

CRIMPING DATA				
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	STRIP LENGTH	
A	.055±.002	18	.281	
B	.052±.002	(2)22		
C	.050±.002	20		
D	.047±.002	22	-	
CRIMP	SIZE	TYPE	FEED	APPLICATOR WILL APPLY
WIRE	.080	F	.740	521050
INSUL	.140	0		521411
INSUL RANGE	WIRE RANGE	APPLICATOR INSTRUCTION SHEET		
.050-.100	22-18	AI 8099	AI 8102	-
TERM APPL SPEC				114-2124

PART NUMBER	REV	FIRST USED	LEADMAKER OR BENCH MODEL
680020-1	P	854400-1	LEADMAKER OR BENCH MODEL G
680020-2	P	565435-5	BENCH MODEL K
680020-7	P	-	KOMAX 162

THIS DRAWING IS A CONTROLLED DOCUMENT. 680020

- 1 RECOMMENDED SPARE PARTS.
- 2 ITEMS NOT SHOWN ON ASSEMBLY.
- 3 TOLERANCE ON CUT LENGTH TO BE ±.13.
- 4 USED ON THE CLS I AND II MACHINES ONLY. REMOVE THE TWO MOUNTING SCREWS SECURING THE PRODUCT DEREELEER AND PLACE THE PRODUCT GUIDE (ITEM 111) ON TOP OF THE MOUNTING BRACKET. REASSEMBLE AND RETIGHTEN THE TWO MOUNTING SCREWS.
- 5 ITEM 127 "T" TERMINATING UNIT CONVERSION KIT 856399-1 CONVERTS APPLICATOR 680020-2 TO A 680020-1.
- 6 ITEM 128 AOM 4A FEED SIDE CONVERSION KIT 856875-1 CONVERTS AN AOM TO RUN APPLICATOR 680020-1.
- 7 ITEM 129 "K" TERMINATING UNIT CONVERSION KIT 856398-1 CONVERTS APPLICATOR 680020-1 TO A 680020-2.
- 8 ADJUSTING THE VALVES (ITEMS 40 AND 47).

8a. FOR 680020-1 ASSEMBLY ONLY.

MAKE SURE THE CAM VALVE (ITEM 84) IS IN THE FULLY DOWN POSITION BEFORE PLACING THE RAM BACK INTO THE APPLICATOR. INSTALL THE APPLICATOR INTO A "T" TERMINATING UNIT, TURNING THE POWER TO THE UNIT OFF WHILE ALLOWING THE AIR TO REMAIN ON. MANUALLY CYCLE THE UNIT, PRODUCT MUST NOT BE PRESENT IN THE APPLICATOR, SO THAT THE RAM IS AT DEAD BOTTOM OF ITS STROKE. LOOSEN THE FOUR SCREWS SECURING THE VALVES (ITEMS 40 AND 47) AND SLOWLY RAISE THE RAM UPWARD UNTIL THE INSULATION CRIMPER LEG (ITEM 78) IS IN THE CENTER OF THE INSERTER (ITEM 18). ADJUST THE LOWER VALVE (ITEM 47) SO IT IS ON THE LOWER LOBE OF THE CAM VALVE (ITEM 84) AND IS ACTUATED, THEN RETIGHTEN THE TWO MOUNTING SCREWS. THIS VALVE WILL CAUSE THE INSERTION CYLINDER TO EXTEND, INSERTING THE HOUSING ONTO THE TERMINATED PRODUCT.

CONTINUE RAISING THE RAM, STOPPING JUST BEFORE TOP DEAD CENTER. NOW POSITION THE UPPER VALVE (ITEM 40) SO IT IS ON THE UPPER LOBE OF THE VALVE CAM (ITEM 84) AND IS ACTUATED, THEN RETIGHTEN THE TWO MOUNTING SCREWS. THIS VALVE WILL CAUSE THE INSERTION CYLINDER TO RETRACT AFTER THE HOUSING IS APPLIED. COMPLETE THE THE UNIT CYCLE TO TOP DEAD CENTER.

CHECK THE ADJUSTMENTS JUST MADE BY PUTTING PRODUCT INTO THE APPLICATOR AND CYCLING THE UNIT UNDER POWER A FEW TIMES AND VERIFY THAT THE CURRENT SETTINGS ARE CORRECT. IF ADJUSTMENTS MUST BE MADE TURN OFF POWER TO THE UNIT, REMOVE ANY PRODUCT AND FOLLOW THE STEPS ABOVE.

NOTE: UNDER MANUAL MODE DAMAGE TO THE HOUSINGS WILL OCCUR WHEN PRODUCT IS APPLIED TO THE APPLICATOR DUE TO TIMING, THIS IS AN ENGINEERED INTERFERENCE AND WILL BE CORRECTED UNDER POWER OF THE UNIT.

8b. FOR 680020-2 ASSEMBLY ONLY.

MAKE SURE THE CAM VALVE (ITEM 84) IS IN THE FULLY UP POSITION BEFORE PLACING THE RAM BACK INTO THE APPLICATOR. INSTALL THE APPLICATOR INTO A "K" TERMINATING UNIT, TURNING THE POWER TO THE UNIT OFF WHILE ALLOWING THE AIR TO REMAIN ON. MANUALLY CYCLE THE UNIT, PRODUCT MAY BE PRESENT IN THE APPLICATOR, SO THAT THE RAM IS AT DEAD BOTTOM OF ITS STROKE. LOOSEN THE FOUR SCREWS SECURING THE VALVES (ITEMS 40 AND 47) AND SLOWLY RAISE THE RAM UPWARD UNTIL THE INSULATION CRIMPER LEG (ITEM 78) CLEARS THE INSERTER BY .03±.03. ADJUST THE LOWER VALVE (ITEM 47) SO IT IS ON THE LOWER LOBE OF THE CAM VALVE (ITEM 84) AND IS ACTUATED, THEN RETIGHTEN THE TWO MOUNTING SCREWS. THIS VALVE WILL CAUSE THE INSERTION CYLINDER TO EXTEND, INSERTING THE HOUSING ONTO THE TERMINATED PRODUCT.

CONTINUE RAISING THE RAM, STOPPING JUST BEFORE TOP DEAD CENTER. NOW POSITION THE UPPER VALVE (ITEM 40) SO IT IS ON THE UPPER LOBE OF THE VALVE CAM (ITEM 84) AND IS ACTUATED, THEN RETIGHTEN THE TWO MOUNTING SCREWS. THIS VALVE WILL CAUSE THE INSERTION CYLINDER TO RETRACT AFTER THE HOUSING IS APPLIED. COMPLETE THE THE UNIT CYCLE TO TOP DEAD CENTER.

CHECK THE ADJUSTMENTS WITH A FEW MANUAL CYCLES OF THE PRESS TO VERIFY CLEARANCES FOR THE TOOLING AND CONTINUING TO ADJUST THE VALVES UNTIL THESE CLEARANCES ARE OBTAINED.

- 9 THE CYLINDER MOUNT (ITEM 31) SHOULD BE ADJUSTED VERTICALLY SO THE INCOMING PRODUCT GOES THROUGH THE STRIP GUIDES (ITEMS 60 AND 95) AND INTO THE INSERTER (ITEM 18) WITHOUT ANY OBSTRUCTIONS TO DISLodge OR STUB ON THE HOUSINGS.
- 10 ADD SHIM BETWEEN POD INSERTER AND HOUSING IF TERMINALS HIT POD INSERTER.

- 11 LOCATE THE REAR KEYS THAT LOCATE THE APPLICATOR TO THE TERMINATING UNIT BASE PLATE. THE SOCKET HEAD CAP SCREW SECURING THE KEY CLOSEST TO THE FRONT OF THE UNIT MUST BE REPLACED WITH A BUTTON HEAD CAP SCREW (ITEM 92 OR 107). THIS CHANGE WILL NOT EFFECT ANY OTHER APPLICATOR.
- 12 BUTTON HEAD CAP SCREW (ITEM 92 OR 107) IS TO BE BAGGED AND SHIPPED ALONG WITH THE APPLICATOR.
- 13 CANNOT RUN 2 WIRES ON LEADMAKER.
- 14 GRIND OFF BOTTOM OF STUD IF IT PROTRUDES BELOW SURFACE OF STRIP GUIDE.
- 15. SPRING LOADED TONKER (P/N 354853-1) MUST BE USED WHEN RUNNING THE APPLICATOR ON A LEADMAKER.
- 16. AIR VALVE CONVERSION KIT, KOMAX 1633069-1 CONVERTS 680020-1 UP TO & INCLUDING REV H TO A 680020-7. AIR VALVE CONVERSION KIT, KOMAX 1633069-2 CONVERTS 680020-1 REV J THRU CURRENT TO A 680020-7.

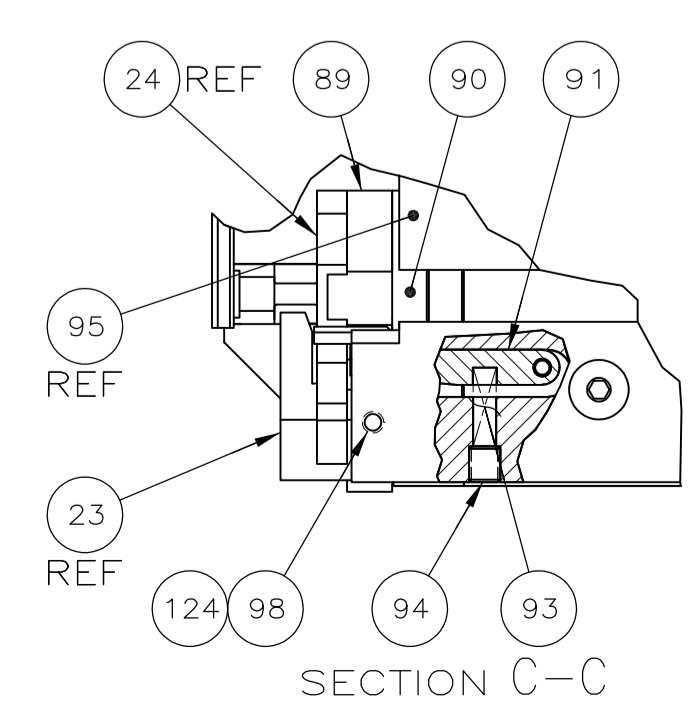
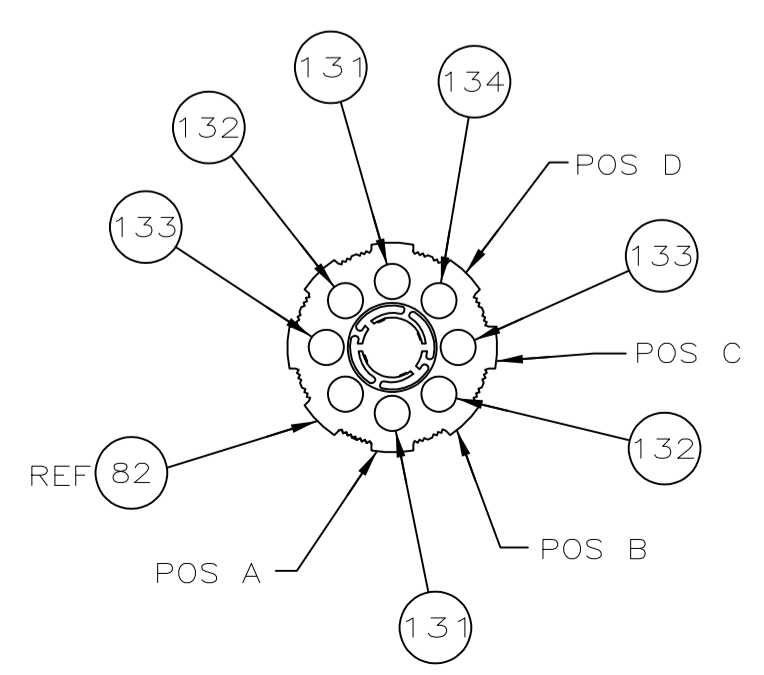
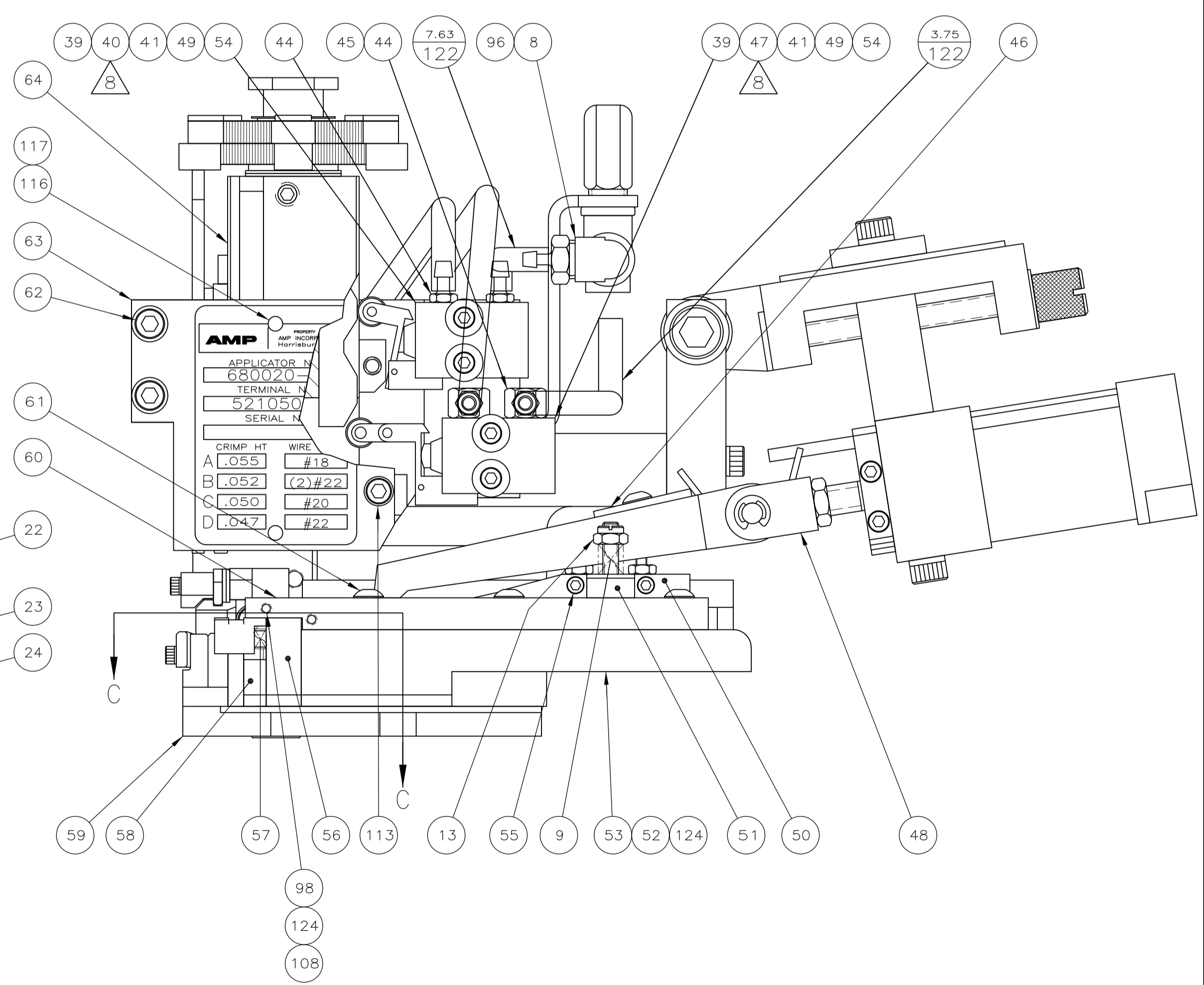
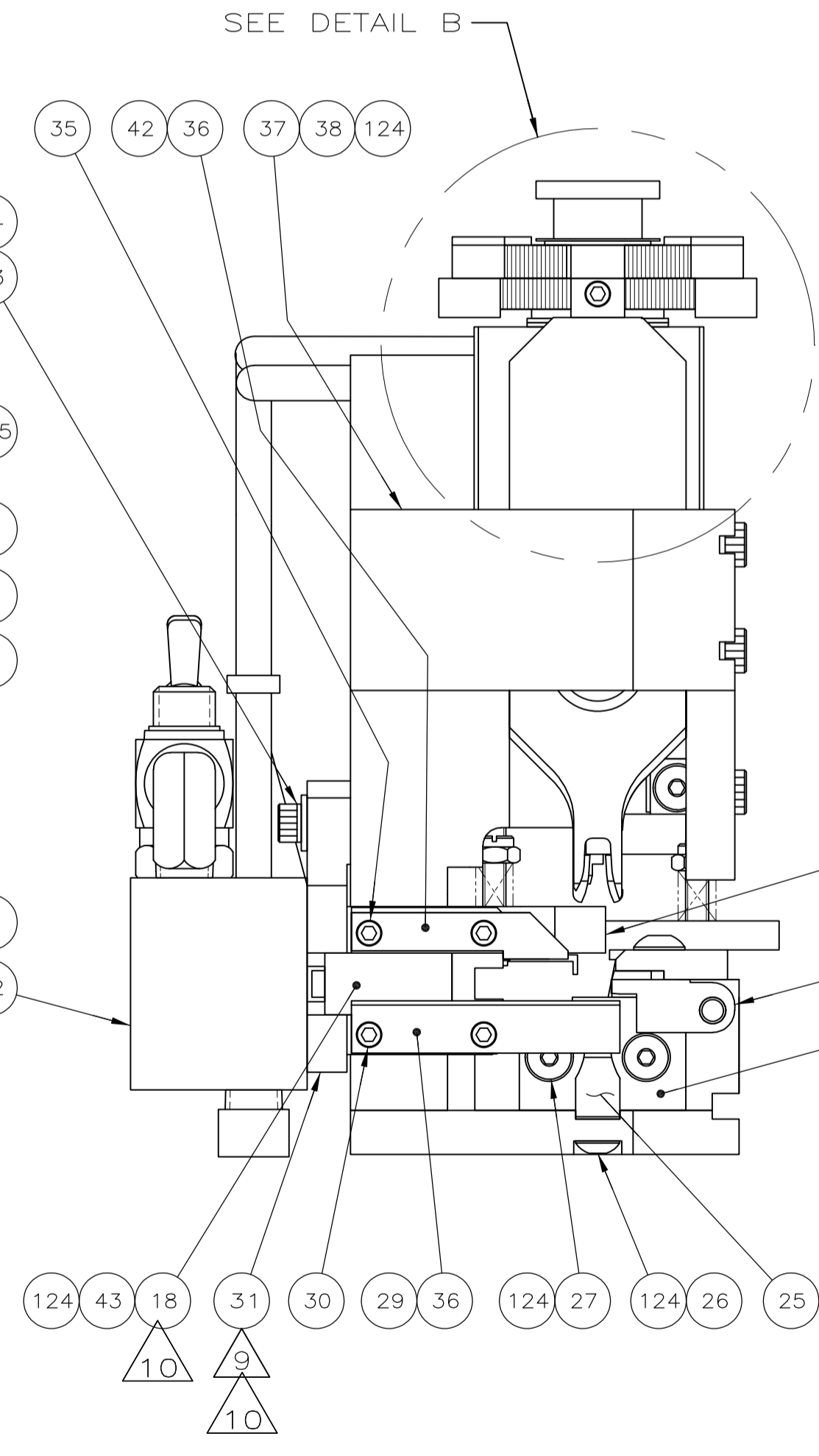
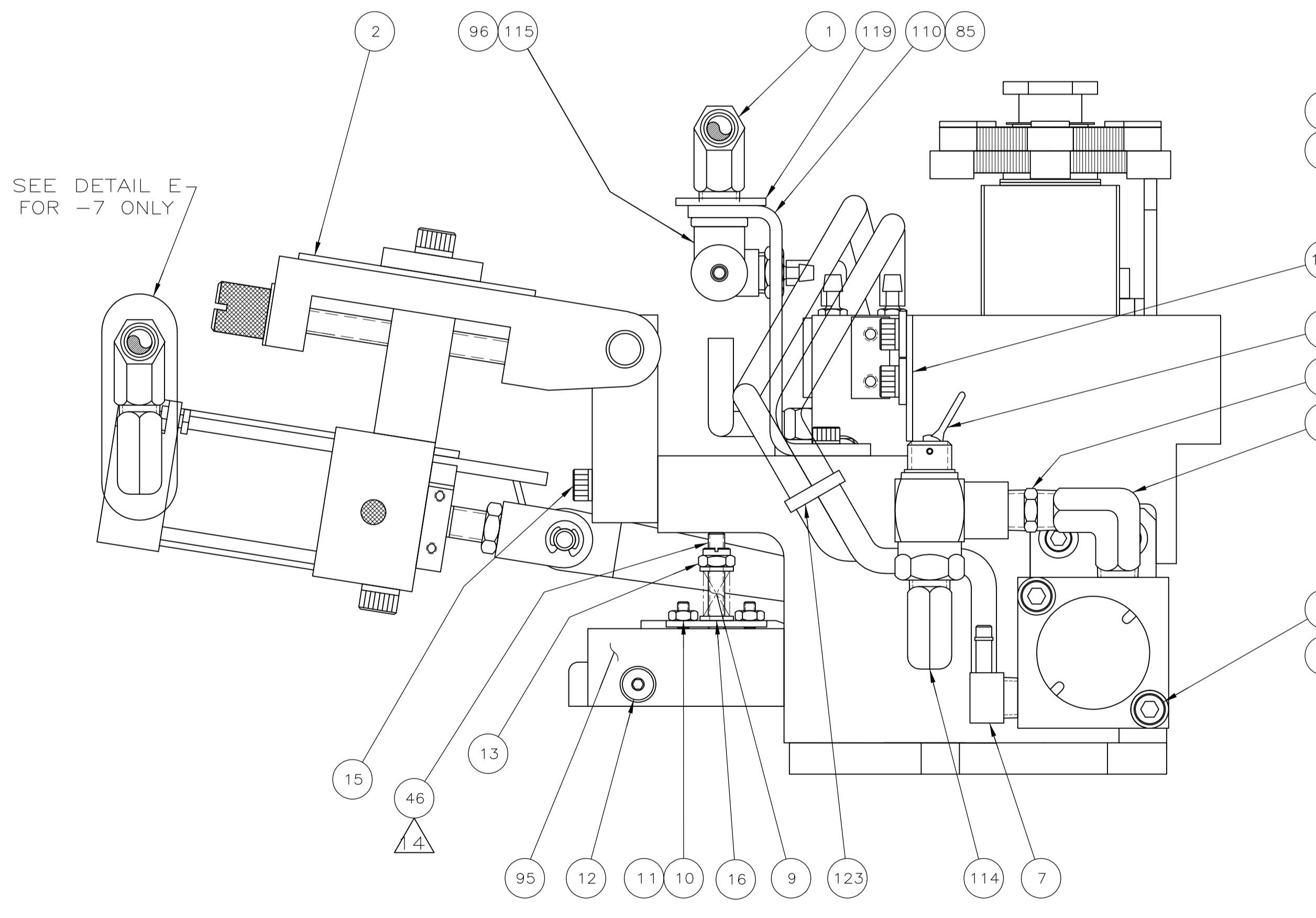
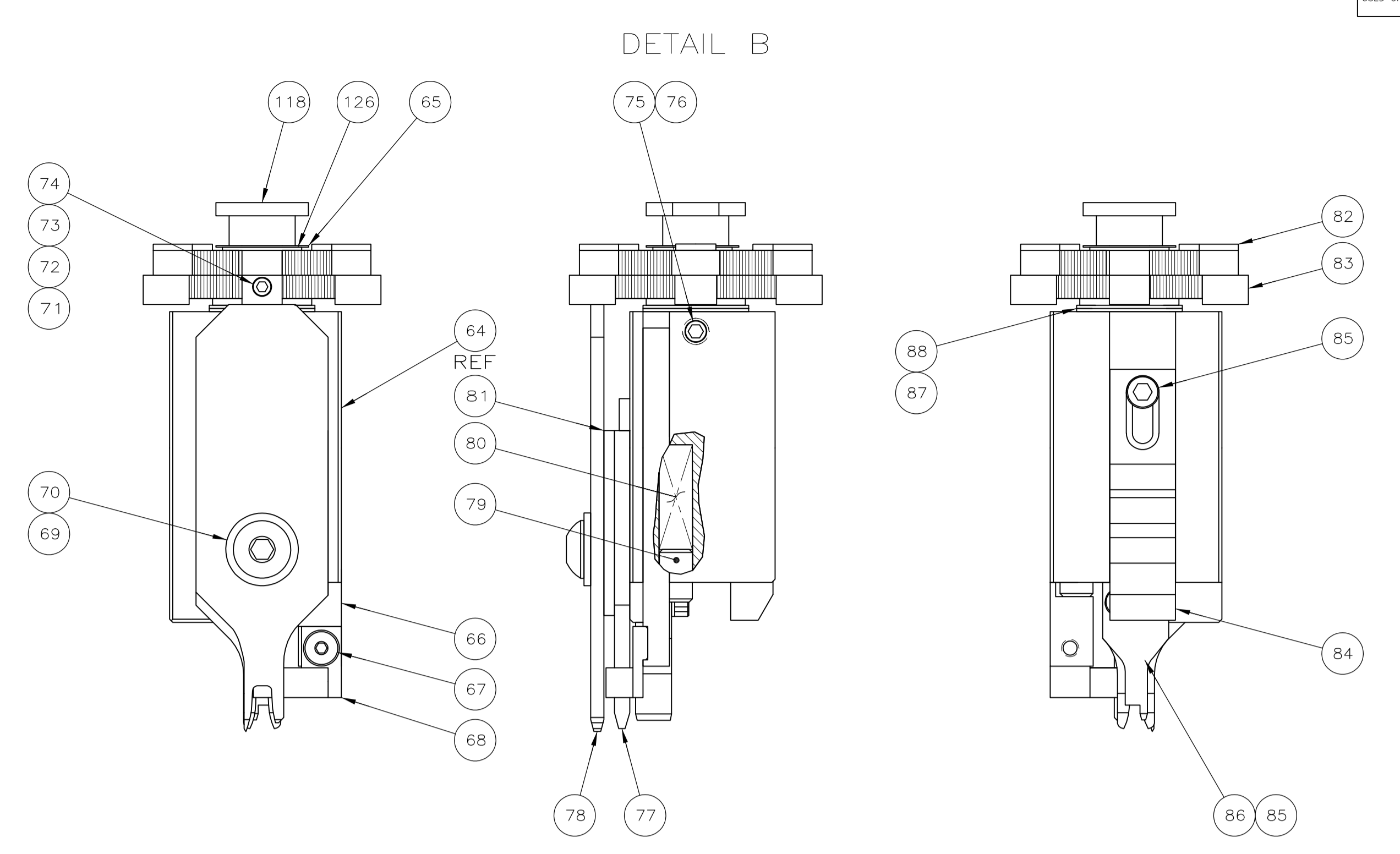
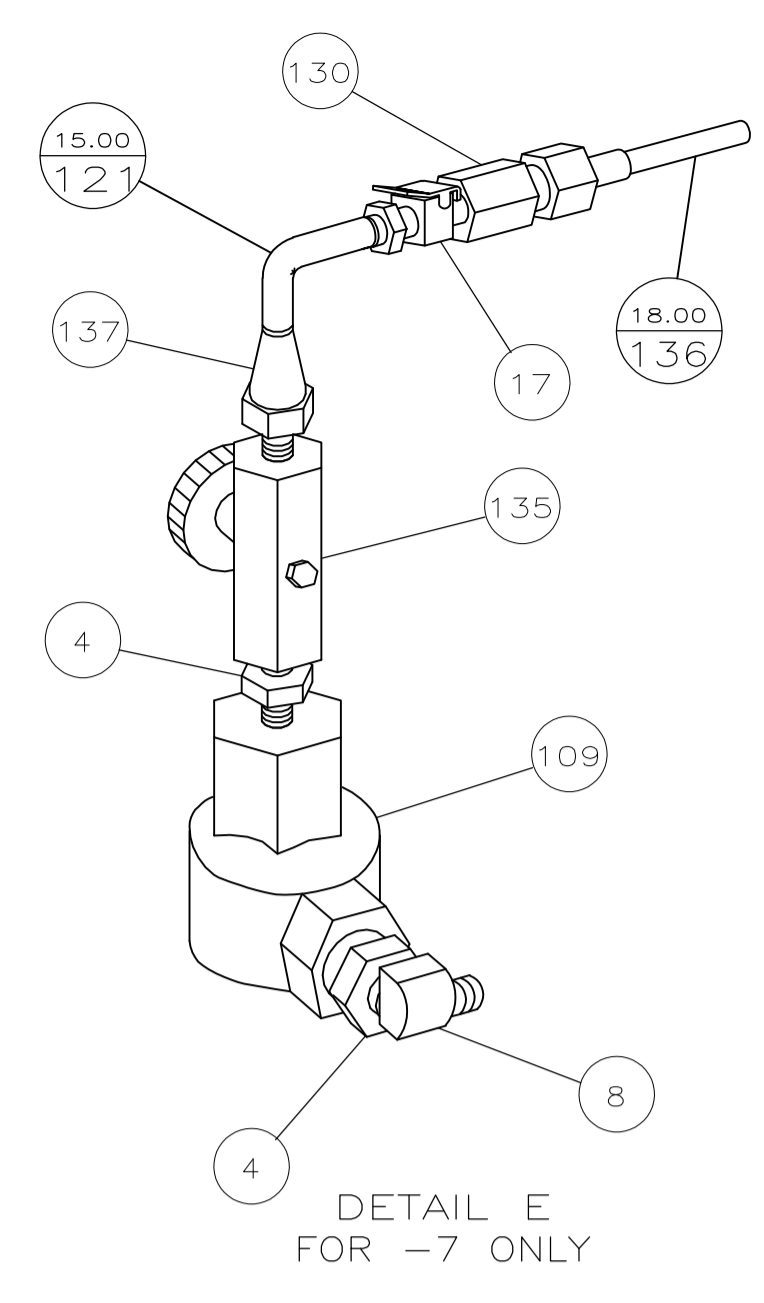
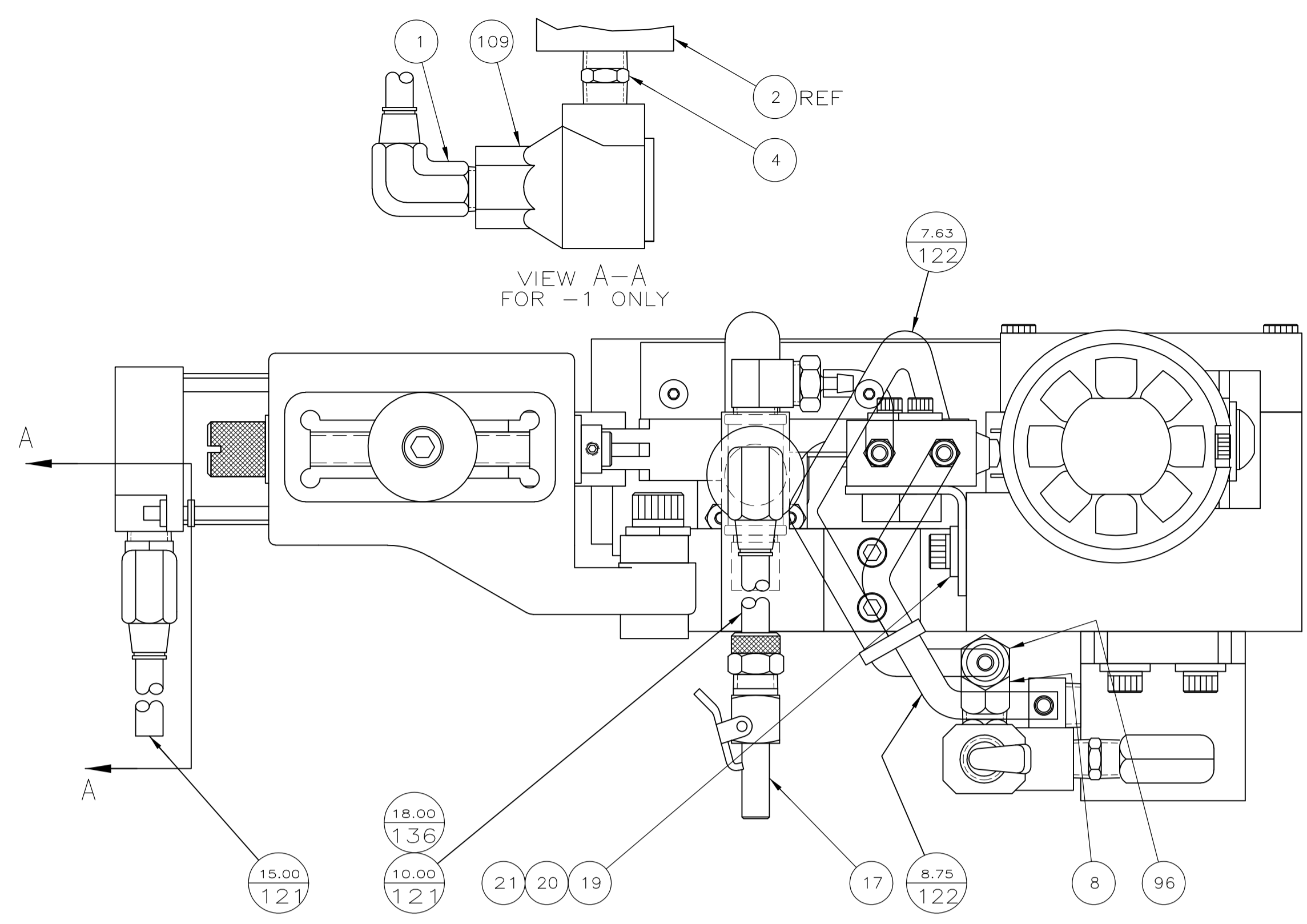
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LOC A
DIST 66

DWG: M. O'BRINE 8-9-93		MATERIAL: -		HEAT TREAT: -	
CHK: C. ERISMAN 8-16-93		APVD: B. WOLFE 8-16-93		Tyco Electronics Corporation Harrisburg, PA 17105-3608	
NAME: WOLFE		ULTRA POD FLAG APPLICATOR			
SCALE: 1:1		SIZE: A1		DRAWING NO: 680020	
SHEET: 1		OF: 3		REV: P2	

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT.
PART NO 680020



AMP	
APPLICATOR N° 680020	
TERMINAL N° 521050	
SERIAL N°	
CRIMP HT	WIRE
A .055	#18
B .052	(2) #22
C .050	#20
D .047	#22

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LOC A
DIST 66

REV	DESCRIPTION	DATE	BY	APPV
1	SEE SHEET 1			

DIMENSIONS:	
INCHES	
TOLERANCES UNLESS OTHERWISE SPECIFIED:	
0 PLC	± .005
1 PLC	± .002
2 PLC	± .001
3 PLC	± .0005
4 PLC	± .0002
ANGLES:	
SURFACE TEXTURE	

DWN	M. O'BRINE	8-9-93	MATERIAL	-	HEAT TREAT	-
CHK	C. ERISMAN	8-16-93				
APVD	B. WOLFE	8-16-93				
NAME		ULTRA POD FLAG APPLICATOR				
SCALE	1:1	SIZE	A1	DRAWING NO	680020	SHEET 3 of 3
REV		P2				

CUSTOMER ACCESSIBLE PRODUCTION DRAWING