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LOC

DIST


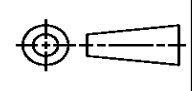
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A1	ECR-14-003639	12MAR2014	GK	HMR




REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2150056-2

FOR REPLACEMENT PARTS FOR APPLICATOR 1531014
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
1531014

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV		 TE Connectivity				
DIMENSIONS:		CHK	RAGHAVENDRA						
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME					
		0 PLC ±		FINE ADJUST END FEED HDI					
		1 PLC ±		APPLICATOR ASSY					
2 PLC ±		APVD		RAGHAVENDRA		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
3 PLC ±		PRODUCT SPEC							
4 PLC ±		APPLICATION SPEC							
ANGLES ±		WEIGHT		A 3					
FINISH		CUSTOMER DRAWING		SCALE		SHEET 1 OF 2		REV A1	

8				7							
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PART NUMBER		REV	TERMINATOR		FEED TYPE		DESCRIPTION				
1531014-1		A	BENCH & LEADMAKER		MECH POST FEED		HDI APPLICATOR				
7-1531014-1		A	BENCH & LEADMAKER		MECH POST FEED		-1 AND SPARE PARTS				
7-1531014-7		A	-		-		SPARE PARTS KIT				

CRIMP DATA		TE TERMINAL		TE CRIMP SPECS	
TERMINAL NAME: .250 FASTON RECEPTACLE					
CRIMP	SIZE	TYPE	RANGE		
WIRE	3.56 [.140 IN]	F	14-10 AWG		
INSUL	7.87 [.310 IN]	F	5.72-6.99 [.225-.275 IN] 3.56 [.140 IN] MAX X 2 14AWG		
WIRE STRIP LENGTH			APPL INSTRUCTIONS 		
5.46-5.84 [.215-.230 IN]			408-8323 & 408-8490		
TERMINAL	114-2036	-		FEED	
APPL SPEC	-	-		21.46 [.845 IN]	

TERMINALS APPLIED

60635	-	-	-
63539	-	-	-
63419	-	-	-
-	-	-	-
-	-	-	-

WIRE SIZE	CRIMP HEIGHT	REF SETTING
10AWG	2.67 ±0.05 [.105 ±.002 IN]	B0
2 X 14AWG	2.39 ±0.05 [.094 ±.002 IN]	B9
12AWG	2.24 ±0.05 [.088 ±.002 IN]	D2
14AWG	1.93 ±0.05 [.076 ±.002 IN]	E3
-	-	-



RECOMMENDED SPARE PARTS

GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.

CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.

4. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

TO CRIMP 10 AWG WIRE USE ITEM 40 (.005 SHIM). DO NOT USE ITEM 39 (.010 SHIM).

TO CRIMP (2) 14 AWG WIRES OR 12 AWG WIRE USE ITEM 39 (.010 SHIM). DO NOT USE ITEM 40 (.005 SHIM).

TO CRIMP 14 AWG WIRE USE ITEMS 39 (.010 SHIM) AND 40 (.005 SHIM).

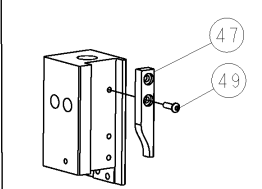
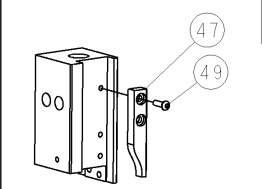
WIRE SIZE	
10 AWG -	.005 SHIM
(2) 14 AWG -	.010 SHIM
12 AWG -	.010 SHIM
14 AWG -	.010 SHIM & .005 SHIM

8. SETUP & QUALIFY APPLICATOR USING ITEMS 38 & 39.

VIEW B ROTATED 180°

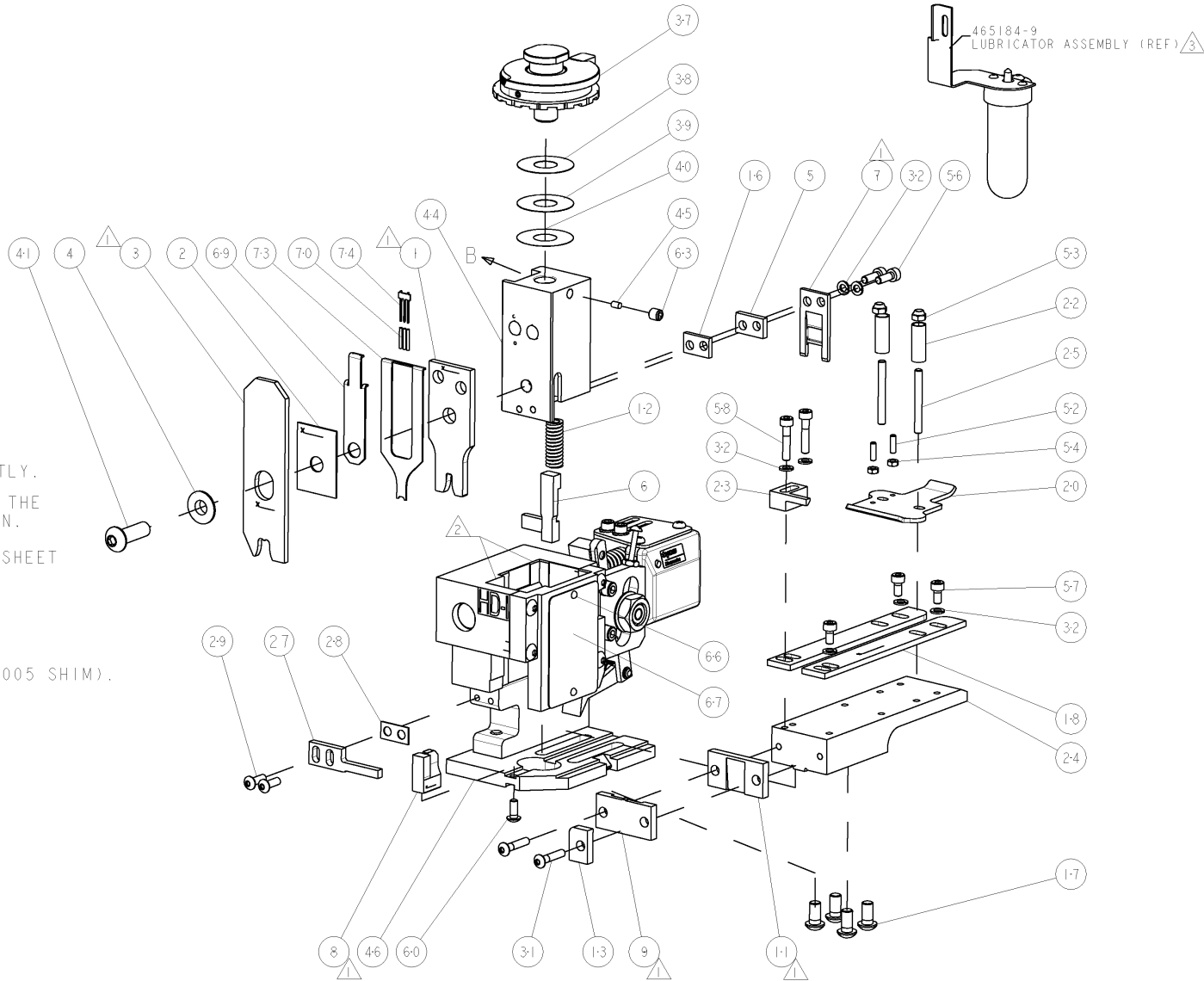
POST-FEED 40mm STROKE

POST-FEED 30mm 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.

SET UP GAGE
458638-3

LOC	DIST	REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE
		A	RELEASED		20NOV2008
					MEH
					GB

-	1	1	1424350-1	HOLDER, PIN, WIRED	74
-	1	1	1490525-5	DEPRESSOR, WIRE	73
-	1	1	1338705-4	DOCUMENTATION PACKAGE	71
-	3	3	2-23147-2	SPRING, COMPRESSION	70
-	1	1	1490524-2	DEPRESSOR, SPACER	69
-	1	1	461264-5	PLATE, IDENTIFICATION	67
-	2	2	21017-2	SCREW, DRIVE	66
-	1	1	3-18031-0	SCR, SET, CUP POINT M6 X 6.0	63
-	1	1	18024-7	SCR, BTN SKT HD CAP (M4 X 10.0)	60
-	2	2	1-18023-4	SCR, SKT HD CAP M4 X 20.0	58
-	3	3	1-18023-0	SCR, SKT HD CAP M4 X 8.0	57
-	2	2	1-18023-2	SCR, SKT HD CAP M4 X 12.0	56
-	2	2	18029-1	NUT, HEX, REG M3	54
-	2	2	986965-1	NUT, LOCK, HEX, TORQUE (M4)	53
-	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	52
-	1	1	18024-3	SCR, BTN SKT HD CAP (M3 X 10.0)	49
-	1	1	1338676-1	CAM, UNIVERSAL POST-FEED	47
-	1	1	1338662-2	SUB ASSY, APPLICATOR FRAME	46
-	1	1	690191-1	PLUG, NYLON	45
-	1	1	1333260-1	RAM	44
-	1	1	2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)	41
-	1	1	469367-2	SHIM	40
-	1	1	469367-1	SHIM	39
-	1	1	690125-1	SHIM SUB-ASSY	38
-	1	1	879103-2	FINE ADJUST HEAD ASSEMBLY	37
-	7	7	18025-2	WASHER, SPRG LOCK, REG M4	32
-	2	2	1-18024-0	SCR, BTN SKT HD CAP (M4 X 20.0)	31
-	2	2	18024-8	SCR, BTN SKT HD CAP (M4 X 12.0)	29
-	1	1	1-690451-7	SPACER, STRIPPER	28
-	1	1	690455-3	STRIPPER, FRONT CASTING	27
-	2	2	1320906-1	STUD, THREADED	25
-	1	1	1-1320995-2	PLATE, STRIP GUIDE	24
-	1	1	240825-5	PLATE, STRIP HOLD DOWN	23
-	2	2	2-22281-6	SPRING, COMPRESSION	22
-	1	1	1338665-1	DRAG	20
-	2	2	454204-4	GUIDE, LOWER STRIP	18
-	4	4	1-18024-8	SCR, BTN SKT HD CAP (M6 X 12.0)	17
-	1	1	1338708-1	SPACER, SLUG BLADE	16
-	1	1	690481-2	SPACER, HOLD DOWN	13
-	1	1	23846-1	SPRING, DIE	12
-	1	1	240644-5	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	4-690495-3	PLATE, FRONT SHEAR	9
-	1	2	4-1633383-8	ANVIL, COMBINATION	8
-	1	1	1-690474-9	BLADE, SLUG	7
-	1	1	1-455892-1	HOLD DOWN, TERMINAL	6
-	1	1	240641-8	SPACER	5
-	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	2	1-1213077-9	CRIMPER, INSULATION PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
-	1	2	456411-9	CRIMPER, WIRE PREMIUM	1

-77-71-1		PART NO	DESCRIPTION			ITEM NO
1. THE CUSTOMER'S RESPONSIBILITY FOR THE FOLLOWING INFORMATION IS LIMITED TO THE INFORMATION PROVIDED BY THE CUSTOMER. THE CUSTOMER'S RESPONSIBILITY FOR THE INFORMATION PROVIDED BY THE CUSTOMER IS LIMITED TO THE INFORMATION PROVIDED BY THE CUSTOMER.						
SPECIFICATIONS:		OWN M. BETTIS		Tyco Electronics		130CT2008
DIMENSIONS:		CHK		Tyco Electronics		
HES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		Harrisburg, PA 17105-3608		
0 P L C ±		APVD M. CLIFFORD		NAME		
1 P L C ±0.1		PRODUCT SPEC		FINE ADJUST END FEED		
2 P L C ±0.01		APPLICATION SPEC		HDI APPLICATOR		
3 P L C ±0.001		SIZE		-		
4 P L C ±0.0001		CASE CODE		DRAWING NO		
ANGLES ±		WEIGHT		RESTRICTED TO		
FINISH		A1 00779		C=1531014		
-		CUSTOMER DRAWING		SCALE 3:5		
-				SHEET 1 OF 1		
				REV A		
CUSTOMER VIEWABLE ASSEMBLY						

Mouser Electronics

Authorized Distributor

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