

4

3

2

1

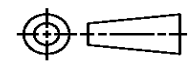
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LOC	DIST	REVISIONS			
P	LTR	DESCRIPTION	DATE	DWN	APVD
	B1	ECR-15-001337	27JAN2015	GK	HMR

# REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2266572-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1528739  
 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  
 1528739

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV		
DIMENSIONS:		CHK	RAGHAVENDRA		
		APVD	RAGHAVENDRA		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	NAME		
0 PLC	±	APPLICATION SPEC	FINE ADJUST SIDE FEED HDI APPLICATOR		
1 PLC	±		SIZE	CAGE CODE	DRAWING NO
2 PLC	±		A3		©- 1528739
3 PLC	±				RESTRICTED TO
4 PLC	±				
ANGLES	±	WEIGHT			
MATERIAL	FINISH	CUSTOMER DRAWING	SCALE	SHEET 1 OF 2	REV B1



PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1528739-1	B	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528739-2	B	BENCH	MECH PRE FEED	CUTS CARRIER
1528739-6	B	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528739-1	B	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528739-2	B	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528739-6	B	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528739-7	A	-	-	SPARE PARTS KIT

CRIMP	SIZE	TYPE	RANGE
WIRE	1.52 [.060 IN]	F	0.50mm <sup>2</sup> or 22 AWG
INSUL	3.45 [.136 IN]	O	3.25 [.128 IN]
WIRE STRIP LENGTH	4.68-5.48 [.184-.216 IN]		

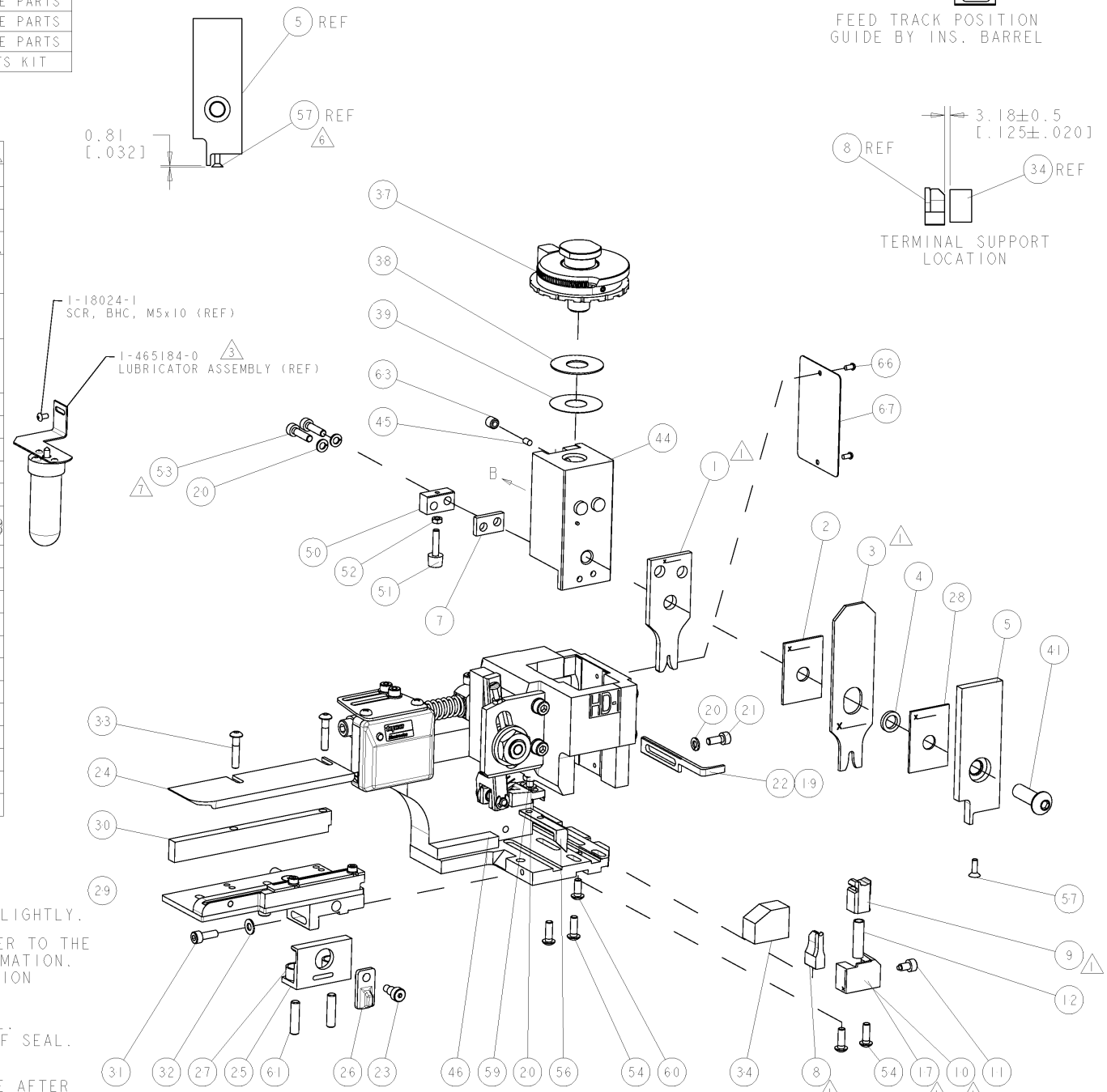
TERMINAL APPL SPEC	MOLEX SPEC	FEED
SD-34083-002	-	11.43 [.450 IN]

TYCO TERM PN	MANUF'S TERM PN	TYCO SEAL PN	MANUF'S SEAL PN
1949235-1	34081-3005	1949248-1	9786-10C930-SBA (FORD)
1949235-2	34083-3003	-	-

WIRE SIZE	CRIMP HEIGHT	REF SETTING
0.50mm <sup>2</sup>	1.10 ± 0.05 [.043 ± .002 IN]	B9
22 AWG	1.00 ± 0.05 [.039 ± .002 IN]	C7



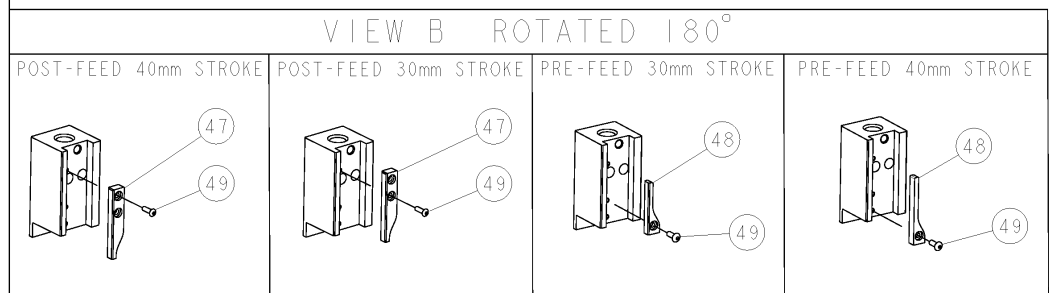
SET UP GAGE  
458637-3

REV	DATE	BY	CHK	DESCRIPTION
A	08FEB2007	MC	MC	SEE ECO-07-003164
B	28JAN2011	L.Z	S.X	ECR-11-002048

REV	DATE	BY	CHK	DESCRIPTION	ITEM NO		
-	-	-	-	-	73		
-	-	-	-	-	72		
-	1	1	1	1	1338705-3	DOCUMENTATION PACKAGE	71
-	-	-	-	-	-	70	
-	-	-	-	-	-	69	
-	-	-	-	-	-	68	
-	1	1	1	1	461264-5	PLATE, IDENTIFICATION	67
-	2	2	2	2	21017-2	SCREW, DRIVE	66
-	-	-	-	-	-	65	
-	-	-	-	-	-	64	
-	1	1	1	1	3-18031-0	SCR, SET, CUP POINT M6 X 6.0	63
-	-	-	-	-	-	62	
-	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	1	1	1	1	18024-7	SCR, BTN SKT HD CAP (M4 X 10.0)	60
-	1	1	1	1	5-18022-2	SCR, HEX HD CAP M4 X 8.0	59
-	-	-	-	-	-	58	
-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1338685-1	PAWL, FEED	56
-	-	-	-	-	-	55	
-	4	4	4	4	18024-8	SCR, BTN SKT HD CAP (M4 X 12.0)	54
-	2	2	2	2	1-18023-3	SCR, SKT HD CAP M4 X 16.0	53
-	1	1	1	1	18030-1	NUT, HEX, REG M3	52
-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	1	1	1	18024-3	SCR, BTN SKT HD CAP (M3 X 10.0)	49
-	-	-	-	-	-	48	
-	1	1	1	1	1338675-1	CAM, UNIVERSAL PRE FEED	47
-	1	1	1	1	1338676-1	CAM, UNIVERSAL POST-FEED	46
-	1	1	1	1	1320999-3	APPLICATOR SUBASSEMBLY, HDI	45
-	1	1	1	1	690191-1	PLUG, NYLON	44
-	1	1	1	1	1338660-1	RAM	43
-	-	-	-	-	-	42	
-	1	1	1	1	2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)	41
-	-	-	-	-	-	40	
-	1	1	1	1	690125-1	SHIM SUB-ASSY	39
-	1	1	1	1	469367-8	SHIM	38
-	1	1	1	1	879103-2	FINE ADJUST HEAD ASSEMBLY	37
-	-	-	-	-	-	36	
-	-	-	-	-	-	35	
-	1	1	1	1	1320934-6	SUPPORT, TERMINAL	34
-	2	2	2	2	1-18024-0	SCR, BTN SKT HD CAP (M4 X 20.0)	33
-	1	1	1	1	18027-2	WASHER, FLAT, REG M4	32
-	1	1	1	1	1-18023-2	SCR, SKT HD CAP M4 X 12.0	31
-	1	1	1	1	1320908-1	SPACER, STRIP GUIDE	30
-	1	1	1	1	1-1633073-3	STRIP GUIDE ASSEMBLY	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	1-22284-0	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1320928-1	PLATE, STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	690472-2	STRIPPER	22
-	1	1	1	1	1-18023-1	SCR, SKT HD CAP M4 X 10.0	21
-	4	4	4	4	18025-2	WASHER, SPRG LOCK, REG M4	20
-	-	-	-	-	-	19	
-	-	-	-	-	-	18	
-	1	1	1	1	1338684-2	SHEAR HOLDER, FRONT	17
-	-	-	-	-	-	16	
-	-	-	-	-	-	15	
-	-	-	-	-	-	14	
-	-	-	-	-	-	13	
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	356885-5	STOP, SHEAR	11
-	1	1	1	1	1-1320921-0	SHEAR HOLDER, FRONT, CUT	10
-	1	1	1	1	318707-2	FLOATING SHEAR, FRONT	9
-	1	2	2	2	3-1633138-0	ANVIL, COMBINATION	8
-	2	1	1	1	240641-5	SPACER	7
-	-	-	-	-	-	6	
-	1	1	1	1	1338680-2	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	2	2	2	8-1583690-9	CRIMPER, INSUL O	3
-	1	1	1	1	1-455888-4	SPACER, CRIMPER	2
-	1	2	2	2	7-1633305-6	CRIMPER, WIRE PREMIUM	1

- △ RECOMMENDED SPARE PARTS.
- 2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
- △ 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.
- △ THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION DIA QUOTED IS OUTSIDE DIAMETER OF SEAL. WIRE INSULATION DIA IS 2.6MM [.102 IN] MAX.
- △ 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.
- △ ITEM 53, CUT TO LENGTH AT ASSEMBLY.
- △ ALL CRIMP DATA SUPPLIED BY MOLEX INCORPORATED.

**\* 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.



REV	DATE	BY	CHK	DESCRIPTION	ITEM NO				
-	-	-	-	-	84				
-	-	-	-	-	83				
-	-	-	-	-	82				
-	-	-	-	-	81				
-	-	-	-	-	80				
-	-	-	-	-	79				
-	-	-	-	-	78				
-	-	-	-	-	77				
-	-	-	-	-	76				
-	-	-	-	-	75				
-	-	-	-	-	74				
-77	-76	-72	-71	-6	-2	-1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm (IN)	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.015 2 PLC ±.02 3 PLC ±.025 4 PLC ±.03 ANGLES ±.05	APVD: M. LLEFFORD PRODUCT SPEC: APPLICATION SPEC: See Table WEIGHT: CUSTOMER DRAWING	Tyco Electronics Harrisburg, PA 17105-3688 <b>FINE ADJUST SIDE FEED HDI APPLICATOR</b> SIZE: A1 CASE CODE: 00779 DRAWING NO: 1528739 SCALE: 3:5 SHEET 1 OF 1 REV B
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