Lock All Fields

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LOC	DIST

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	D1	ECR-13-004734	15MAR2013	XZ	LZ

Dimensioning and tolerancing per ASME Y14.5M-2009

REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2151300-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1528506
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 1528506

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN X. ZHAO	TE Connectivity
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	CHK L. ZHANG	NAME FINE ADJ SIDE FD HD-I APPL
	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	APVD L. ZHANG PRODUCT SPEC APPLICATION SPEC	SIZE A3 / CAGE CODE / DRAWING NO C-1528506 / RESTRICTED TO
MATERIAL	FINISH	WEIGHT	SCALE / SHEET 1 OF 2 / REV D1

1470-19 (3/11)

Pro/ENGINEER DRAWING

DRAWING MADE IN THIRD ANGLE PROJECTION

1528506 ⇔ 1528506

/home/us024474/tecmod

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1528506-1	D	-	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528506-2	D	-	BENCH	MECH PRE FEED	CUTS CARRIER
1528506-6	D	-	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528506-1	D	-	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528506-2	D	-	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528506-6	D	-	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528506-7	A	-	-	-	SPARE PARTS KIT

CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: MCP 1.2MM CONTACT ASSEMBLY

CRIMP	SIZE	TYPE	RANGE
WIRE	1.40 [.055 IN]	F	0.50-0.75mm² or 20AWG
INSUL	1.83 [.072 IN]	SPECIAL	1.40-1.90 [.055-.075 IN] △5

WIRE STRIP LENGTH 3.30-3.90 [.130-.154 IN]

APPL INSTRUCTION 408-8322 & 408-8490

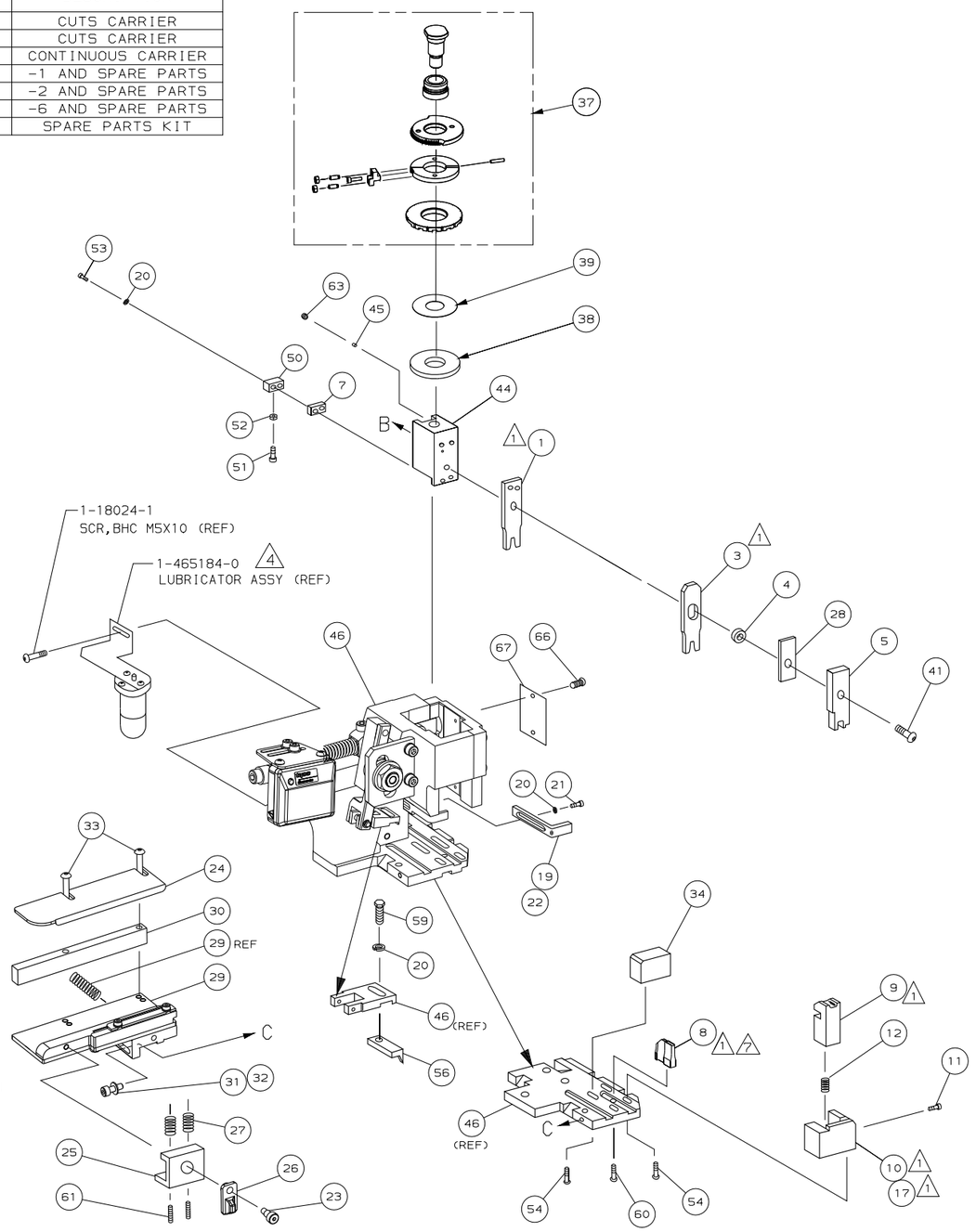
TERMINAL	-	-	FEED
APPL SPEC	114-18464 △6	-	8.00 [.315 IN]

TERMINALS APPLIED

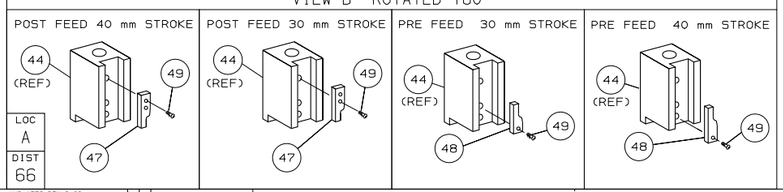
1418760	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-

WIRE SIZE mm² AWG	CRIMP HEIGHT *	REF SETTING
0.75mm²	1.05 ±0.03 [.041 ±.001 IN]	B 5
0.50mm²	0.93 ±0.03 [.037 ±.001 IN]	C 4
20 AWG	0.93 ±0.03 [.037 ±.001 IN]	C 4
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

1. RECOMMENDED SPARE PARTS.
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
4. CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.
5. THIS APPLICATOR HAS BEEN DESIGNED TO APPLY WIRES WITH THIN-WALL (FLR) INSULATION.
6. MAXIMUM INSULATION CRIMP WIDTH 2.05mm & MAXIMUM INSULATION CRIMP HEIGHT 2.05mm. SEE APPLICATION SPECIFICATION TO CLARIFY.
7. DUE TO THE DEMANDS OF APPLICATION SPEC 114-18464 IT IS IMPORTANT, IF THE ANVIL IS MOVED OR REPLACED, THAT IT IS BIASED TOWARDS THE OPERATOR'S POSITION AS FAR AS POSSIBLE WHEN RE-SECURING TO THE BASE PLATE.

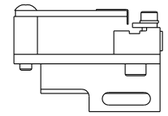


VIEW B ROTATED 180°



* WARNING:

ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



GUIDE OFF INSULATION BARREL

TOOLING APPROVED BY GB GATD & TERMINAL PRODUCT ENGINEERING GERMANY.

ITEM NO	DESCRIPTION	PART NO	-77	-76	-72	-71	-6	-2	-1
1	CRIMPER, WIRE	3-456402-3	1	2	2	2	1	1	1
2									
3	CRIMPER, INSULATION	1752766-1	1	2	2	2	1	1	1
4	SPACER, BLOCK CRIMPER	4-238011-2	-	1	1	1	1	1	1
5	DEPRESSOR, SHEAR (FRONT)	562605-2	-	1	1	1	1	1	1
6									
7	SPACER, DEPRESSOR (REAR)	5-240641-0	-	1	1	1	1	1	1
8	ANVIL	1333231-5	1	2	2	1	1	1	1
9	SHEAR, FLOAT (FRONT)	1-879745-2	-	1	1	1	1	1	1
10	HOLDER, SHEAR, FRONT (CUT)	1320921-1	-	-	1	1	-	1	1
11	SHEAR, FRONT	356885-4	-	1	1	1	1	1	1
12	SPRING, SHEAR	5-22280-0	-	1	1	1	1	1	1
13									
14									
15									
16									
17	HOLDER, SHEAR, FRONT (NO-CUT)	1338684-1	-	1	-	-	1	-	-
18									
19	PARTS LIST	QTY REQD PER ASSY							
20	REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)								
21	PART NO	DESCRIPTION							
22	1528506	PRINT, APPLICATOR LOG SHEET	-	1	1	1	1	1	1
23	1338705-3	DOCUMENTATION PACKAGE	-	1	1	1	1	1	1
24									
25									
26	461264-5	PLATE, IDENTIFICATION	-	1	1	1	1	1	1
27	21017-2	SCR,DRIVE (#2x.19) ID PLATE	-	2	2	2	2	2	2
28									
29	3-18031-0	SCR,SKT SET (M6X6) RAM	-	1	1	1	1	1	1
30									
31	2-18032-5	SCR,SKT SET (M5X20) DRAG	-	2	2	2	2	2	2
32	18024-7	SCR,BHC (M4X10) ANVIL	-	1	1	1	1	1	1
33	5-18022-2	SCR,HEX (M4X8) FEED FINGER	-	1	1	1	1	1	1
34									
35									
36									
37									
38	1338685-1	PAWL, FEED	-	1	1	1	1	1	1
39									
40									
41	2-18024-6	SCR,BHC (M8X25) RAM	-	1	1	1	1	1	1
42									
43									
44	1338660-1	RAM	-	1	1	1	1	1	1
45	690191-1	PLUG, NYLON	-	1	1	1	1	1	1
46	1320999-3	APPLICATOR BASIC SUBASSY	-	1	1	1	1	1	1
47	1338676-1	CAM, POST FEED 30 & 40 mm ST	-	1	-	1	-	1	-
48	1338675-1	CAM, PRE FEED 30 & 40 mm ST	-	-	1	-	-	1	-
49	18024-3	SCR,BHC (M3X10) CAM	-	1	1	1	1	1	1
50	811242-5	BUMPER, HOLDDOWN	-	1	1	1	1	1	1
51	690753-2	SPACER, TONKER	-	1	1	1	1	1	1
52	18030-1	NUT,HEX (M3) HOLD DOWN	-	1	1	1	1	1	1
53	1-18023-3	SCR,SHC (M4X16) TERM HLD DWN	-	2	2	2	2	2	2
54	18024-8	SCR,BHC (M4X12) SHEAR HOLDER	-	4	4	4	4	4	4
55									
56	690125-1	SHIM SUBASSY	-	1	1	1	1	1	1
57									
58									
59	469367-8	SPACER, FINE ADJUST	-	1	1	1	1	1	1
60	879103-3	FINE ADJUST HEAD SUBASSY	-	1	1	1	1	1	1
61									
62									
63	1320934-6	SUPPORT, TERMINAL	-	1	1	1	1	1	1
64	1-18024-0	SCR,BHC (M4X20) STRIP GUIDE	-	2	2	2	2	2	2
65	18027-2	WASHER, FLAT (M4)	-	1	1	1	1	1	1
66	1-18023-2	SCR,SKT CAP (M4X12) MOUNT BLOCK	-	1	1	1	1	1	1
67	1-1320908-5	SPACER, STRIP GUIDE	-	1	1	1	1	1	1
68	1633073-2	STRIP GUIDE PLATE ASSY	-	1	1	1	1	1	1
69	455888-6	SPACER, FRONT SHEAR DEP	-	1	1	1	1	1	1
70	1-22284-0	SPRING, DRAG	-	2	2	2	2	2	2
71	356835-1	LEVER, DRAG RELEASE	-	1	1	1	1	1	1
72	240792-1	DRAG, TERMINAL	-	1	1	1	1	1	1
73	1320928-5	PLATE, STRIP GUIDE	-	1	1	1	1	1	1
74	980371-4	SCR,SHC SHLD	-	1	1	1	1	1	1
75	690472-2	STRIPPER	-	1	-	1	-	1	1
76	1-18023-1	SCR,SHC (M4X10) STRIPPER	-	1	1	1	1	1	1
77	18025-2	WASHER,LOCK (M4) STRIPPER	-	4	4	4	4	4	4
78	1424364-1	STRIPPER	-	-	1	-	-	1	-
79									
80									
81									
82									
83									
84									
85									
86									

P	F	LTR	REVISION RECORD	APP	DATE
		D	ECR-06-007489	RK	MAR06

DIMENSIONS: mm [INCHES]
DO NOT SCALE PRINT.
TOLERANCES UNLESS OTHERWISE SPECIFIED:
1 PLC DEC ±-
2 PLC DEC ±-
3 PLC DEC ±-
ANGLES ± -
SURF TEXTURE: √
REMOVE BURRS, BREAK SHARP EDGES R0.38 MAX

MATL - - HT TR - - FIN - -

DR L.LOFTHOUSE 28SEP05 APP F.BACKHURST 28SEP05
CHK - - REL L.LOFTHOUSE 16NOV05

AMP Tyco Electronics Harrisburg, PA 17105-3608

NAME FINE ADJ SIDE FD HD-I APPL
MACHINE REF HD-I APPL
SCALE - D DWG NO 1528506 SHEET 1 OF 1 REV D

CAGE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO -

Dimensioning and tolerancing per ASME Y14.5M-2009
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LAYOUT L1426281
SET UP GAGE 458637-3

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AMP 1756 REV 3-92 27-MAR-06 14:19:29 us024474

8 7 6 5 4 3 2 1

DRAWING NUMBER - 1528506 SHEET 2 OF 2 REV. D1