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| PART NUMBER | REV | FIRST USED |        |
|-------------|-----|------------|--------|
| 680834-1    | H   | 122500-1   | T-UNIT |
| 680834-2    | J   | 680017-4   | K-UNIT |
| 680834-3    | H   | 354500-1   | G-UNIT |

- SUPERSEDED BY 680834-1  
- SUPERSEDED BY 680834-1

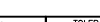
| CRIMPING DATA       |                 |                            |                 | THIS<br>APPLICATOR<br>WILL APPLY |
|---------------------|-----------------|----------------------------|-----------------|----------------------------------|
| PAD<br>LETTER       | CRIMP<br>HEIGHT | WIRE<br>SIZE               | STRIP<br>LENGTH | TERMINAL<br>P/N                  |
| A                   | .073            | #14                        | .231-.234       | 521217                           |
| B                   | .068            | 2 #18                      | .231-.234       | 521451                           |
| C                   | .064            | #16                        | .231-.234       | 521747                           |
| D                   | .058            | #18/(2)#20                 | .231-.234       |                                  |
| CRIMP               | SIZE            | TYPE                       | FEED            |                                  |
| WIRE                | .110            | F                          |                 |                                  |
| INS.                | .210            | F                          | .770            |                                  |
| INSULATION<br>RANGE | WIRE<br>RANGE   | TERM APPL SPEC<br>114-2124 |                 |                                  |
| .130-.180           | 18-14           | AI SHEET 8095 &<br>8098    |                 |                                  |

1. RECOMMENDED SPARE PARTS
2. ITEMS NOT SHOWN
3. TOL  $\pm .25$
4. TO RUN THIS APPLICATOR ON THE AMPOMATOR SEE DOC. PACKAGE ITEM 146.
5. USE SEALANT PN 1-23419-5 AS SHOWN
6. CANNOT RUN 2 WIRES ON LEADMAKER.
7. SPRING LOADED TONKER (P/N 354853-1) MUST BE USED WHEN RUNNING THE APPLICATOR ON A LEADMAKER.
8. FOR INSULATION DIAMETER OF .108"-.118" REPLACE ITEM #98 WITH OVERLAP INSULATION CRIMPER PN 3-318903-4

[illegible][illegible]

|                                                                                                                     |    | J1                     |    | REVISED PER ECR-23-190D96 |          | 18OCT2023  |                               | GK |  | TE |         |
|---------------------------------------------------------------------------------------------------------------------|----|------------------------|----|---------------------------|----------|------------|-------------------------------|----|--|----|---------|
|                                                                                                                     |    | SUPERSEDED BY 680834-1 |    |                           |          |            |                               |    |  |    |         |
|                                                                                                                     |    | SUPERSEDED BY 680834-1 |    |                           |          |            |                               |    |  |    |         |
| △                                                                                                                   | 1  | 1                      | 1  | -                         | A        | 852248-1   | STRIPPER                      |    |  |    | 70      |
|                                                                                                                     |    |                        | 1  | -                         | B        | 852245-2   | CAM, INSERT                   |    |  |    | 69      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 68      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | B        | 852246-1   | CAM,VALVE                     |    |  |    | 67      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 66      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | D        | 856287-1   | RAM                           |    |  |    | 65      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 64      |
| △                                                                                                                   | 1  | -                      | 1  | -                         | A        | 22374-7    | EXHAUST QUICK                 |    |  |    | 63      |
|                                                                                                                     | 1  | -                      | 1  | -                         | A        | 22304-1    | NIPPLE, HEX 1/8 NPT           |    |  |    | 62      |
| △                                                                                                                   | 1  | 1                      | 1  | -                         | A        | 1-23619-6  | PIN,GROOVED .188 DIA          |    |  |    | 61      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | A        | 852298-1   | LINK                          |    |  |    | 60      |
|                                                                                                                     | 4  | 4                      | 4  | -                         | A        | 21045-3    | CRESCENT RING                 |    |  |    | 59      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | A        | 4-23619-0  | PIN,GROOVED, .188 DIA         |    |  |    | 58      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | B        | 852296-1   | CLEVIS                        |    |  |    | 57      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 56      |
|                                                                                                                     | 5  | 5                      | 5  | -                         | A        | 6-21002-1  | SCR,BHC (10-24X.25)AIR CYL    |    |  |    | 55      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 54      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | B        | 852323-2   | MOUNT,AIR CYL.                |    |  |    | 53      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | B        | 852297-1   | ARM,PIVOT                     |    |  |    | 52      |
| △                                                                                                                   | 1  | 1                      | 1  | -                         | C        | 856265-2   | ANVIL                         |    |  |    | 51      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | A        | 985314-1   | AIR CYL., 3/4 BORE X 7/16 ST. |    |  |    | 50      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | C        | 852295-1   | ROD,BACKUP                    |    |  |    | 49      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 48      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | A        | 21021-4    | NUT,FLEXLOC 10-32             |    |  |    | 47      |
| △                                                                                                                   | 1  | 1                      | 1  | -                         | C        | 1-852294-0 | BACKUP, TERMINAL .160         |    |  |    | 46      |
| △                                                                                                                   | 1  | 1                      | 1  | -                         | C        | 1-852294-1 | BACKUP, TERMINAL .140         |    |  |    | 45      |
| △                                                                                                                   | 3  | 3                      | 3  | -                         | A        | 21899-2    | WASHER, FLAT                  |    |  |    | 44      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | C        | 1-852294-2 | BACKUP, TERMINAL .120         |    |  |    | 43      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 42      |
| △                                                                                                                   | 1  | 1                      | 1  | -                         | C        | 1-852294-3 | BACKUP, TERMINAL .187         |    |  |    | 41      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | C        | 852250-5   | GUIDE,FRONT STRIP             |    |  |    | 40      |
|                                                                                                                     | 2  | 2                      | 2  | -                         | A        | 22354-6    | STUD,8-32                     |    |  |    | 39      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | B        | 852251-3   | DRAG                          |    |  |    | 38      |
|                                                                                                                     | 2  | 2                      | 2  | -                         | A        | 2-22280-5  | SPRING, COMP. LC-032C-6       |    |  |    | 37      |
|                                                                                                                     | 2  | 2                      | 2  | -                         | A        | 21022-2    | NUT,FLEXLOC 8-32              |    |  |    | 36      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | B        | 90594-1    | GUIDE, REAR STRIP             |    |  |    | 35      |
|                                                                                                                     | 4  | 4                      | 4  | -                         | A        | 1-21899-3  | WASHER FLAT #8                |    |  |    | 34      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 33      |
| △                                                                                                                   | 1  | 1                      | 1  | -                         | B        | 90591-2    | SHEAR, LEFT                   |    |  |    | 32      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 31      |
| △                                                                                                                   | 1  | 1                      | 1  | -                         | B        | 853981-2   | SHEAR, RIGHT                  |    |  |    | 30      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 29      |
|                                                                                                                     | 4  | 4                      | 4  | -                         | A        | 2-21002-2  | SCR., BUT.HD. 8-32X.50        |    |  |    | 28      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | D        | 856231-2   | PLATE, STRIP GUIDE            |    |  |    | 27      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 26      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 25      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 24      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 23      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 22      |
|                                                                                                                     | 3  | 4                      | 3  | -                         | A        | 23030-2    | SCR. SOC.HD. 6-32X.38 LOK-WEL |    |  |    | 21      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 20      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 19      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 18      |
|                                                                                                                     | 13 | 13                     | 13 | -                         | A        | 2-21002-1  | SCR, BHC 8-32 x .38           |    |  |    | 17      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 16      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 15      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 14      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | A        | 354993-1   | AIR CYL 1 1/8 X .63           |    |  |    | 13      |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 12      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | A        | 5-21028-1  | PIN, SPRING .125 DIA x .50    |    |  |    | 11      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | A        | 1-23470-7  | SPRING, COMP. LC-035C-19      |    |  |    | 10      |
|                                                                                                                     | 1  | 1                      | 1  | -                         | B        | 90777-1    | GIB, HOUSING                  |    |  |    | 9       |
|                                                                                                                     | 1  | 1                      | 1  | -                         | D        | 318198-2   | INSERTOR, POD                 |    |  |    | 8       |
|                                                                                                                     | 1  | 1                      | 1  | -                         | A        | 22733-8    | SCR.,BUT.HD.8-32X.38          |    |  |    | 7       |
|                                                                                                                     | 1  | 1                      | 1  | -                         | D        | 90775-2    | HOUSING, INSERT SLIDE         |    |  |    | 6       |
|                                                                                                                     |    |                        |    |                           |          |            |                               |    |  |    | 5       |
|                                                                                                                     | 1  | 1                      | 1  | -                         | B        | 1338955-4  | HOLDDOWN, FIXED               |    |  |    | 4       |
|                                                                                                                     | 3  | 3                      | 3  | -                         | A        | 2-22733-8  | SCR. BUT HD 1/4-20 X .62      |    |  |    | 3       |
|                                                                                                                     | 1  | 1                      | 1  | -                         | D        | 314866-3   | PLATE, BASE                   |    |  |    | 2       |
|                                                                                                                     | 1  | 1                      | 1  | -                         | D        | 852221-2   | HOUSING, APPLICATOR           |    |  |    | 1       |
|                                                                                                                     | -3 | -2                     | -1 | U/M                       | DWG SIZE | PART NO    | DESCRIPTION                   |    |  |    | ITEM NO |
| <div><div>REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)</div><div>QTY REQD PER ASSYPARTS LIST</div></div> |    |                        |    |                           |          |            |                               |    |  |    |         |

| REVISIONS |     |                           |           |     |      |
|-----------|-----|---------------------------|-----------|-----|------|
| P         | LTR | DESCRIPTION               | DATE      | DWN | APVD |
|           | J1  | REVISED PER ECR-23-190096 | 18OCT2023 | GK  | TE   |

|                                                                                       |                                        |                                                                                          |                               |                                                                                                            |
|---------------------------------------------------------------------------------------|----------------------------------------|------------------------------------------------------------------------------------------|-------------------------------|------------------------------------------------------------------------------------------------------------|
| MACHINE REF<br>MINI APPL                                                              | THIS DRAWING IS A CONTROLLED DOCUMENT. |                                                                                          | DWN<br>C.ERISMAN<br>22JUN1999 |  TE Connectivity Ltd. |
|                                                                                       |                                        |                                                                                          | CHK<br>C.ERISMAN<br>22JUN1999 |                                                                                                            |
| DIMENSIONS:<br>INCHES                                                                 |                                        | TOLERANCES UNLESS<br>OTHERWISE SPECIFIED:                                                | APP'D<br>T.F.BIN<br>22JUN1999 | NAME                                                                                                       |
|  |                                        | 0 PLC ± .<br>1 PLC ± .<br>2 PLC ± .02<br>3 PLC ± .005<br>4 PLC ± .0005<br>ANGLES ± 0°30' | PRODUCT SPEC                  | ULTRA-POD APPLICATOR .250 STRAIGHT                                                                         |
| MATERIAL                                                                              | -                                      | FINISH                                                                                   | 125                           |                                                                                                            |
| WEIGHT                                                                                |                                        |                                                                                          | SIZE                          |                                                                                                            |
| -                                                                                     |                                        |                                                                                          | A1 00779 C-680834             |                                                                                                            |
| CUSTOMER DRAWING                                                                      |                                        |                                                                                          | RESTRICTED TO                 |                                                                                                            |
|                                                                                       |                                        |                                                                                          | -                             |                                                                                                            |
|                                                                                       |                                        |                                                                                          | SCALE                         | 1:1                                                                                                        |
|                                                                                       |                                        |                                                                                          | SHEET                         | 1 of 2                                                                                                     |
|                                                                                       |                                        |                                                                                          | REV                           | J                                                                                                          |

| REVISIONS |           |             |      |    |       |
|-----------|-----------|-------------|------|----|-------|
| #         | DATE      | DESCRIPTION | DATE | BY | APP'D |
| 1         | 22JUN1999 | SEE SHEET 1 |      |    |       |

D

C

B

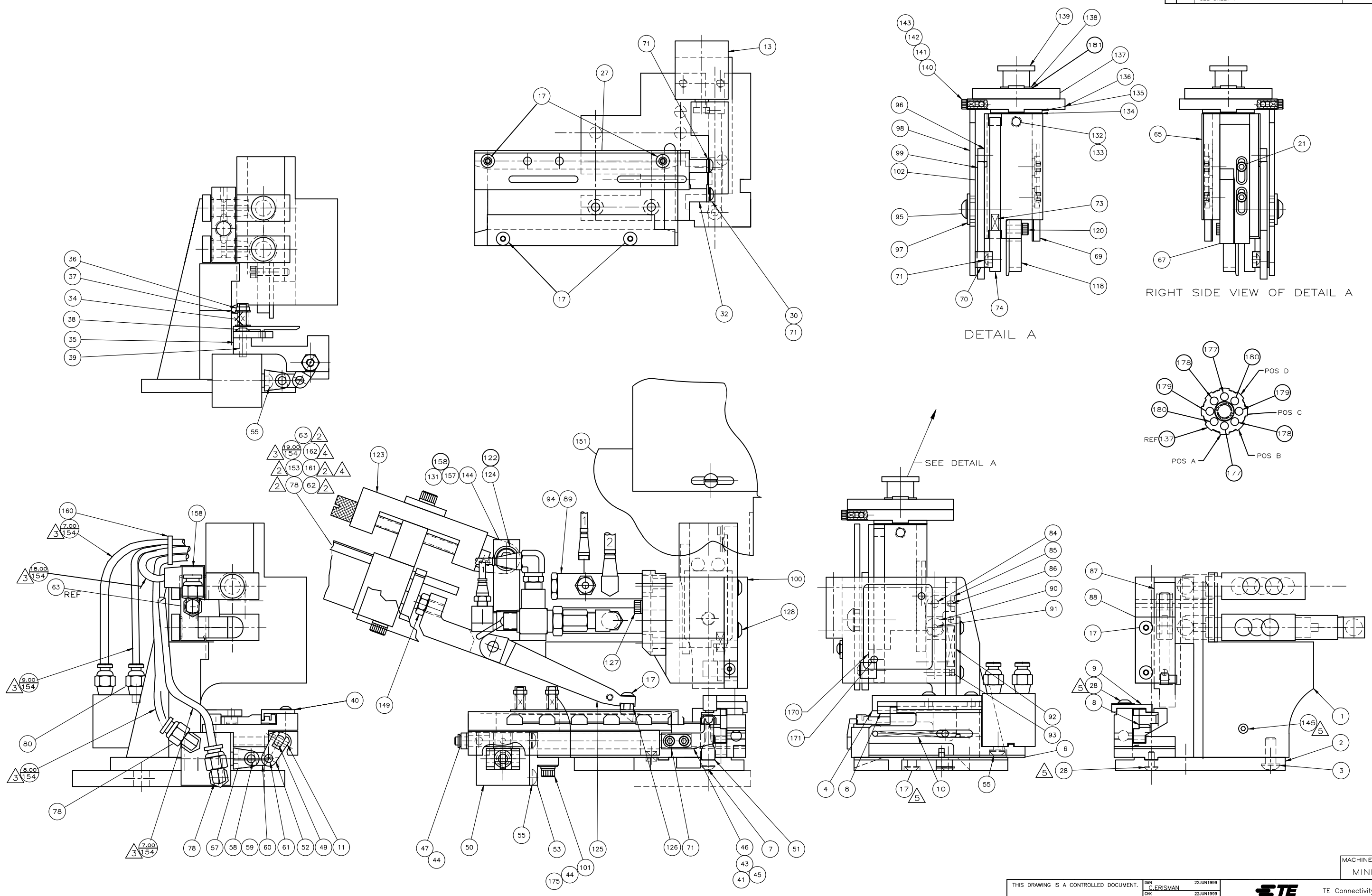
A

D

C

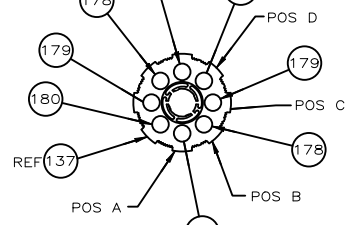
B

A



RIGHT SIDE VIEW OF DETAIL A

DETAIL A



SEE DETAIL A

|                                        |  |                               |                                            |  |  |
|----------------------------------------|--|-------------------------------|--------------------------------------------|--|--|
| THIS DRAWING IS A CONTROLLED DOCUMENT. |  | DWN<br>C.ERISMAN<br>22JUN1999 | MACHINE REF<br>MINI APPL                   |  |  |
| DIMENSIONS:<br>INCHES                  |  | CHK<br>C.ERISMAN<br>22JUN1999 | NAME<br>ULTRA-POD APPLICATOR .250 STRAIGHT |  |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | APP'D<br>T.ELRIN<br>22JUN1999 | PRODUCT SPEC                               |  |  |
| 0.00                                   |  | 1.00                          | APPLICATION SPEC                           |  |  |
| 1.00                                   |  | 2.00                          | WEIGHT                                     |  |  |
| 2.00                                   |  | 3.00                          | SIZE                                       |  |  |
| 3.00                                   |  | 4.00                          | CAGE CODE                                  |  |  |
| 4.00                                   |  | 5.00                          | DRAWING NO                                 |  |  |
| 5.00                                   |  | 6.00                          | RESTRICTED TO                              |  |  |
| 6.00                                   |  | 7.00                          | A1 00779                                   |  |  |
| 7.00                                   |  | 8.00                          | C-680834                                   |  |  |
| 8.00                                   |  | 9.00                          | CUSTOMER DRAWING                           |  |  |
| 9.00                                   |  | 10.00                         | SCALE 1:1 SHEET 2 OF 2 REV J1              |  |  |

CUSTOMER AND ASSEMBLY DRAWING