

4

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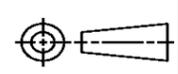
LOC	DIST	REVISIONS			
P	LTR	DESCRIPTION	DATE	DWN	APVD
	A1	ECR-15-007476	19MAY2015	GK	HMR

# REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2266751-1

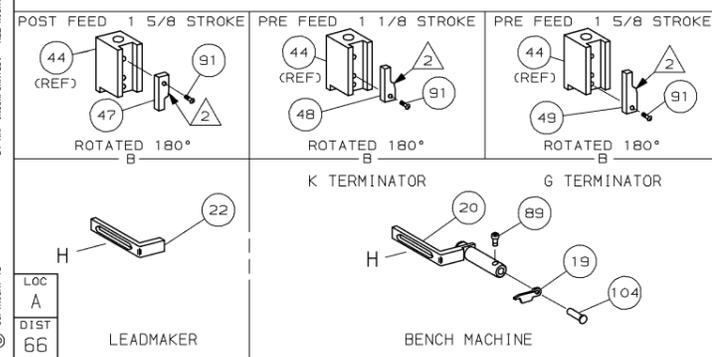
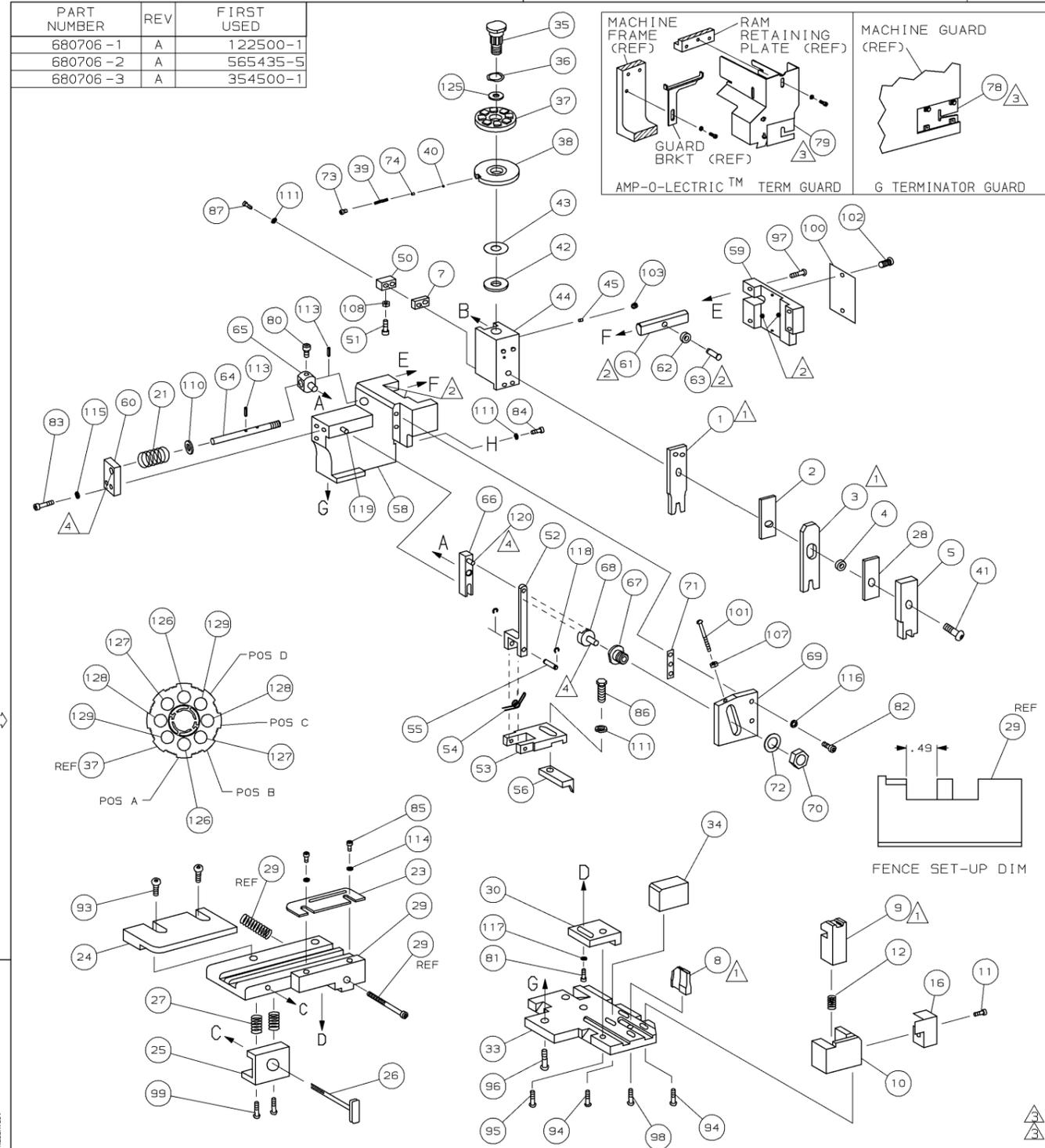
FOR REPLACEMENT PARTS FOR APPLICATOR 680706 REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED) WILL REMAIN AVAILABLE.

THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR 680706

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	±	PRODUCT SPEC	NAME		
0 PLC	±																
1 PLC	±																
2 PLC	±																
3 PLC	±																
4 PLC	±																
ANGLES	±																
MATERIAL		APPLICATION SPEC	SIDE FEED HDM APPLICATOR														
FINISH		WEIGHT	SIZE	CAGE CODE	DRAWING NO												
			A3		©- 680706												
		CUSTOMER DRAWING	SCALE	SHEET 1 OF 2	REV A1												



PART NUMBER	REV	FIRST USED
680706-1	A	122500-1
680706-2	A	565435-5
680706-3	A	354500-1



- 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.

WIRE STRIP LENGTH		TERM APPL	SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.141-.171		NONE		.500	408-8040	458637-1	L2137
2	2	2	-	C	2-354779-6	PIN, WIRE DISC (.3120)D	129
2	2	2	-	C	1-354779-6	PIN, WIRE DISC (.3070)C	128
2	2	2	-	C	354779-6	PIN, WIRE DISC (.3020)B	127
2	2	2	-	C	9-354778-4	PIN, WIRE DISC (.2965)A	126
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	1	-	-	4088040	SF APPL INST 408-8040	123
REF	REF	REF	-	A	1-21030-1	PIN, DOWEL (φ.187x.50) LEVER	120
REF	REF	REF	-	A	1-21030-6	PIN, DOWEL (φ.187x1.25) HOUSING	119
REF	REF	REF	-	A	21045-3	RING, RET "C" (φ.187) FD FING PIN	118
1	1	1	-	A	21024-5	WASHER, LOCK (#10) ADJ BLOCK	117
REF	REF	REF	-	A	21024-5	WASHER, LOCK (#10) ADJ PLATE	116
REF	REF	REF	-	A	21024-5	WASHER, LOCK (#10) FEED GDE ROD	115
2	2	2	-	A	21024-2	WASHER, LOCK (#4) FRONT STP GUIDE	114
REF	REF	REF	-	A	5-21028-1	PIN, SLT SPR (φ.125x.50) ADJ ROD	113
4	4	4	-	A	21024-4	WASHER, LOCK (#8) STRIPPER	112
REF	REF	REF	-	A	21899-4	WASHER, FLAT (φ5/16) SCREW ADJ	110
1	1	1	-	A	21018-5	NUT, HEX (NO. 6) HOLDDOWN	108
REF	REF	REF	-	A	21068-5	NUT, HEX (6-32) FEED ADJ	107
1	1	1	-	A	992031-1	PIN, CLEVIS	104
1	1	1	-	A	21009-2	SCR, SKT SET (1/4-20x.25 LW) RAM	103
2	2	2	-	A	21017-2	SCR, DRIVE (#2x.19) ID PLATE	102
REF	REF	REF	-	A	6-23715-5	SCR, PAN HD (6-32x1.50) FEED ADJ	101
1	1	1	-	B	461264-1	PLATE, IDENTIFICATION	100
2	2	2	-	A	3-21002-0	SCR, BHC (10-32x.88) DRAG	99
1	1	1	-	A	22733-8	SCR, BHC (8-32x.38 LW) ANVIL	98
REF	REF	REF	-	A	2-21002-9	SCR, BHC (10-32x.75) CAP	97
REF	REF	REF	-	A	2-22733-8	SCR, BHC (1/4-20x.62) HOUSING	96
REF	REF	REF	-	A	2-21002-7	SCR, BHC (10-32x.50) 56 ADJ BLOCK	95
4	4	4	-	A	2-21002-2	SCR, BHC (8-32x.50) TERM H DWN	94
2	2	2	-	A	2-21002-1	SCR, BHC (8-32x.50) R STP GDE	93
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38) CAM	91
1	1	1	-	A	7-21000-9	SCR, SHC (4-40x.19) STRIPPER	89
2	2	2	-	A	2-21000-8	SCR, SHC (8-32x.62) DEP-HOLD	87
1	1	1	-	A	2-22603-0	SCR, HEX HD (8-32x.31) FEED FINGER	86
2	2	2	-	A	1-21000-3	SCR, SHC (4-40x.25) F ST GUIDE	85
1	1	1	-	A	2-21000-7	SCR, SHC (8-32x.50) STRIPPER	84
REF	REF	REF	-	A	3-21000-7	SCR, SHC (10-32x.75) FEED ROD GD	83
REF	REF	REF	-	A	3-21000-6	SCR, SHC (10-32x.62) FD ADJ BLK	82
1	1	1	-	A	3-21000-4	SCR, SHC (10-32x.38) 56 ADJ BL	81
REF	REF	REF	-	A	3-21000-4	SCR, SHC (10-32x.38) PIVOT BLK	80
-	REF	REF	-	B	455749-1	GUARD, WINDOW	79
REF	-	-	-	B	679532-1	INSERT, GUARD	78
1	1	1	-	A	690603-1	SPRING, ASSIST	74
1	1	1	-	A	23030-1	SCR, SHC (6-32x.25 SL) INS DISC	73
REF	REF	REF	-	A	458109-1	WASHER, SPECIAL	72
REF	REF	REF	-	A	690517-1	SPACER	71
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY		PARTS LIST					

CRIMP DATA (AMP TERMINAL)	LEADMAKER	MECH POST FEED	MECH PRE FEED
PAD LTR	REF	REF	REF
CRIMP HEIGHT	REF	REF	REF
WIRE SIZE	REF	REF	REF
A .067 ±.002 [1.70 ±0.05mm]	B	22594-8	NUT, HEX (1/2-20)
B .062 ±.002 [1.58 ±0.05mm]	B	240628-1	PLATE, ADJUSTMENT
C .057 ±.002 [1.45 ±0.05mm]	B	240626-1	SHAFT, PIVOT
D .052 ±.002 [1.32 ±0.05mm]	B	240633-1	BUSHING
CRIMP SIZE	A	455680-1	LEVER, INTERMEDIATE
TYPE	B	240629-1	BLOCK, PIVOT
RANGE	A	240632-2	SCREW, ADJ FEED ROD
WIRE .110 [2.79mm]	B	240659-3	PIN, CAM ROLLER
INSUL .155 [3.94mm]	B	240658-1	ROLLER, CAM
FEED .500	B	454398-2	ROD, FEED
APPL INSTRUCTION 408-8040	A	454178-1	GUIDE, FEED ROD
SET UP GAGE 458637-1	C	454220-1	CAP, RAM
LAYOUT L2137	D	454485-1	HOUSING
2 2 2 - C 2-354779-6			
2 2 2 - C 1-354779-6			
2 2 2 - C 354779-6			
2 2 2 - C 9-354778-4			
1 1 1 - A 986950-1			
1 1 1 - A 217238-1			
1 1 1 - - 4088040			
REF REF REF - A 1-21030-1			
REF REF REF - A 1-21030-6			
REF REF REF - A 21045-3			
1 1 1 - A 21024-5			
REF REF REF - A 21024-5			
REF REF REF - A 21024-5			
2 2 2 - A 21024-2			
REF REF REF - A 5-21028-1			
4 4 4 - A 21024-4			
REF REF REF - A 21899-4			
1 1 1 - A 21018-5			
REF REF REF - A 21068-5			
1 1 - - A 992031-1			
1 1 1 - A 21009-2			
2 2 2 - A 21017-2			
REF REF REF - A 6-23715-5			
1 1 1 - B 461264-1			
2 2 2 - A 3-21002-0			
1 1 1 - A 22733-8			
REF REF REF - A 2-21002-9			
REF REF REF - A 2-22733-8			
REF REF REF - A 2-21002-7			
4 4 4 - A 2-21002-2			
2 2 2 - A 2-21002-1			
1 1 1 - A 1-21002-7			
1 1 - - A 7-21000-9			
2 2 2 - A 2-21000-8			
1 1 1 - A 2-22603-0			
2 2 2 - A 1-21000-3			
1 1 1 - A 2-21000-7			
REF REF REF - A 3-21000-7			
REF REF REF - A 3-21000-6			
1 1 1 - A 3-21000-4			
REF REF REF - A 3-21000-4			
- REF - - B 455749-1			
REF - - - B 679532-1			
1 1 1 - A 690603-1			
1 1 1 - A 23030-1			
REF REF REF - A 458109-1			
REF REF REF - A 690517-1			
-3 -2 -1 U/M	DWG SIZE	PART NO	DESCRIPTION
QTY REQD PER ASSY		PARTS LIST	
1 1 1 - C 1-455889-4			
1 1 1 - B 2-238011-2			
1 1 1 - C 683453-3			
1 1 1 - C 455888-4			
1 1 1 - C 4-456408-0			
1 1 1 - A 5-22280-0			
1 1 1 - B 690461-1			
1 1 1 - C 690459-1			
1 1 1 - C 454276-1			
1 1 1 - C 1-662189-0			
1 1 1 - C 240641-5			
1 1 1 - C 1-455889-4			
1 1 1 - B 2-238011-2			
1 1 1 - C 683453-3			
1 1 1 - C 455888-4			
1 1 1 - C 4-456408-0			
-3 -2 -1 U/M	DWG SIZE	PART NO	DESCRIPTION
QTY REQD PER ASSY		PARTS LIST	
1 1 1 - B 318563-1			
1 1 1 - B 318563-1			
1 1 1 - C 1-455889-4			
1 1 1 - B 2-238011-2			
1 1 1 - C 683453-3			
1 1 1 - C 455888-4			
1 1 1 - C 4-456408-0			
1 1 1 - C 1-455889-4			
1 1 1 - B 2-238011-2			
1 1 1 - C 683453-3			
1 1 1 - C 455888-4			
1 1 1 - C 4-456408-0			
1 1 1 - C 1-455889-4			
1 1 1 - B 2-238011-2			
1 1 1 - C 683453-3			
1 1 1 - C 455888-4			
1 1 1 - C 4-456408-0			
1 1 1 - C 1-455889-4			
1 1 1 - B 2-238011-2			
1 1 1 - C 683453-3			
1 1 1 - C 455888-4			
1 1 1 - C 4-456408-0			
1 1 1 - C 1-455889-4			
1 1 1 - B 2-238011-2			
1 1 1 - C 683453-3			
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1 1 1 - C 4-456408-0			
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