

PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE
1385719-1	H	122500-1	LEADMAKER	AIR FEED
1385719-2	H	565435-5	BENCH MODEL K	AIR FEED
1385719-3	H	354500-1	BENCH MODEL G	AIR FEED
1385719-4	H	KOMAX	KOMAX	AIR FEED

TERMINAL NAME: .250 SERIES RECEPTACLE, ULTRA-POD™									
		521632	*		CRIMPING DATA				
		521637	REF						
		521998	SETTING		CRIMP HEIGHT				WIRE SIZE
					B5	.076 ±.002 [1.93 ±0.05mm]			#14
					C5	.071 ±.002 [1.80 ±0.05mm]			2- #18
					D3	.067 ±.002 [1.70 ±0.05mm]			#16 or (1)#18 + (1)#20
					E3	.061 ±.002 [1.55 ±0.05mm]			#18 or (2)#20
					CRIMP	SIZE	TYPE	RANGE	
					WIRE	.110 [2.79mm]	F	#14-#18 or (2)#18 or (1)18 + (1)#20 or #18 or (2)#20	
					INSUL	.240 [6.09mm]	F	.110-.170 or 2-.105 MAX	
WIRE STRIP LENGTH		TERM APPL SPEC		FEED	APPL INSTRUCTION		SET UP GAGE	LAYOUT	
.210-.240		114-02124		.760	408-8095 & 408-8098		-	-	

 RECOMMENDED SPARE PARTS

2 ITEMS NOT SHOWN

3 TOL $\pm .25$

4. SPRING LOADED TONKER REQUIRED WHEN RUNNING APPLICATOR ON LEADMAKER.
5. WIRE PLACEMENT AND STRAIGHTNESS IS EXTREMELY CRITICAL FOR CONSISTANT TERMINAL BARREL. IF THE WIRE COLLECTION OF THE WIRE INTO THE PRESENTATION IS NOT CORRECT OR CONSISTANT, FAULTY TERMINATIONS WILL RESULT.

* 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.

[illegible]

							140	
							139	
							138	
							137	
							136	
							135	
	1	1	1	1	—	690125—1	WASHER,LAMINATED	134
	1	1	1	1	—	21009—2	SCR.,SOC SET 1/4—20 X .25 LG	133
	1	1	1	1	—	690191—1	PLUG,NYLON	132
	1	1	1	1	—	461690—1	SPACER	131
								130
2	—	—	1	—	—	692655—1	VALVE ASSY	129
	2	2	2	2	—	2—21002—9	SCR. BUT HD 10—32 X .75	128
	2	2	2	2	—	3—21000—7	SCR. SOC HD 10—32 X .75	127
	1	1	1	1	—	852224—1	FINGER,FEED	126
	1	1	1	1	—	461062—6	FEED FINGER ASSY	125
	1	1	1	1	—	3—21001—4	SCREW, SOC HD CP 3/8—16 X .88 LG	124
	1	1	1	1	—	852289—1	AIR FEED ASSY	123
								122
								121
	2	2	2	2	—	1—23030—2	SCR,SOC.HD.8—32x.75 LOK—WEL	120
1	1	—	—	—	—	1—455888—0	SPACER, CRIMPER	119
	1	1	1	1	—	852253—1	BLADE,SLUG	118
	1	—	—	—	—	1490524—2	SPACER, DEPRESSOR	117
	1	—	—	—	—	1490525—1	DEPRESSOR	116
	1	—	—	—	—	1424350—1	PIN, HOLDER	115
								114
								113
	—	1	1	1	—	1338045—1	PLATE, DEPRESSOR	112
	3	—	—	—	—	2—23147—2	COMPRESSION SPRING	111
								110
	1	1	1	1	—	21024—4	WASHER #8	109
	1	1	1	1	—	2—22603—1	SCR,HEX(8—32x.38)	108
	4	4	4	4	—	2—21002—6	SCR,BHC(10—32x.38)	107
	—	1	1	1	—	2—21000—7	SCR, SHC 8—32 X .50 LG.	106
	—	2	2	2	—	1—21003—3	SCR, FHC 4—40 X .25 LG.	105
	—	4	4	4	—	7—22280—3	SPRING, COMPRESSION	104
	1	1	1	1	—	1673936—2	RAM CAP PLATE	103
	—	1	1	1	—	1—455888—6	SPACER,CRIMPER	102
	—	1	1	1	—	455888—4	SPACER, CRIMPER	101
	1	1	1	1	—	1424388—2	CAP, RAM	100
1	1	1	1	1	—	6—1490019—6	CRIMPER, WIRE	99
	1	1	1	1	—	6—1424909—6	CRIMPER,INS "F"	98
	1	1	1	1	—	238011—2	BLOCK, CRIMPER SPACER	97
	1	1	1	1	—	1—455888—5	SPACER,CRIMPER	96
	1	1	1	1	—	2—24921—5	SCR.,BUT. HD.5/16 UNF—24 X 1.25	95
	1	—	—	—	—	455888—5	SPACER, CRIMPER	94
	1	1	1	1	—	1—22183—7	PIN, GROOVE TYP 67 .125 DIA X .63	93
	1	1	1	1	—	2—22286—2	SPRING, EXT. LE—031B—2	92
	1	1	1	1	—	1—21919—1	PIN,DOWEL .094 DIA X .375	91
	1	1	1	1	—	852281—2	ROLLER	90
	1	1	1	1	—	354385—4	PNEUMATIC ASSY	89
	1	1	1	1	—	852287—1	PLATE, RETAINER	88
	1	1	1	1	—	852286—1	LATCH, INSERT	87
	2	2	2	2	—	852521—1	PIN, DOWEL MOD. .094 DIA X .49	86
	1	1	1	1	—	852284—1	ARM, LATCH	85
	1	1	1	1	—	1—21030—7	PIN, DOWEL .188 DIA X 1.50	84
								83
								82
								81
	3	2	2	2	—	980282—3	CONNECTOR,MALE 1/8NPTX.25	80
	—	1	—	1	—	980285—2	ELBOW,MALE,SWIVEL 1/8NPTx.25	79
								78
								77
								76
								75
								74
								73
								72
	2	2	2	2	—	22733—3	SCR,BUT HD CP 6—32 X .25 LOK—WEL	71
	—4	—3	—2	—1	U/M	PART NO	DESCRIPTION	ITEM NO
						PARTS LIST		

[illegible]

	H	ECR-09-018424		9-2009	MY	GB
P	LTR	REVISION RECORD		DATE	DWN	APVD

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
INCHES			
	0 PLC	± -	
	1 PLC	± -	
	2 PLC	± .02	
	3 PLC	0° 30/005	
	4 PLC	± .0005	
ANGLES ± -			
SURFACE TEXTURE			

DWN	9-27-95	MATERIAL	HEAT TREAT		
R O WILSON		-	-		
CHK	9-28-95	-	-		
C ERISMAN		 Tyco Electronics Corporation Harrisburg, PA 17105-3608			
APVD	9-28-95				
A BEDDICK					
NAME					
ULTRA-POD APPLICATOR .250 STRAIGHT					
SCALE	SIZE	DRAWING NO	SHEET	OF	REV
1:1	A1	1385719	1	3	H

GUSTOMER ACCESSIBLE PRODUCTION DRAWING

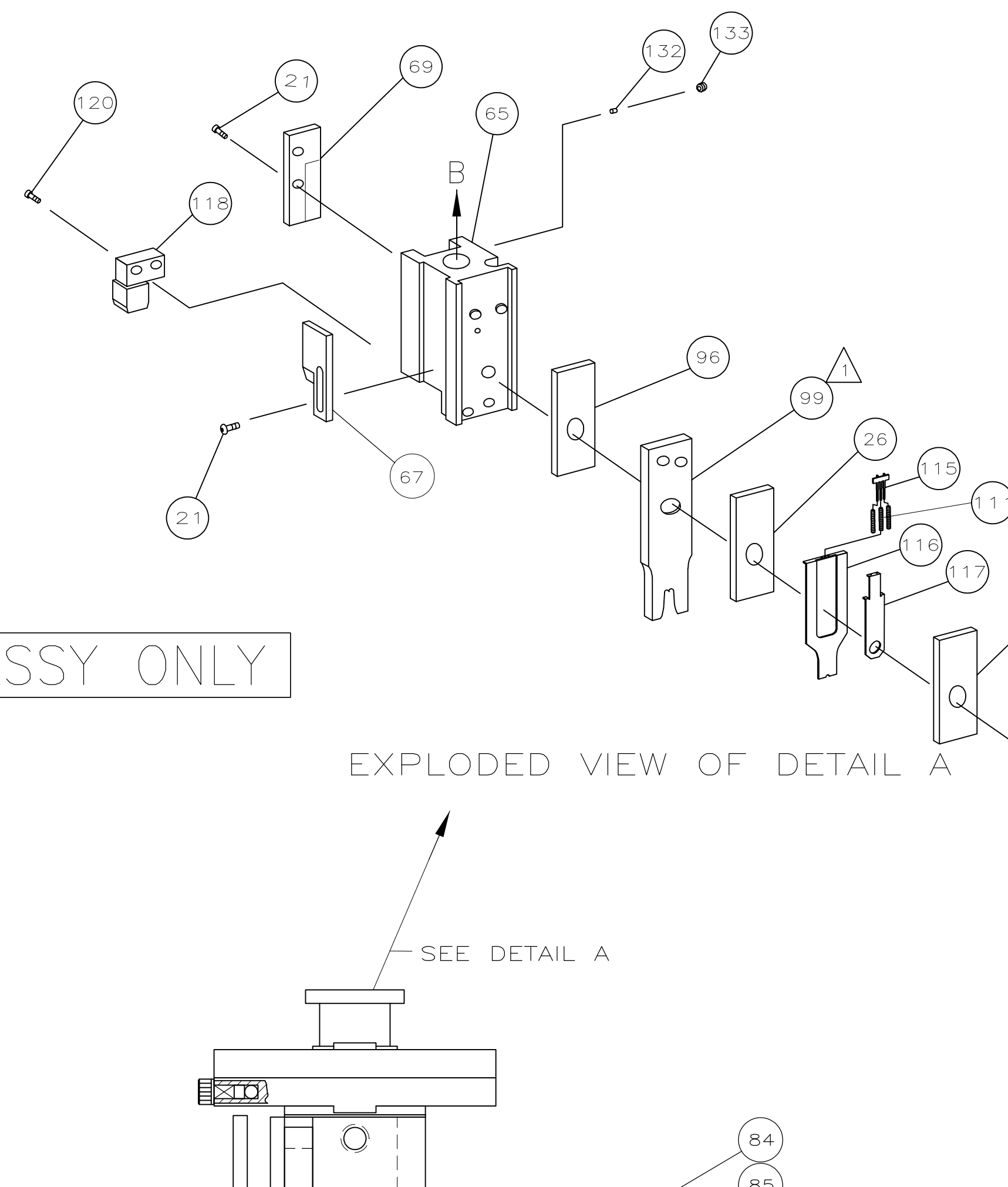
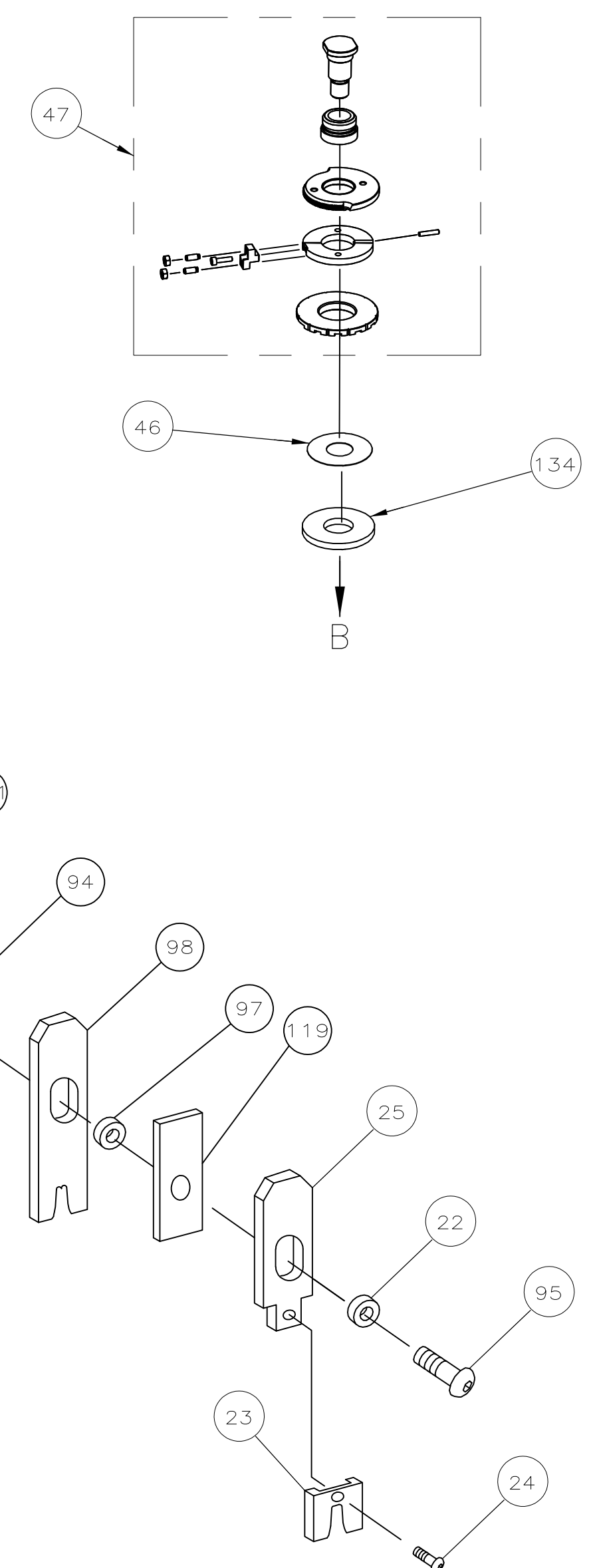
DWN	9-27-95	MATERIAL	HEAT TREAT		
R O WILSON		-	-		
CHK	9-28-95	-			
C ERISMAN		Tyco Electronics Corporation Harrisburg, PA 17105-3608			
APVD	9-28-95				
A BEDDICK					
NAME					
ULTRA-POD APPLICATOR .250 STRAIGHT					
SCALE	SIZE	DRAWING NO	SHEET	OF	REV
1:1	A1	1385719	2	3	H

D

C

B

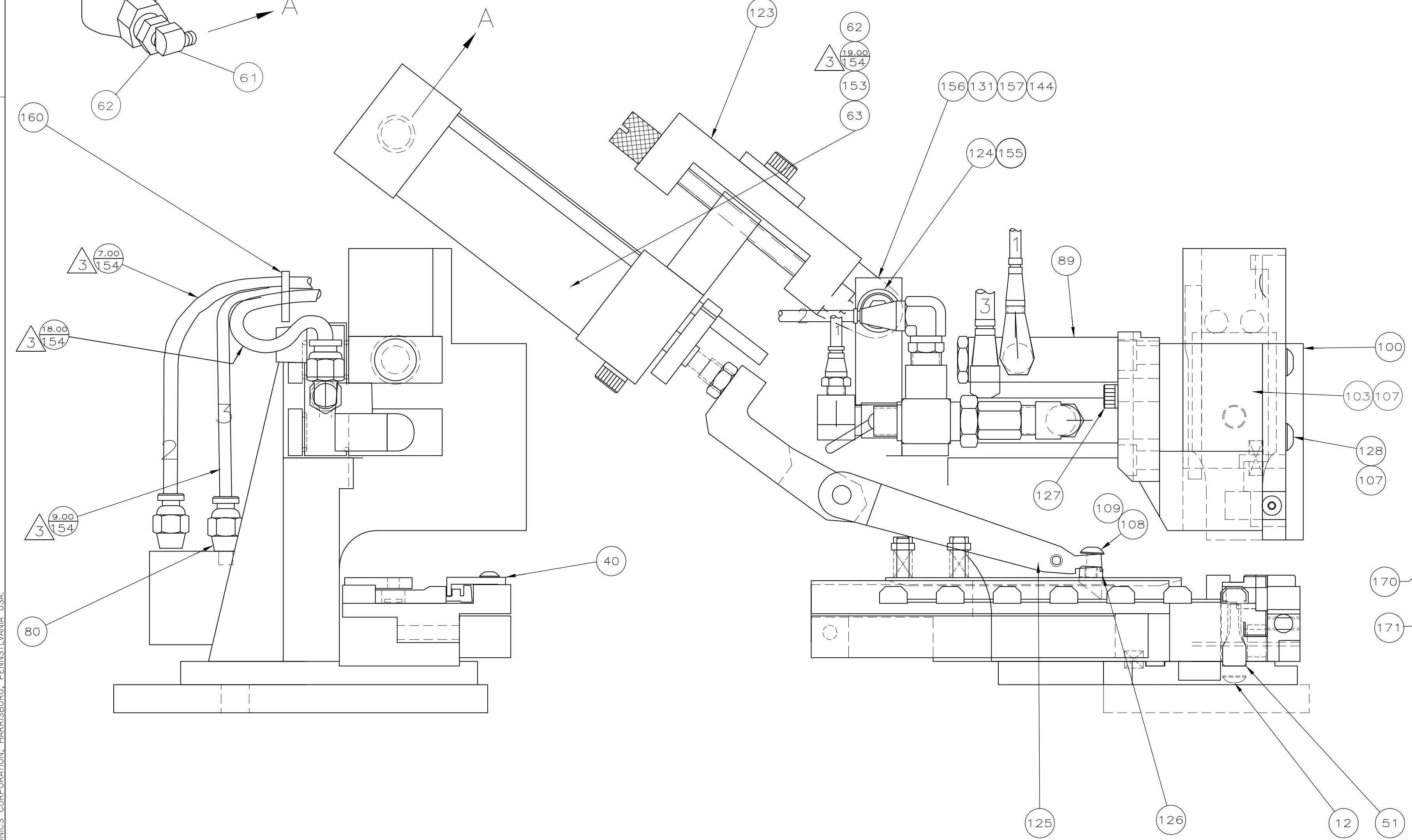
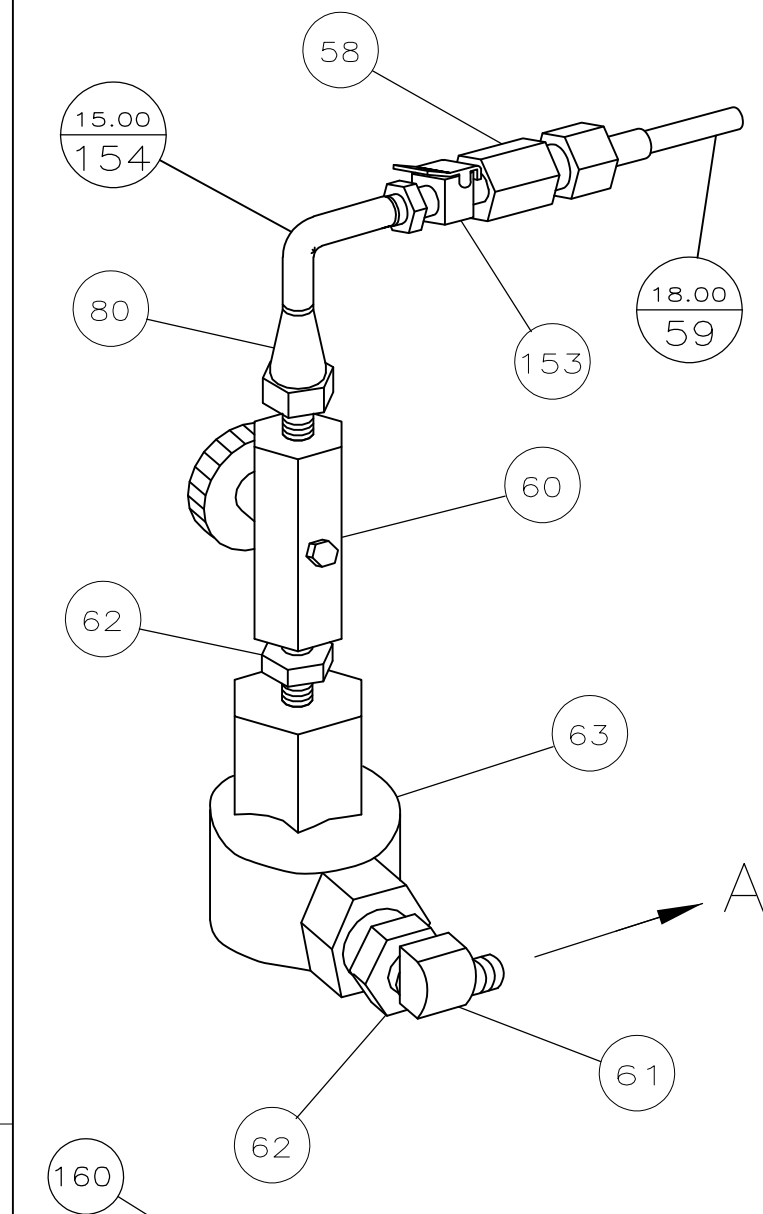
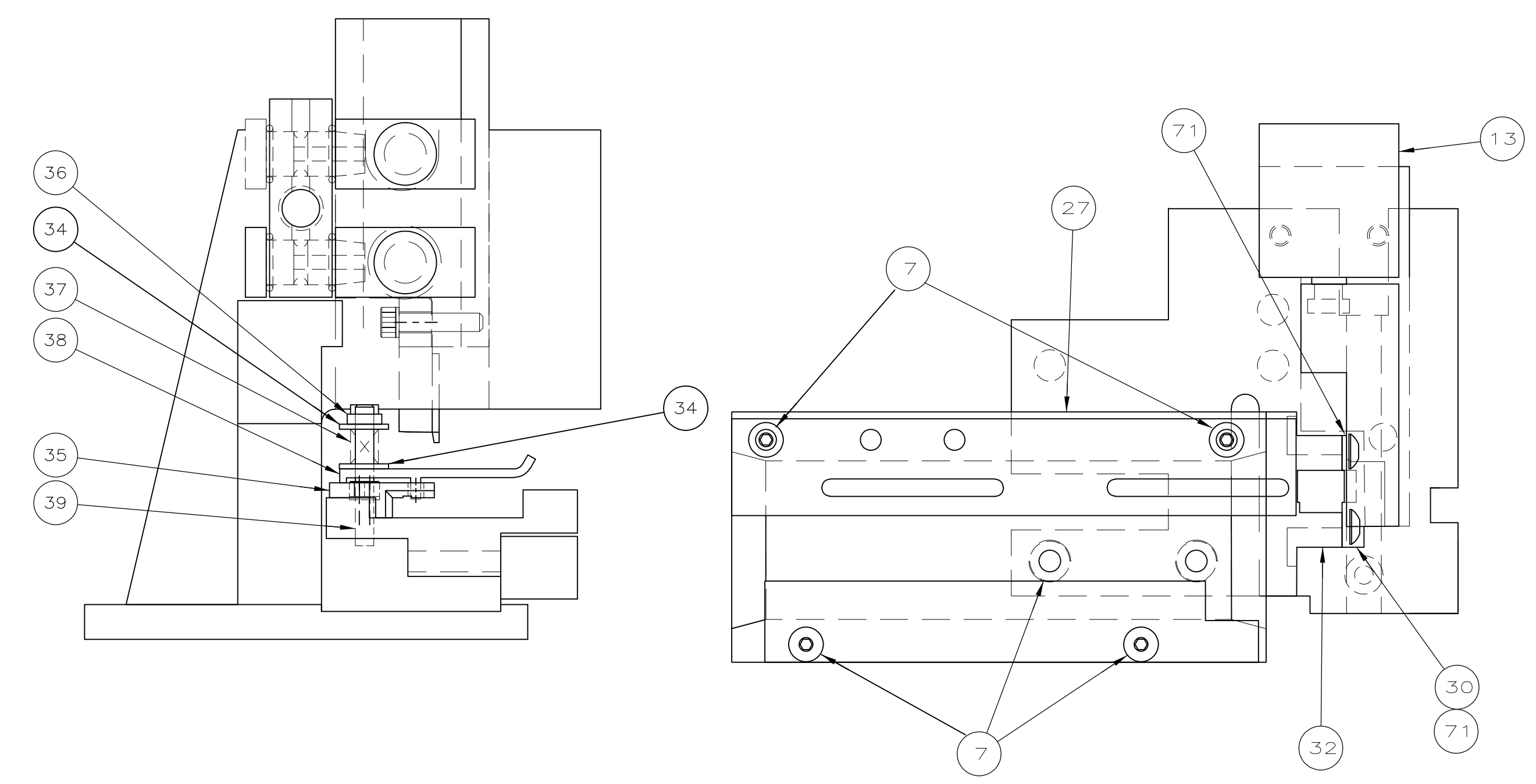
A



SHEET 3 FOR -4 ASSY ONLY

EXPLODED VIEW OF DETAIL A

SEE DETAIL A



								INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		C. ERISMAN APVD 9-28-95 Tyco Electronics Corporation Harrisburg, PA 17105-3608	
										0 PLC ± - 1 PLC ± - 2 PLC ± .02 3 PLC ± .005 4 PLC ± .0005		NAME A. BEDDICK ULTRA-POD APPLICATOR .250 STRAIGHT	
- SEE SHEET 1		-		-		-		ANGLES± -		SCALE		SIZE A1 DRAWING NO 1385719 SHEET 3 of 3 REV H	
P	LTR	REVISION RECORD		DATE		DWN		APVD		SURFACE TEXTURE		✓	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING													

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

LOC
A
DIST
66

4805 (1/08)

13JUL2009 8:22am

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