

4

3

2

1

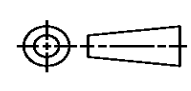
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LOC	DIST	REVISIONS			
P	LTR	DESCRIPTION	DATE	DWN	APVD
	C2	ECR-16-009820	18JUL2016	GK	SD

REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2151651-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1530177
 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
 1530177

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV		
DIMENSIONS:		CHK	GOPALAKRISHNA HV		
		APVD	STOUGH DALE		
		PRODUCT SPEC			
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATION SPEC			
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
MATERIAL	FINISH	A3		©- 1530177	
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	SHEET 1 OF 2 REV C2

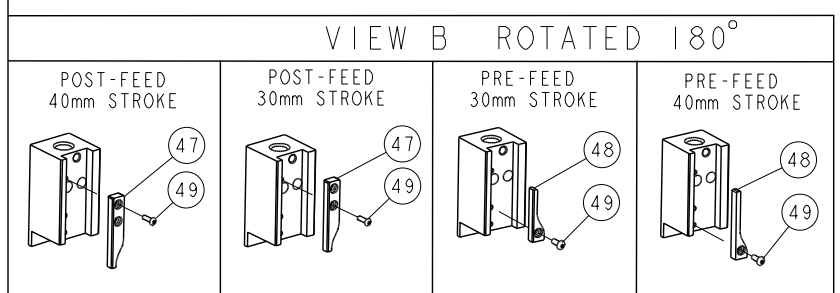


FINE ADJUST SIDE FEED HDI
 APPLICATOR

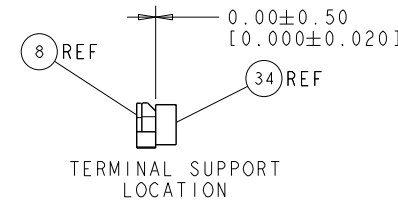
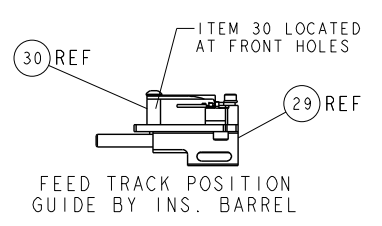
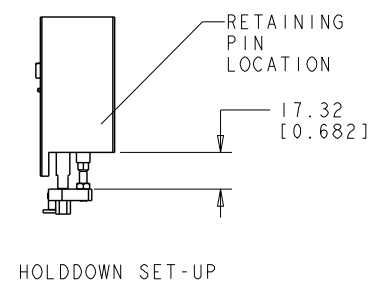
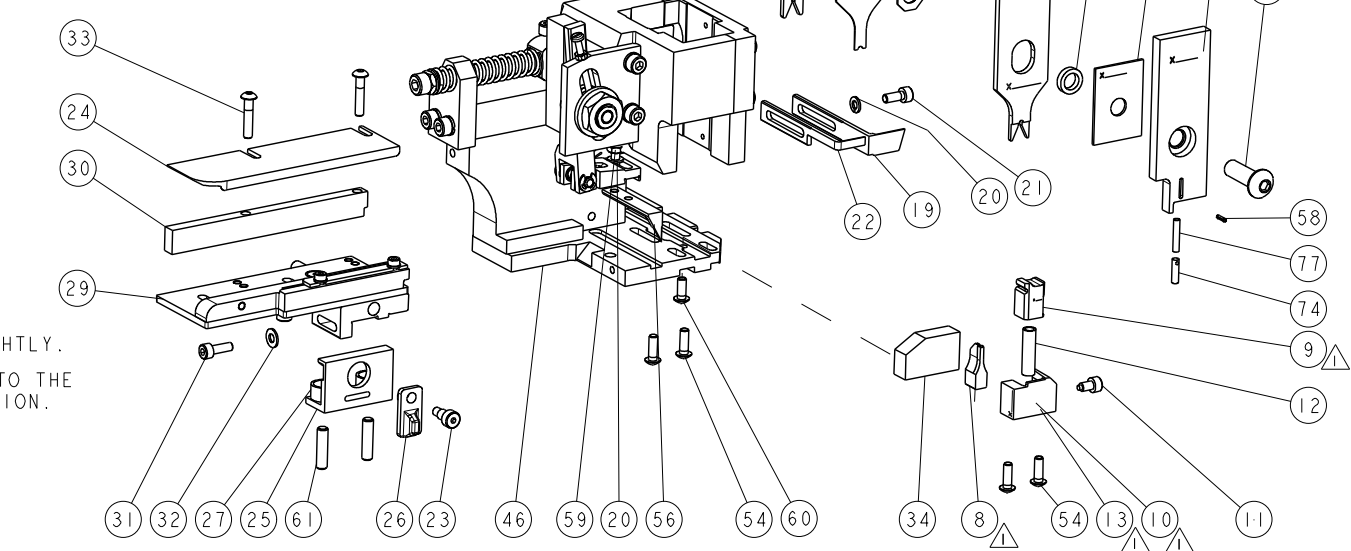
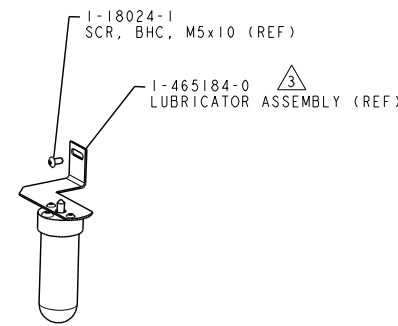
PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1530177-1	C	LEADMAKER	MECH POST FEED	CUTS CARRIER
1530177-2	C	BENCH	MECH PRE FEED	CUTS CARRIER
1530177-6	C	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1530177-1	C	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1530177-2	C	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1530177-6	C	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1530177-7	B	-	-	SPARE PARTS KIT

CRIMP DATA		TEC TERMINAL		TEC CRIMP SPECS	
TERMINAL NAME: CONTACT, RECEPTACLE / TAB, CRIMP SNAP-IN					
CRIMP	SIZE	TYPE	RANGE		
WIRE	1.40 [0.055 IN]	F	20-18 AWG		
INSUL	1.98 [0.078 IN]	O	Ø1.7-2.1 [0.067-0.083 IN]		
WIRE STRIP LENGTH 2.20-2.70 [0.087-0.106 IN]		APPL INSTRUCTIONS 408-8322 & 408-8490			
TERMINAL APPL SPEC 114-13261		FEED		9.00 [0.354 IN]	
TERMINALS APPLIED					
RECEPTACLE	TAB	TAB			
2106123-1	2106124-1	2106124-5			
2106123-3	2106124-2	2106124-6			
-	2106124-3	2106124-7			
WIRE SIZE	CRIMP HEIGHT	REF SETTING			
18 AWG	1.05 ±0.05 [0.041 ±0.002 IN]	A6			
20 AWG	0.87 ±0.05 [0.034 ±0.002 IN]	C0			

- RECOMMENDED SPARE PARTS.
- GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
- CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.
- LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.



*** 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.



SET UP GAGE
458637-3

REVISONS		DATE	OWN	APVD
B	ECR-10-017542	23AUG2010	RK	GB
C	ECR-12-011324	21JUN2012	MY	GB
CI	ECR-14-004979	04APR2014	KH	UG

QTY	LOC	DIST	ITEM NO	DESCRIPTION	ITEM NO			
- 2	2	2	2	2	2	1655785-9	SCR, BTN SKT HD CAP (M3 X 6)	230
- 1	1	1	1	1	1	1-1976053-5	LOCATER BLOCK, TERMINAL	179
- 1	1	1	1	1	1	993111-8	PIN, SLOTTED SPRING 3.0 X 12.0	177
- 2	2	2	2	2	2	3-22280-7	SPRING, COMPRESSION	176
- 1	1	1	1	1	1	1752353-1	GUIDE PIN,HOLDDOWN	175
- 1	1	1	1	1	1	1901680-1	GUIDE PIN,HOLDDOWN	174
- 1	1	1	1	1	1	22278-7	SPRING, COMPRESSION	77
- 1	1	1	1	1	1	854769-4	HOLDER, INS	74
- 1	1	1	1	1	1	1490525-3	DEPRESSOR, WIRE	73
- 1	1	1	1	1	1	1338705-3	DOCUMENTATION PACKAGE	71
- 3	3	3	3	3	3	1-23147-4	SPRING, COMPRESSION	70
- 1	1	1	1	1	1	1490524-1	DEPRESSOR, SPACER	69
- 1	1	1	1	1	1	461264-5	PLATE, IDENTIFICATION	67
- 2	2	2	2	2	2	21017-2	SCREW, DRIVE	66
- 1	1	1	1	1	1	1424350-1	HOLDER, PIN, WIRED	65
- 1	1	1	1	1	1	3-18031-0	SCR, SET, CUP POINT M6 X 6.0	63
- 2	2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
- 1	1	1	1	1	1	18024-7	SCR, BTN SKT HD CAP (M4 X 10.0)	60
- 1	1	1	1	1	1	5-18022-2	SCR, HEX HD CAP M4 X 8.0	59
- 1	1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
- 1	1	1	1	1	1	1338685-1	PAWL, FEED	56
- 4	4	4	4	4	4	18024-8	SCR, BTN SKT HD CAP (M4 X 12.0)	54
- 1	1	1	1	1	1	1-18030-0	NUT, HEX, REG M3.5	52
- 1	1	1	1	1	1	1-1901681-0	HOLDDOWN, TERMINAL	51
- 1	1	1	1	1	1	1-1752354-0	STANDOFF,HOLD-DOWN	50
- 1	1	1	1	1	1	18024-3	SCR, BTN SKT HD CAP (M3 X 10.0)	49
- 1	1	1	1	1	1	1338675-1	CAM, UNIVERSAL PRE FEED	48
- 1	1	1	1	1	1	1338676-1	CAM, UNIVERSAL POST-FEED	47
- 1	1	1	1	1	1	1320999-3	APPLICATOR SUBASSEMBLY, HD1	46
- 1	1	1	1	1	1	690191-1	PLUG,NYLON	45
- 1	1	1	1	1	1	1633724-5	RAM, (SIDE FEED)	44
- 1	1	1	1	1	1	2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)	41
- 1	1	1	1	1	1	690125-1	SHIM SUB-ASSY	39
- 1	1	1	1	1	1	469367-8	SHIM	38
- 1	1	1	1	1	1	879103-3	FINE ADJUST HEAD ASSEMBLY	37
- 1	1	1	1	1	1	1-1752356-8	SUPPORT, TERMINAL	34
- 2	2	2	2	2	2	1-18024-0	SCR, BTN SKT HD CAP (M4 X 20.0)	33
- 1	1	1	1	1	1	18027-2	WASHER, FLAT, REG M4	32
- 1	1	1	1	1	1	1-18023-2	SCR, SKT HD CAP M4 X 12.0	31
- 1	1	1	1	1	1	1320908-4	SPACER, STRIP GUIDE	30
- 1	1	1	1	1	1	1633073-1	STRIP GUIDE ASSEMBLY	29
- 1	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
- 2	2	2	2	2	2	1-22284-0	SPRING, COMPRESSION	27
- 1	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
- 1	1	1	1	1	1	240792-3	DRAG, TERMINAL	25
- 1	1	1	1	1	1	1320928-1	STRIP GUIDE	24
- 1	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
- 1	1	1	1	1	1	1-690472-4	STRIPPER	22
- 1	1	1	1	1	1	1-18023-1	SCR, SKT HD CAP M4 X 10.0	21
- 2	2	2	2	2	2	18025-2	WASHER, SPRG LOCK, REG M4	20
- 1	1	1	1	1	1	1-1338987-9	STRIPPER	19
- 1	1	1	1	1	1	1338684-2	SHEAR HOLDER, FRONT	13
- 1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
- 1	1	1	1	1	1	356885-5	STOP, SHEAR	11
- 1	1	1	1	1	1	1-1320921-0	SHEAR HOLDER, FRONT, CUT	10
- 1	1	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
1	2	2	2	1	1	3-1633128-4	ANVIL, COMBINATION .055	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	854772-6	DEPRESSOR, SHEAR	5
- 1	1	1	1	1	1	1-238011-8	BLOCK, CRIMPER SPACER	4
1	2	2	2	1	1	1-1633757-3	CRIMPER, INSULATION 0	3
-	-	-	-	-	-	-	-	2
1	2	2	2	1	1	2-1633730-1	CRIMPER, WIRE	1

THIS DRAWING IS A CONTROLLED DOCUMENT. DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009. DIMENSIONS: mm [IN]. TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±, 1 PLC ±, 2 PLC ±, 3 PLC ±, 4 PLC ±, ANGLES ±.

OWN: S. ZOU 06AUG2009
CHK: T. ELBIN 06AUG2009
APPV: N. DEMING 06AUG2009

NAME: FINE ADJUST SIDE FEED HD1 APPLICATOR

SIZE: A1 00779 ©=1530177

Customer Accessible Production Drawing SCALE: 3:5 SHEET 1 OF 1 REV: C1