

8

7

6

5

4

3

2

1

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LOC

A

DIST

66

REV

1

DESCRIPTION

ECR-07-027017

DATE

11-2007

DWN

MY

APVD

TE

PART NUMBER

REV

FIRST USED

1385813-1

C

AOM/CLS

1385813-2

A

K UNIT

1385813-3

C

G UNIT

1385813-4

C

KOMAX

OBS

1

RECOMMENDED SPARE PARTS.

2

ITEMS NOT SHOWN ON ASSEMBLY.

3

TOLERANCE ON CUT LENGTH TO BE ±.13.

4

USED ON THE CLS I AND II MACHINES ONLY. REMOVE THE TWO MOUNTING SCREWS SECURING THE PRODUCT DEREELER AND PLACE THE PRODUCT GUIDE (ITEM 111) ON TOP OF THE MOUNTING BRACKET. REASSEMBLE AND RETIGHTEN THE TWO MOUNTING SCREWS.

5

SPRING LOADED TONKER (P/N 354853-1) MUST BE USED WHEN RUNNING THE APPLICATOR ON A LEADMAKER.

6

AIR VALVE CONVERSION KIT, PN 1633069-2 FOR KOMAX MACHINE.

7

GRIND BOTTOM OF ITEM 46 IF IT PROTRUDES BELOW BOTTOM OF ITEM 95.

8

CUT TO LENGTH AT ASSEMBLY

9

SHIM AS REQUIRED TO ALIGN THE POD WITH THE POD INSERTER.

10

SHIM MAY BE REQUIRED BETWEEN STRIP GUIDE PLATE (ITEM 53) AND REAR STRIP GUIDE (ITEM 95) TO CENTER THE TERMINAL OVER THE ANVIL.

TERMINAL APPLIED:

521112

521633

1969110

CRIMPING DATA

PAD LETTER

CRIMP HEIGHT

WIRE SIZE

STRIP LENGTH

A

.070

#14

B

.065

(2)#18

C

.061

#16

D

.055

#18

CRIMP

SIZE

TYPE

FEED

TERM SPEC

WIRE

.110

F

INSUL

.220

0

INSUL RANGE

WIRE RANGE

APPLICATOR INSTRUCTION SHEET

.110-.160

18-14

AI 8099

(2).105MAX

(2)18

AI 8102

KOMAX SET-UP INSTRUCTIONS FOR APPLICATOR 1385813-4

*MUST USE SPRING LOADED TONKER (P/N 1-509538-7).

*TRIGGER POINT WHEN PRESS IS MOVING UP MUST BE SET AT 1.38".

*PROCESS SPEED MUST BE SET TO 90%.

*ACTUATION SPEED FOR FEED CYLINDER MUST BE SET AT 350 MILLISECONDS.

*OPTIMATION MUST BE UNCHECKED.

*SET REFERENCE PRESS HEIGHT SETTING TO 17 ON THE PRESS SCALE.

*WHEN SETTING TRANSFER HEIGHT, WIRE MUST BE LEVEL TO THE BOTTOM OF THE WIRE BARREL AT BOTTOM DEAD CENTER.

*WIRE MUST BE BIASED AWAY FROM THE LONG INSULATION LEG OR STRANDING MAY OCCUR.

*IF LONG INSULATION LEG IS CATCHING POD DURING INSERTION, SPRING LOADED TONK IS SET TOO HIGH.

*FEED PAWL MUST BE SET UP AS CLOSE AS POSSIBLE TO THE SKATE DRAG.

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DWN

K. STAKEM

8/24/04

CHK

C.ERISMAN

8/24/04

DIMENSIONS:

INCHES

0 PLC

±

-

1 PLC

±

-

2 PLC

±

-

3 PLC

±

-

4 PLC

±

-

ANGLES

±

-

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC

±

-

1 PLC

±

-

2 PLC

±

-

3 PLC

±

-

4 PLC

±

-

ANGLES

±

-

MATERIAL

-

FINISH

-

APVD

T. FLRIN

8/24/04

PRODUCT SPEC

APPLICATION SPEC

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

WEIGHT

-

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

CUSTOMER DRAWING

SCALE

1:1

SHEET

1

OF

3

REV

C1

AMP 4805 REV 31MAR2000

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DWN

K. STAKEM

8/24/04

CHK

C.ERISMAN

8/24/04

DIMENSIONS:

INCHES

0 PLC

±

-

1 PLC

±

-

2 PLC

±

-

3 PLC

±

-

4 PLC

±

-

ANGLES

±

-

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC

±

-

1 PLC

±

-

2 PLC

±

-

3 PLC

±

-

4 PLC

±

-

ANGLES

±

-

MATERIAL

-

FINISH

-

APVD

T. FLRIN

8/24/04

PRODUCT SPEC

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SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

WEIGHT

-

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DRAWING NO

RESTRICTED TO

CUSTOMER DRAWING

SCALE

1:1

SHEET

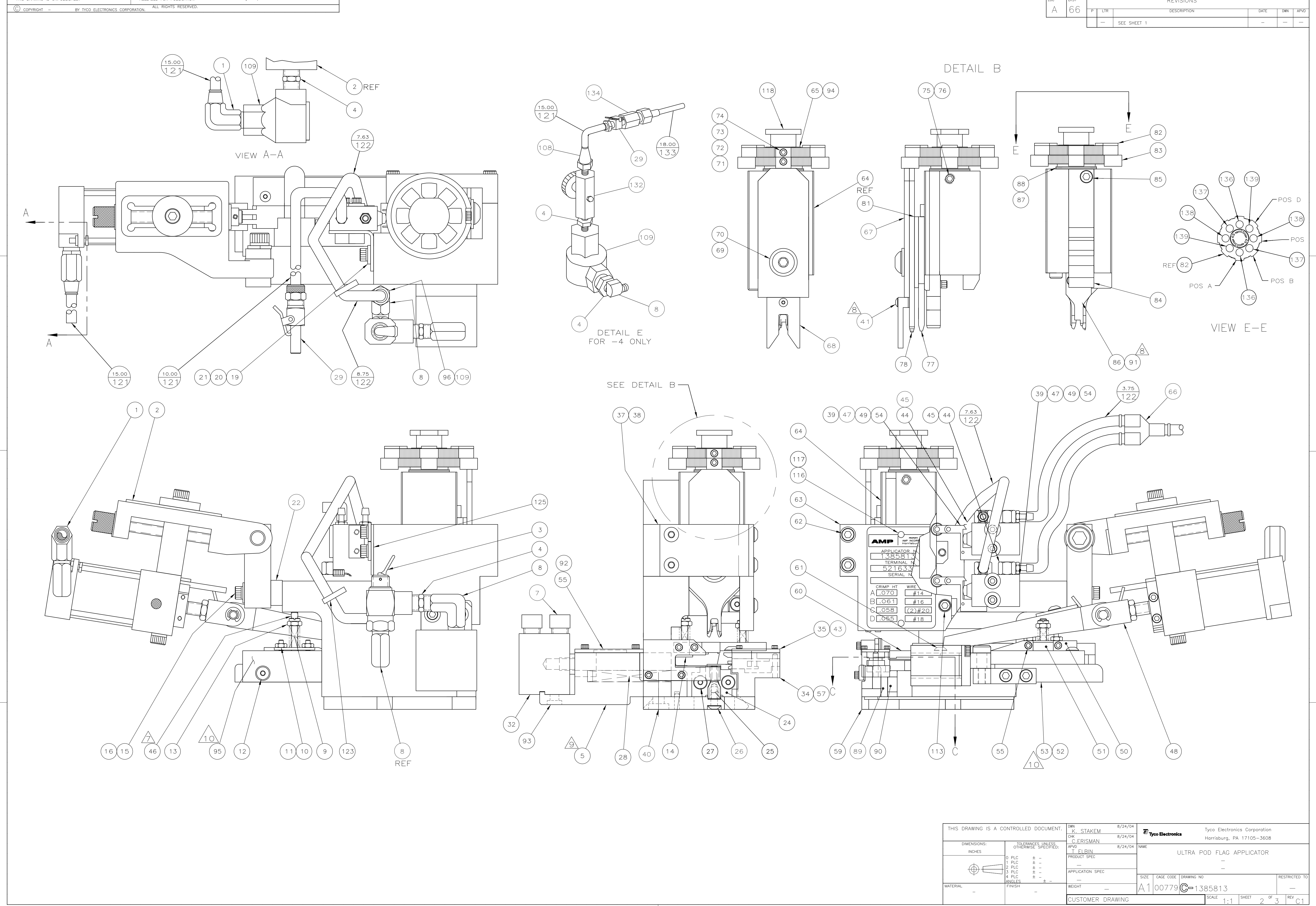
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OF

3

REV

C1



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