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LOC

DIST

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	B1	ECR-14-002790	25FEB2014	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2151211-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1528289
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
1528289

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN GOPALAKRISHNA HV		 TE Connectivity	
CHK RAGHAVENDRA		APVD RAGHAVENDRA			
APVD RAGHAVENDRA		NAME		FINE ADJ SIDE FD HD-I APPL	
PRODUCT SPEC		APPLICATION SPEC		RESTRICTED TO	
SIZE		CAGE CODE		DRAWING NO	
A 3				C- 1528289	
CUSTOMER DRAWING		SCALE		SHEET 1 OF 2 REV B1	

THIS DRAWING IS A CONTROLLED DOCUMENT

LAYOUT L1426232

SET UP GAGE 458637-3

2000

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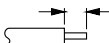
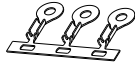
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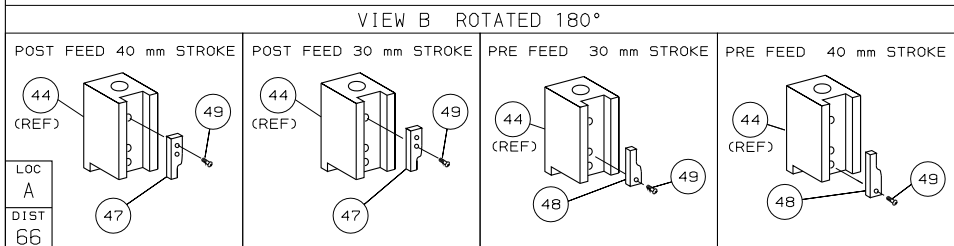
AMP 1756 REV 3-92

DRAWING MADE IN THIRD ANGLE PROJECTION

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1528289-1	B	-	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528289-2	B	-	BENCH	MECH PRE FEED	CUTS CARRIER
1528289-6	B	-	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528289-1	B	-	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528289-2	B	-	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528289-6	B	-	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528289-7	A	-	-	-	SPARE PARTS KIT

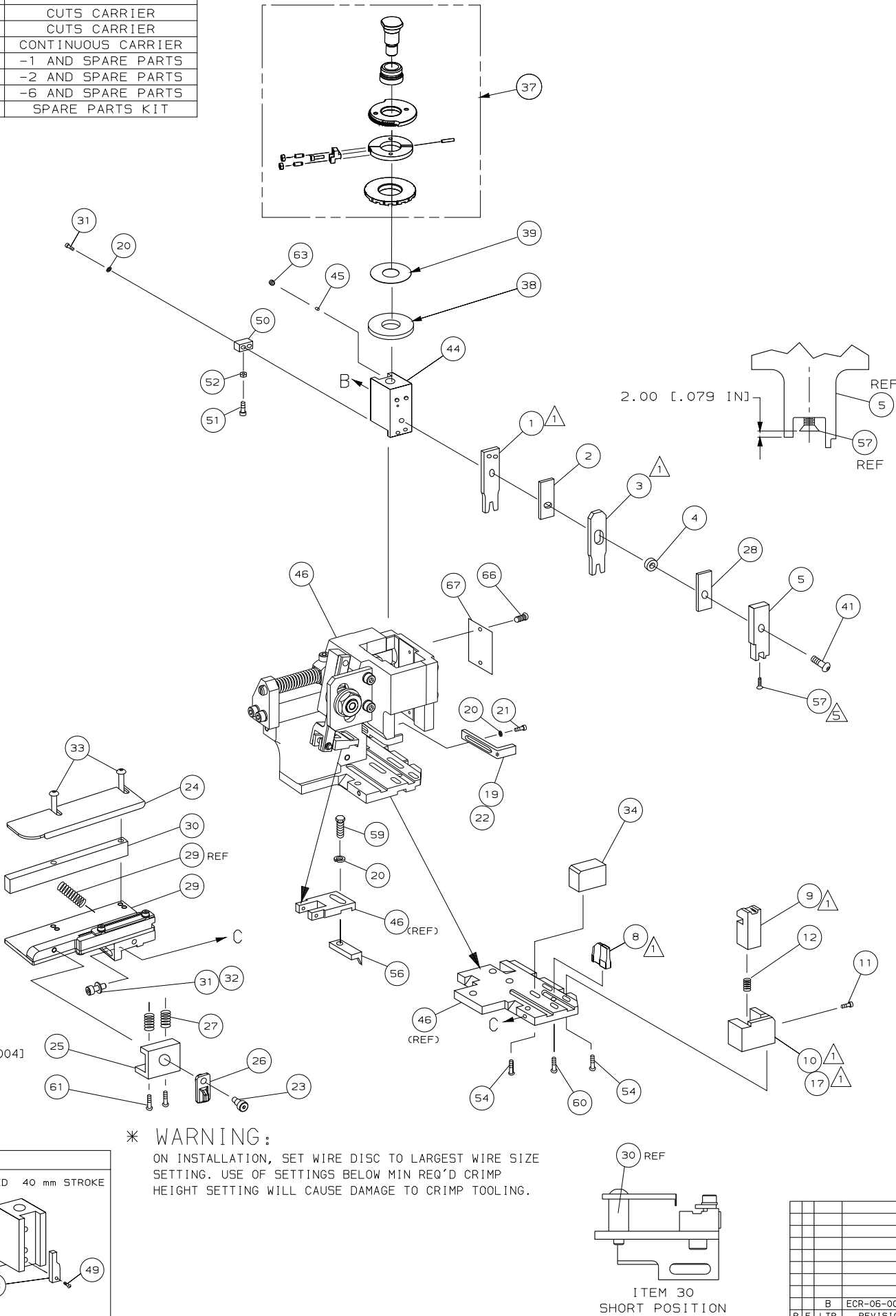
CRIMP DATA AMP TERMINAL AMP CRIMP SPECS				
TERMINAL NAME: CONTACT, RECEPTACLE .070 TYPE (SCAT VERSION)				
CRIMP	SIZE	TYPE	RANGE	
WIRE	2.03 [.080 IN]	F	0.35-1.00mm ²	
INSUL	3.56 [.140 IN]	0	1.20-2.10 [.047-.083 IN]	
WIRE STRIP LENGTH			APPL INSTRUCTION	
4.00-4.50 [.157-.177 IN]			408-8322 & 408-8490	
TERMINAL	-	-		FEED
APPL SPEC	114-8004	-		9.80 [.386 IN]
TERMINALS APPLIED 				
TERMINAL	SEAL	-	-	-
184095	348989 	-	-	-
-	184140 	-	-	-
-	184139 	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
WIRE SIZE		CRIMP HEIGHT		REF SETTING 
mm ² AWG		*		
1.00mm ²		1.29 ±0.05 [.051 ±.002 IN]		C 1
0.75mm ²		1.22 ±0.05 [.048 ±.002 IN]		C 8
0.50mm ²		1.12 ±0.05 [.044 ±.002 IN]		D 4
0.35mm ²		1.02 ±0.05 [.040 ±.002 IN]		E 1
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-
-		-		-

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.
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. FOR INS. DIA 1.5-2.4mm INS. CRIMP HT 3.2mm ±.10mm [.128 ±.004]
7. FOR INS. DIA 1.6-2.1mm; INS CRIMP HT REFER TO 114-8004
8. FOR INS. DIA 1.2-1.7mm; INS CRIMP HT REFER TO 114-8004



* 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	1528289	PRINT, APPLICATOR LOG SHEET	73
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-	-	-	-	-	-	-	-	-	65
-	1	1	1	1	1	1	3-18031-0	SCR, SKT SET (M6X6) RAM	64
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-	2	2	2	2	2	2	1-18024-5	SCR, BHC (M5X25) DRAG	62
-	1	1	1	1	1	1	18024-7	SCR, BHC (M4X10) ANVIL	61
-	1	1	1	1	1	1	5-18022-2	SCR, HEX (M4X8) FEED FINGER	60
-	-	-	-	-	-	-	-	-	59
-	1	1	1	1	1	1	985575-3	SCR, FHC (M3X10) DEP	58
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	57
-	-	-	-	-	-	-	-	-	56
-	4	4	4	4	4	4	18024-8	SCR, BHC (M4x12) SHEAR HOLDER	55
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-	1	1	1	1	1	1	811242-5	BUMPER, HOLDDOWN	52
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-	1	1	1	1	1	1	18024-3	SCR, BHC (M3X10) CAM	50
-	-	-	-	-	-	-	-	-	49
-	1	1	1	1	1	1	1338675-1	CAM, PRE FEED 30 & 40 mm ST	48
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-	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	1338660-1	RAM	44
-	-	-	-	-	-	-	-	-	43
-	1	1	1	1	1	1	2-18024-6	SCR, BHC (M8X25) RAM	42
-	-	-	-	-	-	-	-	-	41
-	1	1	1	1	1	1	690125-1	SHIM SUBASSY	40
-	1	1	1	1	1	1	469367-9	SPACER, FINE ADJUST	39
-	1	1	1	1	1	1	879103-3	FINE ADJUST HEAD SUBASSY	38
-	-	-	-	-	-	-	-	-	37
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-	1	1	1	1	1	1	1320934-1	SUPPORT, TERMINAL	34
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-	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	1320908-1	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1	1633073-1	STRIP GUIDE PLATE ASSY	29
-	1	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	1320928-1	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
-	1	-	-	1	-	-	1338684-2	HOLDER, SHEAR, FRONT (NO-CUT)	18
-	-	-	-	-	-	-	-	-	17
-	-	-	-	-	-	-	-	-	16
-	-	-	-	-	-	-	-	-	15
-	-	-	-	-	-	-	-	-	14
-	-	-	-	-	-	-	-	-	13
-	1	1	1	1	1	1	5-22280-0	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
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-	-	-	-	-	-	-	-	-	7
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-	1	1	1	1	1	1	1338680-2	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	1	1	1	1-238011-0	SPACER, BLOCK CRIMPER	4
-	1	2	2	2	1	1	6-904741-5	CRIMPER, INSULATION	3
-	1	1	1	1	1	1	455888-8	SPACER, CRIMPER	2
-	1	2	2	2	1	1	1-456405-5	CRIMPER, WIRE	1
-77	-76	-72	-71	-6	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	-	-	-	-	-	REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)		
QTY REQD PER ASSY							PARTS LIST		
DIMENSIONS, mm (INCHES)							MATL	HT TR	FIN
DO NOT SCALE PRINT.									
TOLERANCES UNLESS OTHERWISE SPECIFIED:									
1 PLC DEC ±0.5 (.02 IN)									
2 PLC DEC ±-									
3 PLC DEC ±-									
ANGLES ±-									
SURF TEXTURE:									
REMOVE BURRS, BREAK SHARP EDGES RO.38 MAX									
P F LTR									
B ECR-06-007872									
REVISION RECORD									
RK MAR06									
APP DATE									
NAME									
FINE ADJ SIDE FD HD-1 APPL									
SCALE									
D									
DWG NO									
1528289									
SHEET									
1 of 1									
REV									
B									
CUSTOMER AND ASSEMBLY DRAWING									
RESTRICTED TO									

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