

PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE
1385719-1	H	122500-1	LEADMAKER	AIR FEED
1385719-2	H	565435-5	BENCH MODEL K	AIR FEED
1385719-3	H	354500-1	BENCH MODEL G	AIR FEED
1385719-4	H	KOMAX	KOMAX	AIR FEED

SUPERSEDED BY 1385719-1
 SUPERSEDED BY 1385719-1
 OBSOLETE

TERMINAL NAME: .250 SERIES RECEPTACLE, ULTRA-POD™				
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE LAYOUT
.210-.240	114-02124	.760	408-8095 & 408-8098	-

CRIMPING DATA			
SETTING	CRIMP HEIGHT	WIRE SIZE	
B5	.076 ±.002 [1.93 ±0.05mm]	#14	
C5	.071 ±.002 [1.80 ±0.05mm]	2- #18	
D3	.067 ±.002 [1.70 ±0.05mm]	#16 or (1)#18 + (1)#20	
E3	.061 ±.002 [1.55 ±0.05mm]	#18 or (2)#20	
CRIMP	SIZE	TYPE	RANGE
WIRE	.110 [2.79mm]	F	#14-#18 or (2)#18 or (1)18 + (1)#20 or #18 or (2)#20
INSUL	SIZE	TYPE	RANGE
	.240 [6.09mm]	F	.110-.170 or 2-.105 MAX

1 RECOMMENDED SPARE PARTS

2 ITEMS NOT SHOWN

3 TOL ±.25

4. SPRING LOADED TONKER REQUIRED WHEN RUNNING APPLICATOR ON LEADMAKER.

5. WIRE PLACEMENT AND STRAIGHTNESS IS EXTREMELY CRITICAL FOR CONSISTANT TERMINAL BARREL. IF THE WIRE COLLECTION OF THE WIRE INTO THE PRESENTATION IS NOT CORRECT OR CONSISTANT, FAULTY TERMINATIONS WILL RESULT.

* 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.

QTY REQD PER ASSY	REF	DESCRIPTION	ITEM NO
		INSERT, GUARD	174
		SCR., DRIVE 2 X .19	171
		TAG, IDENTIFICATION	170
		LUBRICATOR	168
		NIPPLE	167
		FILTER, MINATURE	166
		TEE, FEMALE BRANCH	165
		BUSHING, PIPE FITTING	163
		BODY,QUICK CONNECT	161
		TIE,WIRE	160
		SHCS, 10-32 X 2.00	157
		WASHER, LOCK #10	156
		WASHER, LOCK	155
		TUBING,NYLON .250 DIA	154
		INSERT,COUPLING	153
		GUARD ASSY	151
			150
			149
			148
			147
			146
		SCR,LOC,SET(1/4-20x.75)	145
		MOUNT,FEED BRACKET	144
			143
			142
			141

QTY REQD PER ASSY	REF	DESCRIPTION	ITEM NO
		WASHER,LAMINATED	134
		SCR,SOC SET 1/4-20 X .25 LG	133
		PLUG,NYLON	132
		SPACER	131
		VALVE ASSY	129
		SCR. BUT HD 10-32 X .75	128
		SCR. SOC HD 10-32 X .75	127
		FINGER,FEED	126
		FEED FINGER ASSY	125
		SCREW, SOC HD CP 3/8-16 X .88 LG	124
		AIR FEED ASSY	123
			122
			121
		SCR,SOC,HD.8-32X.75 LOK-WEL	120
		SPACER, CRIMPER	119
		BLADE,SLUG	118
		SPACER, DEPRESSOR	117
		DEPRESSOR	116
		PIN, HOLDER	115
			114
			113
		PLATE, DEPRESSOR	112
		COMPRESSION SPRING	111
			110
		WASHER #8	109
		SCR,HEX(8-32x.38)	108
		SCR,BHC(10-32x.38)	107
		SCR, SHC 8-32 X .50 LG.	106
		SCR, FHC 4-40 X .25 LG.	105
		SPRING, COMPRESSION	104
		RAM CAP PLATE	103
		SPACER,CRIMPER	102
		SPACER, CRIMPER	101
		CAP, RAM	100
		CRIMPER, WIRE	99
		CRIMPER,INS "F"	98
		BLOCK, CRIMPER SPACER	97
		SPACER,CRIMPER	96
		SCR,BUT. HD.5/16 UNF-24 X 1.25	95
		SPACER, CRIMPER	94
		PIN, GROOVE TYP 67 .125 DIA X .63	93
		SPRING, EXT. LE-031B-2	92
		PIN,DOWEL .094 DIA X .375	91
		ROLLER	90
		PNEUMATIC ASSY	89
		PLATE, RETAINER	88
		LATCH, INSERT	87
		PIN, DOWEL MOD. .094 DIA X .49	86
		ARM, LATCH	85
		PIN, DOWEL .188 DIA X 1.50	84
			83
			82
		CONNECTOR,MALE 1/8NPTX.25	80
		ELBOW,MALE,SWIVEL 1/8NPTx.25	79
			78
			77
			76
			75
			74
			73
			72
		SCR,BUT HD CP 6-32 X .25 LOK-WEL	71

QTY REQD PER ASSY	REF	DESCRIPTION	ITEM NO
		CAM, INSERT	69
		CAM,VALVE	67
		RAM	65
		EXHAUST, QUICK	63
		NIPPLE, HEX 1/8 NPT	62
		ELBOW, MALE 1/8NPT	61
		VALVE, FLOW CONTROL	60
		TUBING, POLY FLOW,.156	59
		AIR LINE KIT, .250 TO 4mm	58
			57
		WIRE DEPRESSOR	56
		WIRE DEPRESSOR	55
		SCR. BUT HD 10-24 X .25	54
		CAP, DEPRESSOR	53
		WIRE DEPRESSOR HOLDER	52
		ANVIL, INSUL FLAT	51
		SUPPORT, LOWER WIRE	50
		SCR,SOC HD(6-32x.38)	49
			48
		FINE ADJUST SUBASSY	47
		SHIM	46
			45
			44
			43
			42
			41
		GUIDE,FRONT STRIP	40
		STUD,8-32	39
		DRAG	38
		SPRING, COMP. LC-032C-6	37
		NUT,FLEXLOC 8-32	36
		GUIDE, REAR STRIP	35
		WASHER,FLAT #8	34
			33
		SHEAR, LEFT	32
			31
		SHEAR, RIGHT	30
			29
			28
		PLATE, STRIP GUIDE	27
		SPACER, CRIMPER	26
		HOLDER, STABILIZER	25
		SCR, BHC (4-40x.25)	24
		STABILIZER	23
		BLOCK, CRIMPER SPACER	22
		SCR. SOC.HD. 6-32x.38 LOK-WEL	21
			20
			19
			18
		SCR,BHC,SELF-LOCKING(8-32x.50)	17
			16
			15
			14
		AIR CYL 1 1/8 X .63	13
		SCR,BHC,SELF-LOCKING(8-32x.38)	12
		SCR, BHC (8-32x.50)	11
		SPRING, COMP. LC-035C-19	10
		GIB, HOUSING	9
		INSERTOR, POD	8
		SCR, BHC (8-32x.38)	7
		HOUSING, INSERT SLIDE	6
			5
		HOLDDOWN	4
		SCR. BUT HD 1/4-20 X .62	3
		PLATE, BASE	2
		HOUSING, APPLICATOR	1

REVISIONS				
P	LTR	DESCRIPTION	DATE	OWN
H1	REVISED PER ECR-23-190096		19OCT2023	GK

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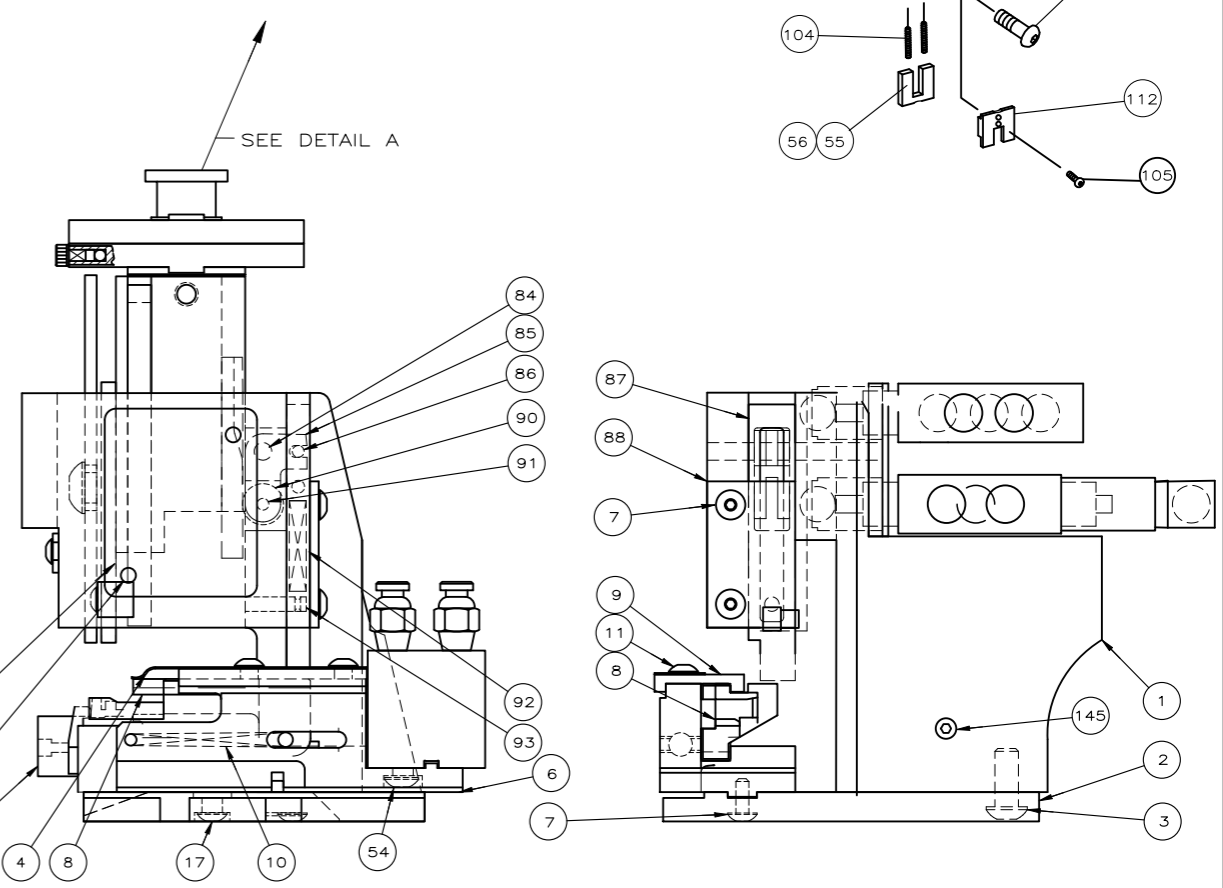
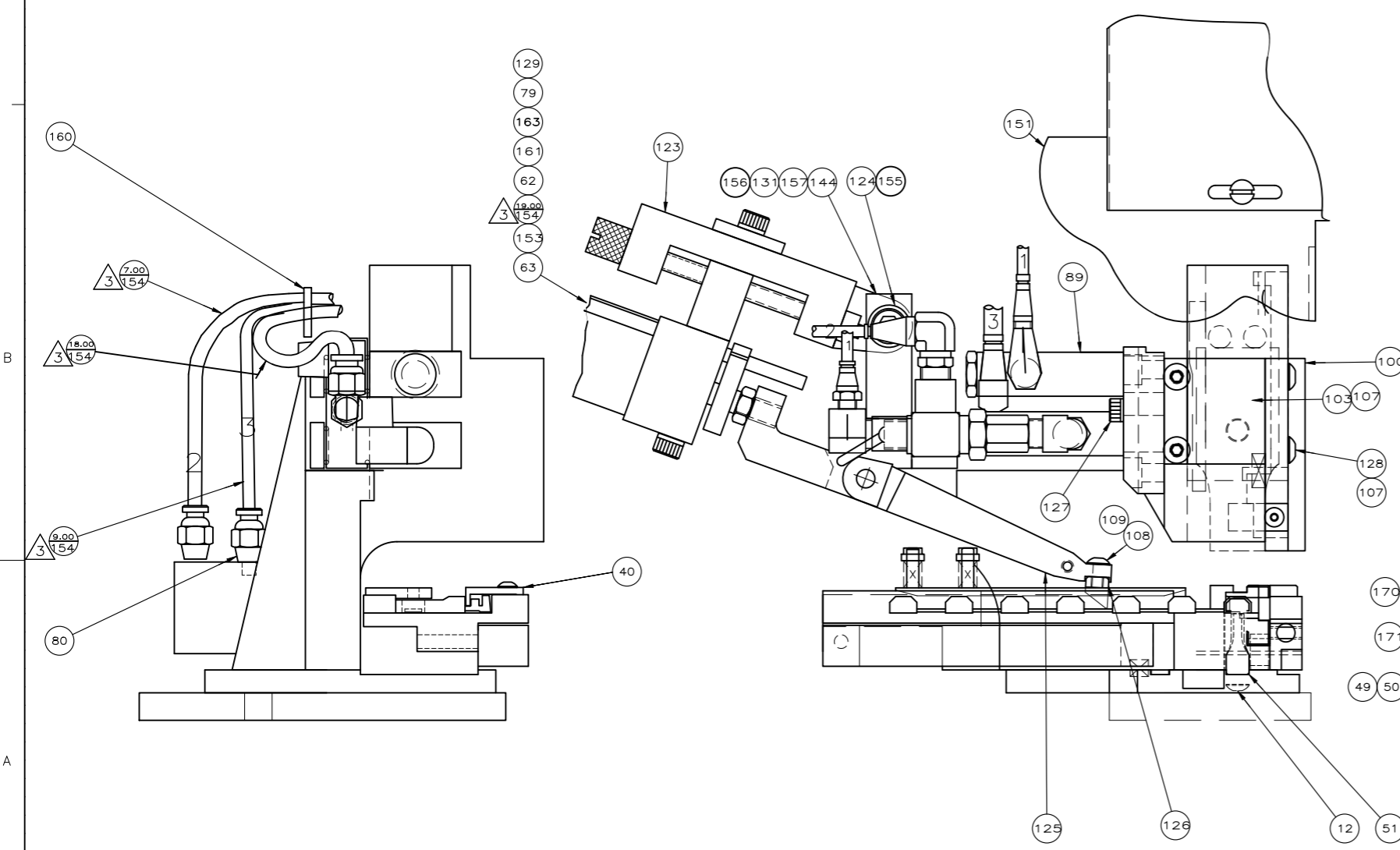
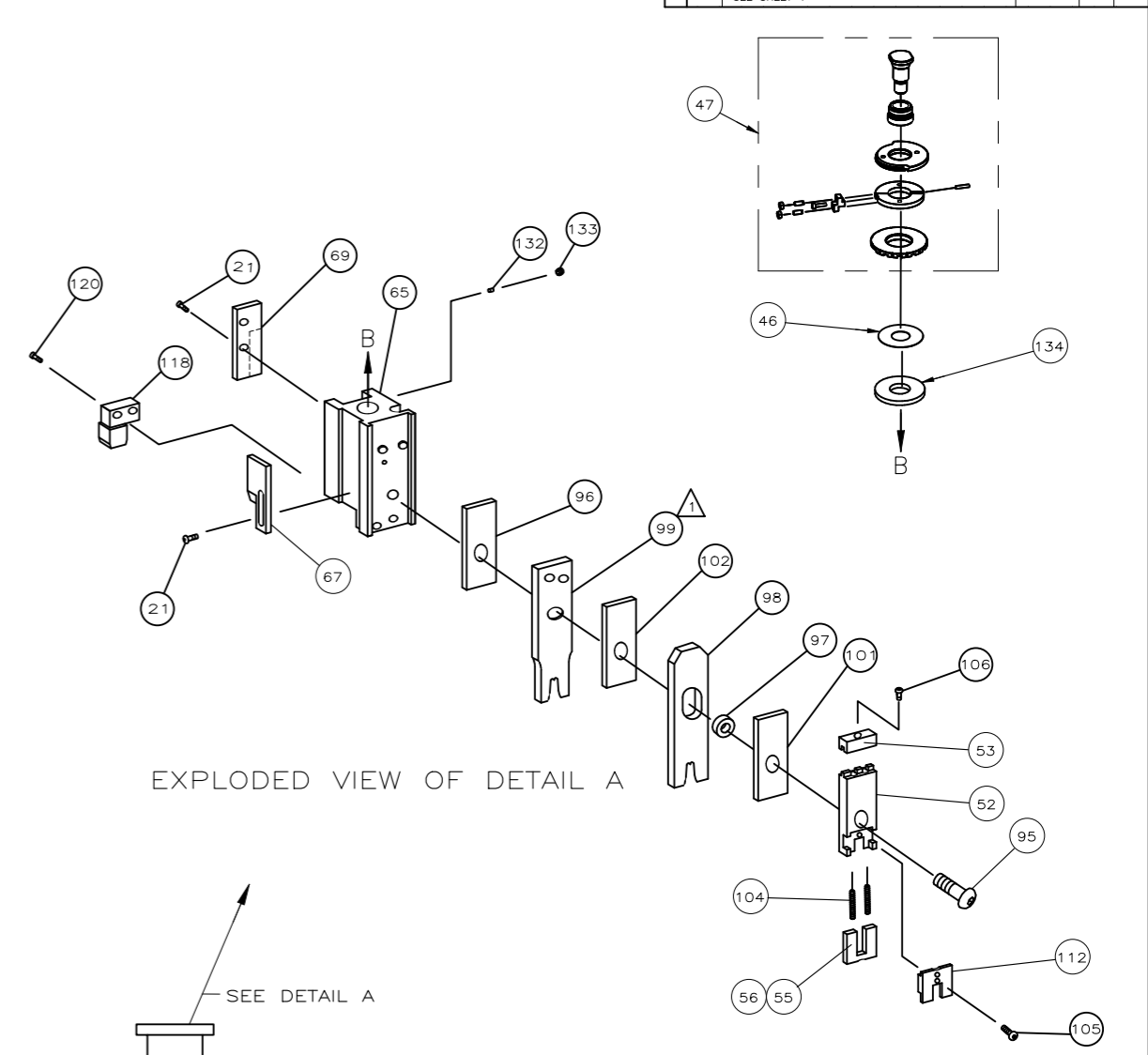
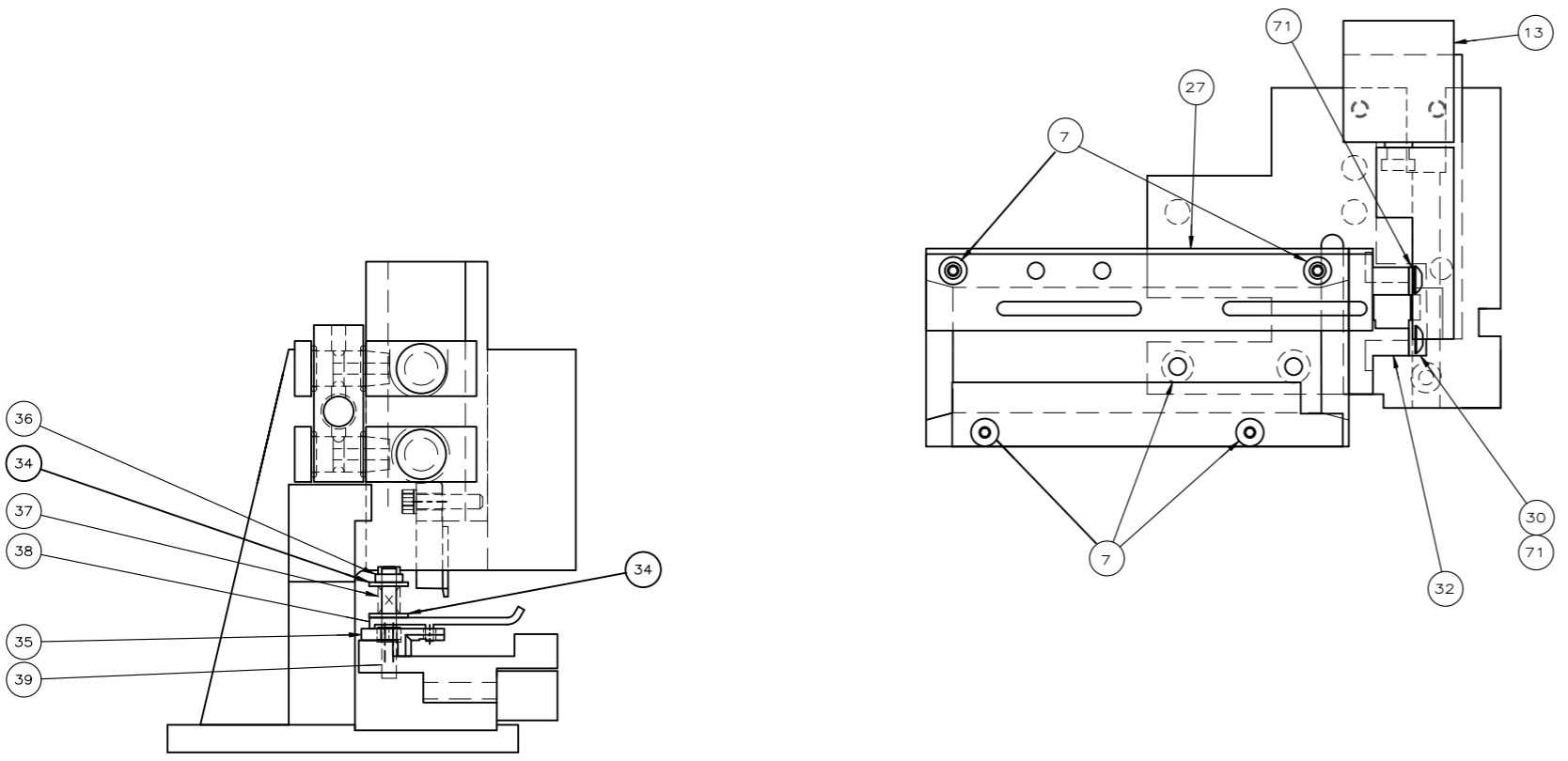
APPROVED: R O WILSON 27SEP1995
 C. ERISMAN 27SEP1995
 A. REDDICK 27SEP1995

TE Connectivity Ltd.
 ULTRA-POD APPLICATOR .250 STRAIGHT

PRODUCT SPEC: -
 APPLICATION SPEC: -
 SIZE: A1
 GAGE CODE: 00779
 DRAWING NO: 1385719

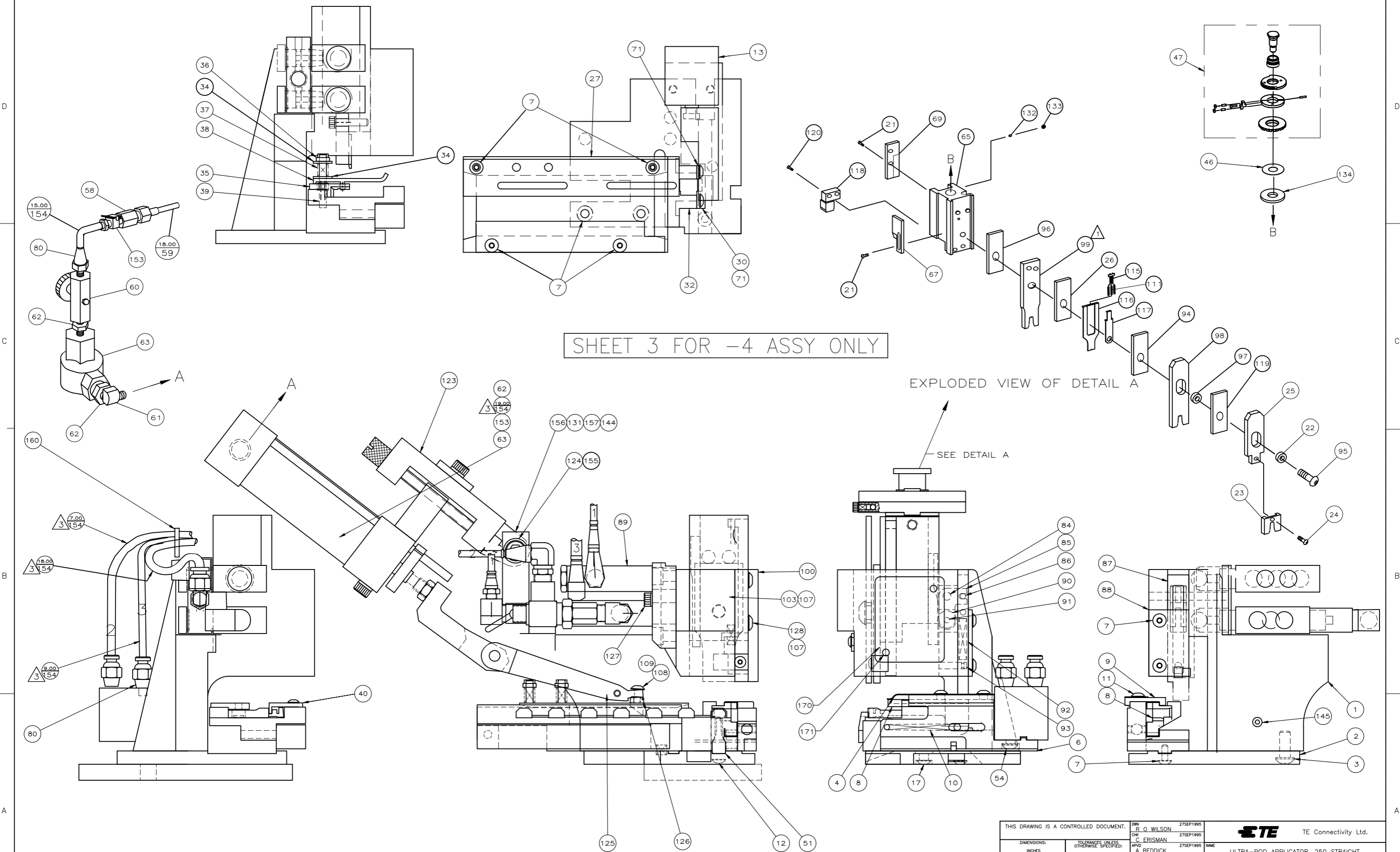
RESTRICTED TO: -
 WEIGHT: -
 SCALE: 1:1
 SHEET: 1 OF 3
 REV: H1

REVISIONS				
#	LTN	DESCRIPTION	DATE	BY
-	-	SEE SHEET 1	-	-



THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN R O WILSON	27SEP1995	TE Connectivity Ltd.																								
DIMENSIONS: INCHES		CHK C ERISMAN	27SEP1995	NAME ULTRA-POD APPLICATOR .250 STRAIGHT																								
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APP'D A REDDICK	27SEP1995	PRODUCT SPEC																								
<table border="0"> <tr><td>0</td><td>PLC</td><td>±</td><td>-</td></tr> <tr><td>1</td><td>PLC</td><td>±</td><td>-</td></tr> <tr><td>2</td><td>PLC</td><td>±</td><td>.02</td></tr> <tr><td>3</td><td>PLC</td><td>±</td><td>.005</td></tr> <tr><td>4</td><td>PLC</td><td>±</td><td>.0005</td></tr> <tr><td colspan="2">ANGLES</td><td>±</td><td>0°30'</td></tr> </table>		0	PLC	±	-	1	PLC	±	-	2	PLC	±	.02	3	PLC	±	.005	4	PLC	±	.0005	ANGLES		±	0°30'	APPLICATION SPEC		RESTRICTED TO
0	PLC	±	-																									
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ANGLES		±	0°30'																									
MATERIAL		WEIGHT		SIZE	CAGE CODE																							
				A1	00779																							
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	1:1																							
				SHEET	2 of 3																							
				REV	H1																							

REVISIONS				
#	LTN	DESCRIPTION	DATE	DRN
-	-	SEE SHEET 1	-	-



SHEET 3 FOR -4 ASSY ONLY

EXPLODED VIEW OF DETAIL A

SEE DETAIL A

THIS DRAWING IS A CONTROLLED DOCUMENT.		DRN: R O WILSON 27SEP1995	TE Connectivity Ltd.
		CHK: C ERISMAN 27SEP1995	
		APP: A REDDICK 27SEP1995	NAME: ULTRA-POD APPLICATOR .250 STRAIGHT
DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:	PRODUCT SPEC: -
\varnothing		0 PLC ± -	APPLICATION SPEC: -
		1 PLC ± .02	SIZE: -
		2 PLC ± .005	WEIGHT: -
		3 PLC ± .0005	SIZE CASE CODE DRAWING NO: A1 00779 C 1385719
		4 PLC ± .0005	RESTRICTED TO: -
		ANGLES ± 0°30'	CUSTOMER ACCESSIBLE PRODUCTION DRAWING
MATERIAL: -		FINISH: -	SCALE: 1:1
			SHEET 3 OF 3
			REV H1