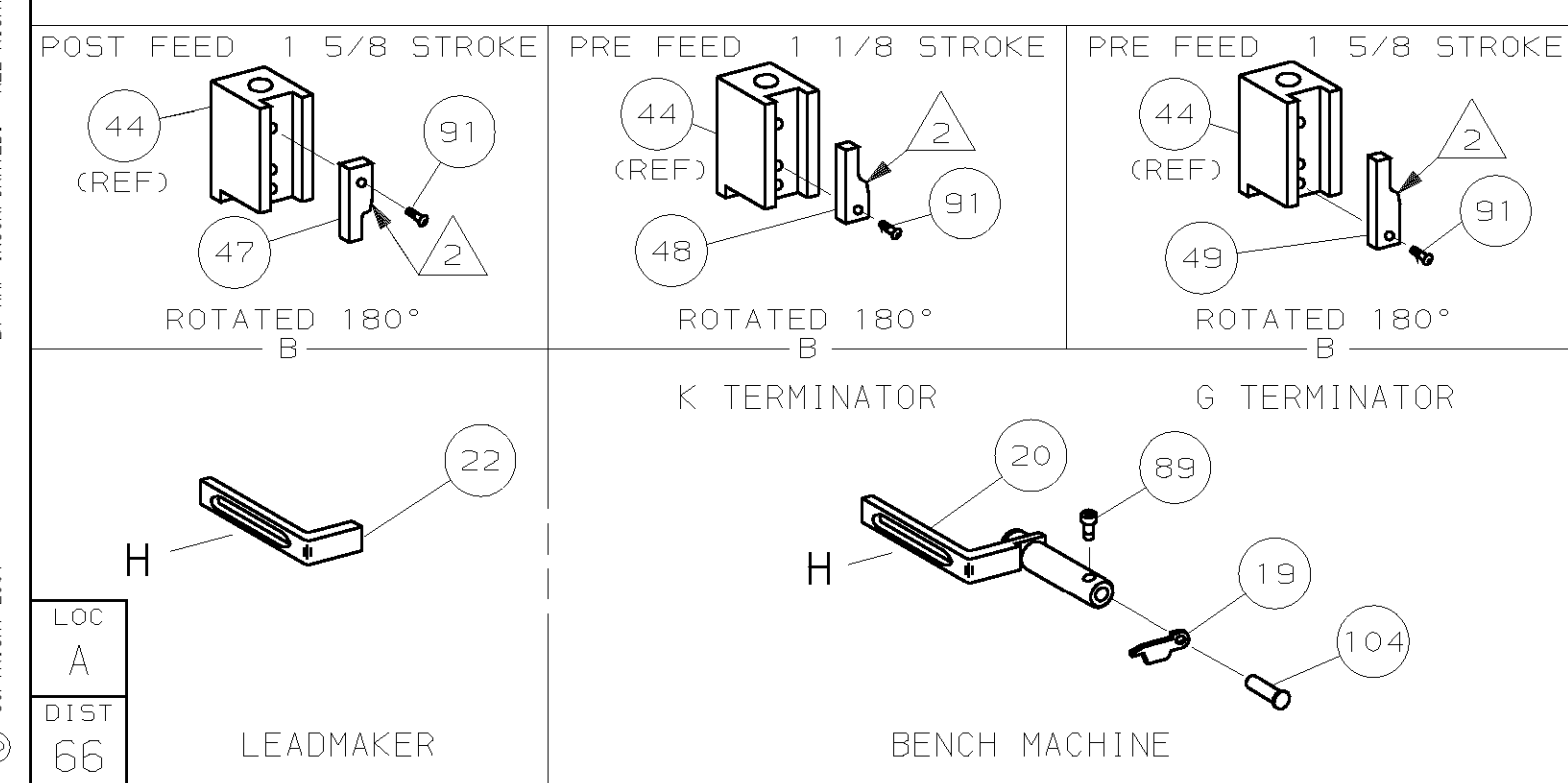
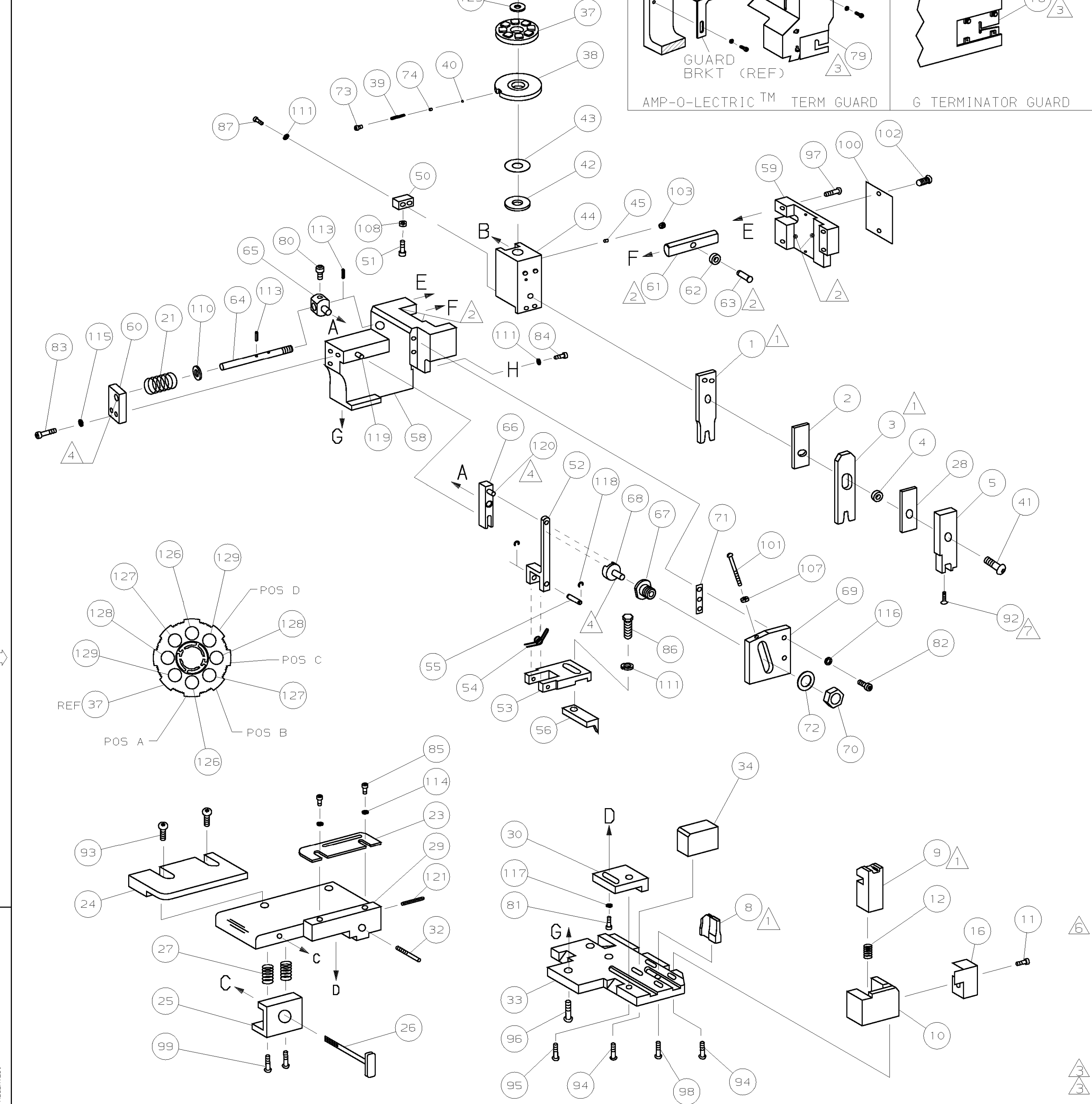


| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------|
| 680528-1    | B   | 122500-1   |
| 680528-2    | B   | 565435-5   |
| 680528-3    | B   | 354500-1   |



- 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 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

| SEAL   | TERMINAL | CRIMPING DATA |                           |                           |                          |
|--------|----------|---------------|---------------------------|---------------------------|--------------------------|
| 963292 | 927772   | PAD LTR       | CRIMP HEIGHT              | WIRE SIZE                 |                          |
|        |          | A             | .044 ±.002 [1.12 ±0.05mm] | 0.5mm <sup>2</sup>        |                          |
|        |          | B             | .041 ±.002 [1.04 ±0.05mm] | 0.35mm <sup>2</sup> OR 22 |                          |
|        |          | C             | .039 ±.002 [0.99 ±0.05mm] | 0.25mm <sup>2</sup>       |                          |
|        |          | D             | .038 ±.002 [0.97 ±0.05mm] | 0.2mm <sup>2</sup>        |                          |
|        |          | CRIMP         | SIZE                      | TYPE                      | RANGE                    |
|        |          | WIRE          | .062 [1.57mm]             | F                         | 0.2mm-0.5mm <sup>2</sup> |
|        |          | INSUL         | .155 [3.94mm]             | 0                         | 3.45MM MAX               |

| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPL INSTRUCTION | SET UP GAGE | LAYOUT |
|-------------------|----------------|------|------------------|-------------|--------|
| .125-.141         | 114-18022      | .551 | 408-8040         | 458637-1    | L1989  |

| QTY | REF | REF | REF | REF | REF        | DESCRIPTION                      | ITEM NO |
|-----|-----|-----|-----|-----|------------|----------------------------------|---------|
| 2   | 2   | 2   | -   | C   | 5-354779-4 | PIN, WIRE DISC (.3260)D          | 129     |
| 2   | 2   | 2   | -   | C   | 5-354779-2 | PIN, WIRE DISC (.3250)C          | 128     |
| 2   | 2   | 2   | -   | C   | 4-354779-2 | PIN, WIRE DISC (.3200)B          | 127     |
| 2   | 2   | 2   | -   | C   | 3-354779-4 | PIN, WIRE DISC (.3160)A          | 126     |
| 1   | 1   | 1   | -   | A   | 986950-1   | WASHER, FLAT PRECISION           | 125     |
| 1   | 1   | 1   | -   | A   | 217238-1   | GENERAL INSTRUCTION PACKAGE      | 124     |
| 1   | 1   | 1   | -   | -   | 4088040    | SF APPL INST 408-8040            | 123     |
|     |     |     |     |     |            |                                  | 122     |
| 1   | 1   | 1   | -   | A   | 4-21028-0  | PIN,SLT SPR(ø.093x.75)ST GDE PL  | 121     |
| REF | REF | REF | -   | A   | 1-21030-1  | PIN,DOWEL (ø.187x.50)LEVER       | 120     |
| REF | REF | REF | -   | A   | 1-21030-6  | PIN,DOWEL (ø.187x1.25)HOUSING    | 119     |
| REF | REF | REF | -   | A   | 21045-3    | RING,RET "C"(ø.187)FD FING PIN   | 118     |
| 1   | 1   | 1   | -   | A   | 21024-5    | WASHER, LOCK (#10)ADJ BLK        | 117     |
| REF | REF | REF | -   | A   | 21024-5    | WASHER,LOCK (#10)ADJ PLATE       | 116     |
| REF | REF | REF | -   | A   | 21024-5    | WASHER,LOCK (#10)FEED GDE ROD    | 115     |
| 2   | 2   | 2   | -   | A   | 21024-2    | WASHER,LOCK (#4)FRONT STP GUIDE  | 114     |
| REF | REF | REF | -   | A   | 5-21028-1  | PIN,SLT SPR(ø.125x.50)ADJ ROD    | 113     |
|     |     |     |     |     |            |                                  | 112     |
| 4   | 4   | 4   | -   | A   | 21024-4    | WASHER,LOCK (#8)STRIPPER         | 111     |
| REF | REF | REF | -   | A   | 21899-4    | WASHER,FLAT (ø5/16)SCREW ADJ     | 110     |
|     |     |     |     |     |            |                                  | 109     |
| 1   | 1   | 1   | -   | A   | 21018-5    | NUT,HEX (NO.6)HOLDDOWN           | 108     |
| REF | REF | REF | -   | A   | 21018-5    | NUT,HEX (6-32)FEED ADJ           | 107     |
|     |     |     |     |     |            |                                  | 106     |
|     |     |     |     |     |            |                                  | 105     |
| 1   | 1   | -   | -   | A   | 992031-1   | PIN, CLEVIS                      | 104     |
| 1   | 1   | 1   | -   | A   | 21009-2    | SCR,5KT SET(1/4-20x.25 LW)RAM    | 103     |
| 2   | 2   | 2   | -   | A   | 21017-2    | SCR,DRIVE (#2x.19)ID PLATE       | 102     |
| REF | REF | REF | -   | A   | 6-23715-5  | SCR,PAN HD (6-32x1.50)FEED ADJ   | 101     |
| 1   | 1   | 1   | -   | B   | 461264-1   | PLATE, IDENTIFICATION            | 100     |
| 2   | 2   | 2   | -   | A   | 3-21002-0  | SCR,BHC (10-32x.88)DRAG          | 99      |
| 1   | 1   | 1   | -   | A   | 22733-8    | SCR,BHC (8-32x.38 LW)ANVIL       | 98      |
| REF | REF | REF | -   | A   | 2-21002-9  | SCR,BHC (10-32x.75)CAP           | 97      |
| REF | REF | REF | -   | A   | 2-22733-8  | SCR,BHC (1/4-20x.62)HOUSING      | 96      |
| REF | REF | REF | -   | A   | 2-21002-7  | SCR,BHC (10-32x.50)5G ADJ BLOCK  | 95      |
| 6   | 6   | 6   | -   | A   | 2-21002-2  | SCR,BHC (8-32x.50)TERM H DWN     | 94      |
|     |     |     |     |     |            |                                  | 93      |
| 1   | 1   | 1   | -   | A   | 1-21003-9  | SCR,FHC (6-32x.38)DEP            | 92      |
| 1   | 1   | 1   | -   | A   | 1-21002-7  | SCR,BHC (6-32x.38)CAM            | 91      |
|     |     |     |     |     |            |                                  | 90      |
| 1   | 1   | -   | -   | A   | 7-21000-9  | SCR,SHC (4-40x.19)STRIPPER       | 89      |
|     |     |     |     |     |            |                                  | 88      |
| 2   | 2   | 2   | -   | A   | 2-21000-7  | SCR,SHC (8-32x.48)DEP-HOLD       | 87      |
| 1   | 1   | 1   | -   | A   | 2-22603-0  | SCR,HEX HD (8-32x.31)FEED FINGER | 86      |
| 2   | 2   | 2   | -   | A   | 1-21000-3  | SCR,SHC (4-40x.25)F ST GUIDE     | 85      |
| 1   | 1   | 1   | -   | A   | 2-21000-7  | SCR,SHC (8-32x.50)STRIPPER       | 84      |
| REF | REF | REF | -   | A   | 3-21000-7  | SCR,SHC (10-32x.75)FEED ROD GD   | 83      |
| REF | REF | REF | -   | A   | 3-21000-6  | SCR,SHC (10-32x.62)FD ADJ BLK    | 82      |
| 1   | 1   | 1   | -   | A   | 3-21000-4  | SCR,SHC (10-32x.38)5G ADJ BL     | 81      |
| REF | REF | REF | -   | A   | 3-21000-4  | SCR,SHC (10-32x.38)PIVOT BLK     | 80      |
| -   | REF | -   | -   | B   | 455749-1   | GUARD, WINDOW                    | 79      |
| REF | -   | -   | -   | B   | 679532-1   | INSERT, GUARD                    | 78      |
|     |     |     |     |     |            |                                  | 77      |
|     |     |     |     |     |            |                                  | 76      |
|     |     |     |     |     |            |                                  | 75      |
| 1   | 1   | 1   | -   | A   | 690603-1   | SPRING, ASSIST                   | 74      |
| 1   | 1   | 1   | -   | A   | 23030-1    | SCR,SHC (6-32x.25 SL)INS DISC    | 73      |
| REF | REF | REF | -   | A   | 458109-1   | WASHER, SPECIAL                  | 72      |
| REF | REF | REF | -   | A   | 690517-1   | SPACER                           | 71      |
|     |     |     |     |     |            |                                  | 70      |
|     |     |     |     |     |            |                                  | 69      |
|     |     |     |     |     |            |                                  | 68      |
|     |     |     |     |     |            |                                  | 67      |
|     |     |     |     |     |            |                                  | 66      |
|     |     |     |     |     |            |                                  | 65      |
|     |     |     |     |     |            |                                  | 64      |
|     |     |     |     |     |            |                                  | 63      |
|     |     |     |     |     |            |                                  | 62      |
|     |     |     |     |     |            |                                  | 61      |
|     |     |     |     |     |            |                                  | 60      |
|     |     |     |     |     |            |                                  | 59      |
|     |     |     |     |     |            |                                  | 58      |
|     |     |     |     |     |            |                                  | 57      |
|     |     |     |     |     |            |                                  | 56      |
|     |     |     |     |     |            |                                  | 55      |
|     |     |     |     |     |            |                                  | 54      |
|     |     |     |     |     |            |                                  | 53      |
|     |     |     |     |     |            |                                  | 52      |
|     |     |     |     |     |            |                                  | 51      |
|     |     |     |     |     |            |                                  | 50      |
|     |     |     |     |     |            |                                  | 49      |
|     |     |     |     |     |            |                                  | 48      |
|     |     |     |     |     |            |                                  | 47      |
|     |     |     |     |     |            |                                  | 46      |
|     |     |     |     |     |            |                                  | 45      |
|     |     |     |     |     |            |                                  | 44      |
|     |     |     |     |     |            |                                  | 43      |
|     |     |     |     |     |            |                                  | 42      |
|     |     |     |     |     |            |                                  | 41      |
|     |     |     |     |     |            |                                  | 40      |
|     |     |     |     |     |            |                                  | 39      |
|     |     |     |     |     |            |                                  | 38      |
|     |     |     |     |     |            |                                  | 37      |
|     |     |     |     |     |            |                                  | 36      |
|     |     |     |     |     |            |                                  | 35      |
|     |     |     |     |     |            |                                  | 34      |
| REF | REF | REF | -   | D   | 455675-1   | PLATE, BASE                      | 33      |
| 1   | 1   | 1   | -   | A   | 690432-3   | SCREW, ADJUSTMENT                | 32      |
|     |     |     |     |     |            |                                  | 31      |
| REF | REF | REF | -   | B   | 455689-1   | BLOCK, STRIP GUIDE ADJ           | 30      |
| 1   | 1   | 1   | -   | C   | 455671-1   | PLATE, STRIP GUIDE               | 29      |
| 1   | 1   | 1   | -   | C   | 2-455888-2 | SPACER, FRONT SHEAR DEP          | 28      |
| 2   | 2   | 2   | -   | A   | 1-22284-0  | SPRING, DRAG                     | 27      |
| 1   | 1   | 1   | -   | B   | 690546-1   | LEVER, DRAG RELEASE              | 26      |
| 1   | 1   | 1   | -   | B   | 240792-1   | DRAG, TERMINAL                   | 25      |
| 1   | 1   | 1   | -   | D   | 6-690504-8 | GUIDE, STRIP (REAR)              | 24      |
| 1   | 1   | 1   | -   | A   | 690438-1   | GUIDE, STRIP (FRONT)             | 23      |
| -   | -   | 1   | -   | B   | 690472-2   | STRIPPER                         | 22      |
| REF | REF | REF | -   | A   | 4-22284-9  | SPRING, FEED RETURN              | 21      |
| 1   | 1   | -   | -   | A   | 679218-1   | STRIPPER WIRE STOP ASSY          | 20      |
| 1   | 1   | -   | -   | B   | 458949-1   | STRIPPER                         | 19      |
|     |     |     |     |     |            |                                  | 18      |
|     |     |     |     |     |            |                                  | 17      |
| 1   | 1   | 1   | -   | B   | 318563-1   | GUARD, CHIP, FRONT               | 16      |
|     |     |     |     |     |            |                                  | 15      |
|     |     |     |     |     |            |                                  | 14      |
|     |     |     |     |     |            |                                  | 13      |
| 1   | 1   | 1   | -   | A   | 5-22280-0  | SPRING, SHEAR                    | 12      |
| 1   | 1   | 1   | -   | B   | 690461-2   | STOP, SHEAR                      | 11      |
| 1   | 1   | 1   | -   | C   | 1-690459-0 | HOLDER, SHEAR (FRONT)            | 10      |
| 1   | 1   | 1   | -   | C   | 318707-1   | SHEAR, FLOAT (FRONT)             | 9       |
| 1   | 1   | 1   | -   | C   | 662184-4   | ANVIL                            | 8       |
|     |     |     |     |     |            |                                  | 7       |
|     |     |     |     |     |            |                                  | 6       |
| 1   | 1   | 1   | -   | C   | 318701-1   | DEPRESSOR, SHEAR (FRONT)         | 5       |
| 1   | 1   | 1   | -   | B   | 238011-8   | SPACER, BLOCK CRIMPER            | 4       |
| 1   | 1   | 1   | -   | C   | 5-456135-4 | CRIMPER, INSULATION              | 3       |
| 1   | 1   | 1   | -   | C   | 1-455888-8 | SPACER, CRIMPER                  | 2       |
| 1   | 1   | 1   | -   | C   | 1-456403-3 | CRIMPER, WIRE                    | 1       |

| QTY | REF | REF | REF | REF | REF | DESCRIPTION   | ITEM NO                     |    |
|-----|-----|-----|-----|-----|-----|---------------|-----------------------------|----|
| -1  |     |     |     |     | B   | LEADMAKER     |                             |    |
| -2  |     |     |     |     | B   | BENCH MODEL K |                             |    |
| -3  |     |     |     |     | G   | BENCH MODEL G |                             |    |
| REF | REF | REF | -   | B   |     | 22594-8       | NUT,HEX (1/2-20)            | 70 |
| REF | REF | REF | -   | B   |     | 240628-1      | PLATE, ADJUSTMENT           | 69 |
| REF | REF | REF | -   | B   |     | 240626-1      | SHAFT, PIVOT                | 68 |
| REF | REF | REF | -   | B   |     | 240633-1      | BUSHING                     | 67 |
| REF | REF | REF | -   | A   |     | 455680-1      | LEVER, INTERMEDIATE         | 66 |
| REF | REF | REF | -   | B   |     | 240629-1      | BLOCK, PIVOT                | 65 |
| REF | REF | REF | -   | A   |     | 240632-2      | SCREW, ADJ FEED ROD         | 64 |
| REF | REF | REF | -   | B   |     | 240659-3      | PIN, CAM ROLLER             | 63 |
| REF | REF | REF | -   | B   |     | 240658-1      | ROLLER, CAM                 | 62 |
| REF | REF | REF | -   | B   |     | 454398-2      | ROD, FEED                   | 61 |
| REF | REF | REF | -   | A   |     | 454178-1      | GUIDE, FEED ROD             | 60 |
| REF | REF | REF | -   | C   |     | 454220-1      | CAP, RAM                    | 59 |
| REF | REF | REF | -   | D   |     | 454485-1      | HOUSING                     | 58 |
|     |     |     |     |     |     |               |                             | 57 |
| 1   | 1   | 1   | -   | B   |     | 690542-2      | PAWL, FEED                  | 56 |
| REF | REF | REF | -   | B   |     | 240624-1      | PIN, FEED FINGER            | 55 |
| REF | REF | REF | -   | B   |     | 691499-1      | SPRING, FEED FINGER         | 54 |
| REF | REF | REF | -   | B   |     | 690541-1      | HOLDER, FEED FINGER         | 53 |
| REF | REF | REF | -   | A   |     | 455679-1      | LEVER, TERMINAL FEED ARM    | 52 |
| 1   | 1   | 1   | -   | A   |     | 811242-2      | BUMPER, HOLDDOWN            | 51 |
| 1   | 1   | 1   | -   | A   |     | 690753-1      | SPACER, TONKER              | 50 |
| 1   | -   | -   | -   | B   |     | 690602-6      | CAM, PRE-FEED 1 5/8 ST      | 49 |
| -   | 1   | -   | -   | B   |     | 690602-5      | CAM, PRE-FEED 1 1/8 ST      | 48 |
| -   | -   | 1   | -   | B   |     | 690501-4      | CAM, POST-FEED 1 5/8 ST     | 47 |
| 1   | 1   | 1   | -   | B   |     | 459456-1      | APPLICATOR, BASIC (SUBASSY) | 46 |
| 1   | 1   | 1   | -   | A   |     | 690191-1      | PLUG, NYLON                 | 45 |
| 1   | 1   | 1   | -   | C   |     | 455673-1      | RAM                         | 44 |
| 1   | 1   | 1   | -   | A   |     | 690125-1      | WASHER, LAMINATED           | 43 |
| 1   | 1   | 1   | -   | A   |     | 690124-1      | WASHER, RAM                 | 42 |
| 1   | 1   | 1   | -   | A   |     | 7-21002-9     | BOLT, CRIMPER (5/16x1.00)   | 41 |
| 1   | 1   | 1   | -   | A   |     | 23241-6       | BALL, STEEL                 | 40 |
| 1   | 1   | 1   | -   | A   |     | 690170-1      | SPRING, COMPRESSION         | 39 |
| 1   | 1   | 1   | -   | C   |     | 1-690142-1    | DISC, INSULATION            | 38 |
| 1   | 1   | 1   | -   | D   |     | 354777-1      | WIRE DISC, PLASTIC          | 37 |
| 1   | 1   | 1   | -   | A   |     | 22480-5       | WASHER, SPRING              | 36 |
| 1   | 1   | 1   | -   | B   |     | 690212-1      | POST, RAM                   | 35 |
| 1   | 1   | 1   | -   | B   |     | 690786-4      | SUPPORT, TERMINAL           | 34 |
| REF | REF | REF | -   | D   |     | 455675-1      | PLATE, BASE                 | 33 |
| 1   | 1   | 1   | -   | A   |     | 690432-3      | SCREW, ADJUSTMENT           | 32 |
|     |     |     |     |     |     |               |                             | 31 |
| REF | REF | REF | -   | B   |     | 455689-1      | BLOCK, STRIP GUIDE ADJ      | 30 |
| 1   | 1   | 1   | -   | C   |     | 455671-1      | PLATE, STRIP GUIDE          | 29 |
| 1   | 1   | 1   | -   | C   |     | 2-455888-2    | SPACER, FRONT SHEAR DEP     | 28 |
| 2   | 2   | 2   | -   | A   |     | 1-22284-0     | SPRING, DRAG                | 27 |
| 1   | 1   | 1   | -   | B   |     | 690546-1      | LEVER, DRAG RELEASE         | 26 |
| 1   | 1   | 1   | -   | B   |     | 240792-1      | DRAG, TERMINAL              | 25 |