

PART NO 1385724

DIMENSIONING AND TOLERANCING PER ASME Y14.5M (ISO STANDARDS). THIS DRAWING IS A CONTROLLED DOCUMENT.

PART NUMBER	REV	FIRST USED	TERMINALS APPLIED
1385724-1	D	AOM / CLS	521471 1969133
1385724-2	A	K UNIT	521597
1385724-3	D	G UNIT	521599
1385724-4	D	KOMAX	521601

CRIMPING DATA				
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	STRIP LENGTH	
A	.061	#14	.195-.240	
B	.055	(2)#18		
C	.052	#16		
D	.047	#18		
CRIMP	SIZE	TYPE	FEED	TERM SPEC
WIRE	.110	F	.580	114-2124
INSUL	.210	0		
INSUL RANGE	WIRE RANGE	APPLICATOR INSTRUCTION SHEET		
.110-.150	18-14	AI 8099		
(2).110MAX	(2)18	AI 8102		

- 1 RECOMMENDED SPARE PARTS.
- 2 ITEMS NOT SHOWN ON ASSEMBLY.
- 3 TOLERANCE ON CUT LENGTH TO BE ±.13.
- 4 USED ON THE CLS I AND II MACHINES ONLY. REMOVE THE TWO MOUNTING SCREWS SECURING THE PRODUCT DEREELEER AND PLACE THE PRODUCT GUIDE (ITEM 111) ON TOP OF THE MOUNTING BRACKET. REASSEMBLE AND RETIGHTEN THE TWO MOUNTING SCREWS.
- 5. SPRING LOADED TONKER (P/N 354853-1) MUST BE USED WHEN RUNNING THE APPLICATOR ON A LEADMAKER.
- 6. AIR VALVE CONVERSION KIT, PN 1633069-2 FOR KOMAX MACHINE.
- 7 GRIND BOTTOM OF ITEM 46 IF IT PROTRUDES BELOW BOTTOM OF ITEM 95.
- 8 CUT TO LENGTH AT ASSEMBLY
- 9 SHIM AS REQUIRED TO ALIGN THE POD WITH THE POD INSERTER.
- 10 SHIM MAY BE REQUIRED BETWEEN STRIP GUIDE PLATE (ITEM 53) AND REAR STRIP GUIDE (ITEM 95) TO CENTER THE TERMINAL OVER THE ANVIL.

KOMAX SET-UP INSTRUCTIONS FOR APPLICATOR 1385724-4

- \* MUST USE SPRING LOADED TONKER (P/N 1-509538-7).
- \* TRIGGER POINT WHEN PRESS IS MOVING UP MUST BE SET AT 1.38".
- \* PROCESS SPEED MUST BE SET TO 90%.
- \* ACTUATION SPEED FOR FEED CYLINDER MUST BE SET AT 350 MILLISECONDS.
- \* OPTIMATION MUST BE UNCHECKED.
- \* SET REFERENCE PRESS HEIGHT SETTING TO 17 ON THE PRESS SCALE.
- \* WHEN SETTING TRANSFER HEIGHT, WIRE MUST BE LEVEL TO THE BOTTOM OF THE WIRE BARREL AT BOTTOM DEAD CENTER.
- \* WIRE MUST BE BIASED AWAY FROM THE LONG INSULATION LEG OR STRANDING MAY OCCUR.
- \* IF LONG INSULATION LEG IS CATCHING POD DURING INSERTION, SPRING LOADED TONK IS SET TOO HIGH.
- \* FEED PAWL MUST BE SET UP AS CLOSE AS POSSIBLE TO THE SKATE DRAG.

LOC A  
DIST 66

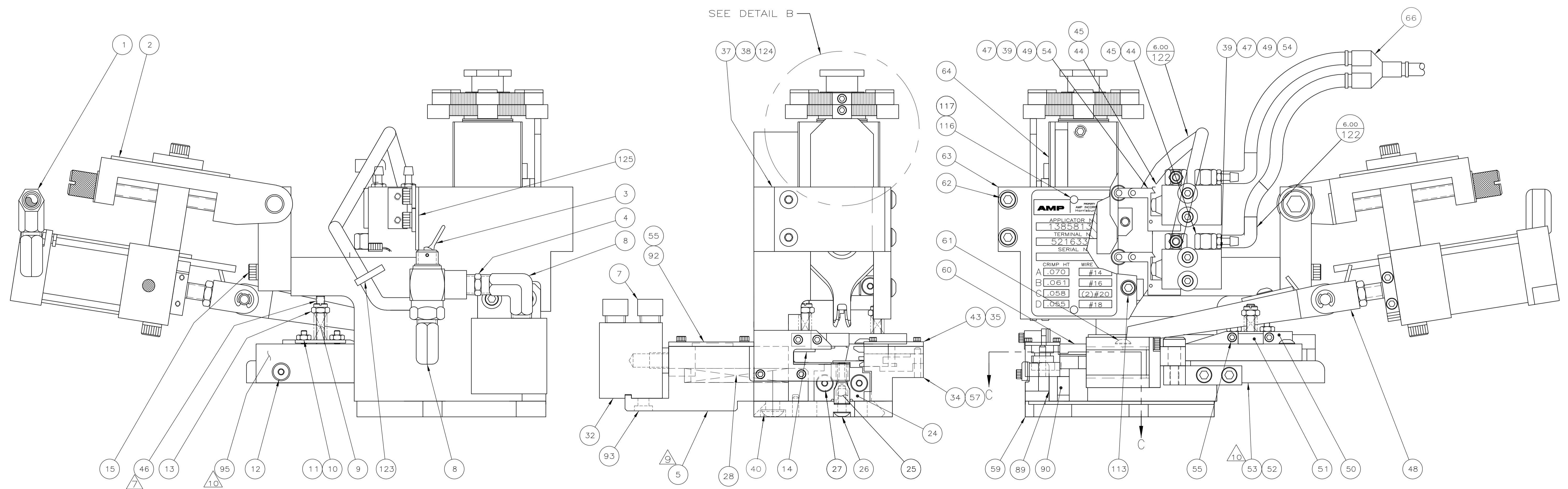
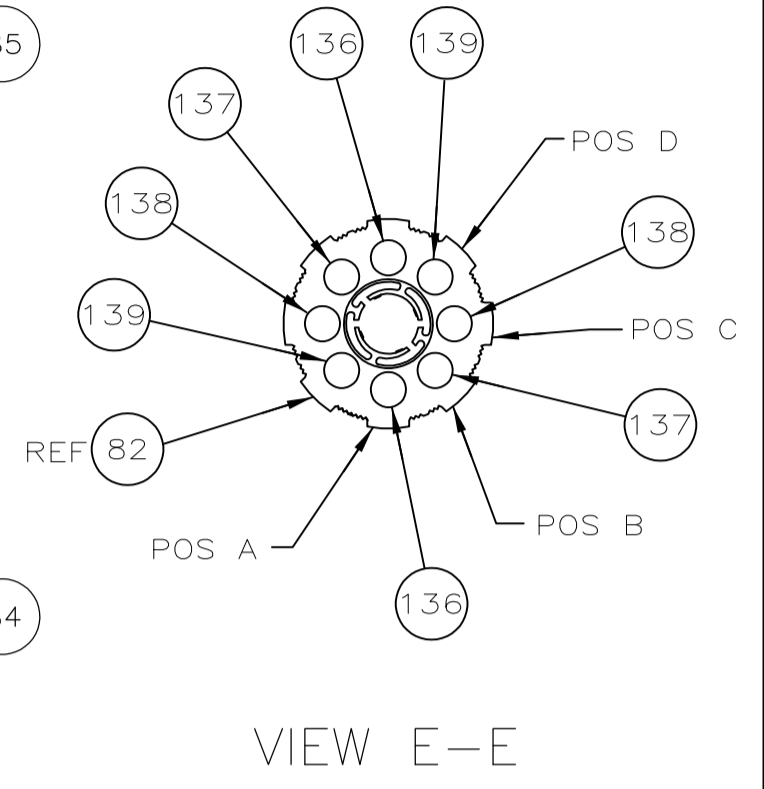
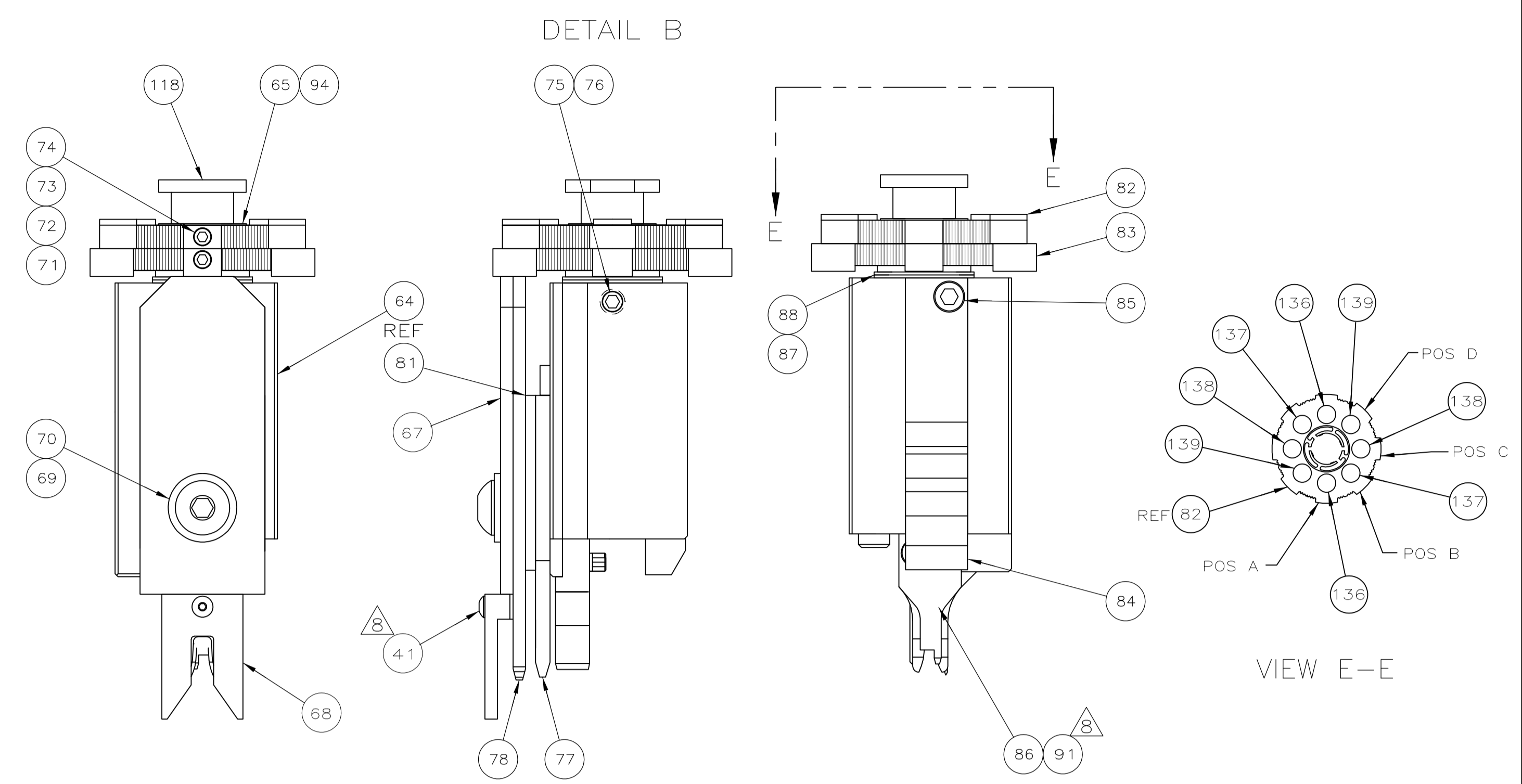
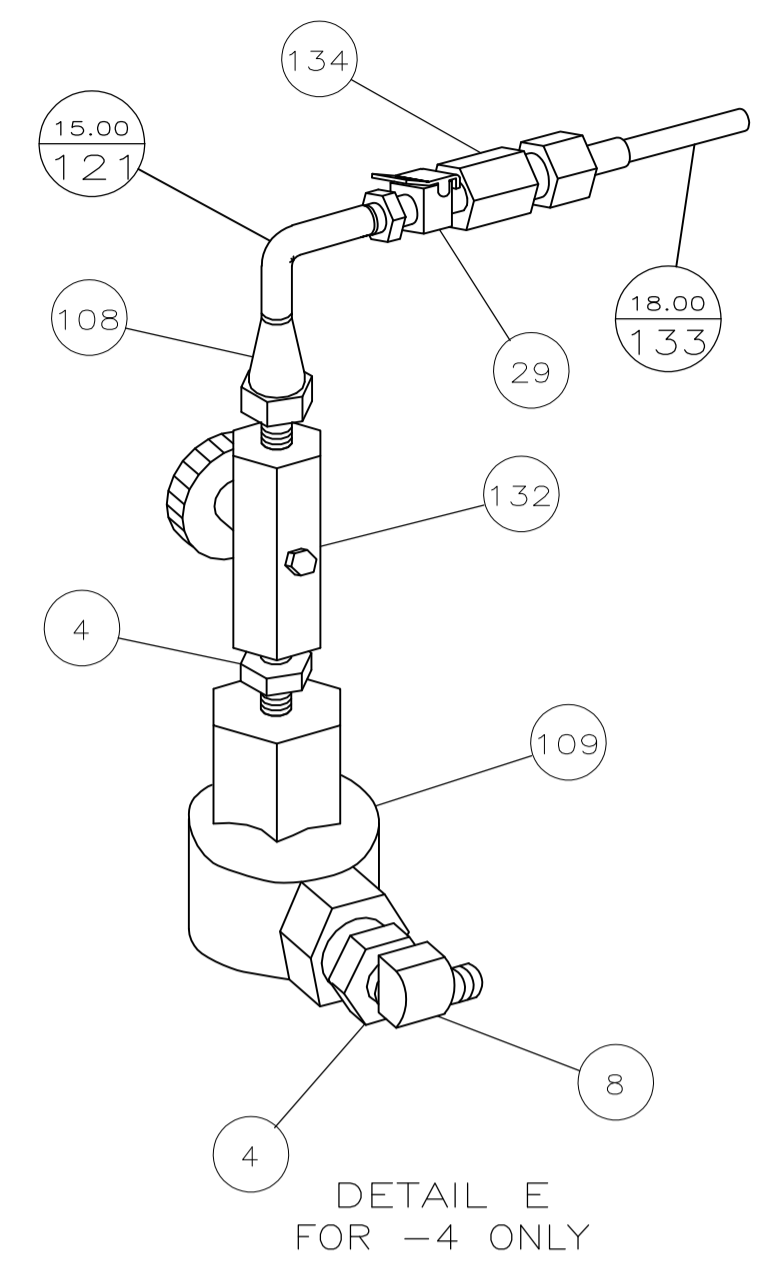
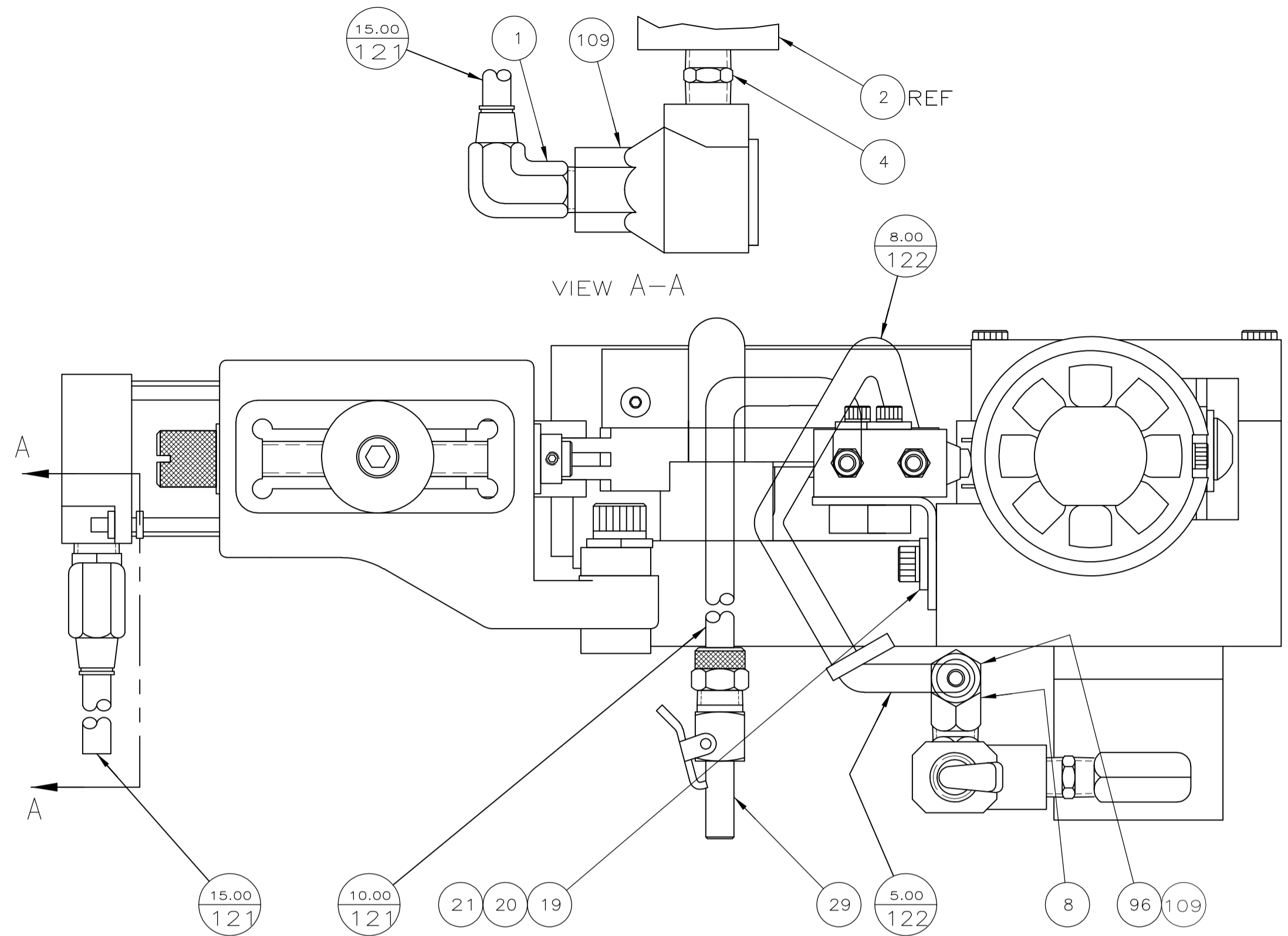
3308-8 (3/11)

D	ECR-12-010612	6-2012	MY	GB	
P	LTR	REVISION RECORD	DATE	OWN	APVD

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
INCHES		0 PLC ±.0005	
1 PLC ±.0008		1 PLC ±.0010	
2 PLC ±.0015		2 PLC ±.0020	
3 PLC ±.0020		3 PLC ±.0025	
4 PLC ±.0030		4 PLC ±.0035	
ANGLES: -		SURFACE TEXTURE: ✓	

DWN	2/11/04	MATERIAL	-	HEAT TREAT	-
CHK	2/11/04				
APVD	2/11/04				
NAME	T. ELBIN				
ULTRA POD FLAG APPLICATOR					
SCALE	1:1	SIZE	A1	DRAWING NO	1385724
				SHEET	1 of 3
				REV	D

DIMENSIONING AND TOLERANCING PER ASME Y14.5M (ISO STANDARDS). THIS DRAWING IS A CONTROLLED DOCUMENT. DWG NO 1385724



AMP	
APPLICATOR N°	
1385813	
TERMINAL N°	
521633	
SERIAL N°	
CRIMP HT	WIRE
A .070	#14
B .061	#16
C .058	(2)#20
D .055	#18

LOC A  
DIST 66

3308-8 (3/11)

8 7 6 5 4 3

DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
0 PLC	± .	0 PLC	± .
1 PLC	± .	1 PLC	± .
2 PLC	± .	2 PLC	± .
3 PLC	± .	3 PLC	± .
4 PLC	± .	4 PLC	± .
ANGLES: °		SURFACE TEXTURE: ✓	
- SEE SHEET 1		SCALE: 1:1	SIZE: A1
REVISION RECORD		DRAWING NO: 1385724	SHEET 2 of 3
DATE	DWN	APVD	REV D

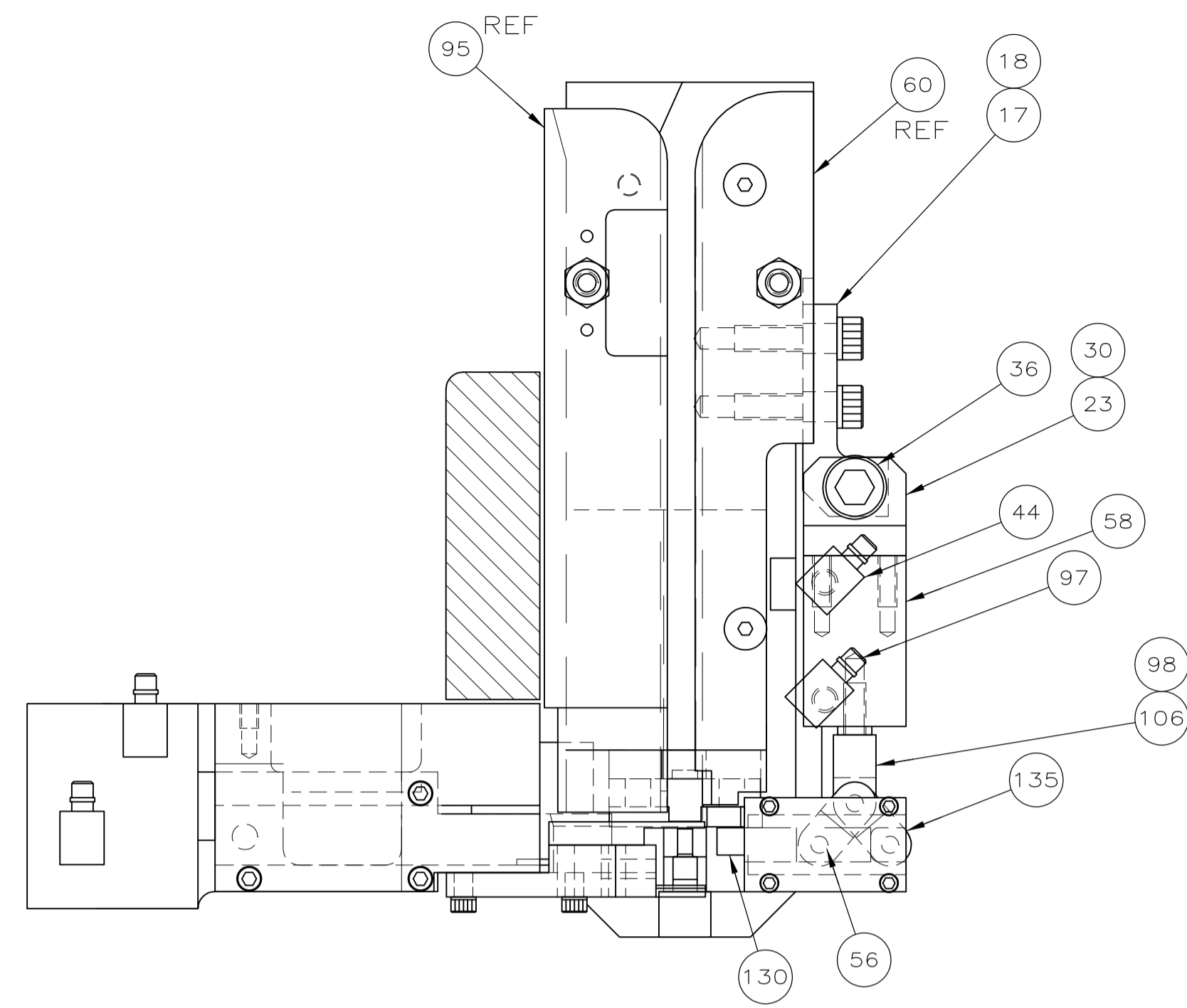
DWN: K. STAKEM	2/11/04	MATERIAL: -	HEAT TREAT: -
CHK: C.ERISMAN	2/11/04	TE Connectivity	
APVD: T.ELBIN	2/11/04		

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

DIMENSIONING AND TOLERANCING PER ASME Y14.5M (ISO STANDARDS). THIS DRAWING IS A CONTROLLED DOCUMENT.

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LOC  
A  
DIST  
66



OBS				QTY	DESCRIPTION	ITEM NO	
2	2	2	2	-	3-354779-0	PIN, WIRE DISC (.3140)D	140
2	2	2	2	-	2-354779-0	PIN, WIRE DISC (.3090)C	138
2	2	2	2	-	354779-9	PIN, WIRE DISC (.3035)B	137
2	2	2	2	-	9-354778-6	PIN, WIRE DISC (.2975)A	136
2	2	2	2	-	1673387-1	LINK, TOGGLE	135
2	-	-	-	-	1424324-1	AIR LINE KIT .250 TO 4mm	134
3	18.00	-	-	-	IN 27319-8	TUBING, POLY FLOW Ø.156	133
1	-	-	-	-	23054-1	VALVE, FLOW CONTROL	132
2	-	REF	-	-	679532-1	INSERT, GUARD	131
1	1	1	1	-	1673388-2	FINGER, BACK-UP	130
-	-	-	-	-	-	-	129
-	-	-	-	-	-	-	128
-	-	-	-	-	-	-	127
-	-	-	-	-	-	-	126
1	1	1	1	-	679172-1	SPACER	125
-	-	-	-	-	-	-	124
-	-	-	-	-	-	-	123
1	1	1	1	-	19832-1	TIE, WIRE	123
27.00	27.00	27.00	27.00	IN	18912-4	HOSE, FLEXIBLE .250 OD	122
25.00	25.00	25.00	25.00	IN	27319-4	TUBE, PLASTIC .250 OD	121
2	-	-	-	-	90647-1	GUARD, MODIFIED	120
-	-	-	-	-	-	-	119
1	1	1	1	-	690212-1	POST, RAM	118
1	1	1	1	-	464249-1	PLATE, IDENTIFICATION	117
2	2	2	2	-	21017-2	SCR., DRIVE #2 X .19 LG	116
-	-	-	-	-	-	-	115
-	-	-	-	-	-	-	114
2	2	2	2	-	6-21000-7	SCR., SHC 8-32UNC X 1.75 LG	113
-	-	-	-	-	692655-5	VALVE ASSEMBLY	112
4	2	2	2	-	768411-1	GUIDE, PRODUCT	111
-	-	-	-	-	-	-	110
2	2	1	2	-	22374-7	VALVE, QUICK EXHAUST 1/8NPT	109
1	-	-	-	-	980282-3	CONNECTOR, TUBING, MALE	108
-	-	-	-	-	-	-	107
1	1	1	1	-	1673636-1	CLEVIS, CYLINDER	106
-	-	-	-	-	1-455750-3	GUARD ASSEMBLY	105
-	-	-	-	-	22307-1	BUSHING, PIPE, FITTING 1/4NPT	104
-	-	-	-	-	23791-2	TEE, PIPE, FITTING 1/4NPT	103
2	-	-	-	-	28580-1	FILTER, MINATURE 1/4NPT	102
-	-	-	-	-	22311-2	NIPPLE, CLOSE 1/4NPT	101
-	-	-	-	-	28582-1	LUBRICATOR 1/4NPT	100
-	-	-	-	-	26108-1	BODY, QUICK CONNECT	99
1	1	1	1	-	4-21006-5	SCR, SOC SET 8-32 X .62	98
1	1	1	1	-	1-28509-3	FITTING, ELBOW	97
1	1	1	1	-	18258-3	CONN., TUBING, MALE 1/8NPT-1/4 TUBE	96
10	1	1	1	-	1752763-1	GUIDE, REAR STRIP	95
1	1	1	1	-	986950-1	WASHER, FLAT PRECISION	94
2	2	2	2	-	6-21002-2	SCR, BHC 10-24 X .39 LG.	93
1	1	1	1	-	1673397-1	COVER, VANE	92
2	2	2	2	-	2-21000-6	SCR., SHC 8-32UNC X .38 LG	91
1	1	1	1	-	852764-2	SHEAR, REAR	90
2	2	2	2	-	852765-2	SPACER, SHEAR	89
1	1	1	1	-	690124-1	WASHER, RAM	88
1	1	1	1	-	690125-1	WASHER, LAMINATED	87
1	1	1	1	-	1752734-1	BLADE, SLUG	86
1	1	1	1	-	2-21000-5	SCR., SHC 8-32UNC X .25 LG	85
1	1	1	1	-	1213817-1	VALVE, CAM	84
1	1	1	1	-	690142-5	DISC, INSULATION	83
1	1	1	1	-	354777-1	DISC, WIRE CRIMP ADJ.	82
1	1	1	1	-	1-455888-6	SPACER, CRIMPER	81
-	-	-	-	-	-	-	80
-	-	-	-	-	-	-	79
1	1	1	1	-	853491-6	CRIMPER, INSULATION	78
1	1	1	1	-	852743-5	CRIMPER, WIRE	77
1	1	1	1	-	21009-6	SCR., SET, SOC 1/4-20UNC X .25 LG	76
1	1	1	1	-	690191-1	PLUG, NYLON	75
1	1	1	1	-	23030-1	SCR., SET, SOC 6-32UNC X .25 LG	74
1	1	1	1	-	690170-1	SPRING, COMP.	73
1	1	1	1	-	690603-1	SPRING, ASSIST	72
1	1	1	1	-	23241-6	BALL, STEEL	71
QTY	REQD	PER	ASSY		PART NO	DESCRIPTION	ITEM NO

OBS				QTY	DESCRIPTION	ITEM NO	
1	1	1	1	-	690686-3	SCR., BHC 5/16-24UNF X 1.00 LG	70
1	1	1	1	-	3-238009-6	BLOCK, CRIMPER SPACER	69
1	1	1	1	-	1633289-1	STABILIZER	68
1	1	1	1	-	1633288-1	HOLDER, STABILIZER	67
1	1	1	1	-	1428088-2	FITTING, Y, TUBE TO TUBE	66
1	1	1	1	-	22480-5	WASHER, WAVE SPRING	65
1	1	1	1	-	852768-3	RAM	64
1	1	1	1	-	856391-2	CAP, RAM	63
2	2	2	2	-	3-21000-9	SCR, SHC 10-32UNC X 1.00 LG	62
2	2	2	2	-	2-21002-3	SCR., BHC 8-32UNC X .62 LG	61
1	1	1	1	-	1752762-1	GUIDE, FRONT STRIP	60
1	1	1	1	-	1633292-1	PLATE, BASE	59
1	1	1	1	-	1725830-1	CYLINDER, COMPACT	58
1	1	1	1	-	1673389-1	MOUNT, FINGER	57
1	1	1	1	-	21030-1	PIN, DOWEL .12 DIA X .38 LG.	56
5	5	5	5	-	1-21000-3	SCR., SHC 4-40UNC X .25 LG	55
4	4	4	4	-	21024-3	WASHER, LOC 6	54
10	1	1	1	-	1673379-1	PLATE, STRIP GUIDE	53
4	4	4	4	-	3-21002-3	SCR, BHC 1/4-20UNC X .50 LG	52
1	1	1	1	-	852740-1	ARM, STOCK DRAG	51
1	1	1	1	-	464452-8	DRAG, STOCK	50
4	4	4	4	-	21055-5	WASHER, FLAT 6	49
1	1	1	1	-	2-460680-5	FEED FINGER ASSEMBLY	48
2	2	2	2	-	986377-1	VALVE, LEVER ROLLER	47
7	2	2	2	-	22354-6	STUD 8-32UNC X 1.00 LG	46
4	4	4	4	-	18326-2	ELBOW, TUBE TO MALE 10-32NPT	45
5	5	5	5	-	18258-1	CONN., MALE TUBE TO MALE THD 10-32NPT	44
1	1	1	1	-	1673390-1	COVER, FINGER	43
-	-	-	-	-	-	-	42
8	1	1	1	-	1-21002-4	SCR, BHC 4-40UNC X .38 LG	41
2	2	2	2	-	3-21002-3	SCR, BHC 1/4-20UNC X .50 LG	40
4	4	4	4	-	2-21000-3	SCR., SHC 6-32UNC X .88 LG	39
3	3	3	3	-	2-22733-8	SCR., BHC 1/4-20UNC X .63 LG	38
1	1	1	1	-	1752764-1	HOUSING, APPLICATOR	37
1	1	1	1	-	21004-1	SCR, SHLD .25 DIA X .38 LG.	36
4	4	4	4	-	21000-9	SCR., SHC 2-56UNC X .19 LG	35
1	1	1	1	-	2-21002-6	SCR., BHC 10-32UNF X .38 LG	34
-	-	-	-	-	-	-	33
1	1	1	1	-	354993-2	CYL., AIR, DOUBLE ACTING 1/8NPT	32
-	-	-	-	-	-	-	31
2	2	2	2	-	1-21000-8	SCR, SHC 6-32 X .25 LG.	30
2	2	2	2	-	23238-1	INSERT, COUPLING	29
1	1	1	1	-	1-23470-7	SPRING, COMPRESSION	28
2	2	2	2	-	2-21002-4	SCR., BHC 8-32UNC X 1.00 LG	27
1	1	1	1	-	22733-8	SCR., BHC 8-32UNC X .38 LG	26
1	1	1	1	-	853088-9	ANVIL	25
1	1	1	1	-	1673377-1	SHEAR, FRONT	24
1	1	1	1	-	1673385-1	EYE, CYLINDER	23
-	-	-	-	-	-	-	22
2	2	2	2	-	3-21000-4	SCR., SHC 10-32UNF X .38 LG	21
2	2	2	2	-	21055-7	WASHER, FLAT 10	20
1	1	1	1	-	1213818-1	BRACKET, VALVE	19
2	2	2	2	-	3-21000-5	SCR, SHC 10-32 X .50 LG.	18
1	1	1	1	-	1673386-1	MOUNT, CYLINDER	17
-	-	-	-	-	-	-	16
2	2	2	2	-	3-21000-9	SCR., SHC 10-32UNF X 1.00 LG	15
1	1	1	1	-	1752765-1	INSERTER, POD	14
2	2	2	2	-	21022-2	NUT, FLEX 8-32UNC	13
2	2	2	2	-	2-21002-1	SCR., BHC 8-32UNC X .38 LG	12
2	2	2	2	-	2-21006-3	SCR., SET, SOC CONE PT 4-40UNC X .38 LG	11
2	2	2	2	-	21018-4	NUT, HEX 4-40UNC	10
2	2	2	2	-	3-22281-4	SPRING, COMP. .300 DIA X .38 LG	9
3	2	2	2	-	22306-1	ELBOW, MALE 1/8NPT	8
1	1	1	1	-	25545-1	MUFFLER, EXHAUST 1/8" NPT	7
-	-	-	-	-	-	-	6
9	1	1	1	-	1673395-1	INSERTER, MOUNT	5
3	2	1	2	-	22304-1	NIPPLE, HEX PIPE 1/8NPT	4
1	1	1	1	-	985836-1	VALVE, TOGGLE 1/8NPT	3
1	1	1	1	-	1-460277-2	AIR FEED ASSEMBLY	2
-	1	1	1	-	985883-2	CONN., TUBING, MALE 1/8NPT-1/4 TUBE	1
QTY	REQD	PER	ASSY		PART NO	DESCRIPTION	ITEM NO

LOC	A	DIST	66
REVISION RECORD	DATE	OWN	APVD
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CUSTOMER ACCESSIBLE PRODUCTION DRAWING