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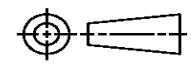
LOC		DIST		REVISIONS			
P	LTR	DESCRIPTION		DATE	DWN	APVD	
	G1	ECR-12-014448		15/08/2012	BH	BH	

Dimensioning and tolerancing per ASME Y14.5M-2009

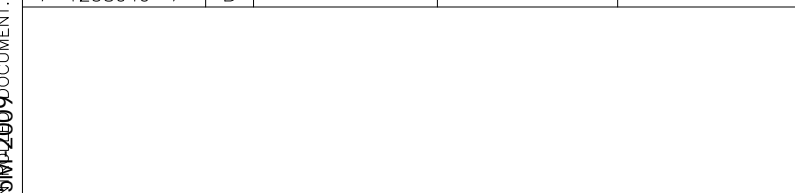
REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2151496-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1238049 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 1238049

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	BOB HIGMAN		 TE Connectivity		
DIMENSIONS:		CHK	T.ELBIN				
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME			
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APVD		G.BAILEY	
MATERIAL		FINISH		PRODUCT SPEC		SIDE FEED, HDI APPLICATOR	
				APPLICATION SPEC		RESTRICTED TO	
				SIZE	CAGE CODE	DRAWING NO	
				A3		©- 1238049	
				WEIGHT		SCALE	SHEET 1 OF 2 REV G1

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1238049-1	F	-	LEADMAKER	MECH POST FEED	CUTS CARRIER
1238049-2	G	-	BENCH	MECH PRE FEED	CUTS CARRIER
1238049-6	F	-	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1238049-1	F	-	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1238049-2	G	-	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1238049-6	F	-	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1238049-7	B	-	-	-	SPARE PARTS KIT



CRIMP DATA (AMP TERMINAL)
TERMINAL NAME: PIN, SOCKET

CRIMP	SIZE	TYPE	RANGE
WIRE	1.40 [.055 IN]	F	20-24
INSUL	1.57 [.062 IN]	0	1.3-1.5 [.050-.060 IN]
WIRE STRIP LENGTH	APPL INSTRUCTION 408-8322		
TERMINAL APPL SPEC	114-10000	-	FEED 7.6 [.300 IN]

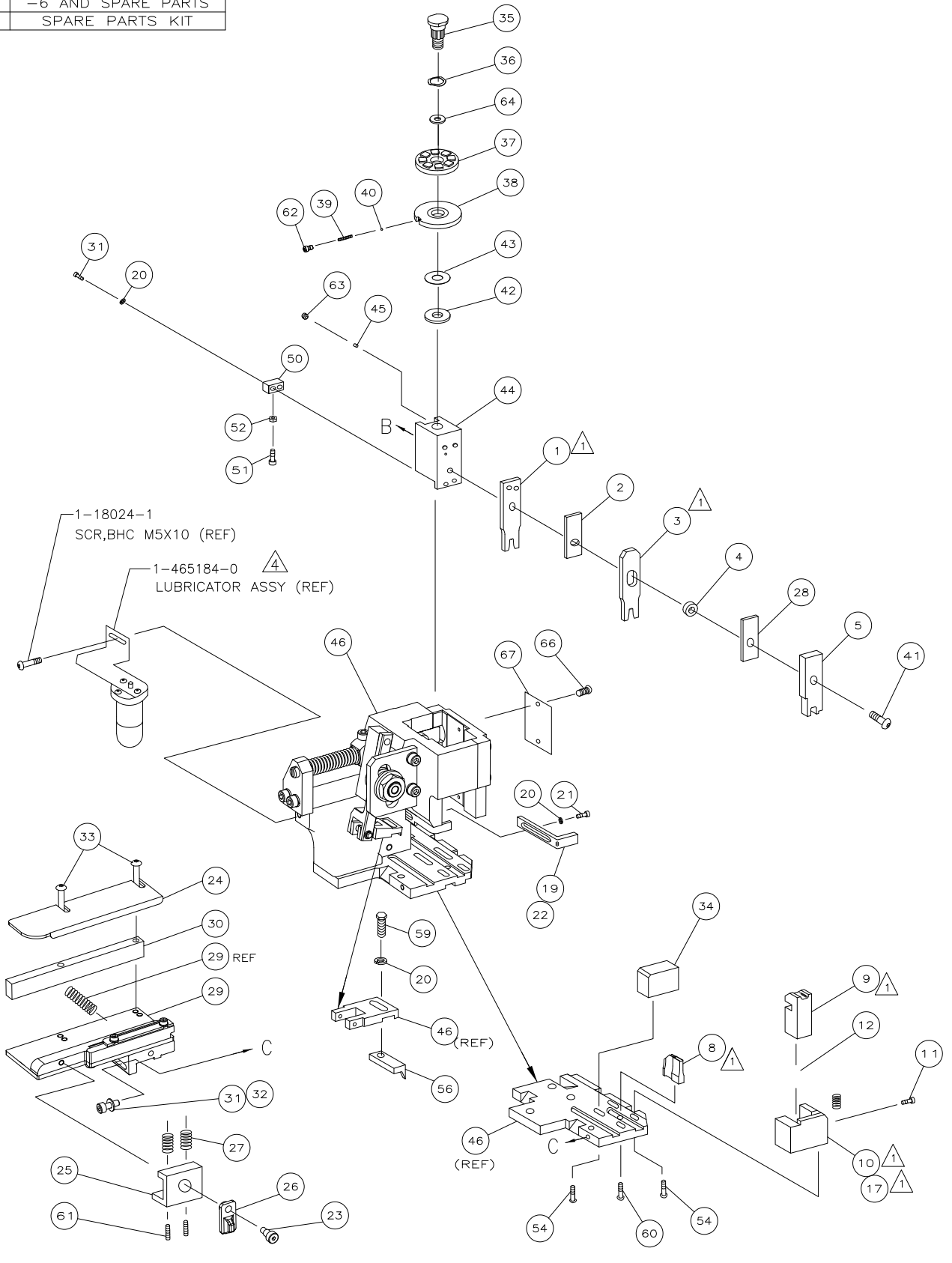
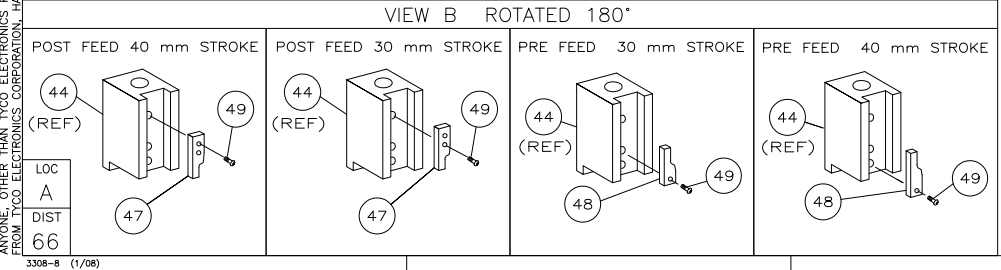
TERMINALS APPLIED

PIN	SOCKET	-	-	-
66506	66504	-	-	-
166053	166051	-	-	-
786743	1658537	-	-	-
1658539	-	-	-	-

WIRE SIZE mm² AWG	CRIMP HEIGHT	PIN PN & LENGTH [IN]
20	0.81 ±0.05 [.032 ±.002 IN]	5-354779-2 [.3250]
22 OR 24	0.81 ±0.05 [.032 ±.002 IN]	5-354779-2 [.3250]
.22mm²	0.81 ±0.05 [.032 ±.002 IN]	5-354779-2 [.3250]
.50mm²	0.81 ±0.05 [.032 ±.002 IN]	5-354779-3 [.3255]

SET UP GAGE 458637-3	LAYOUT L2383
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- 1. 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.
- 4. CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.



QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO						
-	1	1	1	1	1	1	1238049	PRINT, APPLICATOR LOG SHEET	73
-	1	1	1	1	1	1	1338705-1	DOCUMENTATION PACKAGE	72
-	-	-	-	-	-	-	-	-	70
-	-	-	-	-	-	-	-	-	69
-	-	-	-	-	-	-	-	-	68
-	1	1	1	1	1	1	461264-1	PLATE, IDENTIFICATION	67
-	2	2	2	2	2	2	21017-2	SCR,DRIVE(#2x.19)ID PLATE	66
-	-	-	-	-	-	-	-	-	65
-	1	1	1	1	1	1	986950-1	WASHER, FLAT PRECISION	64
-	1	1	1	1	1	1	3-18031-0	SCR,SKT SET(M6X6 LW)RAM	63
-	1	1	1	1	1	1	18023-9	SCR,SHC(M4X6)INS DISC	62
-	2	2	2	2	2	2	2-18032-5	SCR,SOC SET(M5X20)DRAG	61
-	1	1	1	1	1	1	18024-7	SCR,BHC(M4X10)ANVIL	60
-	1	1	1	1	1	1	5-18022-2	SCR,HEX(M4X8)FEED FINGER	59
-	-	-	-	-	-	-	-	-	58
-	-	-	-	-	-	-	-	-	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	-	-	-	-	-	-	-	-	55
-	4	4	4	4	4	4	18024-8	SCR,BHC(M4x12)SHEAR HOLDER	54
-	-	-	-	-	-	-	-	-	53
-	1	1	1	1	1	1	18030-1	NUT,HEX(M3)HOLD DOWN	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLDDOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	1	1	1	1	1	18024-3	SCR,BHC(M3X10)CAM	49
-	-	-	-	-	-	-	-	-	48
-	1	1	1	1	1	1	1338675-1	CAM, PRE FEED 30 & 40 mm ST	47
-	1	1	1	1	1	1	1338676-1	CAM, POST FEED 30 & 40 mm ST	46
-	1	1	1	1	1	1	1320999-3	APPLICATOR BASIC SUBASSY	45
-	1	1	1	1	1	1	690191-1	PLUG, NYLON	44
-	1	1	1	1	1	1	1338660-3	RAM	43
-	1	1	1	1	1	1	690125-1	WASHER, LAMINATED	42
-	1	1	1	1	1	1	690124-1	WASHER, RAM	41
-	1	1	1	1	1	1	2-18024-6	SCR,BHC(M8X25)RAM	40
-	1	1	1	1	1	1	23241-1	BALL, STEEL	39
-	1	1	1	1	1	1	2-22278-7	SPRING, COMPRESSION	38
-	1	1	1	1	1	1	1320922-1	DISC, INSULATION	37
-	1	1	1	1	1	1	354777-1	WIRE DISC, PLASTIC	36
-	1	1	1	1	1	1	22480-5	WASHER, SPRING	35
-	1	1	1	1	1	1	690212-1	POST, RAM	34
-	1	1	1	1	1	1	1424186-1	SUPPORT, TERMINAL	33
-	2	2	2	2	2	2	1-18024-0	SCR,BHC(M4X20)STRIP GUIDE	32
-	1	1	1	1	1	1	18027-2	WASHER, FLAT(M4)	31
-	3	3	3	3	3	3	1-18023-2	SCR,SKT CAP(M4X12)MOUNT BLOCK	30
-	1	1	1	1	1	1	1320908-4	SPACER, STRIP GUIDE	29
-	1	1	1	1	1	1	1633073-1	STRIP GUIDE PLATE ASSY	28
-	1	1	1	1	1	1	1-455888-0	SPACER, FRONT SHEAR DEP	27
-	2	2	2	2	2	2	1-22284-0	SPRING, DRAG	26
-	1	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	25
-	1	1	1	1	1	1	679754-1	DRAG, TERMINAL	24
-	1	1	1	1	1	1	1320928-1	GUIDE, STRIP (REAR)	23
-	1	1	1	1	1	1	980371-4	SCR,SHC SHLD	22
-	1	1	1	1	1	1	690472-2	STRIPPER	21
-	1	1	1	1	1	1	1-18023-1	SCR,SHC(M4X10)STRIPPER	20
-	3	3	3	3	3	3	18025-2	WASHER,LOCK(M4)STRIPPER	19
-	-	-	-	-	-	-	-	-	18
-	1	-	-	1	-	-	1338684-1	HOLDER, SHEAR, FRONT (NO-CUT)	17
-	-	-	-	-	-	-	-	-	16
-	-	-	-	-	-	-	-	-	15
-	-	-	-	-	-	-	-	-	14
-	-	-	-	-	-	-	-	-	13
-	1	1	1	1	1	1	3-22280-3	SPRING, SHEAR	12
-	1	1	1	1	1	1	356885-4	STOP, SHEAR	11
-	-	1	1	-	1	1	1320921-1	HOLDER, SHEAR, FRONT (CUT)	10
-	1	1	1	1	1	1	462006-1	SHEAR, FLOAT (FRONT)	9
1	2	2	2	1	1	1	1338690-9	ANVIL	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	1-455889-8	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	1	1	1	2-238011-0	SPACER, BLOCK CRIMPER	4
1	2	2	2	1	1	1	5-456135-7	CRIMPER, INSULATION	3
-	1	1	1	1	1	1	455888-3	SPACER, CRIMPER	2
1	2	2	2	1	1	1	1-456402-5	CRIMPER, WIRE	1

QTY REQD PER ASSY

Q	T.KINT	15MAY00	MATERIAL	HEAT TREAT
1	CHK	-	-	-
APVD	15MAY00	Tyco Electronics Corporation Harrisburg, PA 17105-3608		
T.ELBIN	NAME	SIDE FEED HD-1 APPLICATOR		
SCALE	SIZE	DRAWING NO	SHEET	REV
-	A1	1238049	1 of 1	G

DIMENSIONS: INCHES
TOLERANCES UNLESS OTHERWISE SPECIFIED:
 0 PLC ±.001
 1 PLC ±.002
 2 PLC ±.003
 3 PLC ±.004
 4 PLC ±.005

ANGLES: SURFACE TEXTURE

REVISION RECORD

REV	DATE	BY	REASON
G	10-2009	MY	TE
P	LTR	REVISION RECORD	

DRAWING NUMBER - 1238049 SHEET 2 OF 2 REV. G

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