

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

WEIGHT

-

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

A1

00779

1385813

-

CUSTOMER DRAWING

SCALE

1:1

SHEET

1

OF

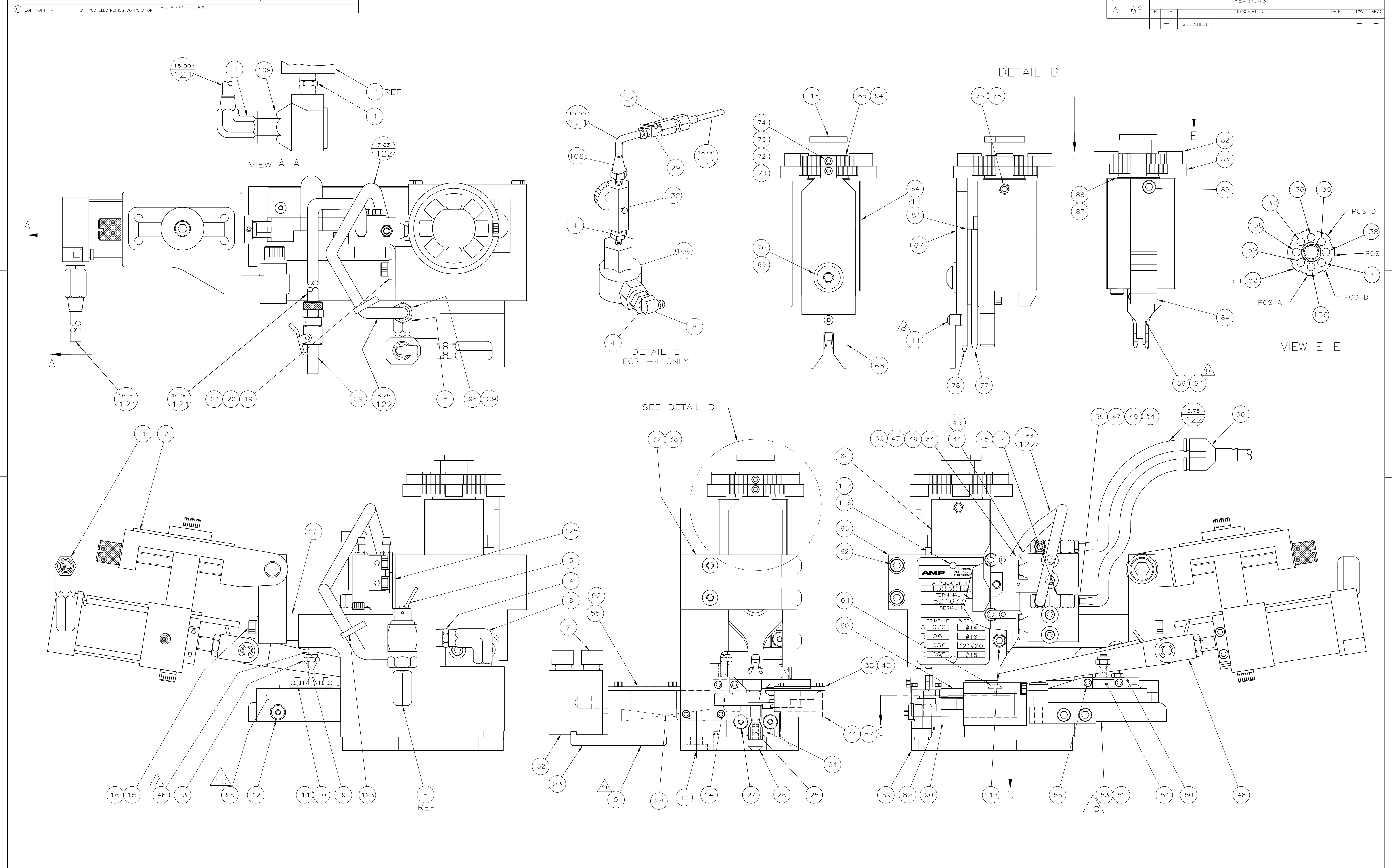
3

REV

C1

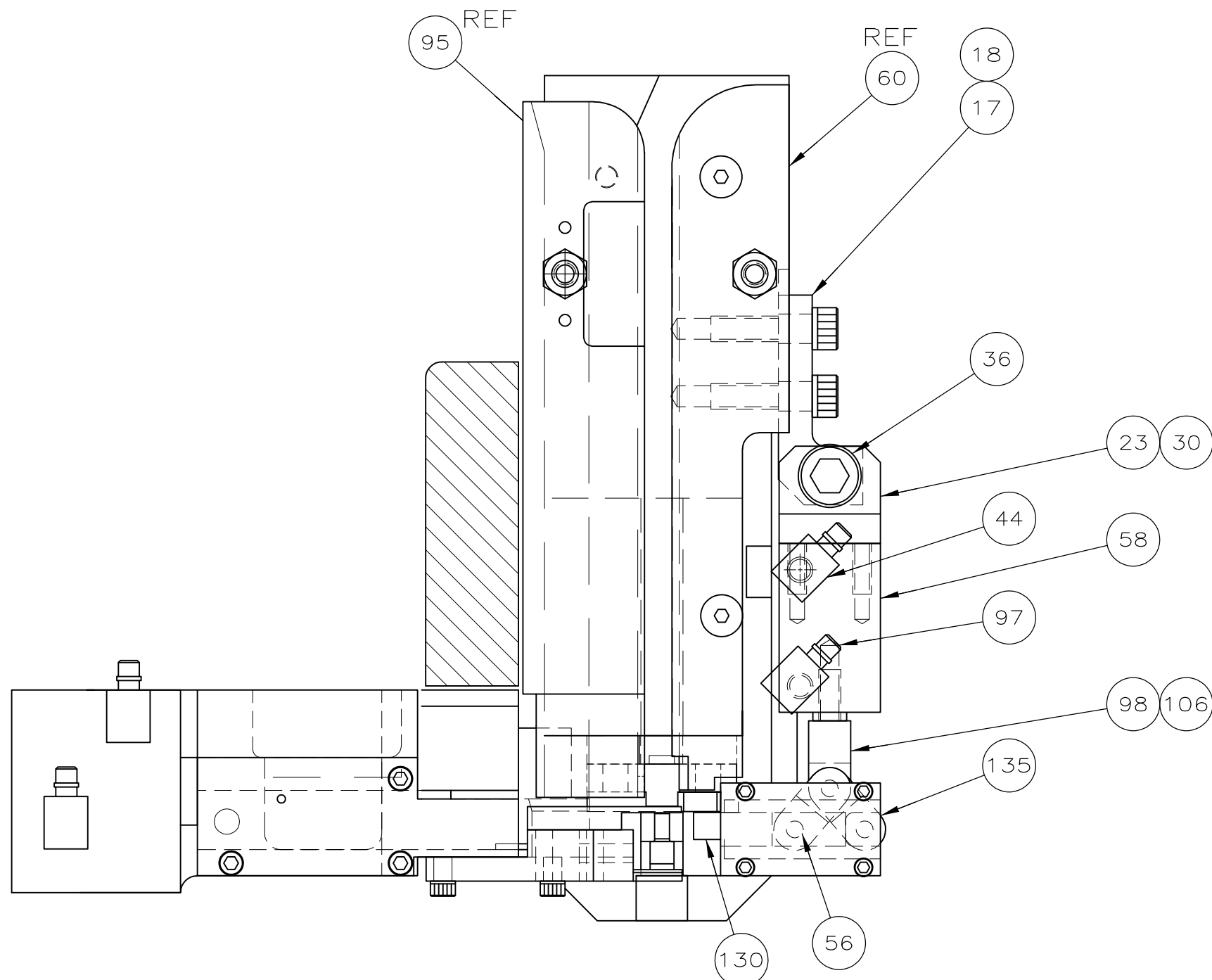
AMP 4805 REV 31MAR2000

09NOV2007 10:27am



LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			—	SEE SHEET 1	—	—	—

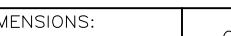
OBSELETE



	2	2	2	2	—	3-354779-6	PIN, WIRE DISC (.3170)D	139	
	2	2	2	2	—	2-354779-5	PIN, WIRE DISC (.3115)C	138	
	2	2	2	2	—	1-354779-6	PIN, WIRE DISC (.3070)B	137	
	2	2	2	2	—	354779-6	PIN, WIRE DISC (.3020)A	136	
	2	2	2	2	—	1673387-1	LINK, TOGGLE	135	
3	2	—	—	—	—	1424324-1	AIR LINE KIT .250 TO 4mm	134	
	18.00	—	—	—	IN	27319-8	TUBING, POLY FLOW Ø.156	133	
2	1	—	—	—	—	23054-1	VALVE, FLOW CONTROL	132	
	—	REF	—	—	—	679532-1	INSERT, GUARD	131	
	—	1	1	1	1	—	1673388-2	FINGER, BACKUP	130
	—	—	—	—	—	—	—	129	
	—	—	—	—	—	—	—	128	
	—	—	—	—	—	—	—	127	
	—	—	—	—	—	—	—	126	
	1	1	1	1	—	679172-1	SPACER	125	
	—	—	—	—	—	—	—	124	
	1	1	1	1	—	19832-1	TIE, WIRE	123	
3	27.76	27.76	27.76	27.76	IN	18912-4	HOSE, FLEXIBLE .250 OD	122	
	25.00	25.00	25.00	25.00	IN	27319-4	TUBE, PLASTIC .250 OD	121	
2	—	—	—	—	—	90647-1	GUARD, MODIFIED	120	
	—	—	—	—	—	—	—	119	
	1	1	1	1	—	690212-1	POST, RAM	118	
	1	1	1	1	—	464249-1	PLATE, IDENTIFICATION	117	
	2	2	2	2	—	21017-2	SCR., DRIVE #2 X .19 LG	116	
	—	—	—	—	—	—	—	115	
	—	—	—	—	—	—	—	114	
2	2	2	2	2	—	6-21000-7	SCR., SHC 8-32UNC X 1.75 LG	113	
	—	—	—	—	—	692655-5	VALVE ASSEMBLY	112	
4	2	—	—	1	—	768411-1	GUIDE, PRODUCT	111	
	—	—	—	—	—	—	—	110	
	2	2	—	2	—	22374-7	VALVE, QUICK EXHAUST 1/8NPT	109	
	1	—	—	—	—	980282-3	CONNECTOR, TUBING, MALE	108	
	—	—	—	—	—	—	—	107	
	1	1	1	1	—	1673636-1	CLEVIS, CYLINDER	106	
2	—	—	—	—	—	1-455750-3	GUARD ASSEMBLY	105	
	—	—	—	—	—	22307-1	BUSHING, PIPE, FITTING 1/4NPT	104	
	—	—	—	—	—	23791-2	TEE, PIPE, FITTING 1/4NPT	103	
	—	—	—	—	—	28580-1	FILTER, MINATURE 1/4NPT	102	
	—	—	2	—	—	22311-2	NIPPLE, CLOSE 1/4NPT	101	
	—	—	—	—	—	28582-1	LUBRICATOR 1/4NPT	100	
	—	—	—	—	—	26108-1	BODY, QUICK CONNECT	99	
	1	1	1	1	—	4-21006-5	SCR, SET, SOC CONE PT 8-32UNC X .62	98	
	1	1	1	1	—	25545-4	10-32NS MUFFLER, EXHAUST	97	
10	1	1	1	1	—	18258-3	1/8NPTF CONNECTOR, TUBING TO MALE	96	
	1	1	1	1	—	852762-1	GUIDE, REAR STRIP	95	
	1	1	1	1	—	986950-1	WASHER, FLAT, PRECISION	94	
	2	2	2	2	—	6-21002-2	SCR., BHC 10-24 X .38 LG	93	
	1	1	1	1	—	1673397-1	COVER, VANE	92	
8	2	2	2	2	—	2-21000-6	SCR., SHC 8-32UNC X .38 LG.	91	
	1	1	1	1	—	852764-1	SHEAR, REAR	90	
1	2	2	2	2	—	852765-1	SPACER, SHEAR	89	
	1	1	1	1	—	690124-1	WASHER, RAM	88	
	1	1	1	1	—	690125-1	WASHER, LAMINATED	87	
1	1	1	1	1	—	852771-1	BLADE, SLUG	86	
	1	1	1	1	—	2-21000-5	SCR., SHC 8-32UNC X .25 LG.	85	
	1	1	1	1	—	1213817-1	VALVE, CAM	84	
	1	1	1	1	—	690142-1	DISC, INSULATION	83	
	1	1	1	1	—	354777-1	DISC, WIRE CRIMP ADJ.	82	
	1	1	1	1	—	1-455888-7	SPACER, CRIMPER	81	
	—	—	—	—	—	—	—	80	
	—	—	—	—	—	—	—	79	
1	1	1	1	1	—	853491-6	CRIMPER, INSULATION	78	
	1	1	1	1	—	852743-6	CRIMPER, WIRE	77	
	1	1	1	1	—	21009-6	SCR., SET, SOC 1/4-20UNC X .25 LG	76	
	1	1	1	1	—	690191-1	PLUG, NYLON	75	
	1	1	1	1	—	23030-1	SCR., SET, SOC 6-32UNC X .25 LG	74	
	1	1	1	1	—	690170-1	SPRING, COMP.	73	
	1	1	1	1	—	690603-1	SPRING, ASSIST	72	
	1	1	1	1	—	23241-6	BALL, STEEL	71	
	-4	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO	
						PARTS LIST			
						QTY REQD PER ASSY			

OBSOLETE

10	1	1	1	1	—	690686-3	SCR., BHC 5/16-24UNF X 1.00 LG	70
	1	1	1	1	—	3-238009-6	BLOCK, CRIMPER SPACER	69
	1	1	1	1	—	1633289-1	STABILIZER	68
	1	1	1	1	—	1633288-1	HOLDER, STABILIZER	67
	1	1	1	1	—	1428088-2	1/4, FITTING, Y, TUBE TO TUBE	66
	1	1	1	1	—	22480-5	WASHER, WAVE SPRING	65
	1	1	1	1	—	852768-3	RAM	64
	1	1	1	1	—	856391-2	CAP, RAM	63
	2	2	2	2	—	3-21000-9	SCR, SHC 10-32UNF X 1.00 LG	62
	2	2	2	2	—	2-21002-3	SCR., BHC 8-32UNC X .62 LG	61
7	1	1	1	1	—	1673378-2	GUIDE, FRONT STRIP	60
	1	1	1	1	—	1633292-1	PLATE, BASE	59
	1	1	1	1	—	1725830-1	CYLINDER, COMPACT	58
	1	1	1	1	—	1673389-1	MOUNT, FINGER	57
	1	1	1	1	—	21030-1	Ø125 x .38 DOWEL PIN	56
	5	5	5	5	—	1-21000-3	SCR., SHC 4-40UNC X .25 LG	55
	4	4	4	4	—	21024-3	WASHER, LOC 6	54
	1	1	1	1	—	1673379-1	PLATE, STRIP GUIDE	53
	4	4	4	4	—	3-21002-3	SCR, BHC 1/4-20UNC X .50 LG	52
	1	1	1	1	—	1-464451-0	ARM, STOCK DRAG	51
8	1	1	1	1	—	1-464452-3	DRAG, STOCK	50
	4	4	4	4	—	21055-5	WASHER, FLAT 6	49
	1	1	1	1	—	2-460680-8	FEED FINGER ASSEMBLY	48
	2	2	2	2	—	986377-1	VALVE, LEVER ROLLER	47
	2	2	2	2	—	22354-6	STUD 8-32UNC X 1.00 LG	46
	4	4	4	4	—	18326-2	ELBOW, TUBE TO MALE 10-32NPT	45
	5	5	5	5	—	18258-1	CONN., MALE TUBE TO MALE THD 10-32NPT	44
	1	1	1	1	—	1673390-1	COVER, FINGER	43
	—	—	—	—	—	—	—	42
	1	1	1	1	—	1-21002-4	SCR, BHC 4-40UNC X .38 LG	41
1	2	2	2	2	—	3-21002-3	SCR, BHC 1/4-20UNC X .50 LG	40
	4	4	4	4	—	2-21000-3	SCR., SHC 6-32UNC X .88 LG	39
	3	3	3	3	—	2-22733-8	SCR., BHC 1/4-20UNC X .63 LG	38
	1	1	1	1	—	1752764-1	HOUSING, APPLICATOR	37
	1	1	1	1	—	21004-1	SCR, SHLD .25 DIA X .38 LG.	36
	4	4	4	4	—	21000-9	SCR., SHC 2-56 X .19 LG.	35
	1	1	1	1	—	2-21002-6	SCR., SHC 10-32UNC X .38 LG	34
	—	—	—	—	—	—	—	33
	1	1	1	1	—	354993-2	CYL., AIR, DOUBLE ACTING 1/8NPT	32
	—	—	—	—	—	—	—	31
9	2	2	2	2	—	1-21000-8	SCR., BHC 6-32UNC X .25 LG	30
	2	2	2	2	—	23238-1	INSERT, COUPLING	29
	1	1	1	1	—	1-23470-7	SPRING, COMP .240 DIA X 2.50 LG	28
	2	2	2	2	—	2-21002-4	SCR., BHC 8-32UNC X .75 LG	27
	1	1	1	1	—	22733-8	SCR., BHC 8-32UNC X .38 LG	26
	1	1	1	1	—	853088-8	ANVIL	25
	1	1	1	1	—	1673377-1	SHEAR, FRONT	24
	1	1	1	1	—	1673385-1	EYE, CYLINDER	23
	1	1	1	1	—	461690-3	SPACER, AIR FEED	22
	2	2	2	2	—	3-21000-4	SCR., SHC 10-32UNF X .38 LG	21
9	2	2	2	2	—	21055-7	WASHER, FLAT 10	20
	1	1	1	1	—	1213818-1	BRACKET, VALVE	19
	2	2	2	2	—	3-21000-5	SCR., SHC 10-32 X .50 LG.	18
	1	1	1	1	—	1673386-1	MOUNT, CYLINDER	17
	2	2	2	2	—	21024-5	WASHER, LOCK #10	16
	2	2	2	2	—	4-21000-2	SCR., SHC 10-32UNF X 1.75 LG	15
	1	1	1	1	—	1804005-1	INSERTER	14
	2	2	2	2	—	21022-2	NUT, FLEX 8-32UNC	13
	2	2	2	2	—	2-21002-1	SCR., 8-32UNC X .38 LG.	12
	2	2	2	2	—	2-21006-3	SCR., SET, SOC CONE PT 4-40UNC X .38 LG	11
9	2	2	2	2	—	21018-4	NUT, HEX 4-40UNC	10
	2	2	2	2	—	22281-6	SPRING, COMP. .300 DIA X .44 LG	9
	3	2	2	2	—	22306-1	1/8 MOD NPT ELBOW, STREET, 90°	8
	1	1	1	1	—	25545-1	1/8NPT MUFFLER, EXHAUST	7
	—	—	—	—	—	—	—	6
	1	1	1	1	—	1673395-1	INSERTER, MOUNT	5
	3	2	1	2	—	22304-1	NIPPLE, HEX PIPE 1/8NPT	4
	1	1	1	1	—	985836-1	VALVE, TOGGLE 1/8NPT	3
	1	1	1	1	—	1-460277-2	AIR FEED ASSEMBLY	2
	—	1	1	1	—	985883-2	CONN., TUBING, MALE 1/8NPT-1/4 TUBE	1
	-4	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
						PARTS LIST		
						QTY REQD PER ASSY		

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN K. STAKEM 8/24/04 CHK C. ERISMAN 8/24/04 APP'D T. ELFIN 8/24/04		 Tyco Electronics Corporation Harrisburg, PA 17105-3608									
DIMENSIONS: INCHES 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0. PLC ± . 1. PLC ± . 2. PLC ± . 3. PLC ± . 4. PLC ± . ANGLES ± .		NAME ULTRA POD FLAG APPLICATOR — —									
MATERIAL —		FINISH —		WEIGHT —		SIZE A1		CAGE CODE 00779		DRAWING NO C1385813		RESTRICTED TO —	
CUSTOMER DRAWING						SCALE —		SHEET 3		OF 3		REV C	

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На всех этапах разработки и производства наши партнеры могут получить квалифицированную поддержку опытных инженеров.

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