

4

3

2

1

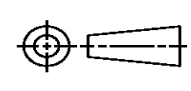
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LOC	DIST	REVISIONS			
P	LTR	DESCRIPTION	DATE	DWN	APVD
	A1	ECR-15-008773	10JUN2015	GK	HMR

# REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2151032-2

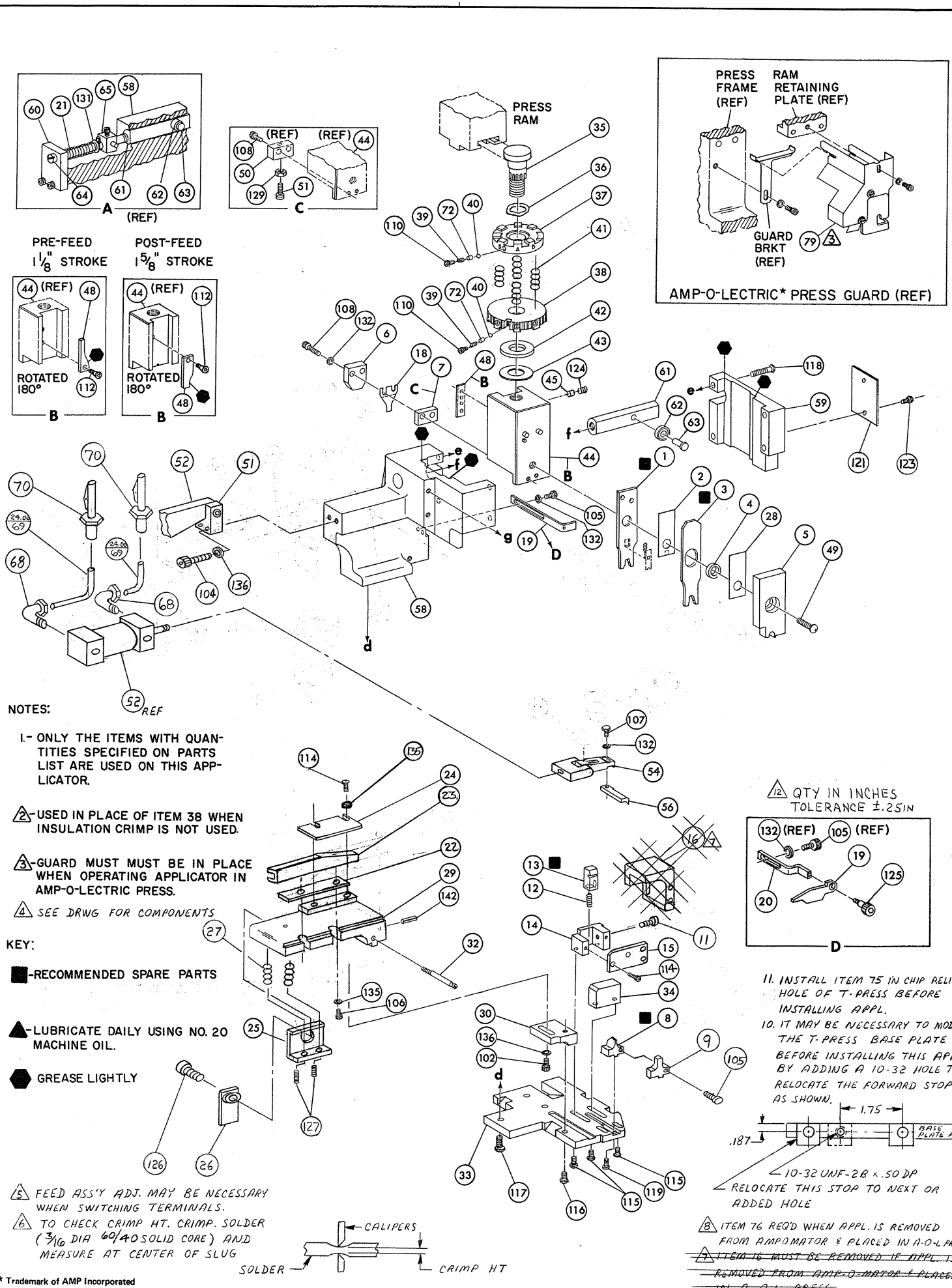
FOR REPLACEMENT PARTS FOR APPLICATOR 680042-1 REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED) WILL REMAIN AVAILABLE.

THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR 680042-1

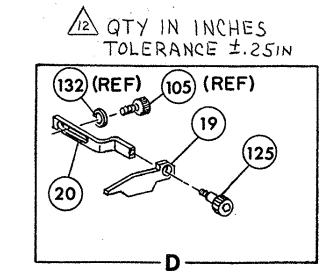
THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV		
DIMENSIONS:		CHK	RAGHAVENDRA		
		APVD	RAGHAVENDRA		
		PRODUCT SPEC	NAME		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATION SPEC	MINIATURE QUICK CHANGE APPLICATOR SIDE FEED		
0 PLC ±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
1 PLC ±		A3		©- 680042-1	
2 PLC ±		CUSTOMER DRAWING		SCALE	SHEET 1 OF 2
3 PLC ±					REV A1
4 PLC ±					
ANGLES ±					
MATERIAL					
FINISH					



THIS IS A CONTROLLED DOCUMENT.



- NOTES:
- 1- ONLY THE ITEMS WITH QUANTITIES SPECIFIED ON PARTS LIST ARE USED ON THIS APPLICATOR.
  - 2- USED IN PLACE OF ITEM 38 WHEN INSULATION CRIMP IS NOT USED.
  - 3- GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN AMP-O-LETRIC PRESS.
  - 4- SEE DRWG FOR COMPONENTS
- KEY:
- - RECOMMENDED SPARE PARTS
  - ▲ - LUBRICATE DAILY USING NO. 20 MACHINE OIL.
  - - GREASE LIGHTLY
- 5- FEED ASS'Y ADJ. MAY BE NECESSARY WHEN SWITCHING TERMINALS.
- 6- TO CHECK CRIMP HT. CRIMP SOLDER (3/16 DIA 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG



11. INSTALL ITEM 75 IN CHIP RELIEF HOLE OF T-PRESS BEFORE INSTALLING APPL.

10. IT MAY BE NECESSARY TO MODIFY THE T-PRESS BASE PLATE BEFORE INSTALLING THIS APPL. BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.

1.75

10-32 UNF-28 X .50 DP  
RELOCATE THIS STOP TO NEXT OR ADDED HOLE

8- ITEM 76 REQ'D WHEN APPL. IS REMOVED FROM AMPOMATOR & PLACED IN A-O-L PRESS.

9- ITEM 16 MUST BE REMOVED IF APPL. IS REMOVED FROM AMP-O-MATOR & PLACED IN A-O-L PRESS.

DIST 66  
AMP 2983-3 (4-76)  
\* Trademark of AMP Incorporated

QTY	PART NO	DESCRIPTION	ITEM NO	QTY	PART NO	DESCRIPTION	ITEM NO
—	21045-3	RING, RETAINING 'C' (.187 DIA) FEED FINGER PIN	145	1	454220-1	CAP, HOUSING	59
—	—	—	144	1	454485-1	HOUSING	58
—	5-21028-1	PIN, SLOT SPR (.125 DIA X .50) ADJ ROD	143				57
1	4-21028-0	PIN, SLOT SPR (.093 DIA X .75) STR G PLATE	142	1	462427-1	PAWL, FEED	56
—	1-21030-1	PIN, DOWEL (.187 DIA X .50) LEVER	141	—	240624-1	PIN, FEED FINGER	55
—	1-21030-6	PIN, DOWEL (.187 DIA X 1.25) HOUSING	140	1	461062-2	ASS'Y, FEED FINGER	54
—	21024-5	WASHER, LOCK (NO 10) LUB ASSY	139			FINGER, FEED	53
7	21024-5	WASHER, LOCK (NO 10) STRIP GUIDE ADJ BLOCK	138	1	461065-4	ASS'Y, AIR FEED	52
—	21024-5	WASHER, LOCK (NO 10) ADJ PLATE	137	1	459610-3	MOUNT, FEED BRACKET	51
3	21024-5	WASHER, LOCK (NO 10) FEED GUIDE ROD	136			SPACER, TONKER	50
4	21024-2	WASHER, LOCK (NO 4) FRONT STRIP GUIDE	135	1	7-21002-9	BOLT, CRIMPER	49
7	21024-4	WASHER, LOCK (NO 8) FEED FINGER	134			CAM FEED STROKE	48
2	21024-4	WASHER, LOCK (NO 8) DEPRESSOR	133				47
4	21024-4	WASHER, LOCK (NO 8) STRIPPER DEP & FINGER	132		459456-1	APPLICATOR, BASIC (SUB ASSY)	46
—	21899-4	WASHER, FLAT (5/16 DIA) SCREW ADJ	131	1	690191-1	PLUG, NYLON	45
—	21899-2	WASHER, FLAT (NO 10) LUB ASSY	130	1	455673-1	RAM	44
—	21018-5	NUT, HEX MACH (6-32) HOLDDOWN	129	1	690125-1	WASHER, LAMINATED	43
—	21018-5	NUT, HEX MACH (6-32) FEED ADJ	128	1	690124-3	WASHER, RAM	42
2	5-21006-6	SCR, SET (10-32 X .75) DRAG	127	8	1-22280-2	SPRING, INS. DISC	41
1	22353-8	SCR, SHLD. (.187 DIA X .250 LG) DRAG LEVER	126	2	23241-6	BALL, STEEL	40
1	456567-1	SCR, SHLD. (.188 DIA X 1.25 LG) STRIPPER	125	2	690170-1	SPRING, COMPRESSION	39
1	21009-2	SCR, SKT SET (1/4-20 X .25) (LOC-WEL) RAM	124	1	690142-1	DISC, INSULATION	38
2	21017-2	SCR, DRIVE, # 2 X .19	123	1	800834-1	DISC, WIRE	37
—	6-23715-5	SCR, PAN HD MACH (6-32 X 1.50) FEED ADJ	122	1	22480-5	WASHER, SPRING	36
1	461264-1	PLATE, IDENTIFICATION	121	1	690212-1	POST, RAM	35
2	2-21002-9	SCR, BUT HD SKT CAP (10-32 X .75) DRAG	120			SUPPORT, TERMINAL	34
1	2-21002-8	SCR, BUT HD SKT CAP (8-32 X .38) (LOC-WEL) ANVIL	119	1	800835-1	PLATE, BASE	33
4	2-21002-9	SCR, BUT HD SKT CAP (10-32 X .75) CAP	118	1	690432-3	SCREW, ADJUSTMENT	32
3	1-17177-1	SCR, BUT HD SKT CAP (1/4-20 X .62) HOUSING	117				31
1	2-21002-7	SCR, BUT HD SKT CAP (10-32 X .50) SG ADJ BLOCK	116	1	455689-1	BLOCK, STRIP GUIDE ADJ	30
2	2-21002-2	SCR, BUT HD SKT CAP (8-32 X .50) SHEAR	115	1	684045-2	PLATE, STRIP GUIDE	29
4	1-21000-3	SCR, SOCKET HD CAP (4-40 X .25) R STRIP GUIDE	114			SPACER, FRONT SHEAR DEPRESSOR	28
7	2-21000-7	SCR, SKT HD CAP (8-32 X .50) ANVIL, INSUL	113	2	22281-9	SPRING, DRAG	27
1	2-21003-0	SCR, FLAT HD SKT CAP (6-32 X .50) CAM	112	1	240793-4	LEVER, DRAG RELEASE	26
—	3-21000-4	SCR, SKT HD CAP (10-32 X .38) LUBRICATOR ASSY	111	1	240792-6	DRAG, STOCK	25
2	23030-1	SCR, SKT HD CAP (6-32 X .25) (LOC-WEL) CP DISC	110	1	690438-1	GUIDE STRIP (REAR)	24
4	1-21000-3	SCR, SKT HD CAP (10-32 X .50) REAR SHEAR PLATE	109	1	684042-2	GUIDE STRIP (FRONT)	23
2	2-21000-9	SCR, SKT HD CAP (8-32 X .75) DEPRESSOR	108	1	817682-1	SPACER, FRONT STRIP GUIDE	22
1	2-22603-0	SCR, HEX HD MACH (8-32 X .31) FEED FINGER	107	—	4-22284-9	SPRING, FEED RETURN	21
3	1-21000-4	SCR, SKT HD CAP (4-40 X .38) F STRIP GUIDE	106			ARM, STRIPPER	20
2	2-21000-7	SCR, SKT HD CAP (8-32 X .50) STRIPPER & ANVIL	105	1	690472-2	STRIPPER	19
2	3-21000-9	SCR, SKT HD CAP (10-32 X .100) AIR FEED ASS'Y	104	1	463460-3	HOLDER, TERMINAL	18
—	3-21000-6	SCR, SKT HD CAP (10-32 X .62) FEED ADJ BLOCK	103				17
1	3-21000-4	SCR, SKT HD CAP (10-32 X .38) SG ADJ BLOCK	102	—	803925-1	GUIDE, CARRIER STRIP	16
—	3-21000-4	SCR, SKT HD CAP (10-32 X .38) PIVOT BLOCK	101	1	803926-1	PLATE, SHEAR (REAR)	15
REF	462992-7	GUARD	79	1	467590-1	HOLDER, SHEAR (REAR)	14
—	1-465184-0	LUBRICATOR ASSY	78	1	469542-3	SHEAR, FLOAT (REAR)	13
—	692655-1	VALVE ASS'Y	77	1	5-22280-0	SPRING, SHEAR	12
REF	803931-1	BRACKET, HOLD DOWN	76	1	1-690461-1	STOP, SHEAR	11
1	568681-1	SPACER, BASE PLATE	75			HOLDER, SHEAR (FRONT)	10
—	458109-1	WASHER, SPECIAL	74	1	1-454766-3	ANVIL, INSULATION	9
2	690603-1	SPRING, ASSIST	73	1	800825-1	ANVIL, WIRE	8
—	690517-1	SPACER	72	1	240641-9	SPACER, DEPRESSOR (REAR)	7
2	23238-1	QUICK DISCONNECT	71	1	690468-6	DEPRESSOR, SHEAR (REAR)	6
48"	27319-4	TUBING 1/2 O.D.	70			DEPRESSOR, SHEAR (FRONT)	5
2	22294-6	ELBOW, MALE 1/8 NPT - 1/4 T	69	1	238009-1	SPACER, TUBULAR, INS CRIMPER	4
—	240633-1	BUSHING	68	1	2-454765-1	CRIMPER, INSULATION	3
—	455680-1	LEVER, INTERMEDIATE	67			SPACER, CRIMPER	2
—	240629-1	BLOCK, PIVOT	66	1	800880-1	CRIMPER, WIRE	1
—	240632-2	SCREW, ADJUSTMENT FEED ROD	65				
—	240659-3	PIN, CAM ROLLER	64				
—	240658-1	ROLLER, CAM	63				
—	454398-2	ROD, FEED	62				
—	454178-1	GUIDE, FEED ROD	60				

CRIMPING DATA				APPLICATOR WILL APPLY	
PAD LTR	CRIMP HEIGHT	WIRE SIZE	SOLDER DIA		
A	.080	14	.19		520402
B	.075	16	.19		520404
C	NOT USED				520406
D	NOT USED				520405

CRIMP	SIZE	TYPE	FEED	APPL INST
WIRE	.205	D		A1 8079
INSUL			.785	

WIRE RANGE	INSULATION RANGE	PRESS NO
16-14	.160 MAX	

REMARKS	NO	REV
APPL USED ON MACHINE PART NO	MACH SERIAL NO	DISTRIBUTION
CUSTOMER NAME	APPL SERIAL NO	ORIGINAL
ADDRESS	PURCHASE ORDER	CUSTOMER COPY
CITY	ENG APP	FIELD ENG COPY

SET UP GAGE	10-1
458637-1	1213
DR 8-25-78	APP
CHK 8-25-78	REL

LOG	NO	REV
A	680042-1	REV A

NAME	MINIATURE QUICK CHANGE APPLICATOR
NAME	SIDE FEED (FULLY INSULATED FASTON)