

4

3

2

1


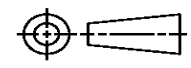
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION
© COPYRIGHT ALL RIGHTS RESERVED.

LOC	DIST	REVISIONS			
P	LTR	DESCRIPTION	DATE	DWN	APVD
	B3	ECR-15-007000	06MAY2015	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2150532-2

FOR REPLACEMENT PARTS FOR APPLICATOR 1385446
REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED)
WILL REMAIN AVAILABLE.

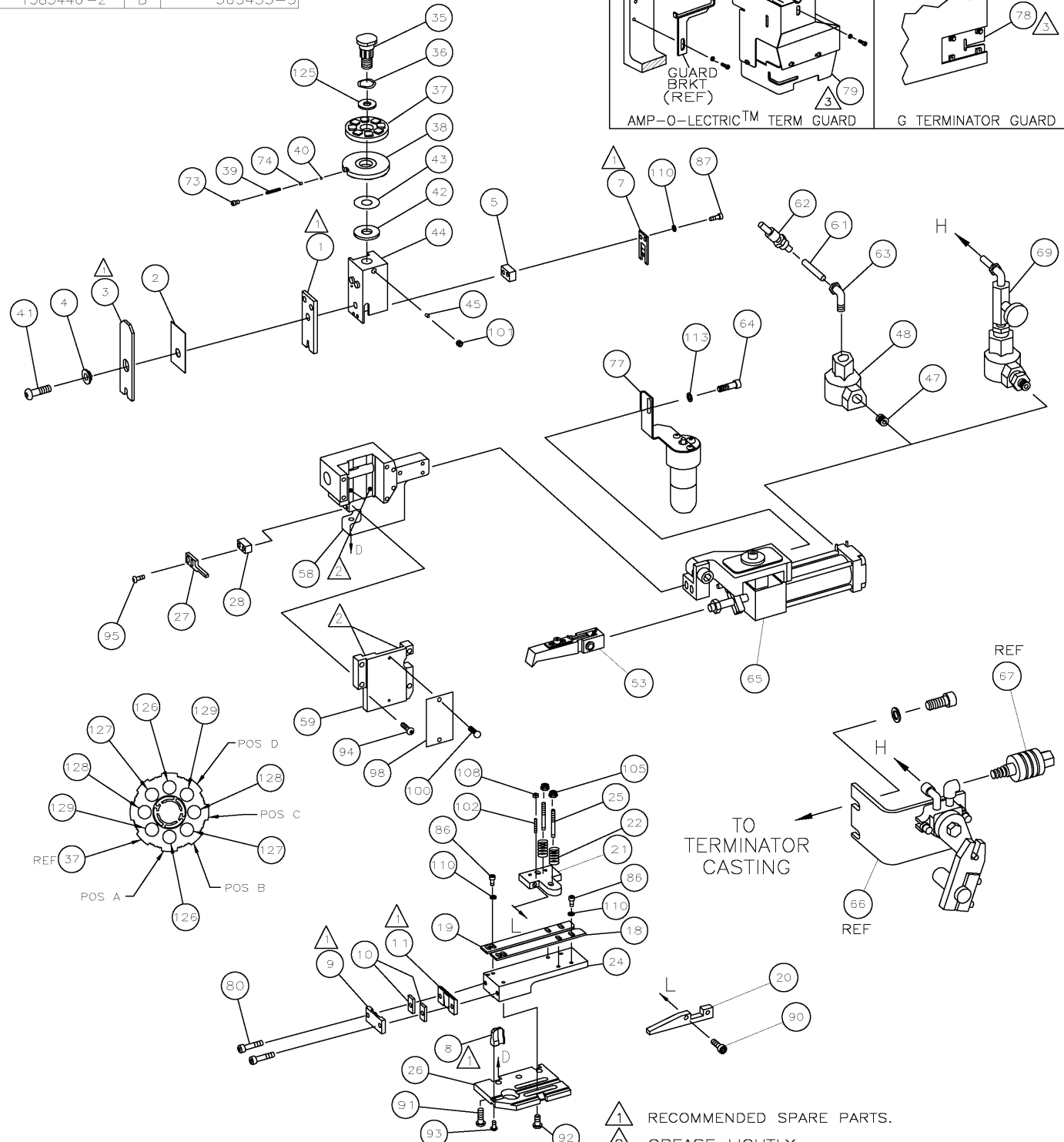
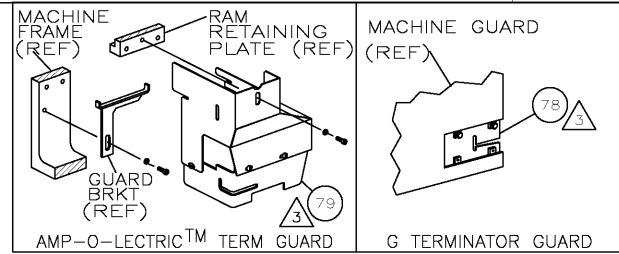
THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE
SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR
1385446

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV			TE Connectivity	
DIMENSIONS:		CHK	RAGHAVENDRA			NAME	
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	RAGHAVENDRA		
		0 PLC ±	1 PLC ±	PRODUCT SPEC			
MATERIAL		2 PLC ±	3 PLC ±	APPLICATION SPEC			
FINISH		4 PLC ±	ANGLES ±	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A3		©- 1385446	
				CUSTOMER DRAWING		SCALE	SHEET 1 OF 2 REV B3

DRAWING MADE IN THIRD ANGLE PROJECTION

1385446 1385446

PART NUMBER	REV	FIRST USED
1385446-1	A	122500-1
1385446-2	B	565435-5



- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 4 SEE DRAWING FOR COMPONENTS
- 5 ITEM 78 USED WITH G TERMINATOR ONLY.
- 6. FEED OFF INSULATION BARREL.
- 7 INSULATION CRIMP HEIGHT MUST BE:
 $1.0\text{mm}^2 = 2.60\text{mm}$
 $0.75\text{mm}^2 = 2.55\text{mm}$
 $0.5\text{mm}^2 = 2.45\text{mm}$
 $0.35\text{mm}^2 = 2.40\text{mm}$

TERMINAL NAME: FLAG			
1544113			
PAD LTR	AMP TERMINAL		AMP CRIMP SPECS
	CRIMP HEIGHT	WIRE SIZE	
A	.064 ±0.002 [1.62 ±0.05mm]	1mm ²	
B	.061 ±0.002 [1.55 ±0.05mm]	.75mm ² or 18AWG	
C	.058 ±0.002 [1.47 ±0.05mm]	.5mm ²	
D	.055 ±0.002 [1.40 ±0.05mm]	.35mm ²	
CRIMP	SIZE	TYPE	RANGE
WIRE	.094 [2.40mm]	F	.35mm ² - 1mm ²
INSUL	.118 [3.0mm]	F	1.3mm - 2mm
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION
.236 - .252	NONE	.728	408-8039
SET UP GAGE LAYOUT	L2687	458638-1	

QTY	RECD	PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
2	2	-	C		2-354779-7	PIN, WIRE DISC (.3125)D	129
2	2	-	C		1-354779-8	PIN, WIRE DISC (.3080)C	128
2	2	-	C		1-354779-2	PIN, WIRE DISC (.3050)B	127
2	2	-	C		354779-8	PIN, WIRE DISC (.3030)A	126
1	1	-	A		986950-1	WASHER, FLAT PRECISION	125
1	1	-	A		217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	-	-		4088039	EF APPL INST 408-8039	123
							122
							121
							120
							119
							118
							117
							116
							115
							114
2	2	-	A		21024-5	WASHER, LOCK (#10) AIR ASSY	113
							112
							111
4	4	-	A		21024-4	WASHER, LOCK (NO.8) SHEAR BL	110
							109
2	2	-	A		21018-4	NUT, HEX (4-40) DRAG	108
							107
							106
2	2	-	A		21022-2	NUT, HEX SL (8-32) DRAG STUD	105
							104
							103
2	2	-	A		2-21006-6	SCR, SKT SET (4-40x.62) DRAG	102
1	1	-	A		21009-2	SCR, SKT SET (1/4-20x.25) RAM	101
2	2	-	A		21017-2	SCR, DRIVE (#2x.19) ID PLATE	100
							99
1	1	-	B		461264-1	PLATE, IDENTIFICATION	98
							97
							96
2	2	-	A		2-21002-2	SCR, BHC (8-32x.50) STRIPPER	95
4	4	-	A		2-21002-9	SCR, BHC (10-32x.75) CAP	94
1	1	-	A		22733-8	SCR, BHC (8-32x.38 LW) ANVIL	93
4	4	-	A		3-21002-3	SCR, BHC (1/4-20x.50) ST GD PL	92
3	3	-	A		2-22733-8	SCR, BHC (1/4-20x.62) HSG	91
2	2	-	A		1-21000-3	SCR, SHC (4-40x.25) DRAG	90
							89
							88
2	2	-	A		2-21000-6	SCR, SHC (8-32x.38) SLUG BLADE	87
4	4	-	A		2-21000-6	SCR, SHC (8-32x.38) STRIP GUIDE	86
							85
							84
							83
							82
							81
2	2	-	A		3-21002-0	SCR, BHC (10-32x.88) SHEAR PL	80
1	-	-	A		455750-8	GUARD ASSY	79
-	REF	-	A		679532-1	INSERT, GUARD	78
1	-	-	C		465184-9	LUBRICATOR ASSY	77
							76
							75
1	1	-	A		690603-1	SPRING, ASSIST	74
1	1	-	A		23030-1	SCR, SKT CAP (6-32x.25) CP DSC	73
							72
							71

QTY	RECD	PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-2	-1		U/M				

QTY		RECD		PER ASSY		U/M		DWG SIZE		PART NO		DESCRIPTION		ITEM NO	

LEADMAKER & BENCH MODEL G				AIR FEED		
BENCH MODEL K				AIR FEED		
1	-	-	C	692655-5	AIR FEED VALVE ASSY	69
						68
REF	-	-	A	24042-2	VALVE, SHUT OFF	67
REF	-	-	C	692655-6	AIR FEED VALVE ASSY	66
1	1	-	B	460277-1	AIR FEED ASSY (1 INCH)	65
2	2	-	A	3-21000-9	SCR, SHC (10-32x1.00) AIR ASSY	64
-	1	-	A	980285-2	ELBOW, SWIVEL 1/8 NPT - 1/4 T	63
-	1	-	A	23238-1	QUICK DISCONNECT	62
-	12.00	IN	A	27319-4	TUBING, POLY-FLO Ø.25	61
						60
1	1	-	C	454220-1	CAP, RAM	59
1	1	-	D	453736-1	HOUSING	58
						57
						56
						55
						54
1	1	-	B	2-460680-3	FEED FINGER ASSY	53
						52
						51
						50
						49
1	-	-	D	22374-7	VALVE, QUICK EXHAUST	48
1	-	-	D	22304-1	NIPPLE, HEX 1/8 NPT	47
						46
1	1	-	A	690191-1	PLUG, NYLON	45
1	1	-	C	455674-2	RAM	44
1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	-	A	690124-1	WASHER, RAM	42
1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16-24x1.00)	41
1	1	-	A	23241-6	BALL, STEEL	40
1	1	-	A	690170-1	SPRING, COMPRESSION	39
1	1	-	C	690142-3	DISC, INSULATION	38
1	1	-	D	354777-1	WIRE DISC, PLASTIC	37
1	1	-	A	22480-5	WASHER, SPRING	36
1	1	-	B	690212-1	POST, RAM	35
						34
						33
						32
						31
						30
						29
1	1	-	B	3-690451-7	SPACER, STRIPPER	28
1	1	-	A	240639-4	STRIPPER	27
1	1	-	D	455676-1	PLATE, BASE	26
2	2	-	A	22354-8	DRAG, STUD	25
1	1	-	B	856076-1	PLATE, STRIP GUIDE	24
						23
2	2	-	A	3-22281-5	SPRING, DRAG	22
1	1	-	A	464451-5	ARM, STOCK DRAG	21
1	1	-	A	464452-4	DRAG, STOCK	20
1	1	-	B	1338002-1	GUIDE, STRIP (REAR)	19
1	1	-	C	1338003-4	GUIDE, STRIP (FRONT)	18
						17
						16
						15
						14
						13
						12
1	1	-	B	240644-1	PLATE, REAR SHEAR	11
2	2	-	C	6-240645-0	SPACER, SHEAR PLATE	10
1	1	-	B	1-240642-1	PLATE, FRONT SHEAR	9
1	1	-	D	9-461295-2	ANVIL	8
1	1	-	B	1633043-1	BLADE, SLUG	7
						6
1	1	-	C	2-240641-1	SPACER, SLUG BLADE	5
1	1	-	B	238009-8	SPACER, BLOCK CRIMPER	4
1	1	-	C	9-683453-9	CRIMPER, INSULATION	3
1	1	-	B	2-455888-7	SPACER, CRIMPER	2
1	1	-	C	9-568176-4	CRIMPER, WIRE	1

QTY	RECD	PER ASSY	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-2	-1		U/M				

QTY		RECD		PER ASSY		U/M		DWG SIZE		PART NO		DESCRIPTION		ITEM NO	

CUSTOMER AND ASSEMBLY DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT

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

LOC A
DIST 66

AMP 1706 REV 3-92