PART NUMBER	REV	FIRST USED
680835–1	H	122500–1
680835–2	H	565435–5

1. RECOMMENDED SPARE PARTS.
2. ITEM NOT SHOWN. (SEE A.I.SHEET 8095)
3. CUTTING TOLERANCE ±.25
4. SPRING LOADED TONKER (P/N 354853–2) MUST BE USED WHEN RUNNING THE APPLICATOR ON A LEADMAKER.
5. ITEMS 57 TO BE USED WITH INSULATION DIAMETER .080–.110. THIS MAY VARY DUE TO INSULATION TYPE.
6. ITEMS 58 TO BE USED WITH INSULATION DIAMETER .110–.140. THIS MAY VARY DUE TO INSULATION TYPE.
7. APPLY SEALANT 1–23419–5 TO SCREW.

–1	LEADMAKER & BENCH MODEL G 1–5/8" STROKE	AIR FEED
–2	BENCH MODEL K 1–1/8" STROKE	AIR FEED

TERMINAL NAME: .110 ULTRA–POD RECEPTACLE

		521219
		521408
		521437
		521228
		521436

CRIMP DATA (AMP TERMINAL)

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.049±.002 [1.24±0.05mm]	18 AWG
B	.043±.002 [1.09±0.05mm]	20 AWG
C	.040±.002 [1.02±0.05mm]	22 AWG
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.062 [1.57mm]	F	22–18
INSUL	.140 [3.56mm]	0	ϕ.080–.140

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	AI 408–8095 & 8098	SET UP GAGE	LAYOUT
.156–.172	114–2124	.770		458637–2	–

USED ON –

–2	–1	U/M	PART NO	DESCRIPTION	ITEM NO
2	2	–	21021–3	NUT, SELF LOCKING	135
					134
1	1	–	21024–8	WASHER, LOCK	133
2	2	–	21024–5	WASHER, LOCK	132
4	4	–	1–21899–3	WASHER	131
1	1	–	21007–8	SCR, SOC SET 1/4–20 X .75	130
1	1	–	21009–2	SCR, SOC SET 1/4–20 X .25	129
2	2	–	1–23030–2	SCR, SOC HD LOK 8–32 X .75	128
3	3	–	1–21002–6	SCR, SOC HD LOK 6–32 X .25	127
4	4	–	23030–2	SCR, SOC HD LOK 6–32 X .38	126
1	1	–	3–21001–4	SCR, SOC HD 3/8–16 X .88	125
2	2	–	4–21000–3	SCR, SOC HD 10–32 X 2.00	124
1	1	–	23030–1	SCR, SOC HD 6–32 X .25	123
2	2	–	3–21000–7	SCR, SOC HD 10–32 X .75	122
1	1	–	1–21000–9	SCR, SOC HD 6–32 X .38	121
2	2	–	2–21000–8	SCR, SOC HD 8–32 X .62	120
2	2	–	2–21002–2	SCR, BUT HD 8–32 X .50	119
6	6	–	2–21002–9	SCR, BUT HD 10–32 X .75	118
1	1	–	690686–3	SCR, MODIFIED 5/16–24 X 1.00	117
					116
2	2	–	6–21002–1	SCR, BUT HD 10–24 X .25	115
15	15	–	2–21002–1	SCR, BUT HD 8–32 X .38	114
3	3	–	2–22733–8	SCR, BUT HD 1/4–20 X .63	113
2	2	–	1–21003–3	SCR, FLT HD 4–40 X .25	112
2	2	–	852521–1	PIN, MODIFIED DOWEL ϕ.094 X .49	111
1	1	–	1–21030–7	PIN, DOWEL ϕ.188 X 1.50	110
1	1	–	1–21919–1	PIN, DOWEL ϕ.094 X .38	109
1	1	–	1–22183–7	PIN, GROOVE TYPE 67 ϕ.125 X .63	108
1	1	–	2–22603–1	SCR, HEX 8–32 X .375	107
1	1	–	2–22286–2	SPRING, EXTENSION LE–031B–2	106
1	1	–	690170–1	SPRING, COMPRESSION	105
4	4	–	7–22280–3	SPRING, COMPRESSION LC–042C–17	104
1	1	–	4–22279–9	SPRING, COMPRESSION LC–026B–9	103
2	2	–	2–22280–9	SPRING, COMPRESSION LC–032C–6	102
1	1	–	1–23470–7	SPRING, COMPRESSION LC–035C–19	101
2	2	–	22354–7	STUD, 8–32	100
1	1	–	21024–4	WASHER, LOCK	99
2	2	–	21026–3	WASHER, INT TOOTH #8	98
					97
1	1	–	461264–1	TAG, IDENTIFICATION	96
2	2	–	21017–2	SCREW DRIVE 2 X .19	95
					94
–	–	–	679532–1	GUARD, INSERT	93
1	–	–	455755–8	ASSEMBLY, GUARD	92
					91
					90
–	1	–	22304–1	NIPPLE, HEX	89
–	1	–	22374–7	VALVE, QUICK EXHAUST	88
2	2	–	3–354779–4	PIN, WIRE DISC (.3160)C	87
2	2	–	2–354779–7	PIN, WIRE DISC (.3125)B	86
2	2	–	1–354779–4	PIN, WIRE DISC (.3060)A	85
					84
1	1	–	852287–1	PLATE, RETAINER	83
1	1	–	852286–1	LATCH, INSERT	82
1	1	–	852284–1	ARM, LATCH	81
1	1	–	852281–2	ROLLER	80
1	1	–	852245–2	CAM, INSERT	79
1	1	–	852246–1	CAM, VALVE	78
					77
1	1	–	354993–1	AIR CYLINDER 1–1/8 X .625	76
1	–	–	26108–1	BODY, QUICK CONNECT	75
1	–	–	23791–2	TEE, FEMALE BRANCH	74
2	–	–	22311–2	NIPPLE	73
1	–	–	28580–1	FILTER, MINIATURE	72
1	–	–	28582–1	LUBRICATOR	71

QTY REQD PER ASSY — PARTS LIST

–2	–1	U/M	PART NO	DESCRIPTION	ITEM NO
68	68	IN	27319–4	TUBING, NYLON .250	70
2	2	–	980282–3	CONNECTOR, MALE 1/8NPT X .25	69
1	–	–	22307–1	BUSHING, PIPE FITTING	68
1	2	–	23238–1	INSERT, COUPLING	67
–	1	–	980285–2	ELBOW, MALE SWIVEL 1/8NPT X .25	66
1	1	–	354385–4	ASSEMBLY, PNEUMATIC	65
1	–	–	692655–5	ASSEMBLY, VALVE	64
1	1	–	852289–1	ASSEMBLY, AIR FEED	63
1	1	–	461690–1	SPACER	62
1	1	–	459610–3	MOUNT, FEED BRACKET	61
1	2	–	19832–1	TIE, WIRE	60
					59
1	1	–	1338042–6	WIRE DEPRESSOR	58
1	1	–	1338042–5	WIRE DEPRESSOR	57
					56
					55
1	1	–	1338045–1	PLATE, DEPRESSOR	54
1	1	–	1338043–1	CAP, DEPRESSOR	53
1	1	–	1338044–1	WIRE DEPRESSOR, HOLDER	52
					51
1	1	–	690191–1	PLUG, NYLON	50
1	1	–	23241–6	BALL, STEEL	49
1	1	–	690603–1	SPRING, ASSIST	48
1	1	–	690212–1	POST, RAM	47
1	1	–	22480–5	WASHER, SPRING	46
1	1	–	986950–1	WASHER, FLAT PRECISION	45
1	1	–	354777–1	DISC, WIRE	44
1	1	–	690142–5	DISC, INSULATION	43
1	1	–	690124–1	WASHER, RAM	42
1	1	–	690125–1	WASHER, LAMINATED	41
					40
1	1	–	852251–2	DRAG	39
					38
1	1	–	853521–1	PAWL, FEED	37
1	1	–	461062–6	ASSEMBLY, FEED FINGER	36
					35
1	1	–	679158–3	GUIDE, REAR STRIP	34
1	1	–	679157–1	GUIDE, FRONT STRIP	33
1	1	–	1338060–1	PLATE, STRIP GUIDE	32
					31
1	1	–	1338955–5	HOLDDOWN, FIXED	30
1	1	–	90777–1	GIB, HOUSING	29
1	1	–	1424331–1	INSERTER, POD	28
1	1	–	90775–1	HOUSING, INSERT SLIDE	27
					26
1	1	–	1338051–1	SHEAR, RIGHT	25
1	1	–	1338050–1	SHEAR, LEFT	24
REF	REF	–	21028–3	PIN, SLOTTED SPRING	23
1	1	–	1633125–1	BLADE, SLUG	22
REF	REF	–	1–25022–5	SPRING, COMPRESSION	21
1	1	–	1338056–8	ANVIL	20
					19
1	1	–	1338041–1	SUPPORT, LOWER WIRE	18
					17
1	1	–	852248–3	STRIPPER	16
1	1	–	852247–1	SLIDE, STRIPPER	15
					14
1	1	–	2–238011–1	BLOCK, CRIMPER SPACER	13
					12
1	1	–	1–455888–0	SPACER, CRIMPER	11
					10
–	1	–	3–456135–8	CRIMPER, INSULATION "O"	9
1	–	–	1338419–1	CRIMPER, INSULATION "O"	8
–	1	–	4–1490019–9	CRIMPER, WIRE	7
1	–	–	1338418–1	CRIMPER, WIRE	6
1	1	–	1424389–1	RAM CAP PLATE	5
1	1	–	856287–2	RAM	4
1	1	–	1424388–1	CAP, RAM	3
1	1	–	1424387–1	HOUSING, APPLICATOR	2
1	1	–	1424368–1	PLATE, BASE	1

QTY REQD PER ASSY — PARTS LIST

P	LTR	REVISION RECORD	DATE	DWN	APVD
	H	ECR–12–010612	6–2012	MY	GB

DIMENSIONS: INCHES
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± – ; 1 PLC ± – ; 2 PLC ± – ; 3 PLC ± – ; 4 PLC ± –
ANGLES ± –
SURFACE TEXTURE √

DWN A.ANDERSON	27FEB01	MATERIAL – –	HEAT TREAT – –
CHK –			
APVD T.ELBIN	27FEB01	TE Connectivity	
NAME ULTRA–POD APPLICATOR, .110 STRAIGHT –			
SCALE 1:1	SIZE A1	DRAWING NO 680835	SHEET 1 OF 2
			REV H

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

DIMENSIONING AND TOLERANCING PER ASME Y14.5M (ISD STANDARDS) THIS DRAWING IS A CONTROLLED DOCUMENT. DWG NO 680835

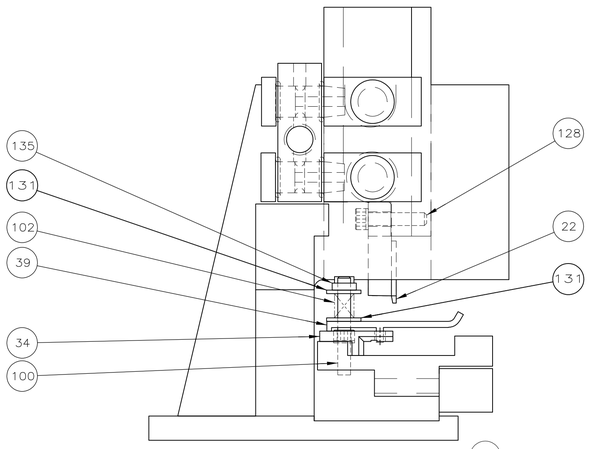
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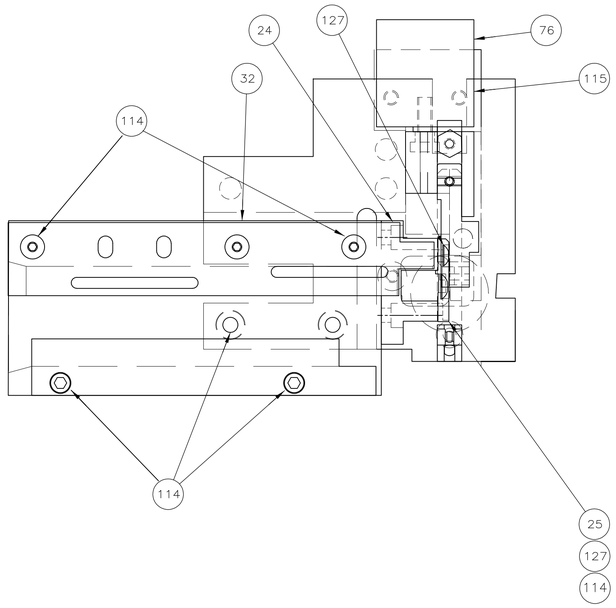
LOC A
DIST 66

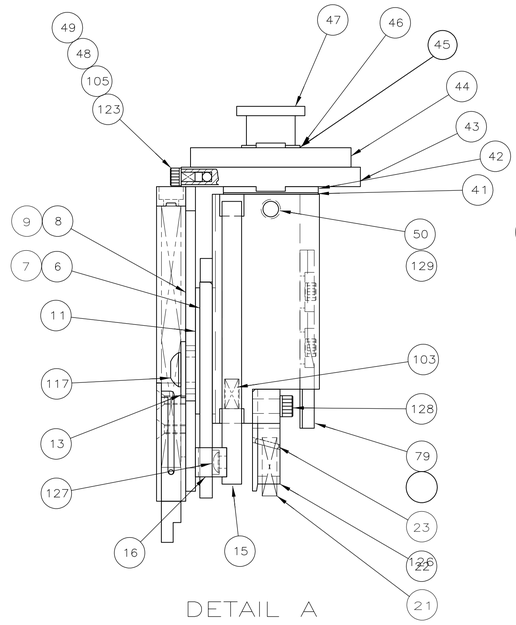
USED ON —

DIMENSIONING AND TOLERANCING PER ASME Y14.5M (ISO STANDARDS)
THIS DRAWING IS A CONTROLLED DOCUMENT.

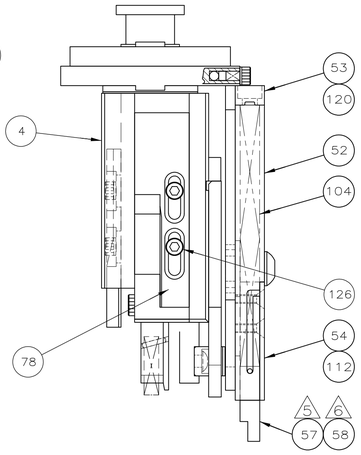
DWG NO 680835



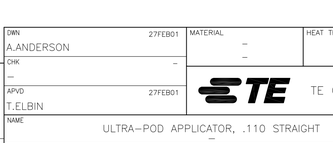




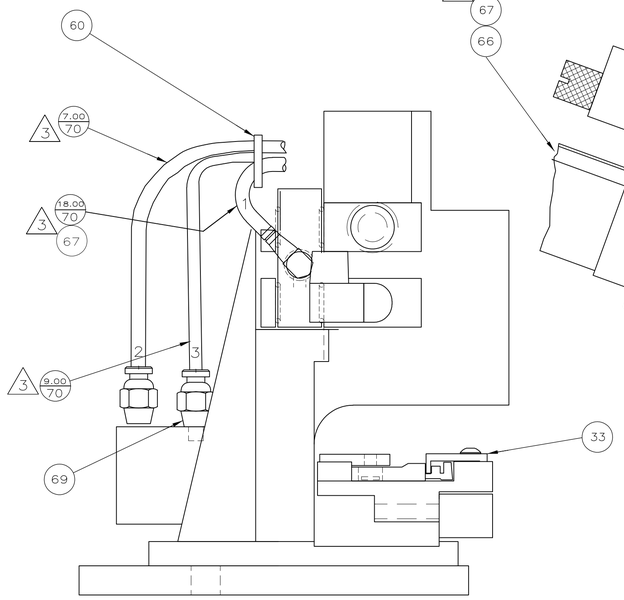
DETAIL A

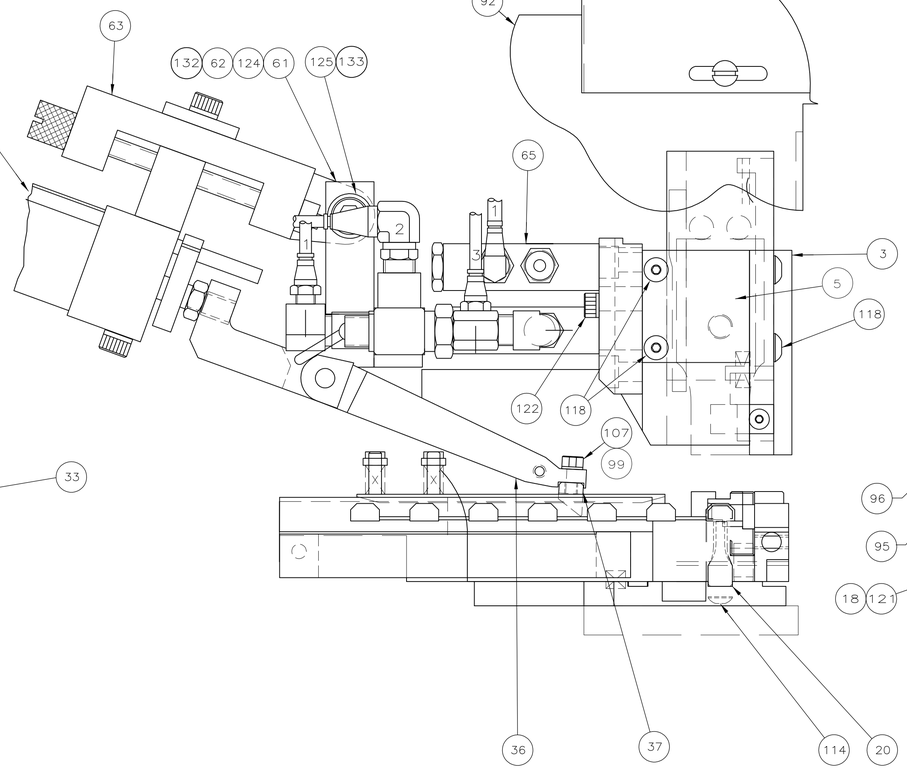


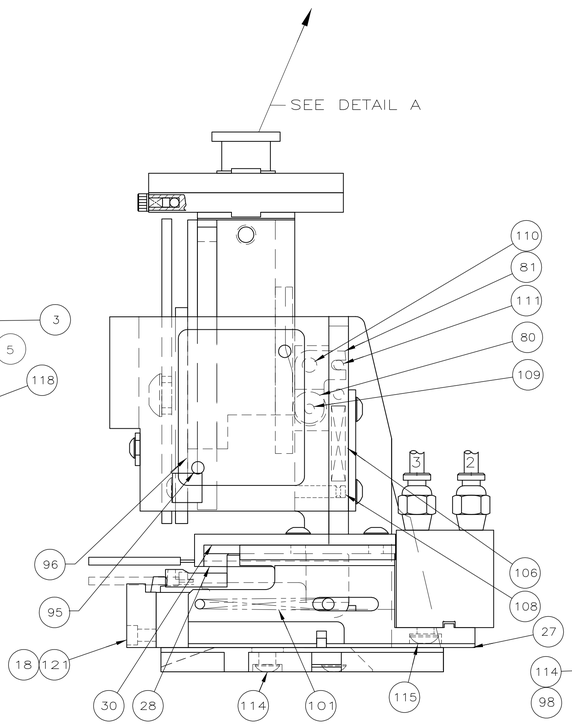
RIGHT SIDE VIEW OF DETAIL A

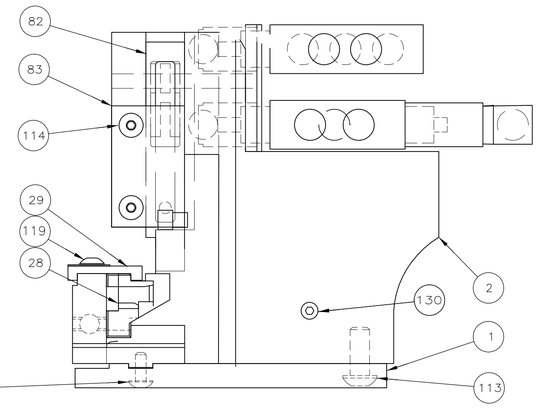












P	LTR	REVISION RECORD	DATE	DWN	APVD
—		SEE SHEET 1	—	—	—

DIMENSIONS: INCHES

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0 PLC ± —
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SURFACE TEXTURE

DWN A.ANDERSON	27FEB01	MATERIAL — —	HEAT TREAT — —
CHK —			
APVD T.ELBIN	27FEB01	TE Connectivity	
NAME ULTRA-POD APPLICATOR, .110 STRAIGHT —			
SCALE 1:1	SIZE A1	DRAWING NO 680835	SHEET 2 OF 2 REV H

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

LOC A
DIST 66

3308-8 (3/11)

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