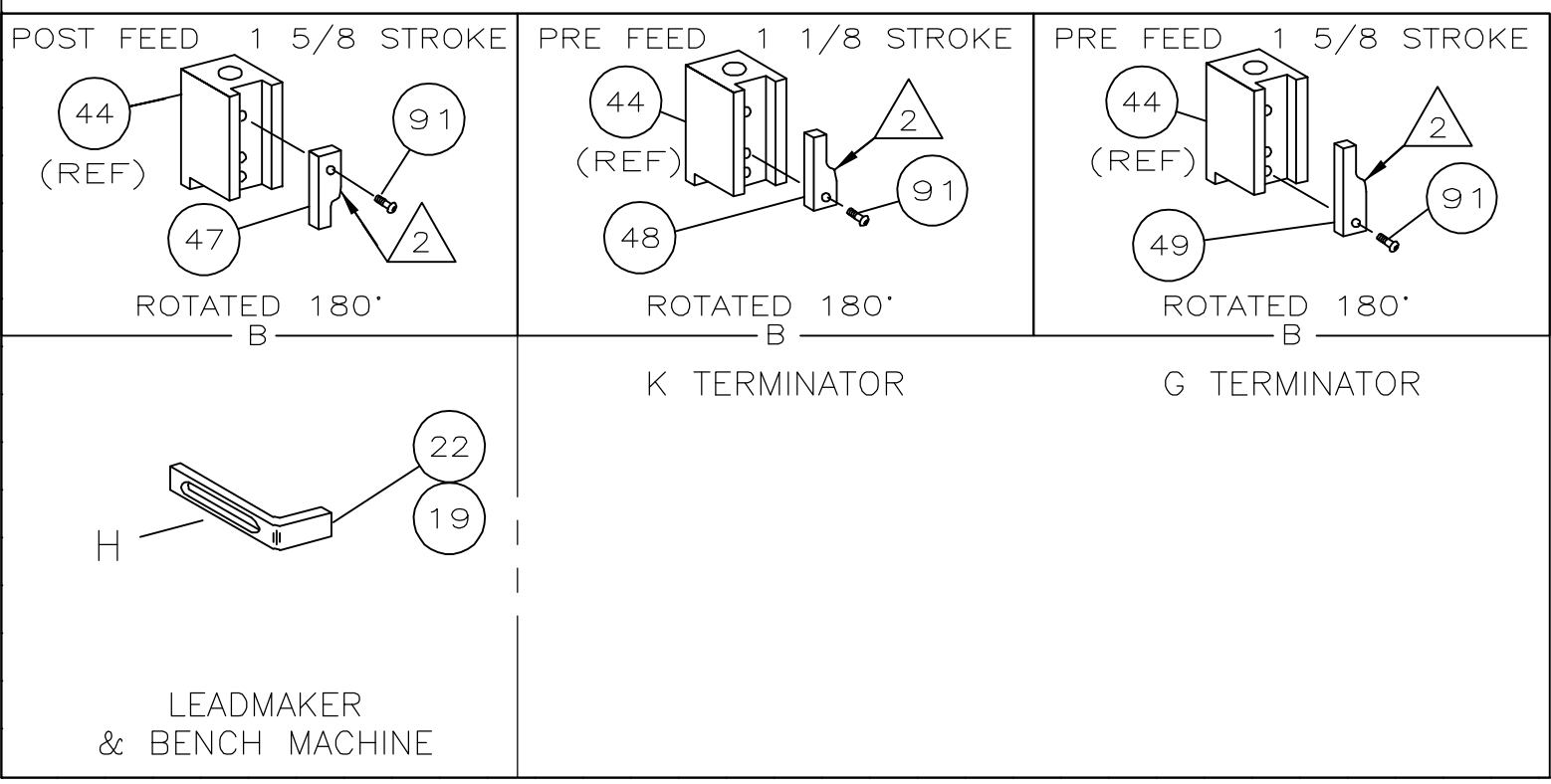
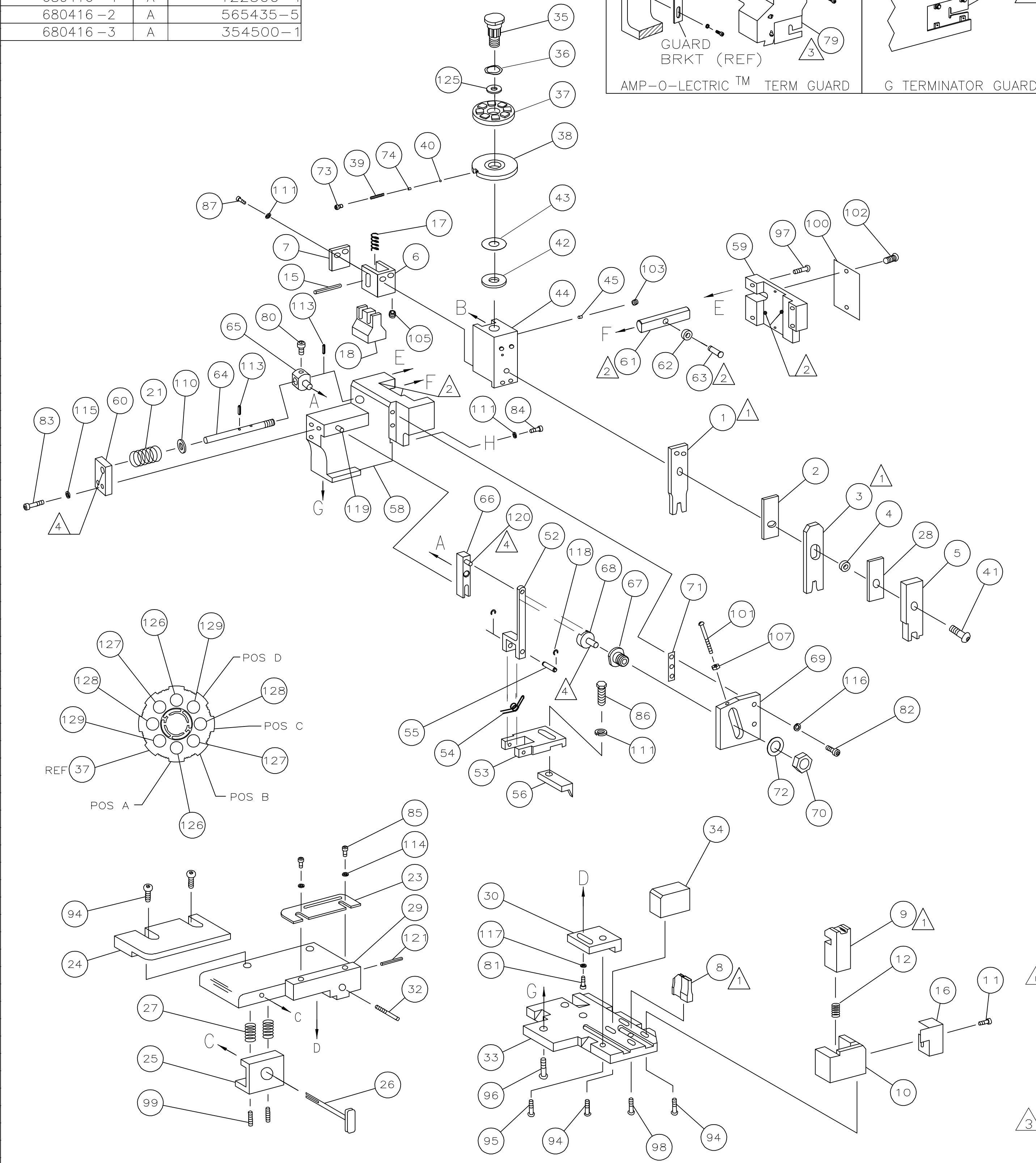
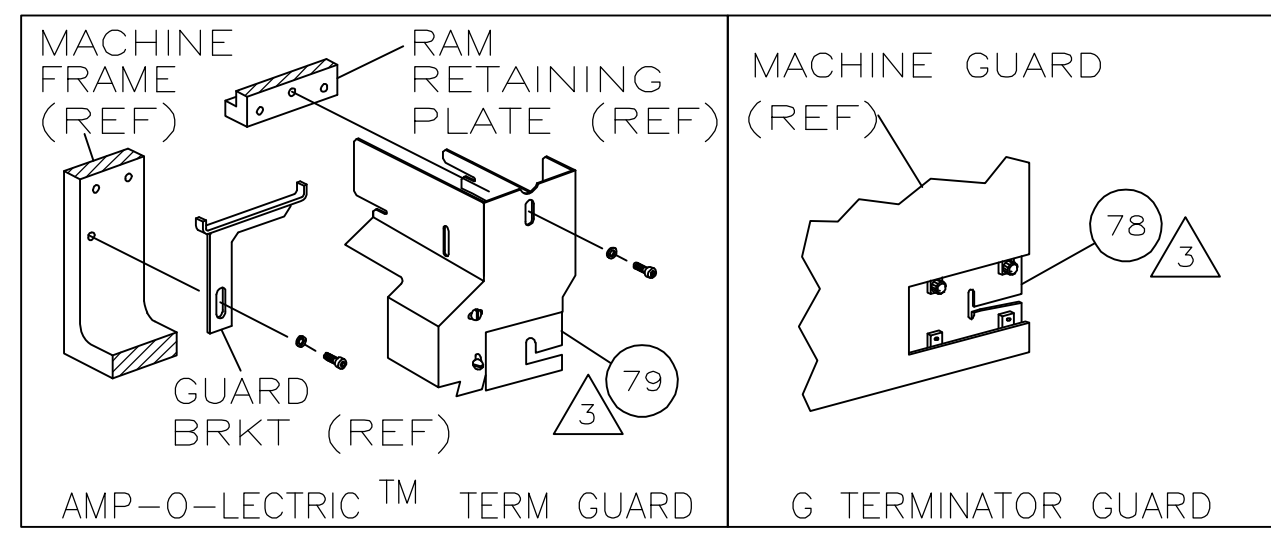


PART NUMBER	REV	FIRST USED
680416-1	A	122500-1
680416-2	A	565435-5
680416-3	A	354500-1



- 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
- 7 WIRE STRIP LENGTH FOR (2) 22 WIRES IS .185.
- 8 GUIDE OFF OF INSULATION BARREL.

TERMINAL NAME: TIMER CONTACT		CRIMPING DATA	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.052 ±.002 [1.32 ±0.05mm]	18	
B	.049 ±.002 [1.24 ±0.05mm]	(2) 22	
C	.047 ±.002 [1.19 ±0.05mm]	20	
D	.043 ±.002 [1.09 ±0.05mm]	22	
CRIMP	SIZE	TYPE	RANGE
WIRE	.070 [1.78mm]	F	22-18
INSUL	.140 [3.56mm]	F	.075-.130
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
.172	114-49003	.500	408-8040
			SET UP GAGE LAYOUT
			458637-1 L1866

QTY	REF	REF	REF	REF	DESCRIPTION	ITEM NO
2	2	2	-	3-354779-6	PIN, WIRE DISC (.3170)D	129
2	2	2	-	2-354779-8	PIN, WIRE DISC (.3130)C	128
2	2	2	-	2-354779-4	PIN, WIRE DISC (.3110)B	127
2	2	2	-	1-354779-8	PIN, WIRE DISC (.3080)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	122
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	112
REF	REF	REF	-	21899-4	WASHER,FLAT(Ø5/16)SCREW ADJ	111
1	1	1	-	21018-5	NUT,HEX(NO.6)HOLDDOWN	109
REF	REF	REF	-	21018-5	NUT,HEX(6-32)FEED ADJ	108
1	1	1	-	2-21008-1	SCR,SKT SET(4-40x.25)CARRIER	107
1	1	1	-	21009-2	SCR,SKT SET(1/4-20x.25)RAM	106
2	2	2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE	105
REF	REF	REF	-	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	104
1	1	1	-	461264-1	PLATE, IDENTIFICATION	103
2	2	2	-	5-21006-6	SCR,SET(10-32x.75)DRAG	102
1	1	1	-	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	101
REF	REF	REF	-	2-21002-9	SCR,BHC(10-32x.75)CAP	100
REF	REF	REF	-	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	99
REF	REF	REF	-	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	98
6	6	6	-	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	97
1	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	96
2	2	2	-	3-21000-0	SCR,SHC(8-32x.88)DEP-HOLD	95
1	1	1	-	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	94
2	2	2	-	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	93
1	1	1	-	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	92
REF	REF	REF	-	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	91
REF	REF	REF	-	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	90
1	1	1	-	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	89
REF	REF	REF	-	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	88
-	REF	-	-	455749-1	GUARD, WINDOW	87
REF	-	-	-	679532-1	INSERT, GUARD	86
1	1	1	-	690603-1	SPRING, ASSIST	85
1	1	1	-	23030-1	SCR,SHC(6-32x.25 SL)INS DISC	84
REF	REF	REF	-	458109-1	WASHER, SPECIAL	83
REF	REF	REF	-	690517-1	SPACER	82
-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

LOC	DIST	REVISIONS			
F	LTR	DESCRIPTION	DATE	BY	APPV
A	66	ECR-07-008457	4-2007	MY	GB

-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	-	22594-8	NUT,HEX(1/2-20)	70
REF	REF	REF	-	240628-1	PLATE, ADJUSTMENT	69
REF	REF	REF	-	240626-1	SHAFT, PIVOT	68
REF	REF	REF	-	240633-1	BUSHING	67
REF	REF	REF	-	455680-1	LEVER, INTERMEDIATE	66
REF	REF	REF	-	240629-1	BLOCK, PIVOT	65
REF	REF	REF	-	240632-2	SCREW, ADJ FEED ROD	64
REF	REF	REF	-	240659-3	PIN, CAM ROLLER	63
REF	REF	REF	-	240658-1	ROLLER, CAM	62
REF	REF	REF	-	454398-2	ROD, FEED	61
REF	REF	REF	-	454178-1	GUIDE, FEED ROD	60
REF	REF	REF	-	454220-1	CAP, RAM	59
REF	REF	REF	-	454485-1	HOUSING	58
1	1	1	-	458537-2	PAWL, FEED	57
REF	REF	REF	-	240624-1	PIN, FEED FINGER	56
REF	REF	REF	-	691499-1	SPRING, FEED FINGER	55
REF	REF	REF	-	690541-1	HOLDER, FEED FINGER	54
REF	REF	REF	-	455679-1	LEVER, TERMINAL FEED ARM	53
1	1	1	-	458537-2	CAM, PRE-FEED 1 5/8 ST	52
-	1	-	-	690602-5	CAM, PRE-FEED 1 1/8 ST	51
-	-	1	-	690501-4	CAM, POST-FEED 1 5/8 ST	50
1	1	1	-	459456-1	APPLICATOR, BASIC (SUBASSY)	49
1	1	1	-	690191-1	PLUG, NYLON	48
1	1	1	-	455673-1	RAM	47
1	1	1	-	690125-1	WASHER, LAMINATED	46
1	1	1	-	690124-1	WASHER, RAM	45
1	1	1	-	7-21002-9	BOLT, CRIMPER(5/16x1.00)	44
1	1	1	-	23241-6	BALL, STEEL	43
1	1	1	-	690170-1	SPRING, COMPRESSION	42
1	1	1	-	690142-1	DISC, INSULATION	41
1	1	1	-	354777-1	WIRE DISC, PLASTIC	40
1	1	1	-	22480-5	WASHER, SPRING	39
1	1	1	-	690212-1	POST, RAM	38
1	1	1	-	690786-1	SUPPORT, TERMINAL	37
REF	REF	REF	-	455675-1	PLATE, BASE	36
1	1	1	-	690432-3	SCREW, ADJUSTMENT	35
REF	REF	REF	-	455689-1	BLOCK, STRIP GUIDE ADJ	34
1	1	1	-	455671-1	PLATE, STRIP GUIDE	33
1	1	1	-	1-455888-0	SPACER, FRONT SHEAR DEP	32
2	2	2	-	1-22284-0	SPRING, DRAG	31
1	1	1	-	690546-1	LEVER, DRAG RELEASE	30
1	1	1	-	240792-1	DRAG, TERMINAL	29
1	1	1	-	6-690504-2	GUIDE, STRIP (REAR)	28
1	1	1	-	690438-1	GUIDE, STRIP (FRONT)	27
-	-	1	-	690472-2	STRIPPER	26
REF	REF	REF	-	4-22284-9	SPRING, FEED RETURN	25
1	1	-	-	691353-1	STRIPPER	24
1	1	1	-	314860-1	HOLD DOWN,TERMINAL	23
2	2	2	-	3-22278-0	SPRING,HOLDDOWN	22
1	1	1	-	318563-1	GUARD, CHIP, FRONT	21
1	1	1	-	4-21028-0	PIN,SPRING .094x.75	20
1	1	1	-	3-22280-3	SPRING, SHEAR	19
1	1	1	-	690461-1	STOP, SHEAR	18
1	1	1	-	690459-1	HOLDER, SHEAR (FRONT)	17
1	1	1	-	462006-1	SHEAR, FLOAT (FRONT)	16
1	1	1	-	662185-4	ANVIL	15
1	1	1	-	455053-1	PLATE,RETAINER	14
1	1	1	-	455052-1	CARRIER,TERM. HOLDER	13
1	1	1	-	2-455889-0	DEPRESSOR, SHEAR (FRONT)	12
1	1	1	-	238011-4	SPACER, BLOCK CRIMPER	11
1	1	1	-	3-683453-1	CRIMPER, INSULATION	10
1	1	1	-	455888-8	SPACER, CRIMPER	9
1	1	1	-	1-456404-8	CRIMPER, WIRE	8
-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DRAWING NO	RESTRICTED TO
0 PLC ± .005	1 PLC ± .002	A1 00779C=680416	-
1 PLC ± .002	2 PLC ± .001	SCALE	-
2 PLC ± .001	3 PLC ± .0005	SHEET	1 of 1
3 PLC ± .0005	4 PLC ± .0002	REV	A
4 PLC ± .0002	ANGLES ± .005	CUSTOMER DRAWING	

tyco Electronics Tyco Electronics Corporation Harrisburg, PA 17105-3608

NAME: SIDE FEED HDM APPLICATOR

DATE: 1-14-97

BY: J. ELBIN

APPV: J. ELBIN

PRODUCT SPEC: -