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LOC

DIST

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	D2	ECR-13-017851	12DEC13	RS	LZ

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2151630-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1385625
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
1385625

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN R.SHEN		 TE Connectivity			
DIMENSIONS:		CHK LJ.ZHANG					
		APVD U.GUO		NAME			
		PRODUCT SPEC		SIDE FEED HDM APPLICATOR			
		APPLICATION SPEC					
MATERIAL		WEIGHT		SIZE A3	CAGE CODE	DRAWING NO C- 1385625	RESTRICTED TO
FINISH		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE		SHEET 1 OF 3	REV D2

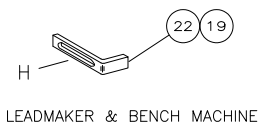
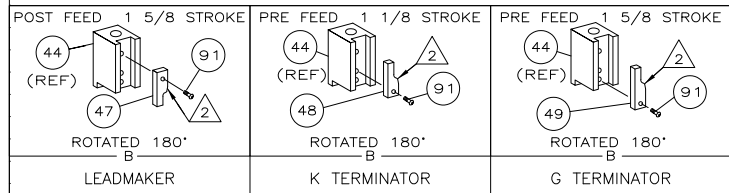
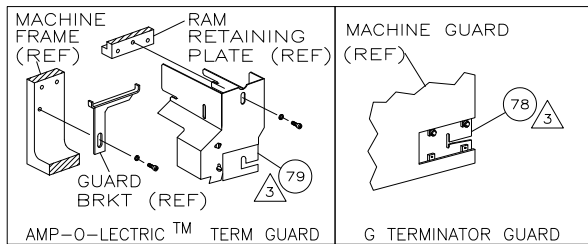
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PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1385625-1	D	122500-1	LEADMAKER	MECH POST FEED	CUTS CARRIER
1385625-2	D	565435-5	BENCH MODEL K	MECH PRE FEED	CUTS CARRIER
1385625-3	D	354500-1	BENCH MODEL G	MECH PRE FEED	CUTS CARRIER
1385625-6	D	122500-1	LEADMAKER	MECH POST FEED	CONT CARRIER
7-1385625-7	D	-	-		SPARE PARTS

1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
4. LUBRICATE DAILY USING NO. 20 MACHINE OIL.
5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
6. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL
7. 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.
8. CUT TO LENGTH AT ASSY



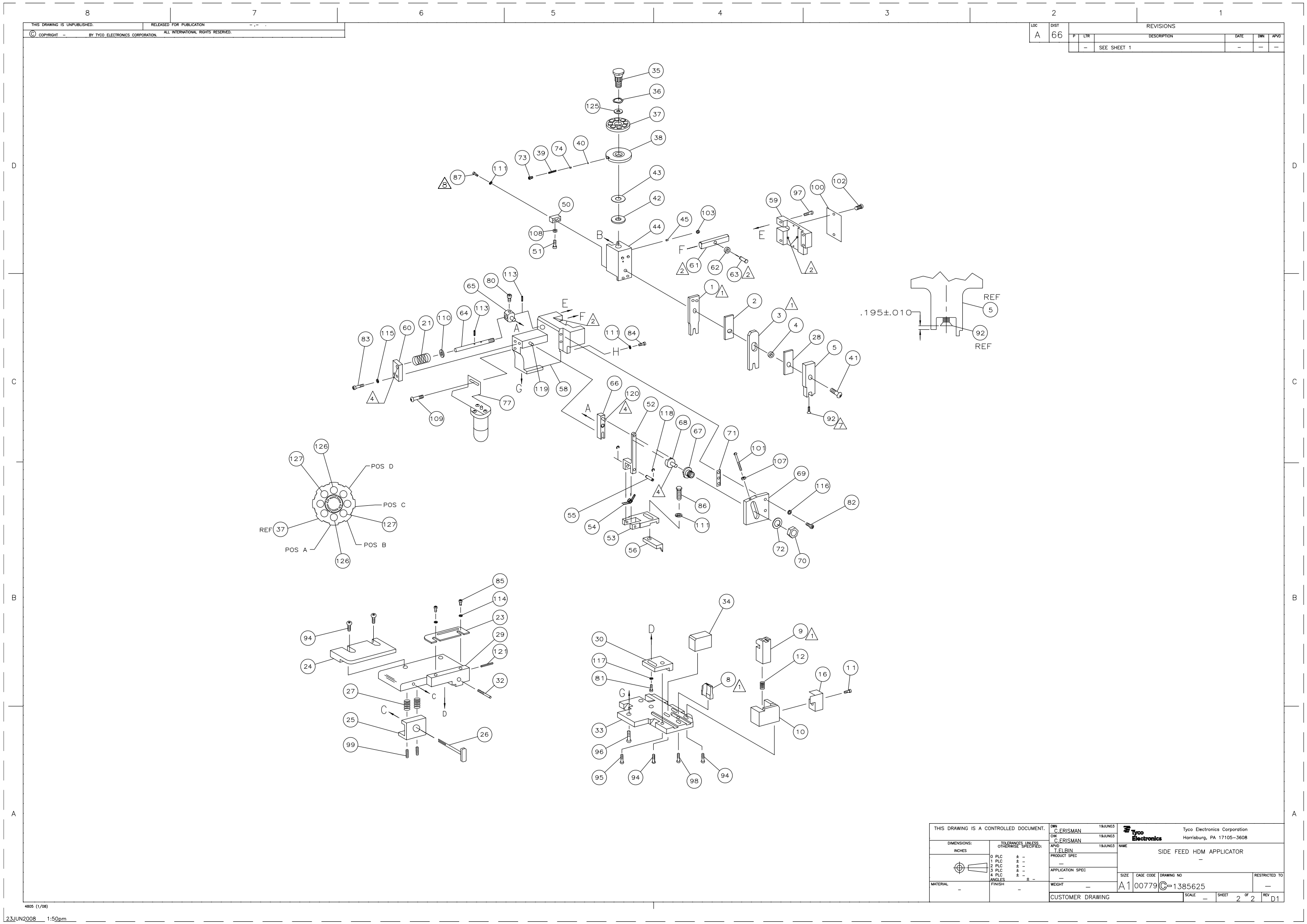
TERMINAL NAME: FEMALE TAXI TERM W/P 150										△6	
SEAL		TERMINAL		CRIMP DATA (NON-AMP TERMINAL-AMP SPEC)							
286867		286866		PAD LTR	CRIMP HEIGHT					WIRE SIZE	
				A	.053 ±.002 [1.35 ±.05mm]					16	
				B	.047 ±.002 [1.20 ±.05mm]					18	
				C	NOT					USED	
				D	NOT					USED	
				CRIMP	SIZE			TYPE	RANGE		
				WIRE	.078 [1.98mm]			F	16-18		
				INSUL	.145 [3.68mm]			0	.080-.112		
WIRE STRIP LENGTH			TERM APPL	SPEC	FEED	APPL INSTRUCTION			SET UP GAGE	LAYOUT	
.203--.234			NONE		.485	408-8040			458637-1	L2378 SUM	

									129
-	2	2	2	2	-	3-354779-2	PIN, WIRE DISC (.3150)B		128
-	2	2	2	2	-	2-354779-0	PIN, WIRE DISC (.3090)A		126
-	1	1	1	1	-	986950-1	WASHER, FLAT PRECISION		125
-	1	1	1	1	-	217238-1	GENERAL INSTRUCTION PACKAGE		124
-	1	1	1	1	-	4088040	SF APPL INST 408-8040		123
									122
-	1	1	1	1	-	4-21028-0	PIN,SLT SPR(Ø.093x.75)ST GDE PL		121
-	REF	REF	REF	REF	-	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER		120
-	REF	REF	REF	REF	-	1-21030-6	PIN,DOWEL(Ø.187x1.25)HOUSING		119
-	REF	REF	REF	REF	-	21045-3	RING,RET "C"(Ø.187)FD FING PIN		118
-	1	1	1	1	-	21024-5	WASHER, LOCK(#10)ADJ BLOCK		117
-	REF	REF	REF	REF	-	21024-5	WASHER,LOCK(#10)ADJ PLATE		116
-	REF	REF	REF	REF	-	21024-5	WASHER,LOCK(#10)FEED GDE ROD		115
-	2	2	2	2	-	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE		114
-	REF	REF	REF	REF	-	5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD		113
									112
-	4	4	4	4	-	21024-4	WASHER,LOCK(#8)STRIPPER		111
-	REF	REF	REF	REF	-	21899-4	WASHER,FLAT(.05/.16)SCREW ADJ		110
-	-	-	1	-	-	2-21002-6	SCR,BHC(10-32x.38)LUBE ASSY		109
-	1	1	1	1	-	21018-5	NUT,HEX(NO.6)HOLDDOWN		108
-	REF	REF	REF	REF	-	21068-5	NUT,HEX(6-32)FEED ADJ		107
									106
									105
									104
-	1	1	1	1	-	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM		103
-	2	2	2	2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE		102
-	REF	REF	REF	REF	-	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ		101
-	1	1	1	1	-	461264-1	PLATE, IDENTIFICATION		100
-	2	2	2	2	-	5-21006-6	SCR,SET(10-32x.75)DRAG		99
-	1	1	1	1	-	22733-8	SCR,BHC(8-32x.38 LW)ANVIL		98
-	REF	REF	REF	REF	-	2-21002-9	SCR,BHC(10-32x.75)CAP		97
-	REF	REF	REF	REF	-	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING		96
-	REF	REF	REF	REF	-	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK		95
-	6	6	6	6	-	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN		94
									93
-	1	1	1	1	-	1-21003-9	SCR,FHC(6-32x.38)DEP		92
-	1	1	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM		91
									90
									89
									88
-	2	2	2	2	-	2-21000-7	SCR,SHC(8-32x.48)DEP-HOLD		87
-	1	1	1	1	-	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER		86
-	2	2	2	2	-	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE		85
-	1	1	1	1	-	2-21000-7	SCR,SHC(8-32x.50)STRIPPER		84
-	REF	REF	REF	REF	-	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD		83
-	REF	REF	REF	REF	-	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK		82
-	1	1	1	1	-	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL		81
-	REF	REF	REF	REF	-	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK		80
-	-	-	REF	-	-	455749-1	GUARD, WINDOW		79
-	-	REF	-	-	-	679532-1	INSERT, GUARD		78
-	-	-	1	-	-	1-465184-0	LUBRICATOR ASSY		77
									76
									75
-	1	1	1	1	-	690603-1	SPRING, ASSIST		74
-	1	1	1	1	-	23030-1	SCR,SHC(6-32x.25 SL)INS DISC		73
-	REF	REF	REF	REF	-	458109-1	WASHER, SPECIAL		72
-	REF	REF	REF	REF	-	690517-1	SPACER		71
-77	-6	-3	-2	-1	U/M	PART NO	DESCRIPTION		ITEM NO
						PARTS LIST			
						QTY REQD PER ASSY			

	REF	REF	REF	REF	—	22594-8	NUT,HEX(1/2-20)	70
—	REF	REF	REF	REF	—	240628-1	PLATE, ADJUSTMENT	69
—	REF	REF	REF	REF	—	240626-1	SHAFT, PIVOT	68
—	REF	REF	REF	REF	—	240633-1	BUSHING	67
—	REF	REF	REF	REF	—	455680-1	LEVER, INTERMEDIATE	66
—	REF	REF	REF	REF	—	240629-1	BLOCK, PIVOT	65
—	REF	REF	REF	REF	—	240632-2	SCREW, ADJ FEED ROD	64
—	REF	REF	REF	REF	—	240659-3	PIN, CAM ROLLER	63
—	REF	REF	REF	REF	—	240658-1	ROLLER, CAM	62
—	REF	REF	REF	REF	—	454398-2	ROD, FEED	61
—	REF	REF	REF	REF	—	454178-1	GUIDE, FEED ROD	60
—	REF	REF	REF	REF	—	454220-1	CAP, RAM	59
—	REF	REF	REF	REF	—	454485-1	HOUSING	58
								57
—	1	1	1	1	—	458537-2	PAWL, FEED	56
—	REF	REF	REF	REF	—	240624-1	PIN, FEED FINGER	55
—	REF	REF	REF	REF	—	691499-1	SPRING, FEED FINGER	54
—	REF	REF	REF	REF	—	690541-1	HOLDER, FEED FINGER	53
—	REF	REF	REF	REF	—	455679-1	LEVER, TERMINAL FEED ARM	52
—	1	1	1	1	—	811242-2	BUMPER, HOLDDOWN	51
—	1	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	—	—	1	—	690501-4	CAM, POST-FEED 1 5/8 ST	47
—	1	1	1	1	—	459456-1	APPLICATOR, BASIC (SUBASSY)	46
—	1	1	1	1	—	690191-1	PLUG, NYLON	45
—	1	1	1	1	—	455673-1	RAM	44
—	1	1	1	1	—	690125-1	WASHER, LAMINATED	43
—	1	1	1	1	—	690124-1	WASHER, RAM	42
—	1	1	1	1	—	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41
—	1	1	1	1	—	23241-6	BALL, STEEL	40
—	1	1	1	1	—	690170-1	SPRING, COMPRESSION	39
—	1	1	1	1	—	1-690142-0	DISC, INSULATION	38
—	1	1	1	1	—	354777-1	WIRE DISC, PLASTIC	37
—	1	1	1	1	—	22480-5	WASHER, SPRING	36
—	1	1	1	1	—	690212-1	POST, RAM	35
—	1	1	1	1	—	690786-1	SUPPORT, TERMINAL	34
—	REF	REF	REF	REF	—	455675-1	PLATE, BASE	33
—	1	1	1	1	—	690432-3	SCREW, ADJUSTMENT	32
								31
—	REF	REF	REF	REF	—	455689-1	BLOCK, STRIP GUIDE ADJ	30
—	1	1	1	1	—	455671-1	PLATE, STRIP GUIDE	29
—	1	1	1	1	—	1-455888-0	SPACER, FRONT SHEAR DEP	28
—	2	2	2	2	—	1-22284-0	SPRING, DRAG	27
—	1	1	1	1	—	690546-1	LEVER, DRAG RELEASE	26
—	1	1	1	1	—	240792-1	DRAG, TERMINAL	25
—	1	1	1	1	—	90765-7	GUIDE, STRIP (REAR)	24
—	1	1	1	1	—	690438-1	GUIDE, STRIP (FRONT)	23
—	1	—	—	1	—	690472-2	STRIPPER	22
—	REF	REF	REF	REF	—	4-22284-9	SPRING, FEED RETURN	21
								20
—	—	1	1	—	—	691353-1	STRIPPER	19
								18
								17
—	1	1	1	1	—	318563-1	GUARD, CHIP, FRONT	16
								15
								14
—	1	—	—	—	—	679625-2	HOLDER, SHEAR (NO CUT)	13
—	1	1	1	1	—	3-22280-3	SPRING, SHEAR	12
—	1	1	1	1	—	690461-2	STOP, SHEAR	11
—	—	1	1	1	—	1-690459-0	HOLDER, SHEAR (FRONT)	10
—	1	1	1	1	—	318707-3	SHEAR, FLOAT (FRONT)	9
1	1	1	1	1	—	2-1424534-1	ANVIL	8
								7
								6
—	1	1	1	1	—	318701-1	DEPRESSOR, SHEAR (FRONT)	5
—	1	1	1	1	—	238011-2	SPACER, BLOCK CRIMPER	4
1	1	1	1	1	—	1583690-7	CRIMPER, INSULATION	3
—	1	1	1	1	—	455888-9	SPACER, CRIMPER	2
1	1	1	1	1	—	4-568176-6	CRIMPER, WIRE	1

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN 18JUN03 C.K. GERISMAN 19JUN03 C.K. GERISMAN 19JUN03 AVALO T. ELBIN 19JUN03		 Tyco Electronics Corporation Harrisburg, PA 17105-3608	
DIMENSIONS: INCHES 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± . 1 PLC ± . 2 PLC ± . 3 PLC ± . 4 PLC ± . ANGLES ± . FINISH ± .		NAME: SIDE FEED HDM APPLICATOR PRODUCT SPEC: - APPLICATION SPEC: - SIZE CASE CODE DRAWING NO: A1 00779 C 1385625 RESTRICTED TO: -	
MATERIAL: -		WEIGHT: -		CUSTOMER DRAWING: -	
				SCALE: - SHEET 1 OF 2 REV D1	

Dimensioning and tolerancing per ASME Y14.5M-2009



THIS DRAWING IS A CONTROLLED DOCUMENT.		OWN C.ERISMAN 19JUN03	19JUN03	Tyco Electronics Corporation Harrisburg, PA 17105-3608	
DIMENSIONS: INCHES		OK C.ERISMAN 19JUN03	19JUN03	NAME SIDE FEED HDM APPLICATOR	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD T.ELBIN 19JUN03	19JUN03	SIZE A1	
0 PLC ± .005		PRODUCT SPEC		CAGE CODE 00779	
1 PLC ± .005		APPLICATION SPEC		DRAWING NO 1385625	
2 PLC ± .005				RESTRICTED TO	
3 PLC ± .005				SCALE	
4 PLC ± .005				SHEET 2 OF 2	
ANGLES ± .005				REV D1	
FINISH		WEIGHT		CUSTOMER DRAWING	