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LOC

DIST

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	G1	ECR-14-002428	22FEB2014	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2151041-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1528161
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
1528161

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				
		APPLICATION SPEC				
MATERIAL		WEIGHT	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
			A3		©- 1528161	
FINISH		CUSTOMER DRAWING		SCALE	SHEET 1 OF 2	REV G1

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1528161-1	G	-	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528161-2	G	-	BENCH	MECH PRE FEED	CUTS CARRIER
1528161-6	G	-	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528161-1	G	-	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528161-2	G	-	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528161-6	G	-	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528161-7	A	-	-	-	SPARE PARTS KIT

CRIMP DATA		AMP TERMINAL	AMP CRIMP SPECS
TERMINAL NAME: AMP MCP 1.2-LL			
CRIMP	SIZE	TYPE	RANGE
WIRE	1.27 [.050 IN]	F	0.25mm ² –0.35mm ² (24–22 AWG)
INSUL	3.05 [.120 IN]	0	1.10–1.75 [.043–.069 IN]
WIRE STRIP LENGTH		APPL INSTRUCTION	
3.00–3.60 [.118–.142 IN]		408–8322 & 408–8490	

TERMINAL	—	—		FEED
APPL SPEC	114-18464	—		7.50 [.295 IN]

TERMINALS APPLIED 

TERMINAL	SEAL	—	—	—
1452665	967067-1	—	—	—
—	967067-2	—	—	—
—	963142-2	—	—	—
—	—	—	—	—
—	—	—	—	—
—	—	—	—	—
—	—	—	—	—

WIRE SIZE mm ² AWG	CRIMP HEIGHT *	REF SETTING
0.35mm ²	0.84 ±0.03 [.033 ±.001 IN]	B0
22 AWG	0.83 ±0.03 [.033 ±.001 IN]	B0
0.25mm ²	0.78 ±0.03 [.031 ±.001 IN]	B3
24 AWG	0.75 ±0.03 [.030 ±.001 IN]	B5

[illegible]

- 
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. WIRE INSULATION DIA IS DEPENDENT ON SEAL BEING APPLIED. CHOICE OF SEAL IS DEPENDENT ON HOUSING CAVITY DIA. & WIRE APPLIED. REFER TO APPL. SPEC. FOR DETAILS.
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. DUE TO THE DEMANDS OF APPLICATION SPEC 114-18464 IT IS IMPORTANT, IF THE ANVIL IS MOVED OR REPLACED, THAT IT IS BIASED TOWARDS THE OPERATOR'S POSITION AS FAR AS POSSIBLE WHEN RE-SECURING TO THE BASE PLATE.

VIEW B ROTATED 180°

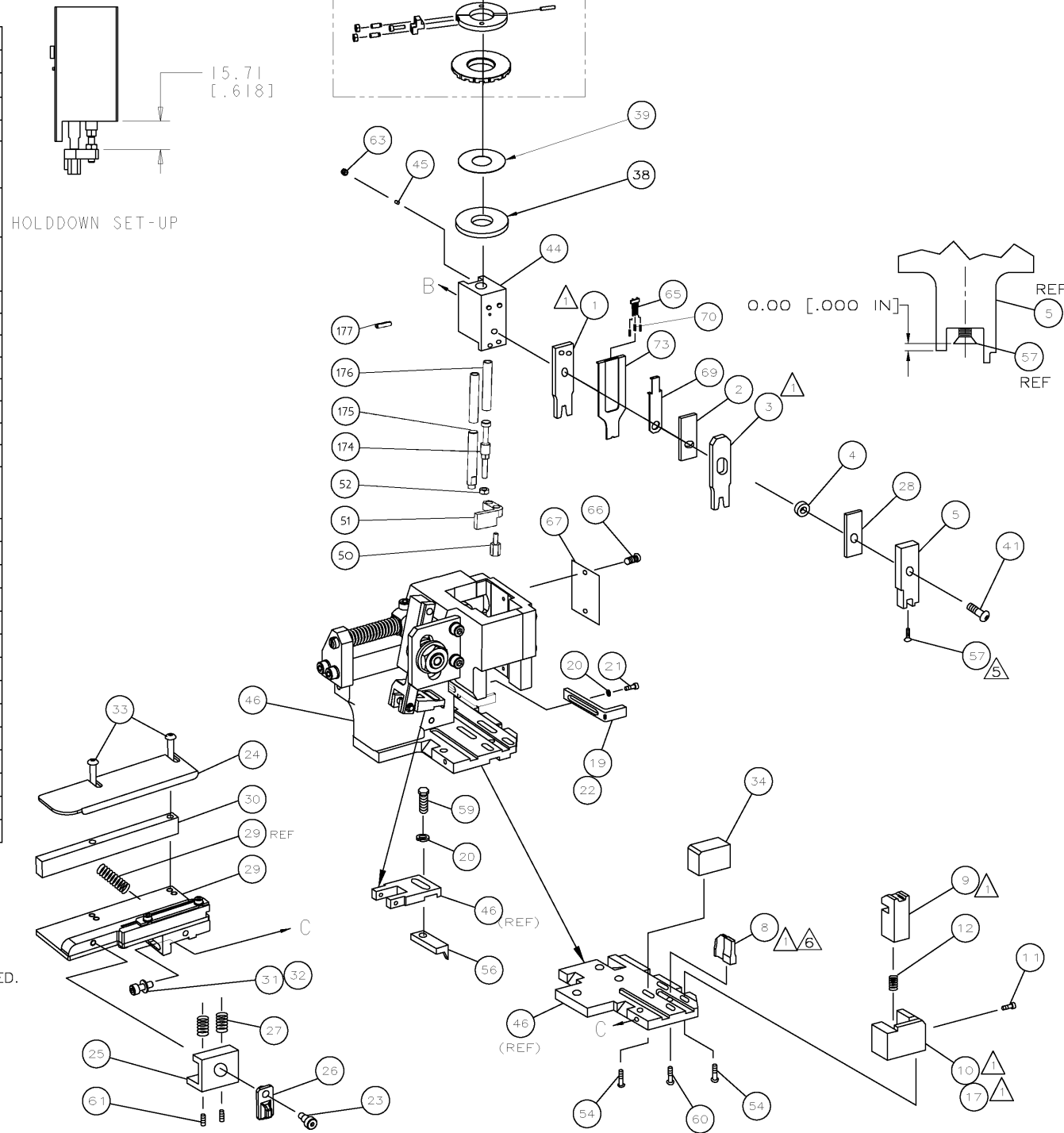
POST FEED 40 mm STROKE	POST FEED 30 mm STROKE	PRE FEED 30 mm STROKE	PRE FEED 40 mm STROKE

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* 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.



TOOLING APPROVED BY
GB GATD & TERMINAL
PRODUCT ENGINEERING
GERMANY.

-	1	1	1	1	1	1	99311-8	PIN, SLOTTED SPRING 3.0X12.0	177
-	2	2	2	2	2	2	3-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1	1752353-1	GUIDE PIN, HOLD DOWN	175
-	1	1	1	1	1	1	1901680-1	GUIDE PIN, HOLD DOWN	174
-	1	1	1	1	1	1	1490525-1	DEPRESSOR, WIRE	73
-	1	1	1	1	1	1	1528161	PRINT, APPLICATOR LOG SHEET	72
-	1	1	1	1	1	1	1338705-3	DOCUMENTATION PACKAGE	71
-	3	3	3	3	3	3	2-23147-2	SPRING, DEPRESSOR	70
-	1	1	1	1	1	1	1490524-2	SPACER, DEPRESSOR	69
-	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	1424350-1	HOLDER, PIN, WIRED	65
-	1	1	1	1	1	1	3-18031-0	SCR,SKT SET(M6X6)RAM	63
-	2	2	2	2	2	2	2-18032-5	SCR,SET(M5X20)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	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
									55
-	4	4	4	4	4	4	18024-8	SCR,BHC(M4x12)SHEAR HOLDER	54
									53
-	1	1	1	1	1	1	1-18030-0	NUT, HEX, REG M3.5	52
-	1	1	1	1	1	1	1901681-1	HOLD DOWN, TERMINAL	51
-	1	1	1	1	1	1	1-1752354-7	STANDOFF, HOLD-DOWN	50
-	1	1	1	1	1	1	18024-3	SCR,BHC(M3X10)CAM	49
-	-	-	-	-	-	-	1338675-1	CAM, PRE FEED 30 & 40 mm ST	48
-	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	1633724-1	RAM	44
									43
									42
-	1	1	1	1	1	1	2-18024-6	SCR,BHC(M8X25)RAM	41
									40
-	1	1	1	1	1	1	690125-1	SHIM SUBASSY	39
-	1	1	1	1	1	1	469367-7	SPACER, FINE ADJUST	38
-	1	1	1	1	1	1	879103-3	FINE ADJUST HEAD SUBASSY	37
									36
									35
-	1	1	1	1	1	1	1-1752356-8	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
-	1	1	1	1	1	1	1-18023-2	SCR,SKT CAP(M4X12)MOUNT BLOCK	31
-	1	1	1	1	1	1	1320908-3	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1	1633073-2	STRIP GUIDE PLATE ASSY	29
-	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	1320928-2	PLATE, STRIP GUIDE	24
-	1	1	1	1	1	1	980371-4	SCR,SHC SHLD	23
-	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	-	1424364-1	STRIPPER	19
									18
-	1	-	-	1	-	-	1338684-2	HOLDER, SHEAR, FRONT (NO-CUT)	17
									16
									15
									14
									13
-	1	1	1	1	1	1	3-22280-3	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	318707-9	SHEAR, FLOAT (FRONT)	9
1	2	2	2	1	1	1	3-1333225-9	ANVIL	8
									7
									6
-	1	1	1	1	1	1	1338680-1	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	1	1	1	238011-4	SPACER, BLOCK CRIMPER	4
1	2	2	2	1	1	1	1-1583690-1	CRIMPER, INSULATION	3
-	1	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	2	2	2	1	1	1	1-1673600-0	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)		
							QTY REQD PER ASSY		PARTS LIST
							DIMENSIONS: mm [INCHES]		MATL
							DO NOT SCALE PRINT.		HT TR
							TOLERANCES UNLESS OTHERWISE SPECIFIED:		FIN
							1 PLC DEC ±		
							2 PLC DEC ±		
							3 PLC DEC ±		
							ANGLES ±		
							SURF TEXTURE: ✓		
							REMOVE BURRS, BREAK SHARP EDGES RO.38 MAX		
							DR L LOFTHOUSE		10JUN03 APP 10JUN03 F BACKHURST
							CHK -		REL 26-05-04 M.CLIFFORD
							NAME		TE Connectivity Harrisburg, PA 17105-3608
							SCALE -		MACHINE REF
							DWG NO		HD-I APPL
							1528161		SHEET
									1 OF 1
									REV
									G
							CASE CODE		RESTRICTED TO
							00779		-
							CUSTOMER AND ASSEMBLY DRAWING		