

- 1. INSTRUCTION SHEET A18044 MUST ACCOMPANY THIS APPLICATOR.
- ITEM 24 459655-2 IS REQUIRED TO APPLY FASTON PRODUCTS.
- USE ITEM 20 PN 459655-3 TO APPLY BUTT SPLICES. THIS ITEM NOT SUPPLIED WITH APPLICATOR.
- THESE FUNNELS ARE AVAILABLE TO AID WIRE INSERTION WHEN USED ON THE AOM CLS MACHINE. USE 815459-1 FOR 22-18 AWG PRODUCT AND 815459-2 FOR 16-14 AWG PRODUCT.
- CUT TUBING TO 16 & 12 INCH SECTIONS.
- INSTALL SPACERS, ITEM 76, AS REQUIRED AT ASSEMBLY BETWEEN ITEMS 39 AND 44 TO LIMIT PLAY IN LOWER SLIDE ASSEMBLY TO .006 MAX.
- INSTALL ITEM 126 WHEN RUNNING 12-10 AWG SOLISTRAND PRODUCT.
- WHEN RUNNING 12-10 BUTT SPLICES, REMOVE ITEM 20, PN 459655-3, AND INSTALL ITEMS 127 AND 128 INTO ITEM 55. THE 2ND 6-32 HEX NUT IS TO SECURE THE URETHANE PAD TO THE HEAD OF THE SCREW.

- WHEN RUNNING 16-14 PIDG FASTON, P/N 640905-2, REMOVE ITEMS 9, 24, 25, 121, AND 122 AND INSTALL ITEMS 126, 127, 128. ADJUST HEIGHT OF 127 AND LOCK WITH 128. THESE ARE USED TO REDUCE TERMINAL TWISTING.
- ITEM 127 MAY NEED TO BE ADJUSTED WHEN SWITCHING TERMINALS.

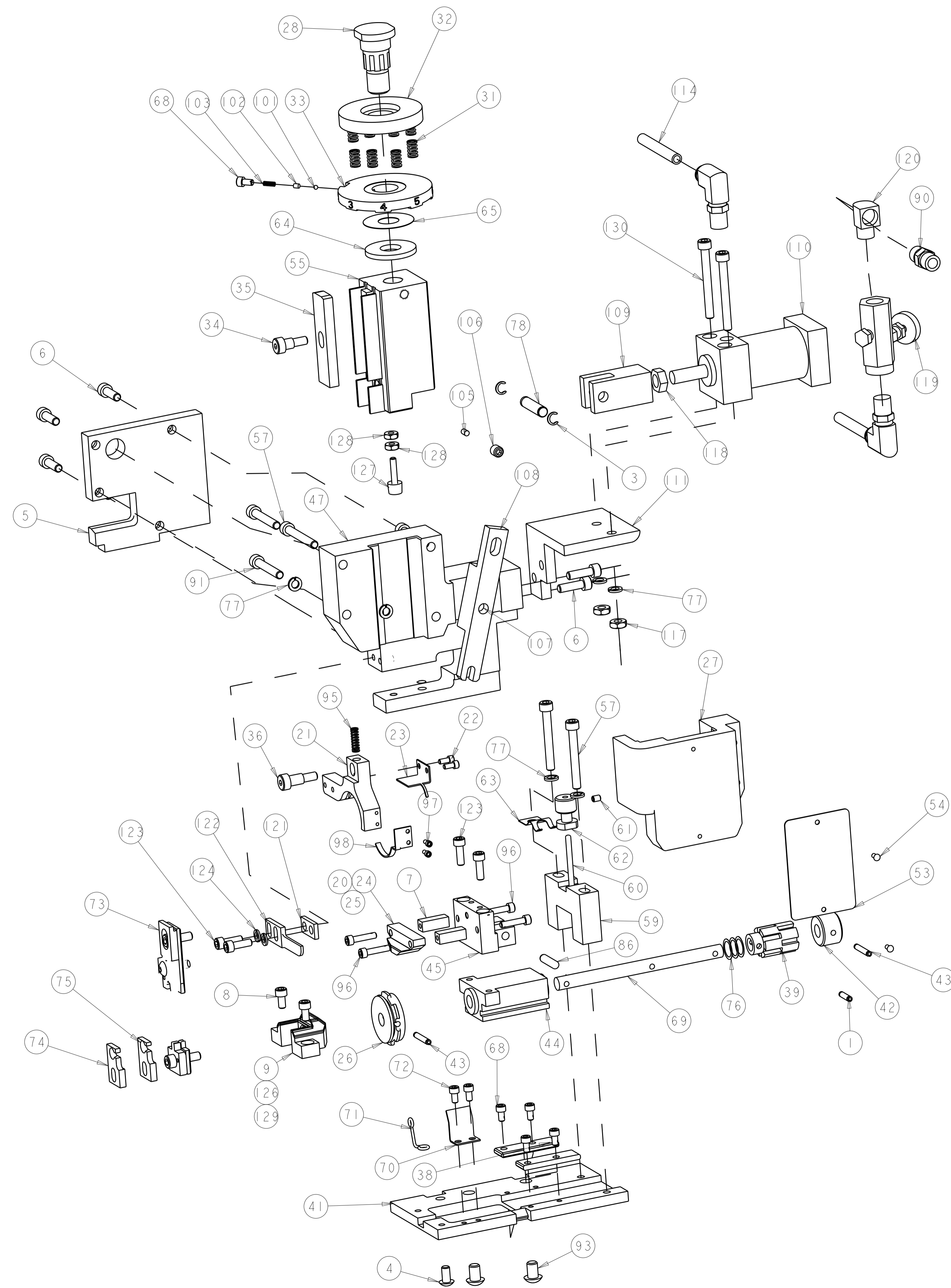
2	-	4-21000-2	SCR, SKT HD CAP 10-32 X 1.750	130
REF	-	318318-3	TOOL HOLDER, LOWER	129
2	-	21018-5	NUT, HEX, REG 6-32	128
1	-	811242-2	BUMPER, HOLD DOWN	127
REF	-	318318-2	TOOL HOLDER, LOWER	126
2	-	21024-4	WASHER, SPRG LOCK, REG NO 8	124
4	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	123
1	-	240639-3	STRIPPER (MACHINING)	122
1	-	1-690451-8	SPACER, STRIPPER	121
1	-	22306-1	ELBOW, STREET, 90° 1/8 NPT	120
1	-	23054-1	VALVE, FLOW CONTROL	119
1	-	22202-3	NUT, HEX, JAM 5/16-18UNC	118
2	-	21018-7	NUT, HEX, REG 10-32	117
28	IN	27319-4	TUBING, POLY-FLO, NATURAL	114
2	-	23238-1	INSERT, COUPLING	113
2	-	980285-2	CONNECTOR, ELBOW, 90°, MINI	112
1	-	257434-1	SUPPORT, AIR CYLINDER	111
1	-	28560-1	AIR CYLINDER DOUBLE ACTING	110
1	-	818317-1	CLEVIS	109
1	-	257435-1	ARM	108
1	-	2-21030-6	PIN, DOWEL .2500 X 1.500	107
1	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	106
1	-	690191-1	PLUG, NYLON	105
1	-	690170-1	SPRING, COMPRESSION	103
1	-	690603-1	SPRING ASSIST AMP-O-MATOR APPLICATOR	102
1	-	23241-6	BALL, STEEL	101
1	-	459647-1	GUIDE, TAPE	98
2	-	21000-9	SCR, SKT HD CAP 2-56 X .188	97
4	-	23030-4	SCR, SKT HD CAP, S-LOCK, 6-32 X .625	96
1	-	3-22279-2	SPRING, COMPRESSION	95
2	-	3-21002-2	SCR, BTN SKT HD CAP 1/4-20 X .375	93
3	-	4-21000-0	SCR, SKT HD CAP 10-32 X 1.250	91
1	-	22304-1	NIPPLE, HEX, PIPE FITTING	90

LOC	DIST	REV	DATE	BY	APPV
A	66				

ITEM NO	QTY	DESCRIPTION	DATE	BY	APPV
1	-	1-21030-3	PIN, DOWEL .1875 X .750		86
1	-	4-23620-3	PIN, RETAIN, GRVD, 1/4 X 1.050		78
8	-	21024-5	WASHER, SPRG LOCK, REG NO 10		77
3	-	1-24954-2	SPACER, SHIM		76
REF	-	815459-2	FUNNEL, WIRE		75
REF	-	815459-1	FUNNEL, WIRE		74
1	-	SEE CHART	DIE, ASSEMBLY		73
2	-	1-21000-8	SCR, SKT HD CAP 6-32 X .250		72
1	-	459648-1	SPRING, TERM. EJECT		71
1	-	459645-1	PLATE, TERMINAL EJECT		70
1	-	459650-1	SHAFT		69
5	-	23030-1	SCR, SKT HD CAP, S-LOCK, 6-32 X .25		68
1	-	690125-1	SHIM SUB-ASSY		65
1	-	690124-1	WASHER, RAM (.115)		64
1	-	459667-1	SPRING		63
1	-	459658-1	KNOB, TERMINAL, FEED		62
1	-	2-21006-8	SCR, SET, CUP POINT 6-32 X .188		61
1	-	21030-8	PIN, DOWEL .1250 X 1.500		60
1	-	459657-1	BLOCK, PIN, MOUNTING		59
3	-	4-21000-1	SCR, SKT HD CAP 10-32 X 1.500		57
1	-	459672-1	RAM		55
2	-	21017-2	SCREW, DRIVE		54
1	-	461264-1	PLATE, IDENTIFICATION		53
1	-	459674-1	HOUSING APPLICATOR		47
1	-	459649-1	BLOCK, PIVOT MOUNT		45
1	-	459646-1	BLOCK, SLIDE		44
2	-	5-21028-5	PIN, SLOTTED SPRING .125 X .750		43
1	-	459651-1	KNOB, HAND		42
1	-	459670-1	BASE PLATE, APPLICATOR (CLOSED BARREL MINI-APPLICATOR)		41
1	-	459652-1	CAM, BARREL		39
2	-	459656-1	GIB		38
1	-	21004-1	SCR, SKT HD SHLDR 1/4 DIA X .375		36
1	-	459662-1	SLIDE, INSULATION CRIMPER		35
1	-	5-21004-7	SCR, SKT HD SHLDR 1/4 DIA X .250		34
1	-	690142-1	DISC, INSULATION		33
1	-	459663-1	DISC, WIRE CRIMP		32
8	-	2-22280-5	SPRING, COMPRESSION		31
1	-	690212-1	POST, RAM		28
1	-	459666-1	CAP, RAM		27
1	-	459668-1	WHEEL, TAPE FEED		26
1	-	459655-1	STOP, TERMINAL		25
1	-	459655-2	STOP, TERMINAL		24
1	-	459644-1	STRIPPER, TAPE		23
2	-	1-21000-3	SCR, SKT HD CAP 4-40 X .250		22
1	-	459671-1	RETAINER, TAPE CLOSED BARREL MINI-APPLICATOR		21
REF	-	459655-3	STOP, TERMINAL		20
1	-	318318-1	TOOL HOLDER, LOWER		9
2	-	7-21000-4	SCR, SKT HD CAP 8-32 X .312		8
2	-	459654-1	SPACER		7
6	-	3-21000-6	SCR, SKT HD CAP 10-32 X .625		6
1	-	459659-1	PLATE, SUPPORT		5
1	-	2-21002-6	SCR, BTN SKT HD CAP 10-32 X .375		4
2	-	21045-6	RING, RETAIN, EXTERN, 1/4 CRESCENT		3
1	-	5-21028-1	PIN, SLOTTED SPRING .125 X .500		1
-1	U/M	PART NO	DESCRIPTION		ITEM NO

DIMENSIONS: IN 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±. FINISH		DATE: 23FEB2007 CHK: T. ELBIN APVD: T. ELBIN PRODUCT SPEC: APPLICATION SPEC: 114-2157 WEIGHT: A100779 Customer Drawing	DATE: 23FEB2007 NAME: T. ELBIN SIZE: A SCALE: 7:60 SHEET: 1 OF 2 REV: AS2	TE Connectivity Harrisburg, PA 17105-3608	CLOSED BARREL MINI APPLICATOR CLOSED BARREL
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LOC	DIST	REVISIONS				
A	66	P. LTH	DESCRIPTION	DATE	OWN	APVD
-	-	SEE SHEET 1				



APPLICATORS SET UPS						
PRODUCT TYPE	DIE SET NO	DIE MARK	TERMINAL STOP	ACCESSORIES	REMARKS	
RING SPADES AND PIDG BUTT SPLICE PIDG PLASTI-GRIP	26-22 YELLOW	69877	YELLOW	459655-1 (SUPPLIED W/687658-1) **459655-3	FUNNELS 815459-1(22-18) 815459-2(16-14)	
	24-20 WHITE	69878	WHITE			
	22-16 RED	59826-1*/69872	RED			
	16-14 BLUE	59827-1*/69873	BLUE			
	12-10 YELLOW	59828-1*/69874	YELLOW			
FASTON PIDG	26-24 YELLOW	69877-2	YELLOW	459655-2 (SUPPLIED W/687658-1)	FUNNELS 815459-1(22-18) 815459-2(16-14)	
	22-18 CLEAR	90248-2				
	22-18 RED	59826-1*	RED			
	16-14 BLUE	59827-1*	BLUE			
	14-12 GREEN	90240-2				
BUTT SPLICES PLASTI-GRIP	26-22 YELLOW	69877	YELLOW	459655-3	FUNNELS 815459-1(22-18) 815459-2(16-14)	
	24-20 WHITE	69878	WHITE			
	22-16 RED	69872	RED			
	16-14 BLUE	69873	BLUE			
LARGE EXPANSION PLASTI-GRIP AND PIDG	12-10 YELLOW	69874	YELLOW	459655-4	904438-1 GUIDE 904707-1 HOLDER	
	12-10 YELLOW	69897	BLACK/ YELLOW			
RING SPADES SOLISTRAND	22-18	68240-1		459655-1 (SUPPLIED W/687658-1)	FUNNELS 852426-3(22-18) 852426-1(16-14) 852426-2(12-10)	
	16-14	68241-1				
	12-10	68242-1				
RING SPADES BUDGET	22-18	68259-1		459655-1 (SUPPLIED W/687658-1)	FUNNELS 852426-3(22-18) 852426-1(16-14) 852426-2(12-10)	
	16-14	68094				
	12-10	68260-2				
.156 SERIES, SHUR PLUG, RECEPTACLE, FULLY INSULATED	16-14 BLUE	59827-2	BLUE	REMOVE TERMINAL STOP	690455-2 STRIPPER REMOVE 240639-1 AND REPLACE WITH 690455-2	

\* TETRI-CRIMP DIE CONFIGURATION.  
 \*\* REQUIRED FOR PIDG BUTT SPLICES ONLY.

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DIMENSIONS: IN	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	NAME: CLOSED BARREL MINI APPLICATOR CLOSED BARREL SIZE: CAGE CODE DRAWING NO A1100779C=687658	RESTRICTED TO: AS2
MATERIAL:	FINISH:	WEIGHT: 114-2157 Customer Drawing	SCALE: 7:10 SHEET 2 OF 2 REV AS2