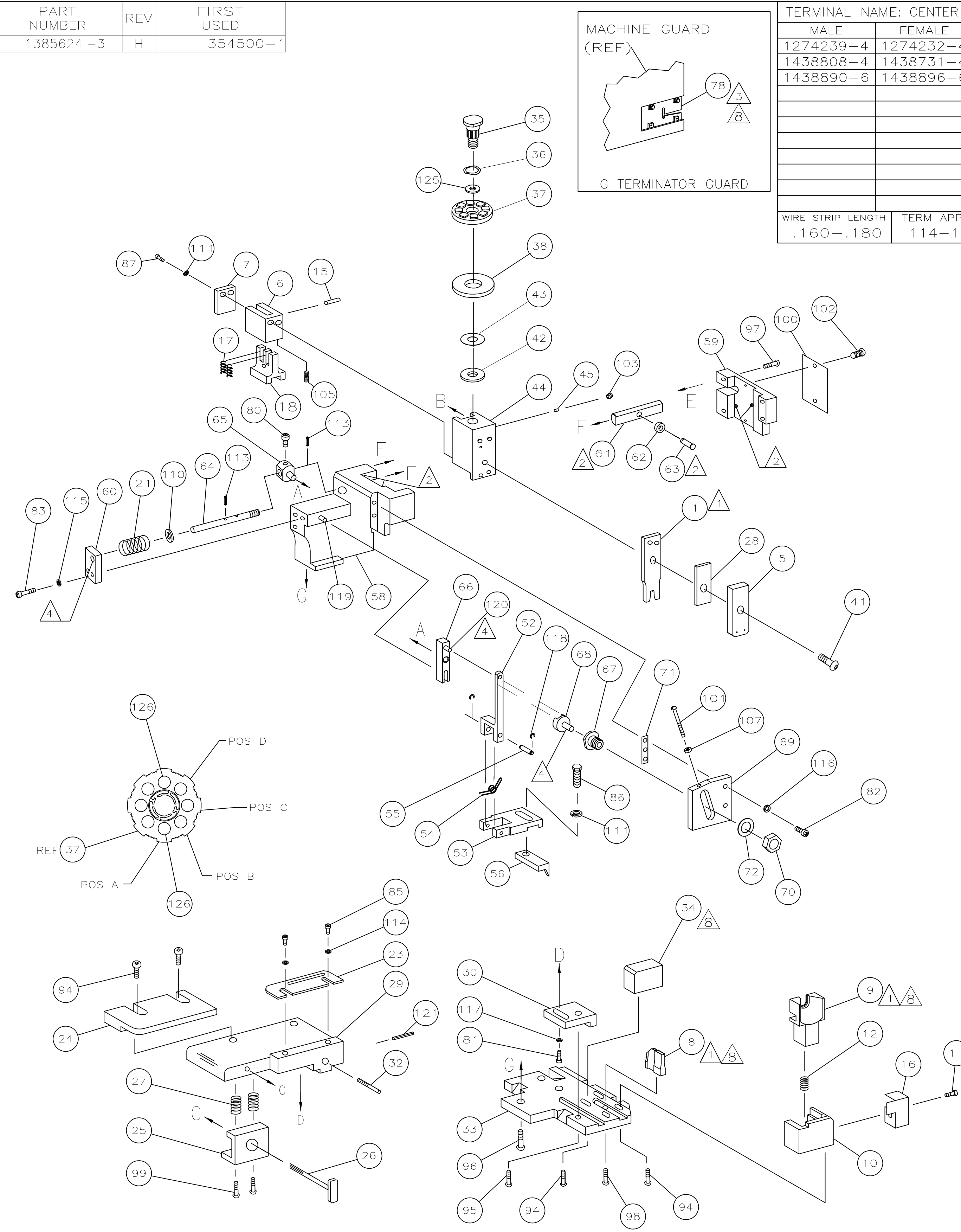


PART NUMBER	REV	FIRST USED
1385624-3	H	354500-1

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- 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 RG-62/U MODIFIED CABLE.

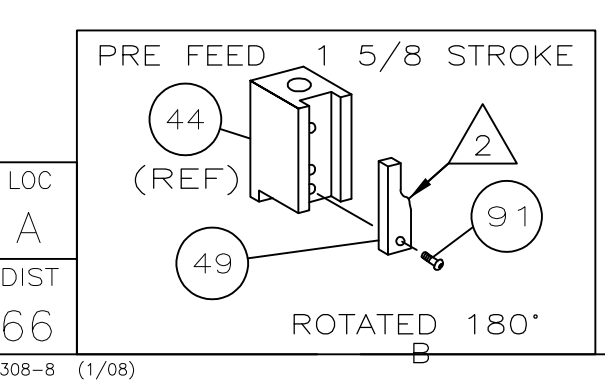
8 ALIGN GUARD INSERT OPENING WITH FLOATING SHEAR, ANVIL AND TERMINAL SUPPORT BEFORE TIGHTENING THUMBSCREWS. PROPER ALIGNMENT OF THIS TOOLING IS CRITICAL FOR CRIMP QUALITY.

TERMINAL NAME: CENTER CONTACT					
MALE	FEMALE				
1274239-4	1274232-4				
1438808-4	1438731-4				
1438890-6	1438896-6				
CRIMP DATA (AMP TERMINAL)					
PAD LTR	CRIMP HEIGHT	WIRE SIZE			
A	.0185 ±.0015 [0.457 ±0.038mm]	Ø.0125 A			
B	NOT	USED			
C	NOT	USED			
D	NOT	USED			
CRIMP	SIZE	TYPE			
WIRE	.033 [0.84mm]	F			
INSUL	-	-			
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.160-.180	114-13125	.300	408-8040	458637-1	L2314

2	-	4-354779-6	PIN, WIRE DISC (.3220)A	126
1	-	986950-1	WASHER, FLAT PRECISION	125
1	-	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	-	4088040	SF APPL INST 408-8040	123
1	-	4-21028-0	PIN,SLT SPR(Ø.093x.75)ST GDE PL	122
REF	-	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	121
REF	-	1-21030-6	PIN,DOWEL(Ø.187x1.25)HOUSING	119
REF	-	21045-3	RING,RET "C"(Ø.187)FD FING PIN	118
1	-	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
REF	-	21024-5	WASHER,LOCK(#10)ADJ PLATE	116
REF	-	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115
2	-	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
REF	-	5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	113
2	-	21024-4	WASHER,LOCK(#8)STRIPPER	112
REF	-	21899-4	WASHER,FLAT(Ø5/16)SCREW ADJ	111
REF	-	21068-5	NUT,HEX(6-32)FEED ADJ	110
1	-	2-21008-1	SCR, SKT SET(4-40x.25) HD	109
1	-	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	108
2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE	107
REF	-	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	106
1	-	461264-1	PLATE, IDENTIFICATION	105
2	-	5-21006-6	SCR,SET(10-32x.75)DRAG	104
1	-	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	103
REF	-	2-21002-9	SCR,BHC(10-32x.75)CAP	102
REF	-	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	101
REF	-	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	99
6	-	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	98
1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	97
2	-	3-21000-0	SCR,SHC(8-32x.88)DEP-HOLD	96
1	-	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	95
2	-	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	94
REF	-	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	84
REF	-	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	83
1	-	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	82
REF	-	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	81
1	-	1338295-1	INSERT, GUARD	80
REF	-	458109-1	WASHER, SPECIAL	79
REF	-	690517-1	SPACER	78
-3	U/M	PART NO	DESCRIPTION	ITEM NO
PARTS LIST				
QTY REQD				

USED ON	-
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REF	-	22594-8	NUT,HEX(1/2-20)	70
REF	-	240628-1	PLATE, ADJUSTMENT	69
REF	-	240626-1	SHAFT, PIVOT	68
REF	-	240633-1	BUSHING	67
REF	-	455680-1	LEVER, INTERMEDIATE	66
REF	-	240629-1	BLOCK, PIVOT	65
REF	-	240632-2	SCREW, ADJ FEED ROD	64
REF	-	240659-3	PIN, CAM ROLLER	63
REF	-	240658-1	ROLLER, CAM	62
REF	-	454398-2	ROD, FEED	61
REF	-	454178-1	GUIDE, FEED ROD	60
REF	-	454220-1	CAP, RAM	59
REF	-	454485-1	HOUSING	58
1	-	4-694433-9	PAWL, FEED	57
REF	-	240624-1	PIN, FEED FINGER	56
REF	-	691499-1	SPRING, FEED FINGER	55
REF	-	690541-1	HOLDER, FEED FINGER	54
REF	-	455679-1	LEVER, TERMINAL FEED ARM	53
1	-	690602-6	CAM, PRE-FEED 1 5/8 ST	52
1	-	459456-1	APPLICATOR, BASIC (SUBASSY)	51
1	-	690191-1	PLUG, NYLON	50
1	-	455673-1	RAM	49
1	-	690125-1	WASHER, LAMINATED	48
1	-	690124-9	WASHER, RAM	47
1	-	7-21002-9	BOLT, CRIMPER(5/16x1.00)	46
1	-	690223-2	SPACER, INSULATION DISC	45
1	-	354777-1	WIRE DISC, PLASTIC	44
1	-	22480-5	WASHER, SPRING	43
1	-	690212-1	POST, RAM	42
1	-	692776-2	SUPPORT, TERMINAL	41
REF	-	455675-1	PLATE, BASE	40
1	-	690432-3	SCREW, ADJUSTMENT	39
REF	-	455689-1	BLOCK, STRIP GUIDE ADJ	38
1	-	455671-1	PLATE, STRIP GUIDE	37
1	-	1-455888-0	SPACER, FRONT SHEAR DEP	36
2	-	1-22284-0	SPRING, DRAG	35
1	-	690546-1	LEVER, DRAG RELEASE	34
1	-	240792-1	DRAG, TERMINAL	33
1	-	4-90765-6	GUIDE, STRIP (REAR)	32
1	-	690438-1	GUIDE, STRIP (FRONT)	31
REF	-	4-22284-9	SPRING, FEED RETURN	30
1	-	1338470-1	DEPRESSOR, WIRE	29
2	-	3-22278-0	SPRING, HOLD DOWN	28
1	-	318563-1	GUARD, CHIP, FRONT	27
1	-	4-21028-0	PIN, SLT SPR(Ø.094x.75) HD	26
1	-	3-22280-3	SPRING, SHEAR	25
1	-	1-690461-6	STOP, SHEAR	24
1	-	1338294-1	HOLDER, SHEAR (FRONT)	23
1	-	1338293-1	SHEAR, FLOAT (FRONT)	22
1	-	3-904132-2	ANVIL	21
1	-	455053-1	PLATE, RETAINER	20
1	-	455052-1	CARRIER, TERM HOLDER	19
1	-	808890-2	DEPRESSOR, SHEAR (FRONT)	18
1	-	1-456400-4	CRIMPER, WIRE	17
-3	U/M	PART NO	DESCRIPTION	ITEM NO
PARTS LIST				
QTY REQD				



DWN	R.O.WILSON	20JUN03	MATERIAL	-	HEAT TREAT	-	
CHK	R.O.WILSON	20JUN03					
APVD	T.ELBIN	23JUN03					
NAME	SIDE FEED HDM APPLICATOR						
SCALE	A1	DRAWING NO	1385624	SHEET	1 of 1	REV	H

CUSTOMER ACCESSIBLE PRODUCTION DRAWING