

4

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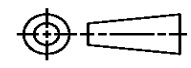
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LOC		DIST		REVISIONS			
P	LTR	DESCRIPTION		DATE	DWN	APVD	
	M1	ECR-14-002926		28FEB2014	GK	HMR	

REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2151123-1

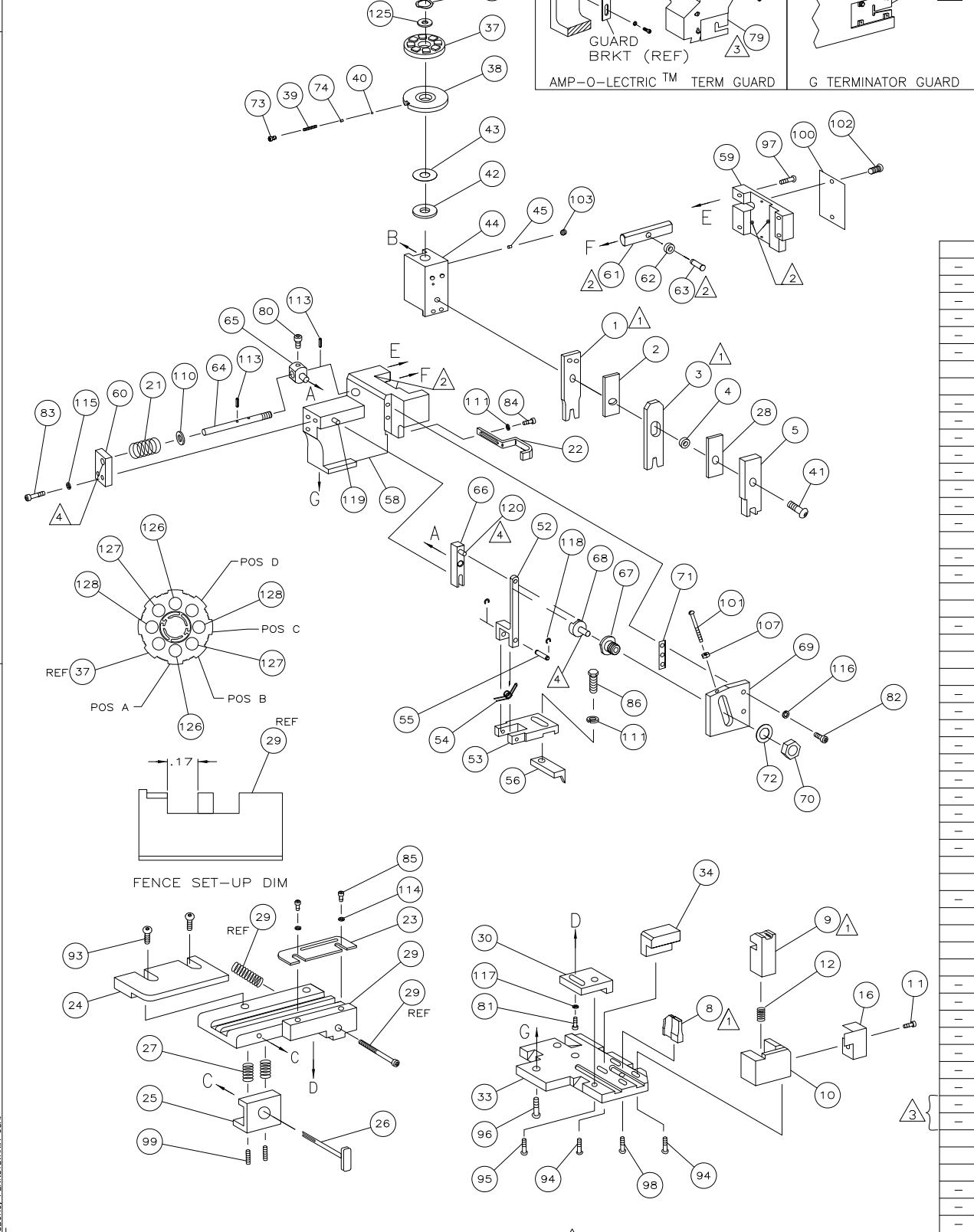
FOR REPLACEMENT PARTS FOR APPLICATOR 680422
REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED)
WILL REMAIN AVAILABLE.

THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE
SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR
680422

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV			TE Connectivity			
DIMENSIONS:		CHK	RAGHAVENDRA			NAME			
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	RAGHAVENDRA				
		0 PLC ±	1 PLC ±	PRODUCT SPEC		SIDE FEED HDM APPLICATOR			
MATERIAL		2 PLC ±	3 PLC ±	APPLICATION SPEC		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
FINISH		4 PLC ±	ANGLES ±	WEIGHT		A3		©- 680422	
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	SHEET 1 OF 2	REV M1	

THIS DRAWING IS A CONTROLLED DOCUMENT.

PART NUMBER	REV	FIRST USED
680422-1	M	122500-1
680422-2	M	565435-5
680422-3	M	354500-1
7-680422-7	M	354500-1

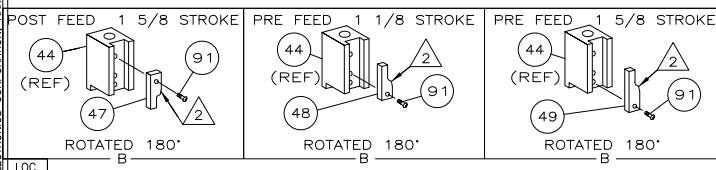


TERMINAL NAME: AMP-IN™ 2000		CRIMPING DATA	
	794121	PAD LTR	CRIMP HEIGHT
		A	.036 ±.003 [0.91 ±.08mm]
		B	.034 ±.003 [0.86 ±.08mm]
		C	.030 ±.003 [0.76 ±.08mm]
		D	NOT USED
		CRIMP	SIZE
		WIRE	.062 [1.57mm]
		INSUL	.130 [3.30mm]
		FEED	.420
		APPL INSTRUCTION	408-8040
		SET UP GAGE	458637-1
		LAYOUT	L1876

QTY REQD	PER ASSY	PART NO	DESCRIPTION	ITEM NO	
-	2	2	5-354779-5	PIN, WIRE DISC (.3265)C	129
-	2	2	4-354779-5	PIN, WIRE DISC (.3215)B	128
-	2	2	4-354779-1	PIN, WIRE DISC (.3195)A	126
-	1	1	986950-1	WASHER, FLAT PRECISION	125
-	1	1	217238-1	GENERAL INSTRUCTION PACKAGE	124
-	1	1	4088040	SF APPL INST 408-8040	123
-					122
-					121
-	REF	REF	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	120
-	REF	REF	1-21030-6	PIN,DOWEL(Ø.187x1.25)HOUSING	119
-	REF	REF	21045-3	RING,RET "C"(Ø.187)FD FING PIN	118
-	1	1	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
-	REF	REF	21024-5	WASHER,LOCK(#10)ADJ PLATE	116
-	REF	REF	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115
-	2	2	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
-	REF	REF	5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	113
-					112
-	2	2	21024-4	WASHER,LOCK(#8)STRIPPER	111
-	REF	REF	21899-4	WASHER,FLAT(Ø5/16)SCREW ADJ	110
-					109
-					108
-	REF	REF	21018-5	NUT,HEX(6-32)FEED ADJ	107
-					106
-					105
-					104
-	1	1	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
-	2	2	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
-	REF	REF	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
-	1	1	461264-1	PLATE, IDENTIFICATION	100
-	2	2	5-21006-6	SCR,SET(10-32x.75)DRAG	99
-	1	1	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
-	REF	REF	2-21002-9	SCR,BHC(10-32x.75)CAP	97
-	REF	REF	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
-	REF	REF	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
-	6	6	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
-					93
-					92
-	1	1	1-21002-7	SCR,BHC(6-32x.38)CAM	91
-					90
-					89
-					88
-					87
-	1	1	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
-	2	2	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	85
-	1	1	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
-	REF	REF	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
-	REF	REF	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	82
-	1	1	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
-	REF	REF	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	80
-	REF	REF	455749-1	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,SHC(6-32x.25 SL)INS DISC	73
-	REF	REF	458109-1	WASHER, SPECIAL	72
-	REF	REF	690517-1	SPACER	71
-	-3	-2	-1	U/M	

USED ON	
-1	LEADMAKER MECH POST FEED
-2	BENCH MODEL K MECH PRE FEED
-3	BENCH MODEL G MECH PRE FEED
-77	SPARE PARTS KIT

QTY REQD	PER ASSY	PART NO	DESCRIPTION	ITEM NO		
-	REF	REF	22594-8	NUT,HEX(1/2-20)	70	
-	REF	REF	240628-1	PLATE, ADJUSTMENT	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	SCREW, ADJ FEED ROD	64	
-	REF	REF	240659-3	PIN, CAM ROLLER	63	
-	REF	REF	240658-1	ROLLER, CAM	62	
-	REF	REF	454398-2	ROD, FEED	61	
-	REF	REF	454178-1	GUIDE, FEED ROD	60	
-	REF	REF	454220-1	CAP, RAM	59	
-	REF	REF	454485-1	HOUSING	58	
-					57	
-	1	1	458537-2	PAWL, FEED	56	
-	REF	REF	240624-1	PIN, FEED FINGER	55	
-	REF	REF	691499-1	SPRING, FEED FINGER	54	
-	REF	REF	690541-1	HOLDER, FEED FINGER	53	
-	REF	REF	455679-1	LEVER, TERMINAL FEED ARM	52	
-					51	
-					50	
-	1	-	690602-6	CAM, PRE-FEED 1 5/8 ST	49	
-	-	1	690602-5	CAM, PRE-FEED 1 1/8 ST	48	
-	-	-	690501-4	CAM, POST-FEED 1 5/8 ST	47	
-	1	1	459456-1	APPLICATOR, BASIC (SUBASSY)	46	
-	1	1	690191-1	PLUG, NYLON	45	
-	1	1	455673-1	RAM	44	
-	1	1	690125-1	WASHER, LAMINATED	43	
-	1	1	690124-1	WASHER, RAM	42	
-	1	1	7-21002-9	BOLT, CRIMPER(5/16x1.00)	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	
-	1	1	469465-2	STOP, WIRE	34	
-	REF	REF	455675-1	PLATE, BASE	33	
-					32	
-					31	
-	REF	REF	455689-1	BLOCK, STRIP GUIDE ADJ	30	
-	1	1	318042-1	STRIP GUIDE PLATE ASSY	29	
-	1	1	455888-4	SPACER, FRONT SHEAR DEP	28	
-	2	2	1-22284-0	SPRING, DRAG	27	
-	1	1	690546-1	LEVER, DRAG RELEASE	26	
-	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	6-690504-8	GUIDE, STRIP (REAR)	24	
-	1	1	690438-1	GUIDE, STRIP (FRONT)	23	
-	1	1	817375-1	STRIPPER	22	
-	REF	REF	4-22284-9	SPRING, FEED RETURN	21	
-					20	
-					19	
-					18	
-					17	
-	1	1	318563-1	GUARD, CHIP, FRONT	16	
-					15	
-					14	
-					13	
-	1	1	3-22280-3	SPRING, SHEAR	12	
-	1	1	690461-1	STOP, SHEAR	11	
-	1	1	690459-1	HOLDER, SHEAR (FRONT)	10	
-	1	1	462006-1	SHEAR, FLOAT (FRONT)	9	
-	1	1	1-464962-4	ANVIL	8	
-					7	
-					6	
-	1	1	2-455889-0	DEPRESSOR, SHEAR (FRONT)	5	
-	1	1	238011-8	SPACER, BLOCK CRIMPER	4	
-	1	1	9-683454-8	CRIMPER, INSULATION	3	
-	1	1	1-455888-0	SPACER, CRIMPER	2	
-	1	1	3-456403-3	CRIMPER, WIRE	1	
-	-77	-3	-2	-1	U/M	



- 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 46.
- 6 RECOMMENDED BOARD HOLE DIAMETER IS .072±.003.
- 7 GUIDE OFF OF INSULATION BARREL.

LOC	DIST
A	66

M	ECR-10-018851	9-2010	MY	GB	ANGLS: -	SCALE: -	SIZE: A1	DRAWING NO: 680422	SHEET 1 of 1	REV M
DIMENSIONS: INCHES TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.0005 1 PLC ±.0010 2 PLC ±.0015 3 PLC ±.0020 4 PLC ±.0025 ANGLS: - SURFACE TEXTURE: -										
M. OBRINE 29JAN97 MATERIAL: - HEAT TREAT: - C. ERISMAN 29JAN97 J. HIRNISEN 29JAN97 Tyco Electronics Corporation Harrisburg, PA 17105-3608 SIDE FEED HDM APPLICATOR CUSTOMER ACCESSIBLE PRODUCTION DRAWING										