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LOC

DIST

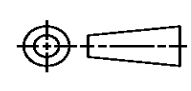
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	G1	ECR-14-002428	22FEB2014	GK	HMR

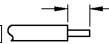
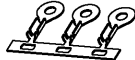
REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2151041-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1528161
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
1528161

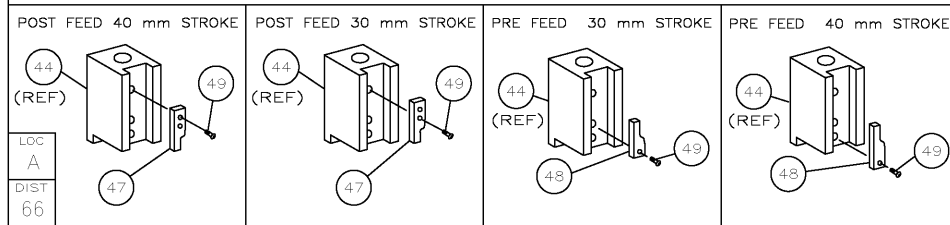
THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN GOPALAKRISHNA HV		 TE Connectivity	
DIMENSIONS:		CHK RAGHAVENDRA			
		APVD RAGHAVENDRA		NAME FINE ADJ SIDE FD HD-I APPL	
		PRODUCT SPEC		SIZE A3	
		APPLICATION SPEC		CAGE CODE	
MATERIAL		WEIGHT		DRAWING NO C- 1528161	
FINISH		CUSTOMER DRAWING		RESTRICTED TO	
		SCALE		SHEET 1 OF 2 REV G1	

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1528161-1	G	-	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528161-2	G	-	BENCH	MECH PRE FEED	CUTS CARRIER
1528161-6	G	-	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528161-1	G	-	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528161-2	G	-	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528161-6	G	-	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528161-7	A	-	-	-	SPARE PARTS KIT

CRIMP DATA AMP TERMINAL AMP CRIMP SPECS				
TERMINAL NAME: AMP MCP 1.2-LL				
CRIMP	SIZE	TYPE	RANGE	
WIRE	1.27 [.050 IN]	F	0.25mm ² -0.35mm ² (24-22 AWG)	
INSUL	3.05 [.120 IN]	0	1.10-1.75 [.043-.069 IN] 	
WIRE STRIP LENGTH		APPL INSTRUCTION		
3.00-3.60 [.118-.142 IN] 		408-8322 & 408-8490		
TERMINAL	-	-		FEED
APPL SPEC	114-18464	-	-	7.50 [.295 IN]
TERMINALS APPLIED 				
TERMINAL	SEAL	-	-	-
1452665	967067-1	-	-	-
-	967067-2	-	-	-
-	963142-2	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
WIRE SIZE 		CRIMP HEIGHT 		REF SETTING 
mm ² AWG		*		
0.35mm ²		0.84 ±0.03 [.033 ±0.001 IN]		B0
22 AWG		0.83 ±0.03 [.033 ±0.001 IN]		B0
0.25mm ²		0.78 ±0.03 [.031 ±0.001 IN]		B3
24 AWG		0.75 ±0.03 [.030 ±0.001 IN]		B5
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-

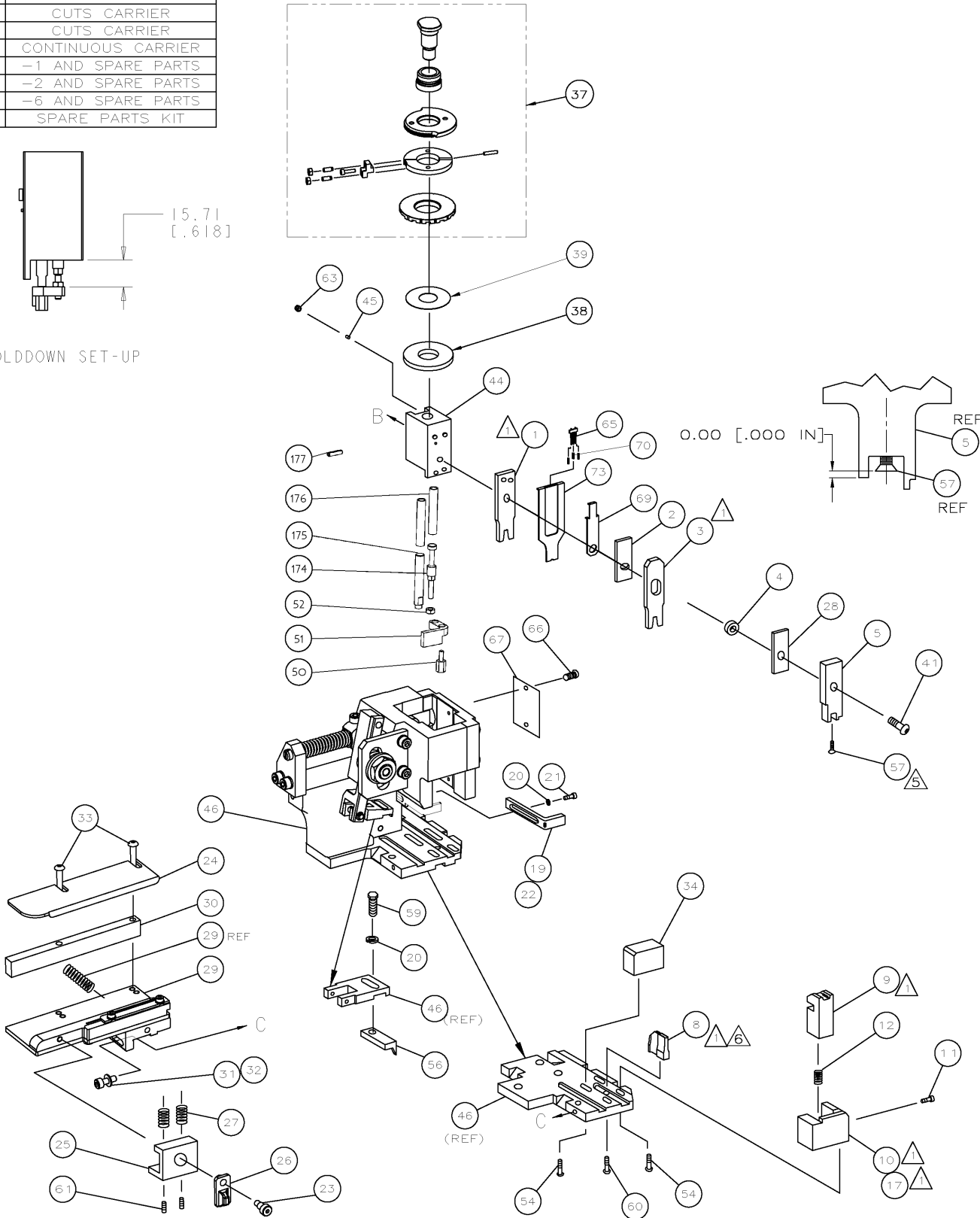
1. RECOMMENDED SPARE PARTS.
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
4. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. WIRE INSULATION DIA IS DEPENDENT ON SEAL BEING APPLIED. CHOICE OF SEAL IS DEPENDENT ON HOUSING CAVITY DIA. & WIRE APPLIED. REFER TO APPL. SPEC. FOR DETAILS.
5. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
6. DUE TO THE DEMANDS OF APPLICATION SPEC 114-18464 IT IS IMPORTANT, IF THE ANVIL IS MOVED OR REPLACED, THAT IT IS BIASED TOWARDS THE OPERATOR'S POSITION AS FAR AS POSSIBLE WHEN RE-SECURING TO THE BASE PLATE.

VIEW B ROTATED 180°



* 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.



TOOLING APPROVED BY
GB GATD & TERMINAL
PRODUCT ENGINEERING
GERMANY.

-	1	1	1	1	1	1	993111-8	PIN, SLOTTED SPRING 3.0X12.0	177
-	2	2	2	2	2	2	3-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1	1752353-1	GUIDE PIN, HOLD DOWN	175
-	1	1	1	1	1	1	1901680-1	GUIDE PIN, HOLD DOWN	174
-	1	1	1	1	1	1	1490525-1	DEPRESSOR, WIRE	73
-	1	1	1	1	1	1	1528161	PRINT, APPLICATOR LOG SHEET	72
-	1	1	1	1	1	1	1338705-3	DOCUMENTATION PACKAGE	71
-	3	3	3	3	3	3	2-23147-2	SPRING, DEPRESSOR	70
-	1	1	1	1	1	1	1490524-2	SPACER, DEPRESSOR	69
-	1	1	1	1	1	1	461264-5	PLATE, IDENTIFICATION	67
-	2	2	2	2	2	2	21017-2	SCR,DRIVE(#2x.19)ID PLATE	66
-	1	1	1	1	1	1	1424350-1	HOLDER, PIN, WIRED	65
-	1	1	1	1	1	1	3-18031-0	SCR,SKT SET(M6X6)RAM	63
-	2	2	2	2	2	2	2-18032-5	SCR,SET(M5X20)DRAG	61
-	1	1	1	1	1	1	18024-7	SCR,BHC(M4X10)ANVIL	60
-	1	1	1	1	1	1	5-18022-2	SCR,HEX(M4X8)FEED FINGER	59
-	1	1	1	1	1	1	985575-3	SCR,FHC(M3X10)DEP	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-									55
-	4	4	4	4	4	4	18024-8	SCR,BHC(M4x12)SHEAR HOLDER	54
-									53
-	1	1	1	1	1	1	1-18030-0	NUT, HEX, REG M3.5	52
-	1	1	1	1	1	1	1901681-1	HOLD DOWN, TERMINAL	51
-	1	1	1	1	1	1	1-1752354-7	STANDOFF, HOLD-DOWN	50
-	1	1	1	1	1	1	18024-3	SCR,BHC(M3X10)CAM	49
-	-	-	-	-	-	-	1338675-1	CAM, PRE FEED 30 & 40 mm ST	48
-	-	-	-	-	-	-	1338676-1	CAM, POST FEED 30 & 40 mm ST	47
-	1	1	1	1	1	1	1320999-3	APPLICATOR BASIC SUBASSY	46
-	1	1	1	1	1	1	690191-1	PLUG, NYLON	45
-	1	1	1	1	1	1	1633724-1	RAM	44
-									43
-									42
-	1	1	1	1	1	1	2-18024-6	SCR,BHC(M8X25)RAM	41
-									40
-	1	1	1	1	1	1	690125-1	SHIM SUBASSY	39
-	1	1	1	1	1	1	469367-7	SPACER, FINE ADJUST	38
-	1	1	1	1	1	1	879103-3	FINE ADJUST HEAD SUBASSY	37
-									36
-									35
-	1	1	1	1	1	1	1-1752356-8	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	1-18024-0	SCR,BHC(M4X20)STRIP GUIDE	33
-	1	1	1	1	1	1	18027-2	WASHER, FLAT(M4)	32
-	1	1	1	1	1	1	1-18023-2	SCR,SKT CAP(M4X12)MOUNT BLOCK	31
-	1	1	1	1	1	1	1320908-3	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1	1633073-2	STRIP GUIDE PLATE ASSY	29
-	1	1	1	1	1	1	455888-7	SPACER, FRONT SHEAR DEP	28
-	2	2	2	2	2	2	1-22284-0	SPRING, DRAG	27
-	1	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1	1	1320928-2	PLATE, STRIP GUIDE	24
-	1	1	1	1	1	1	980371-4	SCR,SHC SHLD	23
-	1	-	-	-	-	-	690472-2	STRIPPER	22
-	1	1	1	1	1	1	1-18023-1	SCR,SHC(M4X10)STRIPPER	21
-	4	4	4	4	4	4	18025-2	WASHER,LOCK(M4)STRIPPER	20
-	-	-	-	-	-	-	1424364-1	STRIPPER	19
-	1	-	-	-	-	-	1338684-2	HOLDER, SHEAR, FRONT (NO-CUT)	17
-									16
-									15
-									14
-									13
-	1	1	1	1	1	1	3-22280-3	SPRING, SHEAR	12
-	1	1	1	1	1	1	356885-5	STOP, SHEAR	11
-	-	-	-	-	-	-	1-1320921-0	HOLDER, SHEAR, FRONT (CUT)	10
-	1	1	1	1	1	1	318707-9	SHEAR, FLOAT (FRONT)	9
-	1	2	2	2	1	1	3-1333225-9	ANVIL	8
-									7
-									6
-	1	1	1	1	1	1	1338680-1	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	1	1	1	238011-4	SPACER, BLOCK CRIMPER	4
-	1	2	2	2	1	1	1-1583690-1	CRIMPER, INSULATION	3
-	1	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	2	2	2	1	1	1-1673600-0	CRIMPER, WIRE	1
-77	-76	-72	-71	-6	-2	-1	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY							REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)		
DIMENSIONS: mm [INCHES]							PARTS LIST		
DO NOT SCALE PRINT.							MATL	HT TR	FIN
TOLERANCES UNLESS OTHERWISE SPECIFIED:							DR LLOTHOUSE	10JUN03 APP	10JUN03 F.BACKHURST
1 PLC DEC ±							CHK -	REL 26-05-04	M.CLIFFORD
2 PLC DEC ±							TE Connectivity		
3 PLC DEC ±							Harrisburg, PA 17105-3608		
ANGLES ±							NAME FINE ADJ SIDE FD HD-I APPL		
SURF TEXTURE:							SCALE		
REMOVE BURRS, BREAK SHARP EDGES R0.38 MAX							DWG NO 1528161		
G ECR-11-018148							MACHINE REF		
P/F LTR REVISION RECORD							SHEET 1 of 1		
DATE 01SEP2011							REV G		
QTY CODE 00779							CUSTOMER AND ASSEMBLY DRAWING		
RESTRICTED TO									

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