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LOC

DIST

REVISIONS

| P | LTR | DESCRIPTION | DATE | DWN | APVD |
|---|-----|-------------|------|-----|------|
|   |     |             |      |     |      |
|   |     |             |      |     |      |
|   |     |             |      |     |      |
|   |     |             |      |     |      |

D

C

B

A

REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER

FOR REPLACEMENT PARTS FOR APPLICATOR 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

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS:



TOLERANCES UNLESS OTHERWISE SPECIFIED:

|        |   |
|--------|---|
| 0 PLC  | ± |
| 1 PLC  | ± |
| 2 PLC  | ± |
| 3 PLC  | ± |
| 4 PLC  | ± |
| ANGLES | ± |

MATERIAL

FINISH

DWN

CHK

APVD

PRODUCT SPEC

APPLICATION SPEC

WEIGHT

TE Connectivity

NAME

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

A3

C-

SCALE

SHEET OF

REV

1470-19 (3/11)

Pro/ENGINEER DRAWING

DRAWING MADE IN THIRD ANGLE PROJECTION

1528213

1528213

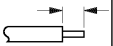
/home/eb003653/edmod

| PART NUMBER | REV | FIRST USED | TERMINATOR | FEED TYPE      | DESCRIPTION        |
|-------------|-----|------------|------------|----------------|--------------------|
| 1528213-1   | A   | -          | LEADMAKER  | MECH POST FEED | CUTS CARRIER       |
| 1528213-2   | A   | -          | BENCH      | MECH PRE FEED  | CUTS CARRIER       |
| 1528213-6   | A   | -          | LEADMAKER  | MECH POST FEED | CONTINUOUS CARRIER |
| 7-1528213-1 | A   | -          | LEADMAKER  | MECH POST FEED | -1 AND SPARE PARTS |
| 7-1528213-2 | A   | -          | BENCH      | MECH PRE FEED  | -2 AND SPARE PARTS |
| 7-1528213-6 | A   | -          | LEADMAKER  | MECH POST FEED | -6 AND SPARE PARTS |
| 7-1528213-7 | A   | -          | -          | -              | SPARE PARTS KIT    |

#### CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: 2.5mm SYSTEM, CONTACT SOCKET / PIN 

| CRIMP | SIZE           | TYPE | RANGE                                                                                            |
|-------|----------------|------|--------------------------------------------------------------------------------------------------|
| WIRE  | 2.79 [.110 IN] | F    | >1.00-2.50mm <sup>2</sup>                                                                        |
| INSUL | 4.32 [.170 IN] | 0    | 3.40 [.134 IN]  |

|                                                                                                            |                                                                                                       |
|------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------|
| WIRE STRIP LENGTH                                                                                          | APPL INSTRUCTION                                                                                      |
| 5.20-5.80 [.205-.228 IN]  | 408-8322 & 408-8490  |

|           |             |   |                                                                                                   |
|-----------|-------------|---|---------------------------------------------------------------------------------------------------|
| TERMINAL  | -           | - | FEED                                                                                              |
| APPL SPEC | 114-18031-1 | - | 14.50 [.571 IN]  |

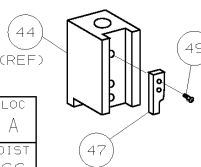
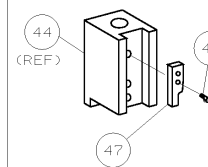
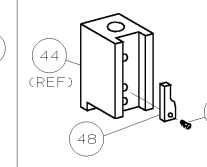
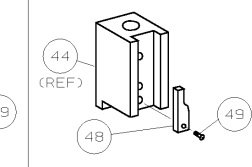
#### TERMINALS APPLIED

| TERMINAL | SEAL     | - | - | - |
|----------|----------|---|---|---|
| 928985   | 828921-1 | - | - | - |
| 928987   | -        | - | - | - |
| 965856   | -        | - | - | - |
| -        | -        | - | - | - |
| -        | -        | - | - | - |
| -        | -        | - | - | - |
| -        | -        | - | - | - |
| -        | -        | - | - | - |

| WIRE SIZE           | CRIMP HEIGHT                                                                      | REF SETTING                                                                       |
|---------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|
| mm <sup>2</sup> AWG |  |  |
| 2.50mm <sup>2</sup> | 1.81 ±0.05 [.071 ±.002 IN]                                                        | C 2                                                                               |
| 2.00mm <sup>2</sup> | 1.71 ±0.05 [.067 ±.002 IN]                                                        | C 7                                                                               |
| 1.50mm <sup>2</sup> | 1.57 ±0.05 [.062 ±.002 IN]                                                        | D 7                                                                               |

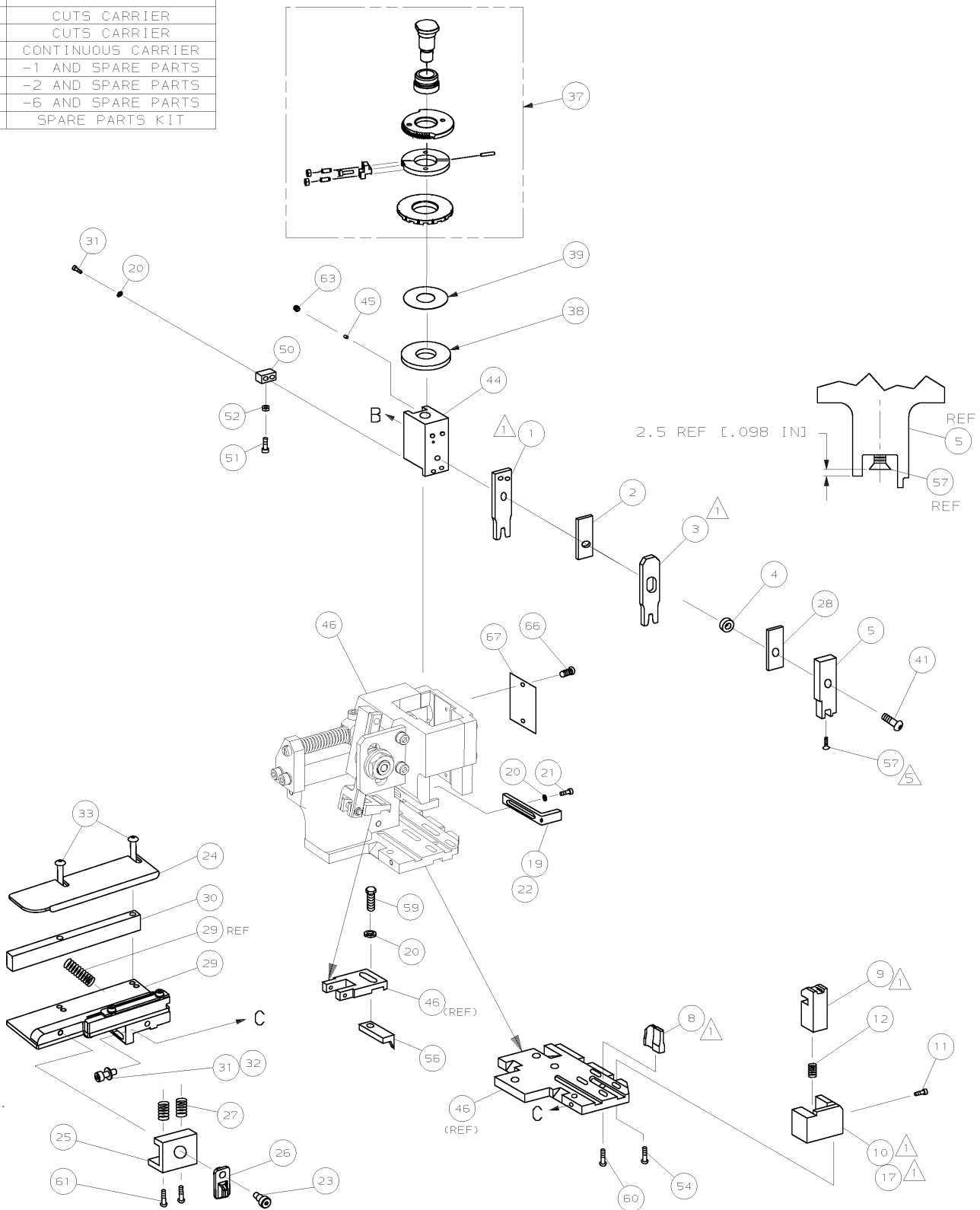
-  1. RECOMMENDED SPARE PARTS.
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  4. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION Ø QUOTED IS OUTER Ø OF SEAL & THE INSULATION DIAMETER IS DEPENDENT UPON SEAL BEING APPLIED.
-  5. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

#### VIEW B ROTATED 180°

| POST FEED 40 mm STROKE                                                              | POST FEED 30 mm STROKE                                                              | PRE FEED 30 mm STROKE                                                               | PRE FEED 40 mm 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.



|   |   |   |   |   |   |   |             |                                  |    |
|---|---|---|---|---|---|---|-------------|----------------------------------|----|
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1528213     | PRINT, APPLICATOR LOG SHEET      | 73 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1338705-3   | DOCUMENTATION PACKAGE            | 71 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 461264-5    | PLATE, IDENTIFICATION            | 67 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 21017-2     | SCR, DRIVE (#2x.19) ID PLATE     | 66 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 3-18031-0   | SCR, SKT SET (M6X6) RAM          | 63 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 1-18024-5   | SCR, BHC (M5X25) DRAG            | 61 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 18024-7     | SCR, BHC (M4X10) ANVIL           | 60 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 5-18022-2   | SCR, HEX (M4X8) FEED FINGER      | 59 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 985575-3    | SCR, FHC (M3X10) DEP             | 57 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1338685-1   | PAWL, FEED                       | 56 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 18024-8     | SCR, BHC (M4X12) SHEAR HOLDER    | 54 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 18030-1     | NUT, HEX (M3) HOLD DOWN          | 52 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 811242-5    | BUMPER, HOLDDOWN                 | 51 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 690753-2    | SPACER, TONKER                   | 50 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 18024-3     | SCR, BHC (M3X10) CAM             | 49 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1338675-1   | CAM, PRE FEED 30 & 40 mm ST      | 48 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1338676-1   | CAM, POST FEED 30 & 40 mm ST     | 47 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1320999-3   | APPLICATOR BASIC SUBASSY         | 46 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 690191-1    | PLUG, NYLON                      | 45 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1338660-1   | RAM                              | 44 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2-18024-6   | SCR, BHC (M8X25) RAM             | 41 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 690125-1    | SHIM SUBASSY                     | 39 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 469367-4    | SPACER, FINE ADJUST              | 38 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 879103-2    | FINE ADJUST HEAD SUBASSY         | 37 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 1-18024-0   | SCR, BHC (M4X20) STRIP GUIDE     | 33 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 18027-2     | WASHER, FLAT (M4)                | 32 |
| - | 3 | 3 | 3 | 3 | 3 | 3 | 1-18023-2   | SCR, SKT CAP (M4X12) MOUNT BLOCK | 31 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1320908-6   | SPACER, STRIP GUIDE              | 30 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1633073-1   | STRIP GUIDE PLATE ASSY           | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-455888-5  | SPACER, FRONT SHEAR DEP          | 28 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 1-22284-0   | SPRING, DRAG                     | 27 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 356835-1    | LEVER, DRAG RELEASE              | 26 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 240792-1    | DRAG, TERMINAL                   | 25 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1320928-1   | PLATE, STRIP GUIDE               | 24 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 980371-4    | SCR, SHC SHLD                    | 23 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 690472-2    | STRIPPER                         | 22 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-18023-1   | SCR, SHC (M4X10) STRIPPER        | 21 |
| - | 4 | 4 | 4 | 4 | 4 | 4 | 18025-2     | WASHER, LOCK (M4) STRIPPER       | 20 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 690472-1    | STRIPPER                         | 19 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1338684-2   | HOLDER, SHEAR, FRONT (NO-CUT)    | 17 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 5-22280-0   | SPRING, SHEAR                    | 12 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 356885-5    | STOP, SHEAR                      | 11 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-1320921-0 | HOLDER, SHEAR, FRONT (CUT)       | 10 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 318707-1    | SHEAR, FLOAT (FRONT)             | 9  |
| - | 1 | 2 | 2 | 2 | 2 | 2 | 3-1333207-4 | ANVIL                            | 8  |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1338680-5   | DEPRESSOR, SHEAR (FRONT)         | 5  |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 238011-2    | SPACER, BLOCK CRIMPER            | 4  |
| - | 1 | 2 | 2 | 2 | 2 | 2 | 904741-3    | CRIMPER, INSULATION              | 3  |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 455888-9    | SPACER, CRIMPER                  | 2  |
| - | 1 | 2 | 2 | 2 | 2 | 2 | 3-456408-9  | CRIMPER, WIRE                    | 1  |

|     |     |     |     |    |    |    |                                                         |             |         |
|-----|-----|-----|-----|----|----|----|---------------------------------------------------------|-------------|---------|
| -77 | -76 | -72 | -71 | -6 | -2 | -1 | PART NO                                                 | DESCRIPTION | ITEM NO |
| -   | -   | -   | -   | -  | -  | -  | REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION) | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | QTY REQD PER ASSY                                       | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | PARTS LIST                                              | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | MATL                                                    | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | HT TR                                                   | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | FIN                                                     | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | DO NOT SCALE PRINT.                                     | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                  | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | 1 PLC DEC ±-                                            | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | 2 PLC DEC ±-                                            | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | 3 PLC DEC ±-                                            | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | ANGLES ±-                                               | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | SURF TEXTURE:                                           | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | REMOVE BURRS                                            | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | SHARP EDGES R0.38 MAX                                   | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | SCALE                                                   | -           | -       |
| -   | -   | -   | -   | -  | -  | -  | DWG NO                                                  | 1528213     | -       |
| -   | -   | -   | -   | -  | -  | -  | SHEET                                                   | 1 OF 1      | -       |
| -   | -   | -   | -   | -  | -  | -  | REV                                                     | A           | -       |
| -   | -   | -   | -   | -  | -  | -  | RESTRICTED TO                                           | -           | -       |

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LAYOUT  
L1528213

SET UP GAGE  
458637-3

2002

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LOC  
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DIST  
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AMP 1756 REV 3-92

01-APR-04 10:53:41 eb003653

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CASE CODE  
00779

CUSTOMER AND ASSEMBLY DRAWING

1528213

D

C

B

A

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