

4

3

2

1

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LOC

DIST

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	D2	ECR-13-017851	12DEC13	RS	LZ

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2151630-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1385625
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
1385625

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN R.SHEN		 TE Connectivity	
DIMENSIONS:		CHK LJ.ZHANG			
		APVD U.GUO		NAME SIDE FEED HDM APPLICATOR	
		PRODUCT SPEC			
		MATERIAL		APPLICATION SPEC	
FINISH		WEIGHT		CAGE CODE	
				DRAWING NO C- 1385625	
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		RESTRICTED TO	
		SCALE		SHEET 1 OF 3	
				REV D2	

Dimensioning and tolerancing per ASME Y14.5M-2009

8

7

6

5

4

3

2

1

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PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1385625-1	D	122500-1	LEADMAKER	MECH POST FEED	CUTS CARRIER
1385625-2	D	565435-5	BENCH MODEL K	MECH PRE FEED	CUTS CARRIER
1385625-3	D	354500-1	BENCH MODEL G	MECH PRE FEED	CUTS CARRIER
1385625-6	D	122500-1	LEADMAKER	MECH POST FEED	CONT CARRIER
7-1385625-7	D	-	-	-	SPARE PARTS

1

RECOMMENDED SPARE PARTS.

2

GREASE LIGHTLY.

3

GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.

4

LUBRICATE DAILY USING NO. 20 MACHINE OIL.

5

ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.

6

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL

7

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.

8

CUT TO LENGTH AT ASSY

MACHINE FRAME (REF)

RAM RETAINING PLATE (REF)

MACHINE GUARD (REF)

GUARD BRKT (REF)

AMP-O-LECTRIC™ TERM GUARD

78

3

G TERMINATOR GUARD

POST FEED 1 5/8 STROKE

PRE FEED 1 1/8 STROKE

PRE FEED 1 5/8 STROKE

44 (REF)

47

91

2

ROTATED 180°

B

LEADMAKER

44 (REF)

48

91

2

ROTATED 180°

B

K TERMINATOR

44 (REF)

49

91

2

ROTATED 180°

B

G TERMINATOR

22

19

H

LEADMAKER & BENCH MACHINE

TERMINAL NAME: FEMALE TAXI TERM W/P 150

SEAL 286867

TERMINAL 286866

CRIMP DATA (NON-AMP TERMINAL-AMP SPEC)

PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.053 ±.002 [1.35 ±0.05mm]	16	
B	.047 ±.002 [1.20 ±0.05mm]	18	
C	NOT	USED	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.078 [1.98mm]	F	16-18
INSUL	.145 [3.68mm]	0	.080-.112

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.203-.234	NONE	.485	408-8040	458637-1	L2378 SIM

-	2	2	2	2	-	3-354779-2	PIN, WIRE DISC (.3150)B	129
-	2	2	2	2	-	2-354779-0	PIN, WIRE DISC (.3090)A	128
-	1	1	1	1	-	986950-1	WASHER, FLAT PRECISION	127
-	1	1	1	1	-	217238-1	GENERAL INSTRUCTION PACKAGE	126
-	1	1	1	1	-	4088040	SF APPL INST 408-8040	125
-	1	1	1	1	-	4-21028-0	PIN,SLT SPR(Ø.093x.75)ST GDE PL	124
-	REF	REF	REF	REF	-	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	123
-	REF	REF	REF	REF	-	1-21030-6	PIN,DOWEL(Ø.187x1.25)HOUSING	122
-	REF	REF	REF	REF	-	21045-3	RING,RET "C"(Ø.187)FD FING PIN	121
-	1	1	1	1	-	21024-5	WASHER, LOCK(#10)ADJ BLOCK	120
-	REF	REF	REF	REF	-	21024-5	WASHER,LOCK(#10)ADJ PLATE	119
-	REF	REF	REF	REF	-	21024-5	WASHER,LOCK(#10)FEED GDE ROD	118
-	2	2	2	2	-	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	117
-	REF	REF	REF	REF	-	5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	116
-	4	4	4	4	-	21024-4	WASHER,LOCK(#8)STRIPPER	115
-	REF	REF	REF	REF	-	21899-4	WASHER,FLAT(Ø.16)SCREW ADJ	114
-	-	-	1	-	-	2-21002-6	SCR,BHC(10-32x.38)LUBE ASSY	113
-	1	1	1	1	-	21018-5	NUT,HEX(NO.6)HOLDDOWN	112
-	REF	REF	REF	REF	-	21068-5	NUT,HEX(6-32)FEED ADJ	111
-	1	1	1	1	-	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	110
-	2	2	2	2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE	109
-	REF	REF	REF	REF	-	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	108
-	1	1	1	1	-	461264-1	PLATE, IDENTIFICATION	107
-	2	2	2	2	-	5-21006-6	SCR,SET(10-32x.75)DRAG	106
-	1	1	1	1	-	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	105
-	REF	REF	REF	REF	-	2-21002-9	SCR,BHC(10-32x.75)CAP	104
-	REF	REF	REF	REF	-	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	103
-	REF	REF	REF	REF	-	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	102
-	6	6	6	6	-	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	101
-	1	1	1	1	-	1-21003-9	SCR,FHC(6-32x.38)DEP	100
-	1	1	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	99
-	2	2	2	2	-	2-21000-7	SCR,SHC(8-32x.48)DEP-HOLD	98
-	1	1	1	1	-	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	97
-	2	2	2	2	-	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	96
-	1	1	1	1	-	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	95
-	REF	REF	REF	REF	-	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	94
-	REF	REF	REF	REF	-	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	93
-	1	1	1	1	-	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	92
-	REF	REF	REF	REF	-	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	91
-	-	-	REF	-	-	455749-1	GUARD, WINDOW	90
-	-	REF	-	-	-	679532-1	INSERT, GUARD	89
-	-	-	1	-	-	1-465184-0	LUBRICATOR ASSY	88
-	1	1	1	1	-	690603-1	SPRING, ASSIST	87
-	1	1	1	1	-	23030-1	SCR,SHC(6-32x.25 SL)INS DISC	86
-	REF	REF	REF	REF	-	458109-1	WASHER, SPECIAL	85
-	REF	REF	REF	REF	-	690517-1	SPACER	84
-77	-6	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY	PARTS LIST
1	22
1	19

LOC A

DIST 66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
D1		ECR-08-015892	6-2008	MY	TE

-	REF	REF	REF	REF	-	22594-8	NUT,HEX(1/2-20)	70
-	REF	REF	REF	REF	-	240628-1	PLATE, ADJUSTMENT	69
-	REF	REF	REF	REF	-	240626-1	SHAFT, PIVOT	68
-	REF	REF	REF	REF	-	240633-1	BUSHING	67
-	REF	REF	REF	REF	-	455680-1	LEVER, INTERMEDIATE	66
-	REF	REF	REF	REF	-	240629-1	BLOCK, PIVOT	65
-	REF	REF	REF	REF	-	240632-2	SCREW, ADJ FEED ROD	64
-	REF	REF	REF	REF	-	240659-3	PIN, CAM ROLLER	63
-	REF	REF	REF	REF	-	240658-1	ROLLER, CAM	62
-	REF	REF	REF	REF	-	454398-2	ROD, FEED	61
-	REF	REF	REF	REF	-	454178-1	GUIDE, FEED ROD	60
-	REF	REF	REF	REF	-	454220-1	CAP, RAM	59
-	REF	REF	REF	REF	-	454485-1	HOUSING	58
-	1	1	1	1	-	458537-2	PAWL, FEED	57
-	REF	REF	REF	REF	-	240624-1	PIN, FEED FINGER	56
-	REF	REF	REF	REF	-	691499-1	SPRING, FEED FINGER	55
-	REF	REF	REF	REF	-	690541-1	HOLDER, FEED FINGER	54
-	REF	REF	REF	REF	-	455679-1	LEVER, TERMINAL FEED ARM	53
-	1	1	1	1	-	811242-2	BUMPER, HOLDDOWN	52
-	1	1	1	1	-	690753-1	SPACER, TONKER	51
-	-	1	-	-	-	690602-6	CAM, PRE-FEED 1 5/8 ST	50
-	-	-	1	-	-	690602-5	CAM, PRE-FEED 1 1/8 ST	49
-	1	-	-	-	1	690501-4	CAM, POST-FEED 1 5/8 ST	48
-	1	1	1	1	-	459456-1	APPLICATOR, BASIC (SUBASSY)	47
-	1	1	1	1	-	690191-1	PLUG, NYLON	46
-	1	1	1	1	-	455673-1	RAM	45
-	1	1	1	1	-	690125-1	WASHER, LAMINATED	44
-	1	1	1	1	-	690124-1	WASHER, RAM	43
-	1	1	1	1	-	7-21002-9	BOLT, CRIMPER(5/16x1.00)	42
-	1	1	1	1	-	23241-6	BALL, STEEL	41
-	1	1	1	1	-	690170-1	SPRING, COMPRESSION	40
-	1	1	1	1	-	1-690142-0	DISC, INSULATION	39
-	1	1	1	1	-	354777-1	WIRE DISC, PLASTIC	38
-	1	1	1	1	-	22480-5	WASHER, SPRING	37
-	1	1	1	1	-	690212-1	POST, RAM	36
-	1	1	1	1	-	690786-1	SUPPORT, TERMINAL	35
-	REF	REF	REF	REF	-	455675-1	PLATE, BASE	34
-	1	1	1	1	-	690432-3	SCREW, ADJUSTMENT	33
-	REF	REF	REF	REF	-	455689-1	BLOCK, STRIP GUIDE ADJ	32
-	1	1	1	1	-	455671-1	PLATE, STRIP GUIDE	31
-	1	1	1	1	-	1-455888-0	SPACER, FRONT SHEAR DEP	30
-	2	2	2	2	-	1-22284-0	SPRING, DRAG	29
-	1	1	1	1	-	690546-1	LEVER, DRAG RELEASE	28
-	1	1	1	1	-	240792-1	DRAG, TERMINAL	27
-	1	1	1	1	-	90765-7	GUIDE, STRIP (REAR)	26
-	1	1	1	1	-	690438-1	GUIDE, STRIP (FRONT)	25
-	1	-	-	1	-	690472-2	STRIPPER	24
-	REF	REF	REF	REF	-	4-22284-9	SPRING, FEED RETURN	23
-	-	1	1	-	-	691353-1	STRIPPER	22
-	1	1	1	1	-	318563-1	GUARD, CHIP, FRONT	21
-	1	1	1	1	-	679625-2	HOLDER, SHEAR (NO CUT)	20
-	1	1	1	1	-	3-22280-3	SPRING, SHEAR	19
-	1	1	1	1	-	690461-2	STOP, SHEAR	18
-	-	1	1	1	-	1-690459-0	HOLDER, SHEAR (FRONT)	17
-	1	1	1	1	-	318707-3	SHEAR, FLOAT (FRONT)	16
-	1	1	1	1	-	2-1424534-1	ANVIL	15
-	1	1	1	1	-	318701-1	DEPRESSOR, SHEAR (FRONT)	14
-	1	1	1	1	-	238011-2	SPACER, BLOCK CRIMPER	13
-	1	1	1	1	-	1583690-7	CRIMPER, INSULATION	12
-	1	1	1	1	-	455888-9	SPACER, CRIMPER	11
-	1	1	1	1	-	4-568176-6	CRIMPER, WIRE	10
-77	-6	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY	PARTS LIST
1	22
1	19

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DWN C.ERISMAN 19AUN03

CHK C.ERISMAN 19AUN03

APVD T.ELBIN 19AUN03

NAME Tyco Electronics Corporation Harrisburg, PA 17105-3608

PRODUCT SPEC

APPLICATION SPEC

WEIGHT

CUSTOMER DRAWING

SCALE

SHEET 1 OF 2

REV D1

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLG ± .005

1 PLG ± .005

2 PLG ± .005

3 PLG ± .005

4 PLG ± .005

ANGLES ± .005

FINISH

SIDE FEED HDM APPLICATOR

SIZE CASE CODE DRAWING NO

RESTRICTED TO

4805 (1/08)

27JUN2008 12:08pm

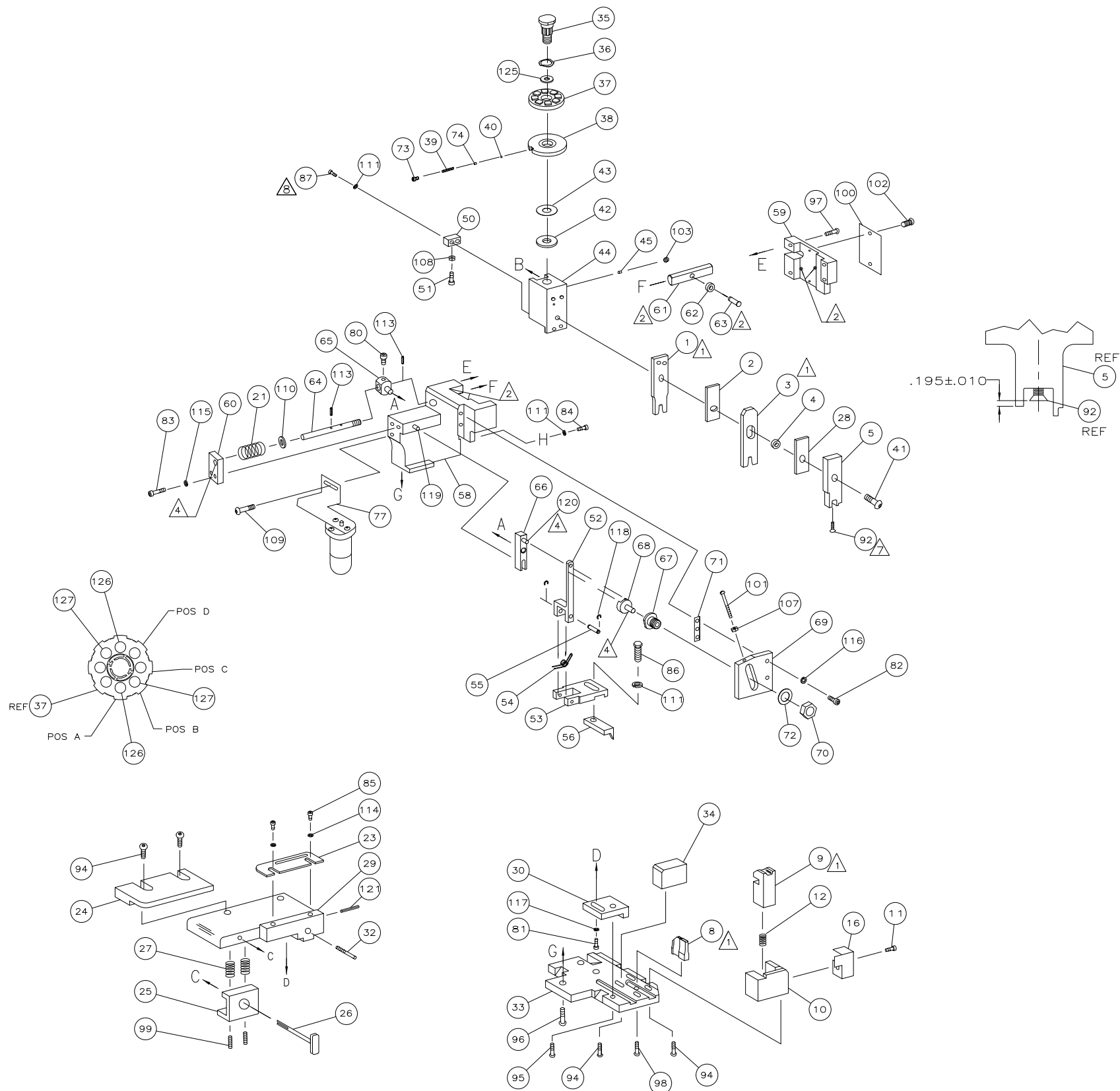
CUSTOMER ACCESSIBLE PRODUCTION DRAWING

DRAWING NUMBER - 1385625 SHEET 2 OF 3 REV. D2

Dimensioning and tolerancing per ASME Y14.5M-2009

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LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			—	SEE SHEET 1	—	—	—



THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN C. FERISMAN 19/JUN/03 CHK C. FERISMAN 19/JUN/03 APP T. FERLIN 19/JUN/03		 Tyco Electronics Corporation Harrisburg, PA 17105-3608	
DIMENSIONS: INCHES 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± . 1 PLC ± . 2 PLC ± . 3 PLC ± . 4 PLC ± . ANGLES ± . FINISH		NAME SIDE FEED HDM APPLICATOR - APPLICATION SPEC - SIZE CASE CODE DRAWING NO RESTRICTED TO A1 00779 C 1385625 CUSTOMER DRAWING SCALE - SHEET 2 OF 2 REV D	

Mouser Electronics

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