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LOC

DIST


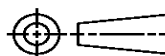
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD

REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER

FOR REPLACEMENT PARTS FOR APPLICATOR 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

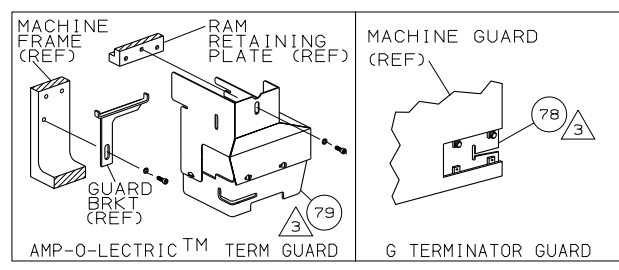
THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	 TE Connectivity			
DIMENSIONS:		CHK				
		APVD	NAME			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	APPLICATION SPEC			
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		WEIGHT	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
MATERIAL	FINISH		A3		C-	
		SCALE	SHEET	OF	REV	

DRAWING MADE IN THIRD ANGLE PROJECTION

680027 680027

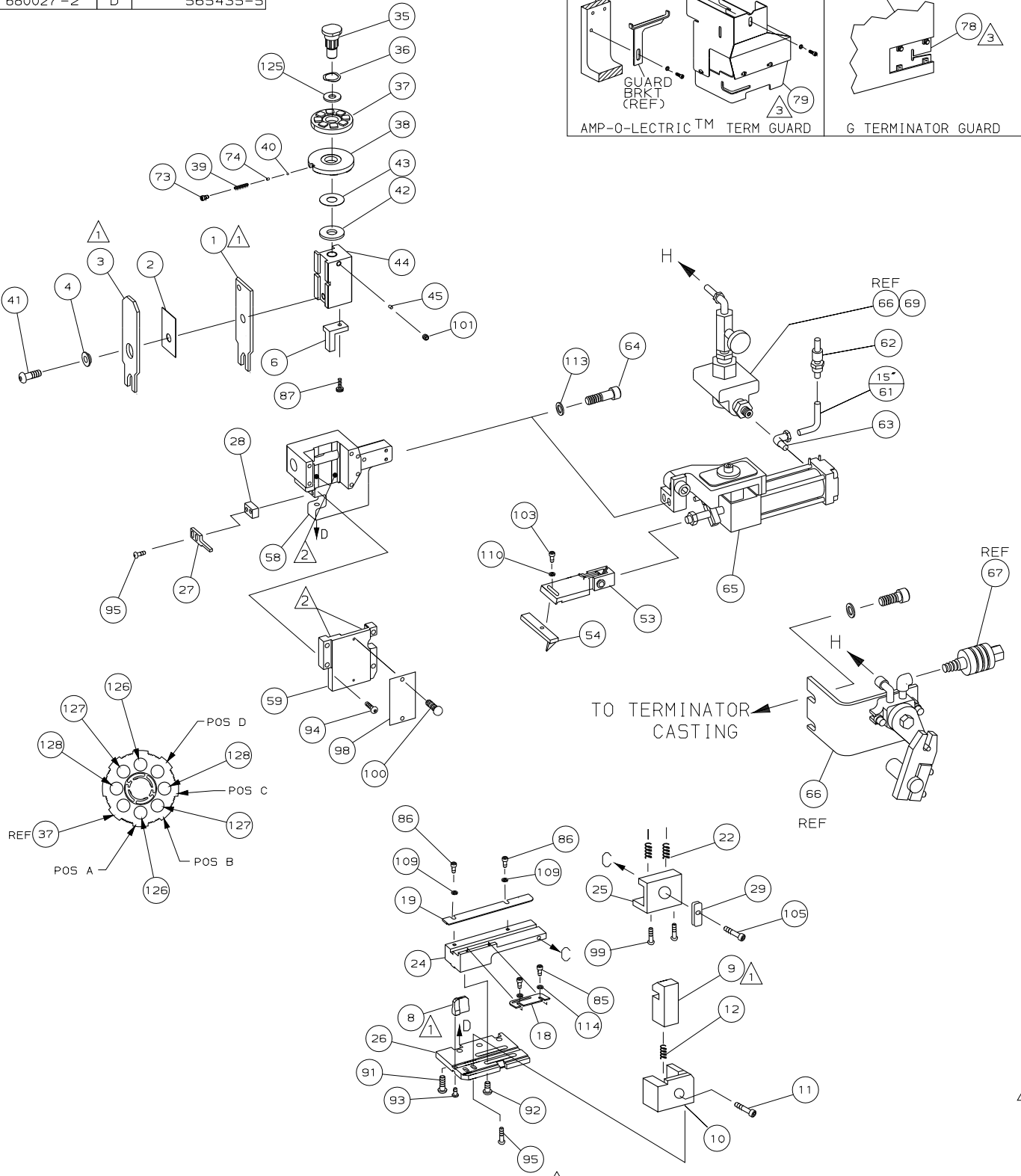
/home/us016926/DMTECmod

PART NUMBER	REV	FIRST USED
680027-1	D	854400-1
680027-2	D	565435-5



TERMINAL NAME: 2.5mm FLAG CONTACT, SOCKET					
927812	CRIMPING DATA				
927814					
PAD LTR	CRIMP HEIGHT	WIRE SIZE			
A	.071 ±.002 [1.8 ±0.05mm]	2.5mm ²			
B	.067 ±.002 [1.7 ±0.05mm]	2mm ²			
C	.062 ±.002 [1.57 ±0.05mm]	1.5mm ²			
D	.059 ±.002 [1.5 ±0.05mm]	1.25mm ²			
CRIMP	SIZE	TYPE	RANGE		
WIRE	.110 [2.79mm]	F	1.25 - 2.5mm ²		
INSUL	.140 [3.56mm]	F	1.8 - 2.9mm		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.197-.227	114-18031	.788	408-8039	458638-1	L1527

-1	LEADMAKER & BENCH MODEL G	AIRFEED
-2	BENCH MODEL K	AIRFEED



QTY	RECD	PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	2	-	C		354779-4	PIN, WIRE DISC (.3010)D	129
2	2	-	C		9-354778-7	PIN, WIRE DISC (.2980)C	128
2	2	-	C		8-354778-7	PIN, WIRE DISC (.2930)B	127
2	2	-	C		7-354778-9	PIN, WIRE DISC (.2890)A	126
1	1	-	A		986950-1	WASHER, FLAT PRECISION	125
							124
							123
							122
							121
							120
							119
							118
							117
							116
							115
2	2	-	A		21024-2	WASHER, LOCK (NO. 4) ST GU PL	114
2	2	-	A		21024-5	WASHER, LOCK (NO. 10) SHEAR PL	113
							112
							111
1	1	-	A		21024-4	WASHER, LOCK (NO. 8) FEED	110
2	2	-	A		21024-3	WASHER, LOCK (NO. 6) ST GU PL	109
							108
							107
							106
1	1	-	A		22353-8	SCR, SHLD (#.187X.25) DRAG LEVER	105
							104
1	1	-	A		2-21000-6	SCR, SHC (8-32X.38) FEED HOLDER	103
2	2	-	A		2-21006-6	SCR, SKT SET (4-40X.62) DRAG	102
1	1	-	A		21009-2	SCR, SKT SET (1/4-20X.25) RAM	101
2	2	-	A		21017-2	SCR, DRIVE (#2X.19) ID PLATE	100
2	2	-	A		3-21002-0	SCR, BHC (10-32X.88) DRAG	99
1	1	-	B		461264-1	PLATE, IDENTIFICATION	98
							97
							96
4	4	-	A		2-21002-2	SCR, BHC (8-32X.50) STRIPPER	95
4	4	-	A		2-21002-9	SCR, BHC (10-32X.75) CAP	94
1	1	-	A		22733-8	SCR, BHC (8-32X.38 LW) ANVIL	93
4	4	-	A		3-21002-3	SCR, BHC (1/4-20X.50) ST GD PL	92
3	3	-	A		2-22733-8	SCR, BHC (1/4-20X.62) HSG	91
							90
							89
							88
1	1	-	A		2-21000-7	SCR, SHC (8-32X.50) SHEAR DEP	87
2	2	-	A		2-21000-0	SCR, SHC (6-32X.50) STRIP GUIDE	86
2	2	-	A		1-21000-3	SCR, SHC (4-40X.25) F ST GU	85
							84
							83
							82
							81
2	2	-	A		3-21000-8	SCR, SKT CAP (10-32X.88) SH PL	80
1	-	-	A		455750-7	GUARD ASSY	79
-	REF	-	A		679532-1	INSERT, GUARD	78
							77
							76
							75
1	1	-	A		690603-1	SPRING, ASSIST	74
1	1	-	A		23030-1	SCR, SKT CAP (6-32X.25) CP DSC	73
							72
							71

QTY	RECD	PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
1	1	-	C		692655-5	AIR FEED VALVE ASSY	69
							68
REF	-	-	A		24042-2	VALVE, SHUT OFF	67
REF	-	-	C		692655-6	AIR FEED VALVE ASSY	66
1	1	-	B		460277-1	AIR FEED ASSY	65
2	2	-	A		3-21000-9	SCR, SHC 10-32x1.00 AIR ASSY	64
-	1	-	A		22294-6	ELBOW, TUBING 1/8NPT - 1/4 T	63
-	1	-	A		23238-1	QUICK DISCONNECT	62
12.00	12.00	IN	A		27319-4	TUBING, POLY-FLO Ø.25	61
							60
1	1	-	C		467284-1	CAP, RAM	59
1	1	-	D		683742-1	HOUSING	58
							57
							56
							55
1	1	-	B		679904-1	PAWL, FEED	54
1	1	-	B		461062-1	HOLDER, FEED FINGER	53
							52
							51
							50
							49
							48
							47
							46
1	1	-	A		690191-1	PLUG, NYLON	45
1	1	-	C		683741-2	RAM	44
1	1	-	A		690125-1	WASHER, LAMINATED	43
1	1	-	A		690124-1	WASHER, RAM	42
1	1	-	A		7-21002-9	BOLT, CRIMPER (5/16-24x1.00)	41
1	1	-	A		23241-6	BALL, STEEL	40
1	1	-	A		690170-1	SPRING, COMPRESSION	39
1	1	-	C		690142-1	DISC, INSULATION	38
1	1	-	D		354777-1	WIRE DISC, PLASTIC	37
1	1	-	A		22480-5	WASHER, SPRING	36
1	1	-	B		690212-1	POST, RAM	35
							34
							33
							32
							31
							30
1	1	-	B		240793-1	LEVER, DRAG RELEASE	29
1	1	-	B		3-690451-2	SPACER, STRIPPER	28
1	1	-	A		468281-2	STRIPPER	27
1	1	-	D		679850-1	PLATE, BASE	26
1	1	-	B		240792-1	DRAG, TERMINAL	25
1	1	-	B		679868-1	PLATE, STRIP GUIDE	24
							23
2	2	-	A		1-22284-0	SPRING, DRAG	22
							21
							20
1	1	-	B		679768-1	GUIDE, STRIP (REAR)	19
1	1	-	C		690438-2	GUIDE, STRIP (FRONT)	18
							17
							16
							15
							14
							13
1	1	-	A		5-22280-0	SPRING, SHEAR	12
1	1	-	A		1-690461-3	STOP, SHEAR	11
1	1	-	B		679829-1	HOLDER, SHEAR	10
1	1	-	C		679835-1	SHEAR, FLOATING	9
1	1	-	D		679887-2	ANVIL	8
							7
1	1	-	B		467499-3	DEPRESSOR, SHEAR	6
							5
1	1	-	B		1-238009-2	SPACER, BLOCK CRIMPER	4
1	1	-	C		5-683453-1	CRIMPER, INSULATION	3
1	1	-	B		1-455888-5	SPACER, CRIMPER	2
1	1	-	C		456408-6	CRIMPER, WIRE	1

- 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 REQUIRED FOR BENCH G TERMINATOR ONLY.

QTY	RECD	PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
PARTS LIST							

QTY	RECD	PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
PARTS LIST							

LOC A
DIST 66

D1	ECR-06-019743	GB	8-06
D	0150-8054-97	TB	10-97
C	ECN 0150-5946-95	CE	2-95
B	ECN 0150-5564-94	PM	10-94
A	ECN 0150-5041-93	PM	1-94

AMP Incorporated
Harrisburg, PA 17105-3608

NAME: END FEED HDM APPLICATOR MINI APPL

SCALE: 1:1

DWG NO: 680027

SHEET 1 of 1

REV D1

CUSTOMER AND ASSEMBLY DRAWING