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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		
DIMENSIONS:		CHK	RAGHAVENDRA			NAME		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	RAGHAVENDRA		FINE ADJ SIDE FD HD-I APPL			
0 PLC ±		PRODUCT SPEC			APPLICATION SPEC			
1 PLC ±		APPLICATOR SPEC			SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
2 PLC ±		WEIGHT			A3		©- 1528289	
3 PLC ±		CUSTOMER DRAWING			SCALE	SHEET	1 OF 2	REV B1
4 PLC ±								
ANGLES ±								
FINISH								

A

A

D

D

C

C

B

B

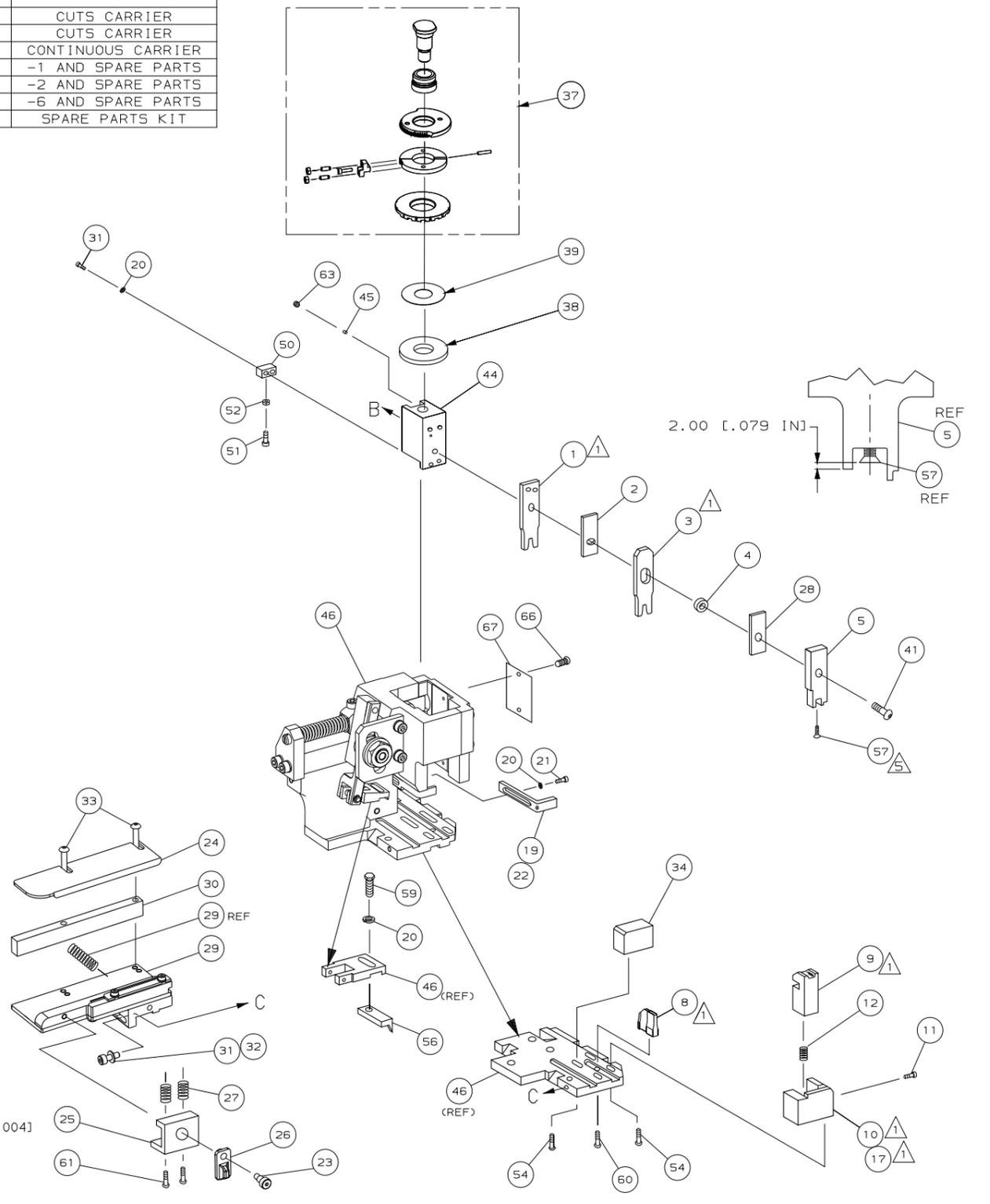
DRAWING MADE IN THIRD ANGLE PROJECTION

1528289 1528289

/home/us024474/tecmod

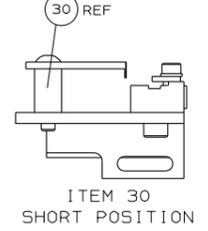
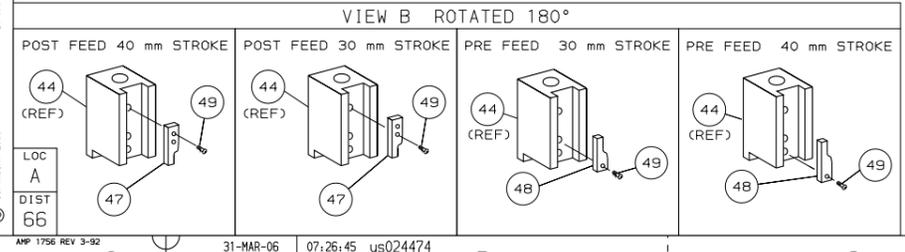
PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1528289-1	B	-	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528289-2	B	-	BENCH	MECH PRE FEED	CUTS CARRIER
1528289-6	B	-	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528289-1	B	-	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528289-2	B	-	BENCH	MECH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



QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO			
-	1	1	1	1	1	1	1528289	PRINT, APPLICATOR LOG SHEET	73
-	1	1	1	1	1	1	1338705-3	DOCUMENTATION PACKAGE	71
-	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	3-18031-0	SCR, SKT SET (M6X6) RAM	63
-	2	2	2	2	2	2	1-18024-5	SCR, BHC (M5X25) 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	58
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	57
-	4	4	4	4	4	4	18024-8	SCR, BHC (M4X12) SHEAR HOLDER	55
-	1	1	1	1	1	1	18030-1	NUT, HEX (M3) HOLD DOWN	53
-	1	1	1	1	1	1	811242-5	BUMPER, HOLDDOWN	52
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	51
-	1	1	1	1	1	1	18024-3	SCR, BHC (M3X10) CAM	49
-	1	1	1	1	1	1	1338675-1	CAM, PRE FEED 30 & 40 mm ST	48
-	1	1	1	1	1	1	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	1338660-1	RAM	44
-	1	1	1	1	1	1	2-18024-6	SCR, BHC (M8X25) RAM	41
-	1	1	1	1	1	1	690125-1	SHIM SUBASSY	39
-	1	1	1	1	1	1	469367-9	SPACER, FINE ADJUST	38
-	1	1	1	1	1	1	879103-3	FINE ADJUST HEAD SUBASSY	37
-	1	1	1	1	1	1	1320934-1	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	1320908-1	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	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	1	1	1	1	690472-1	STRIPPER	19
-	1	1	1	1	1	1	1338684-2	HOLDER, SHEAR, FRONT (NO-CUT)	17
-	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	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	3-1333204-4	ANVIL	8
-	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

DIMENSIONS, mm [INCHES]		MATERIAL		FINISH	
DO NOT SCALE PRINT.		MATERIAL		FINISH	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL		FINISH	
1 PLC DEC ±0.5 [.02 IN]		MATERIAL		FINISH	
2 PLC DEC ±-		MATERIAL		FINISH	
3 PLC DEC ±-		MATERIAL		FINISH	
ANGLES ±-		MATERIAL		FINISH	
SURF TEXTURE:		MATERIAL		FINISH	
REMOVE BURRS		MATERIAL		FINISH	
SHARP EDGES RO.3B MAX		MATERIAL		FINISH	
BREAK		MATERIAL		FINISH	
SCALE		MATERIAL		FINISH	
DWG NO		MATERIAL		FINISH	
1528289		MATERIAL		FINISH	
SHEET		MATERIAL		FINISH	
1 of 1		MATERIAL		FINISH	
REV		MATERIAL		FINISH	
B		MATERIAL		FINISH	
CUSTOMER AND ASSEMBLY DRAWING		MATERIAL		FINISH	

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LAYOUT L1426232 SET UP GAGE 458637-3

2000

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