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LOC

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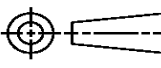
REVISIONS

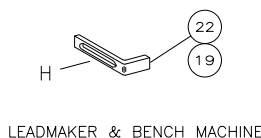
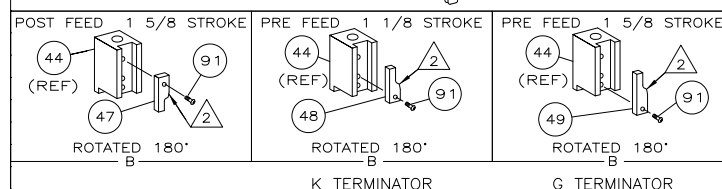
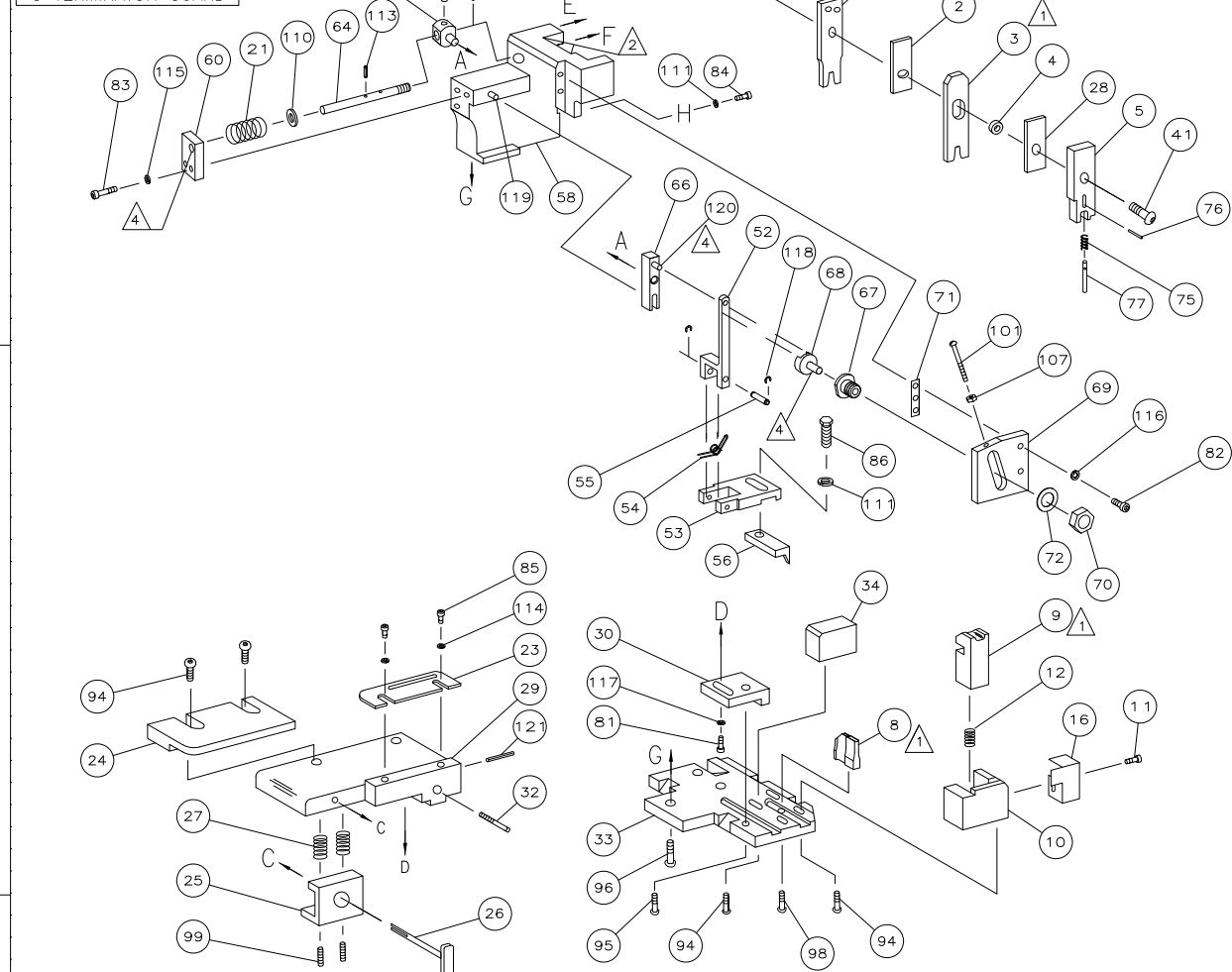
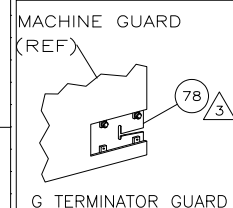
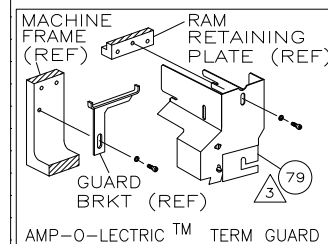
P	LTR	DESCRIPTION	DATE	DWN	APVD
	E2	ECR-14-003312	05MAR2014	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART  
NUMBER 2151245-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1385559  
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  
1385559

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- 1385559		
		CUSTOMER DRAWING		SCALE		SHEET 1 OF 2
						REV E2



- 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 CUT TO LENGTH AT ASSEMBLY.
- 7 APPL FEED ADJUSTMENT REQUIRED WHEN CHANGING FROM ONE GROUP TO ANOTHER.
- 8 TERMINAL SPEC FOR GROUP 1 IS (114-18079-0)  
TERMINAL SPEC FOR GROUP 2 IS (114-18080-0)

TERMINAL NAME: DOUBLE FLAT-LEAF CONTACT									
500 FEED		.800 FEED		CRIMPING DATA					
GROUP 1	GROUP 2	REF SETTING	CRIMP HEIGHT			WIRE SIZE			
925595	925612	B2	.067	±002	[1.70 ±0.05mm]	2.5mm <sup>2</sup>			
925621	826042	B9	.063	±002	[1.59 ±0.05mm]	14			
	926006								
	926923	C2	.062	±002	[1.58 ±0.05mm]	2.00mm <sup>2</sup>			
	964202	C3	.060	±002	[1.52 ±0.05mm]	1.75mm <sup>2</sup>			
	928805								
	926973	C9	.057	±002	[1.45 ±0.05mm]	1.50mm <sup>2</sup> or (2)18			
		D2	.055	±002	[1.40 ±0.05mm]	1.25mm <sup>2</sup> or 16			
		D6	.052	±002	[1.32 ±0.05mm]	1.0mm <sup>2</sup>			
		D9	.050	±002	[1.27 ±0.05mm]	0.8mm <sup>2</sup> OR 18			
		CRIMP	SIZE		TYPE	RANGE			
		WIRE	.110	[2.79mm]		F	0.8-2.5mm <sup>2</sup> or 18-14		
		INSUL	.155	[3.94mm]		F	.118-.170		
WIRE STRIP LENGTH		TERM APPL SPEC	△ FEED	APPL INSTRUCTION		SET UP GAGE		LAYOUT	
.156-.188		114-18079-0	.500/.800	408-8040		458637-1		1245	

[illegible]

LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	OWN	AP
			E1	ECR-09-009221	4-2009	MY	G

-1	LEADMAKER	MECH POST FEED
-2	BENCH MODEL K	MECH PRE FEED
-3	BENCH MODEL G	MECH PRE FEED

REF	REF	REF	—	22594-8	NUT, HEX(1/2-20)	70
REF	REF	REF	—	240628-1	PLATE, ADJUSTMENT	69
REF	REF	REF	—	240626-1	SHAFT, PIVOT	68
REF	REF	REF	—	240633-1	BUSHING	67
REF	REF	REF	—	455680-1	LEVER, INTERMEDIATE	66
REF	REF	REF	—	240629-1	BLOCK, PIVOT	65
REF	REF	REF	—	240632-2	SCREW, ADJ FEED ROD	64
REF	REF	REF	—	240659-3	PIN, CAM ROLLER	63
REF	REF	REF	—	240658-1	ROLLER, CAM	62
REF	REF	REF	—	454398-2	ROD, FEED	61
REF	REF	REF	—	454178-1	GUIDE, FEED ROD	60
REF	REF	REF	—	454220-1	CAP, RAM	59
REF	REF	REF	—	454485-1	HOUSING	58

1	1	1	—	458537-2	PAWL, FEED	57
REF	REF	REF	—	240624-1	PIN, FEED FINGER	56
REF	REF	REF	—	691499-1	SPRING, FEED FINGER	55
REF	REF	REF	—	690541-1	HOLDER, FEED FINGER	53
REF	REF	REF	—	455679-1	LEVER, TERMINAL FEED ARM	52
1	1	1	—	811242-2	BUMPER, HOLDDOWN	51
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	—	690501-4	CAM, POST-FEED 1 5/8 ST	47
1	1	1	—	459456-1	APPLICATOR, BASIC (SUBASSY)	46
1	1	1	—	690191-1	PLUG, NYLON	45
1	1	1	—	455673-1	RAM	44
1	1	1	—	469367-2	SPACER, FINE ADJUST	43
1	1	1	—	469367-9	SPACER, FINE ADJUST	42
1	1	1	—	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41

1	1	1	—	879103-2	FINE ADJUST HEAD SUBASSY	37
						36
1	1	1	—	690786-1	SUPPORT, TERMINAL	34
REF	REF	REF	—	455675-1	PLATE, BASE	33
1	1	1	—	690432-3	SCREW, ADJUSTMENT	32

REF	REF	REF	—	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	—	455671-6	PLATE, STRIP GUIDE	29
1	1	1	—	1-455888-8	SPACER, FRONT SHEAR DEP	28
2	2	2	—	1-22284-0	SPRING, DRAG	27
1	1	1	—	690546-1	LEVER, DRAG RELEASE	26
1	1	1	—	240792-5	DRAG, TERMINAL	25
1	1	1	—	7-690504-6	GUIDE, STRIP (REAR)	24
1	1	1	—	1-690438-0	GUIDE, STRIP (FRONT)	23
—	—	1	—	690472-2	STRIPPER	22
REF	REF	REF	—	4-22284-9	SPRING, FEED RETURN	21


1	1	-	-	691353-1	STRIPPER	19
						18
						17
1	1	1	-	318563-1	GUARD, CHIP, FRONT	16

1	1	1	—	3-22280-3	SPRING, SHEAR	12
1	1	1	—	690461-1	STOP, SHEAR	11
1	1	1	—	690459-1	HOLDER, SHEAR (FRONT)	10
1	1	1	—	462006-1	SHEAR, FLOAT (FRONT)	9
1	1	1	—	2-803653-7	ANVIL	8

1	1	1	—	1-240641-6	SPACER	7
1	1	1	—	854772-1	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	—	2-238011-2	SPACER, BLOCK CRIMPER	4
1	1	1	—	683453-3	CRIMPER, INSULATION	3
1	1	1	—	455888-8	SPACER, CRIMPER	2
1	1	1	—	456408-2	CRIMPER, WIRE	1

-3	-2	-1	U/M	PART NO	DESCRIPTION	ITE NO
				PARTS LIST		
QTY REQD PER ASSY						

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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	CITY		Harrisburg, PA 17105-3608	
INCHES			PART NO.		NAME	
		0 P/LC ± .0005	11FEB03		SIDE FEED HDM APPLICATOR	
		1 P/LC ± .0005	APPROX PRODUCT SPEC		—	
		3 P/LC ± .0005	APPLICATION SPEC		—	
		4 P/LC ± .0005	—		SIZE CAGE CODE DRAWING NO	
		ANODIZE — ± .0005	WEIGHT —		RESTRICTED	
MATERIAL	FINISH		CUSTOMER DRAWING		SCALE SHEET 1 OF 1 REV E	
—	—		A1 00779 © 1385559			

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