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DIST

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	C1	ECR-14-002791	25FEB2014	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2151564-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1528232
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
1528232

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN GOPALAKRISHNA HV		 TE Connectivity	
DIMENSIONS:		CHK RAGHAVENDRA			
		APVD RAGHAVENDRA		NAME FINE ADJ SIDE FD HD-I APPL	
		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
		APPLICATION SPEC		A3 C- 1528232	
MATERIAL		WEIGHT		CUSTOMER DRAWING	
FINISH		SCALE		SHEET 1 OF 2 REV C1	

THIS DRAWING IS A CONTROLLED DOCUMENT

LAYOUT L1528232

SET UP GAGE 458637-3

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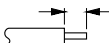
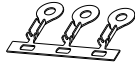
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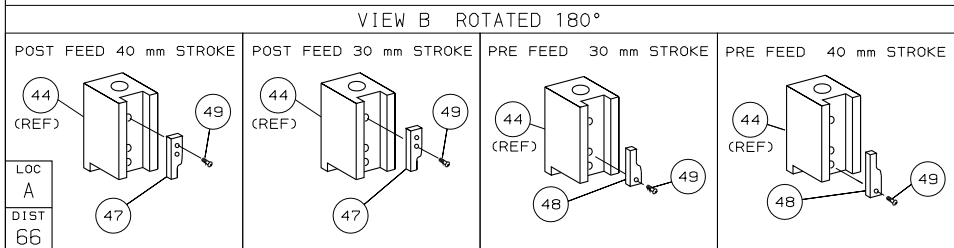
AMP 1756 REV 3-92

DRAWING MADE IN THIRD ANGLE PROJECTION

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1528232-1	C	-	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528232-2	C	-	BENCH	MECH PRE FEED	CUTS CARRIER
1528232-6	C	-	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528232-1	C	-	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528232-2	C	-	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528232-6	C	-	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528232-7	A	-	-	-	SPARE PARTS KIT

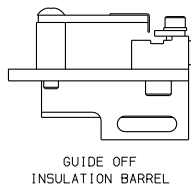
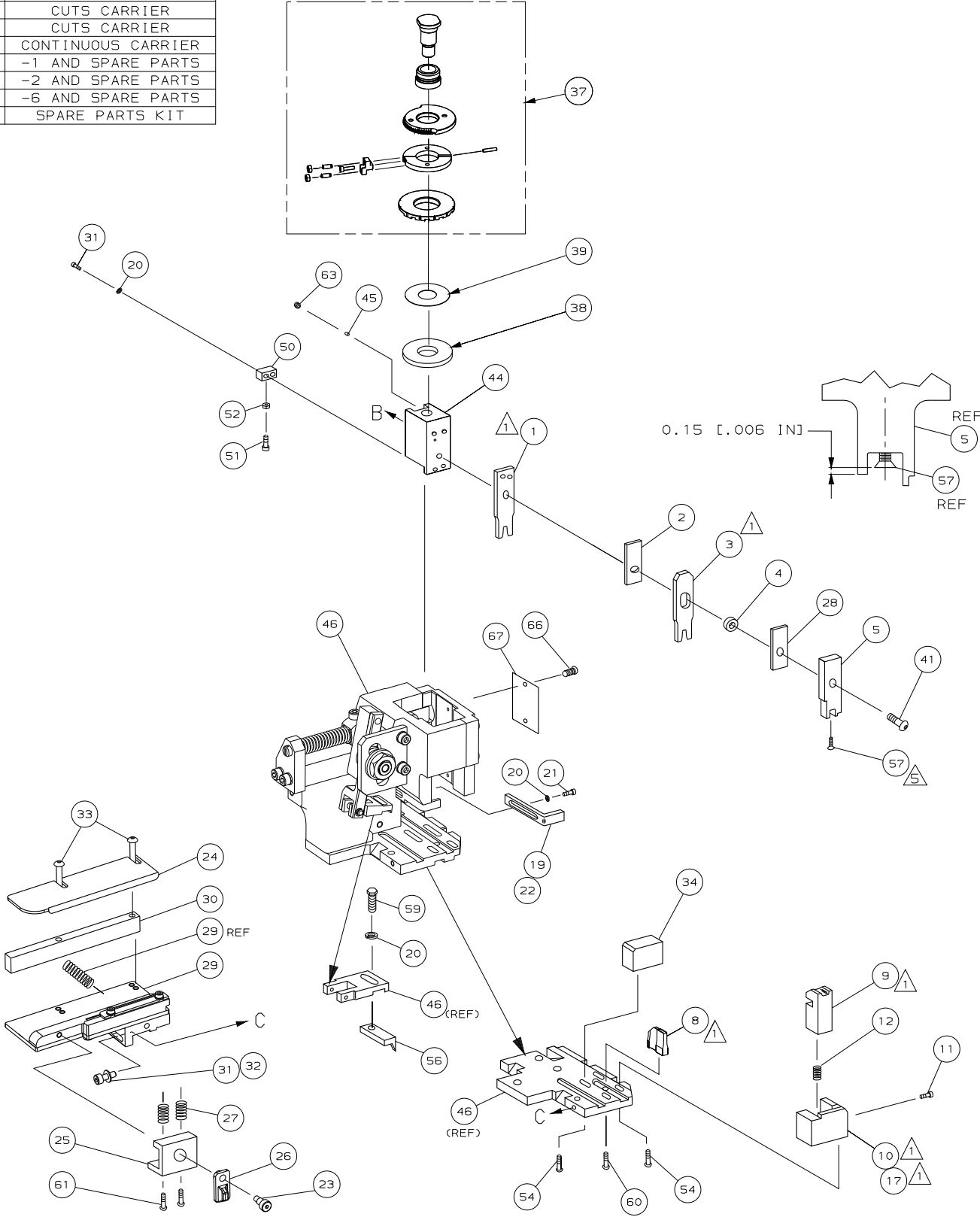
CRIMP DATA AMP TERMINAL AMP CRIMP SPECS					
TERMINAL NAME: AMP MCP2.8K FLAT TYPE RECEPTACLE					
CRIMP	SIZE	TYPE	RANGE		
WIRE	1.40 [0.055 IN]	F	0.2mm ² - 0.35mm ²		
INSUL	3.94 [0.155 IN]	0	3.40 MAX [0.134 IN MAX] 		
WIRE STRIP LENGTH			APPL INSTRUCTION		
3.40-4.00 [0.134-.157 IN]			408-8322 & 408-8490		
TERMINAL	-	-		FEED	
APPL SPEC	114-18387	-	-	12.00 [0.472 IN]	
TERMINALS APPLIED					
TERMINAL	SEAL	-	-	-	
1241392	963294-1	-	-	-	
-	-	-	-	-	
-	-	-	-	-	
-	-	-	-	-	
-	-	-	-	-	
-	-	-	-	-	
-	-	-	-	-	
-	-	-	-	-	
WIRE SIZE		CRIMP HEIGHT		REF SETTING	
mm ² AWG		✱			
0.35mm ²		1.03 ±0.03 [0.041 ±0.001 IN]		B 4	
0.25mm ²		0.98 ±0.03 [0.039 ±0.001 IN]		B 7	
0.22mm ²		0.96 ±0.03 [0.038 ±0.001 IN]		B 9	
0.20mm ²		0.96 ±0.03 [0.038 ±0.001 IN]		B 9	
-		-		-	
-		-		-	
-		-		-	
-		-		-	
-		-		-	
-		-		-	
-		-		-	
-		-		-	
-		-		-	
-		-		-	
-		-		-	

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 DIAMETER OF SEAL. WIRE INSULATION DIA IS DEPENDENT ON SEAL BEING APPLIED. SEAL P/N 963294-1 INS. RANGE 1.2-2.1 [0.047-.083 IN]. (TERMINAL INSULATION RANGE IS 1.1-1.5 [0.043-.059 IN].)
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.



* 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.



DIMENSIONS, mm [INCHES]		MATERIAL		FIN	
DO NOT SCALE PRINT.		HT TR		-	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		DR		07AUG03	
1 PLC DEC ±-		CHK		07AUG03	
2 PLC DEC ±-		REL		08SEP03	
3 PLC DEC ±-		L.LOFTHOUSE		L.LOFTHOUSE	
ANGLES ±-		NAME		FINE ADJ SIDE FD HD-I APPL	
SURF TEXTURE:		SCALE		D	
REMOVE BURRS, BREAK SHARP EDGES RO.38 MAX		DWG NO		1528232	
CHG CODE		CUSTOMER AND ASSEMBLY DRAWING		SHEET 1 of 1	
00779		REV C		RESTRICTED TO	

-	1	1	1	1	1	1	1528232	PRINT, APPLICATOR LOG SHEET	73
-	1	1	1	1	1	1	1338705-3	DOCUMENTATION PACKAGE	71
-	-	-	-	-	-	-	-	-	70
-	-	-	-	-	-	-	-	-	69
-	-	-	-	-	-	-	-	-	68
-	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
-	1	1	1	1	1	1	3-18031-0	SCR,SKT SET (M6X6) RAM	64
-	-	-	-	-	-	-	-	-	63
-	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
-	-	-	-	-	-	-	-	-	54
-	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	50
-	-	-	-	-	-	-	-	-	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
-	-	-	-	-	-	-	-	-	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	469367-8	SPACER, FINE ADJUST	39
-	1	1	1	1	1	1	879103-2	FINE ADJUST HEAD SUBASSY	38
-	-	-	-	-	-	-	-	-	37
-	-	-	-	-	-	-	-	-	36
-	-	-	-	-	-	-	-	-	35
-	1	1	1	1	1	1	1320934-4	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	1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1	1633073-2	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	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
-	1	1	1	1	1	1	318707-1	SHEAR, FLOAT (FRONT)	9
1	2	2	2	1	1	1	4-1333201-9	ANVIL	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	1338680-2	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	1	1	1	238011-4	SPACER, BLOCK CRIMPER	4
1	2	2	2	1	1	1	1-562244-1	CRIMPER, INSULATION	3
-	1	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	2	2	2	1	1	1	456402-1	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)		

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