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LOC

DIST


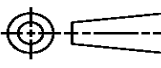
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	B1	ECR-16-009822	15JUL2016	GK	SD

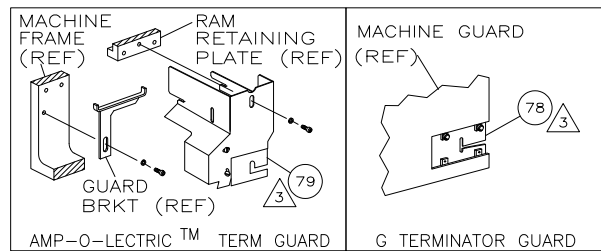
REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2151223-1

FOR REPLACEMENT PARTS FOR APPLICATOR 680371
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
680371

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV		 TE Connectivity						
		CHK	GOPALAKRISHNA HV								
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	NAME						
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		STOUGH DALE		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
				PRODUCT SPEC							
				APPLICATION SPEC							
				WEIGHT							
MATERIAL		FINISH		CUSTOMER DRAWING		SCALE		SHEET 1 OF 2		REV B1	

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PART NUMBER	REV	FIRST USED			
680371-1	B	122500-1			
680371-2	B	565435-5			
680371-3	B	354500-1			



TERMINAL NAME: .040 SERIES III SEALED TAB 8					
CRIMPING DATA					
SEAL	TERMINAL	PAD LTR	CRIMP HEIGHT	WIRE SIZE	
286523	316834	A	.050 ±.002 [1.26 ±.05mm]	0.5mm ²	
		B	.046 ±.002 [1.17 ±.05mm]	0.3mm ²	
		C	NOT	USED	
		D	NOT	USED	
		CRIMP	SIZE	TYPE	RANGE
		WIRE	.067 [1.70mm]	F	0.3mm ² - 0.5mm ²
		INSUL	.120 [3mm]	0	-
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.157-.177	114-5227	.394	408-8040	458637-1	L1830

LOC	DIST	REVISIONS			
A	66	REV	DESCRIPTION	DATE	OWN
B		ECR-08-012691		5-2008	MY

-1	LEADMAKER	MECH PRE FEED
-2	BENCH MODEL K	MECH PRE FEED
-3	BENCH MODEL G	MECH PRE FEED

REF	REF	REF	-	22594-8	NUT, HEX(1/2-20)	70
REF	REF	REF	-	240628-1	PLATE, ADJUSTMENT	69
REF	REF	REF	-	240626-1	SHAFT, PIVOT	68
REF	REF	REF	-	240633-1	BUSHING	67
REF	REF	REF	-	455680-1	LEVER, INTERMEDIATE	66
REF	REF	REF	-	240629-1	BLOCK, PIVOT	65
REF	REF	REF	-	240632-2	SCREW, ADJ FEED ROD	64
REF	REF	REF	-	240659-3	PIN, CAM ROLLER	63
REF	REF	REF	-	240658-1	ROLLER, CAM	62
REF	REF	REF	-	454398-2	ROD, FEED	61
REF	REF	REF	-	454178-1	GUIDE, FEED ROD	60
REF	REF	REF	-	454220-1	CAP, RAM	59
REF	REF	REF	-	454485-1	HOUSING	58

1	1	1	-	458537-2	PAWL, FEED	56
REF	REF	REF	-	240624-1	PIN, FEED FINGER	55
REF	REF	REF	-	691499-1	SPRING, FEED FINGER	54
REF	REF	REF	-	690541-1	HOLDER, FEED FINGER	53
REF	REF	REF	-	455679-1	LEVER, TERMINAL FEED ARM	52
1	1	1	-	811242-2	BUMPER, HOLDDOWN	51
1	1	1	-	690753-1	SPACER, TONKER	50
1	-	1	-	690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	1	-	-	690602-5	CAM, PRE-FEED 1 1/8 ST	48

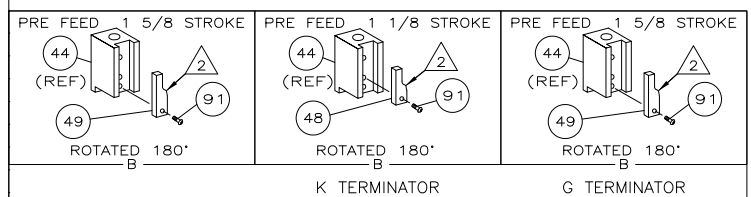
1	1	1	-	459456-1	APPLICATOR, BASIC (SUBASSY)	46
1	1	1	-	690191-1	PLUG, NYLON	45
1	1	1	-	455673-1	RAM	44
1	1	1	-	690125-1	WASHER, LAMINATED	43
1	1	1	-	690124-1	WASHER, RAM	42
1	1	1	-	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41
1	1	1	-	23241-6	BALL, STEEL	40
1	1	1	-	690170-1	SPRING, COMPRESSION	39
1	1	1	-	690142-1	DISC, INSULATION	38
1	1	1	-	354777-1	WIRE DISC, PLASTIC	37
1	1	1	-	22480-5	WASHER, SPRING	36
1	1	1	-	690212-1	POST, RAM	35
1	1	1	-	690786-1	SUPPORT, TERMINAL	34
REF	REF	REF	-	455675-1	PLATE, BASE	33
1	1	1	-	690432-3	SCREW, ADJUSTMENT	32

REF	REF	REF	-	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	455671-1	PLATE, STRIP GUIDE	29
1	1	1	-	1-455888-9	SPACER, FRONT SHEAR DEP	28
2	2	2	-	1-22284-0	SPRING, DRAG	27
1	1	1	-	690546-1	LEVER, DRAG RELEASE	26
1	1	1	-	240792-1	DRAG, TERMINAL	25
1	1	1	-	9-690504-2	GUIDE, STRIP (REAR)	24
1	1	1	-	690438-1	GUIDE, STRIP (FRONT)	23
-	-	1	-	690472-2	STRIPPER	22
REF	REF	REF	-	4-22284-9	SPRING, FEED RETURN	21

1	1	-	-	691353-1	STRIPPER	19
1	1	1	-	318563-1	GUARD, CHIP, FRONT	16
1	1	1	-	3-22280-3	SPRING, SHEAR	12
1	1	1	-	690461-2	STOP, SHEAR	11
1	1	1	-	1-690459-0	HOLDER, SHEAR (FRONT)	10
1	1	1	-	318707-1	SHEAR, FLOAT (FRONT)	9
1	1	1	-	662520-1	ANVIL	8
1	1	1	-	318701-1	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	2-238011-2	SPACER, BLOCK CRIMPER	4
1	1	1	-	2-456135-4	CRIMPER, INSULATION	3
1	1	1	-	455888-8	SPACER, CRIMPER	2
1	1	1	-	2-568176-3	CRIMPER, WIRE	1

1	1	1	-	318701-1	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	2-238011-2	SPACER, BLOCK CRIMPER	4
1	1	1	-	2-456135-4	CRIMPER, INSULATION	3
1	1	1	-	455888-8	SPACER, CRIMPER	2
1	1	1	-	2-568176-3	CRIMPER, WIRE	1

-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY				PARTS LIST		
QTY REQD PER ASSY				PARTS LIST		
QTY REQD PER ASSY				PARTS LIST		



- RECOMMENDED SPARE PARTS.
- GREASE LIGHTLY.
- GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
- CUT TO LENGTH AT ASSY
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

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DIMENSIONS: INCHES				NAME			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				SIDE FEED HDM APPLICATOR			
0 PLC ±.005				SIZE			
1 PLC ±.003				GAGE CODE			
2 PLC ±.002				DRAWING NO			
3 PLC ±.001				RESTRICTED TO			
4 PLC ±.0005				A100779			
ANGLES FINISH				CUSTOMER DRAWING			
MATERIAL				SCALE			
FINISH				SHEET 1 OF 1			

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