

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

RELEASED FOR PUBLICATION

© COPYRIGHT

ALL RIGHTS RESERVED.

LOC

DIST

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A1	ECR-14-003639	12MAR2014	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2150056-2

FOR REPLACEMENT PARTS FOR APPLICATOR 1531014
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
1531014

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN GOPALAKRISHNA HV		 TE Connectivity			
DIMENSIONS:		CHK RAGHAVENDRA					
		APVD RAGHAVENDRA		NAME FINE ADJUST END FEED HDI APPLICATOR ASSY			
		PRODUCT SPEC					
		APPLICATION SPEC					
MATERIAL		WEIGHT		SIZE A3	CAGE CODE	DRAWING NO C- 1531014	RESTRICTED TO
FINISH		CUSTOMER DRAWING		SCALE		SHEET 1 OF 2	REV A1

8		7		
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		
(C) COPYRIGHT 20		20		
BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.				
PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1531014-1	A	BENCH & LEADMAKER	MECH POST FEED	HDI APPLICATOR
7-1531014-1	A	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1531014-7	A	-	-	SPARE PARTS KIT

CRIMP DATA		TE TERMINAL		TE CRIMP SPECS	
TERMINAL NAME: .250 FASTON RECEPTACLE					
CRIMP	SIZE	TYPE	RANGE		
WIRE	3.56 [.140 IN]	F	14-10 AWG		
INSUL	7.87 [.310 IN]	F	5.72-6.99 [.225- .275 IN] 3.56 [.140 IN] MAX X 2 14AWG		
WIRE STRIP LENGTH			APPL INSTRUCTIONS		
5.46-5.84 [.215- .230 IN]			408-8323 & 408-8490		
TERMINAL	114-2036	-		FEED	
APPL SPEC	-	-		21.46 [.845 IN]	

TERMINALS APPLIED

60635	-	-	-
63539	-	-	-
63419	-	-	-
-	-	-	-
-	-	-	-

WIRE SIZE	CRIMP HEIGHT	REF SETTING
10AWG	2.67 ±0.05 [.105 ±.002 IN]	B0
2 X 14AWG	2.39 ±0.05 [.094 ±.002 IN]	B9
12AWG	2.24 ±0.05 [.088 ±.002 IN]	D2
14AWG	1.93 ±0.05 [.076 ±.002 IN]	E3
-	-	-



RECOMMENDED SPARE PARTS

GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.

CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.

4. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

TO CRIMP 10 AWG WIRE USE ITEM 40 (.005 SHIM). DO NOT USE ITEM 39 (.010 SHIM).

TO CRIMP (2) 14 AWG WIRES OR 12 AWG WIRE USE ITEM 39 (.010 SHIM). DO NOT USE ITEM 40 (.005 SHIM).

TO CRIMP 14 AWG WIRE USE ITEMS 39 (.010 SHIM) AND 40 (.005 SHIM).

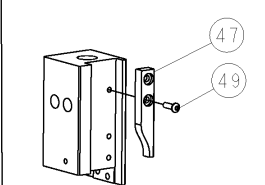
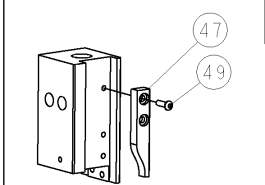
WIRE SIZE	
10 AWG	.005 SHIM
(2) 14 AWG	.010 SHIM
12 AWG	.010 SHIM
14 AWG	.010 SHIM & .005 SHIM

8. SETUP & QUALIFY APPLICATOR USING ITEMS 38 & 39.

VIEW B ROTATED 180°

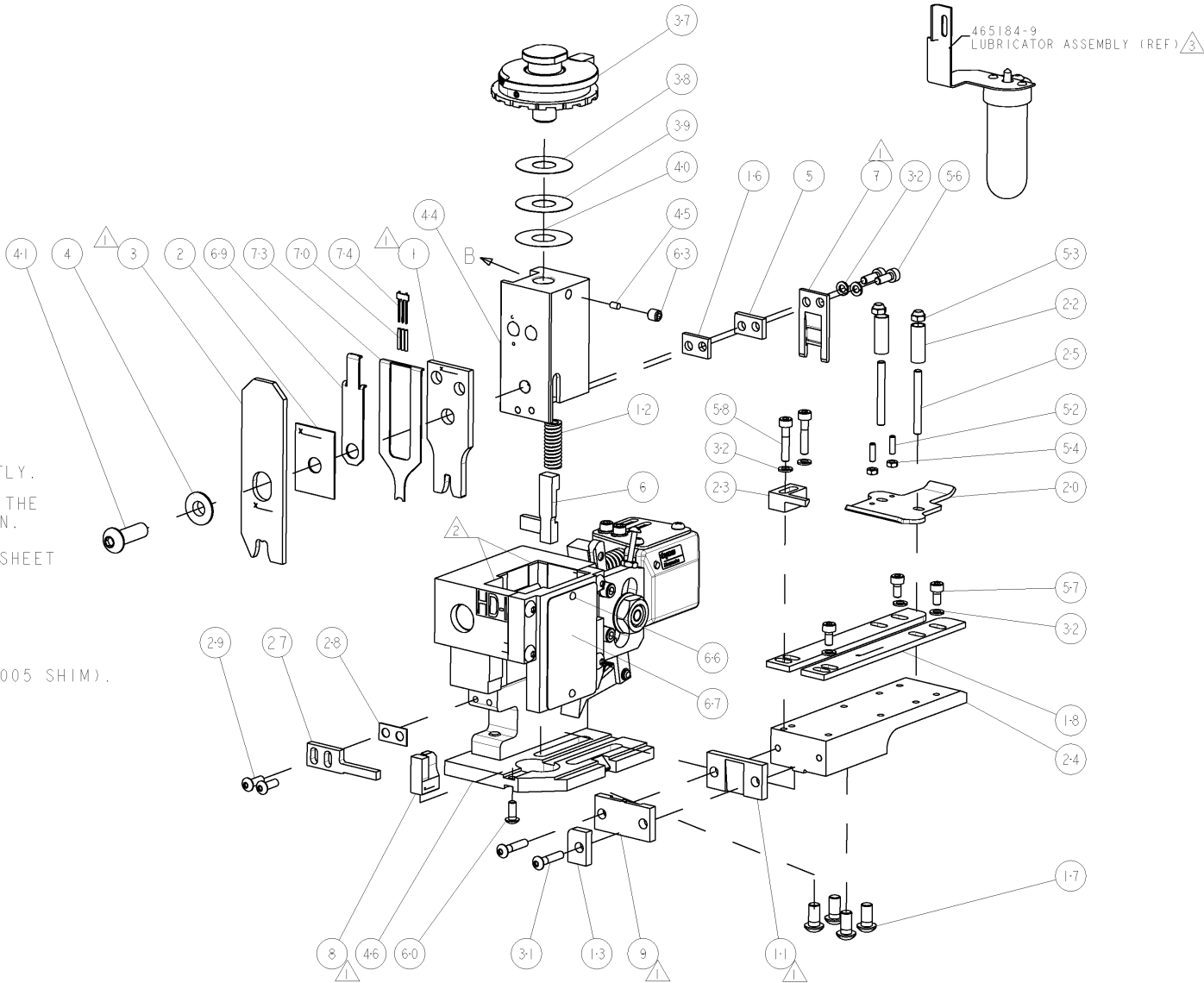
POST-FEED 40mm STROKE

POST-FEED 30mm STROKE



* 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.

SET UP GAGE
458638-3

LOC	DIST	REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE
		A	RELEASED		20NOV2008
					MEH
					GB

-	1	1	1424350-1	HOLDER, PIN, WIRED	74
-	1	1	1490525-5	DEPRESSOR, WIRE	73
-	1	1	1338705-4	DOCUMENTATION PACKAGE	71
-	3	3	2-23147-2	SPRING, COMPRESSION	70
-	1	1	1490524-2	DEPRESSOR, SPACER	69
-	1	1	461264-5	PLATE, IDENTIFICATION	67
-	2	2	21017-2	SCREW, DRIVE	66
-	1	1	3-18031-0	SCR, SET, CUP POINT M6 X 6.0	63
-	1	1	18024-7	SCR, BTN SKT HD CAP (M4 X 10.0)	60
-	2	2	1-18023-4	SCR, SKT HD CAP M4 X 20.0	58
-	3	3	1-18023-0	SCR, SKT HD CAP M4 X 8.0	57
-	2	2	1-18023-2	SCR, SKT HD CAP M4 X 12.0	56
-	2	2	18029-1	NUT, HEX, REG M3	54
-	2	2	986965-1	NUT, LOCK, HEX, TORQUE (M4)	53
-	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	52
-	1	1	18024-3	SCR, BTN SKT HD CAP (M3 X 10.0)	49
-	1	1	1338676-1	CAM, UNIVERSAL POST-FEED	47
-	1	1	1338662-2	SUB ASSY, APPLICATOR FRAME	46
-	1	1	690191-1	PLUG, NYLON	45
-	1	1	1333260-1	RAM	44
-	1	1	2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)	41
-	1	1	469367-2	SHIM	40
-	1	1	469367-1	SHIM	39
-	1	1	690125-1	SHIM SUB-ASSY	38
-	1	1	879103-2	FINE ADJUST HEAD ASSEMBLY	37
-	7	7	18025-2	WASHER, SPRG LOCK, REG M4	32
-	2	2	1-18024-0	SCR, BTN SKT HD CAP (M4 X 20.0)	31
-	2	2	18024-8	SCR, BTN SKT HD CAP (M4 X 12.0)	29
-	1	1	1-690451-7	SPACER, STRIPPER	28
-	1	1	690455-3	STRIPPER, FRONT CASTING	27
-	2	2	1320906-1	STUD, THREADED	25
-	1	1	1-1320995-2	PLATE, STRIP GUIDE	24
-	1	1	240825-5	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-6	SPRING, COMPRESSION	22
-	1	1	1338665-1	DRAG	20
-	2	2	454204-4	GUIDE, LOWER STRIP	18
-	4	4	1-18024-8	SCR, BTN SKT HD CAP (M6 X 12.0)	17
-	1	1	1338708-1	SPACER, SLUG BLADE	16
-	1	1	690481-2	SPACER, HOLD DOWN	13
-	1	1	23846-1	SPRING, DIE	12
-	1	1	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	4-690495-3	PLATE, FRONT SHEAR	9
-	1	2	4-1633383-8	ANVIL, COMBINATION	8
-	1	1	1-690474-9	BLADE, SLUG	7
-	1	1	1-455892-1	HOLD DOWN, TERMINAL	6
-	1	1	240641-8	SPACER	5
-	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	2	1-1213077-9	CRIMPER, INSULATION PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	456411-9	CRIMPER, WIRE PREMIUM	1

-77-71-1		PART NO	DESCRIPTION			ITEM NO
1. THE CUSTOMER'S RESPONSIBILITY FOR THE FOLLOWING INFORMATION IS LIMITED TO THE INFORMATION PROVIDED BY THE CUSTOMER. THE CUSTOMER'S RESPONSIBILITY FOR THE INFORMATION PROVIDED BY THE CUSTOMER IS LIMITED TO THE INFORMATION PROVIDED BY THE CUSTOMER.						
DRAWING NO.		130CT2008		Tyco Electronics		130CT2008
REV.		M. BETTIS		Tyco Electronics		130CT2008
DATE		130CT2008		Harrisburg, PA 17105-3608		130CT2008
APPROVED BY		M. CLIFFORD		NAME		130CT2008
PRODUCT SPEC		APPLICATION SPEC		FINE ADJUST END FEED		130CT2008
WEIGHT		SIZE		CASE CODE		130CT2008
CUSTOMER DRAWING		A1		00779		130CT2008
SCALE		3:5		SHEET		130CT2008
REV		A		REV		130CT2008
CUSTOMER VIEWABLE ASSEMBLY						130CT2008

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[1531014-1](#)