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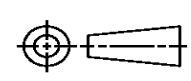
LOC	DIST	REVISIONS			
P	LTR	DESCRIPTION	DATE	DWN	APVD
	G1	ECR-14-018880	17DEC2014	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2150189-2

FOR REPLACEMENT PARTS FOR APPLICATOR 680052 REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED) WILL REMAIN AVAILABLE.

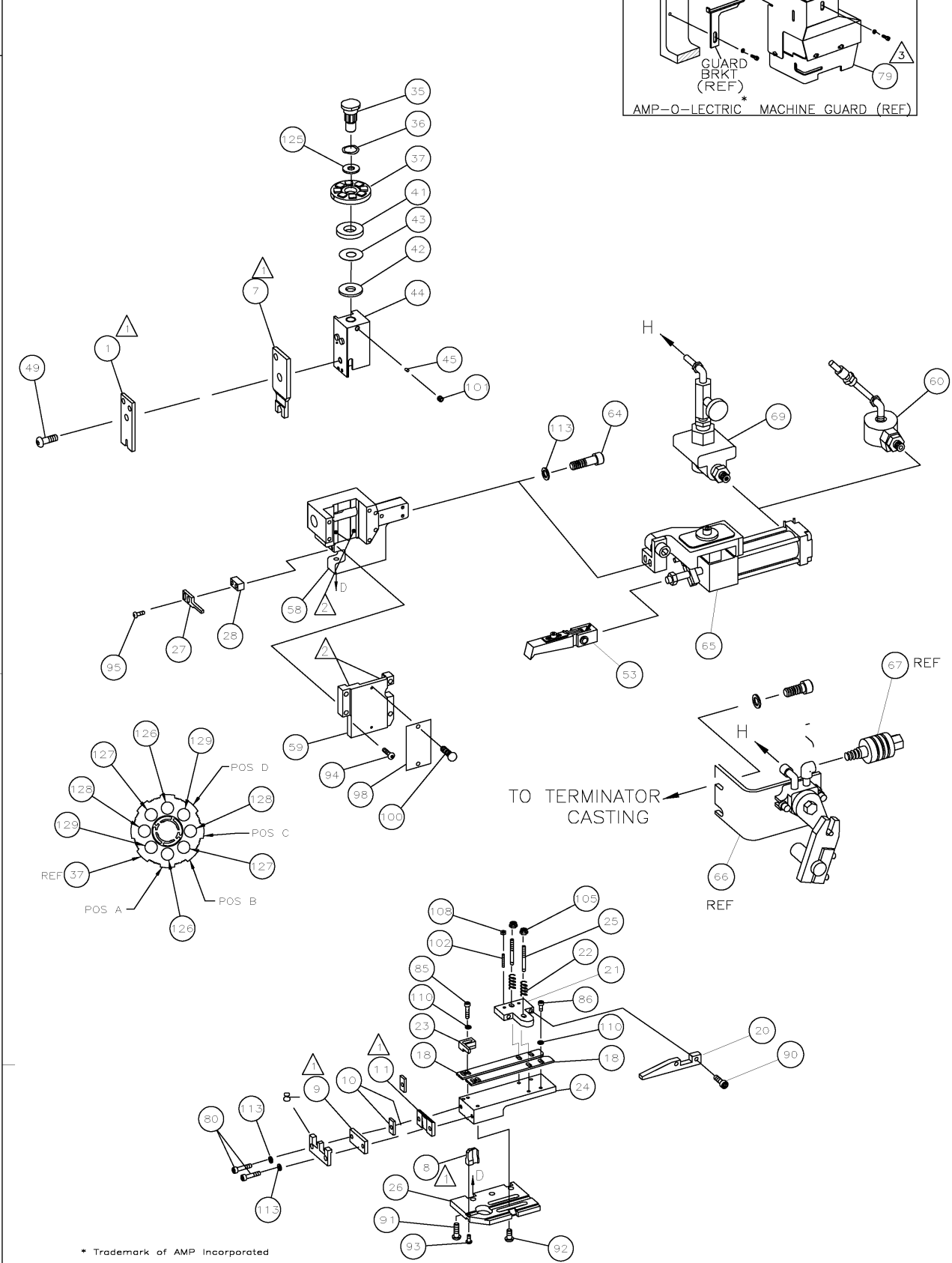
THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR 680052

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV														
DIMENSIONS:		CHK	RAGHAVENDRA														
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	RAGHAVENDRA														
<table border="0"> <tr><td>0 PLC</td><td>±</td></tr> <tr><td>1 PLC</td><td>±</td></tr> <tr><td>2 PLC</td><td>±</td></tr> <tr><td>3 PLC</td><td>±</td></tr> <tr><td>4 PLC</td><td>±</td></tr> <tr><td>ANGLES</td><td>±</td></tr> </table>		0 PLC	±	1 PLC	±	2 PLC	±	3 PLC	±	4 PLC	±	ANGLES	±	NAME	END FEED HDM APPLICATOR		
0 PLC	±																
1 PLC	±																
2 PLC	±																
3 PLC	±																
4 PLC	±																
ANGLES	±																
MATERIAL		PRODUCT SPEC															
FINISH		APPLICATION SPEC															
		WEIGHT	SIZE	CAGE CODE	DRAWING NO												
			A3		©- 680052												
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	SHEET 1 OF 2 REV G1												



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PART NUMBER	REV	FIRST USED
680052 -1	G	854400-1
680052 -2	G	565435-5



* Trademark of AMP Incorporated

- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-O-LECTRIC MACHINE. SEE DRAWING FOR COMPONENTS

TERMINAL NAME: CIRCULAR WIRE PIN		CRIMPING DATA			
	925856	PAD LTR	CRIMP HEIGHT	WIRE SIZE	
		A	.085 ±002	2.5mm ²	
		B	.081 ±002	14 AWG	
		C	.078 ±002	2.0mm ²	
		D	.071 ±002	1.5mm ² 16 AWG	
		CRIMP	SIZE	TYPE	RANGE
		WIRE	.080	0	1.5 - 2.5 mm ²
		INSUL	-	-	-
		FEED	.345	APPL INST	408-8039
				SET UP GAGE	458638-1
				LAYOUT	L1535
TERM APPL SPEC	114-2088	WIRE STRIP LENGTH	.322-.362		

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

2	2	-	1-354779-2	PIN, WIRE DISC (.3050)D	129
2	2	-	354779-2	PIN, WIRE DISC (.3000)C	128
2	2	-	9-354778-3	PIN, WIRE DISC (.2960)B	127
2	2	-	8-354778-5	PIN, WIRE DISC (.2920)A	126
1	1	-	986950-1	WASHER, FLAT PRECISION	125
					124
					123
					122
					121
					120
					119
					118
					117
					116
					115
					114
4	4	-	21024-5	WASHER, LOCK(NO.10) SHEAR PL	113
					112
					111
7	7	-	21024-4	WASHER, LOCK(NO.8) SHEAR BL	110
					109
2	2	-	21018-4	NUT, HEX(4-40) DRAG	108
					107
					106
2	2	-	21022-2	NUT, HEX SL(8-32) DRAG STUD	105
					104
					103
2	2	-	4-21078-8	SKT SKT SET (4-40x.75) 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
					99
1	1	-	461264-1	PLATE, IDENTIFICATION	98
					97
					96
2	2	-	8-21002-9	SCR, BHC(8-32x1.00) STRIPPER	95
4	4	-	2-21002-9	SCR, BHC(10-32x.75) 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
3	3	-	2-22733-8	SCR, BHC(1/4-20x.62) HSG	91
2	2	-	1-21000-3	SCR, SHC(4-40x.25) DRAG	90
					89
					88
					87
					86
3	3	-	2-21000-5	SCR, SHC(8-32x.25) STRIP GUIDE	85
2	2	-	2-21000-9	SCR, SHC(8-32x.75) R STRIP GUIDE	84
					83
					82
					81
2	2	-	3-21000-9	SCR, SKT CAP(10-32x1.00) SH PL	80
1	-	-	455750-8	GUARD ASSY	79
					78
					77
					76
					75
					74
					73
					72
					71

QTY	REQD	PER ASSY	PARTS LIST
-2	-1	U/M	PART NO DESCRIPTION ITEM NO

QTY	REQD	PER ASSY	PARTS LIST	
1	-	-	692655-5 AIR FEED VALVE ASSY 69	
			68	
			67	
REF	-	-	24042-2 VALVE, SHUT OFF 66	
REF	-	-	692655-6 VALVE ASSY 66	
1	1	-	460277-1 AIR FEED ASSY 65	
2	2	-	3-21000-9 SCR, SHC(10-32x1.00) AIR FD ASSY 64	
			63	
			62	
			61	
-	1	-	692655-7 AIR FEED VALVE ASSY 60	
1	1	-	454220-1 CAP, RAM 59	
1	1	-	453736-1 HOUSING 58	
			57	
			56	
			55	
			54	
4	1	1	-	460680-2 FEED FINGER ASSY 53
				52
				51
				50
1	1	-	7-21002-9 BOLT, CRIMPER(5/16-24x1.00) 49	
				48
				47
				46
1	1	-	690191-1 PLUG, NYLON 45	
1	1	-	455674-9 RAM 44	
1	1	-	690125-1 WASHER, LAMINATED 43	
1	1	-	690124-1 WASHER, RAM 42	
1	1	-	690223-2 SPACER, INSULATION DISC 41	
				40
				39
				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
				32
				31
				30
				29
1	1	-	4-690451-5 SPACER, STRIPPER 28	
1	1	-	690455-1 STRIPPER 27	
1	1	-	455676-3 PLATE, BASE 26	
2	2	-	22354-8 DRAG, STUD 25	
1	1	-	455678-1 PLATE, STRIP GUIDE 24	
1	1	-	240825-9 PLATE, STRIP HOLD DOWN 23	
2	2	-	2-22281-3 SPRING, DRAG 22	
1	1	-	464451-1 ARM, STOCK DRAG 21	
1	1	-	464452-1 DRAG, STOCK 20	
				19
2	2	-	454204-2 GUIDE, STRIP (FRONT) 18	
				17
				16
				15
				14
				13
				12
1	1	1	-	240644-1 PLATE, REAR SHEAR 11
2	2	-	6-240645-5 SPACER, SHEAR PLATE 10	
1	1	-	690619-4 PLATE, FRONT SHEAR 9	
1	1	-	690618-8 ANVIL 8	
1	1	-	2-459722-2 BLADE, SLUG 7	
				6
				5
				4
				3
				2
1	1	1	-	3-459492-1 CRIMPER, WIRE 1

LOC A	DIST 66	3308-8 (3/11)	8	7	6	5	4	3
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APV	BA WOLFE	10/26/93	END FEED HDM APPLICATOR
CHK	C. ERISMAN	10/26/93	
OWN	JC BAKER	10/26/93	
MATERIAL	-	HEAT TREAT	-

DIMENSIONS: INCHES	TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLG ± .010	1 PLG ± .005
1 PLG ± .005	2 PLG ± .005
2 PLG ± .005	3 PLG ± .005
3 PLG ± .005	4 PLG ± .005
4 PLG ± .005	
ANGLES: -	
SURFACE TEXTURE: -	

G	ECR-12-006746	12APR2012	LZ	S.X
P	LTR	REVISION RECORD	DATE	DWN

SCALE	SHEET	OF	REV
-	A1	1	G

CUSTOMER ACCESSIBLE PRODUCTION DRAWING