

4

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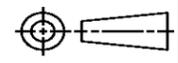
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LOC	DIST	REVISIONS			
P	LTR	DESCRIPTION	DATE	DWN	APVD
	B1	ECR-15-007000	06MAY2015	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2150539-2

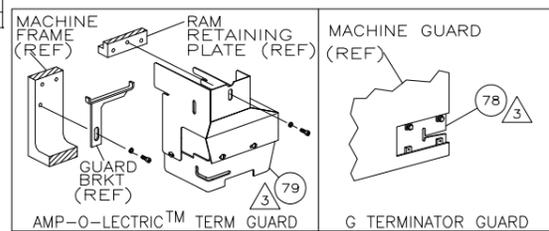
FOR REPLACEMENT PARTS FOR APPLICATOR 680652 REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED) WILL REMAIN AVAILABLE.

THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR 680652

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV		 TE Connectivity
DIMENSIONS:		CHK	RAGHAVENDRA		
		APVD	RAGHAVENDRA		NAME
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC			END FEED HDM APPLICATOR
MATERIAL	FINISH	APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO
		WEIGHT	A3		©- 680652
CUSTOMER DRAWING			SCALE	SHEET 1 OF 2	REV B1

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PART NUMBER	REV	FIRST USED
680652-1	B	122500-1
680652-2	B	565435-5



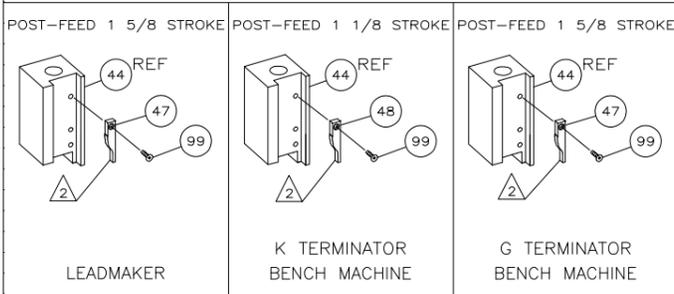
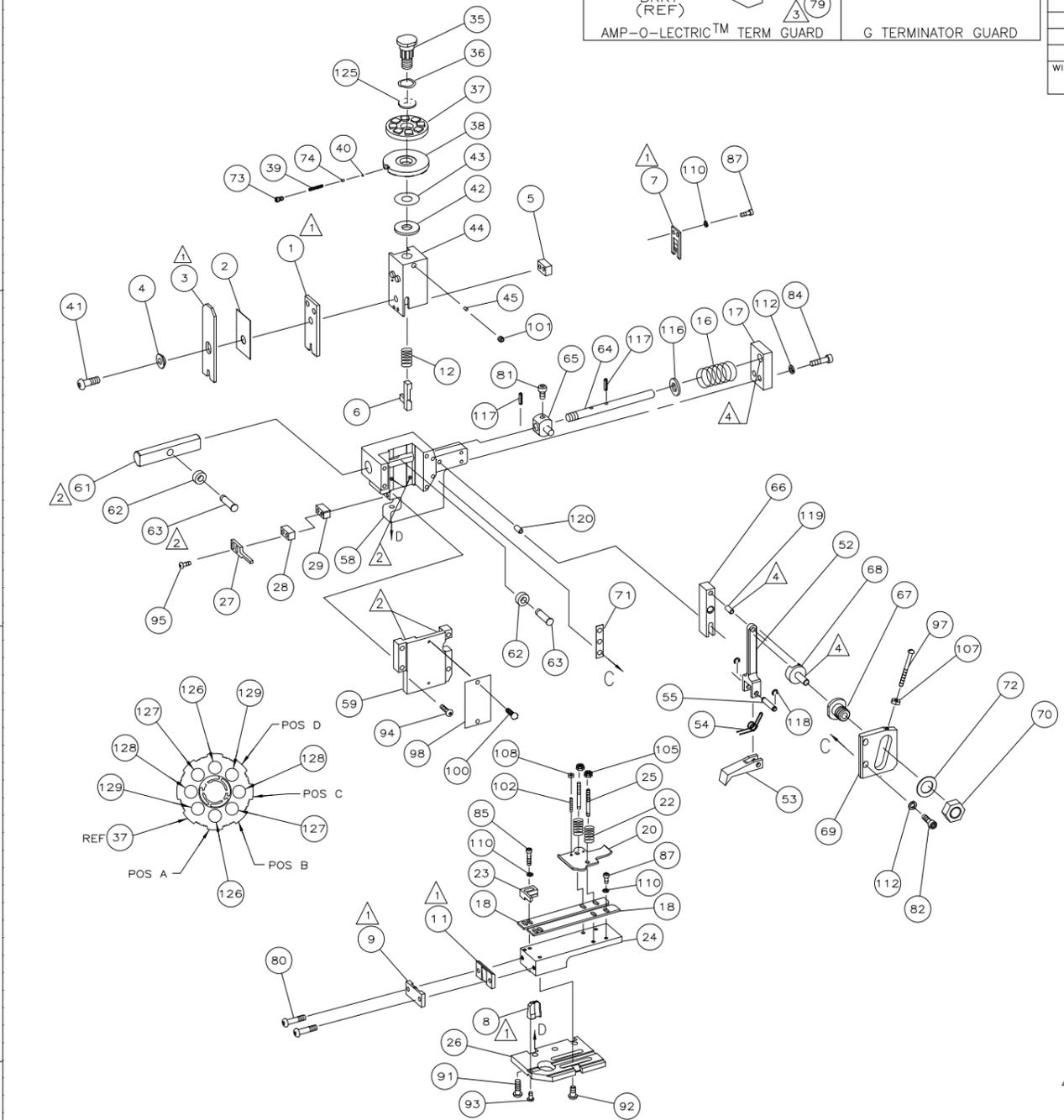
TERMINAL NAME: RECPT, POS-LOK, MARK III, .187

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.063 ±.002 [1.60 ±0.05mm]	14
B	.060 ±.002 [1.52 ±0.05mm]	(2)18
C	.056 ±.002 [1.42 ±0.05mm]	16
D	.051 ±.002 [1.30 ±0.05mm]	18
CRIMP SIZE	TYPE	RANGE
WIRE .120 [3.05mm]	F	18-14
INSUL .220 [5.59mm]	F	Ø.150-.200 or (2)Ø.110 MAX

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.172-.203	114-2074	.730	408-8039	458638-1	L2087

LOC	DIST	REVISIONS	DATE	OWN	APPD
A	66				
B		ECR-07-007380	3-2007	MY	GB

REV	DESCRIPTION
-1	LEADMAKER & MECH POST FEED
-2	BENCH MODEL G MECH POST FEED



- 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 32.
- 6 ITEM 78 USED WITH G TERMINATOR ONLY.

QTY	REF	DESCRIPTION	ITEM NO
2	2	3-354779-2 PIN, WIRE DISC (.3150)D	129
2	2	2-354779-2 PIN, WIRE DISC (.3100)C	128
2	2	1-354779-4 PIN, WIRE DISC (.3060)B	127
2	2	354779-4 PIN, WIRE DISC (.3010)A	126
1	1	986950-1 WASHER, FLAT PRECISION	125
1	1	217238-1 GENERAL INSTRUCTION PACKAGE	124
1	1	4088039 EF APPL INST 408-8039	123
			122
			121
REF	REF	1-21030-7 PIN,DOWEL(Ø.187x1.50)HSG	120
REF	REF	1-21030-1 PIN,DOWEL(Ø.187x.50)LEVER	119
REF	REF	21045-3 RING,RET"C"(Ø.187)FD PIN	118
REF	REF	5-21028-1 PIN,STD SPRING(Ø.12)FD ADJ ROD	117
REF	REF	21899-4 WASHER,FLAT(Ø5/16)SCR ADJ	116
			115
			114
			113
REF	REF	21024-5 WASHER,LOCK(NO.10)FD ROD GDE	112
			111
7	7	21024-4 WASHER,LOCK(NO.8)SHEAR BL	110
			109
2	2	21018-4 NUT,HEX(4-40)DRAG	108
REF	REF	21018-5 NUT,HEX(6-32)FD ADJ PL	107
			106
2	2	21022-2 NUT,HEX SL(8-32)DRAG STUD	105
			104
			103
2	2	2-21006-6 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)ID PLATE	100
1	1	1-21002-7 SCR,BHC(6-32x.38)CAM	99
1	1	461264-1 PLATE, IDENTIFICATION	98
REF	REF	6-23715-5 SCR,PAN HD(6-32x1.50)FEED ADJ	97
			96
2	2	2-21002-2 SCR,BHC(8-32x.50)STRIPPER	95
REF	REF	2-21002-9 SCR,BHC(10-32x.75)HSG CAP	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
REF	REF	2-22733-8 SCR,BHC(1/4-20x.62)BASE PL	91
			90
			89
			88
5	5	2-21000-6 SCR,SHC(8-32x.38)SLUG BLADE	87
			86
2	2	2-21000-9 SCR,SHC(8-32x.75)R STP GUIDE	85
REF	REF	3-21000-7 SCR,SHC(10-32x.75)FEED ROD GDE	84
			83
REF	REF	3-21000-6 SCR,SHC(10-32x.62)FEED ADJ PL	82
REF	REF	3-21000-4 SCR,SHC(10-32x.38)PIVOT BLOCK	81
2	2	3-21002-0 SCR,BHC(10-32x.88)SHEAR PL	80
REF	REF	455745-1 GUARD, WINDOW	79
REF	REF	679532-1 INSERT, GUARD	78
			77
			76
			75
1	1	690603-1 SPRING, ASSIST	74
1	1	23030-1 SCR,SKT CAP(6-32x.25)CP DSC	73
REF	REF	458109-1 WASHER, FLAT (SPECIAL)	72
REF	REF	690517-1 SPACER	71

REF	REF	DESCRIPTION	QTY
REF	REF	22594-8 NUT, HEX	70
REF	REF	240628-1 PLATE, ADJ	69
REF	REF	240626-1 SHAFT, PIVOT	68
REF	REF	240633-1 BUSHING	67
REF	REF	455680-1 LEVER, INTERMEDIATE	66
REF	REF	240629-1 BLOCK, PIVOT	65
REF	REF	240632-2 SCR, ADJ	64
REF	REF	240659-3 PIN, CAM ROLLER	63
REF	REF	240658-1 CAM, ROLLER	62
REF	REF	454398-1 ROD, FEED	61
			60
REF	REF	454220-1 CAP, RAM	59
REF	REF	453736-1 HOUSING	58
			57
			56
REF	REF	240624-1 PIN, FEED FINGER	55
REF	REF	691499-1 SPRING, FEED FINGER	54
REF	REF	240635-1 FINGER, FEED	53
REF	REF	240634-1 LEVER, TERMINAL	52
			51
			50
			49
1	-	690501-3 CAM, POST FEED 1 1/8 ST	48
-	1	690501-4 CAM, POST-FEED 1 5/8 ST	47
			46
1	1	690191-1 PLUG, NYLON	45
1	1	455674-1 RAM	44
1	1	690125-1 WASHER, LAMINATED	43
1	1	690124-1 WASHER, RAM	42
1	1	7-21002-9 BOLT, CRIMPER(5/16-24x1.00)	41
1	1	23241-6 BALL, STEEL	40
1	1	690170-1 SPRING, COMPRESSION	39
1	1	690142-1 DISC, INSULATION	38
1	1	354777-1 WIRE DISC, PLASTIC	37
1	1	22480-5 WASHER, SPRING	36
1	1	690212-1 POST, RAM	35
			34
			33
1	1	458980-1 APPLICATOR, BASIC (SUB ASSY)	32
			31
			30
1	1	1-690451-4 SPACER, STRIPPER	29
1	1	3-690451-2 SPACER, STRIPPER	28
1	1	240639-2 STRIPPER	27
REF	REF	455676-1 PLATE, BASE	26
2	2	22354-8 DRAG, STUD	25
1	1	455678-1 PLATE, STRIP GUIDE	24
1	1	240825-3 PLATE, STRIP HOLD DOWN	23
2	2	4-22281-1 SPRING, DRAG	22
			21
1	1	454177-1 DRAG, STOCK	20
			19
2	2	454204-3 GUIDE, STRIP (FRONT)	18
REF	REF	454178-1 GUIDE, FEED ROD	17
REF	REF	4-22284-9 SPRING, FEED RETURN	16
			15
			14
			13
1	1	23846-1 SPRING, HOLD DOWN	12
1	1	240644-1 PLATE, REAR SHEAR	11
			10
1	1	690482-6 PLATE, FRONT SHEAR	9
1	1	6-461295-9 ANVIL	8
1	1	690474-6 BLADE, SLUG	7
1	1	1-455892-0 HOLD DOWN, TERMINAL	6
1	1	240641-6 SPACER, SLUG BLADE	5
1	1	238009-1 SPACER, BLOCK CRIMPER	4
1	1	1-683453-3 CRIMPER, INSULATION	3
1	1	455888-4 SPACER, CRIMPER	2
1	1	1-456409-0 CRIMPER, WIRE	1