

PART NUMBER	REV	FIRST USED
1385725-1	K	AOM / CLS
1385725-2	D	K UNIT
1385725-3	K	G UNIT
1385725-4	K	KOMAX

OBS

THIS DRAWING IS A CONTROLLED DOCUMENT.

DRAW NO 1385725

- 1 RECOMMENDED SPARE PARTS.
- 2 ITEMS NOT SHOWN ON ASSEMBLY.
- 3 TOLERANCE ON CUT LENGTH TO BE  $\pm 1.3$ .
- 4 USED ON THE CLS I AND II MACHINES ONLY. REMOVE THE TWO MOUNTING SCREWS SECURING THE PRODUCT DEREELEER 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:	
521470	
521596	
521598	
521600	
1969106	
1969107	

CRIMPING DATA				
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	STRIP LENGTH	
A	.052	18	.195	
B	.047	20		
C	.043	22		
D	-	-		
CRIMP	SIZE	TYPE	FEED	TERM SPEC
WIRE	.070	F	.580	114-2124
INSUL	.140	0		
INSUL RANGE	WIRE RANGE	APPLICATOR INSTRUCTION SHEET		
060-.110	22-18	AI 8099 AI 8102		

### KOMAX SET-UP INSTRUCTIONS FOR APPLICATOR 1385725-4 (REFERENCE ONLY)

- \* 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.
- \* FEED PAWL MUST BE SET UP AS CLOSE AS POSSIBLE TO THE SKATE DRAG.

THIS INFORMATION IS CONFIDENTIAL AND PROPRIETARY TO TYCO ELECTRONICS CORPORATION AND ITS WORLDWIDE SUBSIDIARIES AND AFFILIATES. IT MAY NOT BE DISCLOSED TO ANY OTHER PARTY WITHOUT THE WRITTEN AUTHORIZATION OF TYCO ELECTRONICS CORPORATION, HARRISBURG, PENNSYLVANIA, USA.

LOC A  
DIST 66

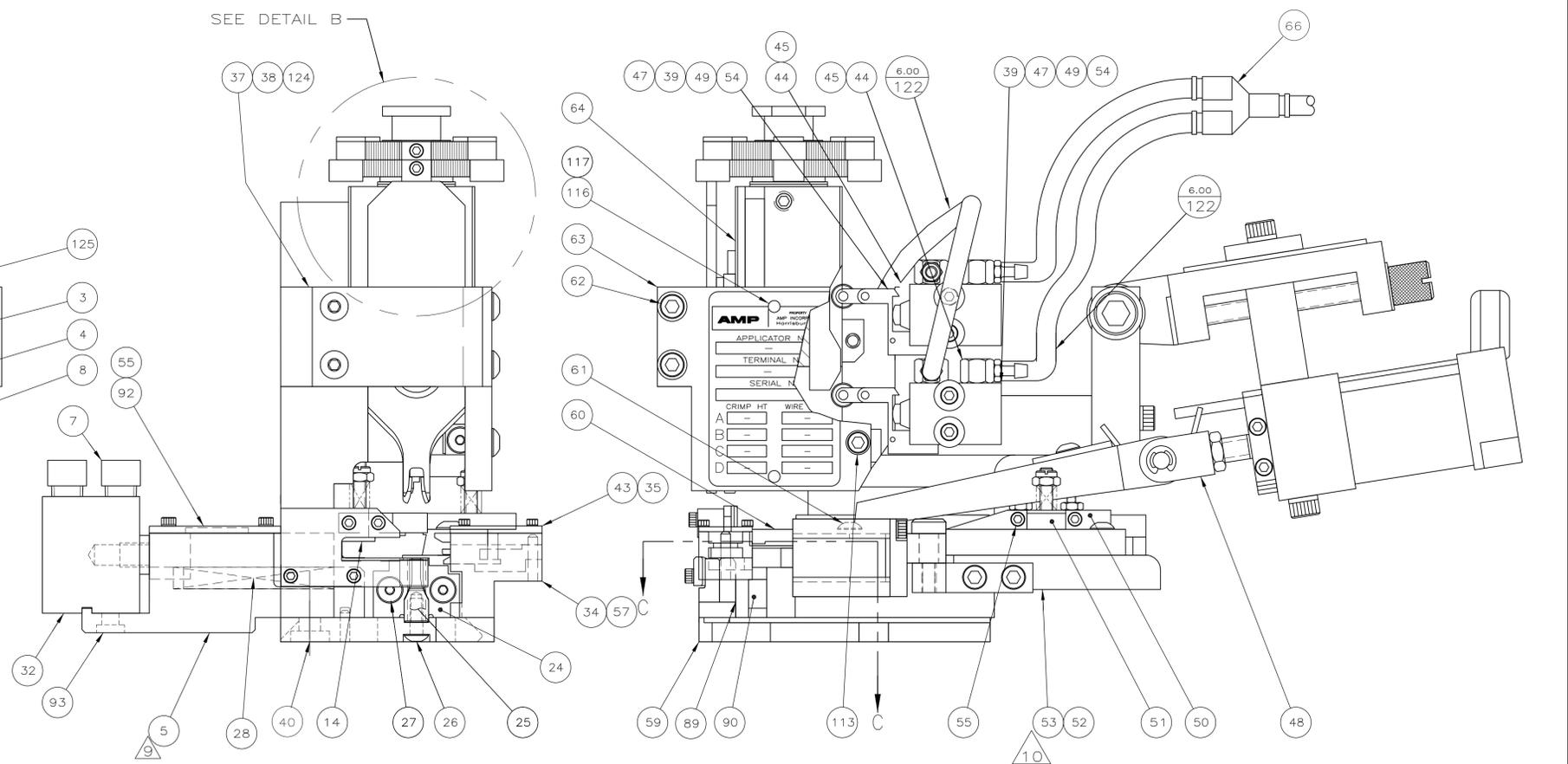
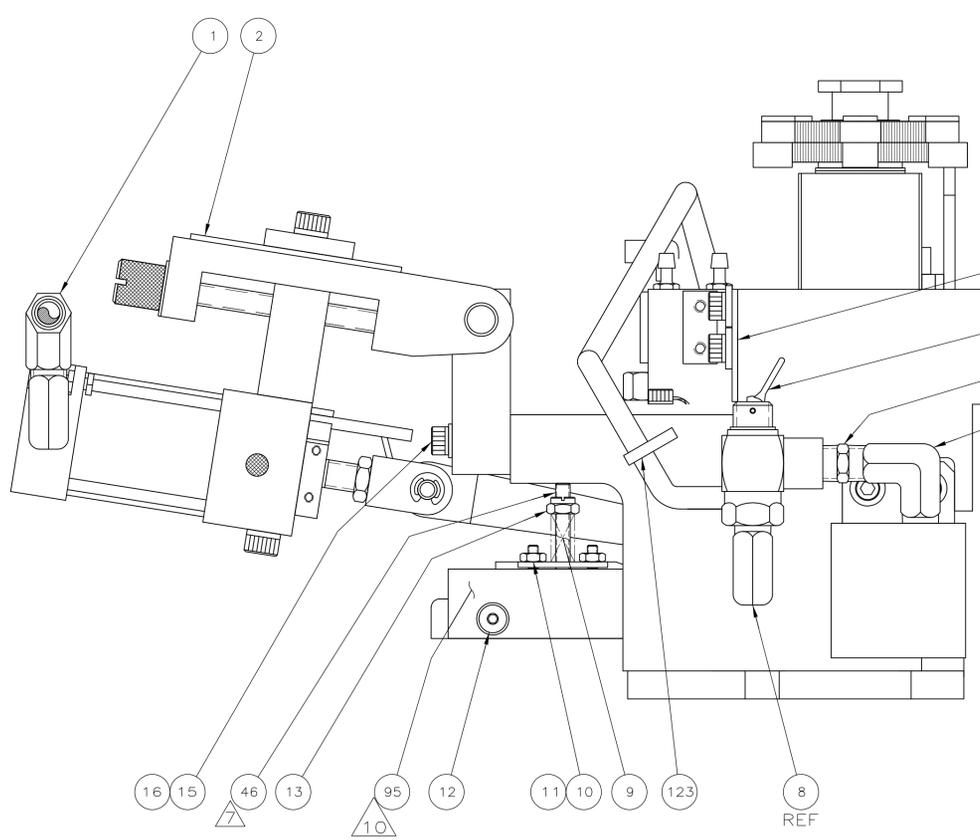
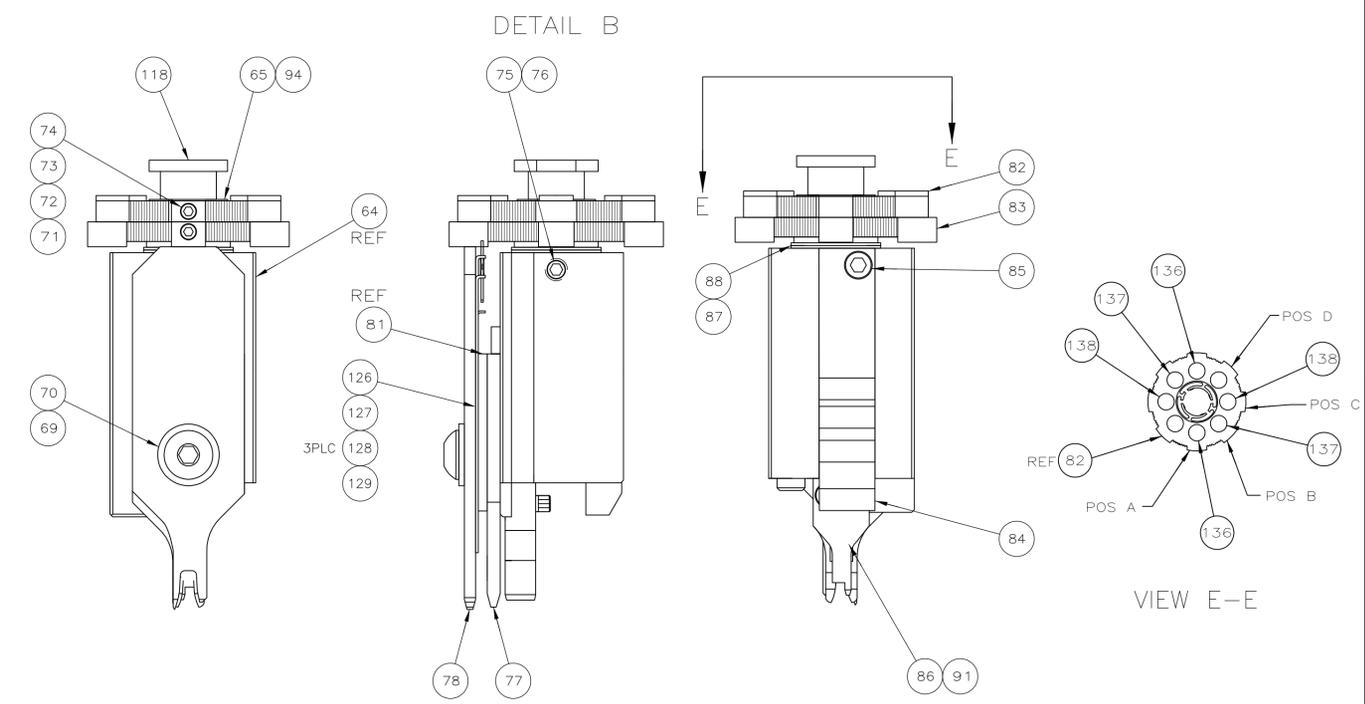
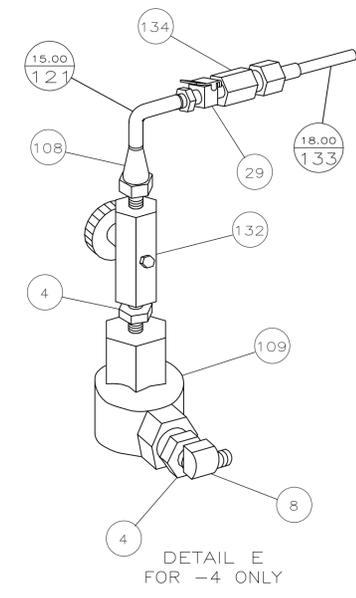
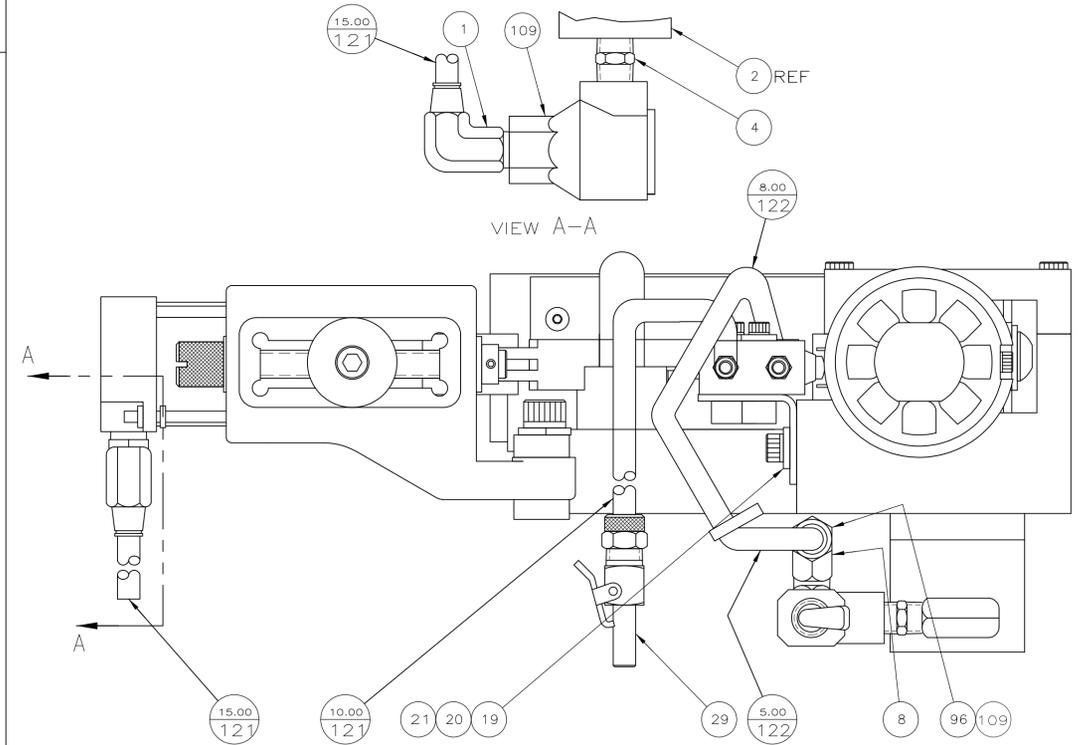
P	LTR	REVISION RECORD	DATE	DWN	APVD

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:
INCHES	0 PLC $\pm .01$
	1 PLC $\pm .005$
	2 PLC $\pm .002$
	3 PLC $\pm .001$
	4 PLC $\pm .0005$
ANGLES:	-
SURFACE TEXTURE:	$\sqrt{\quad}$

DWN	2/11/04	MATERIAL	-	HEAT TREAT	-
CHK	2/11/04				
APVD	2/11/04	 TE CONNECTIVITY Harrisburg, PA 17105-3608			
NAME	T ELBIN				
ULTRA POD FLAG APPLICATOR					
SCALE	1:1	SIZE	A1	DRAWING NO	1385725
SHEET	1	OF	3	REV	K

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT.



THIS INFORMATION IS CONFIDENTIAL AND PROPRIETARY TO TYCO ELECTRONICS CORPORATION AND ITS WORLDWIDE SUBSIDIARIES AND AFFILIATES. IT MAY NOT BE DISCLOSED TO ANY OTHER PARTY WITHOUT THE WRITTEN AUTHORIZATION OF TYCO ELECTRONICS CORPORATION, HARRISBURG, PENNSYLVANIA, USA.

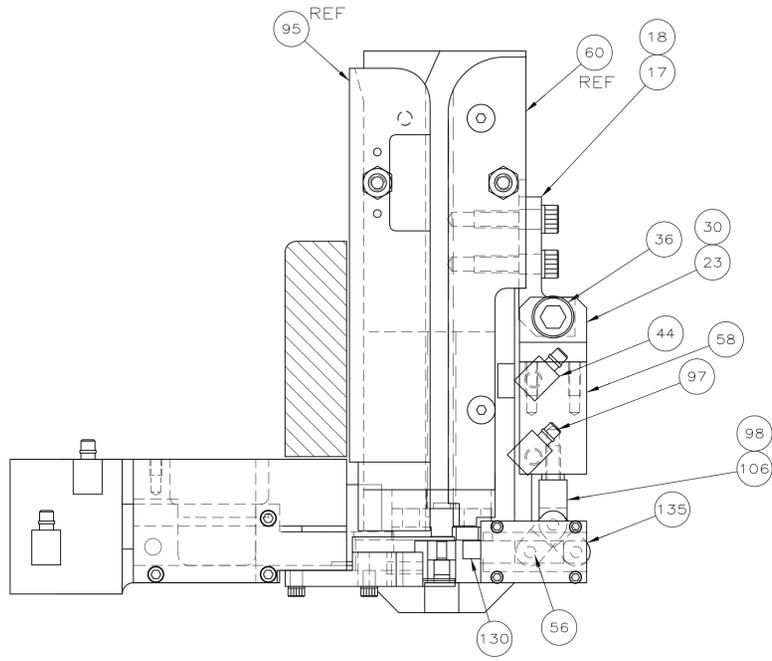
LOC A  
DIST 66

REVISION RECORD		DATE	OWN	APVD
- SEE SHEET 1				

DWN	K. STAKEM	8/24/04	MATERIAL	-	HEAT TREAT	-					
CHK	C.ERISMAN	8/24/04									
APVD	T.ELBIN	8/24/04									
NAME											
ULTRA POD FLAG APPLICATOR											
SCALE	1:1	SIZE	A1	DRAWING NO	1385725	SHEET	2	OF	3	REV	K

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT.



OBSOLETE

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
-	-	-	-	-	-	139
2	2	2	2	5-354779-3	PIN, WIRE DISC (.3255)C	138
2	2	2	2	4-354779-2	PIN, WIRE DISC (.3200)B	137
2	2	2	2	3-354779-3	PIN, WIRE DISC (.3155)A	136
2	2	2	2	1673387-1	LINK, TOGGLE	135
2	-	-	-	1424324-1	AIR LINE KIT .250 TO 4mm	134
3	18.00	-	-	IN 27319-8	TUBING, POLY FLOW $\phi$ .156	133
1	-	-	-	23054-1	VALVE, FLOW CONTROL	132
2	-	REF	-	679532-1	INSERT, GUARD	131
1	1	1	1	1673388-2	FINGER, BACK-UP	130
1	1	1	1	1424350-1	HOLDER, PIN, WIRED	129
3	3	3	3	2-23147-2	SPRING, DEPRESSOR	128
1	1	1	1	1490524-2	SPACER, DEPRESSOR	127
1	1	1	1	1490525-2	DEPRESSOR, WIRE	126
1	1	1	1	679172-1	SPACER	125
-	-	-	-	-	-	124
1	1	1	1	19832-1	TIE, WIRE	123
27.00	27.00	27.00	27.00	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	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	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
-	-	-	-	1-455750-3	GUARD ASSEMBLY	105
-	-	-	-	22307-1	BUSHING, PIPE, FITTING 1/4NPT	104
-	-	-	-	23791-2	TEE, PIPE, FITTING 1/4NPT	103
2	-	-	-	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	4-21006-4	SCR, SOC SET 8-32 X .50	98
1	1	1	1	25545-4	MUFFLER, EXHAUST	97
1	1	1	1	18258-3	CONN., TUBING, MALE 1/8NPT-1/4 TUBE	96
10	1	1	1	1752763-1	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 .39 LG.	93
1	1	1	1	1673397-1	COVER, VANE	92
2	2	2	2	2-21000-6	SCR., SHC 8-32UNC X .38 LG	91
1	1	1	1	852764-2	SHEAR, REAR	90
2	2	2	2	852765-2	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	1752734-1	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	455888-6	SPACER, CRIMPER	81
-	-	-	-	-	-	80
-	-	-	-	-	-	79
1	1	1	1	853491-2	CRIMPER, INSULATION	78
1	1	1	1	852743-3	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

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO	
-4	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO	
-4	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

OBSOLETE

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
1	1	1	1	7-21002-9	SCR., BHC 5/16-24UNF X 1.00 LG	70
1	1	1	1	238009-1	BLOCK, CRIMPER SPACER	69
-	-	-	-	-	-	68
-	-	-	-	-	-	67
1	1	1	1	1428088-2	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 10-32UNC X 1.00 LG	62
2	2	2	2	2-21002-3	SCR., BHC 8-32UNC X .62 LG	61
1	1	1	1	1633285-1	GUIDE, FRONT STRIP	60
1	1	1	1	1673380-1	PLATE, BASE	59
1	1	1	1	1725830-1	CYLINDER, COMPACT	58
1	1	1	1	1673389-2	MOUNT, FINGER	57
1	1	1	1	21030-1	PIN, DOWEL .12 DIA X .38 LG.	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
10	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	852740-1	ARM, STOCK DRAG	51
1	1	1	1	464452-8	DRAG, STOCK	50
4	4	4	4	21055-5	WASHER, FLAT 6	49
1	1	1	1	2-460680-7	FEED FINGER ASSEMBLY	48
2	2	2	2	986377-1	VALVE, LEVER ROLLER	47
7	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
-	-	-	-	-	-	41
2	2	2	2	3-21002-3	SCR, SHC 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 2-56UNC X .19 LG	35
1	1	1	1	2-21002-6	SCR., BHC 10-32UNC X .38 LG	34
-	-	-	-	-	-	33
1	1	1	1	354993-2	CYL., AIR, DOUBLE ACTING 1/8NPT	32
-	-	-	-	-	-	31
2	2	2	2	1-21000-8	SCR, SHC 6-32 X .25 LG.	30
2	2	2	2	23238-1	INSERT, COUPLING	29
1	1	1	1	1-23470-7	SPRING, COMPRESSION	28
2	2	2	2	2-21002-4	SCR., BHC 8-32UNC X 1.00 LG	27
1	1	1	1	22733-8	SCR., BHC 8-32UNC X .38 LG	26
1	1	1	1	853088-5	ANVIL	25
1	1	1	1	1673377-1	SHEAR, FRONT	24
1	1	1	1	1673385-1	EYE, CYLINDER	23
-	-	-	-	-	-	22
2	2	2	2	3-21000-4	SCR., SHC 10-32UNC X .38 LG	21
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	#10 LOCK WASHER	16
2	2	2	2	3-21000-9	SCR., SHC 10-32UNC X 1.00 LG	15
1	1	1	1	1752765-1	INSERTER, POD	14
2	2	2	2	21022-2	NUT, FLEX 8-32UNC	13
2	2	2	2	2-21002-1	SCR., BHC 8-32UNC X .38 LG	12
2	2	2	2	2-21006-3	SCR., SET, SOC CONE PT 4-40UNC X .38 LG	11
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	22304-1	ELBOW, MALE 1/8NPT	8
1	1	1	1	25545-1	MUFFLER, EXHAUST 1/8" NPT	7
-	-	-	-	-	-	6
1	1	1	1	1673395-1	INSERTER, MOUNT	5
3	2	2	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

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO	
-4	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO	
-4	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

THIS INFORMATION IS CONFIDENTIAL AND PROPRIETARY TO TYCO ELECTRONICS CORPORATION AND ITS WORLDWIDE SUBSIDIARIES AND AFFILIATES. IT MAY NOT BE DISCLOSED TO ANY OTHER PARTY WITHOUT THE EXPRESS WRITTEN AUTHORIZATION FROM TYCO ELECTRONICS CORPORATION, HARRISBURG, PENNSYLVANIA, USA.

LOC A  
DIST 66

3308-8 (1/08)	8	7	6	5	4	3	2	1	
REVISION RECORD	DATE	OWN	APVD	DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		TE CONNECTIVITY Harrisburg, PA 17105-3608	
- SEE SHEET 1	-	-	-	0 PLC ±.0005 1 PLC ±.0010 2 PLC ±.0015 3 PLC ±.0020 4 PLC ±.0025		ANGLES: SURFACE TEXTURE		SCALE: 1:1 SIZE: A1 DRAWING NO: 1385725 SHEET 3 OF 3 REV K	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING									

Компания «Life Electronics» занимается поставками электронных компонентов импортного и отечественного производства от производителей и со складов крупных дистрибьюторов Европы, Америки и Азии.

С конца 2013 года компания активно расширяет линейку поставок компонентов по направлению коаксиальный кабель, кварцевые генераторы и конденсаторы (керамические, пленочные, электролитические), за счёт заключения дистрибьюторских договоров

Мы предлагаем:

- Конкуренспособные цены и скидки постоянным клиентам.
- Специальные условия для постоянных клиентов.
- Подбор аналогов.
- Поставку компонентов в любых объемах, удовлетворяющих вашим потребностям.
- Приемлемые сроки поставки, возможна ускоренная поставка.
- Доставку товара в любую точку России и стран СНГ.
- Комплексную поставку.
- Работу по проектам и поставку образцов.
- Формирование склада под заказчика.
- Сертификаты соответствия на поставляемую продукцию (по желанию клиента).
- Тестирование поставляемой продукции.
- Поставку компонентов, требующих военную и космическую приемку.
- Входной контроль качества.
- Наличие сертификата ISO.

В составе нашей компании организован Конструкторский отдел, призванный помогать разработчикам, и инженерам.

Конструкторский отдел помогает осуществить:

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



Тел: +7 (812) 336 43 04 (многоканальный)

Email: [org@lifeelectronics.ru](mailto:org@lifeelectronics.ru)