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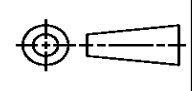
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	B1	ECR-14-003278	05MAR2014	GK	HMR






REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2151186-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1528266
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
1528266

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV		 TE Connectivity					
		CHK	RAGHAVENDRA							
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	NAME					
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		RAGHAVENDRA		FINE ADJUST SIDE FEED HDI APPLICATOR				
				PRODUCT SPEC						
				APPLICATION SPEC						
MATERIAL		FINISH		WEIGHT	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
					A3		©- 1528266			
CUSTOMER DRAWING				SCALE	SHEET	1	OF	2	REV	B1

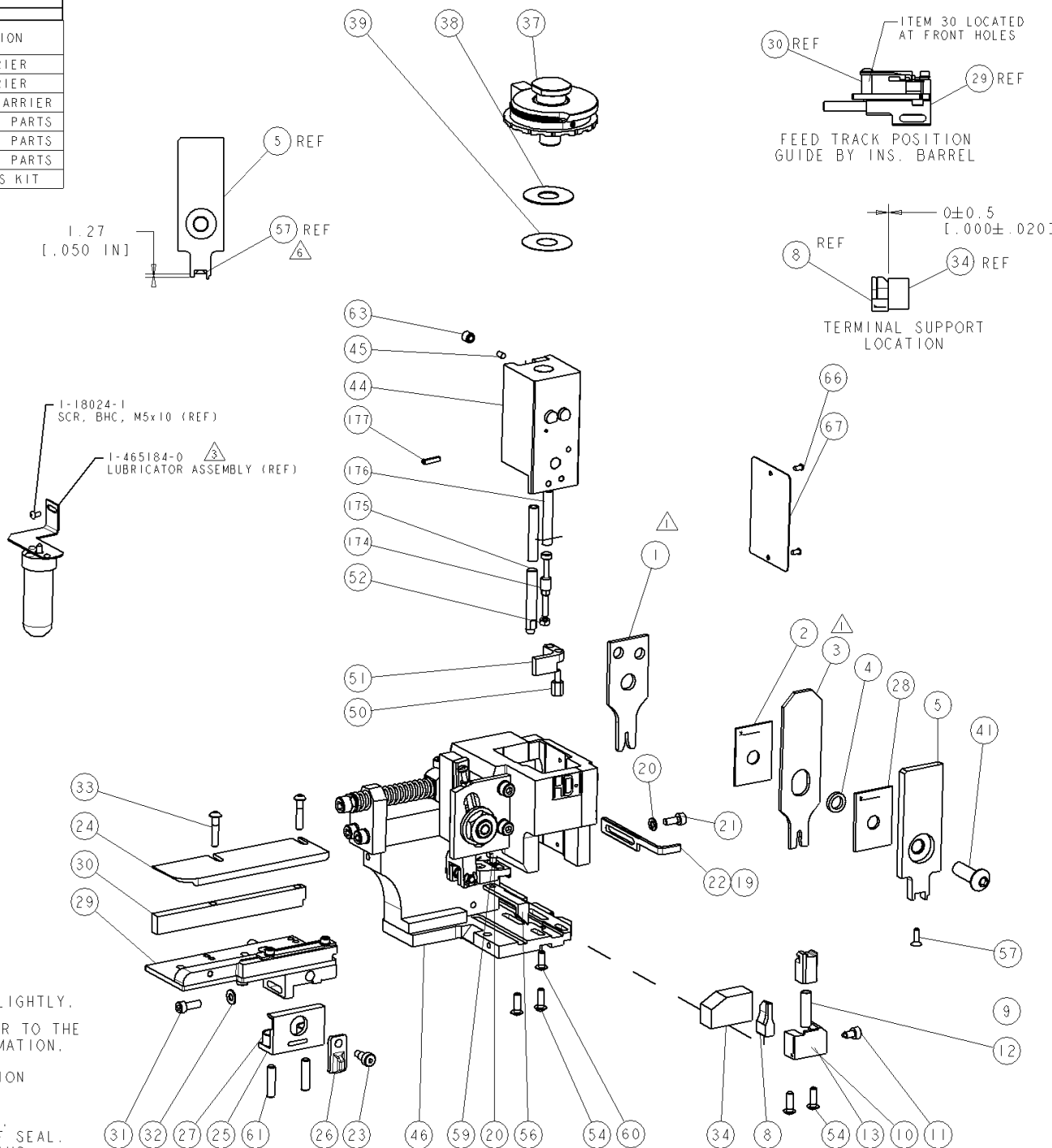
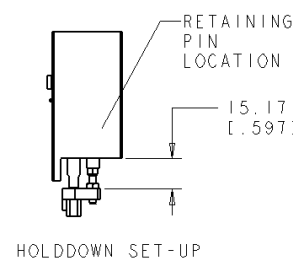
8		7		6		5		4		3		2		1	
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PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION											
1528266-1	B	LEADMAKER	MECH POST FEED	CUTS CARRIER											
1528266-2	B	BENCH	MECH PRE FEED	CUTS CARRIER											
1528266-6	A	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER											
7-1528266-1	B	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS											
7-1528266-2	B	BENCH	MECH PRE FEED	-2 AND SPARE PARTS											
7-1528266-6	A	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS											
7-1528266-7	A	-	-	SPARE PARTS KIT											

CRIMP DATA		TE TERMINAL		TE CRIMP SPECS	
TERMINAL NAME: .040 III SEALED CONTACT					
CRIMP	SIZE	TYPE	RANGE		
WIRE	1.70 [.067 IN]	F	0.30-0.50mm ²		
INSUL	3.00 [.118 IN]	O	1.40-1.70 [.055-.067 IN]		
WIRE STRIP LENGTH 4.00-4.50 [.157-.177 IN]			APPL INSTRUCTIONS 408-8322 & 408-8490		
TERMINAL APPL SPEC		114-5227 -		FEED 9.50 [.374 IN]	
TERMINALS APPLIED					
TE PN		SEAL PN	-	-	
316833		286912-1	-	-	
316832		286912-1	-	-	
-		1572038-1	-	-	
-		-	-	-	
WIRE SIZE		CRIMP HEIGHT		REF SETTING 	
0.50mm ²		1.03 ±0.05 [.041 ±.002 IN]	B4		
0.30mm ² or 0.35mm ²		.94 ±0.05 [.037 ±.002 IN]	C2		
-		-	-		
-		-	-		
-		-	-		
-		-	-		
-		-	-		
-		-	-		
-		-	-		
-		-	-		
-		-	-		
-		-	-		
-		-	-		
-		-	-		

1. RECOMMENDED SPARE PARTS.
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
3. CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.
4. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
5. 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 PN - INS. DIA RANGE IS -.
6. APPLY TORO-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.

VIEW B ROTATED 180°			
POST-FEED 40mm STROKE	POST-FEED 30mm STROKE	PRE-FEED 30mm STROKE	PRE-FEED 40mm STROKE

* 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.



SET UP GAGE
458637-3

REVISIONS			
P	REV	DESCRIPTION	DATE
1	DEVELOPMENT	03APR2009	C.C. N.D.
A	RELEASED	24APR2009	LG GB
B	REVISED ECR-10-005761	22MAR2010	C.C. S.X

-	1	1	1	1	1	1	993111-8	PIN, SLOTTED SPRING 3.0 X 12.0	177
-	2	2	2	2	2	2	3-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1	1752353-1	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1	1	1901680-1	GUIDE PIN, HOLDDOWN	174
-	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	SCREW, DRIVE	66
-	1	1	1	1	1	1	3-18031-0	SCR, SET, CUP POINT M6 X 6.0	63
-	2	2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	1	1	1	1	1	1	18024-7	SCR, BTN SKT HD CAP (M4 X 10.0)	60
-	1	1	1	1	1	1	5-18022-2	SCR, HEX HD CAP M4 X 8.0	59
-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	18024-8	SCR, BTN SKT HD CAP (M4 X 12.0)	54
-	1	1	1	1	1	1	1-18030-0	NUT, HEX, REG M3.5	52
-	1	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1	1	1-1752354-9	STANDOFF, HOLD-DOWN	50
-	1	1	1	1	1	1	18024-3	SCR, BTN SKT HD CAP (M3 X 10.0)	49
-	-	-	-	-	-	-	1338675-1	CAM, UNIVERSAL PRE FEED	48
-	1	-	-	-	-	-	1338676-1	CAM, UNIVERSAL POST-FEED	47
-	1	1	1	1	1	1	1320999-3	APPLICATOR SUBASSEMBLY, HDI	46
-	1	1	1	1	1	1	690191-1	PLUG, NYLON	45
-	1	1	1	1	1	1	1633724-1	RAM, (SIDE FEED)	44
-	1	1	1	1	1	1	2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)	41
-	1	1	1	1	1	1	690125-1	SHIM SUB-ASSY	39
-	1	1	1	1	1	1	469367-8	SHIM	38
-	1	1	1	1	1	1	879103-2	FINE ADJUST HEAD ASSEMBLY	37
-	1	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	1-18024-0	SCR, BTN SKT HD CAP (M4 X 20.0)	33
-	1	1	1	1	1	1	18027-2	WASHER, FLAT, REG M4	32
-	1	1	1	1	1	1	1-18023-2	SCR, SKT HD CAP M4 X 12.0	31
-	1	1	1	1	1	1	1320908-4	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1	1633073-1	STRIP GUIDE ASSEMBLY	29
-	1	1	1	1	1	1	1-455888-6	SPACER, CRIMPER	28
-	2	2	2	2	2	2	1-22284-0	SPRING, COMPRESSION	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, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	-	-	-	-	-	690472-2	STRIPPER	22
-	1	1	1	1	1	1	1-18023-1	SCR, SKT HD CAP M4 X 10.0	21
-	2	2	2	2	2	2	18025-2	WASHER, SPRG LOCK, REG M4	20
-	-	-	-	-	-	-	690472-1	STRIPPER	19
-	1	-	-	-	-	-	1338684-2	SHEAR HOLDER, FRONT	13
-	-	-	-	-	-	-	-	-	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	356885-5	STOP, SHEAR	11
-	-	-	-	-	-	-	1-1320921-0	SHEAR HOLDER, FRONT, CUT	10
-	1	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
-	1	2	2	2	1	1	1333225-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	1338680-2	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
-	1	2	2	1	1	1	409415-1	INSULATION CRIMPER	3
-	1	1	1	1	1	1	455888-8	SPACER, CRIMPER	2
-	1	2	2	1	1	1	409414-1	WIRE CRIMPER	1

-77 -76 -72 -71 -6 -2 -1		PART NO	DESCRIPTION	ITEM NO
TYCO ELECTRONICS CORPORATION		03APR2009	TYCO ELECTRONICS CORPORATION	
C. CHEN		03APR2009	TYCO ELECTRONICS CORPORATION	
S. XI		03APR2009	TYCO ELECTRONICS CORPORATION	
N. DEMING		03APR2009	TYCO ELECTRONICS CORPORATION	
PRODUCT SPEC			TYCO ELECTRONICS CORPORATION	
APPLICATION SPEC			TYCO ELECTRONICS CORPORATION	
See Table			TYCO ELECTRONICS CORPORATION	
MATERIAL			TYCO ELECTRONICS CORPORATION	
FINISH			TYCO ELECTRONICS CORPORATION	
WEIGHT			TYCO ELECTRONICS CORPORATION	
CUSTOMER DRAWING			TYCO ELECTRONICS CORPORATION	
SIZE		00779	00779	
SCALE		3-5	3-5	
SHEET		1	1	
REV		B	B	