

4

3

2

1

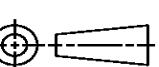
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				P LTR DESCRIPTION DATE DWN APVD			
				D2	ECR-13-013108	5SEP2013	RS LZ

# REPLACED BY OCEAN STYLE APPLICATOR PART

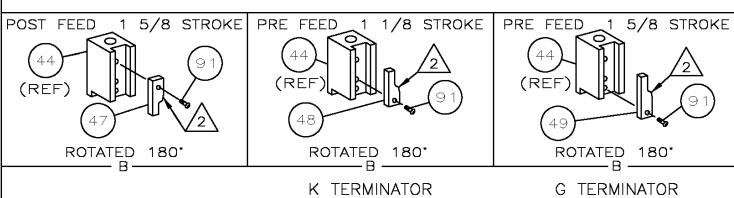
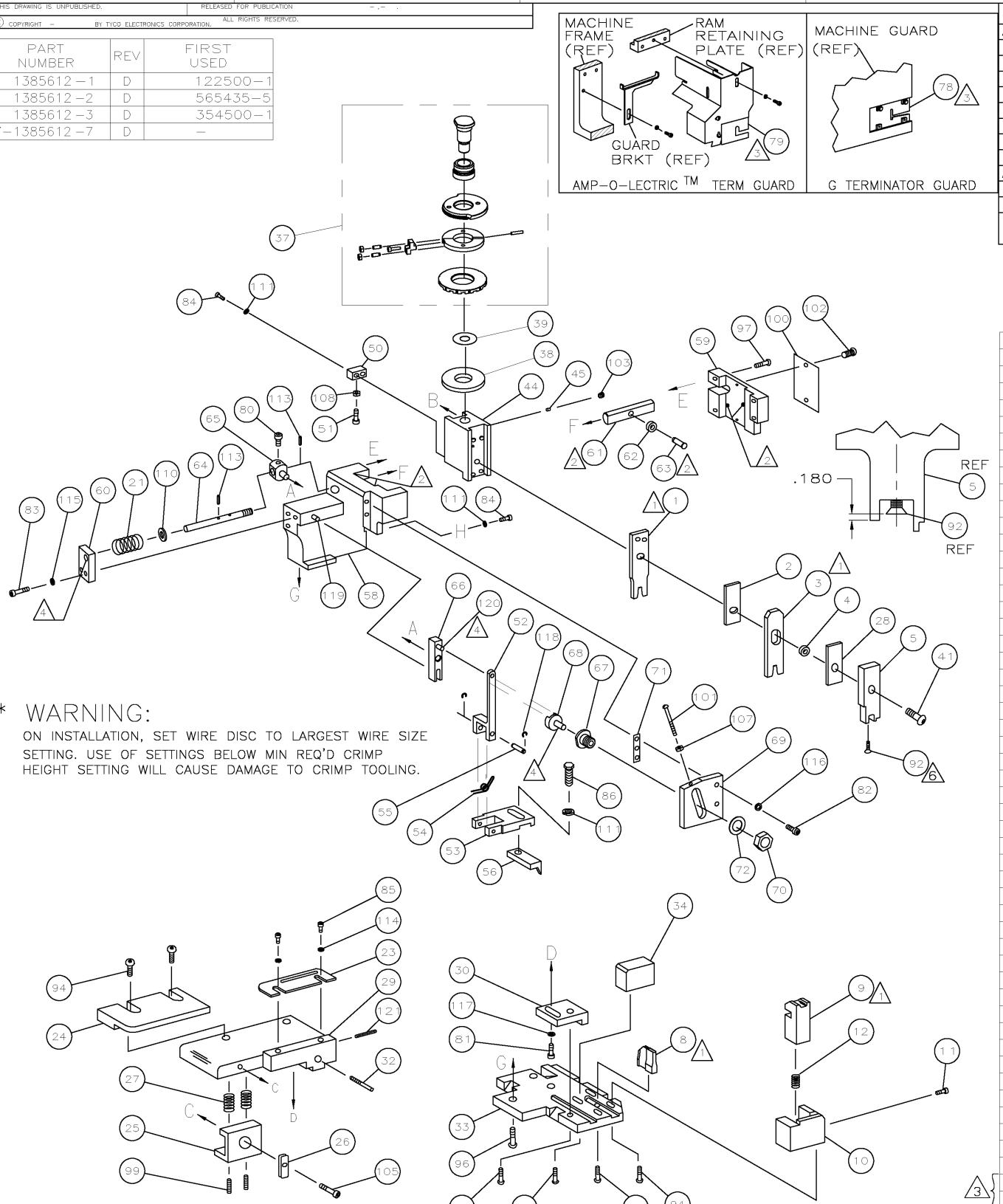
## NUMBER 2151853-2

FOR REPLACEMENT PARTS FOR APPLICATOR 1385612  
 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  
 1385612

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN R.SHEN		TE Connectivity	
DIMENSIONS:		CHK L.J.ZHANG			
		APVD U.GUO			
		PRODUCT SPEC			
		APPLICATION SPEC			
		NAME SIDE FEED HDM APPLICATOR			
MATERIAL	FINISH	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
		A 3		C- 1385612	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE	SHEET 1 OF 2 REV D2

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PART NUMBER	REV	FIRST USED	
1385612-1	D	122500-1	
1385612-2	D	565435-5	
1385612-3	D	354500-1	
7-1385612-7	D	—	



## RECOMMENDED SPARE PARTS

2 GREASE LIGHTLY

 GUARD MUST BE IN PLACE WHEN OPERATING  
APPLICATOR IN A BENCH MACHINE.

 4 LUBRICATE DAILY USING NO. 20 MACHINE OIL.

 5 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

 6 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE A

FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT  
QUALIFICATION. APPLY PN 1-23419-5 LOC-TITE TO THREADS.

✓. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.

TERMINAL NAME: CLIP 8mm		NG1-1 CAPACITE 3 A 6mm <sup>2</sup>		PRONER TERMINAL		PRONER CRIMP SPECS	
AMP TERM PN	MFR TERM PN	PAD LTR	CRIMP HEIGHT	WIRE SIZE	REF SETTING		
1544227-1	2398-C-001	A	.122 ±.002 [3.10 ±.05mm]	6 mm <sup>2</sup>	A4		
		B	.118 ±.002 [3.00 ±.05mm]	5 mm <sup>2</sup>	B1		
		C	.107 ±.002 [2.72 ±.05mm]	4 mm <sup>2</sup>	C8		
		D	.100 ±.002 [2.54 ±.05mm]	3 mm <sup>2</sup>	D6		
AMP SEAL PN		CRIMP	SIZE	TYPE	RANGE		
1544316-1	P8010489526	WIRE	.160 [4.06mm]	F	3-6 mm <sup>2</sup>		
		INSUL	.240 [6.10mm]	0V	3.6-4,1mm		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT		
.250-.267	NONE	.866	408-8040	458637-1	L2842		

							129
							128
							127
							126
							125
—	1	1	1	—	217238-1	GENERAL INSTRUCTION PACKAGE	124
—	1	1	1	—	4088040	SF APPL INST 408-8040	123
							122
—	1	1	1	—	3-21028-6	PIN,SLT SPR(Φ093x.50)ST GDE PL	121
—	1	1	1	—	1-21030-1	PIN,DOWEL(Φ.187x.50)LEVER	120
—	1	1	1	—	1-21030-6	PIN,DOWEL(Φ.187x1.25)HOUSING	119
—	2	2	2	—	21045-3	RING,RET "C"(Φ.187)FD FING PIN	118
—	3	3	3	—	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
—	2	2	2	—	21024-5	WASHER,LOCK(#10)ADJ PLATE	116
—	2	2	2	—	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115
—	2	2	2	—	21024-2	WASHER,LOCK(#4)FRONT STP. GUIDE	114
—	2	2	2	—	5-21028-1	PIN,SLT SPR(Φ.125x.50)ADJ ROD	113
							112
—	4	4	4	—	21024-4	WASHER,LOCK(#8)STRIPPER	111
—	1	1	1	—	21899-4	WASHER,FLAT(Φ5/16)SCREW ADJ	110
							109
—	1	1	1	—	21018-5	NUT,HEX(NO.6)HOLDDOWN	108
—	1	1	1	—	21068-5	NUT,HEX(6-32)FEED ADJ	107
							106
—	1	1	1	—	22353-8	SCR,SHLD(Φ.187x.25)DRAG LEVER	105
							104
—	1	1	1	—	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
—	2	2	2	—	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
—	1	1	1	—	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
—	1	1	1	—	461264-5	PLATE, IDENTIFICATION	100
—	2	2	2	—	5-21006-6	SCR,SET(10-32x.75)DRAG	99
—	1	1	1	—	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
—	4	4	4	—	2-21002-9	SCR,BHC(10-32x.75)CAP	97
—	3	3	3	—	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
—	1	1	1	—	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
—	6	6	6	—	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
							93
—	1	1	1	—	1-21003-9	SCR,FHC(6-32x.38)DEP	92
—	1	1	1	—	1-21002-7	SCR,BHC(6-32x.38)CAM	91
							90
							89
							88
							87
—	1	1	1	—	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
—	2	2	2	—	1-21000-3	SCR,SHC(4-40x.25)FR ST GUIDE	85
—	3	3	3	—	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
—	2	2	2	—	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
—	2	2	2	—	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	82
—	1	1	1	—	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
—	1	1	1	—	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	80
—	—	1	—	—	462992-7	GUARD ASSY	79
—	REF	—	—	—	679532-1	INSERT, GUARD	78
							77
							76
							75
							74
							73
—	1	1	1	—	458109-1	WASHER, SPECIAL	72
—	1	1	1	—	690517-1	SPACER	71
—77	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
PARTS LIST							
QTY	REQD	PER ASSY					

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DW	APVD
		D1		ECR-11-020807	10-2011	RS	SX
-1	LEADMAKER	MECH	POST	FEED			
-2	BENCH MODEL K	MECH	PRE	FEED			
-3	BENCH MODEL G	MECH	PRE	FEED			
-	1	1	1	-	22594-8	NUT, HEX(1/2-20)	70
-	1	1	1	-	240628-1	PLATE, ADJUSTMENT	69
-	1	1	1	-	240626-1	SHAFT, PIVOT	68
-	1	1	1	-	240633-1	BUSHING	67
-	1	1	1	-	455680-1	LEVER, INTERMEDIATE	66
-	1	1	1	-	240629-1	BLOCK, PIVOT	65
-	1	1	1	-	240632-2	SCREW, ADJ FEED ROD	64
-	1	1	1	-	240659-3	PIN, CAM ROLLER	63
-	1	1	1	-	240658-1	ROLLER, CAM	62
-	1	1	1	-	454398-2	ROD, FEED	61
-	1	1	1	-	454178-1	GUIDE, FEED ROD	60
-	1	1	1	-	454220-1	CAP, RAM	59
-	1	1	1	-	454485-1	HOUSING	58
							57
-	1	1	1	-	3-694433-0	PAWL, FEED	56
-	1	1	1	-	240624-1	PIN, FEED FINGER	55
-	1	1	1	-	691499-1	SPRING, FEED FINGER	54
-	1	1	1	-	690541-1	HOLDER, FEED FINGER	53
-	1	1	1	-	455679-2	LEVER, TERMINAL FEED ARM	52
-	1	1	1	-	811242-2	BUMPER, HOLDDOWN	51
-	1	1	1	-	690753-1	SPACER, TONKER	50
-	1	-	-	-	690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	-	1	-	-	690602-5	CAM, PRE-FEED 1 1/8 ST	48
-	-	-	1	-	690501-4	CAM, POST-FEED 1 5/8 ST	47
							46
-	1	1	1	-	690191-1	PLUG, NYLON	45
-	1	1	1	-	819307-6	RAM	44
							43
							42
-	1	1	1	-	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41
							40
-	1	1	1	-	690125-1	SHIM	39
-	1	1	1	-	469367-1	SPACER, FINE ADJUST	38
-	1	1	1	-	879103-2	FINE ADJUST HEAD SUBASSY	37
							36
							35
-	1	1	1	-	690786-3	SUPPORT, TERMINAL	34
-	1	1	1	-	318055-4	PLATE, BASE	33
-	1	1	1	-	690432-3	SCREW, ADJUSTMENT	32
							31
-	1	1	1	-	455689-1	BLOCK, STRIP GUIDE ADJ	30
-	1	1	1	-	5-458144-0	PLATE, STRIP GUIDE	29
-	1	1	1	-	455888-6	SPACER, FRONT SHEAR DEP	28
-	2	2	2	-	1-22284-0	SPRING, DRAG	27
-	1	1	1	-	240793-1	LEVER, DRAG RELEASE	26
-	1	1	1	-	240792-1	DRAG, TERMINAL	25
-	1	1	1	-	9-690504-0	GUIDE, STRIP (REAR)	24
-	1	1	1	-	1-690438-0	GUIDE, STRIP (FRONT)	23
-	-	-	1	-	690472-2	STRIPPER	22
-	1	1	1	-	4-22284-9	SPRING, FEED RETURN	21
							20
-	1	1	-	-	691353-1	STRIPPER	19
							18
							17
							16
							15
							14
							13
-	1	1	1	-	3-22280-3	SPRING, SHEAR	12
-	1	1	1	-	690461-3	STOP, SHEAR	11
-	1	1	1	-	679625-4	HOLDER, SHEAR (FRONT)	10
-	1	1	1	-	318059-4	SHEAR, FLOAT (FRONT)	9
1	1	1	1	-	3-318711-5	ANVIL	8
							7
							6
-	1	1	1	-	122399-4	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	-	3-238011-0	SPACER, BLOCK CRIMPER	4
1	1	1	1	-	5-854830-5	CRIMPER, INSULATION	3
-	1	1	1	-	2-455888-7	SPACER, CRIMPER	2
1	1	1	1	-	1-456414-1	CRIMPER, WIRE	1
-77	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
PARTS LIST							
QTY	REQD	PER ASSY					

DRAWING IS A CONTROLLED DOCUMENT.		DWN R. KNEPPER		24JUL03	TE CONNECTIVITY	
DIMENSIONS: INCHES		TOLERANCES: UNLESS OTHERWISE SPECIFIED:		CHK	Harrisburg, PA 17105-3608	
	APVD	24JUL03		NAME		
	TLERIN	PRODUCT SPEC		SIDE FEED HDM APPLICATOR		
	—	APPLICATION SPEC		—		
	0.050 ± 0.005	—		—		
1.000 ± 0.005	—		—			
3.000 ± 0.025	—		—			
4.000 ± 0.025	—		—			
4 PLUG ANGLES		—		—		
FINISH		WEIGHT		SIZE   CAGE CODE   DRAWING NO   RESTRICTED TO		
—		F		A1   00779   C-1385612   —		
CUSTOMER DRAWING				SCALE	SHEET	1 OF 1 REV D1