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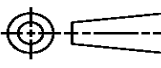
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	ECR-14-001799	07FEB2014	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2151993-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1385561
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
1385561

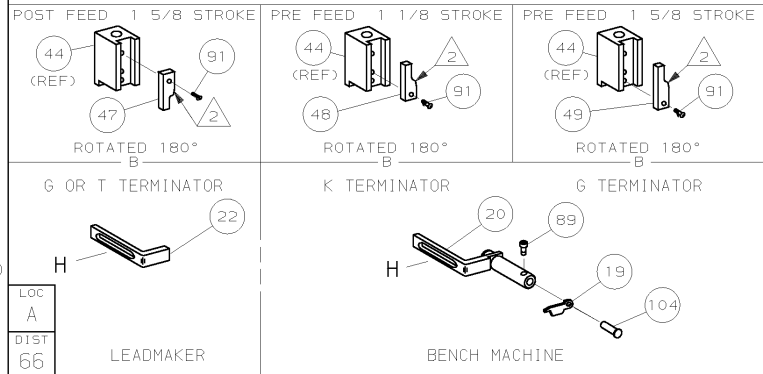
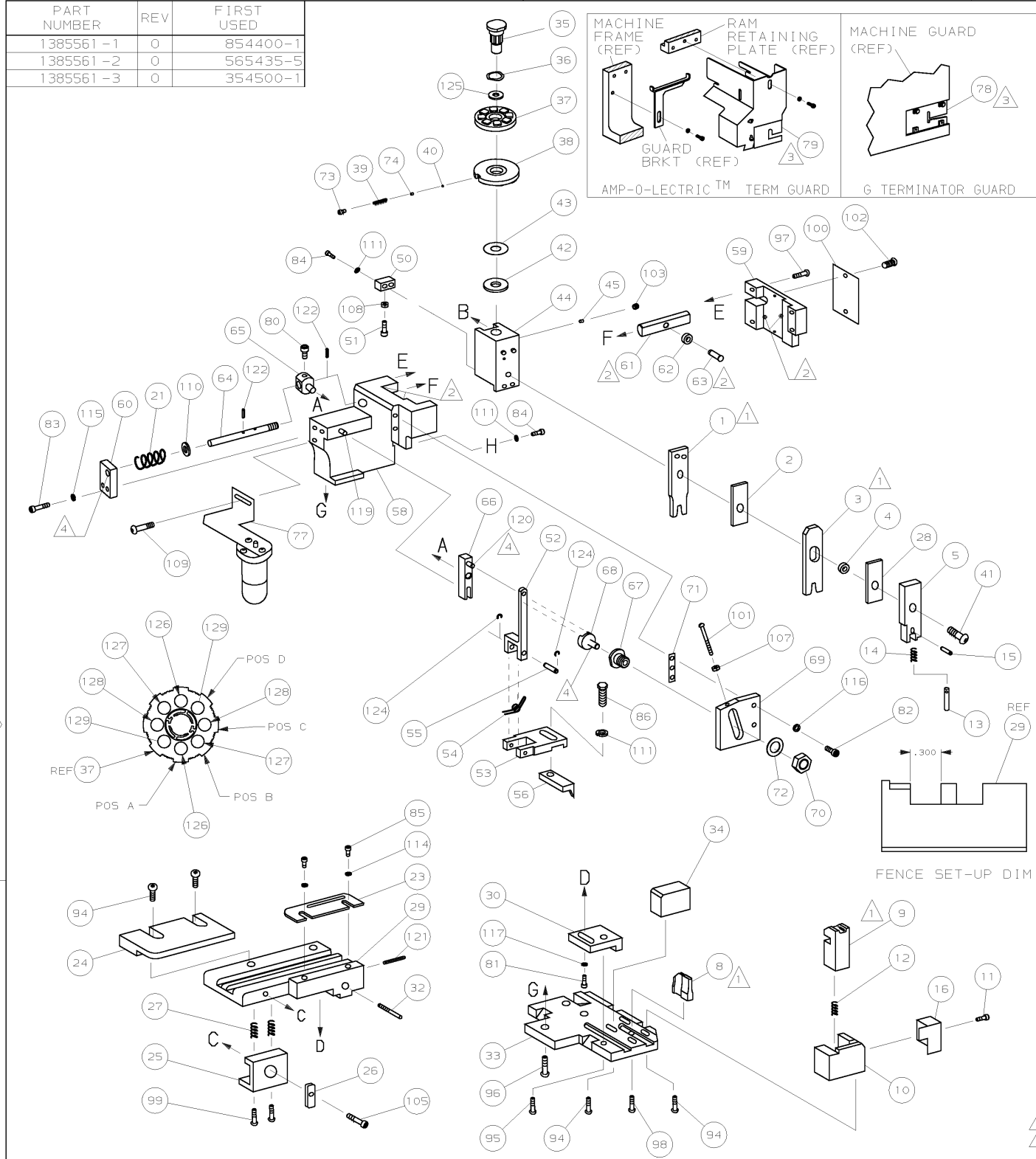
THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV		 TE Connectivity	
DIMENSIONS:		CHK	RAGHAVENDRA			
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		
		0 PLC ±		SIDE FEED HDM APPLICATOR		
		1 PLC ±				
MATERIAL		2 PLC ±		SIZE		
		3 PLC ±		CAGE CODE		
		4 PLC ±		DRAWING NO		
		ANGLES ±		RESTRICTED TO		
FINISH		WEIGHT		C- 1385561		
		CUSTOMER DRAWING		SCALE		SHEET 1 OF 2
						REV A

DRAWING MADE IN THIRD ANGLE PROJECTION

1385561 1385561

/home/us014442/app/L/misc/newdesign

PART NUMBER	REV	FIRST USED
1385561 -1	0	854400-1
1385561 -2	0	565435-5
1385561 -3	0	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.
- 6 LUBRICATION REQUIRED WITH GOLD PLATED TERMINALS.
- 7 ITEM 29 MUST BE ADJUSTED TO ACQUIRE PROPER CUT-OFF TABS.

TERMINAL NAME: .070 SERIES TAB CONTACT				
173645				
PAD LTR	CRIMP HEIGHT		WIRE SIZE	
	AMP CRIMP SPECS			
A	.063 ±.002	[1.60 ±0.05mm]	14	
B	.060 ±.002	[1.52 ±0.05mm]	16	
C	.054 ±.002	[1.37 ±0.05mm]	18	
D	.049 ±.002	[1.24 ±0.05mm]	20	
WIRE	CRIMP	SIZE	TYPE	RANGE
	INSUL	.090 [2.29mm]	F	20-14
		.100 [2.54mm]	F	.078-.102
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE LAYOUT
.137-.177	114-5092-1	.469	408-8040	458637-1 L1382

2	2	2	-	C	2-354779-4	PIN, WIRE DISC (.3110)D	129
2	2	2	-	C	1-354779-4	PIN, WIRE DISC (.3060)C	128
2	2	2	-	C	354779-2	PIN, WIRE DISC (.3000)B	127
2	2	2	-	C	9-354778-5	PIN, WIRE DISC (.2970)A	126
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
REF	REF	REF	-	A	21045-3	RING, RET "C" (Ø.187)FD FING PIN	124
REF	REF	REF	-	A	5-21028-1	PIN, SLT SPR (Ø.125x.50)ADJ ROD	123
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
1	1	1	-	A	21024-5	WASHER, LOCK (#10)ADJ BLOCK	118
REF	REF	REF	-	A	21024-5	WASHER, LOCK (#10)ADJ PLATE	117
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
4	4	4	-	A	21024-4	WASHER, LOCK (#8)STRIPPER	111
REF	REF	REF	-	A	21899-4	WASHER, FLAT (Ø5/16)SCREW ADJ	110
-	1	-	-	A	2-21002-6	SCR, BHC (10-32x.38)LUBE ASSY	109
1	1	1	-	A	21018-5	NUT, HEX (NO. 6)HOLDDOWN	108
REF	REF	REF	-	A	21018-5	NUT, HEX (6-32)FEED ADJ	107
1	1	1	-	A	22353-8	SCR, SHLD (Ø.187x.25)DRAG LEVER	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)56 ADJ BLOCK	95
6	6	6	-	A	2-21002-2	SCR, BHC (8-32x.50)SHEAR	94
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38)CAM	91
1	1	-	-	A	7-21000-9	SCR, SHC (4-40x.19)STRIPPER	89
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
3	3	3	-	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)56 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
-	1	-	-	C	1-465184-0	LUBRICATOR ASSY	77
1	1	1	-	A	690603-1	SPRING, ASSIST	75
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	DESCRIPTION	ITEM NO
				REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)			
QTY RECD PER ASSY				PARTS LIST			

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	811242-2	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	1-690142-1	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	690786-1	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	843869-1	PLATE, STRIP GUIDE	29		
1	1	1	- C	1-455888-7	SPACER, FRONT SHEAR DEP	28		
2	2	2	- A	1-22284-0	SPRING, DRAG	27		
1	1	1	- B	240793-1	LEVER, DRAG RELEASE	26		
1	1	1	- B	240792-1	DRAG, TERMINAL	25		
1	1	1	- D	6-690504-2	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	691667-1	GUARD, CHIP (FRONT)	16		
1	1	1	- A	21028-2	PIN, SLOTTED SPRING	15		
1	1	1	- A	1-22278-0	SPRING, COMPRESSION	14		
1	1	1	- B	854769-1	HOLDER, INSULATION	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	462006-1	ANVIL, FLOAT (FRONT)	9		
1	1	1	- C	854014-1	ANVIL	8		
						7		
						6		
1	1	1	- C	854772-1	DEPRESSOR, SHEAR (FRONT)	5		
1	1	1	- B	238011-9	SPACER, BLOCK CRIMPER	4		
1	1	1	- C	4-683453-7	CRIMPER, INSULATION	3		
1	1	1	-	455888-1	SPACER, CRIMPER	2		
1	1	1	- C	1-456406-8	CRIMPER, WIRE	1		
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO	
				← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)				
QTY RECD PER ASSY				PARTS LIST				
DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±.02 3 PLC DEC ±. 4 PLC DEC ±. ANGLES ±. SURF TEXTURE, ✓ REMOVE BURRS, BREAK SHARP EDGES R.015 MAX				MATL		HT TR	FIN	
				DR D. SALTZER 6/21/94 APP 6-21-94 T. BEDDICK		AMP		
				CHK 6-21-94 C. ERISMAN REL 7/13/94 B. MORGAN		AMP Incorporated Harrisburg, PA 17105-3608		
				NAME SIDE FEED HDM APPLICATOR		MACHINE REF MINI APPL		
SCALE -				D	DWG NO	1385561	SHEET 1 OF 1 REV 0	
CAGE CODE 00779				CUSTOMER AND ASSEMBLY DRAWING				RESTRICTED TO -

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