

PART NUMBER	REV	FIRST USED
1385725-1	K	AOM / CLS
1385725-2	D	K UNIT
1385725-3	K	G UNIT
1385725-4	K	KOMAX

OBSOLETE
SUPERSEDED BY 1385725-1
OBSOLETE

REVISIONS				
#	LR	DESCRIPTION	DATE	APP'D
K1		REVISED PER ECR-23-190096	19OCT2023	GK TE

TERMINAL APPLIED:	
521470	
521596	
521598	
521600	
1969106	
1969107	

CRIMPING DATA				
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	STRIP LENGTH	
A	.052	18	.195	
B	.047	20		
C	.043	22		
D	-	-		
CRIMP WIRE	SIZE	TYPE	FEED	TERM SPEC
	.070	F	.580	114-2124
INSUL	.140	0		
INSUL RANGE	WIRE RANGE	APPLICATOR INSTRUCTION SHEET		
060-.110	22-18	AI 8099 AI 8102		

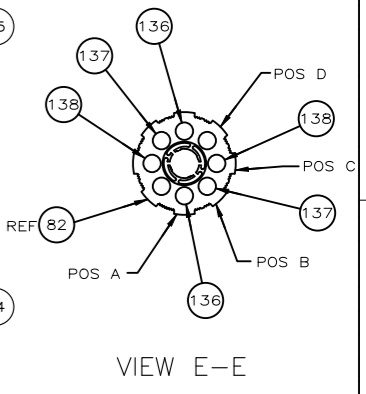
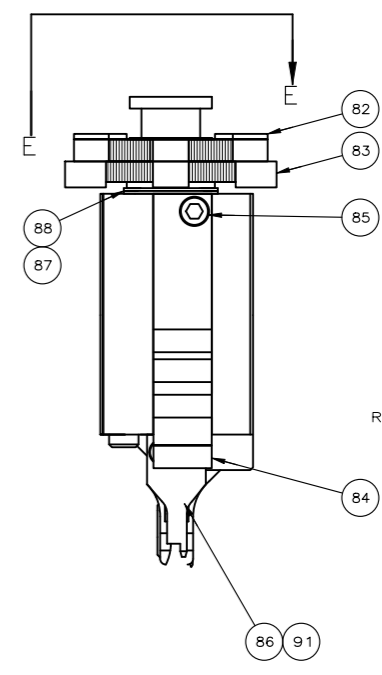
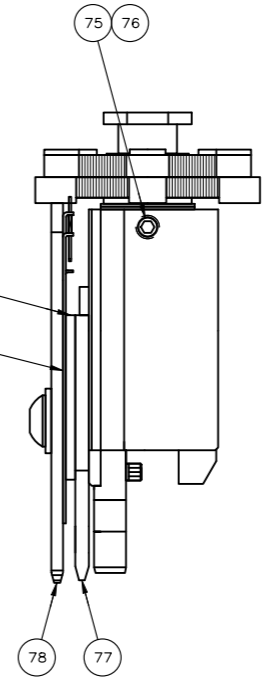
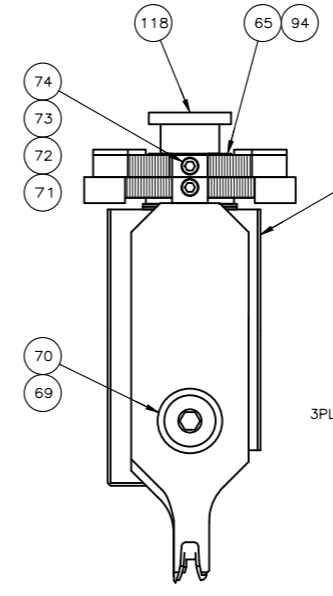
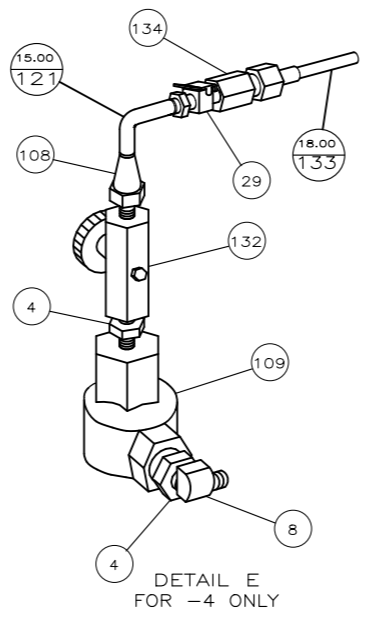
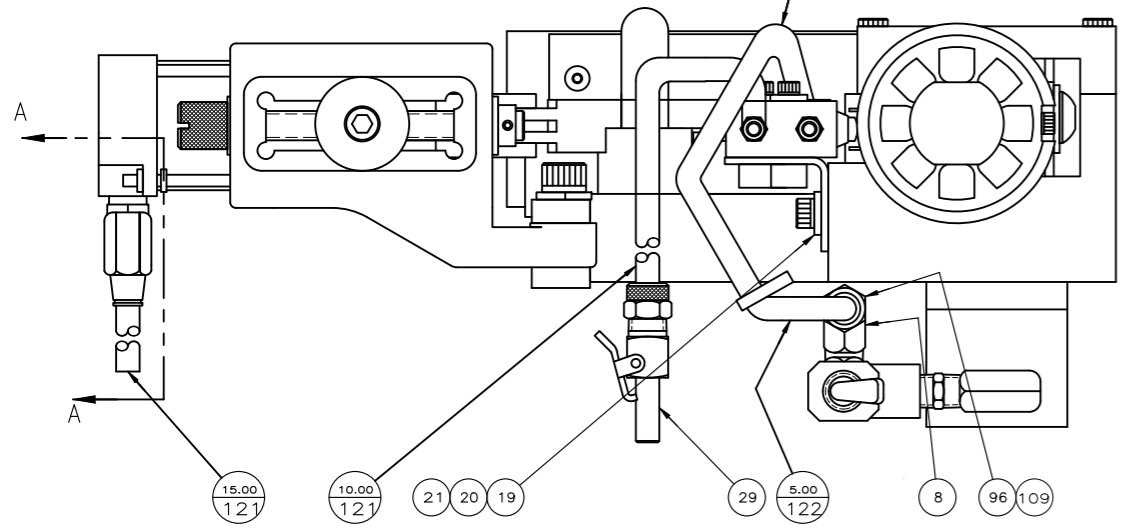
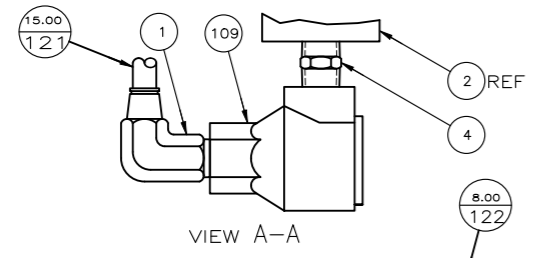
- 1 RECOMMENDED SPARE PARTS.
- 2 ITEMS NOT SHOWN ON ASSEMBLY.
- 3 TOLERANCE ON CUT LENGTH TO BE ± 1.3 .
- 4 USED ON THE CLS I AND II MACHINES ONLY. REMOVE THE TWO MOUNTING SCREWS SECURING THE PRODUCT DEREELEER AND PLACE THE PRODUCT GUIDE (ITEM 111) ON TOP OF THE MOUNTING BRACKET. REASSEMBLE AND RETIGHTEN 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 1385725-4 (REFERENCE ONLY)

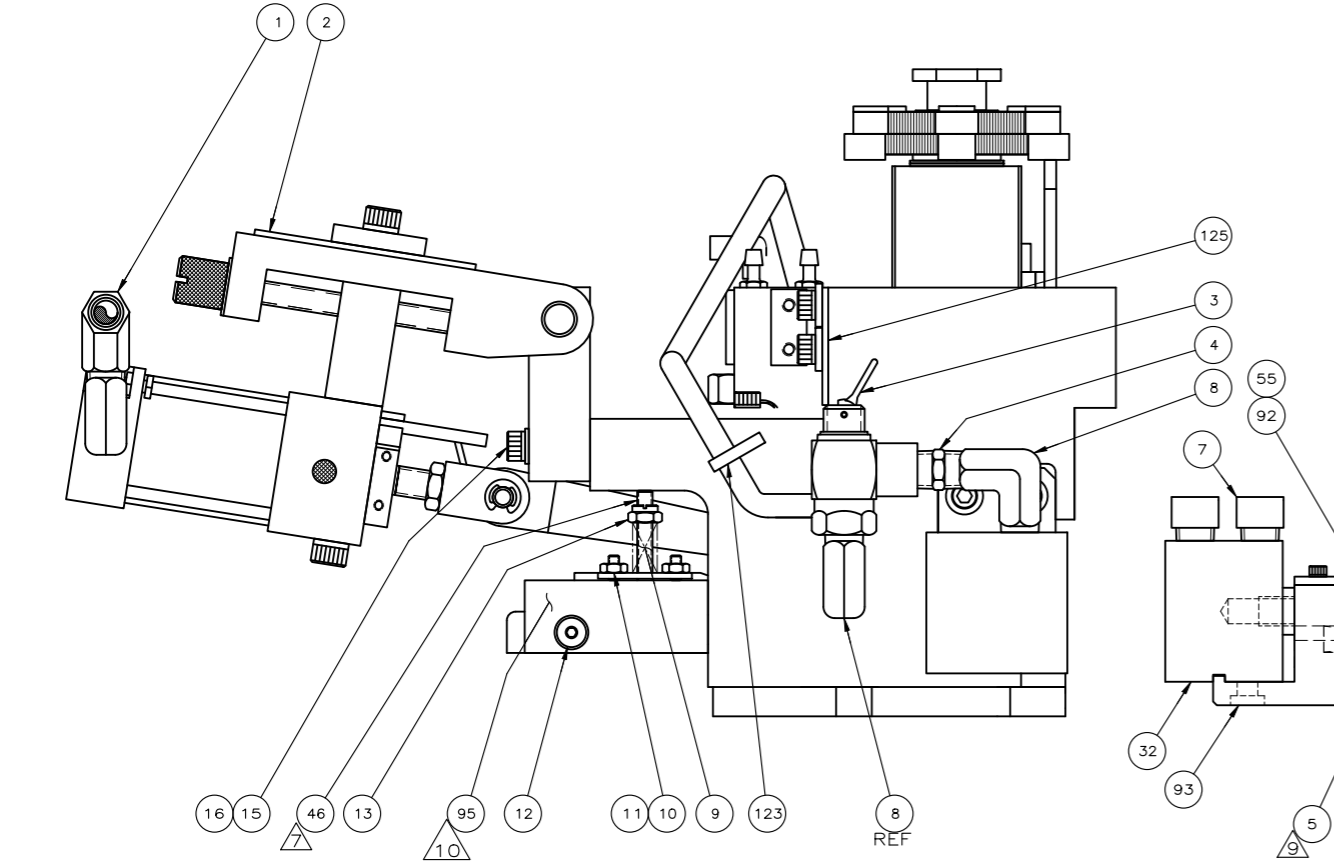
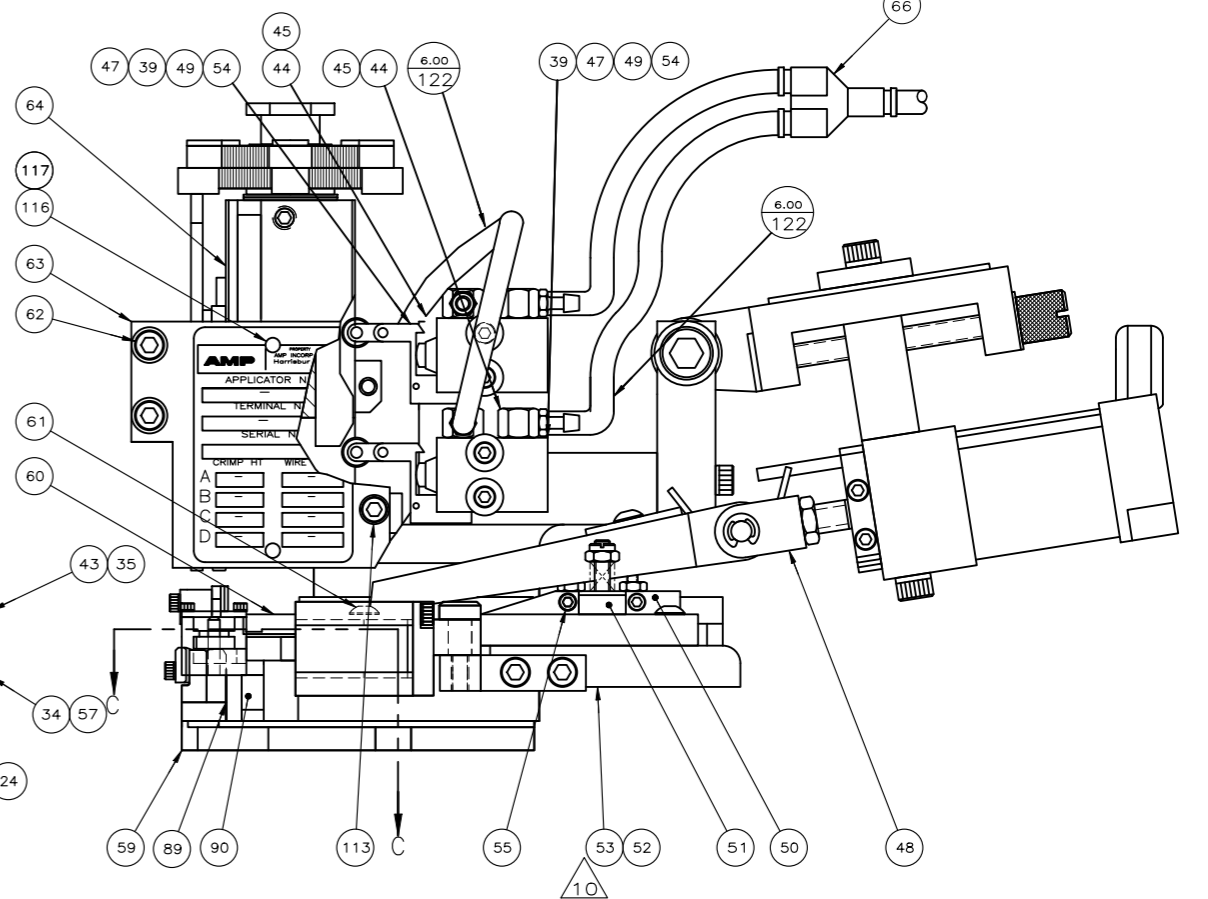
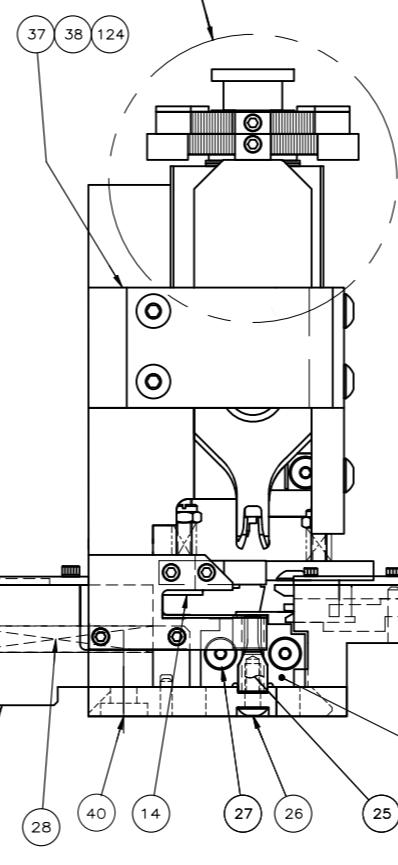
- * MUST USE SPRING LOADED TONKER (P/N 1-509538-7).
- * TRIGGER POINT WHEN PRESS IS MOVING UP MUST BE SET AT 1.38".
- * ~~PROCESS SPEED MUST BE SET TO 90%.~~
- * ACTUATION SPEED FOR FEED CYLINDER MUST BE SET AT 350 MILLISECONDS.
- * OPTIMIZATION MUST BE UNCHECKED.
- * SET REFERENCE PRESS HEIGHT SETTING 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.
- * FEED PAWL MUST BE SET UP AS CLOSE AS POSSIBLE TO THE SKATE DRAG.

THIS DRAWING IS A CONTROLLED DOCUMENT.		DRW K. STAKEM 11FEB2004	TE Connectivity Ltd.	
DIMENSIONS: INCHES		CHK C. ERISMAN 11FEB2004	NAME ULTRA POD FLAG APPLICATOR	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± - 1 PLC ± - 2 PLC ± - 3 PLC ± - 4 PLC ± - ANGLES ± -		APVD T. FLBIN 11FEB2004	PRODUCT SPEC APPLICATION SPEC	
MATERIAL	FINISH	WEIGHT	SIZE A1	CAGE CODE 00779
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1	DRAWING NO 1385725	RESTRICTED TO -
		SHEET 1	OF 3	REV K1

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

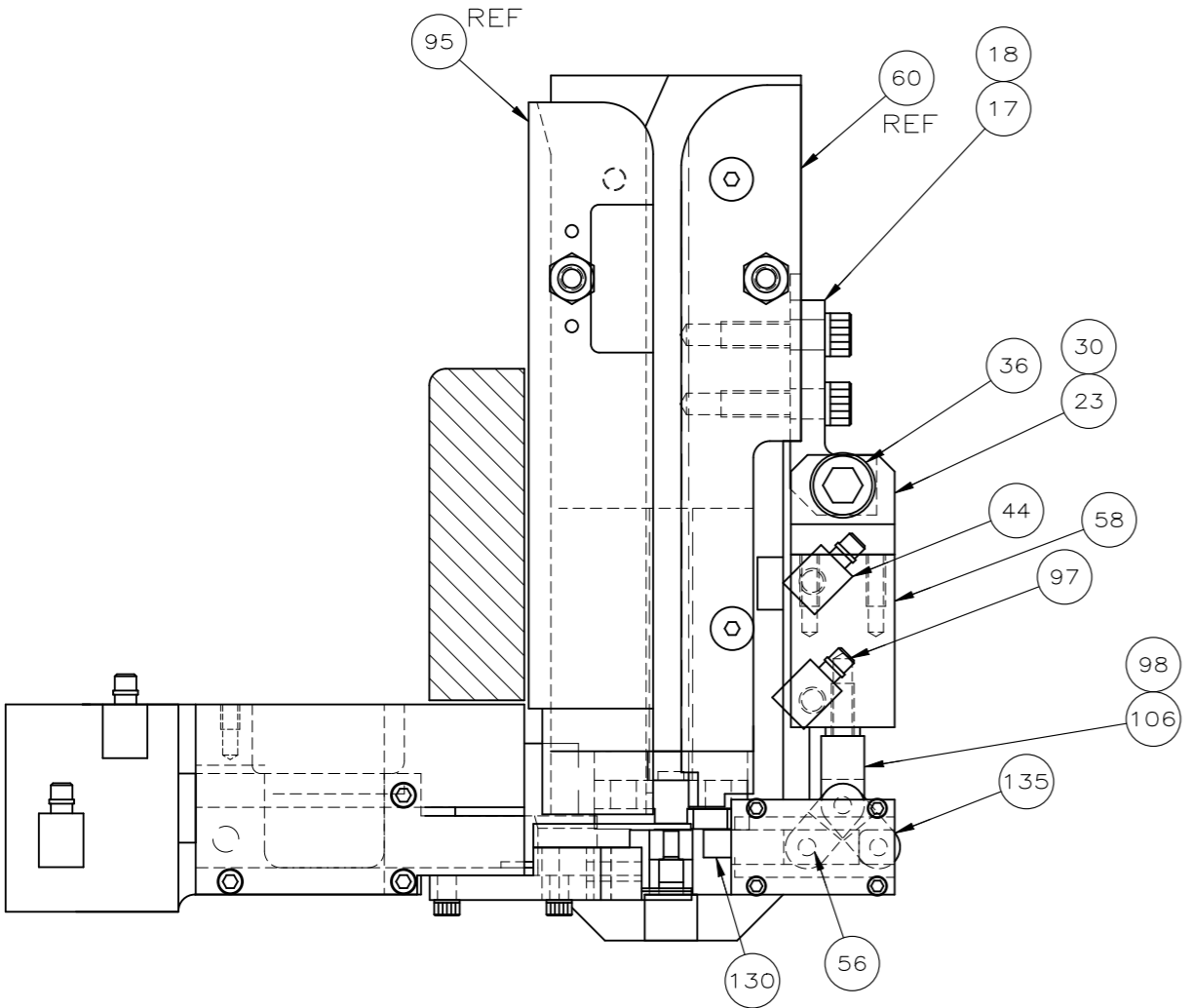


SEE DETAIL B



THIS DRAWING IS A CONTROLLED DOCUMENT.		DRW: K. STAKEM 11FEB2004	TE Connectivity Ltd.
		CHK: C. ERISMAN 11FEB2004	
DIMENSIONS: INCHES TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± .005 1 PLC ± .005 2 PLC ± .005 3 PLC ± .005 4 PLC ± .005 ANGLES ± .5°		NAME: T. FLBIN PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 1385725 RESTRICTED TO:
MATERIAL: -		FINISH: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:1 SHEET: 2 of 3 REV: K1

REVISIONS				
P	LR	DESCRIPTION	DATE	APPD
-	-	SEE SHEET 1	-	-



OBSOLETE		SUPERSEDED BY 1385725-1		OBSOLETE		QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
2	2	2	2	-	-	-	5-354779-3	PIN, WIRE DISC (.3255)C	139
2	2	2	2	-	-	-	4-354779-2	PIN, WIRE DISC (.3200)B	138
2	2	2	2	-	-	-	3-354779-3	PIN, WIRE DISC (.3155)A	137
2	2	2	2	-	-	-	1673387-1	LINK, TOGGLE	136
2	2	2	2	-	-	-	1424324-1	AIR LINE KIT .250 TO 4mm	135
3	18.00	-	-	-	-	IN	27319-8	TUBING, POLY FLOW ϕ 1.56	134
2	REF	-	-	-	-	-	23054-1	VALVE, FLOW CONTROL	133
2	REF	-	-	-	-	-	679532-1	INSERT, GUARD	132
1	1	1	1	-	-	-	1673388-2	FINGER, BACK-UP	131
3	3	3	3	-	-	-	1424350-1	HOLDER, PIN, WIRED	130
1	1	1	1	-	-	-	2-23147-2	SPRING, DEPRESSOR	129
1	1	1	1	-	-	-	1490524-2	SPACER, DEPRESSOR	128
1	1	1	1	-	-	-	1490525-2	DEPRESSOR, WIRE	127
1	1	1	1	-	-	-	679172-1	SPACER	126
1	1	1	1	-	-	-	-	-	125
1	1	1	1	-	-	-	19832-1	TIE, WIRE	124
3	27.00	27.00	27.00	IN	IN	18912-4	HOSE, FLEXIBLE .250 OD	123	
25	25.00	25.00	25.00	IN	IN	27319-4	TUBE, PLASTIC .250 OD	122	
2	-	-	-	-	-	-	90647-1	GUARD, MODIFIED	121
1	-	-	-	-	-	-	-	-	120
1	-	-	-	-	-	-	-	-	119
1	-	-	-	-	-	-	690212-1	POST, RAM	118
1	-	-	-	-	-	-	464249-1	PLATE, IDENTIFICATION	117
2	2	2	2	-	-	-	21017-2	SCR., DRIVE #2 X .19 LG	116
2	2	2	2	-	-	-	-	-	115
2	2	2	2	-	-	-	6-21000-7	SCR., SHC 8-32UNC X 1.75 LG	114
2	2	2	2	-	-	-	692655-5	VALVE ASSEMBLY	113
4	2	2	2	-	-	-	768411-1	GUIDE, PRODUCT	112
2	2	2	2	-	-	-	22374-7	VALVE, QUICK EXHAUST 1/8NPT	111
2	2	2	2	-	-	-	980282-3	CONNECTOR, TUBING, MALE	110
1	-	-	-	-	-	-	-	-	109
1	-	-	-	-	-	-	1673636-1	CLEVIS, CYLINDER	108
1	-	-	-	-	-	-	1-455750-3	GUARD ASSEMBLY	107
1	-	-	-	-	-	-	22307-1	BUSHING, PIPE, FITTING 1/4NPT	106
1	-	-	-	-	-	-	23791-2	TEE, PIPE, FITTING 1/4NPT	105
2	-	-	-	-	-	-	28580-1	FILTER, MINATURE 1/4NPT	104
1	-	-	-	-	-	-	22311-2	NIPPLE, CLOSE 1/4NPT	103
1	-	-	-	-	-	-	28582-1	LUBRICATOR 1/4NPT	102
1	-	-	-	-	-	-	26108-1	BODY, QUICK CONNECT	101
1	-	-	-	-	-	-	4-21006-4	SCR, SOC SET 8-32 X .50	100
1	-	-	-	-	-	-	25545-4	MUFFLER, EXHAUST	99
10	1	1	1	-	-	-	18258-3	CONN., TUBING, MALE 1/8NPT-1/4 TUBE	98
2	2	2	2	-	-	-	1752763-1	GUIDE, REAR STRIP	97
2	2	2	2	-	-	-	986950-1	WASHER, FLAT PRECISION	96
2	2	2	2	-	-	-	6-21002-2	SCR, BHC 10-24 X .39 LG.	95
2	2	2	2	-	-	-	1673397-1	COVER, VANE	94
2	2	2	2	-	-	-	2-21000-6	SCR., SHC 8-32UNC X .38 LG	93
2	2	2	2	-	-	-	852764-2	SHEAR, REAR	92
2	2	2	2	-	-	-	852765-2	SPACER, SHEAR	91
1	1	1	1	-	-	-	690124-1	WASHER, RAM	90
1	1	1	1	-	-	-	690125-1	WASHER, LAMINATED	89
1	1	1	1	-	-	-	1752734-1	BLADE, SLUG	88
1	1	1	1	-	-	-	2-21000-5	SCR., SHC 8-32UNC X .25 LG	87
1	1	1	1	-	-	-	1213817-1	VALVE, CAM	86
1	1	1	1	-	-	-	690142-1	DISC, INSULATION	85
1	1	1	1	-	-	-	354777-1	DISC, WIRE CRIMP ADJ.	84
1	1	1	1	-	-	-	455888-6	SPACER, CRIMPER	83
1	1	1	1	-	-	-	-	-	82
1	1	1	1	-	-	-	-	-	81
1	1	1	1	-	-	-	-	-	80
1	1	1	1	-	-	-	-	-	79
1	1	1	1	-	-	-	853491-2	CRIMPER, INSULATION	78
1	1	1	1	-	-	-	852743-3	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						

OBSOLETE		SUPERSEDED BY 1385725-1		OBSOLETE		QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
1	-	-	-	-	-	-	7-21002-9	SCR., BHC 5/16-24UNF X 1.00 LG	70
1	-	-	-	-	-	-	238009-1	BLOCK, CRIMPER SPACER	69
1	-	-	-	-	-	-	-	-	68
1	-	-	-	-	-	-	-	-	67
1	-	-	-	-	-	-	1428088-2	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	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	-	-	-	1633285-1	GUIDE, FRONT STRIP	60
1	1	1	1	-	-	-	1673380-1	PLATE, BASE	59
1	1	1	1	-	-	-	1725830-1	CYLINDER, COMPACT	58
1	1	1	1	-	-	-	1673389-2	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	-	-	-	2-460680-7	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
-	-	-	-	-	-	-	-	-	41
2	2	2	2	-	-	-	3-21002-3	SCR, SHC 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 10-32UNC 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	-	-	-	853088-5	ANVIL	25
1	1	1	1	-	-	-	1673377-1	SHEAR, FRONT	24
-	-	-	-	-	-	-	1673385-1	EYE, CYLINDER	23
-	-	-	-	-	-	-	-	-	22
2	2	2	2	-	-	-	3-21000-4	SCR., SHC 10-32UNC 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
2	2	2	2	-	-	-	21024-5	#10 LOCK WASHER	16
2	2	2	2	-	-	-	3-21000-9	SCR., SHC 10-32UNC 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	-	-	-	22281-6	SPRING, COMP. .300 DIA X .44 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	2	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
-	-	-	-	-	-	-	985883-2	CONN., TUBING, MALE 1/8NPT-1/4 TUBE	1
QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO						

THIS DRAWING IS A CONTROLLED DOCUMENT. DWG: K. STAKEM 11FEB2004
 CHK: G. ERISMAN 11FEB2004
 APPD: T. ELFIN 11FEB2004

TE TE Connectivity Ltd.

ULTRA POD FLAG APPLICATOR

PRODUCT SPEC: -
 APPLICATION SPEC: -
 MATERIAL: -
 FINISH: -
 WEIGHT: -

SIZE: A1
 CASE CODE: 00779
 DRAWING NO: 1385725
 RESTRICTED TO: -

CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:1 SHEET: 3 OF 3 REV: K1