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LOC

DIST

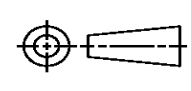
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	C1	ECR-14-001798	07FEB2014	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2151258-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1528246
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
1528246

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN Gopalakrishna HV		 TE Connectivity	
CHK RAGHAVENDRA		APVD RAGHAVENDRA			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME FINE ADJ SIDE FD HD-I APPL	
		0 PLC ±		SIZE A3	
		1 PLC ±		CAGE CODE	
		2 PLC ±		DRAWING NO	
		3 PLC ±		RESTRICTED TO	
4 PLC ±		4 PLC ±		C- 1528246	
MATERIAL		FINISH		WEIGHT	
				CUSTOMER DRAWING	
				SCALE	
				SHEET 1 OF 2	
				REV C1	

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LOC

DIST

REV

DESCRIPTION

DATE

DWN

APVD

A

66

ECR-08-025427

10-2008

MY

TE

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1528246-1	C	-	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528246-2	C	-	BENCH	MECH PRE FEED	CUTS CARRIER
1528246-6	C	-	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528246-1	C	-	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528246-2	C	-	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528246-6	C	-	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528246-7	A	-	-	-	SPARE PARTS KIT

CRIMP DATA

AMP TERMINAL

AMP CRIMP SPECS

TERMINAL NAME: STANDARD POWER TIMER CONTACT.

CRIMP	SIZE	TYPE	RANGE
WIRE	3.30 [.130 IN]	F	>2.50mm ² - 4.00mm ²
INSUL	6.60 [.260 IN]	0	6.0 MAX [.236 IN]

WIRE STRIP LENGTH

5.00-5.60 [.197-.220 IN]

APPL INSTRUCTION

408-8322 & 408-8490

TERMINAL

APPL SPEC

114-18037

FEED

19.00 [.748 IN]

TERMINALS APPLIED

TERMINAL	AMP SEAL	-	-	-
964334	963245	-	-	-
928966	-	-	-	-
968037	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-

WIRE SIZE	CRIMP HEIGHT	REF
mm ² AWG	*	SETTING
4.00mm ²	2.35 ±0.05 [.093 ±.002 IN]	A 0
3.00mm ²	2.13 ±0.05 [.084 ±.002 IN]	B 7
2.50mm ²	2.02 ±0.05 [.080 ±.002 IN]	C 3

SET UP GAGE

LAYOUT

458637-3

L1426156

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. INSULATION DIA QUOTED IS OUTSIDE DIA OF SEAL. WIRE INSULATION DIA IS DEPENDENT ON SEAL BEING APPLIED.

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. WIRE SIZES OUTSIDE THE NOMINAL RANGE MAY BE APPLIED FOR SPECIAL CUSTOMER REQUIREMENTS AND THEREFORE MAY NOT CONFORM TO PARAMETERS LISTED IN APPL SPEC.

VIEW B

ROTATED 180°

POST FEED 40 mm STROKE	POST FEED 30 mm STROKE	PRE FEED 30 mm STROKE	PRE FEED 40 mm STROKE

4805 (1/08)

09OCT2008 8:55am

3.048 [.120 IN]

REF

REF

* WARNING:

ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN REQ'D CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

	1	1	1	1	1	1	1528246	PRINT, APPLICATOR LOG SHEET	72	
	1	1	1	1	1	1	1338705-3	DOCUMENTATION PACKAGE	71	
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									69	
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	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	
									65	
									64	
	1	1	1	1	1	1	3-18031-0	SCR,SKT SET(M6X6)RAM	63	
									62	
	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	
									58	
	1	1	1	1	1	1	985575-3	SCR,FHC(M3X10)DEP	57	
	1	1	1	1	1	1	1338685-1	PAWL, FEED	56	
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	4	4	4	4	4	4	18024-8	SCR,BHC(M4X12)SHEAR HOLDER	54	
									53	
	1	1	1	1	1	1	18030-1	NUT,HEX(M3)HOLD DOWN	52	
	1	1	1	1	1	1	811242-6	BUMPER, HOLDDOWN	51	
	1	1	1	1	1	1	690753-2	SPACER, TONKER	50	
	1	1	1	1	1	1	18024-3	SCR,BHC(M3X10)CAM	49	
	-	1	-	-	1	-	1338675-1	CAM, PRE FEED 30 & 40 mm ST	48	
	1	-	1	1	-	1	1338676-1	CAM, POST FEED 30 & 40 mm ST	47	
	1	1	1	1	1	1	1320999-4	APPLICATOR BASIC SUBASSY	46	
	1	1	1	1	1	1	690191-1	PLUG, NYLON	45	
	1	1	1	1	1	1	1338660-1	RAM	44	
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	1	1	1	1	1	1	2-18024-6	SCR,BHC(M8X25)RAM	42	
									41	
	1	1	1	1	1	1	469367-2	SHIM SUBASSY	39	
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	1	1	1	1	1	1	879103-2	FINE ADJUST HEAD SUBASSY	37	
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									35	
	1	1	1	1	1	1	1-1320934-2	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	
	3	3	3	3	3	3	1-18023-2	SCR,SKT CAP(M4X12)MOUNT BLOCK	31	
	1	1	1	1	1	1	1320908-7	SPACER, STRIP GUIDE	30	
	1	1	1	1	1	1	1633073-1	STRIP GUIDE PLATE ASSY	29	
	1	1	1	1	1	1	455888-6	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	-	1	1	-	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	
	-	1	-	-	1	-	690472-1	STRIPPER	19	
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	1	-	-	1	-	-	1338684-2	HOLDER, SHEAR, FRONT (NO-CUT)	17	
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									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	1	-	1	1	1-1320921-0	HOLDER, SHEAR, FRONT (CUT)	10	
	1	1	1	1	1	1	318707-1	SHEAR, FLOAT (FRONT)	9	
	1	2	2	2	1	1	1333229-5	ANVIL	8	
									7	
									6	
	1	1	1	1	1	1	1338680-6	DEPRESSOR, SHEAR (FRONT)	5	
	1	1	1	1	1	1	4-238011-7	SPACER, BLOCK CRIMPER	4	
	1	2	2	2	1	1	2-904741-7	CRIMPER, INSULATION	3	
	1	1	1	1	1	1	1-455888-3	SPACER, CRIMPER	2	
	1	2	2	2	1	1	456410-4	CRIMPER, WIRE	1	
	-77	-76	-72	-71	-6	-2	-1	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY

PARTS LIST

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DWN

M.CLIFFORD

24MAR04

OK

F.BACKHURST

24MAR04

NAME

TYCO ELECTRONICS CORPORATION

FINISH

0 PLC ± -

1 PLC ± -

2 PLC ± -

3 PLC ± 0.5 [02 IN]

4 PLC ± -

ANGLES ± -

MATERIAL

FINISH

WEIGHT

F

SIZE

A1

CAGE CODE

00779

DRAWING NO

1528246

RESTRICTED TO

C

CUSTOMER DRAWING

SCALE

SHEET

1

OF

1

REV

C

4805 (1/08)

09OCT2008 8:55am

CUSTOMER DRAWING

DRAWING NUMBER - 1528246 SHEET 2 OF 2 REV. C1

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