

4

3

2


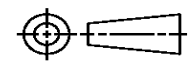
1

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LOC	DIST	REVISIONS			
P	LTR	DESCRIPTION	DATE	DWN	APVD
	F1	ECR-16-002691	2MAR2016	RS	UG

THIS PART NUMBER IS OBSOLETE (NO LONGER ACTIVE OR PRODUCED).
 THE CUSTOMER SHOULD CONTACT THEIR SALES REPRESENTATIVE OR TAC
 TO IDENTIFY THE APPLICATOR THAT WILL PROCESS THE TERMINAL TO BE APPLIED.
 IF ONE DOES NOT EXIST, A REQUEST TO QUOTE A NEW APPLICATOR WILL NEED TO
 BE PROCESSED.

FOR REPLACEMENT PARTS FOR APPLICATOR 680516
 REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED)
 WILL REMAIN AVAILABLE.

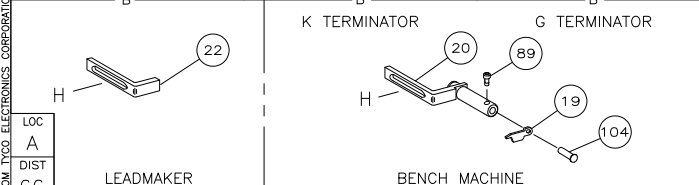
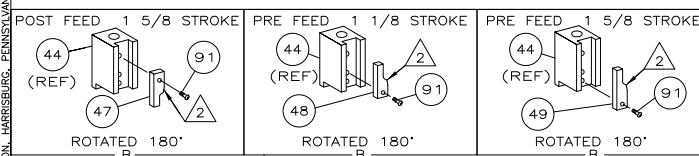
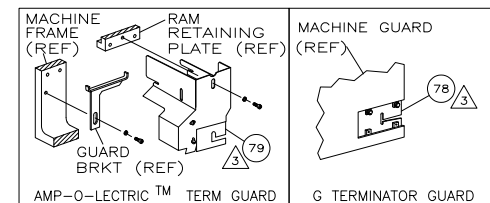
THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN R.SHEN	 TE Connectivity		
DIMENSIONS:		CHK LJ.ZHANG			
		APVD U.GUO	NAME SIDE FEED HDM APPLICATOR		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	APPLICATION SPEC		
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		WEIGHT	SIZE A3	CAGE CODE	DRAWING NO ©- 680516
MATERIAL		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	SHEET 1 OF 3 REV F1

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED	CARRIER STRIP
680516-1	F	122500-1	LEADMAKER	MECH POST FEED	CUT
680516-2	F	565435-5	BENCH MODEL K	MECH PRE FEED	CUT
680516-3	F	354500-1	BENCH MODEL G	MECH PRE FEED	CUT
680516-4	F	122500-1	LEADMAKER	MECH POST FEED	NO CUT
680516-5	F	565435-5	BENCH MODEL K	MECH PRE FEED	NO CUT
680516-6	F	354500-1	BENCH MODEL G	MECH PRE FEED	NO CUT

TERMINAL NAME: TERMINAL, MALE, METRI PACK							
AMP				MFR			
286618		12034047		CRIMPING DATA			
286804		12020119		CRIMP HEIGHT		WIRE SIZE	
		A		.059 ±.002 [1.50 ±.05mm]		1.00mm ²	
		B		.049 ±.002 [1.25 ±.05mm]		0.8 OR 0.5mm ²	
		C		NOT		USED	
		D		NOT		USED	
		CRIMP		SIZE		TYPE	
		WIRE		.090 [2.29mm]		F	
		INSUL		.130 [3.30mm]		F	
WIRE STRIP LENGTH		TERM APPL SPEC		FEED .490		APPL INSTRUCTION	
.219-.250		NONE		.625		408-8040	
				SET UP GAGE		LAYOUT	
				458637-1		L1977	

QTY REQD PER ASSY	DESCRIPTION	ITEM NO
129		
128		
2	2 2 2 2 2 2 -	3-354779-4 PIN, SIRE DISC (.3160)B
2	2 2 2 2 2 2 -	1-354779-4 PIN, WIRE DISC (.3060)A
1	1 1 1 1 1 1 -	986950-1 WASHER, FLAT PRECISION
1	1 1 1 1 1 1 -	217238-1 GENERAL INSTRUCTION PACKAGE
1	1 1 1 1 1 1 -	4088040 SF APPL INST 408-8040
122		
1	1 1 1 1 1 1 -	4-21028-0 PIN,SLT SPR(Ø.093x.75)ST GDE PL
REF	REF REF REF REF REF REF -	1-21030-1 PIN,DOWEL(Ø.187x.50)LEVER
REF	REF REF REF REF REF REF -	1-21030-6 PIN,DOWEL(Ø.187x1.25)HOUSING
REF	REF REF REF REF REF REF -	21045-3 RING,RET "C"(Ø.187)FD FING PIN
1	1 1 1 1 1 1 -	21024-5 WASHER, LOCK(#10)ADJ BLOCK
REF	REF REF REF REF REF REF -	21024-5 WASHER,LOCK(#10)ADJ PLATE
REF	REF REF REF REF REF REF -	21024-5 WASHER,LOCK(#10)FEED GDE ROD
2	2 2 2 2 2 2 -	21024-2 WASHER,LOCK(#4)FRONT STP GUIDE
REF	REF REF REF REF REF REF -	5-21028-1 PIN,SLT SPR(Ø.125x.50)ADJ ROD
112		
4	4 4 4 4 4 4 -	21024-4 WASHER,LOCK(#8)STRIPPER
REF	REF REF REF REF REF REF -	21899-4 WASHER,FLAT(Ø5/16)SCREW ADJ
109		
1	1 1 1 1 1 1 -	21018-5 NUT,HEX(NO.6)HOLDDOWN
REF	REF REF REF REF REF REF -	21018-5 NUT,HEX(6-32)FEED ADJ
106		
1	1 1 1 1 1 1 -	22353-8 SCR,SHLD(Ø.187x.25)DRAG LEVER
1	1 1 1 1 1 1 -	992031-1 PIN, CLEVIS
1	1 1 1 1 1 1 -	21009-2 SCR,SKT SET(1/4-20x.25 LW)RAM
2	2 2 2 2 2 2 -	21017-2 SCR,DRIVE(#2x.19)ID PLATE
REF	REF REF REF REF REF REF -	6-23715-5 SCR,PAN HD(6-32x1.50)FEED ADJ
100		
1	1 1 1 1 1 1 -	461264-1 PLATE, IDENTIFICATION
2	2 2 2 2 2 2 -	3-21002-0 SCR,BHC(10-32x.88)DRAG
1	1 1 1 1 1 1 -	22733-8 SCR,BHC(8-32x.38 LW)ANVIL
REF	REF REF REF REF REF REF -	2-21002-9 SCR,BHC(10-32x.75)CAP
REF	REF REF REF REF REF REF -	2-22733-8 SCR,BHC(1/4-20x.62)HOUSING
REF	REF REF REF REF REF REF -	2-21002-7 SCR,BHC(10-32x.50)SG ADJ BLOCK
2	2 2 2 2 2 2 -	2-21002-3 SCR,BHC(8-32x.58)TERM H DWN
6	6 6 6 6 6 6 -	2-21002-2 SCR,BHC(3-32x.50)R STP GDE
92		
1	1 1 1 1 1 1 -	1-21002-7 SCR,BHC(6-32x.38)CAM
90		
1	1 1 1 1 1 -	7-21000-9 SCR,SHC(4-40x.19)STRIPPER
89		
88		
87		
1	1 1 1 1 1 1 -	2-22603-0 SCR,HEX HD(8-32x.31)FEED FINGER
2	2 2 2 2 2 2 -	1-21000-3 SCR,SHC(4-40x.25)F ST GUIDE
3	3 3 3 3 3 3 -	2-21000-7 SCR,SHC(8-32x.50)STRIPPER
REF	REF REF REF REF REF REF -	3-21000-7 SCR,SHC(10-32x.75)FEED ROD GD
REF	REF REF REF REF REF REF -	3-21000-6 SCR,SHC(10-32x.62)FD ADJ BLK
1	1 1 1 1 1 1 -	3-21000-4 SCR,SHC(10-32x.38)SG ADJ BL
REF	REF REF REF REF REF REF -	3-21000-4 SCR,SHC(10-32x.38)PIVOT BLK
79		
REF	REF REF REF REF -	455749-1 GUARD, WINDOW
REF	REF REF REF REF -	679532-1 INSERT, GUARD
78		
77		
76		
75		
1	1 1 1 1 1 1 -	690603-1 SPRING, ASSIST
1	1 1 1 1 1 1 -	23030-1 SCR,SHC(6-32x.25 SL)INS DISC
REF	REF REF REF REF REF REF -	458109-1 WASHER, SPECIAL
REF	REF REF REF REF REF REF -	690517-1 SPACER
71		
-6	-5 -4 -3 -2 -1 U/M	PART NO
		DESCRIPTION
		ITEM NO
PARTS LIST		

QTY REQD PER ASSY	DESCRIPTION	ITEM NO
REF	REF REF REF REF REF REF -	22594-8 NUT,HEX(1/2-20)
REF	REF REF REF REF REF REF -	240628-1 PLATE, ADJUSTMENT
REF	REF REF REF REF REF REF -	240626-1 SHAFT, PIVOT
REF	REF REF REF REF REF REF -	240633-1 BUSHING
REF	REF REF REF REF REF REF -	455680-1 LEVER, INTERMEDIATE
REF	REF REF REF REF REF REF -	240629-1 BLOCK, PIVOT
REF	REF REF REF REF REF REF -	240632-2 SCREW, ADJ FEED ROD
REF	REF REF REF REF REF REF -	240659-3 PIN, CAM ROLLER
REF	REF REF REF REF REF REF -	240658-1 ROLLER, CAM
REF	REF REF REF REF REF REF -	454398-2 ROD, FEED
REF	REF REF REF REF REF REF -	454178-1 GUIDE, FEED ROD
REF	REF REF REF REF REF REF -	454220-1 CAP, RAM
REF	REF REF REF REF REF REF -	454485-1 HOUSING
57		
1	1 1 1 1 1 1 -	458537-2 PAWL, FEED
REF	REF REF REF REF REF REF -	240624-1 PIN, FEED FINGER
REF	REF REF REF REF REF REF -	691499-1 SPRING, FEED FINGER
REF	REF REF REF REF REF REF -	690541-1 HOLDER, FEED FINGER
REF	REF REF REF REF REF REF -	455679-2 LEVER, TERMINAL FEED ARM
1	1 1 1 1 1 1 -	811242-2 BUMPER, HOLDDOWN
1	1 1 1 1 1 1 -	690753-1 SPACER, TONKER
49		
1	- - - 1 - - -	690602-6 CAM, PRE-FEED 1 5/8 ST
- 1	- - - 1 - - -	690602-5 CAM, PRE-FEED 1 1/8 ST
- - 1	- - - 1 - - -	690501-4 CAM, POST-FEED 1 5/8 ST
1	1 1 1 1 1 1 -	459456-2 APPLICATOR, BASIC (SUBASSY)
1	1 1 1 1 1 1 -	690191-1 PLUG, NYLON
1	1 1 1 1 1 1 -	455673-1 RAM
1	1 1 1 1 1 1 -	690125-1 WASHER, LAMINATED
1	1 1 1 1 1 1 -	690124-1 WASHER, RAM
1	1 1 1 1 1 1 -	690686-1 BOLT, CRIMPER(5/16x1.00)
1	1 1 1 1 1 1 -	23241-6 BALL, STEEL
1	1 1 1 1 1 1 -	690170-1 SPRING, COMPRESSION
1	1 1 1 1 1 1 -	690142-1 DISC, INSULATION
1	1 1 1 1 1 1 -	354777-1 WIRE DISC, PLASTIC
1	1 1 1 1 1 1 -	22480-5 WASHER, SPRING
1	1 1 1 1 1 1 -	690212-1 POST, RAM
1	1 1 1 1 1 1 -	690786-5 SUPPORT, TERMINAL
REF	REF REF REF REF REF REF -	455675-1 PLATE, BASE
1	1 1 1 1 1 1 -	690432-3 SCREW, ADJUSTMENT
31		
REF	REF REF REF REF REF REF -	455689-1 BLOCK, STRIP GUIDE ADJ
1	1 1 1 1 1 1 -	3-458144-3 PLATE, STRIP GUIDE
1	1 1 1 1 1 1 -	1-455888-5 SPACER, FRONT SHEAR DEP
2	2 2 2 2 2 2 -	1-22284-0 SPRING, DRAG
1	1 1 1 1 1 1 -	240793-1 LEVER, DRAG RELEASE
1	1 1 1 1 1 1 -	240792-1 DRAG, TERMINAL
1	1 1 1 1 1 1 -	6-690504-1 GUIDE, STRIP (REAR)
1	1 1 1 1 1 1 -	690438-1 GUIDE, STRIP (FRONT)
- - 1	- - - 1 - - -	690472-2 STRIPPER
REF	REF REF REF REF REF REF -	4-22284-9 SPRING, FEED RETURN
1	1 1 - 1 1 - -	679218-1 STRIPPER WIRE STOP ASSY
1	1 1 - 1 1 - -	458949-1 STRIPPER
18		
17		
1	1 1 1 1 1 1 -	318563-1 GUARD, CHIP, FRONT
15		
14		
1	1 1 1 - - - -	679625-1 HOLDER, SHEAR NO-CUT
1	1 1 1 1 1 1 -	3-22280-3 SPRING, SHEAR
1	1 1 1 1 1 1 -	690461-1 STOP, SHEAR
- - -	- 1 1 1 - -	690459-1 HOLDER, SHEAR (FRONT)
1	1 1 1 1 1 1 -	1-454276-9 SHEAR, FLOAT (FRONT)
1	1 1 1 1 1 1 -	1-662187-5 ANVIL
1	1 1 1 1 1 1 -	240641-2 SPACER, DEPRESSOR (REAR)
6		
1	1 1 1 1 1 1 -	1-455889-4 DEPRESSOR, SHEAR (FRONT)
1	1 1 1 1 1 1 -	238011-2 SPACER, BLOCK CRIMPER
1	1 1 1 1 1 1 -	8-456134-0 CRIMPER, INSULATION
1	1 1 1 1 1 1 -	1-455888-5 SPACER, CRIMPER
1	1 1 1 1 1 1 -	1-456406-6 CRIMPER, WIRE
1		
-6	-5 -4 -3 -2 -1 U/M	PART NO
		DESCRIPTION
		ITEM NO
PARTS LIST		



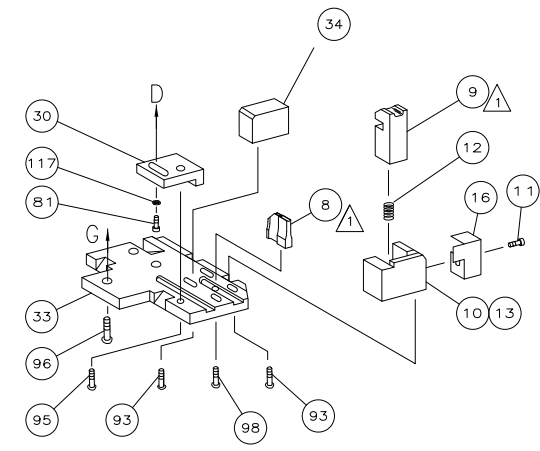
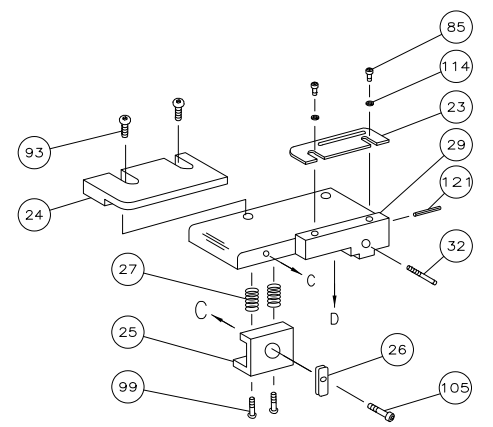
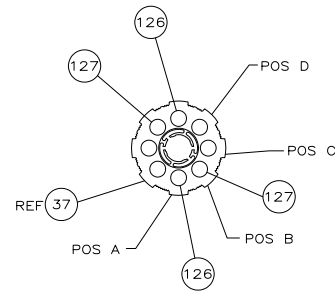
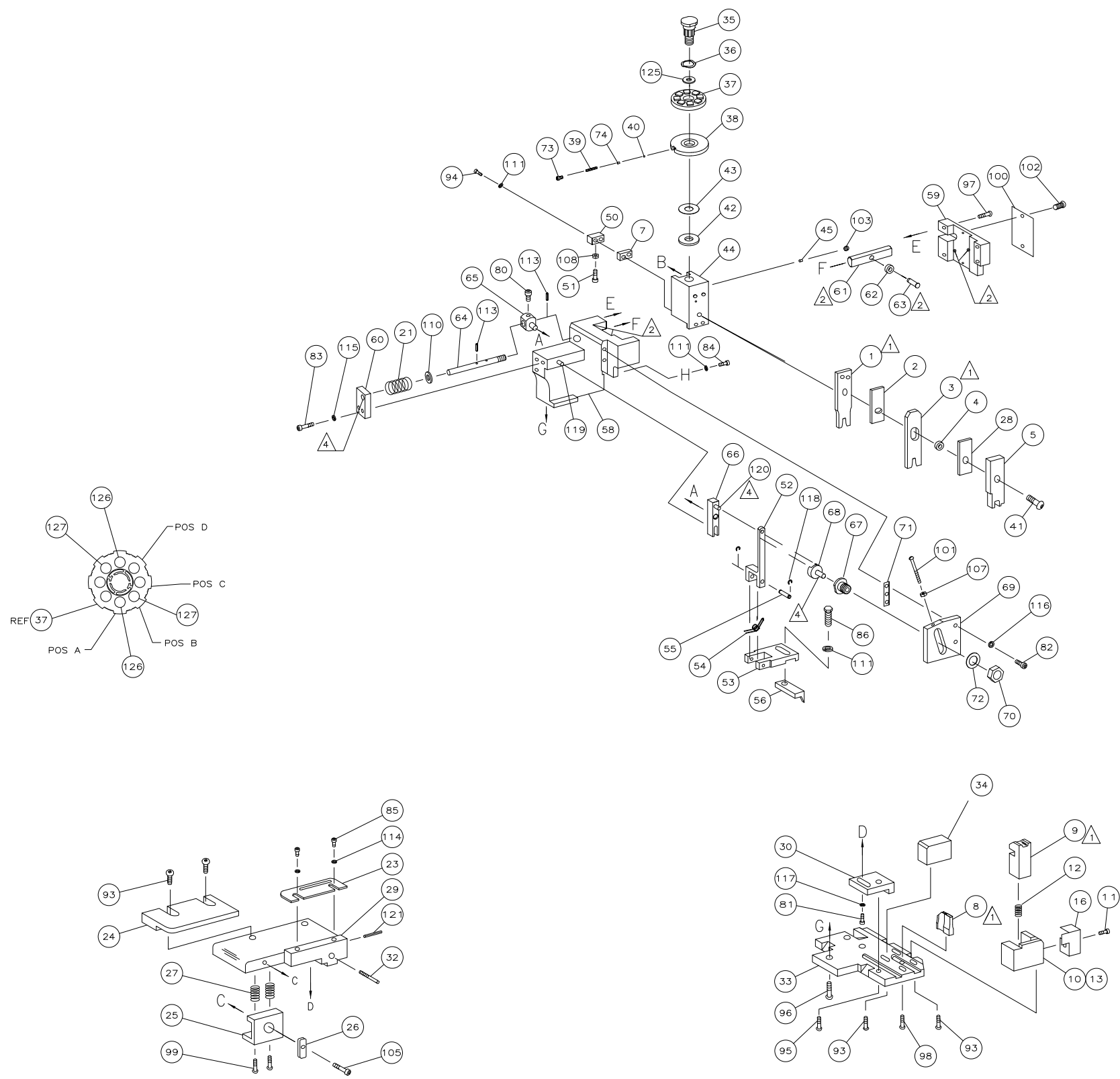
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LOC A
DIST 66
3308-B (1/08)

TE Connectivity
Harrisburg, PA 17105-3608

SCALE: 1:1 SIZE: A1 DRAWING NO: 680516 SHEET 1 OF 2 REV F

GUSTOMER ACCESSIBLE PRODUQTION DRAWING



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LOC
A
 DIST
66
 3308-8 (1/08)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
INCHES	0 PLC ± .010	1 PLC ± .005	2 PLC ± .003
	3 PLC ± .002	4 PLC ± .001	
ANGLES	SURFACE TEXTURE		
SEE SHEET 1	DATE	DNV	APVD
REVISION RECORD		DATE	DNV
SCALE: 1:1		SIZE: A1	DRAWING NO: 680516
SHEET 2 OF 2		REV F	

CUSTOMER ACCESSIBLE PRODUCTION DRAWING