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LOC

DIST

REVISIONS

| P | LTR | DESCRIPTION   | DATE      | DWN | APVD |
|---|-----|---------------|-----------|-----|------|
|   | B1  | ECR-14-003117 | 04MAR2014 | GK  | HMR  |
|   |     |               |           |     |      |
|   |     |               |           |     |      |
|   |     |               |           |     |      |

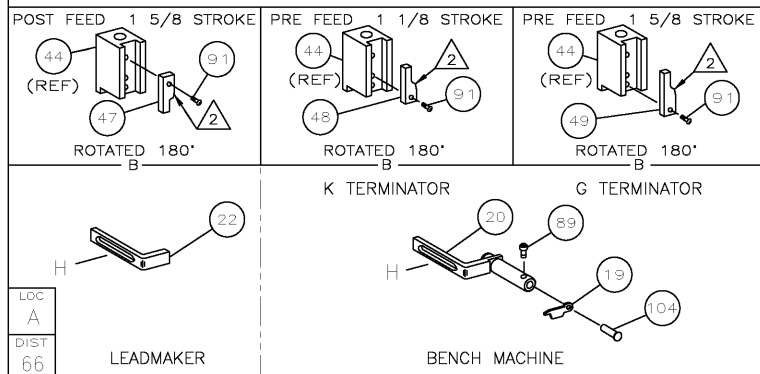
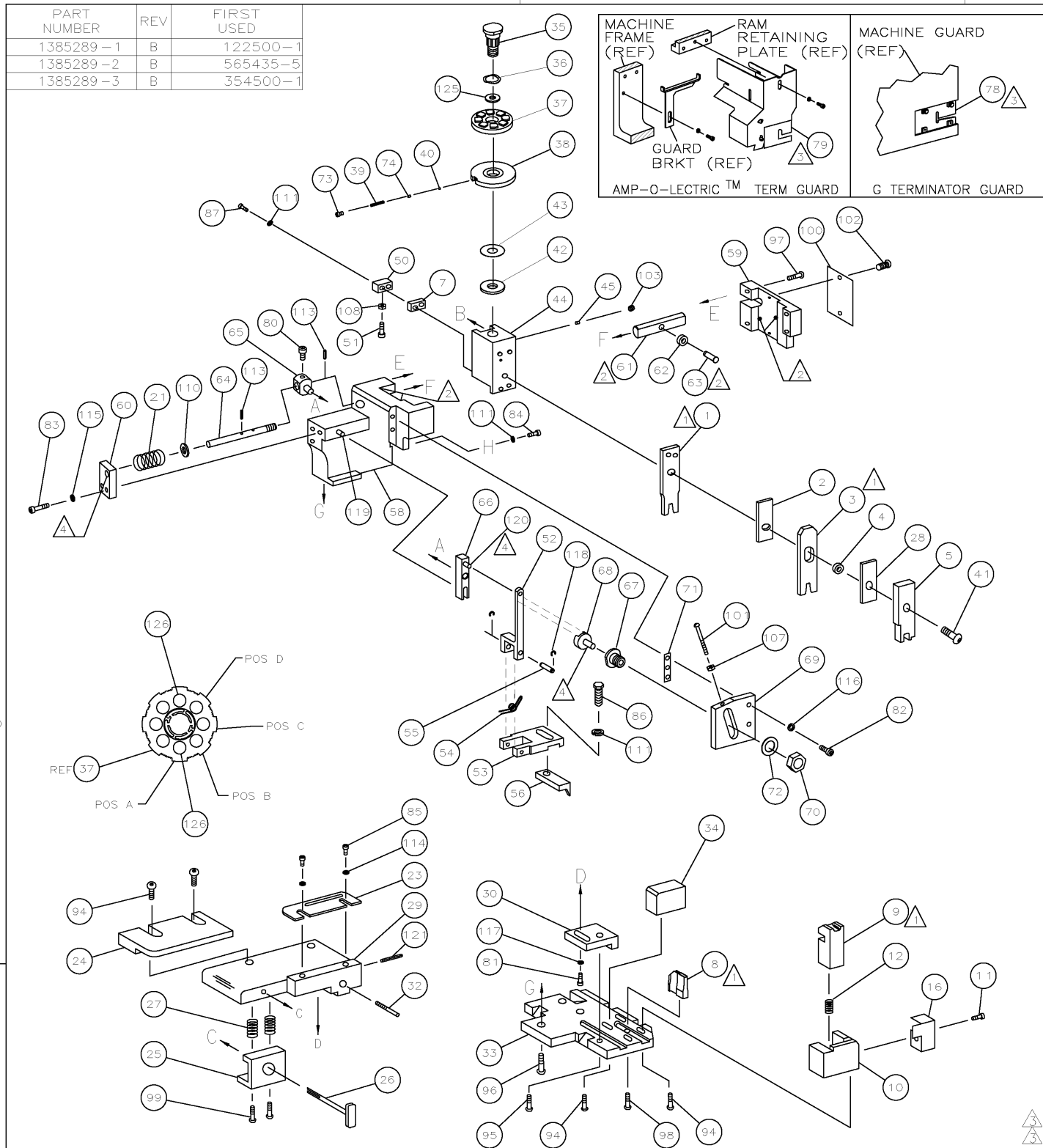
REPLACED BY OCEAN STYLE APPLICATOR PART  
NUMBER 2151396-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1385289  
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  
1385289

|                                                                                       |  |                      |  |                                                                                                       |           |                          |               |
|---------------------------------------------------------------------------------------|--|----------------------|--|-------------------------------------------------------------------------------------------------------|-----------|--------------------------|---------------|
| THIS DRAWING IS A CONTROLLED DOCUMENT.                                                |  | DWN GOPALAKRISHNA HV |  |  TE Connectivity |           |                          |               |
| DIMENSIONS:                                                                           |  | CHK RAGHAVENDRA      |  |                                                                                                       |           |                          |               |
|  |  | APVD RAGHAVENDRA     |  | NAME<br>SIDE FEED HDM APPLICATOR                                                                      |           |                          |               |
|                                                                                       |  | PRODUCT SPEC         |  |                                                                                                       |           |                          |               |
|                                                                                       |  | APPLICATION SPEC     |  |                                                                                                       |           |                          |               |
| MATERIAL                                                                              |  | WEIGHT               |  | SIZE<br>A3                                                                                            | CAGE CODE | DRAWING NO<br>C- 1385289 | RESTRICTED TO |
| FINISH                                                                                |  | CUSTOMER DRAWING     |  | SCALE                                                                                                 |           | SHEET 1 OF 2             | REV B1        |

| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------|
| 1385289-1   | B   | 122500-1   |
| 1385289-2   | B   | 565435-5   |
| 1385289-3   | B   | 354500-1   |



- 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.

| TERMINAL NAME: JST VL CONNECTOR |                |              |                          |                 |          |
|---------------------------------|----------------|--------------|--------------------------|-----------------|----------|
| AMP PN                          | MFR PN         | JST TERMINAL |                          | AMP CRIMP SPECS |          |
| PIN                             |                | PAD LTR      | CRIMP HEIGHT             | WIRE SIZE       |          |
| 286971                          | SVM-61T-P2.0   | A            | .042 ±.002 [1.07 ±.05mm] | 18              |          |
|                                 |                | B            | NOT                      | USED            |          |
| SOCKET                          |                | C            | NOT                      | USED            |          |
| 1572905                         | SVF-61T-P2.0   | D            | NOT                      | USED            |          |
|                                 |                | CRIMP        | SIZE                     | TYPE            | RANGE    |
|                                 |                | WIRE         | .120 [3.05mm]            | F               | —        |
|                                 |                | INSUL        | .160 [4.06mm]            | F               | .160 MAX |
| WIRE STRIP LENGTH               | TERM APPL SPEC | FEED         | APPL INSTRUCTION         | SET UP GAGE     | LAYOUT   |
| .215                            | NONE           | .551         | 408-8040                 | 458637-1        | L2550    |

|                   |     |     |     |            |            |                                 |         |
|-------------------|-----|-----|-----|------------|------------|---------------------------------|---------|
|                   |     |     |     |            |            |                                 | 129     |
|                   |     |     |     |            |            |                                 | 128     |
|                   |     |     |     |            |            |                                 | 127     |
| 2                 | 2   | 2   | —   | C          | 5-354779-9 | PIN, WIRE DISC (.3285)A         | 126     |
| 1                 | 1   | 1   | —   | A          | 986950-1   | WASHER, FLAT PRECISION          | 125     |
| 1                 | 1   | 1   | —   | A          | 217238-1   | GENERAL INSTRUCTION PACKAGE     | 124     |
| 1                 | 1   | 1   | —   | —          | 4088040    | SF APPL INST 408-8040           | 123     |
|                   |     |     |     |            |            |                                 | 122     |
| 1                 | 1   | 1   | —   | A          | 4-21028-0  | PIN,SLT SPR(Ø.093x.75)ST GDE PL | 121     |
| REF               | REF | REF | —   | A          | 1-21030-1  | PIN,DOWEL(Ø.187x.50)LEVER       | 120     |
| REF               | REF | REF | —   | A          | 1-21030-6  | PIN,DOWEL(Ø.187x1.25)HOUSING    | 119     |
| REF               | REF | REF | —   | A          | 21045-3    | RING,RET "C"(Ø.187)FD FING PIN  | 118     |
| 1                 | 1   | 1   | —   | A          | 21024-5    | WASHER, LOCK(#10)ADJ BLOCK      | 117     |
| REF               | REF | REF | —   | A          | 21024-5    | WASHER,LOCK(#10)ADJ PLATE       | 116     |
| REF               | REF | REF | —   | A          | 21024-5    | WASHER,LOCK(#10)FEED GDE ROD    | 115     |
| 2                 | 2   | 2   | —   | A          | 21024-2    | WASHER,LOCK(#4)FRONT STP GUIDE  | 114     |
| REF               | REF | REF | —   | A          | 5-21028-1  | PIN,SLT SPR(Ø.125x.50)ADJ ROD   | 113     |
|                   |     |     |     |            |            |                                 | 112     |
| 4                 | 4   | 4   | —   | A          | 21024-4    | WASHER,LOCK(#8)STRIPPER         | 111     |
| REF               | REF | REF | —   | A          | 21899-4    | WASHER,FLAT(Ø5/16)SCREW ADJ     | 110     |
|                   |     |     |     |            |            |                                 | 109     |
| 1                 | 1   | 1   | —   | A          | 21018-5    | NUT,HEX(NO.6)HOLDDOWN           | 108     |
| REF               | REF | REF | —   | A          | 21068-5    | NUT,HEX(6-32)FEED ADJ           | 107     |
|                   |     |     |     |            |            |                                 | 106     |
|                   |     |     |     |            |            |                                 | 105     |
| 1                 | 1   | —   | —   | A          | 992031-1   | PIN, CLEVIS                     | 104     |
| 1                 | 1   | 1   | —   | A          | 21009-2    | SCR,SKT SET(1/4-20x.25 LW)RAM   | 103     |
| 2                 | 2   | 2   | —   | A          | 21017-2    | SCR,DRIVE(#2x.19)ID PLATE       | 102     |
| REF               | REF | REF | —   | A          | 6-23715-5  | SCR,PAN HD(6-32x1.50)FEED ADJ   | 101     |
| 1                 | 1   | 1   | —   | B          | 461264-1   | PLATE, IDENTIFICATION           | 100     |
| 2                 | 2   | 2   | —   | A          | 3-21002-0  | SCR,BHC(10-32x.88)DRAG          | 99      |
| 1                 | 1   | 1   | —   | A          | 22733-8    | SCR,BHC(8-32x.38 LW)ANVIL       | 98      |
| REF               | REF | REF | —   | A          | 2-21002-9  | SCR,BHC(10-32x.75)CAP           | 97      |
| REF               | REF | REF | —   | A          | 2-22733-8  | SCR,BHC(1/4-20x.62)HOUSING      | 96      |
| REF               | REF | REF | —   | A          | 2-21002-7  | SCR,BHC(10-32x.50)SG ADJ BLOCK  | 95      |
| 6                 | 6   | 6   | —   | A          | 2-21002-2  | SCR,BHC(8-32x.50)TERM H DWN     | 94      |
|                   |     |     |     |            |            |                                 | 93      |
|                   |     |     |     |            |            |                                 | 92      |
| 1                 | 1   | 1   | —   | A          | 1-21002-7  | SCR,BHC(6-32x.38)CAM            | 91      |
|                   |     |     |     |            |            |                                 | 90      |
| 1                 | 1   | —   | —   | A          | 7-21000-9  | SCR,SHC(4-40x.19)STRIPPER       | 89      |
|                   |     |     |     |            |            |                                 | 88      |
| 2                 | 2   | 2   | —   | A          | 2-21000-8  | SCR,SHC(8-32x.62)DEP-HOLD       | 87      |
| 1                 | 1   | 1   | —   | A          | 2-22603-0  | SCR,HEX HD(8-32x.31)FEED FINGER | 86      |
| 2                 | 2   | 2   | —   | A          | 1-21000-3  | SCR,SHC(4-40x.25)F ST GUIDE     | 85      |
| 1                 | 1   | 1   | —   | A          | 2-21000-7  | SCR,SHC(8-32x.50)STRIPPER       | 84      |
| REF               | REF | REF | —   | A          | 3-21000-7  | SCR,SHC(10-32x.75)FEED ROD GD   | 83      |
| REF               | REF | REF | —   | A          | 3-21000-6  | SCR,SHC(10-32x.62)FD ADJ BLK    | 82      |
| 1                 | 1   | 1   | —   | A          | 3-21000-4  | SCR,SHC(10-32x.38)SG ADJ BL     | 81      |
| REF               | REF | REF | —   | A          | 3-21000-4  | SCR,SHC(10-32x.38)PIVOT BLK     | 80      |
| —                 | REF | —   | —   | B          | 455749-1   | GUARD, WINDOW                   | 79      |
| REF               | —   | —   | —   | B          | 679532-1   | INSERT, GUARD                   | 78      |
|                   |     |     |     |            |            |                                 | 77      |
|                   |     |     |     |            |            |                                 | 76      |
|                   |     |     |     |            |            |                                 | 75      |
| 1                 | 1   | 1   | —   | A          | 690603-1   | SPRING, ASSIST                  | 74      |
| 1                 | 1   | 1   | —   | A          | 23030-1    | SCR,SHC(6-32x.25 SL)INS DISC    | 73      |
| REF               | REF | REF | —   | A          | 458109-1   | WASHER, SPECIAL                 | 72      |
| REF               | REF | REF | —   | A          | 690517-1   | SPACER                          | 71      |
| -3                | -2  | -1  | U/M | DWG SIZE   | PART NO    | DESCRIPTION                     | ITEM NO |
| QTY REQD PER ASSY |     |     |     | PARTS LIST |            |                                 |         |

| -1                                                                               | LEADMAKER     |     |     |                                                         | MECH POST FEED |                             |         |
|----------------------------------------------------------------------------------|---------------|-----|-----|---------------------------------------------------------|----------------|-----------------------------|---------|
| -2                                                                               | BENCH MODEL K |     |     |                                                         | MECH PRE FEED  |                             |         |
| -3                                                                               | BENCH MODEL G |     |     |                                                         | MECH PRE FEED  |                             |         |
| REF                                                                              | REF           | REF | -   | B                                                       | 22594-8        | NUT,HEX(1/2-20)             | 70      |
| REF                                                                              | REF           | REF | -   | B                                                       | 240628-1       | PLATE, ADJUSTMENT           | 69      |
| REF                                                                              | REF           | REF | -   | B                                                       | 240626-1       | SHAFT, PIVOT                | 68      |
| REF                                                                              | REF           | REF | -   | B                                                       | 240633-1       | BUSHING                     | 67      |
| REF                                                                              | REF           | REF | -   | A                                                       | 455680-1       | LEVER, INTERMEDIATE         | 66      |
| REF                                                                              | REF           | REF | -   | B                                                       | 240629-1       | BLOCK, PIVOT                | 65      |
| REF                                                                              | REF           | REF | -   | A                                                       | 240632-2       | SCREW, ADJ FEED ROD         | 64      |
| REF                                                                              | REF           | REF | -   | B                                                       | 240659-3       | PIN, CAM ROLLER             | 63      |
| REF                                                                              | REF           | REF | -   | B                                                       | 240658-1       | ROLLER, CAM                 | 62      |
| REF                                                                              | REF           | REF | -   | B                                                       | 454398-2       | ROD, FEED                   | 61      |
| REF                                                                              | REF           | REF | -   | A                                                       | 454178-1       | GUIDE, FEED ROD             | 60      |
| REF                                                                              | REF           | REF | -   | C                                                       | 454220-1       | CAP, RAM                    | 59      |
| REF                                                                              | REF           | REF | -   | D                                                       | 454485-1       | HOUSING                     | 58      |
|                                                                                  |               |     |     |                                                         |                |                             | 57      |
| 1                                                                                | 1             | 1   | -   | B                                                       | 690542-2       | PAWL, FEED                  | 56      |
| REF                                                                              | REF           | REF | -   | B                                                       | 240624-1       | PIN, FEED FINGER            | 55      |
| REF                                                                              | REF           | REF | -   | B                                                       | 691499-1       | SPRING, FEED FINGER         | 54      |
| REF                                                                              | REF           | REF | -   | B                                                       | 690541-1       | HOLDER, FEED FINGER         | 53      |
| REF                                                                              | REF           | REF | -   | A                                                       | 455679-1       | LEVER, TERMINAL FEED ARM    | 52      |
| 1                                                                                | 1             | 1   | -   | A                                                       | 811242-7       | BUMPER, HOLDDOWN            | 51      |
| 1                                                                                | 1             | 1   | -   | A                                                       | 690753-1       | SPACER, TONKER              | 50      |
| 1                                                                                | -             | -   | -   | B                                                       | 690602-6       | CAM, PRE-FEED 1 5/8 ST      | 49      |
| -                                                                                | 1             | -   | -   | B                                                       | 690602-5       | CAM, PRE-FEED 1 1/8 ST      | 48      |
| -                                                                                | -             | 1   | -   | B                                                       | 690501-4       | CAM, POST-FEED 1 5/8 ST     | 47      |
| 1                                                                                | 1             | 1   | -   | B                                                       | 459456-1       | APPLICATOR, BASIC (SUBASSY) | 46      |
| 1                                                                                | 1             | 1   | -   | A                                                       | 690191-1       | PLUG, NYLON                 | 45      |
| 1                                                                                | 1             | 1   | -   | C                                                       | 455673-1       | RAM                         | 44      |
| 1                                                                                | 1             | 1   | -   | A                                                       | 690125-1       | WASHER, LAMINATED           | 43      |
| 1                                                                                | 1             | 1   | -   | A                                                       | 690124-1       | WASHER, RAM                 | 42      |
| 1                                                                                | 1             | 1   | -   | A                                                       | 7-21002-9      | BOLT, CRIMPER(5/16x1.00)    | 41      |
| 1                                                                                | 1             | 1   | -   | A                                                       | 23241-6        | BALL, STEEL                 | 40      |
| 1                                                                                | 1             | 1   | -   | A                                                       | 690170-1       | SPRING, COMPRESSION         | 39      |
| 1                                                                                | 1             | 1   | -   | C                                                       | 1-690142-0     | DISC, INSULATION            | 38      |
| 1                                                                                | 1             | 1   | -   | D                                                       | 354777-1       | WIRE DISC, PLASTIC          | 37      |
| 1                                                                                | 1             | 1   | -   | A                                                       | 22480-5        | WASHER, SPRING              | 36      |
| 1                                                                                | 1             | 1   | -   | B                                                       | 690212-1       | POST, RAM                   | 35      |
| 1                                                                                | 1             | 1   | -   | B                                                       | 690786-3       | SUPPORT, TERMINAL           | 34      |
| REF                                                                              | REF           | REF | -   | D                                                       | 455675-1       | PLATE, BASE                 | 33      |
| 1                                                                                | 1             | 1   | -   | A                                                       | 690432-3       | SCREW, ADJUSTMENT           | 32      |
|                                                                                  |               |     |     |                                                         |                |                             | 31      |
| REF                                                                              | REF           | REF | -   | B                                                       | 455689-1       | BLOCK, STRIP GUIDE ADJ      | 30      |
| 1                                                                                | 1             | 1   | -   | C                                                       | 455671-9       | PLATE, STRIP GUIDE          | 29      |
| 1                                                                                | 1             | 1   | -   | C                                                       | 1-455888-9     | SPACER, FRONT SHEAR DEP     | 28      |
| 2                                                                                | 2             | 2   | -   | A                                                       | 1-22284-0      | SPRING, DRAG                | 27      |
| 1                                                                                | 1             | 1   | -   | B                                                       | 690546-1       | LEVER, DRAG RELEASE         | 26      |
| 1                                                                                | 1             | 1   | -   | B                                                       | 240792-1       | DRAG, TERMINAL              | 25      |
| 1                                                                                | 1             | 1   | -   | D                                                       | 6-690504-8     | GUIDE, STRIP (REAR)         | 24      |
| 1                                                                                | 1             | 1   | -   | A                                                       | 690438-1       | GUIDE, STRIP (FRONT)        | 23      |
| -                                                                                | -             | 1   | -   | B                                                       | 690472-2       | STRIPPER                    | 22      |
| REF                                                                              | REF           | REF | -   | A                                                       | 4-22284-9      | SPRING, FEED RETURN         | 21      |
| 1                                                                                | 1             | -   | -   | A                                                       | 679218-1       | STRIPPER WIRE STOP ASSY     | 20      |
| 1                                                                                | 1             | -   | -   | B                                                       | 458949-1       | STRIPPER                    | 19      |
|                                                                                  |               |     |     |                                                         |                |                             | 18      |
|                                                                                  |               |     |     |                                                         |                |                             | 17      |
| 1                                                                                | 1             | 1   | -   | B                                                       | 318563-1       | GUARD, CHIP, FRONT          | 16      |
|                                                                                  |               |     |     |                                                         |                |                             | 15      |
|                                                                                  |               |     |     |                                                         |                |                             | 14      |
|                                                                                  |               |     |     |                                                         |                |                             | 13      |
| 1                                                                                | 1             | 1   | -   | A                                                       | 5-22280-0      | SPRING, SHEAR               | 12      |
| 1                                                                                | 1             | 1   | -   | B                                                       | 690461-1       | STOP, SHEAR                 | 11      |
| 1                                                                                | 1             | 1   | -   | C                                                       | 690459-1       | HOLDER, SHEAR (FRONT)       | 10      |
| 1                                                                                | 1             | 1   | -   | C                                                       | 454276-1       | SHEAR, FLOAT (FRONT)        | 9       |
| 1                                                                                | 1             | 1   | -   | C                                                       | 1-662190-3     | ANVIL                       | 8       |
| 1                                                                                | 1             | 1   | -   | C                                                       | 5-240641-2     | SPACER, DEPRESSOR (REAR)    | 7       |
|                                                                                  |               |     |     |                                                         |                |                             | 6       |
| 1                                                                                | 1             | 1   | -   | C                                                       | 1-455889-4     | DEPRESSOR, SHEAR (FRONT)    | 5       |
| 1                                                                                | 1             | 1   | -   | B                                                       | 1-238011-0     | SPACER, BLOCK CRIMPER       | 4       |
| 1                                                                                | 1             | 1   | -   | C                                                       | 683453-5       | CRIMPER, INSULATION         | 3       |
| 1                                                                                | 1             | 1   | -   | C                                                       | 1-455888-1     | SPACER, CRIMPER             | 2       |
| 1                                                                                | 1             | 1   | -   | C                                                       | 2-456409-0     | CRIMPER, WIRE               | 1       |
| -3                                                                               | -2            | -1  | U/M | DWG SIZE                                                | PART NO        | DESCRIPTION                 | ITEM NO |
| QTY REQD PER ASSY                                                                |               |     |     | PARTS LIST                                              |                |                             |         |
| DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: |               |     |     | REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION) |                |                             |         |
| 2 PLC DEC ±                                                                      |               |     |     | MATERIAL                                                |                |                             |         |
| 3 PLC DEC ±                                                                      |               |     |     | HT TR                                                   |                |                             |         |
| 4 PLC DEC ±                                                                      |               |     |     | FIN                                                     |                |                             |         |
| ANGLES ±                                                                         |               |     |     | DR R. KNEPPER                                           |                |                             |         |
| SURF TEXTURE: ✓                                                                  |               |     |     | CHK 26JUN01                                             |                |                             |         |
| REMOVE BURRS, BREAK SHARP EDGES R.015 MAX                                        |               |     |     | REL -                                                   |                |                             |         |
|                                                                                  |               |     |     | APP 26JUN01                                             |                |                             |         |
|                                                                                  |               |     |     | DATE                                                    |                |                             |         |
|                                                                                  |               |     |     | NAME                                                    |                |                             |         |
|                                                                                  |               |     |     | SCALE                                                   |                |                             |         |
|                                                                                  |               |     |     | DWG NO                                                  |                |                             |         |
|                                                                                  |               |     |     | 1385289                                                 |                |                             |         |
|                                                                                  |               |     |     | SHEET 1 OF 1                                            |                |                             |         |
|                                                                                  |               |     |     | REV B                                                   |                |                             |         |
|                                                                                  |               |     |     | MACHINE REF                                             |                |                             |         |
|                                                                                  |               |     |     | MINI APPL                                               |                |                             |         |
| CAGE CODE 00779                                                                  |               |     |     | CUSTOMER AND ASSEMBLY DRAWING                           |                |                             |         |
|                                                                                  |               |     |     | RESTRICTED TO -                                         |                |                             |         |

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