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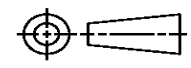
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LOC		DIST		REVISIONS			
P	LTR	DESCRIPTION		DATE	DWN	APVD	
	A1	ECR-16-001574		19FEB2016	RS	UG	

# REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2266139-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1528931  
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  
1528931

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN R.SHEN	 <b>TE Connectivity</b>		
DIMENSIONS:		CHK LJ.ZHANG			
		APVD U.GUO	NAME FINE ADJUST SIDE FEED HDI APPLICATOR		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	APPLICATION SPEC		
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		WEIGHT	SIZE A3	CAGE CODE	DRAWING NO C-1528931
MATERIAL		CUSTOMER DRAWING		SCALE	SHEET 1 OF 2
FINISH				REV A1	RESTRICTED TO

PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1528931-1	A	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528931-2	A	BENCH	MECH PRE FEED	CUTS CARRIER
1528931-6	A	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528931-1	A	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528931-2	A	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528931-6	A	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528931-7	A	-	-	SPARE PARTS KIT

CRIMP	SIZE	TYPE	RANGE
WIRE	1.40 [0.055 IN]	F	26-22 AWG
INSUL	1.78 [0.070 IN]	F	1.20-1.75 [0.047-.069 IN]

WIRE STRIP LENGTH	APPL INSTRUCTIONS
3.00-3.50 [0.118-.138 IN]	408-8322 & 408-8490

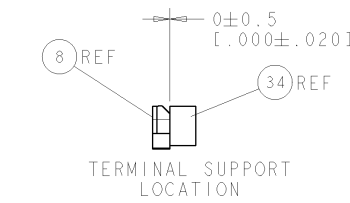
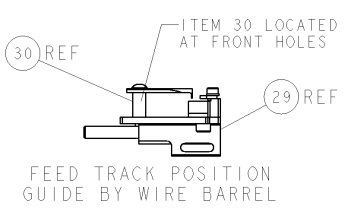
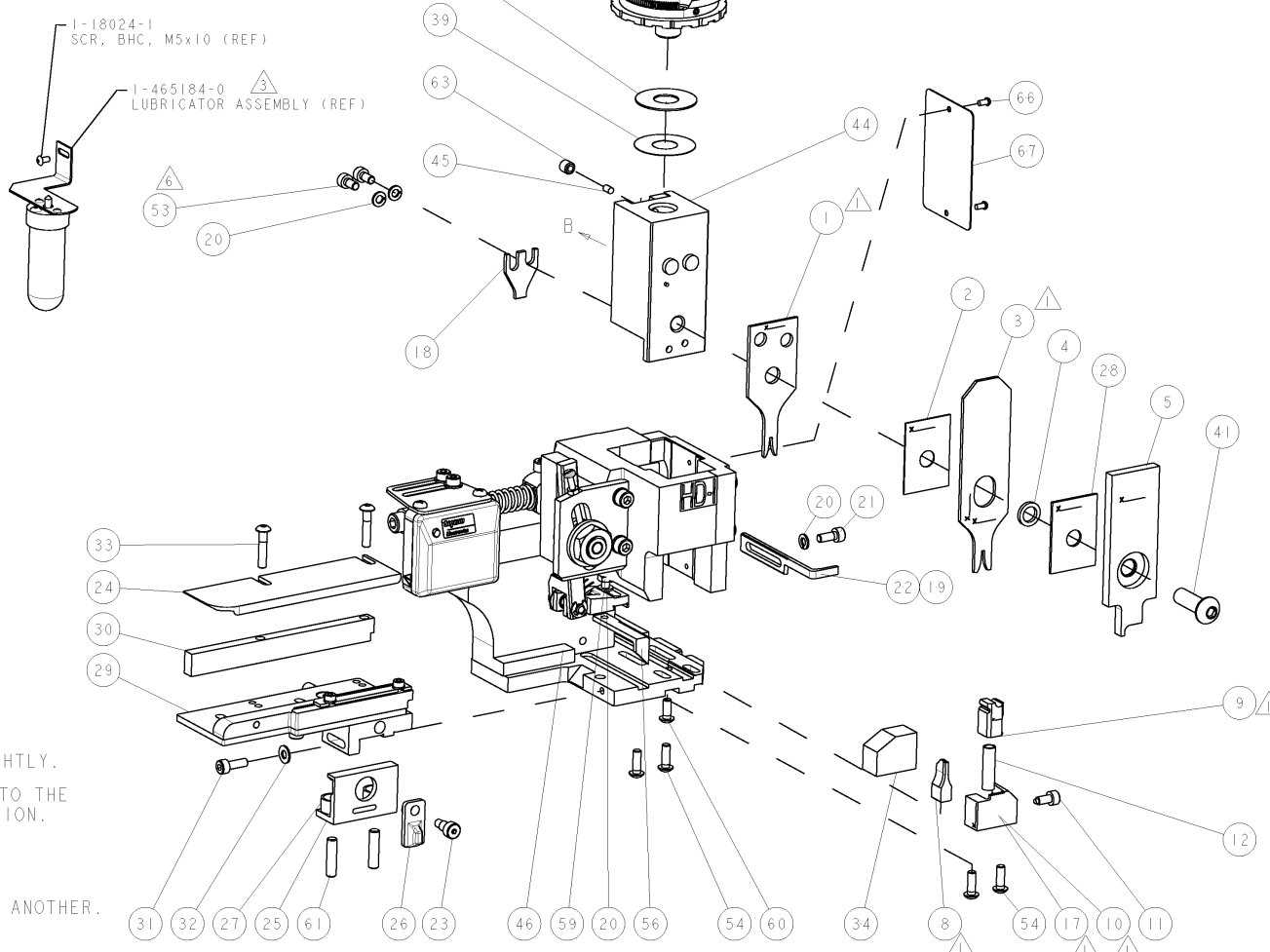
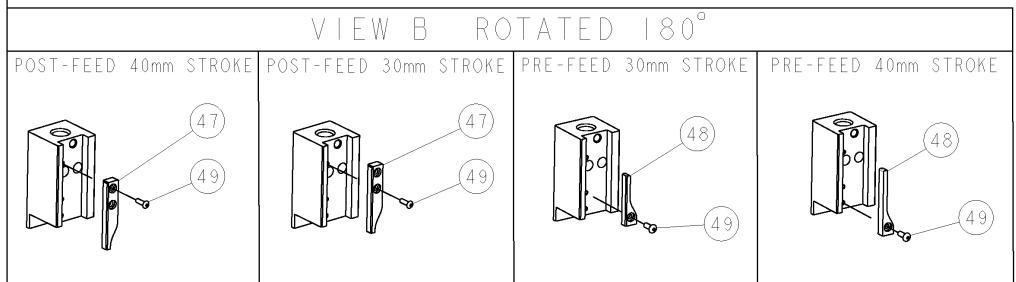
TERMINAL	FEED
114-13172	8.60 [0.339 IN]

WIRE SIZE	CRIMP HEIGHT	REF SETTING
22 AWG	0.89 ± 0.05 [0.035 ± 0.002 IN]	B 7
24 AWG	0.84 ± 0.05 [0.033 ± 0.002 IN]	C 1
26 AWG	0.76 ± 0.05 [0.030 ± 0.002 IN]	C 6

- △ 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.
- △ ADJUST FEED WHEN CHANGING FROM ONE TERMINAL TO ANOTHER.
- △ CUT TO LENGTH AT ASSEMBLY.

**\* 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

REVISONS		DATE	DWN	APPD
1	A	14OCT2008	LJL	MC

ITEM NO	DESCRIPTION	DATE	DWN	APPD
73				
72				
71	DOCUMENTATION PACKAGE			
70				
69				
68				
67	PLATE, IDENTIFICATION			
66	SCREW, DRIVE			
65				
64				
63	SCR, SET, CUP POINT M6 X 6.0			
62				
61	SCR, SET, FLT POINT M5 X 20.0			
60	SCR, BTN SKT HD CAP (M4 X 10.0)			
59	SCR, HEX HD CAP M4 X 8.0			
58				
57				
56	PAWL, FEED			
55				
54	SCR, BTN SKT HD CAP (M4 X 12.0)			
53	SCR, SKT HD CAP M4 X 8.0			
52				
51				
50				
49	SCR, BTN SKT HD CAP (M3 X 10.0)			
48	CAM, UNIVERSAL PRE FEED			
47	CAM, UNIVERSAL POST-FEED			
46	APPLICATOR SUBASSEMBLY, HDI			
45	PLUG, NYLON			
44	RAM			
43				
42				
41	SCR, BTN SKT HD CAP (M8 X 25.0)			
40				
39	SHIM SUB-ASSY			
38	SHIM			
37	FINE ADJUST HEAD ASSEMBLY			
36				
35				
34	SUPPORT, TERMINAL			
33	SCR, BTN SKT HD CAP (M4 X 20.0)			
32	WASHER, FLAT, REG M4			
31	SCR, SKT HD CAP M4 X 12.0			
30	SPACER, STRIP GUIDE			
29	STRIP GUIDE ASSEMBLY			
28	SPACER, CRIMPER			
27	SPRING, COMPRESSION			
26	LEVER, DRAG RELEASE			
25	DRAG, TERMINAL			
24	PLATE, STRIP GUIDE			
23	SCR, SKT HD SHLDR 5.0 DIA X 6.0			
22	STRIPPER			
21	SCR, SKT HD CAP M4 X 10.0			
20	WASHER, SPRG LOCK, REG M4			
19	STRIPPER			
18	HOLD DOWN, TERMINAL			
17	SHEAR HOLDER, FRONT			
16				
15				
14				
13				
12	SPRING, COMPRESSION			
11	STOP, SHEAR			
10	SHEAR HOLDER, FRONT, CUT			
9	FLOATING SHEAR, FRONT			
8	ANVIL, COMBINATION .055			
7				
6				
5	DEPRESSOR, SHEAR			
4	BLOCK, CRIMPER SPACER			
3	CRIMPER, INSULATION PREMIUM			
2	SPACER, CRIMPER			
1	CRIMPER, WIRE PREMIUM			

ITEM NO	DESCRIPTION	ITEM NO
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16OCT2008 LOTHOUSE Tyco Electronics  
Harrisburg, PA 17105-3608

APPR: MCLIFFORD NAME: FINE ADJUST SIDE FEED HDI APPLICATOR

PRODUCT SPEC: See Table

APPLICATION SPEC: See Table

SIZE: A1 CASE CODE: 00779 DRAWING NO: 1528931 RESTRICTED TO: A

CUSTOMER DRAWING SCALE: 3:5 SHEET 1 OF 1 REV A