

4

3

2

1


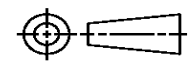
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LOC	DIST	REVISIONS			
P	LTR	DESCRIPTION	DATE	DWN	APVD
	B1	ECR-14-002921	27FEB2014	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2151105-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1528276 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 1528276

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV			TE Connectivity			
DIMENSIONS:		CHK	RAGHAVENDRA			NAME			
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		FINE ADJUST SIDE FEED HDI APPLICATOR					
		0 PLC	±	APVD	RAGHAVENDRA		PRODUCT SPEC		
MATERIAL		1 PLC	±	APPLICATION SPEC		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
FINISH		2 PLC	±	WEIGHT		A3		©- 1528276	
		3 PLC	±	CUSTOMER DRAWING		SCALE	SHEET 1 OF 2	REV B1	
		4 PLC	±						
		ANGLES	±						

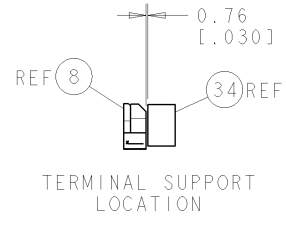
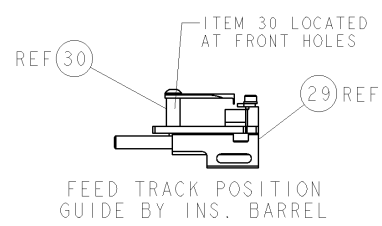
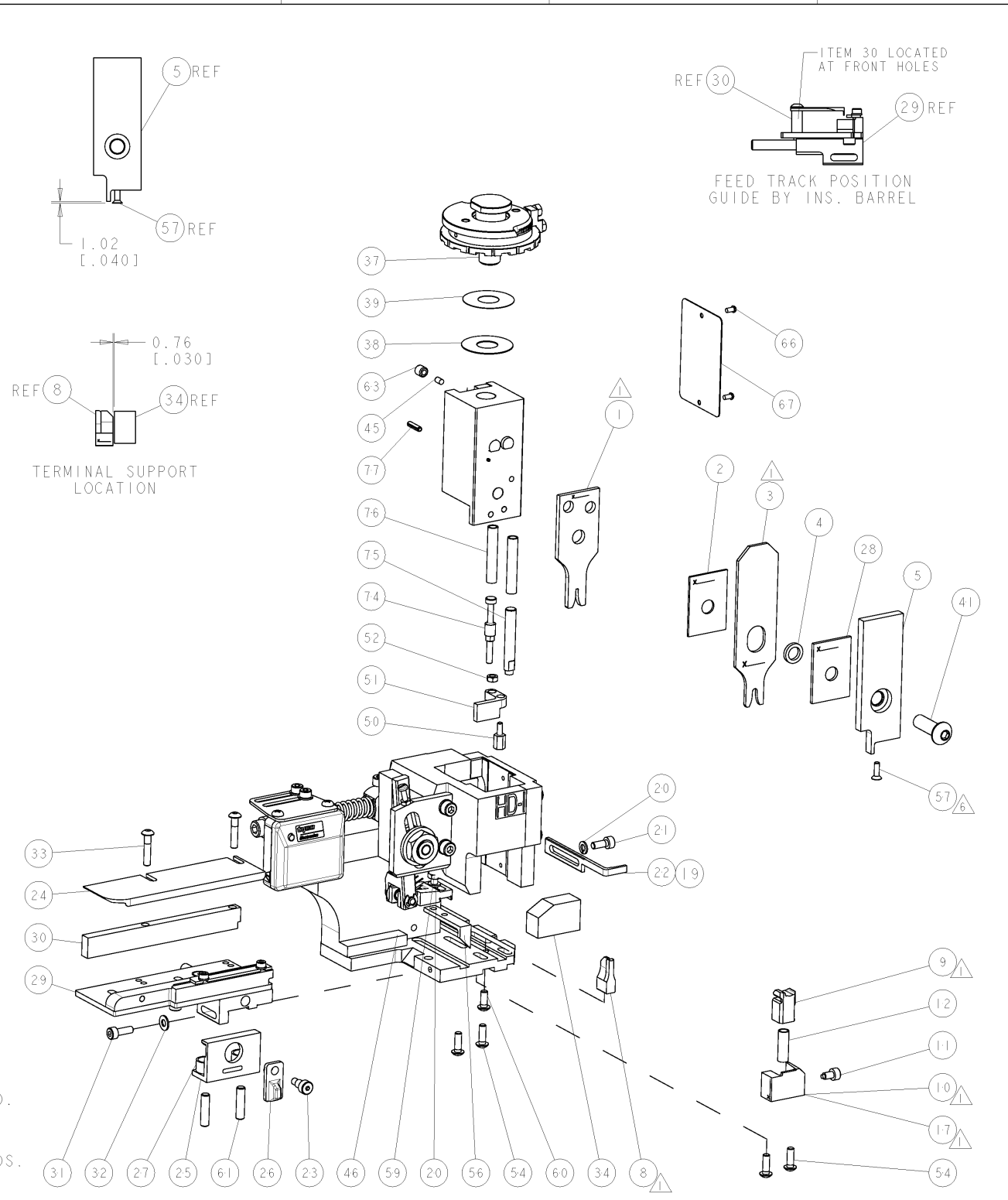
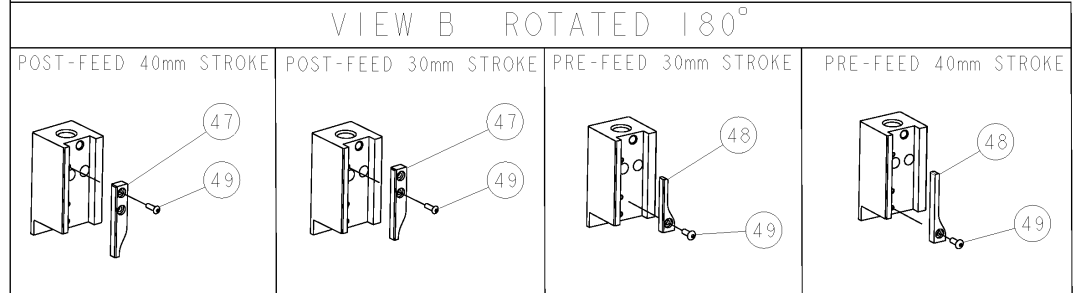
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PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1528276-1	B	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528276-2	B	BENCH	MECH PRE FEED	CUTS CARRIER
1528276-6	B	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528276-1	B	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528276-2	B	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528276-6	B	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528276-7	A	-	-	SPARE PARTS KIT

CRIMP DATA		TYCO TERMINAL		TYCO CRIMP SPEC	
TERMINAL NAME: RECEPTACLE CONTACT .070 TYPE ECONOSEAL					
CRIMP	SIZE	TYPE	RANGE		
WIRE	1.57 [.062 IN]	F	0.20-0.50mm ²		
INSUL	3.40 [.134 IN]	0	1.50-2.20 [.059-.087 IN]		
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]		APPL INSTRUCTIONS 408-8322 & 408-8490			
TERMINAL APPL SPEC 114-5082		FEED 9.80 [.386 IN]			
TERMINALS APPLIED					
TERMINAL	SEAL				
171630	172746				
-	178210				
WIRE SIZE					
CRIMP HEIGHT	REF SETTING				
0.50mmsq or 20AWG	1.09 ± 0.05 [.043 ± .002 IN]	C 0			
0.30mmsq or 22AWG	1.06 ± 0.05 [.042 ± .002 IN]	C 1			
0.20mmsq or 24AWG	1.00 ± 0.05 [.039 ± .002 IN]	C 7			

- RECOMMENDED SPARE PARTS
- GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY
- LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION RANGE IS DEPENDENT ON SEAL BEING APPLIED.
- 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.
- USE TENSILE VALUES IN 114-3118, IF WIRES USED IN PRODUCTION ARE NOT COMPATIBLE TO 114-5082.

*** 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.



QTY	DESCRIPTION	ITEM NO
1	PIN, SLOTTED SPRING 3.0 X 12.0	77
2	SPRING, COMPRESSION	76
1	GUIDE PIN, HOLDDOWN	75
1	GUIDE PIN, HOLDDOWN	74
-77 -76 -72 -71 -6 -2 -1	PART NO	DESCRIPTION

SET UP GAGE 458637-3

REV	DESCRIPTION	DATE	BY	APPV
A	SEE ECO-05-004443	24JUN2005	LJL	FB
B	ECR-11-015093	01AUG2011	L.Z	S.X

QTY	DESCRIPTION	ITEM NO
-	-	73
-	-	72
-	1338705-3	DOCUMENTATION PACKAGE
-	-	70
-	-	69
-	-	68
-	461264-5	PLATE, IDENTIFICATION
-	21017-2	SCREW, DRIVE
-	-	65
-	-	64
-	3-18031-0	SCR, SET, CUP POINT M6 X 6.0
-	-	62
-	2-18032-5	SCR, SET, FLT POINT M5 X 20.0
-	18024-7	SCR, BTN SKT HD CAP (M4 X 10.0)
-	5-18022-2	SCR, HEX HD CAP M4 X 8.0
-	-	58
-	985575-3	SCR, FLT SKT HD CAP M3 X 10.0
-	1338685-1	PAWL, FEED
-	-	55
-	4-18024-8	SCR, BTN SKT HD CAP (M4 X 12.0)
-	-	54
-	-	53
-	1-18030-0	NUT, HEX, REG M3.5
-	1901681-1	HOLDDOWN, TERMINAL
-	1-1752354-8	STANDOFF, HOLD-DOWN
-	18024-3	SCR, BTN SKT HD CAP (M3 X 10.0)
-	1338675-1	CAM, UNIVERSAL PRE FEED
-	1338676-1	CAM, UNIVERSAL POST-FEED
-	1320999-3	APPLICATOR SUBASSEMBLY, HDI
-	690191-1	PLUG, NYLON
-	1633724-1	RAM, (SIDE FEED)
-	-	43
-	-	42
-	2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)
-	-	41
-	690125-1	SHIM SUB-ASSY
-	469367-9	SHIM
-	879103-2	FINE ADJUST HEAD SUBASSY
-	-	37
-	-	36
-	-	35
-	1752356-3	SUPPORT, TERMINAL
-	1-18024-0	SCR, BTN SKT HD CAP (M4 X 20.0)
-	18027-2	WASHER, FLAT, REG M4
-	1-18023-2	SCR, SKT HD CAP M4 X 12.0
-	1320908-8	SPACER, STRIP GUIDE
-	1633073-1	STRIP GUIDE ASSEMBLY
-	1-455888-6	SPACER, CRIMPER
-	1-22284-0	SPRING, COMPRESSION
-	356835-1	LEVER, DRAG RELEASE
-	240792-1	DRAG, TERMINAL
-	1320928-1	PLATE, STRIP GUIDE
-	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0
-	690472-2	STRIPPER
-	1-18023-1	SCR, SKT HD CAP M4 X 10.0
-	18025-2	WASHER, SPRG LOCK, REG M4
-	690472-1	STRIPPER
-	-	19
-	-	18
-	1338684-2	HOLDER, SHEAR, NO-CUT
-	-	17
-	-	16
-	-	15
-	-	14
-	-	13
-	5-22280-0	SPRING, COMPRESSION
-	356885-5	STOP, SHEAR
-	1-1320921-0	SHEAR HOLDER, FRONT, CUT
-	318707-1	FLOATING SHEAR, FRONT
-	1333202-6	ANVIL, COMBINATION
-	-	7
-	-	6
-	1338680-2	DEPRESSOR, SHEAR
-	2-238011-2	BLOCK, CRIMPER SPACER
-	7-683454-3	CRIMPER, INSULATION O
-	1-455888-0	SPACER, CRIMPER
-	1-456403-5	CRIMPER, WIRE PREMIUM
-	-	1

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