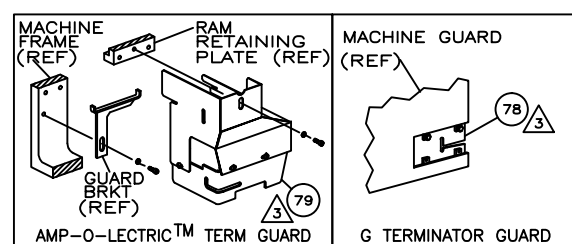
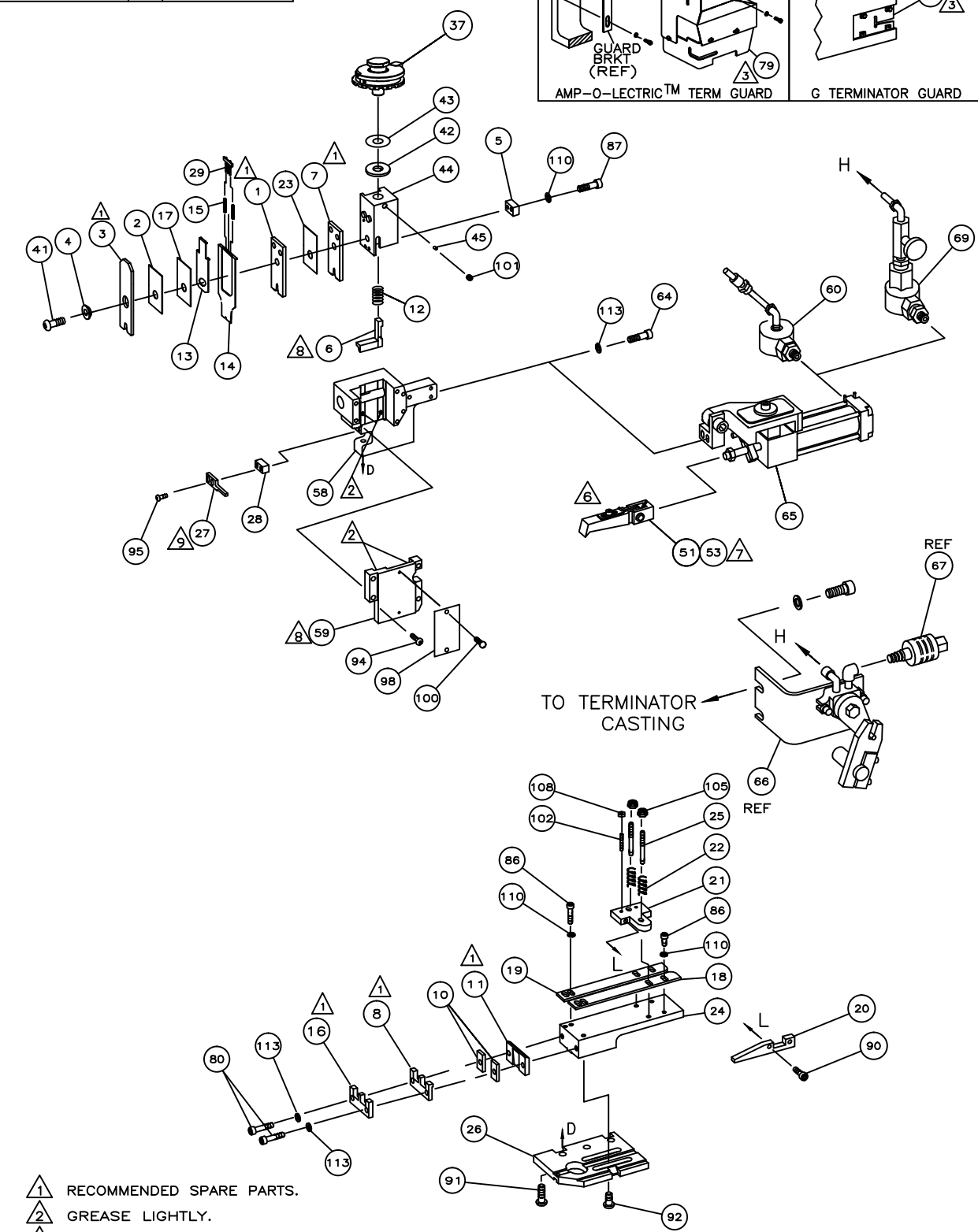


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PART NUMBER	REV	FIRST USED
1855184-1	C	122500-1
1855184-2	C	565435-5
7-1855184-7	B	-



TERMINAL NAME: .250 FLAG POS LOCK			
REF SETTING	CRIMP HEIGHT	WIRE SIZE	
B9	1.82 ±0.05mm [.072 ±.002]	14	
D3	1.62 ±0.05mm [.064 ±.002]	16	
E1	1.50 ±0.05mm [.059 ±.002]	18	
-	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	2.79mm [.110]	F	18-14
INSUL	3.61mm [.170]	0	2.79-3.81mm [.110-.150]
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
4.50-5.49mm	114-5070	19.00mm	408-8039
			SET UP GAGE LAYOUT
			458638-1 L1414



- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 4 SEE DRAWING FOR COMPONENTS
- 5 ITEM 78 USED WITH G TERMINATOR ONLY.
- 6 USE 8-32x 3/8 BHCS (2-21002-1) TO HOLD FEED FINGER TIP BECAUSE OF CLEARANCE.
- 7 MAGNET MUST BE REVERSED AT ASSY.
- 8 REMOVE ITEM 59 TO INSTALL ITEM 6.
- 9 INVERT ITEM 27

QTY REQD PER ASSY	REF	PART NO	DESCRIPTION	ITEM NO		
-				129		
-				128		
-				127		
-				126		
-				125		
-	1	1	217238-1 GENERAL INSTRUCTION PACKAGE	124		
-	1	1	4088039 EF APPL INST 408-8039	123		
-				122		
-				121		
-				120		
-				119		
-				118		
-				117		
-				116		
-				115		
-				114		
-	3	3	21024-5 WASHER,LOCK(#10)AIR ASSY	113		
-				112		
-				111		
-	4	4	21024-4 WASHER,LOCK(NO.8)SHEAR BL	110		
-				109		
-	2	2	21018-4 NUT,HEX(4-40)DRAG	108		
-				107		
-				106		
-	2	2	21022-2 NUT,HEX SL(8-32)DRAG STUD	105		
-				104		
-				103		
-	2	2	4-21078-8 SCR,SKT SET(4-40x.62)DRAG	102		
-	1	1	21009-2 SCR,SKT SET(1/4-20x.25)RAM	101		
-	2	2	21017-2 SCR,DRIVE(#2x.19)D PLATE	100		
-				99		
-	1	1	461264-1 PLATE, IDENTIFICATION	98		
-				97		
-				96		
-	2	2	2-21002-4 SCR,BHC(8-32x.75)STRIPPER	95		
-	4	4	2-21002-9 SCR,BHC(10-32x.75)CAP	94		
-				93		
-	4	4	3-21002-3 SCR,BHC(1/4-20x.50)ST GD PL	92		
-	3	3	2-22733-8 SCR,BHC(1/4-20x.62)HSG	91		
-	2	2	1-21000-3 SCR,SHC(4-40x.25)DRAG	90		
-				89		
-				88		
-	2	2	2-21000-6 SCR,SHC(8-32x.38)SLUG BLADE	87		
-	4	4	2-21000-8 SCR,SHC(8-32x.63)STRIP GUIDE	86		
-				85		
-				84		
-				83		
-				82		
-				81		
-	2	2	4-21000-0 SCR,SHC(10-32x1.25)SHEAR PL	80		
-	1	-	455750-7 GUARD ASSY	79		
-	-	REF	679532-1 INSERT, GUARD	78		
-				77		
-				76		
-				75		
-				74		
-				73		
-				72		
-				71		
-77	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

*** WARNING:**
 ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

LOC	DIST	REV	DATE	BY	APPD
A	66		2-2014	JH	TE

REV	DESCRIPTION
-1	LEADMAKER & BENCH MODEL G AIR FEED
-2	BENCH MODEL K AIR FEED

QTY REQD PER ASSY	REF	PART NO	DESCRIPTION	ITEM NO		
-				70		
-				69		
-				68		
-	REF		24042-2 VALVE, SHUT OFF	67		
-	REF		692655-6 AIR FEED VALVE ASSY	66		
-	1	1	2-460277-1 AIR FEED ASSY (1 INCH)	65		
-	2	2	3-21000-9 SCR,SHC(10-32x1.00)AIR ASSY	64		
-				63		
-				62		
-				61		
-				60		
-	1	1	692655-7 AIR FEED VALVE ASSY	60		
-	1	1	1424325-1 CAP, RAM	59		
-	1	1	453736-1 HOUSING	58		
-				57		
-				56		
-				55		
-				54		
-	1	1	356116-3 FEED PAWL	53		
-				52		
-	1	1	461062-8 FEED FINGER ASSY	51		
-				50		
-				49		
-				48		
-				47		
-				46		
-	1	1	690191-1 PLUG, NYLON	45		
-	1	1	1338281-1 RAM	44		
-				43		
-				42		
-	1	1	690686-3 BOLT, CRIMPER(5/16-24 x 1.00)	41		
-				40		
-	1	1	690125-1 SHIM, SUB-ASSY	39		
-	1	1	469367-8 SHIM	38		
-	1	1	879103-2 FINE ADJUST HEAD ASSY	37		
-				36		
-				35		
-				34		
-				33		
-				32		
-				31		
-				30		
-	1	1	1424350-1 HOLDER, PIN, WIRED	29		
-	1	1	4-690451-2 SPACER, STRIPPER	28		
-	1	1	468281-7 STRIPPER	27		
-	1	1	455676-4 PLATE, BASE	26		
-	2	2	22354-7 DRAG, STUD	25		
-	1	1	856076-1 PLATE, STRIP GUIDE	24		
-	1	1	455888-4 SPACER, WIRE CRIMPER	23		
-	2	2	22281-8 SPRING, DRAG	22		
-	1	1	464451-7 ARM, STOCK DRAG	21		
-	1	1	1-464452-3 DRAG, STOCK	20		
-	1	1	854753-1 GUIDE, STRIP (REAR)	19		
-	1	1	1338283-2 GUIDE, STRIP (FRONT)	18		
-	1	1	2-455888-1 SPACER, INS CRIMPER	17		
-	1	1	2-690702-6 ANVIL, INSULATION	16		
-	2	2	1-23147-4 SPRING,COMPRESSION	15		
-	1	1	1490525-3 DEPRESSOR, WIRE	14		
-	1	1	1490524-1 SPACER, CRIMPER	13		
-	1	1	5-22282-5 SPRING, HOLD DOWN	12		
-	1	1	240833-4 PLATE, REAR SHEAR	11		
-	2	2	1-240645-9 SPACER, SHEAR PLATE	10		
-				9		
-	1	1	1	2-690618-4 ANVIL, WIRE	8	
-	1	1	1	856077-1 BLADE, SLUG	7	
-	1	1	1	1338282-2 HOLD DOWN, TERMINAL	6	
-	1	1	1	5-240641-0 SPACER, SLUG BLADE	5	
-	1	1	1	238009-4 SPACER, BLOCK CRIMPER	4	
-	1	1	1	461296-3 CRIMPER, INSULATION	3	
-	1	1	1	2-455888-5 SPACER, CRIMPER	2	
-	1	1	1	456408-8 CRIMPER, WIRE	1	
-77	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES 0 PLC ±.01 1 PLC ±.02 2 PLC ±.03 3 PLC ±.04 4 PLC ±.05 ANGLES ±.5° FINISH -	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.02 2 PLC ±.03 3 PLC ±.04 4 PLC ±.05 ANGLES ±.5° FINISH -	THIS DRAWING IS A CONTROLLED DOCUMENT. DIM M. YOUNGER CHK R. WILSON DATE 1/21/14 APPD [Signature] PRODUCT SPEC APPLICATION SPEC MATERIAL - FINISH - HEIGHT - CUSTOMER DRAWING	END FEED HDM APPLICATOR SIZE CASE CODE DRAWING NO A1 00779 C-1855184 RESTRICTED TO SCALE - SHEET 1 of 1 REV C
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