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LOC

DIST

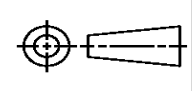
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	G1	ECR-13-017849	29NOV13	RS	LZ

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2151170-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1528054
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
1528054

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN R.SHEN		 TE Connectivity			
DIMENSIONS:		CHK LJ.ZHANG					
		APVD U.GUO		NAME			
		PRODUCT SPEC		FINE ADJ SIDE FD HD-I APPL			
		APPLICATION SPEC					
MATERIAL		WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A 3		©- 1528054	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE	SHEET 1 OF 2	REV G1	

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1528054-1	G	-	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528054-2	G	-	BENCH	MECH PRE FEED	CUTS CARRIER
1528054-6	G	-	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528054-1	G	-	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528054-2	G	-	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528054-6	G	-	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528054-7	A	-	-	-	SPARE PARTS KIT

CRIMP DATA (AMP TERMINAL)				
TERMINAL NAME: MICRO TIMER CONTACT FOR SINGLE WIRE SEALING.				
CRIMP	SIZE	TYPE	RANGE	
WIRE	2.03 [.080 IN]	F	0.5mm ² - 1.0mm ²	
INSUL	3.30 [.130 IN]	0	1.4-2.1 [.055-.082 IN]	
WIRE STRIP LENGTH		APPL INSTRUCTION		
3.5-4.1 [.138-.161 IN]		408-8322 & 408-8490		

TERMINAL	114-18082 (A)	-	FEED
APPL SPEC	114-18081 (B)	-	11.0 [.433 IN]

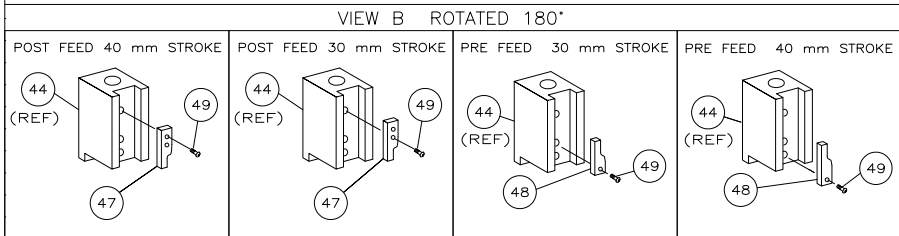
TERMINALS APPLIED

TERMINAL	SEAL	-	-	-
962876 (B)	964972	-	-	-
962965 (A)	963530	-	-	-
963904 (A)	964971	-	-	-
968015 (B)	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-

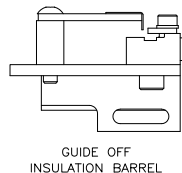
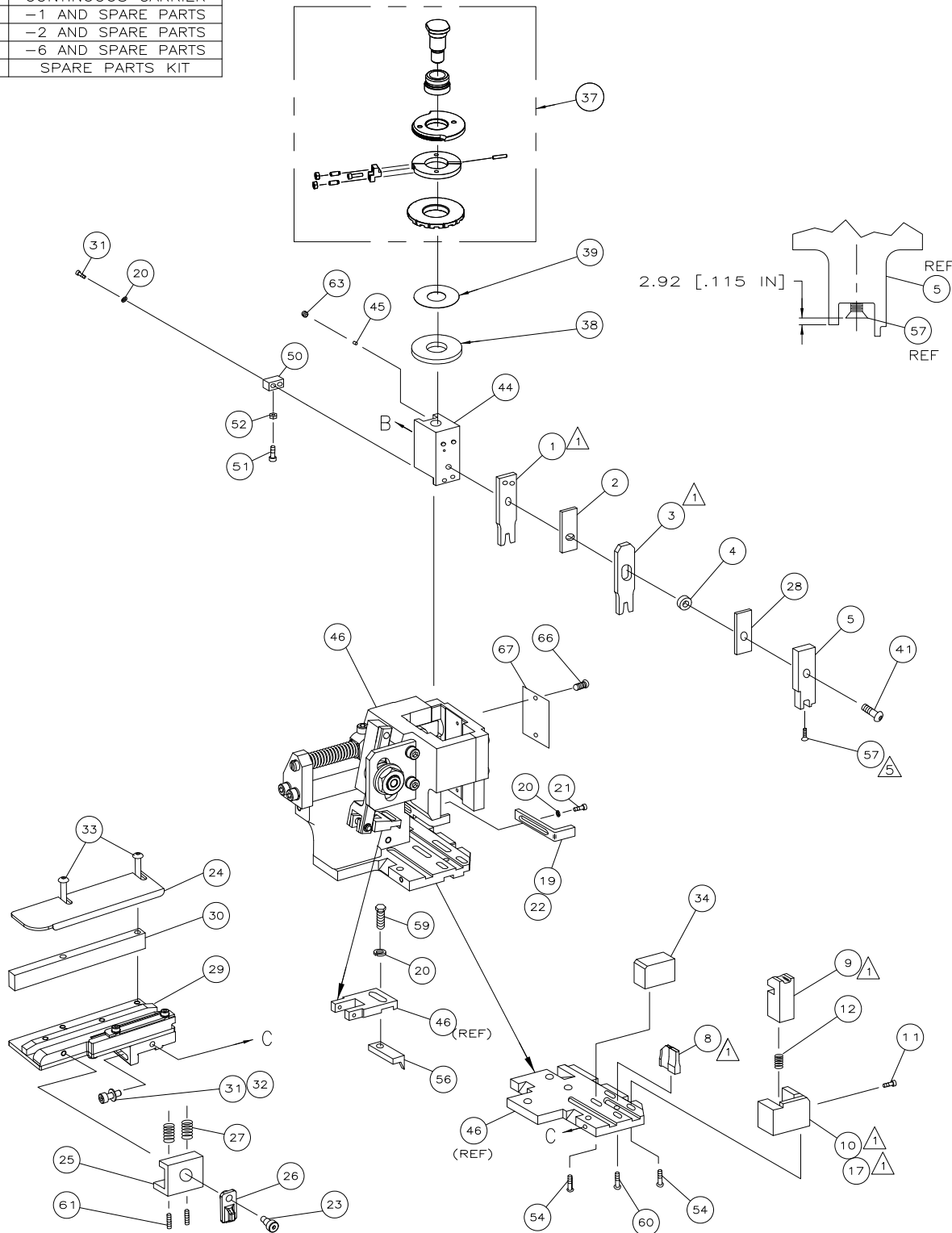
WIRE SIZE mm ² AWG	CRIMP HEIGHT *	REF SETTING *
1.00mm ²	1.36 ±0.05 [.054 ±0.002 IN]	B6
0.75mm ²	1.27 ±0.05 [.050 ±0.002 IN]	C3
0.50mm ²	1.18 ±0.05 [.046 ±0.002 IN]	D0
0.85mm ²	1.31 ±0.05 [.052 ±0.002 IN]	C4
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

SET UP GAGE	LAYOUT
458637-3	L1426017

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.
SEAL PT.NO. 963530 INS. RANGE 1.4 - 1.9 DIA
SEAL PT.NO. 964972 INS. RANGE 1.9 - 2.1 DIA
SEAL PT.NO. 964971 INS. RANGE 1.2-1.6 DIA (0.5SQMM WIRE).
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 REQ'D CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



REVISIONS									
LOC	DIST	P	LTR	DESCRIPTION	DATE	OWN	APVD	DATE	OWN
A	66	G		ECR-08-017492	7-2008	MY	GB		

-	1	1	1	1	1	1	1528054	PRINT, APPLICATOR LOG SHEET	73
-	1	1	1	1	1	1	1338705-3	DOCUMENTATION PACKAGE	71
-									70
-									69
-	1	1	1	1	1	1	461264-5	PLATE, IDENTIFICATION	68
-	2	2	2	2	2	2	21017-2	SCR,DRIVE(#2x.19)ID PLATE	67
-									65
-									64
-	1	1	1	1	1	1	3-18031-0	SCR,SKT SET(M6X6 LW)RAM	63
-									62
-	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
-									58
-	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	18030-1	NUT,HEX(M3)HOLD DOWN	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLDDOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	1	1	1	1	1	18024-3	SCR,BHC(M3X10)CAM	49
-	-	1	-	-	1	-	1338675-1	CAM, PRE FEED 30 & 40 mm ST	48
-	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	39
-	1	1	1	1	1	1	469367-8	SPACER, FINE ADJUST	38
-	1	1	1	1	1	1	879103-2	FINE ADJUST HEAD SUBASSY	37
-									36
-									35
-	1	1	1	1	1	1	1-1320934-3	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	1320908-8	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	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)	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	318707-2	SHEAR, FLOAT (FRONT)	9
1	2	2	2	1	1	1	1333204-5	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	6-456135-2	CRIMPER, INSULATION	3
-	1	1	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
1	2	2	2	1	1	1	1-456405-5	CRIMPER, WIRE	1
-77	-76	-72	-71	-6	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.									
TOLERANCES UNLESS OTHERWISE SPECIFIED:									
DIMENSIONS: INCHES									
0 PLC ± .010									
1 PLC ± .005									
2 PLC ± .003									
3 PLC ± .002									
4 PLC ± .001									
MATERIAL: -									
FINISH: -									
WEIGHT: -									
CUSTOMER DRAWING									
OWN: M. CLIFFORD									
CHK: -									
APVD: P. BACKHURST									
PRODUCT SPEC: -									
APPLICATION SPEC: -									
SIZE: A1									
GAGE CODE: 00779									
DRAWING NO: 1528054									
RESTRICTED TO: -									
SCALE: -									
SHEET: 1 OF 1									
REV: G									