

PART NUMBER	REV	FIRST USED
1385813-1	F	AOM/CLS
1385813-2	A	K UNIT
1385813-3	F	G UNIT
1385813-4	F	KOMAX

OBSOLETE
SUPERSEDED BY 1385813-1
OBSOLETE

REVISIONS				
P	LTR	DESCRIPTION	DATE	APPV
F1		REVISED PER ECR-23-190096	18OCT2023	GK TE

TERMINAL APPLIED:	
521112	
521633	
1969110	

CRIMPING DATA				
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	STRIP LENGTH	
A	.070	#14	.281	
B	.065	(2)#18		
C	.061	#16		
D	.055	#18		
CRIMP	SIZE	TYPE	FEED	TERM SPEC
WIRE	.110	F	.740	114-2124
INSUL	.220	0		
INSUL RANGE	WIRE RANGE	APPLICATOR INSTRUCTION SHEET		
.110-.160	18-14	AI 8099		
(2).105MAX	(2)18	AI 8102		

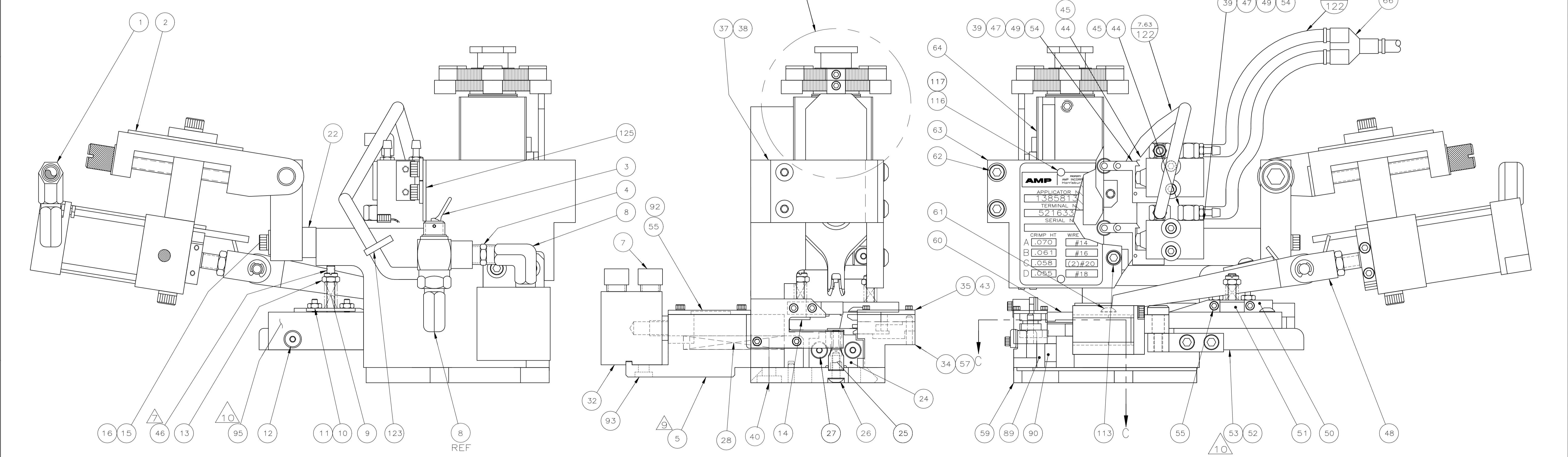
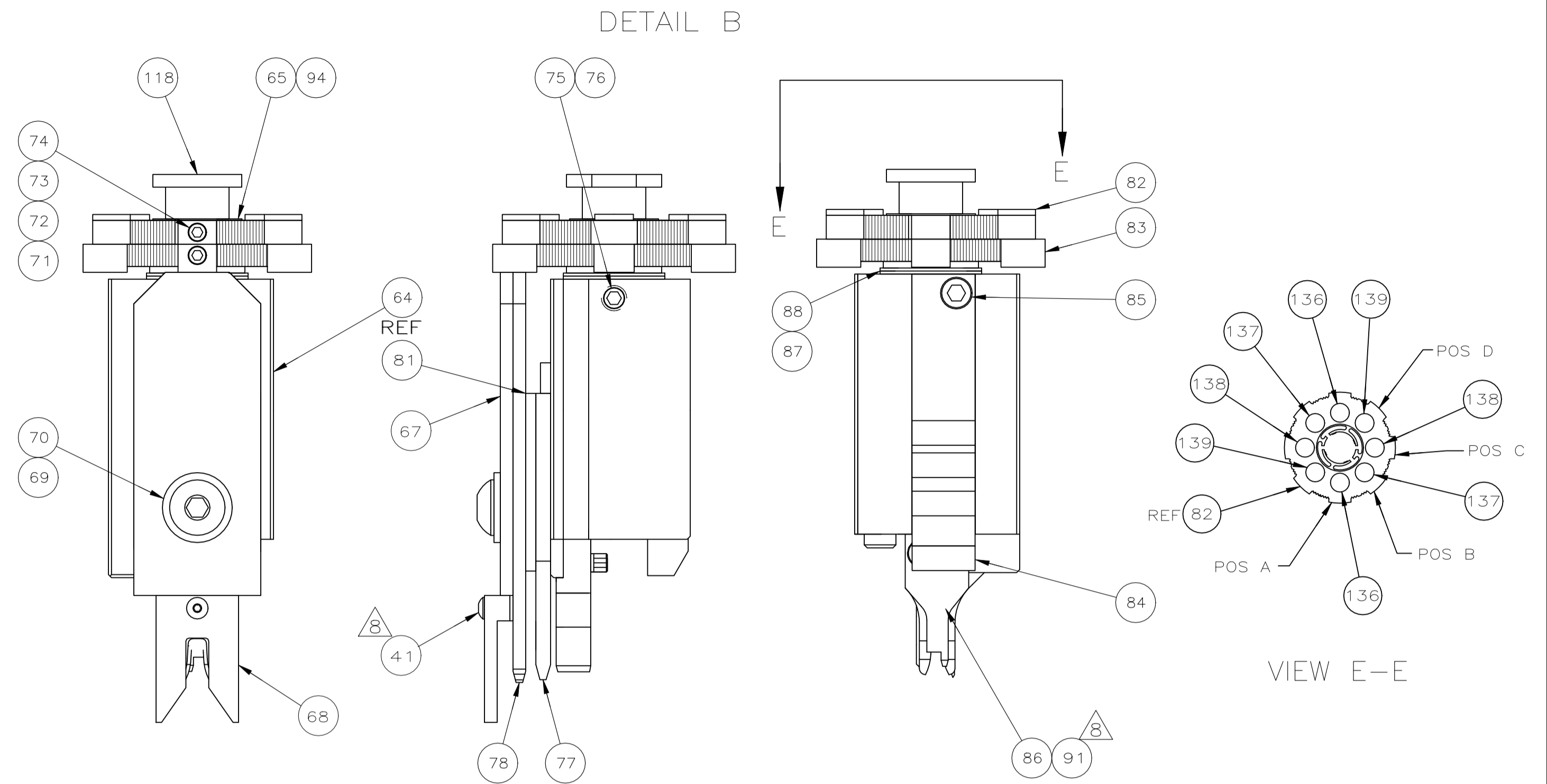
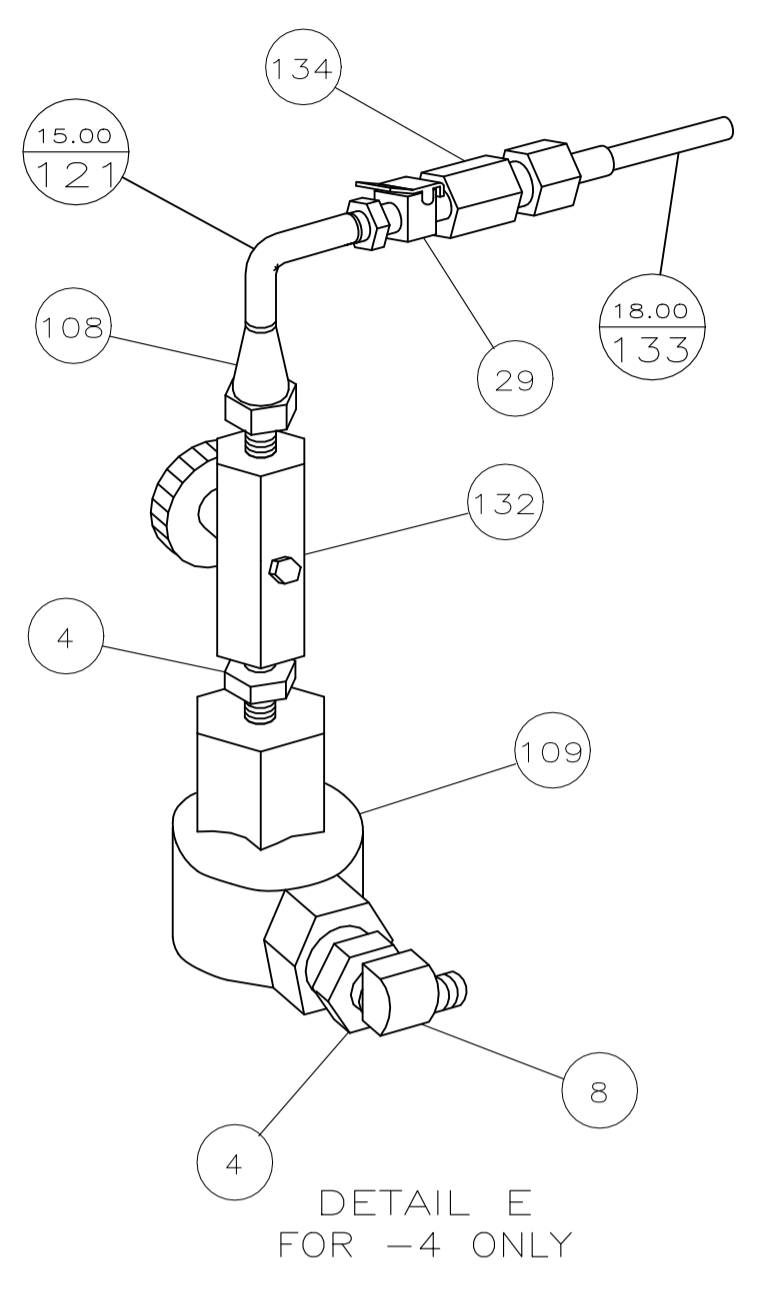
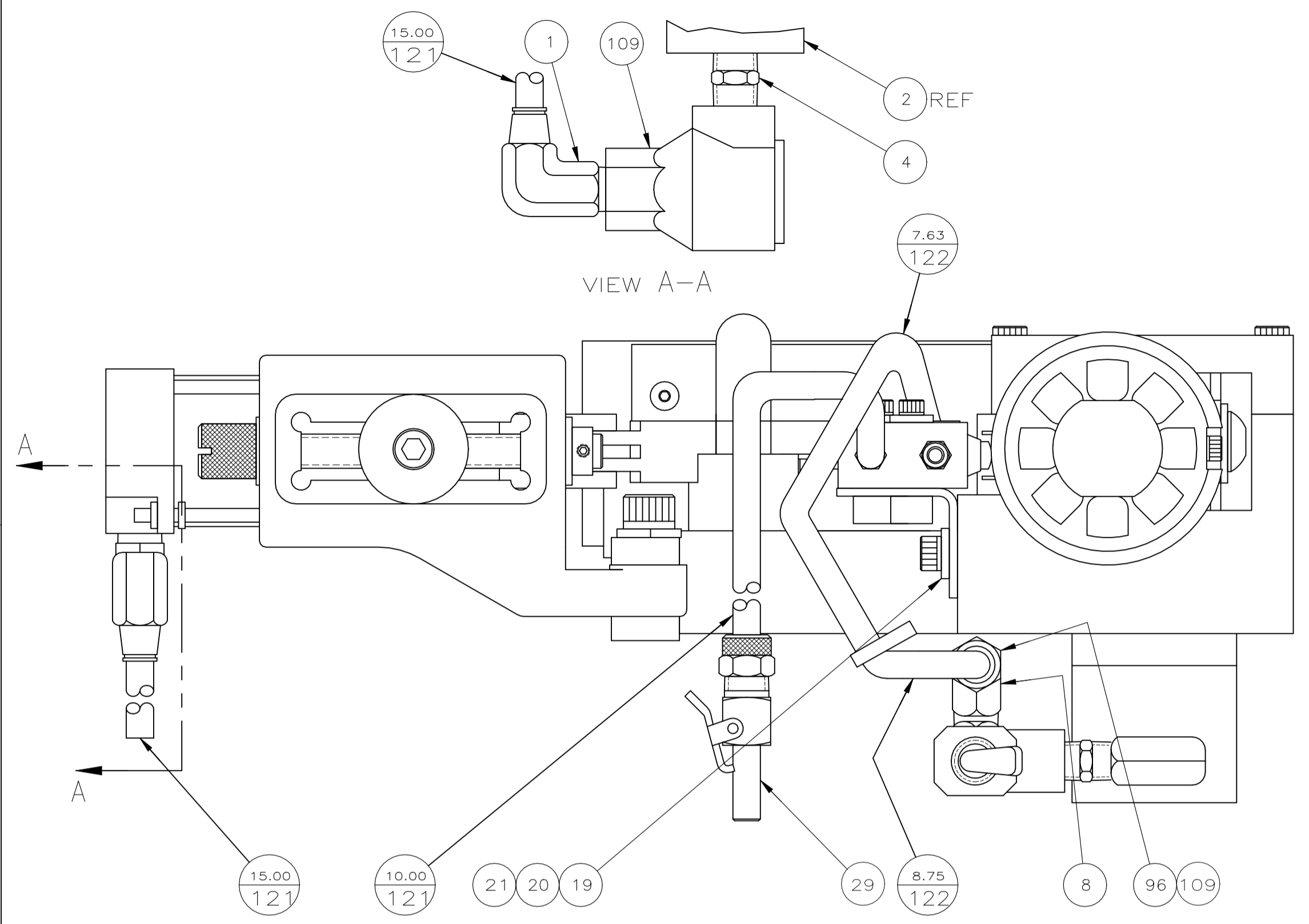
- 1. RECOMMENDED SPARE PARTS.
- 2. ITEMS NOT SHOWN ON ASSEMBLY.
- 3. TOLERANCE ON CUT LENGTH TO BE ±.13.
- 4. USED ON THE CLS I AND II MACHINES ONLY. REMOVE THE TWO MOUNTING SCREWS SECURING THE PRODUCT DEREELEER AND PLACE THE PRODUCT GUIDE (ITEM 111) ON TOP OF THE MOUNTING BRACKET. REASSEMBLE AND RETIGHTEN 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 1385813-4

- * 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.

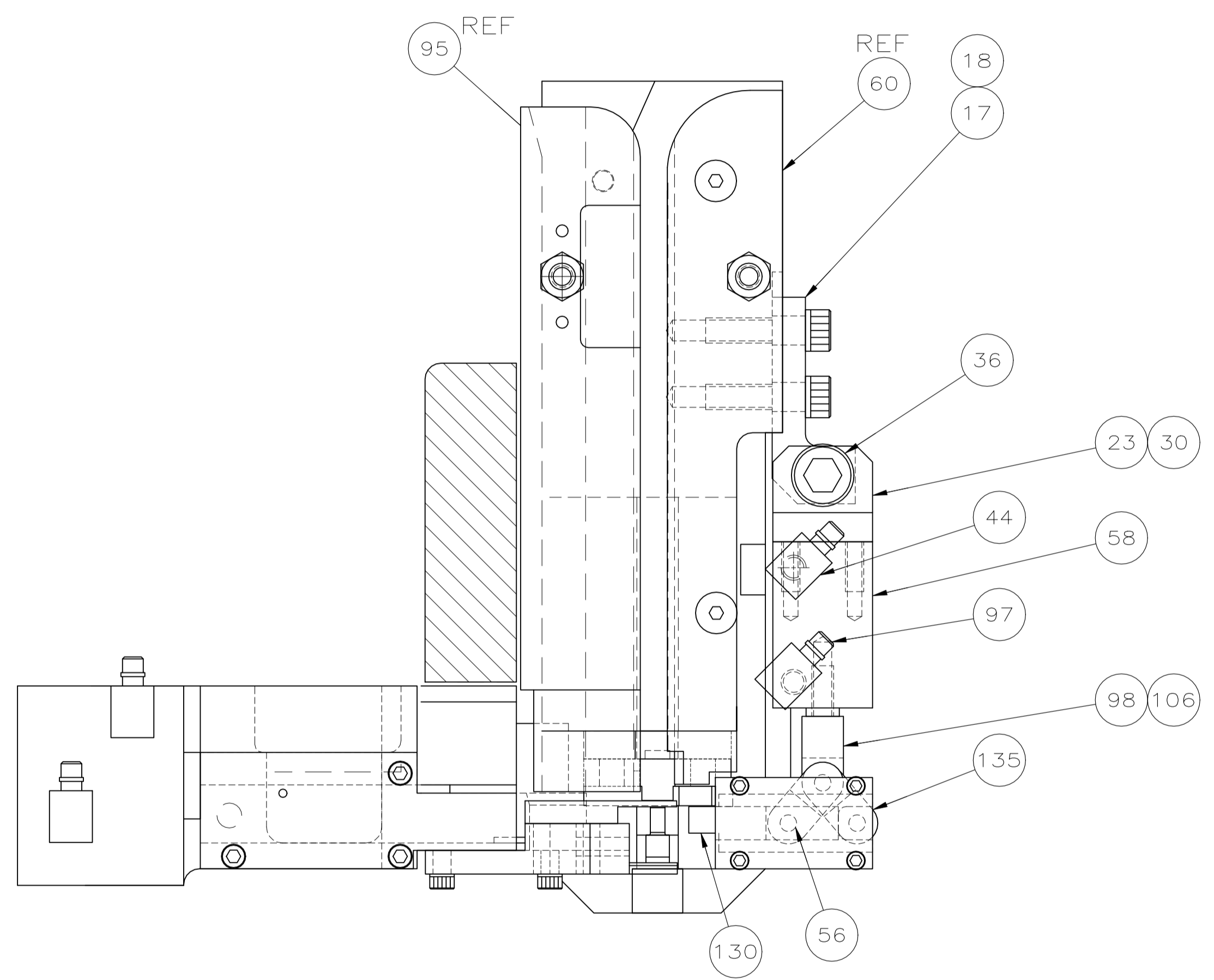
THIS DRAWING IS A CONTROLLED DOCUMENT.		DIN K STAKEM 24AUG2004	
		CHK C.ERISMAN 24AUG2004	
DIMENSIONS: INCHES	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APPV T.ELBIN 24AUG2004	NAME
	0. PLC ± -	PRODUCT SPEC	
	1. PLC ± -	APPLICATION SPEC	
	2. PLC ± -	SIZE	
	3. PLC ± -	CAGE CODE	
	4. PLC ± -	DRAWING NO	
	ANGLES ± -	RESTRICTED TO	
MATERIAL	FINISH	WEIGHT	SCALE 1:1 SHEET 1 OF 3 REV F1
		CUSTOMER DRAWING	

REVISIONS				
P	LTR	DESCRIPTION	DATE	APVD
-	-	SEE SHEET 1	-	-



THIS DRAWING IS A CONTROLLED DOCUMENT.		DWG: K. STAKEM 24AUG2004	
DIMENSIONS: INCHES		CHK: C. ERISMAN 24AUG2004	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD: T. ELBIN 24AUG2004	NAME: ULTRA-POD FLAG APPLICATOR
0. PLC	± .005	PRODUCT SPEC	SIZE: A1
1. PLC	± .002	APPLICATION SPEC	CAGE CODE: 00779
2. PLC	± .001	WEIGHT	DRAWING NO: 1385813
3. PLC	± .0005	CUSTOMER DRAWING	SCALE: 1:1
4. PLC	± .0002		SHEET 2 OF 3
ANGLES	± .0001		REV F1

REVISIONS				
P	LTR	DESCRIPTION	DATE	APPV
-		SEE SHEET 1	-	-



OBSOLETE		SUPERSEDED BY 1385813-1		OBSOLETE					
QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO			
2				3-354779-6	PIN, WIRE DISC (.3170)D	139			
2				2-354779-5	PIN, WIRE DISC (.3115)C	138			
2				1-354779-6	PIN, WIRE DISC (.3070)B	137			
2				354779-6	PIN, WIRE DISC (.3020)A	136			
2				1673387-1	LINK, TOGGLE	135			
2				1424324-1	AIR LINE KIT .250 TO 4mm	134			
3	18.00			27319-8	TUBING, POLY FLOW Ø156	133			
1				23054-1	VALVE, FLOW CONTROL	132			
2				679532-1	INSERT, GUARD	131			
1				1673388-2	FINGER, BACKUP	130			
						129			
						128			
						127			
						126			
1				679172-1	SPACER	125			
						124			
						123			
3	27.76	27.76	27.76	18912-4	HOSE, FLEXIBLE .250 OD	122			
3	25.00	25.00	25.00	27319-4	TUBE, PLASTIC .250 OD	121			
2				90647-1	GUARD, MODIFIED	120			
						119			
1				690212-1	POST, RAM	118			
1				464249-1	PLATE, IDENTIFICATION	117			
2				21017-2	SCR., DRIVE #2 X .19 LG	116			
						115			
						114			
2				6-21000-7	SCR., SHC 8-32UNC X 1.75 LG	113			
2				692655-5	VALVE ASSEMBLY	112			
4				768411-1	GUIDE, PRODUCT	111			
						110			
2				22374-7	VALVE, QUICK EXHAUST 1/8NPT	109			
1				980282-3	CONNECTOR, TUBING, MALE	108			
						107			
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				4-21006-5	SCR, SET, SOC CONE PT 8-32UNC X .62	98			
1				25545-4	10-32NS MUFFLER, EXHAUST	97			
1				18258-3	1/8NPTF CONNECTOR, TUBING TO MALE	96			
10				852762-1	GUIDE, REAR STRIP	95			
1				986950-1	WASHER, FLAT, PRECISION	94			
2				6-21002-2	SCR., BHC 10-24 X .38 LG	93			
1				1673397-1	COVER, VANE	92			
8				2-21000-6	SCR., SHC 8-32UNC X .38 LG	91			
1				852764-1	SHEAR, REAR	90			
2				852765-1	SPACER, SHEAR	89			
				690124-1	WASHER, RAM	88			
				690125-1	WASHER, LAMINATED	87			
1				852771-1	BLADE, SLUG	86			
1				2-21000-5	SCR., SHC 8-32UNC X .25 LG	85			
1				1213817-1	VALVE, CAM	84			
1				690142-1	DISC, INSULATION	83			
1				354777-1	DISC, WIRE CRIMP ADJ.	82			
1				1-455888-7	SPACER, CRIMPER	81			
						80			
						79			
1				1-853491-0	CRIMPER, INSULATION	78			
1				852743-6	CRIMPER, WIRE	77			
1				21009-6	SCR., SET, SOC 1/4-20UNC X .25 LG	76			
1				690191-1	PLUG, NYLON	75			
1				23030-1	SCR., SET, SOC 6-32UNC X .25 LG	74			
1				690170-1	SPRING, COMP.	73			
1				690603-1	SPRING, ASSIST	72			
1				23241-6	BALL, STEEL	71			
QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO			

OBSOLETE		SUPERSEDED BY 1385813-1		OBSOLETE					
QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO			
1				690686-3	SCR., BHC 5/16-24UNF X 1.00 LG	70			
1				3-238009-4	BLOCK, CRIMPER SPACER	69			
1				1633289-1	STABILIZER	68			
1				1633288-2	HOLDER, STABILIZER	67			
1				1428088-2	1/4, FITTING, Y, TUBE TO TUBE	66			
1				22480-5	WASHER, WAVE SPRING	65			
1				852768-3	RAM	64			
1				856391-2	CAP, RAM	63			
2				3-21000-9	SCR, SHC 10-32UNC X 1.00 LG	62			
2				2-21002-3	SCR., BHC 8-32UNC X .62 LG	61			
1				1673378-2	GUIDE, FRONT STRIP	60			
1				1633292-1	PLATE, BASE	59			
1				1725830-1	CYLINDER, COMPACT	58			
1				1673389-1	MOUNT, FINGER	57			
1				21030-1	Ø125 x .38 DOWEL PIN	56			
5				1-21000-3	SCR., SHC 4-40UNC X .25 LG	55			
4				21024-3	WASHER, LOC 6	54			
4				1673379-1	PLATE, STRIP GUIDE	53			
4				3-21002-3	SCR, BHC 1/4-20UNC X .50 LG	52			
1				1-464451-0	ARM, STOCK DRAG	51			
1				1-464452-3	DRAG, STOCK	50			
4				21055-5	WASHER, FLAT 6	49			
1				2-460680-8	FEED FINGER ASSEMBLY	48			
2				986377-1	VALVE, LEVER ROLLER	47			
2				22354-6	STUD 8-32UNC X 1.00 LG	46			
4				18326-2	ELBOW, TUBE TO MALE 10-32NPT	45			
5				18258-1	CONN., MALE TUBE TO MALE THD 10-32NPT	44			
1				1673390-1	COVER, FINGER	43			
						42			
1				1-21002-4	SCR, BHC 4-40UNC X .38 LG	41			
2				3-21002-3	SCR, BHC 1/4-20UNC X .50 LG	40			
4				2-21000-3	SCR., SHC 6-32UNC X .88 LG	39			
3				2-22733-8	SCR., BHC 1/4-20UNC X .63 LG	38			
1				1752764-1	HOUSING, APPLICATOR	37			
1				21004-1	SCR, SHLD .25 DIA X .38 LG	36			
4				21000-9	SCR., SHC 2-56 X .19 LG	35			
1				2-21002-6	SCR., SHC 10-32UNC X .38 LG	34			
						33			
1				354993-2	CYL., AIR, DOUBLE ACTING 1/8NPT	32			
						31			
2				1-21000-8	SCR., BHC 6-32UNC X .25 LG	30			
2				23238-1	INSERT, COUPLING	29			
1				1-23470-7	SPRING, COMP .240 DIA X 2.50 LG	28			
2				2-21002-4	SCR., BHC 8-32UNC X .75 LG	27			
1				22733-8	SCR., BHC 8-32UNC X .38 LG	26			
1				853088-8	ANVIL	25			
1				1673377-1	SHEAR, FRONT	24			
1				1673385-1	EYE, CYLINDER	23			
1				461690-3	SPACER, AIR FEED	22			
2				3-21000-4	SCR., SHC 10-32UNC X .38 LG	21			
2				21055-7	WASHER, FLAT 10	20			
1				1213818-1	BRACKET, VALVE	19			
2				3-21000-5	SCR., SHC 10-32 X .50 LG	18			
1				1673386-1	MOUNT, CYLINDER	17			
2				21024-5	WASHER, LOCK #10	16			
2				4-21000-2	SCR., SHC 10-32UNC X 1.75 LG	15			
1				1804005-1	INSERTER	14			
2				21022-2	NUT, FLEX 8-32UNC	13			
2				2-21002-1	SCR., 8-32UNC X .38 LG	12			
2				2-21006-3	SCR., SET, SOC CONE PT 4-40UNC X .38 LG	11			
2				21018-4	NUT, HEX 4-40UNC	10			
2				22281-6	SPRING, COMP. .300 DIA X .44 LG	9			
3				22306-1	1/8 MOD NPT ELBOW, STREET, 90°	8			
1				25545-1	1/8NPT MUFFLER, EXHAUST	7			
						6			
1				1673395-1	INSERTER, MOUNT	5			
3				22304-1	NIPPLE, HEX PIPE 1/8NPT	4			
1				985836-1	VALVE, TOGGLE 1/8NPT	3			
1				1-460277-2	AIR FEED ASSEMBLY	2			
1				985883-2	CONN., TUBING, MALE 1/8NPT-1/4 TUBE	1			
QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO			

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DIMENSIONS: INCHES	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DIN K. STAKEM 24AUG2004	TE Connectivity Ltd.
0 PLC ± .005	1 PLC ± .005	CHK C. FERISMAN 24AUG2004	NAME ULTRA POD FLAG APPLICATOR
2 PLC ± .005	3 PLC ± .005	APPV T. ELBIN 24AUG2004	APPLICATION SPEC
4 PLC ± .005	ANGLES ± .1	SIZE A1	CAGE CODE 00779
MATERIAL	FINISH	WEIGHT	DRAWING NO 1385813
			RESTRICTED TO
			SCALE 1:1 SHEET 3 OF 3 REV F1