

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

RELEASED FOR PUBLICATION

© COPYRIGHT

ALL RIGHTS RESERVED.

LOC

DIST

REVISIONS

| P | LTR | DESCRIPTION | DATE | DWN | APVD |
|---|-----|-------------|------|-----|------|
|   |     |             |      |     |      |
|   |     |             |      |     |      |
|   |     |             |      |     |      |
|   |     |             |      |     |      |

D

C

B

A

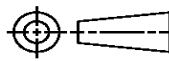
REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER

FOR REPLACEMENT PARTS FOR APPLICATOR 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

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS:



TOLERANCES UNLESS OTHERWISE SPECIFIED:

|        |   |
|--------|---|
| 0 PLC  | ± |
| 1 PLC  | ± |
| 2 PLC  | ± |
| 3 PLC  | ± |
| 4 PLC  | ± |
| ANGLES | ± |

MATERIAL

FINISH

DWN

CHK

APVD

PRODUCT SPEC

APPLICATION SPEC

WEIGHT

TE Connectivity

NAME

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

A3

C-

SCALE

SHEET OF

REV

1470-19 (3/11)

Pro/ENGINEER DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT.

LAYOUT  
L1528213

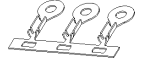
SET UP GAGE  
458637-3

BY AMP INCORPORATED. ALL RIGHTS RESERVED.  
THIS DRAWING IS UNPUBLISHED.  
© COPYRIGHT 2002

LOC  
A  
DIST  
66

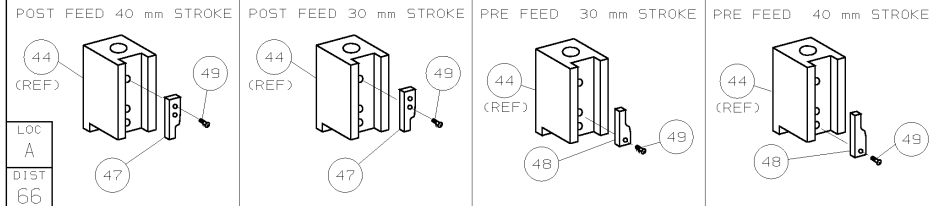
DRAWING MADE IN THIRD ANGLE PROJECTION

| PART NUMBER | REV | FIRST USED | TERMINATOR | FEED TYPE      | DESCRIPTION        |
|-------------|-----|------------|------------|----------------|--------------------|
| 1528213-1   | A   | -          | LEADMAKER  | MECH POST FEED | CUTS CARRIER       |
| 1528213-2   | A   | -          | BENCH      | MECH PRE FEED  | CUTS CARRIER       |
| 1528213-6   | A   | -          | LEADMAKER  | MECH POST FEED | CONTINUOUS CARRIER |
| 7-1528213-1 | A   | -          | LEADMAKER  | MECH POST FEED | -1 AND SPARE PARTS |
| 7-1528213-2 | A   | -          | BENCH      | MECH PRE FEED  | -2 AND SPARE PARTS |
| 7-1528213-6 | A   | -          | LEADMAKER  | MECH POST FEED | -6 AND SPARE PARTS |
| 7-1528213-7 | A   | -          | -          | -              | SPARE PARTS KIT    |

| CRIMP DATA AMP TERMINAL AMP CRIMP SPECS                                                                                             |                                                                                   |                                                                                                                           |                                                                                                  |                         |
|-------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------|-------------------------|
| TERMINAL NAME: 2.5mm SYSTEM, CONTACT SOCKET / PIN  |                                                                                   |                                                                                                                           |                                                                                                  |                         |
| CRIMP                                                                                                                               | SIZE                                                                              | TYPE                                                                                                                      | RANGE                                                                                            |                         |
| WIRE                                                                                                                                | 2.79 [.110 IN]                                                                    | F                                                                                                                         | >1.00-2.50mm <sup>2</sup>                                                                        |                         |
| INSUL                                                                                                                               | 4.32 [.170 IN]                                                                    | 0                                                                                                                         | 3.40 [.134 IN]  |                         |
| WIRE STRIP LENGTH<br>5.20-5.80 [.205-.228 IN]      |                                                                                   | APPL INSTRUCTION<br>408-8322 & 408-8490  |                                                                                                  |                         |
| TERMINAL -                                                                                                                          |                                                                                   | -                                                                                                                         |                 | FEED<br>14.50 [.571 IN] |
| APPL SPEC 114-18031-1                                                                                                               |                                                                                   | -                                                                                                                         |                                                                                                  |                         |
| TERMINALS APPLIED                                  |                                                                                   |                                                                                                                           |                                                                                                  |                         |
| TERMINAL                                                                                                                            | SEAL                                                                              | -                                                                                                                         | -                                                                                                | -                       |
| 928985                                                                                                                              | 828921-1                                                                          | -                                                                                                                         | -                                                                                                | -                       |
| 928987                                                                                                                              | -                                                                                 | -                                                                                                                         | -                                                                                                | -                       |
| 965856                                                                                                                              | -                                                                                 | -                                                                                                                         | -                                                                                                | -                       |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         | -                                                                                                | -                       |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         | -                                                                                                | -                       |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         | -                                                                                                | -                       |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         | -                                                                                                | -                       |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         | -                                                                                                | -                       |
| WIRE SIZE                                                                                                                           | CRIMP HEIGHT                                                                      | REF SETTING                              |                                                                                                  |                         |
| mm <sup>2</sup> AWG                                |  |                                          |                                                                                                  |                         |
| 2.50mm <sup>2</sup>                                                                                                                 | 1.81 ±0.05 [.071 ±.002 IN]                                                        | C 2                                                                                                                       |                                                                                                  |                         |
| 2.00mm <sup>2</sup>                                                                                                                 | 1.71 ±0.05 [.067 ±.002 IN]                                                        | C 7                                                                                                                       |                                                                                                  |                         |
| 1.50mm <sup>2</sup>                                                                                                                 | 1.57 ±0.05 [.062 ±.002 IN]                                                        | D 7                                                                                                                       |                                                                                                  |                         |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         |                                                                                                  |                         |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         |                                                                                                  |                         |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         |                                                                                                  |                         |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         |                                                                                                  |                         |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         |                                                                                                  |                         |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         |                                                                                                  |                         |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         |                                                                                                  |                         |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         |                                                                                                  |                         |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         |                                                                                                  |                         |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         |                                                                                                  |                         |
| -                                                                                                                                   | -                                                                                 | -                                                                                                                         |                                                                                                  |                         |

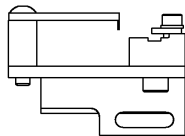
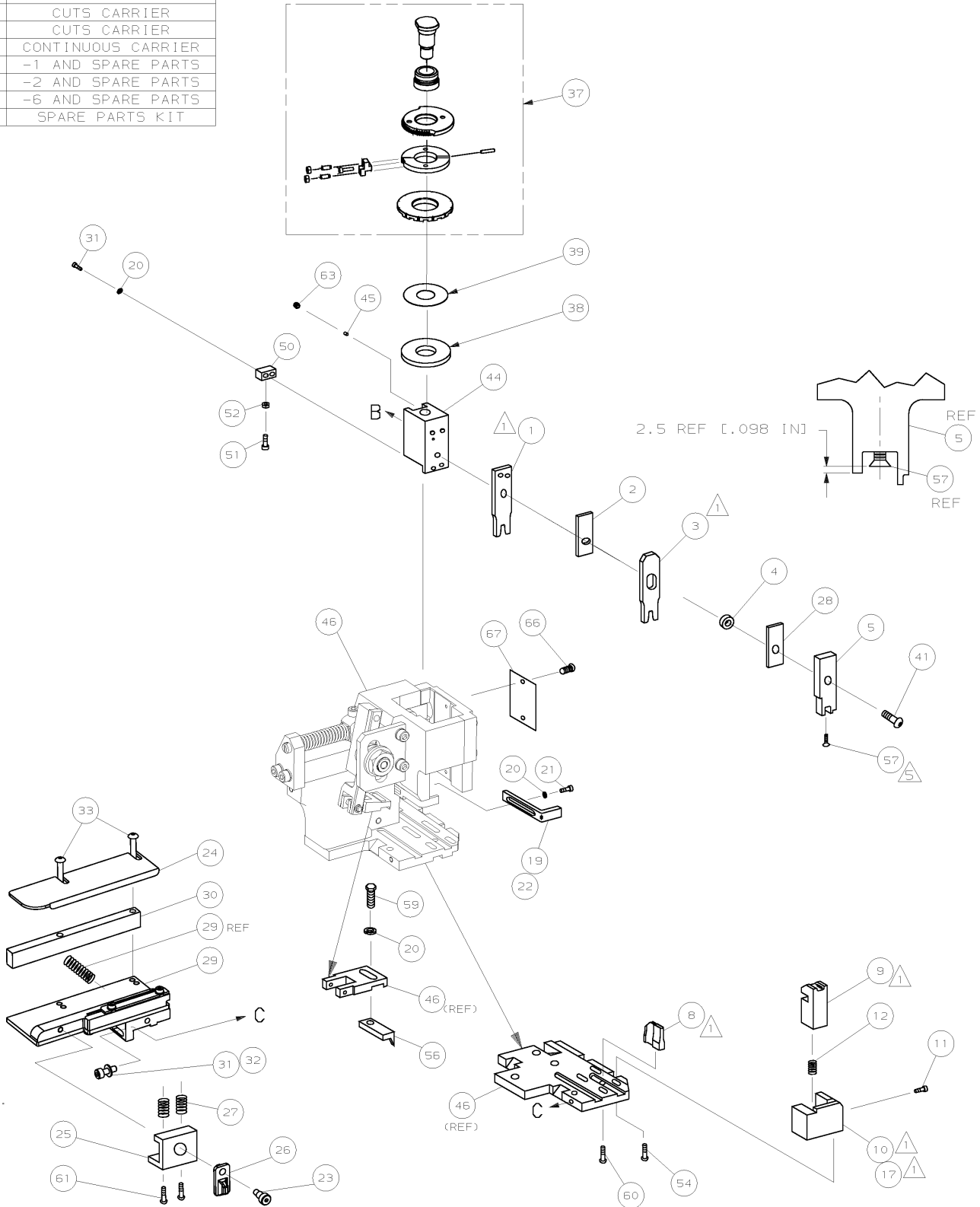
-  1. RECOMMENDED SPARE PARTS.
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  4. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION Ø QUOTED IS OUTER Ø OF SEAL & THE INSULATION DIAMETER IS DEPENDENT UPON SEAL BEING APPLIED.
-  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.

VIEW B ROTATED 180°



\* 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.



|   |   |   |   |   |   |   |             |                                 |    |
|---|---|---|---|---|---|---|-------------|---------------------------------|----|
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1528213     | PRINT, APPLICATOR LOG SHEET     | 73 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1338705-3   | DOCUMENTATION PACKAGE           | 71 |
| - | - | - | - | - | - | - | -           | -                               | 70 |
| - | - | - | - | - | - | - | -           | -                               | 69 |
| - | - | - | - | - | - | - | -           | -                               | 68 |
| - | 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 |
| - | - | - | - | - | - | - | -           | -                               | 65 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 3-18031-0   | SCR,SKT SET (M6X6) RAM          | 64 |
| - | - | - | - | - | - | - | -           | -                               | 63 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 1-18024-5   | SCR,BHC (M5X25) 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 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 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 |
| - | - | - | - | - | - | - | -           | -                               | 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 | 469367-4    | SPACER, FINE ADJUST             | 38 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 879103-2    | FINE ADJUST HEAD SUBASSY        | 37 |
| - | - | - | - | - | - | - | -           | -                               | 36 |
| - | - | - | - | - | - | - | -           | -                               | 35 |
| - | - | - | - | - | - | - | -           | -                               | 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 | 1320908-6   | SPACER, STRIP GUIDE             | 30 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1633073-1   | STRIP GUIDE PLATE ASSY          | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-455888-5  | 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 | - | 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 |
| - | - | - | - | - | - | - | -           | -                               | 18 |
| - | 1 | - | - | 1 | - | - | 1338684-2   | HOLDER, SHEAR, FRONT (NO-CUT)   | 17 |
| - | - | - | - | - | - | - | -           | -                               | 16 |
| - | - | - | - | - | - | - | -           | -                               | 15 |
| - | - | - | - | - | - | - | -           | -                               | 14 |
| - | - | - | - | - | - | - | -           | -                               | 13 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 5-22280-0   | 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 | 318707-1    | SHEAR, FLOAT (FRONT)            | 9  |
| - | 1 | 2 | 2 | 2 | 1 | 1 | 3-1333207-4 | ANVIL                           | 8  |
| - | - | - | - | - | - | - | -           | -                               | 7  |
| - | - | - | - | - | - | - | -           | -                               | 6  |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1338680-5   | DEPRESSOR, SHEAR (FRONT)        | 5  |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 238011-2    | SPACER, BLOCK CRIMPER           | 4  |
| - | 1 | 2 | 2 | 2 | 1 | 1 | 904741-3    | CRIMPER, INSULATION             | 3  |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 455888-9    | SPACER, CRIMPER                 | 2  |
| - | 1 | 2 | 2 | 2 | 1 | 1 | 3-456408-9  | 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 | -  | HT TR                                                     | -        | FIN                        | -            |                                                             |                 |
| DO NOT SCALE PRINT.                    |       |                                           |     |    |      |    |                                                           |          |                            |              |                                                             |                 |
| TOLERANCES UNLESS OTHERWISE SPECIFIED: |       |                                           |     |    |      |    |                                                           |          |                            |              |                                                             |                 |
| 1 PLC DEC ±                            |       |                                           |     |    |      |    | DR                                                        | 16JUL03  | APP                        | 16JUL03      | <b>AMP</b><br>AMP Incorporated<br>Harrisburg, PA 17105-3608 |                 |
| 2 PLC DEC ±                            |       |                                           |     |    |      |    | M                                                         | CLIFFORD |                            | F. BACKHURST |                                                             |                 |
| 3 PLC DEC ±                            |       |                                           |     |    |      |    | CHK                                                       | -        | REL                        | 31MAR04      |                                                             |                 |
| ANGLES ±                               |       |                                           |     |    |      |    | NAME                                                      |          | FINE ADJ SIDE FD HD-I APPL |              |                                                             | MACHINE REF     |
| SURF TEXTURE: ✓                        |       |                                           |     |    |      |    | SCALE                                                     |          | - [D] DWG NO 1528213       |              |                                                             | HD-I APPL       |
| LJL                                    | MAR04 | REMOVE BURRS, BREAK SHARP EDGES RO.3B MAX |     |    |      |    |                                                           |          |                            |              |                                                             | SHEET 1 of 1    |
| APP                                    | DATE  |                                           |     |    |      |    |                                                           |          |                            |              |                                                             | REV A           |
| CASE CODE 00779                        |       |                                           |     |    |      |    | CUSTOMER AND ASSEMBLY DRAWING                             |          |                            |              |                                                             | RESTRICTED TO - |

CUSTOMER AND ASSEMBLY DRAWING