

4

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2

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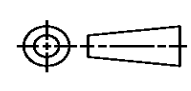
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LOC	DIST	REVISIONS			
P	LTR	DESCRIPTION	DATE	DWN	APVD
	C2	ECR-14-005483	15MAY2014	GK	HMR

# REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2150085-2

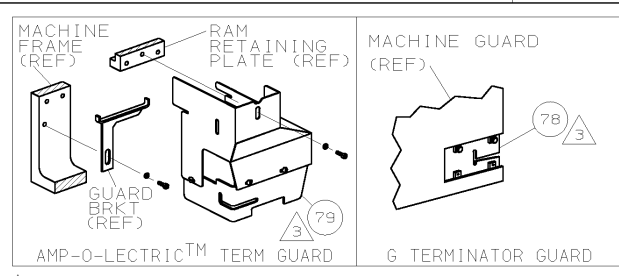
FOR REPLACEMENT PARTS FOR APPLICATOR 680278 REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED) WILL REMAIN AVAILABLE.

THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR 680278

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV		
DIMENSIONS:		CHK	RAGHAVENDRA		
		APVD	RAGHAVENDRA		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	NAME		
0 PLC	±	APPLICATION SPEC	END FEED HDM APPLICATOR		
1 PLC	±		SIZE	CAGE CODE	DRAWING NO
2 PLC	±		A3		©- 680278
3 PLC	±		RESTRICTED TO		
4 PLC	±				
ANGLES	±	WEIGHT			
MATERIAL	FINISH	CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	SHEET 1 OF 2
					REV C2

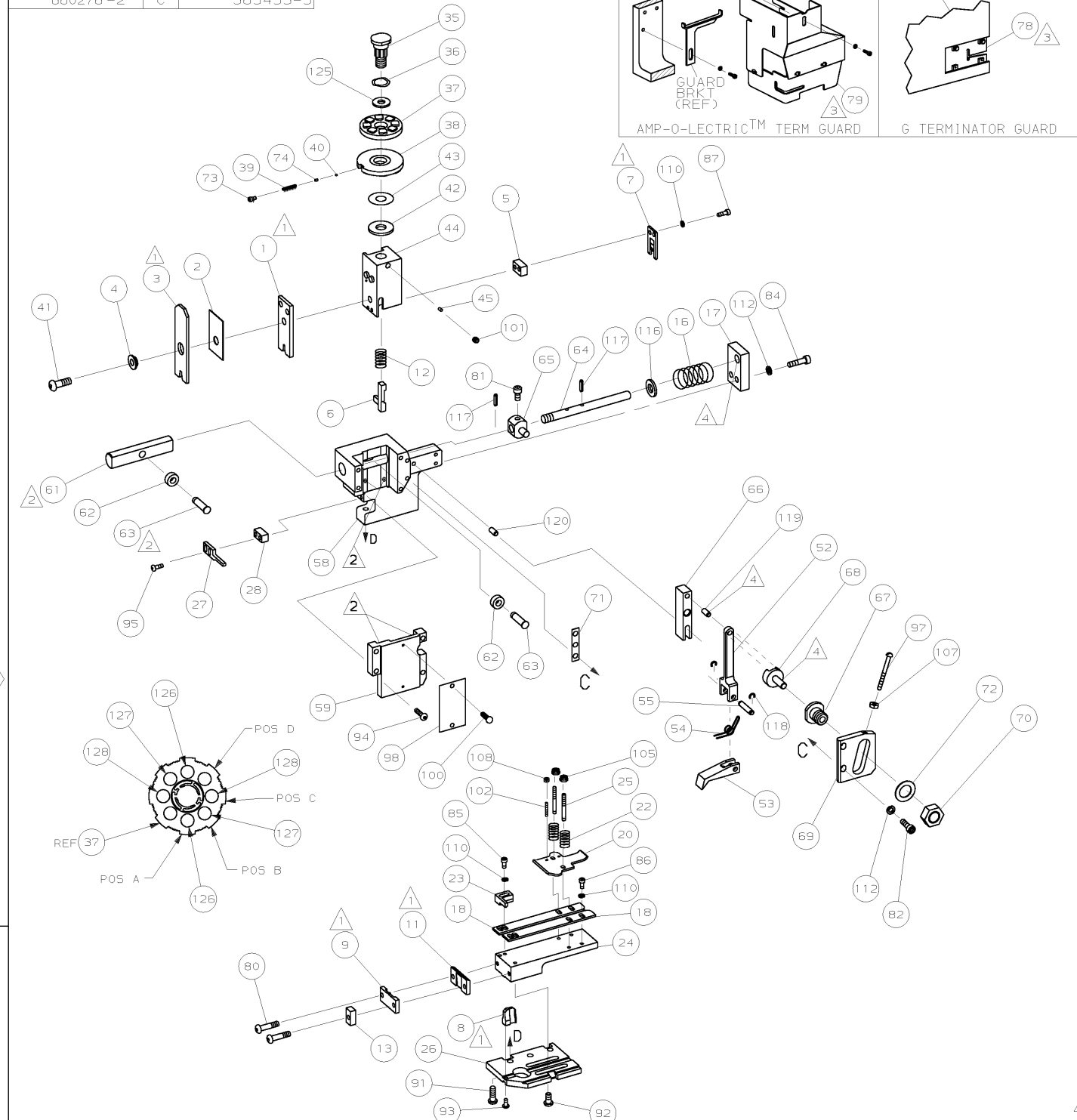


PART NUMBER	REV	FIRST USED
680278-1	C	122500-1
680278-2	C	565435-5

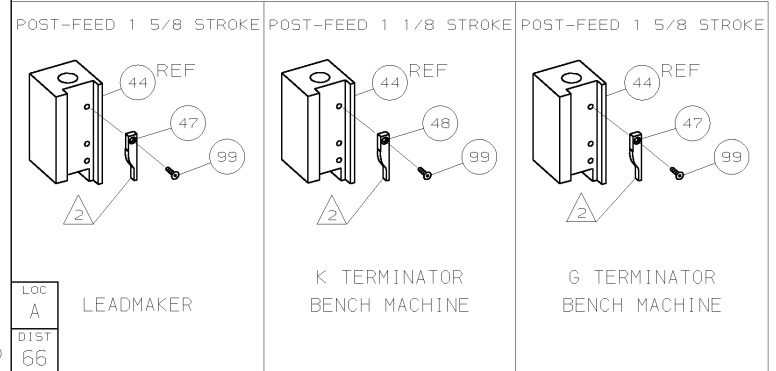


TERMINAL NAME: .110 POSITIVE LOCK CONTACT					
175411	CRIMPING DATA				
1746231					
PAD LTR	CRIMP HEIGHT				
A .040 ±.002 [1.02 ±0.05mm]	WIRE SIZE				
B .036 ±.002 [0.91 ±0.05mm]	20				
C .033 ±.002 [0.84 ±0.05mm]	22				
D NOT USED	24				
	USED				
CRIMP	SIZE	TYPE	RANGE		
WIRE .062 [1.57mm]	F	24-20			
INSUL .090 [2.29mm]	F	φ1.02mm-1.78mm			
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
-	114-5120	.774	408-8039	458638-1	L1746

LEADMAKER & BENCH MODEL G		MECH POST FEED		
REF	REF	MECH MODEL K	MECH POST FEED	
REF	REF	- A	22594-8 NUT, HEX 70	
REF	REF	- B	240628-1 PLATE, ADJ 69	
REF	REF	- B	240626-1 SHAFT, PIVOT 68	
REF	REF	- B	240633-1 BUSHING 67	
REF	REF	- A	455680-1 LEVER, INTERMEDIATE 66	
REF	REF	- B	240629-1 BLOCK, PIVOT 65	
REF	REF	- A	240632-2 SCR, ADJ 64	
REF	REF	- B	240659-3 PIN, CAM ROLLER 63	
REF	REF	- B	240658-1 CAM, ROLLER 62	
REF	REF	- B	454398-1 ROD, FEED 61	
REF	REF	- B		60
REF	REF	- C	454220-1 CAP, RAM 59	
REF	REF	- D	453736-1 HOUSING 58	
				57
				56
				55
REF	REF	- B	240624-1 PIN, FEED FINGER 55	
REF	REF	- B	691499-1 SPRING, FEED FINGER 54	
REF	REF	- B	240635-1 FINGER, FEED 53	
REF	REF	- B	240634-1 LEVER, TERMINAL 52	
				51
				50
				49
1	-	- B	690501-3 CAM, POST FEED 1 1/8 ST 48	
-	1	- B	690501-4 CAM, POST-FEED 1 5/8 ST 47	
				46
1	1	- A	690191-1 PLUG, NYLON 45	
1	1	- C	455674-1 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
1	1	- D	458980-1 APPLICATOR, BASIC (SUB ASSY) 32	
				31
				30
				29
1	1	- B	3-690451-2 SPACER, STRIPPER 28	
1	1	- A	240639-1 STRIPPER 27	
REF	REF	- C	455676-1 PLATE, BASE 26	
2	2	- A	22354-8 DRAG, STUD 25	
1	1	- B	455678-1 PLATE, STRIP GUIDE 24	
1	1	- C	240825-7 PLATE, STRIP HOLD DOWN 23	
2	2	- A	4-22281-1 SPRING, DRAG 22	
				21
1	1	- A	454177-1 DRAG, STOCK 20	
				19
2	2	- C	454204-6 GUIDE, STRIP (FRONT) 18	
REF	REF	- A	454178-1 GUIDE, FEED ROD 17	
REF	REF	- A	4-22284-9 SPRING, FEED RETURN 16	
				15
				14
1	1	- C	690481-2 SPACER, HOLD DOWN 13	
1	1	- A	23846-1 SPRING, HOLD DOWN 12	
1	1	- B	240644-1 PLATE, REAR SHEAR 11	
				10
1	1	- B	690482-5 PLATE, FRONT SHEAR 9	
1	1	- D	356038-3 ANVIL 8	
1	1	- B	1-690474-5 BLADE, SLUG 7	
1	1	- D	1-455892-9 HOLD DOWN, TERMINAL 6	
1	1	- C	240641-1 SPACER, SLUG BLADE 5	
1	1	- B	1-238009-2 SPACER, BLOCK CRIMPER 4	
1	1	- C	8-456134-8 CRIMPER, INSULATION 3	
1	1	- B	455888-9 SPACER, CRIMPER 2	
1	1	- C	3-456403-2 CRIMPER, WIRE 1	



QTY	RECD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
2	2	-	C	5-354779-6	PIN, WIRE DISC (.3270)C	129
2	2	-	C	5-354779-0	PIN, WIRE DISC (.3240)B	128
2	2	-	C	4-354779-2	PIN, WIRE DISC (.3200)A	126
1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	1	-	A	217238-1	DOCUMENTATION PACKAGE	124
1	1	-	-	4088039	EF APPL INST 408-8039	123
						122
						121
REF	REF	-	A	1-21030-7	PIN, DOWEL (φ.187x1.50)H5G	120
REF	REF	-	A	1-21030-1	PIN, DOWEL (φ.187x.50)LEVER	119
REF	REF	-	A	21045-3	RING, RET "C" (φ.187)FD PIN	118
REF	REF	-	A	5-21028-1	PIN, STD SPRING (φ.12)FD ADJ ROD	117
REF	REF	-	A	21899-4	WASHER, FLAT (φ5/16)SCR ADJ	116
						115
						114
						113
REF	REF	-	A	21024-5	WASHER, LOCK (NO.10)FD ROD GDE	112
						111
6	6	-	A	21024-4	WASHER, LOCK (NO.8)SHEAR BL	110
						109
2	2	-	A	21018-4	NUT, HEX (4-40)DRAG	108
REF	REF	-	A	21018-5	NUT, HEX (6-32)FD ADJ PL	107
						106
2	2	-	A	21022-2	NUT, HEX SL (8-32)DRAG STUD	105
						104
						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
1	1	-	A	1-21002-7	SCR, BHC (6-32x.38)CAM	99
1	1	-	B	461264-1	PLATE, IDENTIFICATION	98
REF	REF	-	A	6-23715-5	SCR, PAN HD (6-32x1.50)FEED ADJ	97
						96
2	2	-	A	2-21002-2	SCR, BHC (8-32x.50)STRIPPER	95
REF	REF	-	A	2-21002-9	SCR, BHC (10-32x.75)H5G 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
REF	REF	-	A	2-22733-8	SCR, BHC (1/4-20x.62)BASE PL	91
						90
						89
						88
2	2	-	A	2-21000-7	SCR, 5HC (8-32x.50)SLUG BLADE	87
3	3	-	A	2-21000-5	SCR, 5HC (8-32x.25)STRIP GUIDE	86
2	2	-	A	2-21000-8	SCR, 5HC (8-32x.62)HOLD DOWN	85
REF	REF	-	A	3-21000-7	SCR, 5HC (10-32x.75)FEED ROD GDE	84
						83
REF	REF	-	A	3-21000-6	SCR, 5HC (10-32x.62)FEED ADJ PL	82
REF	REF	-	A	3-21000-4	SCR, 5HC (10-32x.38)PIVOT BLOCK	81
2	2	-	A	3-21002-0	SCR, BHC (10-32x.88)SHEAR PL	80
REF	-	-	A	455745-1	GUARD, WINDOW	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 D5C	73
REF	REF	-	A	458109-1	WASHER, FLAT (SPECIAL)	72
REF	REF	-	A	690517-1	SPACER	71



- 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.

LOC	DESCRIPTION
A	LEADMAKER
K	K TERMINATOR BENCH MACHINE
G	G TERMINATOR BENCH MACHINE

QTY	RECD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
1	1	-	A	690603-1	SPRING, ASSIST	74
1	1	-	A	23030-1	SCR, SKT CAP (6-32x.25)CP D5C	73
REF	REF	-	A	458109-1	WASHER, FLAT (SPECIAL)	72
REF	REF	-	A	690517-1	SPACER	71

QTY	RECD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
1	1	-	A	690603-1	SPRING, ASSIST	74
1	1	-	A	23030-1	SCR, SKT CAP (6-32x.25)CP D5C	73
REF	REF	-	A	458109-1	WASHER, FLAT (SPECIAL)	72
REF	REF	-	A	690517-1	SPACER	71