

PART NUMBER	REV	FIRST USED	TERMINALS APPLIED
1385724-1	E	AOM / CLS	521471 1969133
1385724-2	A	K UNIT	521597
1385724-3	E	G UNIT	521599
1385724-4	E	KOMAX	521601

~~DISOLETE~~
~~SUPERSEDED BY 1385724-1~~
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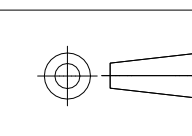
REVISIONS				
P	LTR	DESCRIPTION	DATE	BYN
E1		REVISED PER ECR-23-190096	19OCT2023	GK

CRIMPING DATA				
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	STRIP LENGTH	
A	.061	#14	.195-.240	
B	.055	(2)#18		
C	.052	#16		
D	.047	#18		
CRIMP	SIZE	TYPE	FEED	TERM SPEC
WIRE	.110	F	.580	114-2124
INSUL	.220	0		
INSUL RANGE	WIRE RANGE	APPLICATOR INSTRUCTION SHEET		
.110-.150	18-14	AI 8099		
(2).110MAX	(2)18	AI 8102		

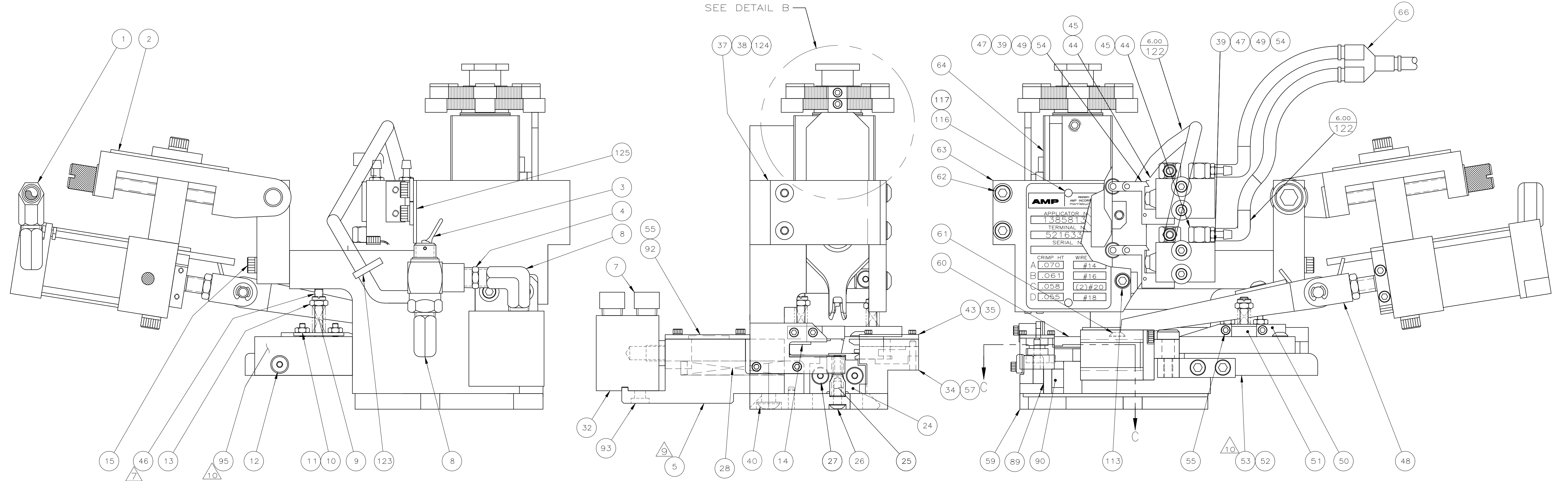
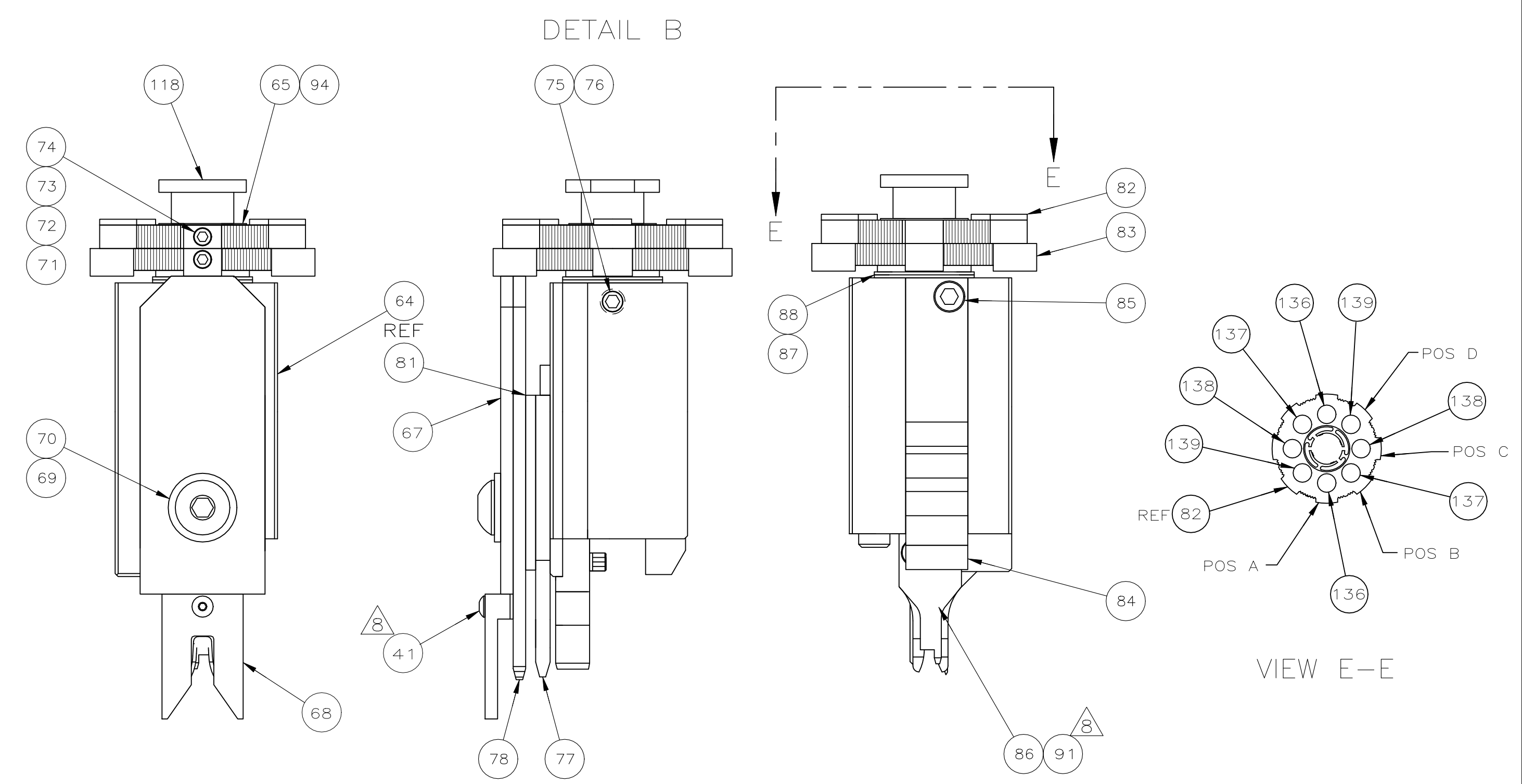
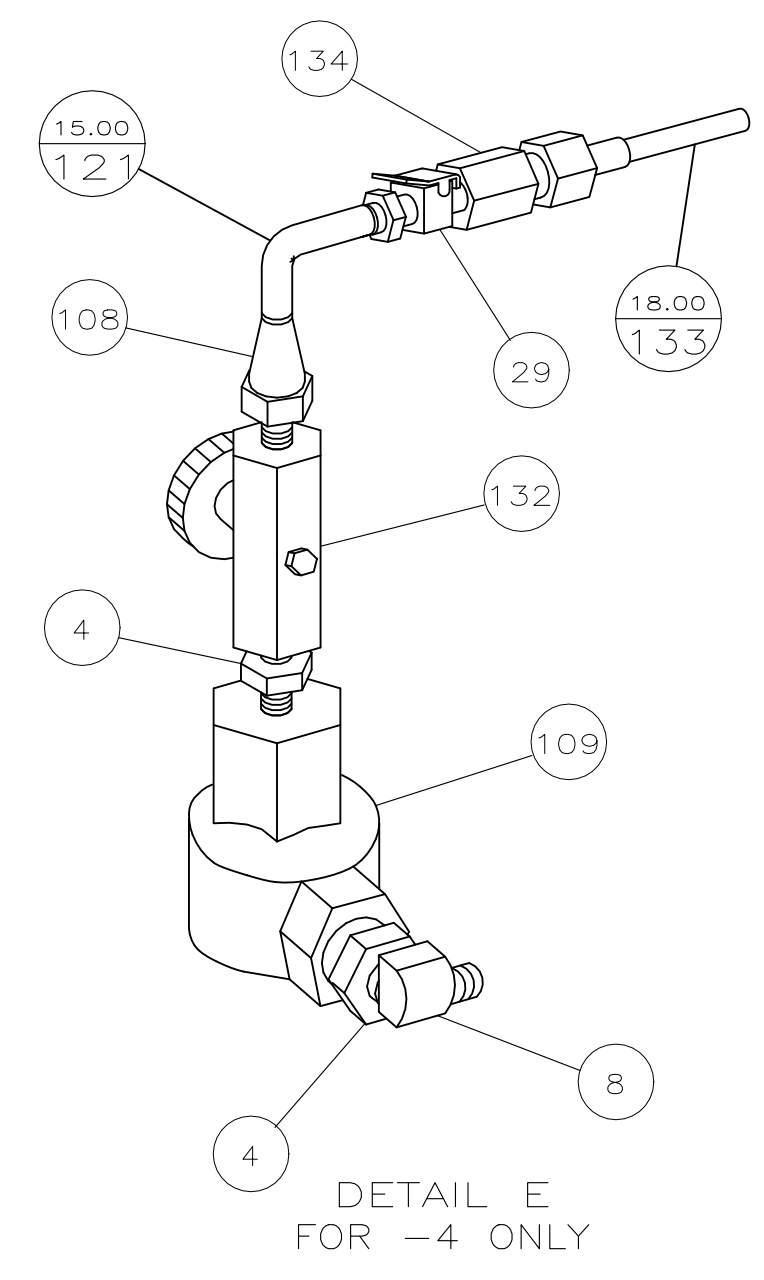
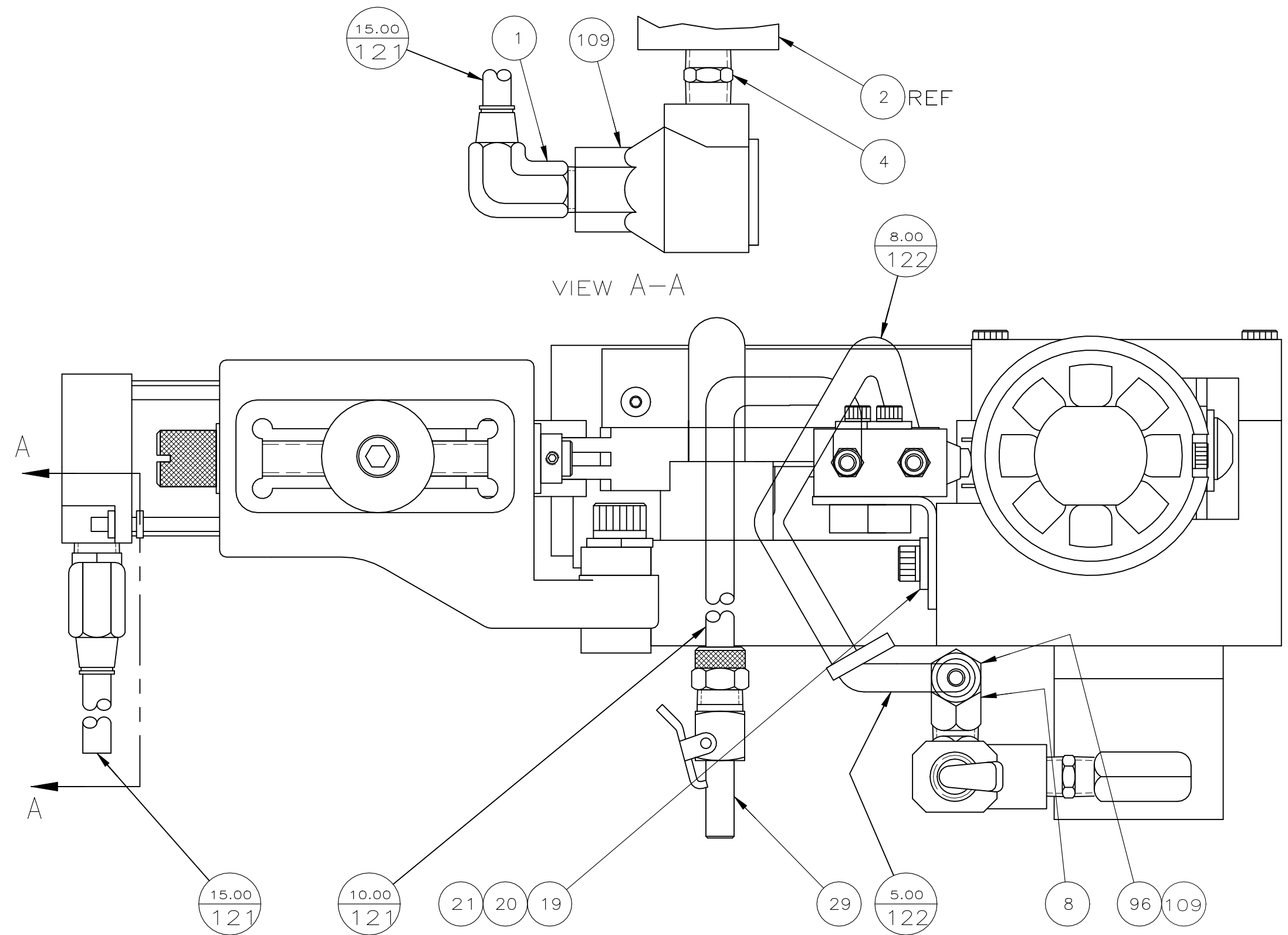
- 1 RECOMMENDED SPARE PARTS.
- 2 ITEMS NOT SHOWN ON ASSEMBLY.
- 3 TOLERANCE ON CUT LENGTH TO BE ±.13.
- 4 USED ON THE CLS I AND II MACHINES ONLY. REMOVE THE TWO MOUNTING SCREWS SECURING THE PRODUCT DEREELEER AND PLACE THE PRODUCT GUIDE (ITEM 111) ON TOP OF THE MOUNTING BRACKET. REASSEMBLE AND RETIGHTEN 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 1385724-4

- * 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 11FEB2004	 TE Connectivity Ltd.	
DIMENSIONS: INCHES		GJK C.FRISMAN 11FEB2004		
		APVD T.FLRIN 11FEB2004	NAME: ULTRA POD FLAG APPLICATOR	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	APPLICATION SPEC	
0. PLC ± .005		SIZE: A1 00779 C=1385724		
1. PLC ± .005		WEIGHT: --		
2. PLC ± .005		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		
3. PLC ± .005		SCALE: 1:1		
4. PLC ± .005		SHEET 1 OF 3		
ANGLES ± .005		REV E1		

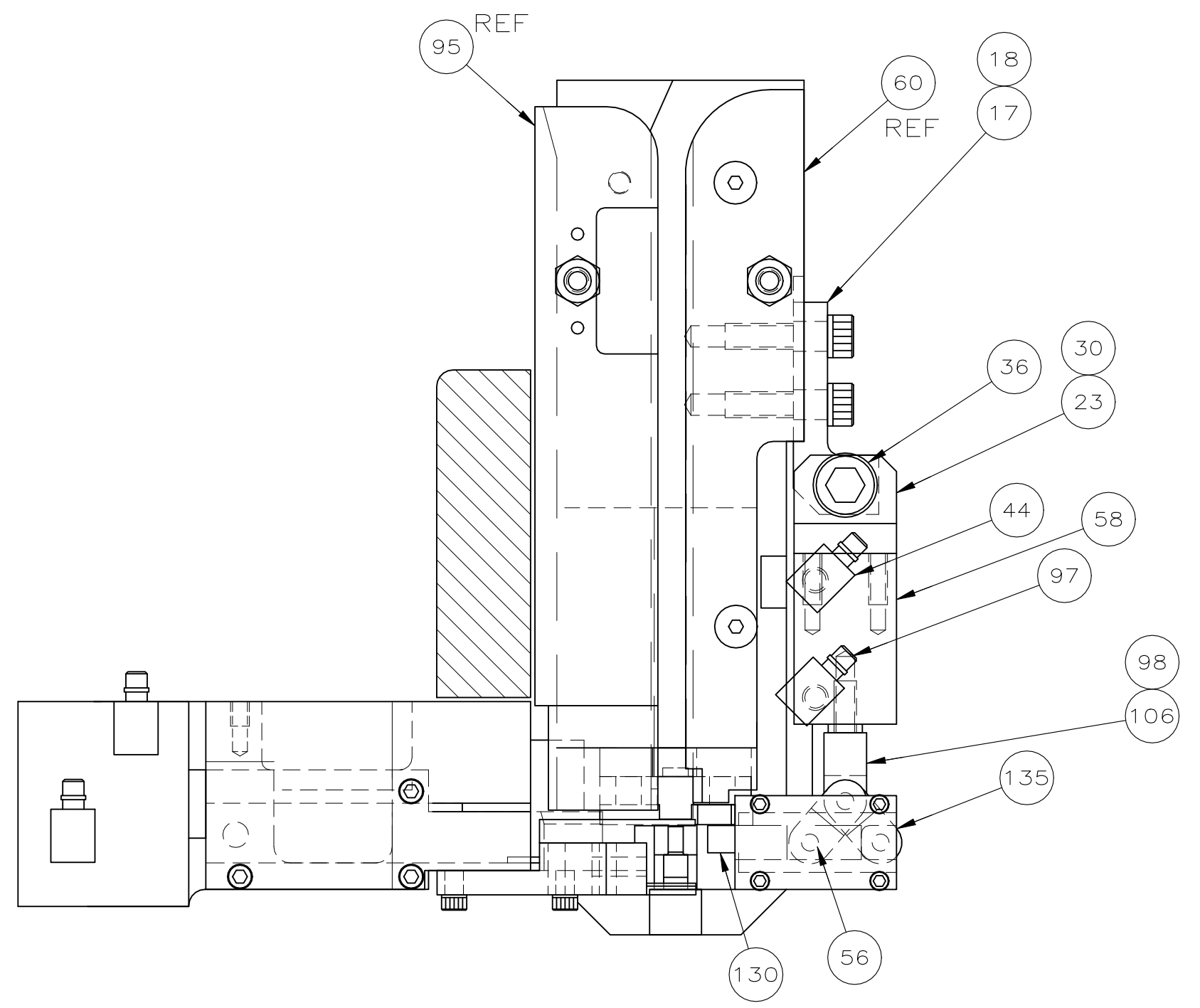
REVISIONS				
P	LTR	DESCRIPTION	DATE	APPRO
-	SEE SHEET 1		-	-



THIS DRAWING IS A CONTROLLED DOCUMENT.		DIN K. STAKEM 11FEB2004	
DIMENSIONS: INCHES		CHK C. ERISMAN 11FEB2004	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPRO T. ELBIN 11FEB2004	NAME
0. PLC ± .005	1. PLC ± .005	ULTRA POD FLAG APPLICATOR	
2. PLC ± .005	3. PLC ± .005	PRODUCT SPEC	
4. PLC ± .005	ANGLES ± .005	APPLICATION SPEC	
MATERIAL	FINISH	SIZE	RESTRICTED TO
		A1 00779 C=1385724	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1	SHEET 2 OF 3 REV E1

DIMENSIONING AND TOLERANCING PER ASME Y14.5M (USD STANDARDS)

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



QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
2				3-354779-0	PIN, WIRE DISC (.3140)D	140
2				2-354779-0	PIN, WIRE DISC (.3090)C	139
2				354779-9	PIN, WIRE DISC (.3035)B	138
2				9-354778-6	PIN, WIRE DISC (.2975)A	137
2				1673387-1	LINK, TOGGLE	136
2				1424324-1	AIR LINE KIT .250 TO 4mm	135
3	18.00			27319-8	TUBING, POLY FLOW Ø156	134
2				23054-1	VALVE, FLOW CONTROL	133
2				679532-1	INSERT, GUARD	132
2				1673388-2	FINGER, BACK-UP	131
						130
						129
						128
						127
						126
1				679172-1	SPACER	125
						124
1				19832-1	TIE, WIRE	123
3	27.00	27.00	27.00	18912-4	HOSE, FLEXIBLE .250 OD	122
2	25.00	25.00	25.00	27319-4	TUBE, PLASTIC .250 OD	121
				90647-1	GUARD, MODIFIED	120
						119
1				690212-1	POST, RAM	118
2				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
				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
				4-21006-5	SCR, SOC SET 8-32 X .62	98
				1-28509-3	FITTING, ELBOW	97
				18258-3	CONN., TUBING, MALE 1/8NPT-1/4 TUBE	96
10				1752763-1	GUIDE, REAR STRIP	95
				986950-1	WASHER, FLAT PRECISION	94
2				6-21002-2	SCR, BHC 10-24 X .39 LG.	93
				1673397-1	COVER, VANE	92
2				2-21000-6	SCR., SHC 8-32UNC X .38 LG	91
2				852764-2	SHEAR, REAR	90
2				852765-2	SPACER, SHEAR	89
				690124-1	WASHER, RAM	88
				690125-1	WASHER, LAMINATED	87
1				1752734-1	BLADE, SLUG	86
				2-21000-5	SCR., SHC 8-32UNC X .25 LG	85
				1213817-1	VALVE, CAM	84
				690142-5	DISC, INSULATION	83
				354777-1	DISC, WIRE CRIMP ADJ.	82
				1-455888-6	SPACER, CRIMPER	81
						80
						79
1				1-853491-0	CRIMPER, INSULATION	78
				852743-5	CRIMPER, WIRE	77
				21009-6	SCR., SET, SOC 1/4-20UNC X .25 LG	76
				690191-1	PLUG, NYLON	75
				23030-1	SCR., SET, SOC 6-32UNC X .25 LG	74
				690170-1	SPRING, COMP.	73
				690603-1	SPRING, ASSIST	72
				23241-6	BALL, STEEL	71
-4	-3	-2	-1	U/M	PART NO	ITEM NO

QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
1				690686-3	SCR., BHC 5/16-24UNF X 1.00 LG	70
1				3-238009-6	BLOCK, CRIMPER SPACER	69
1				1633289-1	STABILIZER	68
1				1633288-1	HOLDER, STABILIZER	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				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				1752762-1	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	PIN, DOWEL .12 DIA X .38 LG.	56
5				1-21000-3	SCR., SHC 4-40UNC X .25 LG	55
4				21024-3	WASHER, LOC 6	54
10				1673379-1	PLATE, STRIP GUIDE	53
4				3-21002-3	SCR, BHC 1/4-20UNC X .50 LG	52
1				852740-1	ARM, STOCK DRAG	51
1				464452-8	DRAG, STOCK	50
4				21055-5	WASHER, FLAT 6	49
1				2-460680-5	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 2-56UNC X .19 LG	35
1				2-21002-6	SCR., BHC 10-32UNC X .38 LG	34
						33
1				354993-2	CYL., AIR, DOUBLE ACTING 1/8NPT	32
						31
2				1-21000-8	SCR, SHC 6-32 X .25 LG.	30
2				23238-1	INSERT, COUPLING	29
1				1-23470-7	SPRING, COMPRESSION	28
2				2-21002-4	SCR., BHC 8-32UNC X 1.00 LG	27
1				22733-8	SCR., BHC 8-32UNC X .38 LG	26
1				853088-9	ANVIL	25
1				1673377-1	SHEAR, FRONT	24
1				1673385-1	EYE, CYLINDER	23
						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
						16
2				3-21000-9	SCR., SHC 10-32UNC X 1.00 LG	15
1				1752765-1	INSERTER, POD	14
2				21022-2	NUT, FLEX 8-32UNC	13
2				2-21002-1	SCR., BHC 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				3-22281-4	SPRING, COMP. .300 DIA X .38 LG	9
3				22306-1	ELBOW, MALE 1/8NPT	8
1				25545-1	MUFFLER, EXHAUST 1/8" NPT	7
						6
9				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
				985883-2	CONN., TUBING, MALE 1/8NPT-1/4 TUBE	1
-4	-3	-2	-1	U/M	PART NO	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DIN K. STAKEM 11FEB2004	TE Connectivity Ltd.
0 PLC ± .005 1 PLC ± .005 2 PLC ± .005 3 PLC ± .005 4 PLC ± .005 ANGLES ± .005		CJK C. FERISMAN 11FEB2004 APVD T. ELBIN 11FEB2004 NAME: ULTRA POD FLAG APPLICATOR	
MATERIAL	FINISH	WEIGHT	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 1385724 RESTRICTED TO:
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:1	SHEET 3 OF 3 REV E1