

4

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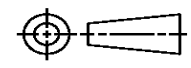
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LOC	DIST	REVISIONS			
P	LTR	DESCRIPTION	DATE	DWN	APVD
	B1	ECR-14-002921	27FEB2014	GK	HMR

# 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		
DIMENSIONS:		CHK	RAGHAVENDRA		
		APVD	RAGHAVENDRA		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	NAME		
0 PLC	±	APPLICATION SPEC	FINE ADJUST SIDE FEED HDI APPLICATOR		
1 PLC	±		SIZE	CAGE CODE	DRAWING NO
2 PLC	±		A3		©- 1528276
3 PLC	±				RESTRICTED TO
4 PLC	±				
ANGLES	±	WEIGHT			
MATERIAL	FINISH	CUSTOMER DRAWING	SCALE	SHEET 1 OF 2	REV B1



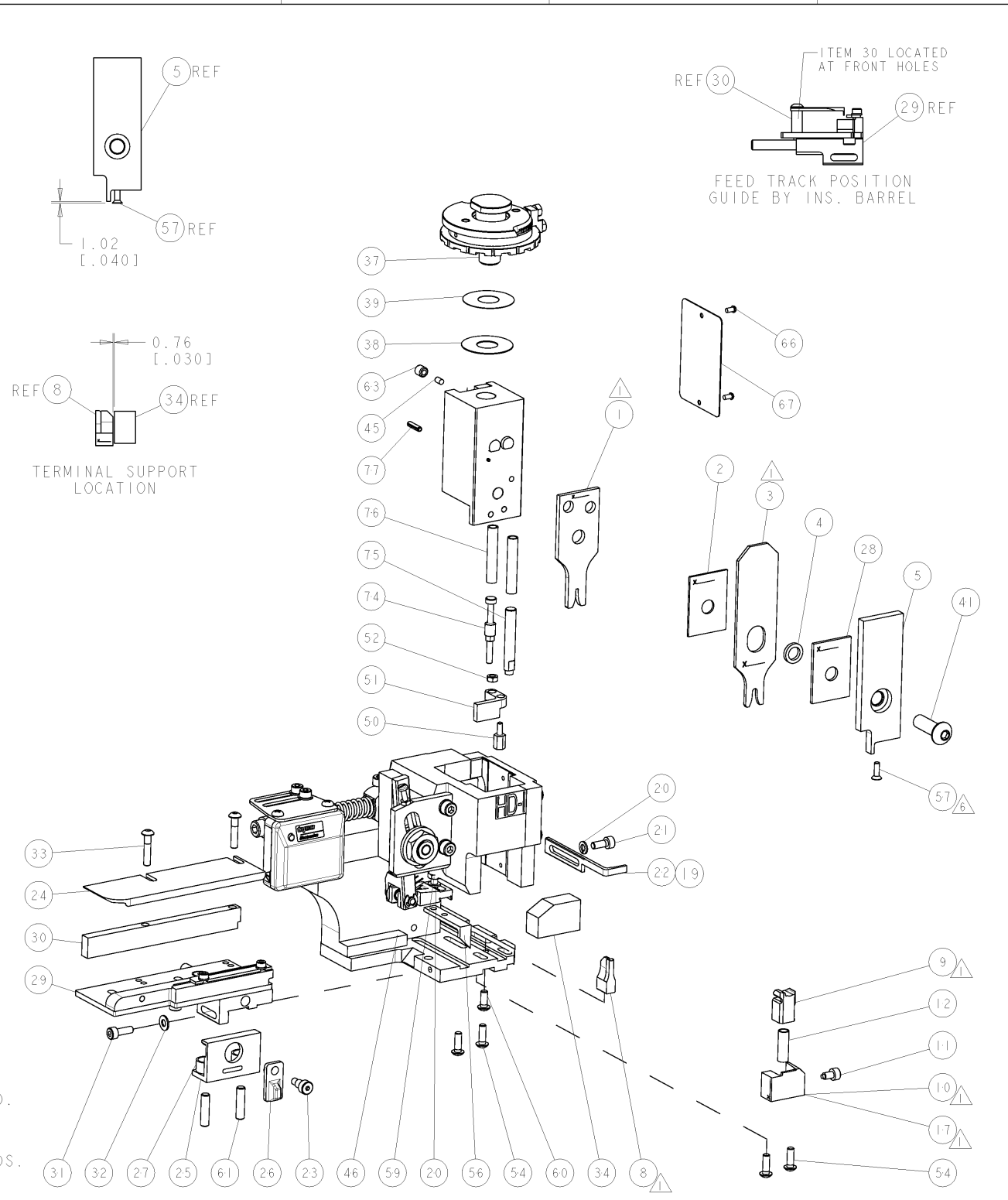
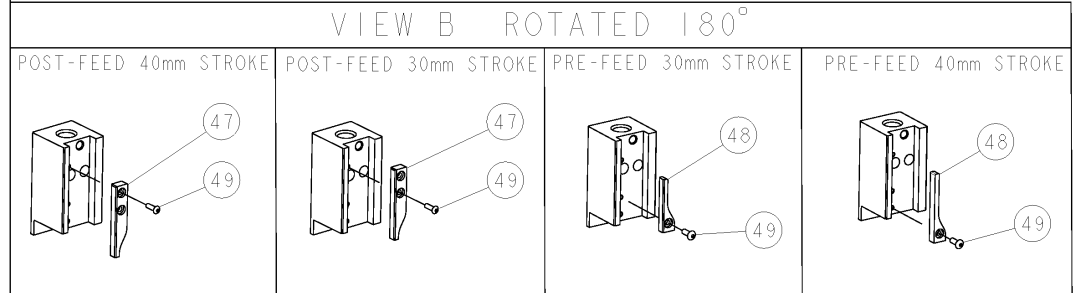
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PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1528276-1	B	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528276-2	B	BENCH	MECH PRE FEED	CUTS CARRIER
1528276-6	B	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528276-1	B	LEADMAKER	MECH POST FEED	-1 AND SPARE 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 <sup>2</sup>		
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 ± 0.002 IN]	C 0			
0.30mmsq or 22AWG	1.06 ± 0.05 [.042 ± 0.002 IN]	C 1			
0.20mmsq or 24AWG	1.00 ± 0.05 [.039 ± 0.002 IN]	C 7			

- RECOMMENDED SPARE PARTS
- 2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY
- 3. 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	
-	-	82	
-	-	81	
-	-	80	
-	-	79	
-	-	78	
1	993111-8 PIN, SLOTTED SPRING 3.0 X 12.0	77	
2	3-22280-7 SPRING, COMPRESSION	76	
1	1752353-1 GUIDE PIN, HOLDDOWN	75	
1	1901680-1 GUIDE PIN, HOLDDOWN	74	
-77	-76 -72 -71 -6 -2 -1 PART NO	DESCRIPTION	ITEM NO

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	71
-	-	70
-	-	69
-	-	68
-	461264-5 PLATE, IDENTIFICATION	67
-	21017-2 SCREW, DRIVE	66
-	-	65
-	-	64
-	3-18031-0 SCR, SET, CUP POINT M6 X 6.0	63
-	-	62
-	2-18032-5 SCR, SET, FLT POINT M5 X 20.0	61
-	18024-7 SCR, BTN SKT HD CAP (M4 X 10.0)	60
-	5-18022-2 SCR, HEX HD CAP M4 X 8.0	59
-	-	58
-	985575-3 SCR, FLT SKT HD CAP M3 X 10.0	57
-	1338685-1 PAWL, FEED	56
-	-	55
-	4 18024-8 SCR, BTN SKT HD CAP (M4 X 12.0)	54
-	-	53
-	1-18030-0 NUT, HEX, REG M3.5	52
-	1901681-1 HOLDDOWN, TERMINAL	51
-	1-1752354-8 STANDOFF, HOLD-DOWN	50
-	18024-3 SCR, BTN SKT HD CAP (M3 X 10.0)	49
-	1338675-1 CAM, UNIVERSAL PRE FEED	48
-	1338676-1 CAM, UNIVERSAL POST-FEED	47
-	1320999-3 APPLICATOR SUBASSEMBLY, HDI	46
-	690191-1 PLUG, NYLON	45
-	1633724-1 RAM, (SIDE FEED)	44
-	-	43
-	-	42
-	2-18024-6 SCR, BTN SKT HD CAP (M8 X 25.0)	41
-	-	40
-	690125-1 SHIM SUB-ASSY	39
-	469367-9 SHIM	38
-	879103-2 FINE ADJUST HEAD SUBASSY	37
-	-	36
-	-	35
-	1752356-3 SUPPORT, TERMINAL	34
-	1-18024-0 SCR, BTN SKT HD CAP (M4 X 20.0)	33
-	18027-2 WASHER, FLAT, REG M4	32
-	1-18023-2 SCR, SKT HD CAP M4 X 12.0	31
-	1320908-8 SPACER, STRIP GUIDE	30
-	1633073-1 STRIP GUIDE ASSEMBLY	29
-	1-455888-6 SPACER, CRIMPER	28
-	1-22284-0 SPRING, COMPRESSION	27
-	356835-1 LEVER, DRAG RELEASE	26
-	240792-1 DRAG, TERMINAL	25
-	1320928-1 PLATE, STRIP GUIDE	24
-	980371-4 SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	690472-2 STRIPPER	22
-	1-18023-1 SCR, SKT HD CAP M4 X 10.0	21
-	18025-2 WASHER, SPRG LOCK, REG M4	20
-	690472-1 STRIPPER	19
-	-	18
-	1338684-2 HOLDER, SHEAR, NO-CUT	17
-	-	16
-	-	15
-	-	14
-	-	13
-	5-22280-0 SPRING, COMPRESSION	12
-	356885-5 STOP, SHEAR	11
-	1-1320921-0 SHEAR HOLDER, FRONT, CUT	10
-	318707-1 FLOATING SHEAR, FRONT	9
-	1333202-6 ANVIL, COMBINATION	8
-	-	7
-	-	6
-	1338680-2 DEPRESSOR, SHEAR	5
-	2-238011-2 BLOCK, CRIMPER SPACER	4
-	7-683454-3 CRIMPER, INSULATION O	3
-	1-455888-0 SPACER, CRIMPER	2
-	1-456403-5 CRIMPER, WIRE PREMIUM	1

APV: L. LOETHOUSE	DATE: 24-Jun-05	TE Connectivity	17105-3608
APV: J. BACKHURST	DATE: 24-Jun-05	FINE ADJUST SIDE FEED HDI APPLICATOR	
DIMENSIONS: mm [IN]		MATERIAL: 303 STAINLESS STEEL	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		FINISH: POLISHED	
0 PLC	±	SIZE	CAGE CODE
1 PLC	±	DRAWING NO	RESTRICTED TO
2 PLC	±	00779	1528276
3 PLC	±	SCALE	3:5
4 PLC	±	SHEET	1 OF 1
APPROVAL	DATE	REV	B