

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

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TERMINAL NAME: .250 SERIES RECEPTACLE, ULTRA-POD™

REF SETTING	CRIMP HEIGHT	WIRE SIZE
521632	B5 .076 ±0.002 [1.93 ±0.05mm]	#14
521637	C5 .071 ±0.002 [1.80 ±0.05mm]	2- #18
521998	D3 .067 ±0.002 [1.70 ±0.05mm]	#16 or (1)#18 + (1)#20
	E3 .061 ±0.002 [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	.240 [6.09mm]	F .110-.170 or 2-.105 MAX
WIRE STRIP LENGTH	TERM APPL SPEC	FEED APPL INSTRUCTION
.210-.240	114-02124	.760 408-8095 & 408-8098
SET UP GAGE	LAYOUT	
-	-	-

- 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	PART NO	DESCRIPTION	ITEM NO
-	REF	-	679532-1
2	2	2	21017-2
1	1	1	461264-5
-	-	1	28582-1
-	-	2	22311-2
-	-	1	28580-1
-	-	1	23791-2
-	-	1	22307-1
-	-	1	26108-1
1	1	1	19832-1
2	2	2	4-21000-3
2	2	2	21024-5
1	1	1	21024-8
80	65	65	27319-4
2	2	1	23238-1
-	-	1	455755-8
1	1	1	21009-7
1	1	1	459610-3
-4	-3	-2	-1
U/M	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
-	-	-	140
-	-	-	139
-	-	-	138
-	-	-	137
-	-	-	136
-	-	-	135
1	1	1	690125-1
1	1	1	21009-2
1	1	1	690191-1
1	1	1	461690-1
-	-	1	692655-1
2	2	2	2-21002-9
2	2	2	3-21000-7
1	1	1	852224-1
1	1	1	461062-6
1	1	1	3-21001-4
1	1	1	852289-1
2	2	2	1-23030-2
1	-	-	1-455888-0
1	1	1	852253-1
1	-	-	1490524-2
1	-	-	1490525-1
1	-	-	1424350-1
-	1	1	1338045-1
3	-	-	2-23147-2
1	1	1	21024-4
1	1	1	2-22603-1
4	4	4	2-21002-6
-	1	1	2-21000-7
-	2	2	1-21003-3
-	4	4	7-22280-3
1	1	1	1673936-2
-	1	1	1-455888-6
-	1	1	455888-4
1	1	1	1424388-2
1	1	1	6-1490019-6
1	1	1	6-1424909-6
1	1	1	238011-2
1	1	1	1-455888-5
1	1	1	2-24921-5
1	-	-	455888-5
1	1	1	1-22183-7
1	1	1	2-22286-2
1	1	1	1-21919-1
1	1	1	852281-2
1	1	1	354385-4
1	1	1	852287-1
1	1	1	852286-1
2	2	2	852521-1
1	1	1	852284-1
1	1	1	1-21030-7
3	2	2	980282-3
-	1	-	980285-2
2	2	2	22733-3
-4	-3	-2	-1
U/M	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
1	1	1	852245-2
1	1	1	852246-1
1	1	1	856287-1
1	1	-	22374-7
2	1	-	22304-1
1	-	-	22306-1
1	-	-	23054-1
18	-	-	27319-8
1	-	-	1424324-1
-	1	1	1338042-7
-	1	1	1338042-5
2	2	2	6-21002-1
-	1	1	1338043-1
-	1	1	1338044-1
1	1	1	1-1338056-3
-	1	1	1338041-1
-	1	1	1-21000-9
1	1	1	879103-3
1	1	1	469367-9
1	1	1	852250-1
2	2	2	22354-7
1	1	1	852251-2
2	2	2	2-22280-9
2	2	2	21021-3
1	1	1	90594-1
4	4	4	21055-6
1	1	1	90591-1
1	1	1	853981-1
-	-	-	-
1	1	1	1338060-1
1	-	-	455888-1
1	-	-	1633303-1
1	-	-	1-21002-3
1	-	-	1633289-2
1	-	-	3-238009-7
4	4	4	23030-2
2	2	2	22733-9
1	1	1	354993-1
1	1	1	22733-8
2	2	2	2-21002-2
1	1	1	1-23470-7
1	1	1	90777-1
1	1	1	318198-1
12	12	12	2-21002-1
1	1	1	90775-1
1	1	1	1338955-1
3	3	3	2-22733-8
1	1	1	1424368-3
1	1	1	1424387-1
-4	-3	-2	-1
U/M	PART NO	DESCRIPTION	ITEM NO

LOC A
DIST 66

REVISION RECORD

P	LT	REVISION	DATE	BY	CHK	APVD
H	ECR-09-018424	9-2009	MY	GB		

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0	PLC	± .0005
1	PLC	± .002
2	PLC	± .005
3	PLC	± .010
4	PLC	± .020

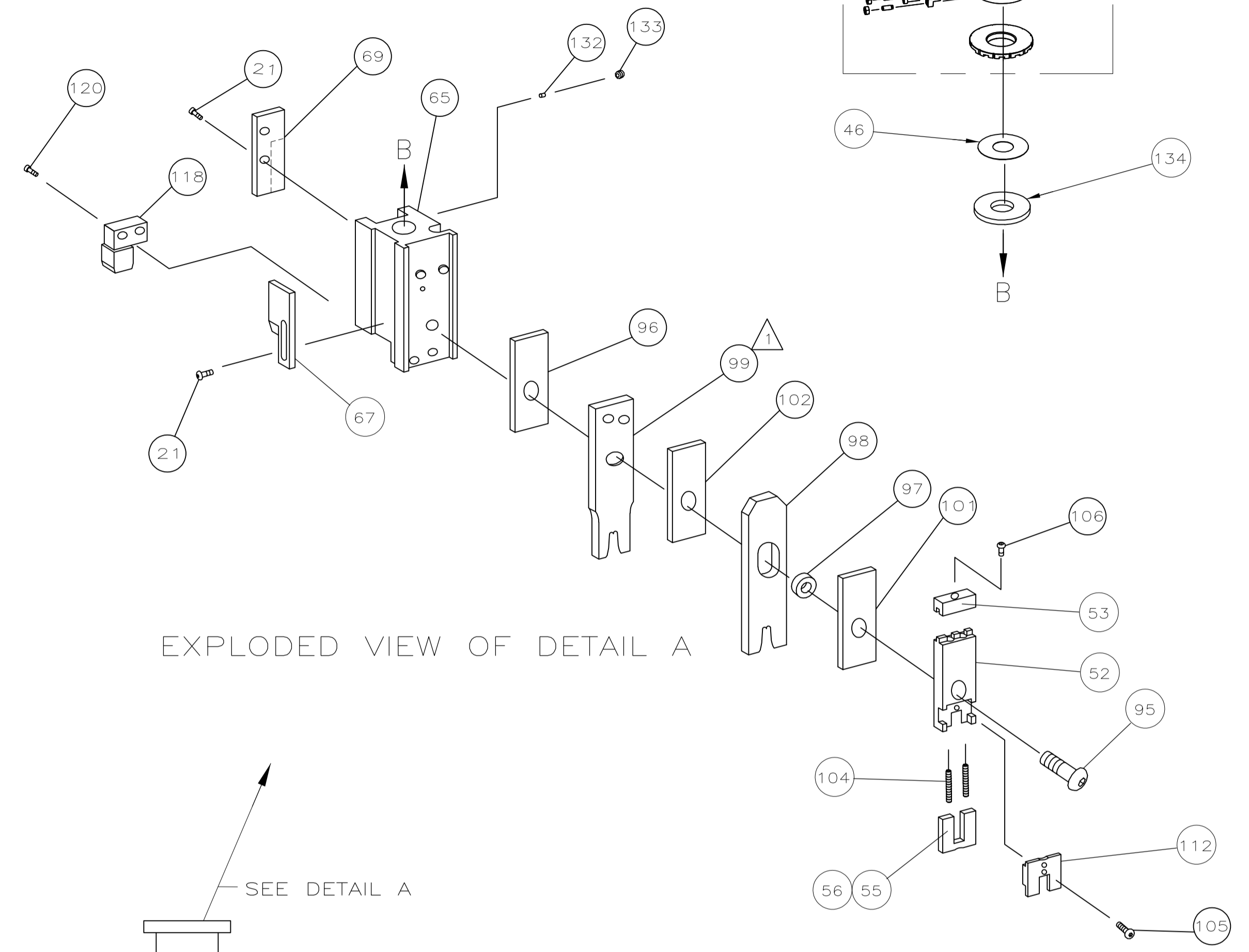
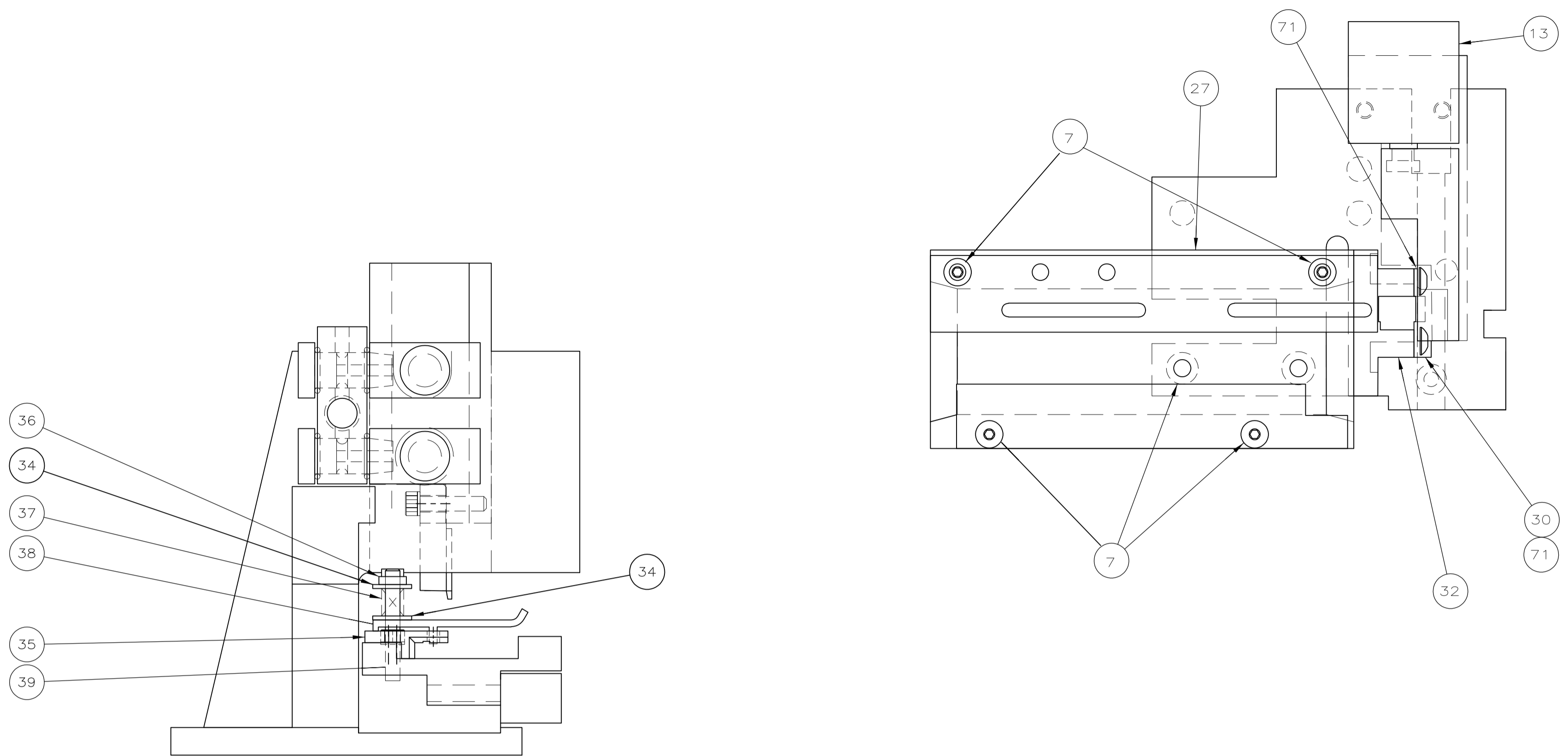
ANGLER: SURFACE TEXTURE

NAME: ULTRA-POD APPLICATOR .250 STRAIGHT

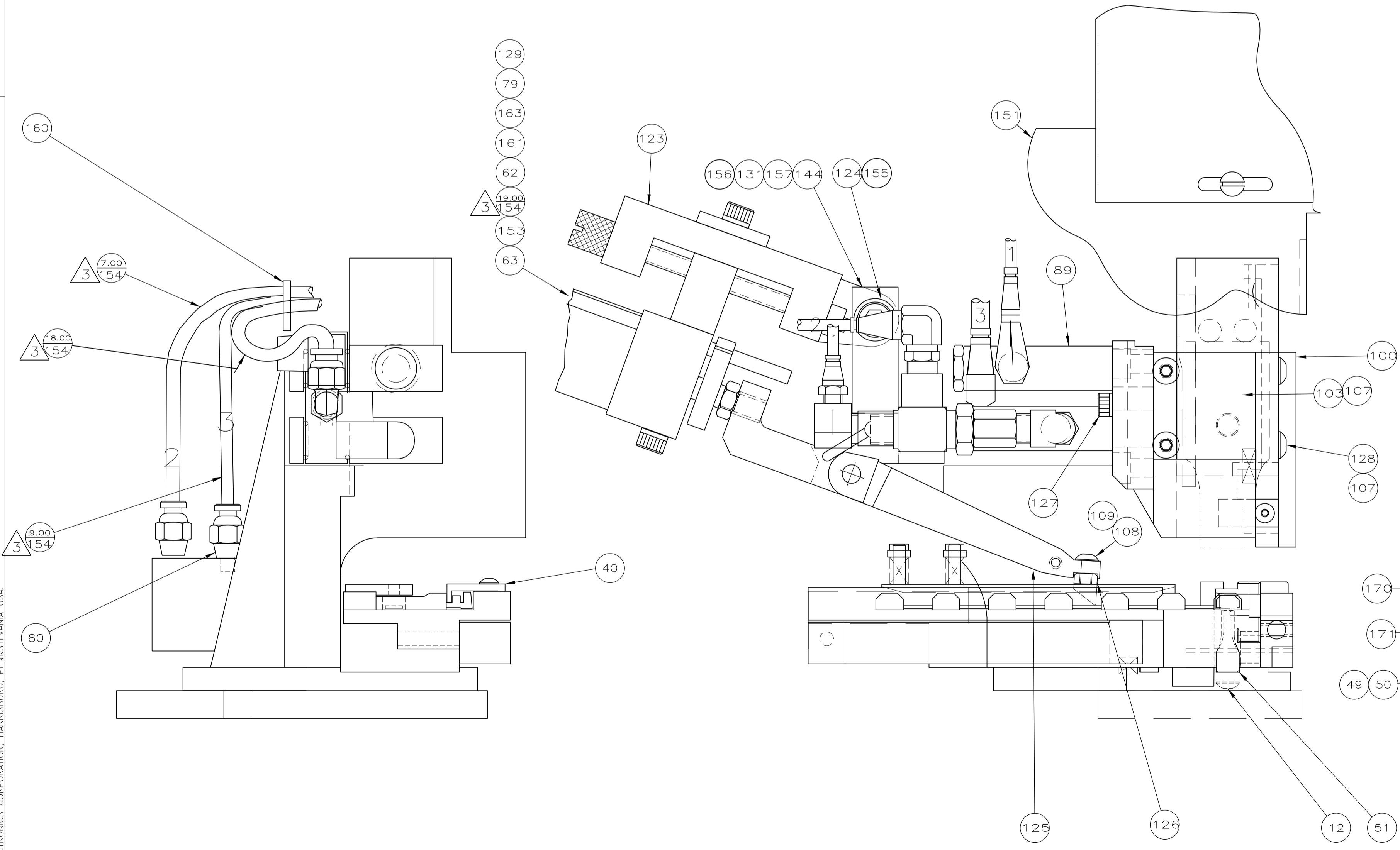
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Customer Accessible Production Drawing

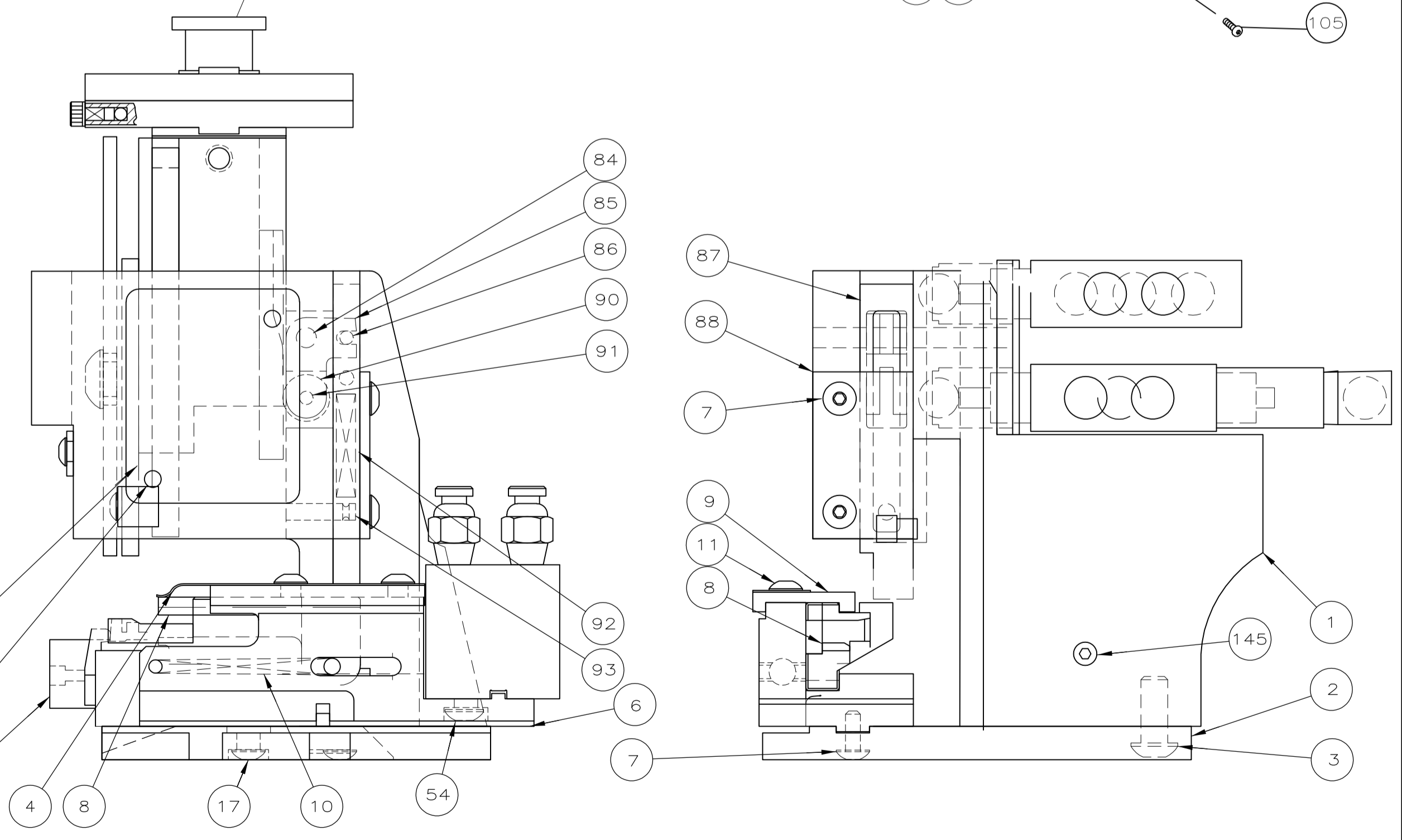
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EXPLODED VIEW OF DETAIL A



SEE DETAIL A

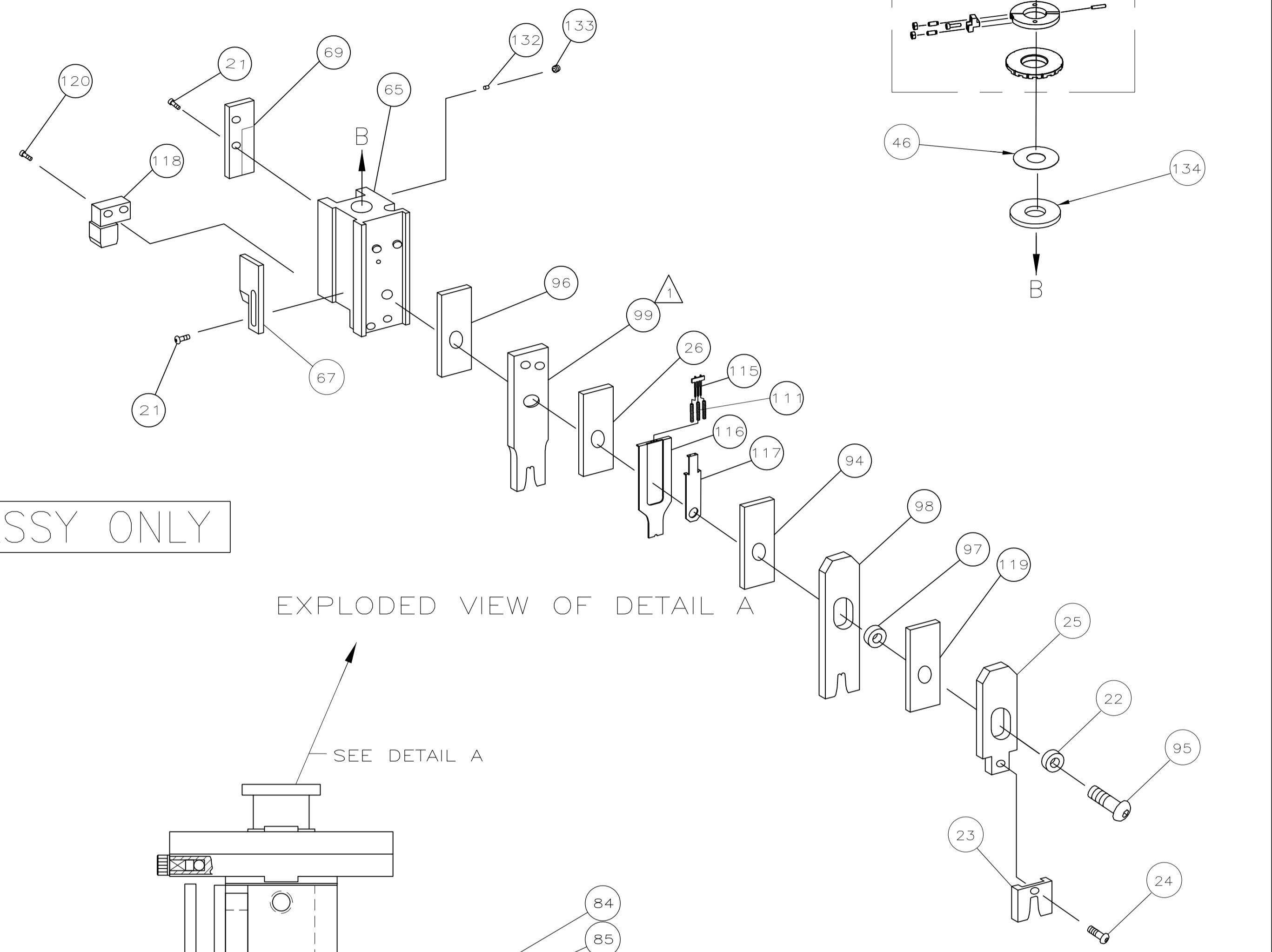
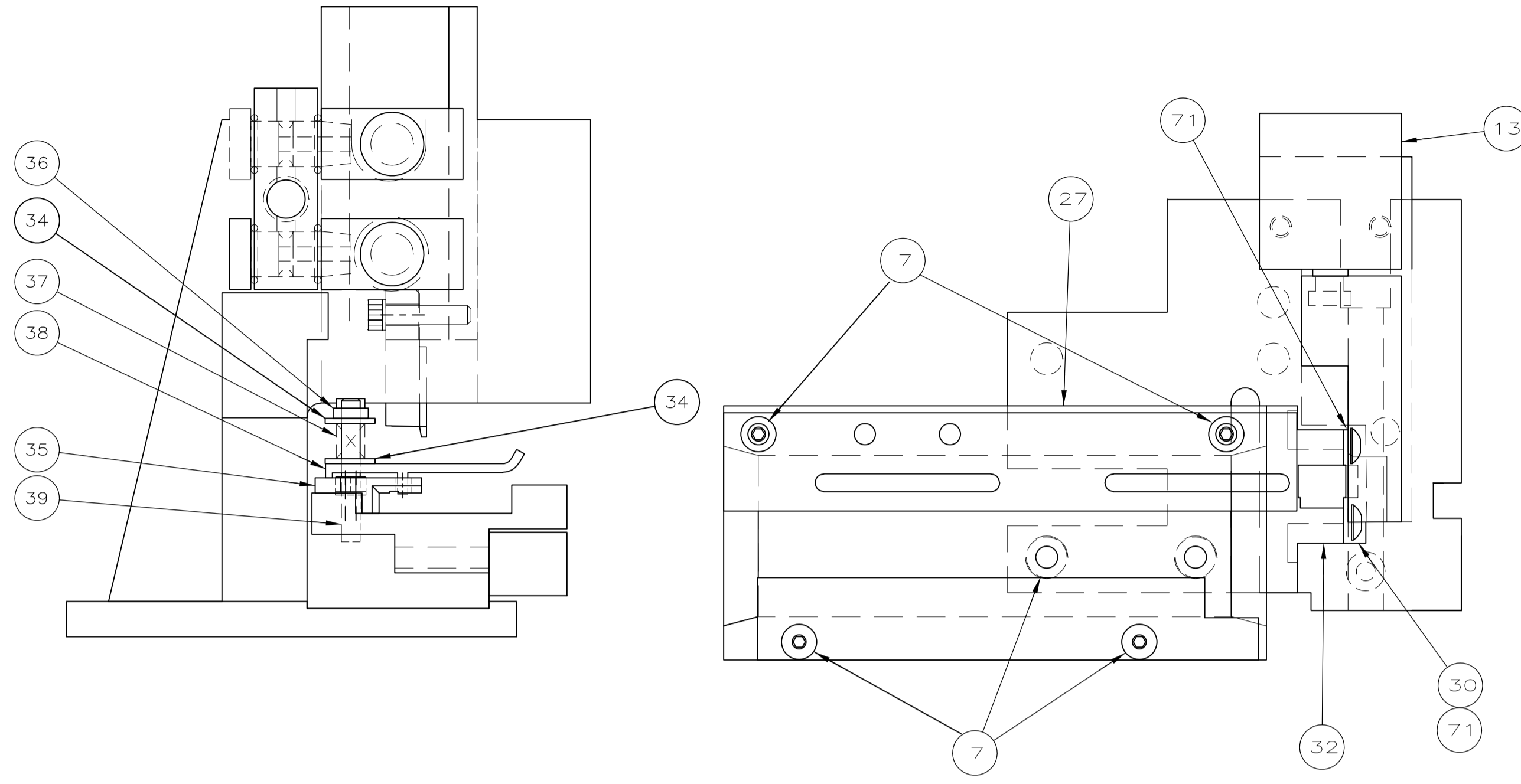
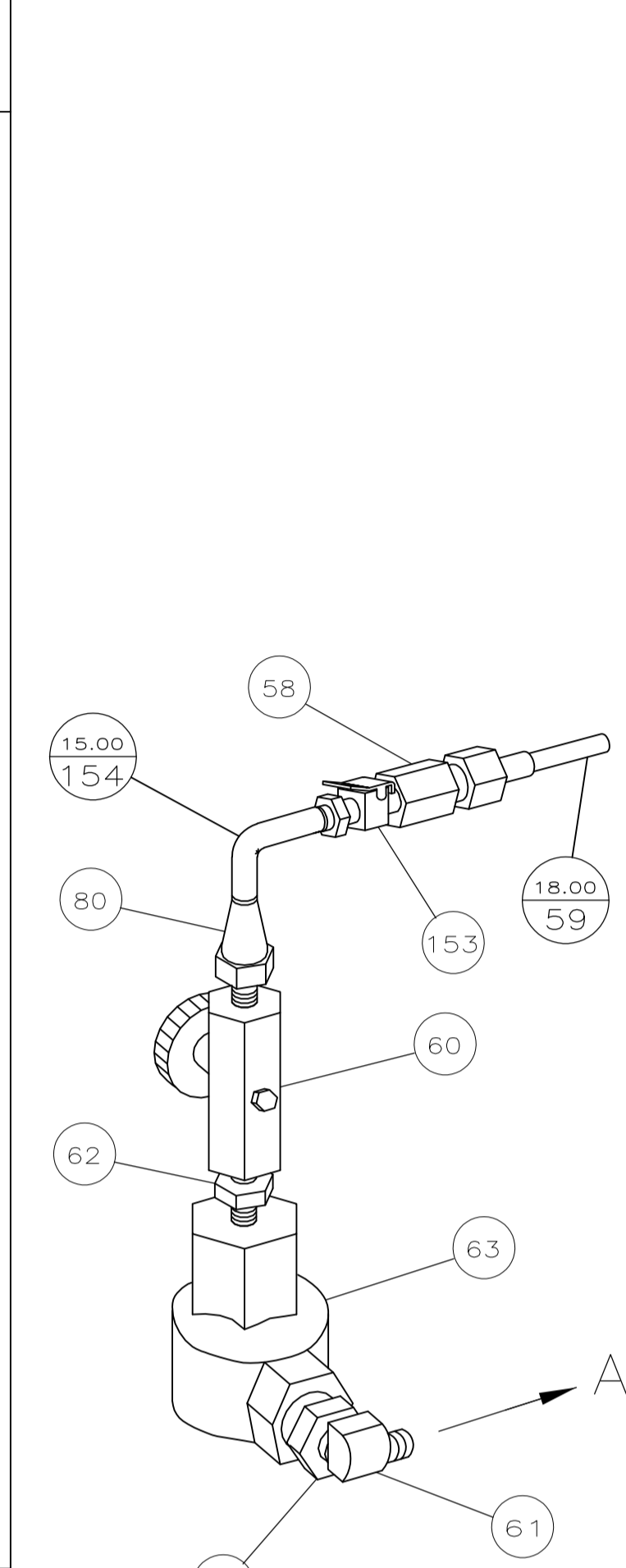


LOC A
DIST 66

DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
0 PLC	± .005	1 PLC	± .002
1 PLC	± .002	2 PLC	± .001
2 PLC	± .001	3 PLC	± .0005
3 PLC	± .0005	4 PLC	± .0002
4 PLC	± .0002		
ANGLES: -		SURFACE TEXTURE: ✓	
- SEE SHEET 1		REVISION RECORD	
P	LTR	DATE	DWN
			APVD
DWG NO: 1385719		SCALE: 1:1	
DRAWING NO: 1385719		SIZE: A1	
SHEET 2 OF 3		REV H	

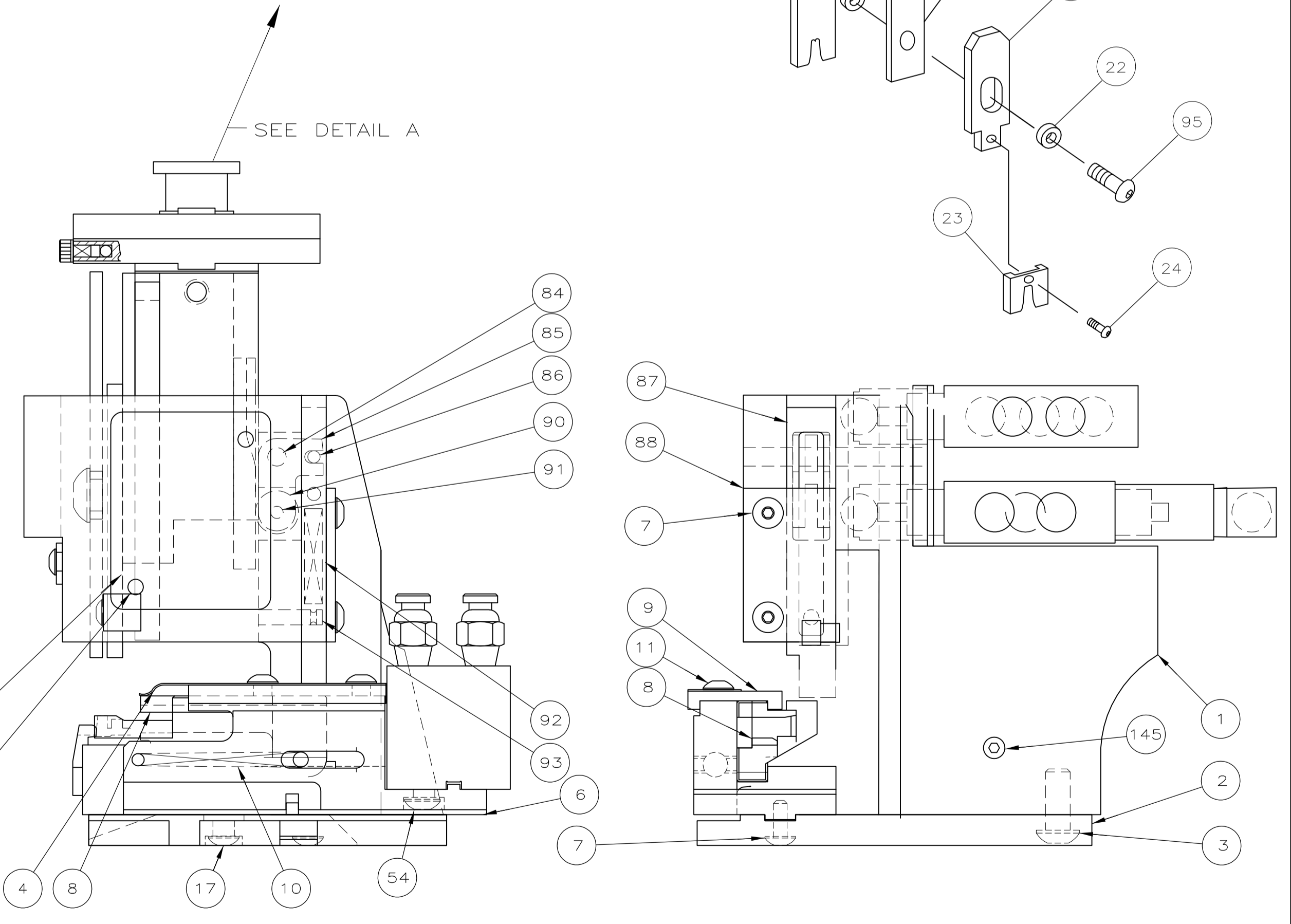
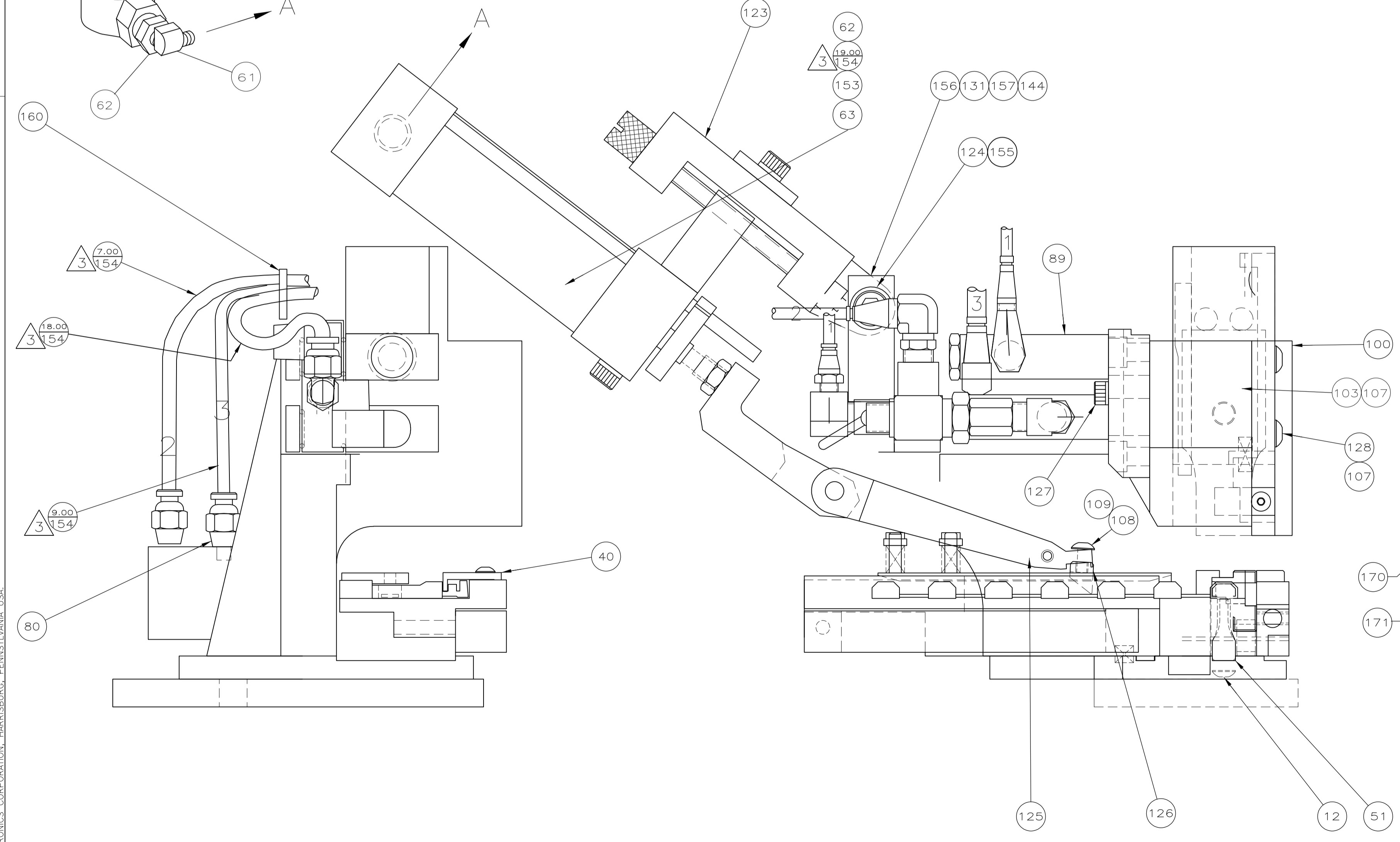
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SHEET 3 FOR -4 ASSY ONLY

EXPLODED VIEW OF DETAIL A



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LOC
 A
 DIST
 66

REV	DESCRIPTION	DATE	BY	CHK
-	SEE SHEET 1	-	-	-
P	LTR	REVISION RECORD	DATE	DWN

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:
INCHES	0 PLC ± .
	1 PLC ± .
	2 PLC ± .02
	3 PLC ± .005
	4 PLC ± .0005
ANGLES:	
SURFACE TEXTURE:	√

DWN	R O WILSON	9-27-95	MATERIAL	-	HEAT TREAT	-
CHK	C ERISMAN	9-28-95				
APVD	A BEDDICK	9-28-95	Tyco Electronics Corporation Harrisburg, PA 17105-3608			
NAME	ULTRA-POD APPLICATOR .250 STRAIGHT					
SCALE	1:1	SIZE	A1	DRAWING NO	1385719	SHEET 3 of 3
REV	H					

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

Mouser Electronics

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