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LOC DIST

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD

# REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER

FOR REPLACEMENT PARTS FOR APPLICATOR REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED) WILL REMAIN AVAILABLE.

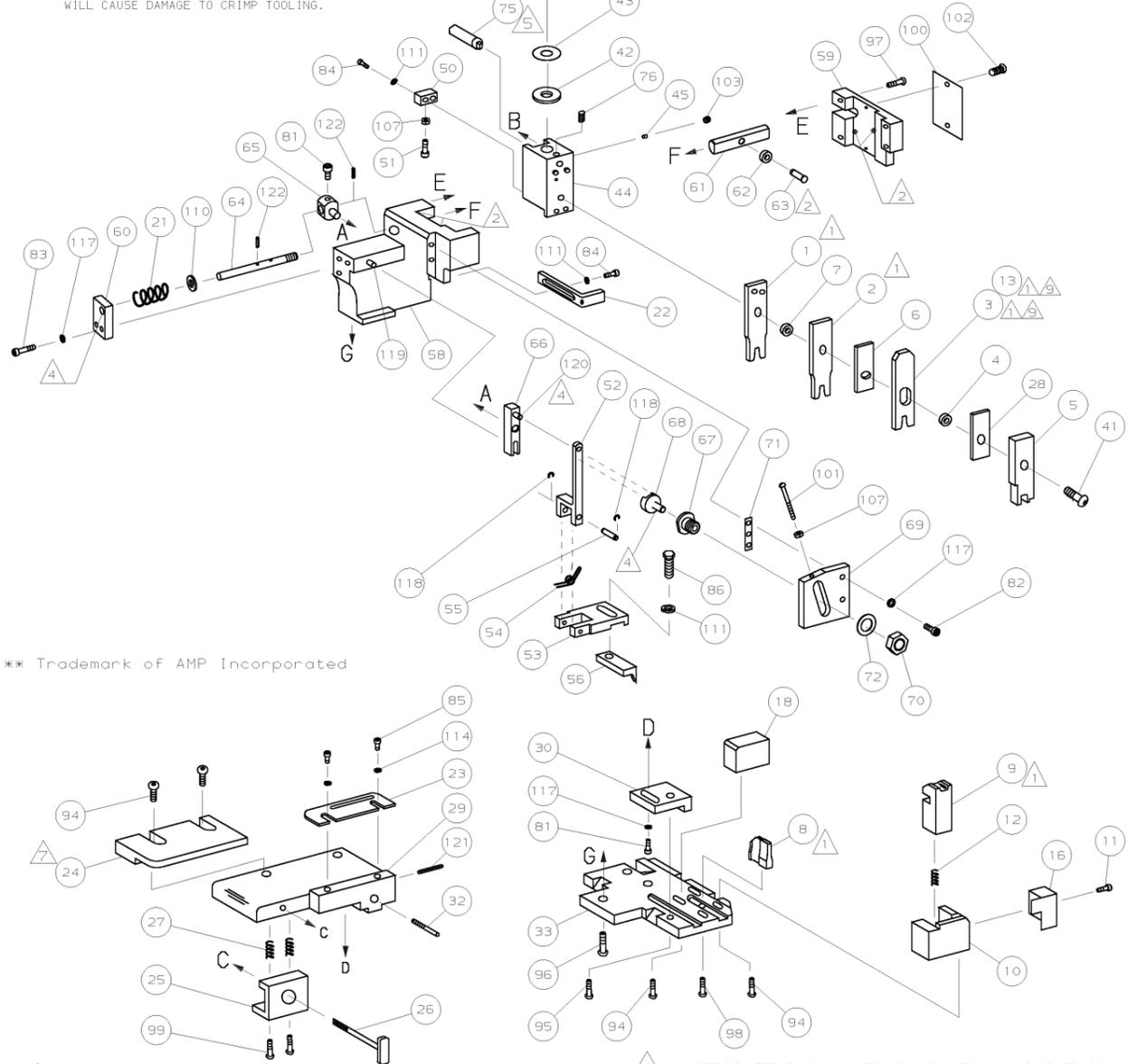
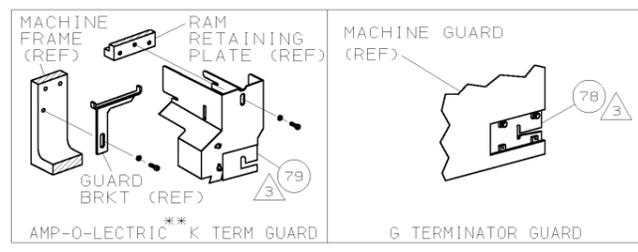
THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	 TE Connectivity		
DIMENSIONS:		CHK			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	NAME		
 <ul style="list-style-type: none"> <li>0 PLC ±</li> <li>1 PLC ±</li> <li>2 PLC ±</li> <li>3 PLC ±</li> <li>4 PLC ±</li> <li>ANGLES ±</li> </ul>		PRODUCT SPEC	RESTRICTED TO		
		APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO
MATERIAL	FINISH	WEIGHT	A3	C-	
		SCALE	SHEET	OF	REV

PART NUMBER	REV	FIRST USED
1385797-1	A	854400-1
1385797-2	A	565435-5
1385797-3	A	354500-1

**\* WARNING:**

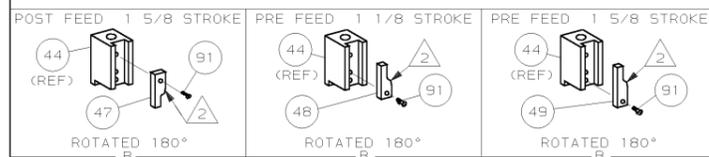
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



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- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.

- 4 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
- 6 STABILIZER CRIMPER SHAFT MUST BE TURNED SO THAT LETTER SHOWING (RIGHT SIDE OF RAM) MATCHES FINE ADJUST SETTING AS SHOWN IN CRIMP HEIGHT CHART.



LOC A LEADMAKER  
DIST 66

13-SEP-04 10:48:44 us014442

TERMINAL PN	REF SETTING	ITEM 75 SETTING	TERMINAL NAME: Ø.140 PIN AND SOCKET	TYCO TERMINAL	TYCO CRIMP SPECS
61626					
61627					
925714					
925715	B1	A		* CRIMP HEIGHT	WIRE SIZE
794974	C9	C		.061±.002 [1.55 ±0.05mm]	16
	E3	D		.054±.002 [1.37 ±0.05mm]	18
	E8	D		.051±.002 [1.3 ±0.05mm]	20
	B3	B		.070±.002 [1.78 ±0.05mm]	2mm <sup>2</sup>
	C5	B		.063±.002 [1.59 ±0.05mm]	1.5mm <sup>2</sup>
	D9	C		.056±.002 [1.43 ±0.05mm]	1mm <sup>2</sup>
	E4	D		.053±.002 [1.35 ±0.05mm]	0.75mm <sup>2</sup>
	E8	D		.051±.002 [1.3 ±0.05mm]	0.5mm <sup>2</sup>
				CRIMP SIZE	TYPE
				.100 [2.54mm]	F
				INSUL .180 [4.57mm]	F
					20-14 OR 0.5-2mm <sup>2</sup>
					.086-.146 FLK

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
	114-1007	.590	408-8040	458637-1	L377A

QTY	RECD	PER	ASSY	PARTS LIST	DESCRIPTION	ITEM NO	
1	1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
					4088861	APPL INST 408-8861	123
REF	REF	REF	-	A	5-21028-1	PIN, SLT SPR (Ø.125x.50) ADJ ROD	122
1	1	1	-	A	4-21028-0	PIN, SLT SPR (Ø.093x.75) ST GDE PL	121
REF	REF	REF	-	A	1-21030-1	PIN, DOWEL (Ø.187x.50) LEVER	120
REF	REF	REF	-	A	1-21030-6	PIN, DOWEL (Ø.187x1.25) HOUSING	119
REF	REF	REF	-	A	21045-3	RING, RET "C" (Ø.187) FD FING PIN	118
1	1	1	-	A	21024-5	WASHER, LOCK (#10) ADJ BLOCK	117
REF	REF	REF	-	A	21024-5	WASHER, LOCK (#10) ADJ PLATE	116
REF	REF	REF	-	A	21024-5	WASHER, LOCK (#10) FEED GDE ROD	115
2	2	2	-	A	21024-2	WASHER, LOCK (#4) FRONT STP GUIDE	114
4	4	4	-	A	21024-4	WASHER, LOCK (#8) STRIPPER	111
REF	REF	REF	-	A	21899-4	WASHER, FLAT (Ø5/16) SCREW ADJ	110
							109
1	1	1	-	A	21018-5	NUT, HEX (6-32) BUMPER	108
REF	REF	REF	-	A	21018-5	NUT, HEX (6-32) FEED ADJ	107
							106
							105
							104
1	1	1	-	A	21009-2	SCR, SKT SET (1/4-20x.25 LW) RAM	103
2	2	2	-	A	21017-2	SCR, DRIVE (#2x.19) ID PLATE	102
REF	REF	REF	-	A	6-23715-5	SCR, PAN HD (6-32x1.50) FEED ADJ	101
1	1	1	-	B	461264-1	PLATE, IDENTIFICATION	100
2	2	2	-	A	3-21002-0	SCR, BHC (10-32x.88) DRAG	99
1	1	1	-	A	22733-8	SCR, BHC (8-32x.38 LW) ANVIL	98
REF	REF	REF	-	A	2-21002-9	SCR, BHC (10-32x.75) CAP	97
REF	REF	REF	-	A	2-22733-8	SCR, BHC (1/4-20x.62) HOUSING	96
REF	REF	REF	-	A	2-21002-7	SCR, BHC (10-32x.50) 56 ADJ BLOCK	95
4	4	4	-	A	2-21002-2	SCR, BHC (8-32x.50) SHEAR	94
							93
							92
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38) CAM	91
							90
							89
							88
							87
1	1	1	-	A	2-22603-0	SCR, HEX HD (8-32x.31) FEED FINGER	86
2	2	2	-	A	1-21000-3	SCR, SHC (4-40x.25) F ST GUIDE	85
3	3	3	-	A	2-21000-7	SCR, SHC (8-32x.50) STRIPPER	84
REF	REF	REF	-	A	3-21000-7	SCR, SHC (10-32x.75) FEED ROD GD	83
REF	REF	REF	-	A	3-21000-6	SCR, SHC (10-32x.62) FD ADJ BLK	82
1	1	1	-	A	3-21000-4	SCR, SHC (10-32x.38) 56 ADJ BL	81
REF	REF	REF	-	A	3-21000-4	SCR, SHC (10-32x.38) PIVOT BLK	80
-	REF	-	-	B	455749-1	GUARD, WINDOW	79
REF	-	-	-	B	679532-1	INSERT, GUARD	78
							77
1	1	1	-	A	22859-7	PLUNGER, SPRING	76
1	1	1	-	C	453412-9	SHAFT, STABILIZER	75
							74
							73
REF	REF	REF	-	A	458109-1	WASHER, SPECIAL	72
REF	REF	REF	-	A	690517-1	SPACER	71
-3	-2	-1	U/M				
				PARTS LIST		DESCRIPTION	
QTY RECD PER ASSY				REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)		ITEM NO	

- 7 GUIDE TERMINAL FROM STABILIZER BARREL.
- 8 INSULATION DIA .149 OR LESS STRIP LENGTH .188-.312 INSULATION DIA .150-.180 STRIP LENGTH .281-.343
- 9 USE ITEM 3 FOR INSULATION UP TO .130 DIA USE ITEM 13 FOR INSULATION UP TO .146 DIA
- 10 DUE TO CRIMP WINGS BOTTOMING, THE USE OF 20 AWG OR 0.5MM<sup>2</sup> IS CUSTOMERS OWN RESPONSIBILITY.

QTY	RECD	PER	ASSY	PARTS LIST	DESCRIPTION	ITEM NO	
-1					LEADMAKER	MECH POST FEED	
-2					BENCH MODEL K	MECH PRE FEED	
-3					BENCH MODEL G	MECH PRE FEED	
REF	REF	REF	-	B	22594-8	NUT, HEX (1/2-20)	70
REF	REF	REF	-	B	240628-1	PLATE, ADJUSTMENT	69
REF	REF	REF	-	B	240626-1	SHAFT, PIVOT	68
REF	REF	REF	-	B	240633-1	BUSHING	67
REF	REF	REF	-	A	455680-1	LEVER, INTERMEDIATE	66
REF	REF	REF	-	B	240629-1	BLOCK, PIVOT	65
REF	REF	REF	-	A	240632-2	SCREW, ADJ FEED ROD	64
REF	REF	REF	-	B	240659-3	PIN, CAM ROLLER	63
REF	REF	REF	-	B	240658-1	ROLLER, CAM	62
REF	REF	REF	-	B	454398-2	ROD, FEED	61
REF	REF	REF	-	A	454178-1	GUIDE, FEED ROD	60
1	1	1	-	C	454220-1	CAP, RAM	59
REF	REF	REF	-	D	454485-1	HOUSING	58
							57
1	1	1	-	B	1-694433-1	PAWL, FEED	56
REF	REF	REF	-	B	240624-1	PIN, FEED FINGER	55
REF	REF	REF	-	B	691499-1	SPRING, FEED FINGER	54
REF	REF	REF	-	B	690541-1	HOLDER, FEED FINGER	53
REF	REF	REF	-	A	455679-1	LEVER, TERMINAL FEED ARM	52
1	1	1	-	A	811242-2	BUMPER, HOLDDOWN	51
1	1	1	-	A	690753-1	SPACER, TONKER	50
1	-	-	-	B	690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	1	-	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST	48
-	-	1	-	B	690501-4	CAM, POST-FEED 1 5/8 ST	47
1	1	1	-	B	459456-1	APPLICATOR, BASIC (SUBASSY)	46
1	1	1	-	A	690191-1	PLUG, NYLON	45
1	1	1	-	C	817855-2	RAM	44
1	1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	1	-	A	1-469367-0	WASHER, RAM	42
1	1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)	41
							40
1	1	1	-	A	690125-1	WASHER, LAMINATED	39
1	1	1	-	D	469367-1	SPACER, FINE ADJUST	38
1	1	1	-	-	879103-2	FINE ADJUST HEAD SUBASSY	37
							36
							35
							34
REF	REF	REF	-	D	455675-1	PLATE, BASE	33
1	1	1	-	A	690432-3	SCREW, ADJUSTMENT	32
							31
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	C	455671-1	PLATE, STRIP GUIDE	29
1	1	1	-	C	455888-4	SPACER, FRONT SHEAR DEP	28
2	2	2	-	A	1-22284-0	SPRING, DRAG	27
1	1	1	-	B	690546-1	LEVER, DRAG RELEASE	26
1	1	1	-	B	240792-1	DRAG, TERMINAL	25
1	1	1	-	D	3-90765-2	GUIDE, STRIP (REAR)	24
1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
1	1	1	-	B	690472-1	STRIPPER	22
REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	21
							20
							19
1	1	1	-	B	692776-2	SUPPORT, TERMINAL	18
							17
1	1	1	-	B	691667-1	GUARD, CHIP (FRONT)	16
							15
							14
1	1	1	-	C	1-1213077-0	CRIMPER, INSULATION	13
1	1	1	-	A	5-22280-0	SPRING, SHEAR	12
1	1	1	-	B	690461-2	STOP, SHEAR	11
1	1	1	-	C	1-690459-0	HOLDER, SHEAR (FRONT)	10
1	1	1	-	C	454276-5	SHEAR, FLOAT (FRONT)	9
1	1	1	-	C	7-803653-6	ANVIL	8
1	1	1	-	C	238011-2	SPACER, BLOCK CRIMPER	7
1	1	1	-	C	455888-6	SPACER, CRIMPER	6
1	1	1	-	C	1-455889-8	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	238011-4	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	9-456134-7	CRIMPER, INSULATION	3
1	1	1	-	C	817852-5	CRIMPER, STABILIZER	2
1	1	1	-	C	817854-9	CRIMPER, WIRE	1
-3	-2	-1	U/M				
				PARTS LIST		DESCRIPTION	
QTY RECD PER ASSY				REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)		ITEM NO	

MATL - HT TR - FIN -

DR C.ERISMAN 30JUL04 APP 30JUL04 T.ELBIN

CHK - REL -

AMP AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR MINI APPL

SCALE - DWG NO 1385797 SHEET 1 of 1 REV A

CASE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO

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- Техническую поддержку проекта.
- Защиту от снятия компонента с производства.
- Оценку стоимости проекта по компонентам.
- Изготовление тестовой платы монтаж и пусконаладочные работы.



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