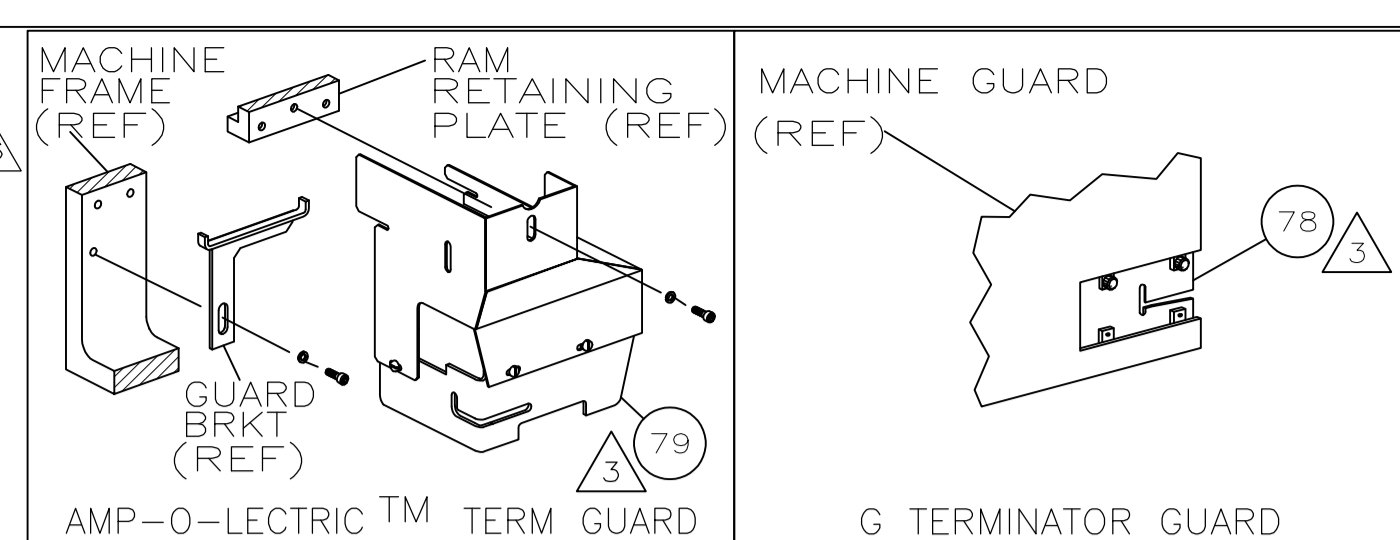
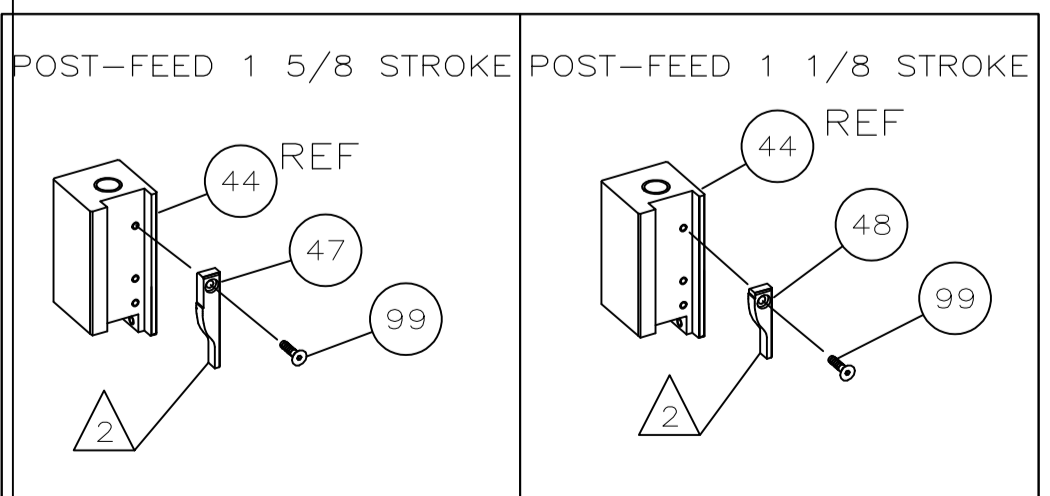
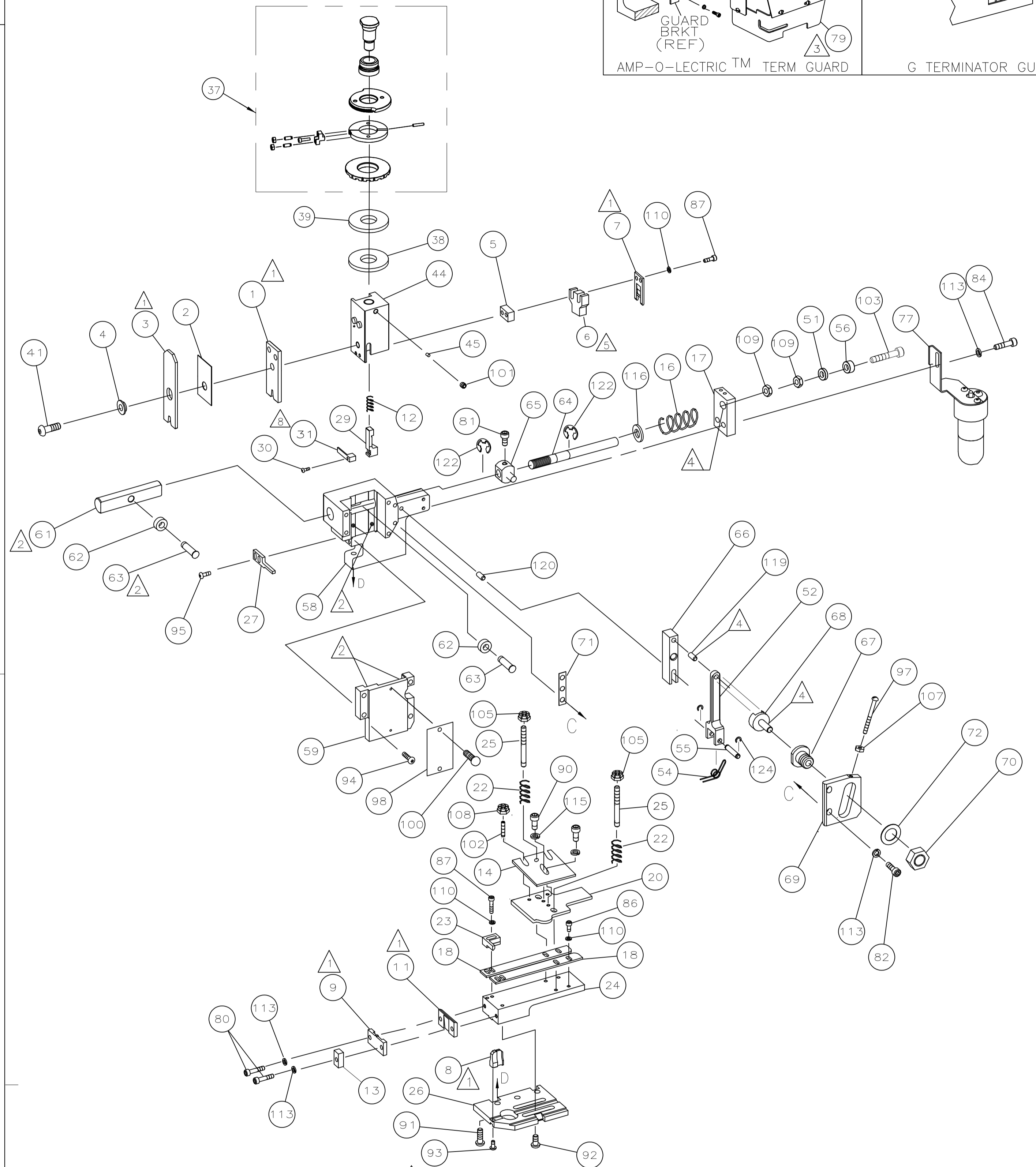


DIMENSIONING AND TOLERANCING PER ASME Y14.5M (USD STANDARDS). THIS DRAWING IS A CONTROLLED DOCUMENT.

PART NUMBER	REV	FIRST USED	POWER UNIT	FEED
1855212-1	B	854400-1	LEADMAKER& BENCH G	MECH POST FEED
1855212-2	B	565435-5	BENCH K	MECH-POST FEED
7-1855212-7	A	354500-1	SPARE TOOLING	



TERMINAL NAME: .250 POSI LOCK RECIP						
63097	63312	63442	63515	63809	AMP TERMINAL AMP CRIMP SPECS	
					CRIMP HEIGHT	WIRE SIZE
		A-9	.074 ±.002 [1.88 ±0.05mm]	14		
		C-7	.065 ±.002 [1.65 ±0.05mm]	16		
		E-2	.058 ±.002 [1.47 ±0.05mm]	18		
		-	NOT	USED		
CRIMP		SIZE	TYPE	RANGE		
WIRE		.110 [2.79mm]	F	14-18		
INSUL		.180 [4.57mm]	F	Ø090-.155		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT	
.173-.203	114-2074	1.035	408-8039	458638-1	1165	



- 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 ADJUST SO THAT BOTTOM OF NEOPRENE IS APPROX .125 ABOVE BOTTOM OF SLUG BLADE POCKET.
- 6 ON LEADMAKER WITH T TERMINATING UNITS: IF TERMINAL LOCKING LANCE IS BEING BENT DOWN BEFORE ENTERING APPLICATOR, ORDER SHROUD KIT, PN 189781-1.
- 7 ITEM 78 USED WITH G TERMINATING UNIT ONLY
- 8 PUT ITEM 31 ON AFTER RAM HAS BEEN PUT INTO HOUSING.

***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

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO	
-	1	1	-	986950-1	WASHER, FLAT PRECISION	125	
-	2	2	-	21045-3	RING,RET"C"(Ø.187)FD PIN	124	
-	2	2	-	1-21046-6	RING,RETAINING,EXT(5/16)FD ADJ ROD	122	
-	1	1	-	1-21030-7	PIN,DOWEL(Ø.187x1.50)HSG	120	
-	1	1	-	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	119	
-	1	1	-	1-21028-9	PIN SPRING Ø.078 X .50	118	
-	1	1	-	21899-4	WASHER,FLAT(Ø5/16)SCR ADJ	116	
-	2	2	-	21024-3	WASHER,LOCK(NO.6)PL DRAG	115	
-	6	6	-	21024-5	WASHER,LOCK(NO.10)SHEAR PL	113	
-	1	1	-	21055-6	WASHER,FLAT(NO 8) FEED FIN	111	
-	7	7	-	21024-4	WASHER,LOCK(NO.8)SHEAR BL	110	
-	2	2	-	22593-1	NUT,HEX(1/4-20)MAGNET	109	
-	2	2	-	21018-4	NUT,HEX(4-40)DRAG	108	
-	1	1	-	21018-5	NUT,HEX(6-32)FD ADJ PL	107	
-	2	2	-	21022-2	NUT,HEX SL(8-32)DRAG STUD	105	
-	1	1	-	3-21081-3	SCR,SHC(1/4-20X1.25)MAGNET	103	
-	2	2	-	2-21006-6	SCR,SKT SET(4-40 X.62)DRAG	102	
-	1	1	-	21009-2	SCR,SKT SET(1/4-20x.25)RAM	101	
-	2	2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE	100	
-	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	99	
-	1	1	-	461264-5	PLATE, IDENTIFICATION	98	
-	1	1	-	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	97	
-	2	2	-	2-21002-2	SCR,BHC(8-32X.50)STRIPPER	95	
-	4	4	-	2-21002-9	SCR,BHC(10-32X.75)	94	
-	1	1	-	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	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)BASE PL	91	
-	2	2	-	1-21000-8	SCR,SHC(6-32 X .25)PL DRAG	90	
-	1	1	-	2-21000-5	SCR,SHC(8-32 X .25)FEED FIN	88	
-	4	4	-	2-21000-9	SCR,SHC(8-32x.75)SLUG BLADE	87	
-	3	3	-	2-21000-6	SCR,SHC(8-32x.38)STRIP GUIDE	86	
-	2	2	-	3-21000-7	SCR, SKT CAP(10-32x.75)FD GDE	84	
-	2	2	-	3-21000-6	SCR,SKT CAP(10-32x.62)FD ADJ P	82	
-	1	1	-	3-21000-4	SCR,SKT CAP(10-32x.38)PIVOT BL	81	
-	2	2	-	3-21000-8	SCR,SKT CAP(10-32x.88)SH PL	80	
-	REF	REF	-	455745-1	GUARD, WINDOW	79	
-	REF	REF	-	679532-1	INSERT, GUARD	78	
-	1	1	-	465184-9	LUBRICATOR ASSY	77	
-	1	1	-	690603-1	SPRING, ASSIST	74	
-	1	1	-	23030-1	SCR,SKT CAP(6-32x.25)CP DSC	73	
-	1	1	-	458109-1	WASHER, FLAT (SPECIAL)	72	
-	1	1	-	690517-1	SPACER	71	
-	77	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO	
-	1	1	-	22594-8	NUT, HEX	70	
-	1	1	-	240628-1	PLATE, ADJ	69	
-	1	1	-	240626-1	SHAFT, PIVOT	68	
-	1	1	-	240633-1	BUSHING	67	
-	1	1	-	455680-1	LEVER, INTERMEDIATE	66	
-	1	1	-	240629-1	BLOCK, PIVOT	65	
-	1	1	-	1804311-1	SCR, ADJ	64	
-	1	1	-	240659-3	PIN, CAM ROLLER	63	
-	1	1	-	240658-1	CAM, ROLLER	62	
-	1	1	-	454398-1	ROD, FEED	61	
-	1	1	-	189467-1	CAP, RAM	59	
-	1	1	-	453736-1	HOUSING	58	
-	1	1	-	A31804299-1	SPACER, MAGNET	56	
-	1	1	-	240624-1	PIN, FEED FINGER	55	
-	1	1	-	691499-1	SPRING, FEED FINGER	54	
-	1	1	-	1752620-2	FINGER, FEED	53	
-	1	1	-	240634-1	LEVER, TERMINAL	52	
-	1	1	-	1804310-1	MAGNET, RING	51	
-	1	-	-	690501-3	CAM, POST FEED 1 1/8 ST	48	
-	-	1	-	690501-4	CAM, POST-FEED 1 5/8 ST	47	
-	1	1	-	690191-1	PLUG, NYLON	46	
-	1	1	-	455674-1	RAM	45	
-	1	1	-	7-21002-9	BOLT, CRIMPER(5/16-24x1.00)	41	
-	1	1	-	690125-1	SHIM ASSEMBLY	39	
-	1	1	-	469367-1	SPACER, FINE ADJUST	38	
-	1	1	-	879103-2	FINE ADJUST HEAD SUB	37	
-	1	1	-	1752621-1	SPRING SWIVEL TIP	34	
-	1	1	-	1752622-1	TIP, SWIVEL F.F	33	
-	1	1	-	189181-1	STRIPPER,TERMINAL	31	
-	1	1	-	1-21000-6	SCR,SHC (4-40 X.62)STR	30	
-	1	1	-	189453-1	SLIDE, STRIPPER	29	
-	1	1	-	189257-1	STRIPPER	27	
-	1	1	-	455676-1	PLATE, BASE	26	
-	2	2	-	22354-8	DRAG, STUD	25	
-	1	1	-	804823-2	PLATE, STRIP GUIDE	24	
-	1	1	-	568663-1	PLATE, STRIP HOLD DOWN	23	
-	2	2	-	4-22281-1	SPRING, DRAG	22	
-	1	1	-	814130-1	DRAG, STOCK	20	
-	2	2	-	454204-3	GUIDE STRIP,FRONT & REAR	18	
-	1	1	-	1804305-2	GUIDE, FEED ROD	17	
-	1	1	-	4-22284-9	SPRING, FEED RETURN	16	
-	1	1	-	683875-1	PLATE, DRAG LOCATOR	14	
-	1	1	-	690481-2	SPACER, HOLD DOWN	13	
-	1	1	-	8-22282-9	SPRING, HOLD DOWN	12	
-	1	1	-	240833-1	PLATE, REAR SHEAR	11	
-	1	1	-	690482-7	PLATE, FRONT SHEAR	9	
-	1	1	-	6-240693-8	ANVIL	8	
-	1	1	-	3-690474-9	BLADE, SLUG	7	
-	1	1	-	463460-1	HOLD DOWN, TERMINAL	6	
-	1	1	-	1-240641-6	SPACER, SLUG BLADE	5	
-	1	1	-	238009-1	SPACER, BLOCK CRIMPER	4	
-	1	1	-	8-456134-5	CRIMPER, INSULATION	3	
-	1	1	-	455888-9	SPACER, CRIMPER	2	
-	1	1	-	456408-7	CRIMPER, WIRE	1	
-	77	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

LOC	LEADMAKER & G TERMINATOR	K TERMINATOR BENCH MACHINE
DIST	66	