PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339621-1	A	-	BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1339621-1	A	-	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339621-7	A	-	-	-	SPARE PARTS KIT

CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: CLIP SECURITE 4.8 A ENFICHAGE DOUX

CRIMP	SIZE	TYPE	RANGE
WIRE	2.40 [.094 IN]	F	0.50-1.50mm²
INSUL	3.60 [.142 IN]	F	2.60-3.50 [.102-.138 IN]

WIRE STRIP LENGTH 4.00-4.80 [.157-.189 IN]

APPL INSTRUCTION 408-8323

TERMINAL - - FEED

APPL SPEC C1544291 △4 △5 - 19.50 [.768 IN]

TERMINALS APPLIED

1544291	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-

WIRE SIZE mm² AWG	CRIMP HEIGHT	PIN PN AND LENGTH [IN]
1.50mm²	1.64 ±0.05 [.065 ±.002 IN]	5-354778-2 [.2755]
1.00mm²	1.48 ±0.05 [.058 ±.002 IN]	6-354778-7 [.2830]
0.75mm²	1.41 ±0.03 [.056 ±.001 IN]	7-354778-1 [.2850]
0.50mm²	1.33 ±0.03 [.052 ±.001 IN]	8-354778-1 [.2900]
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

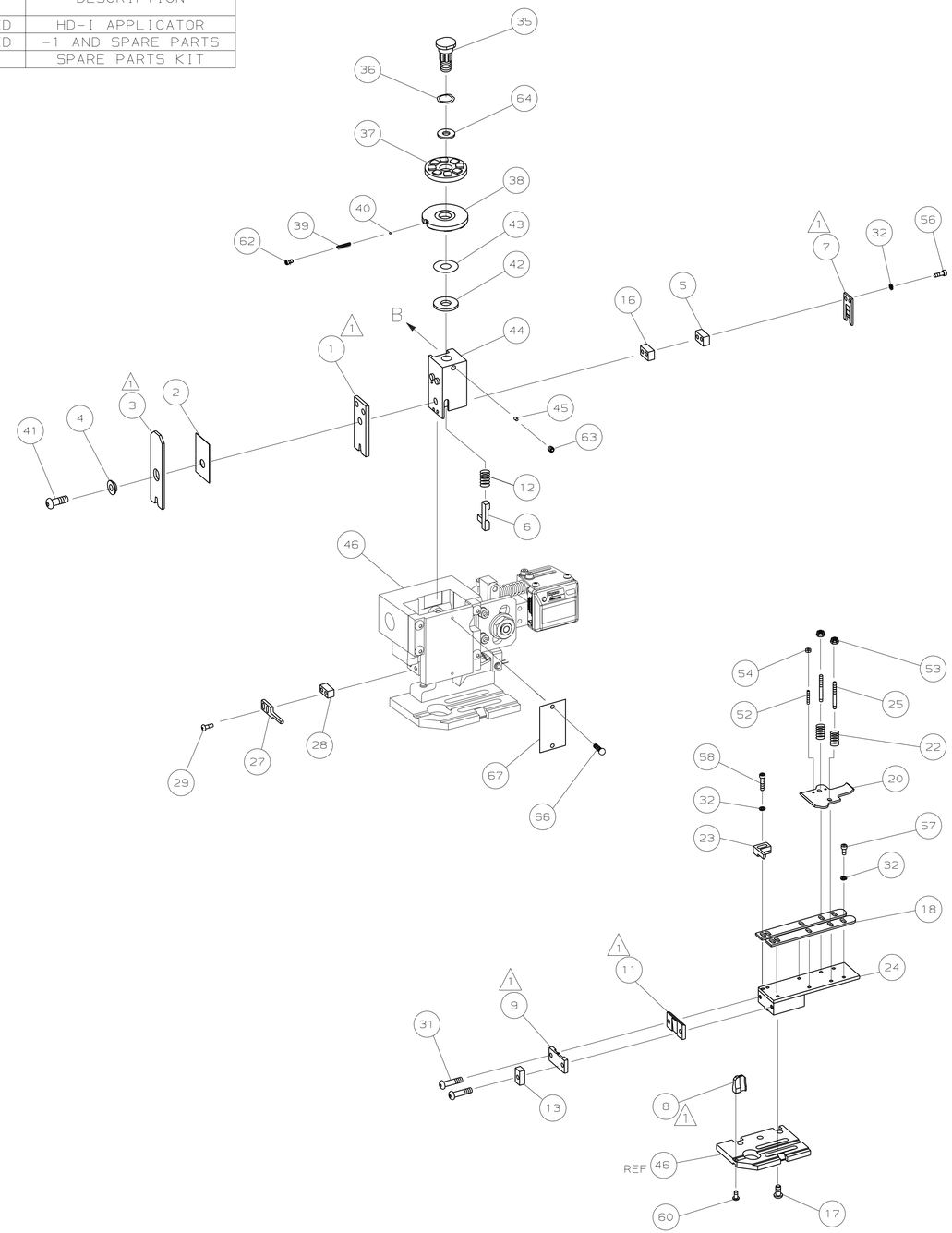
△1 RECOMMENDED SPARE PARTS.

2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.

3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

△4 CONTRADICTORY TO INSULATION CRIMP HEIGHT SPECIFIED ON C1544291, MAXIMUM INSULATION CRIMP HEIGHT TO BE 3.50mm FOR ALL WIRE SIZES.

△5 TENSILE VALUE STATED ON C1544291 FOR 1.50mm² WILL NOT ACHIEVE CAPABILITIY IF A STUDY IS COMPLETED.



					73
-	1	1	1339621	PRINT, APPLICATOR LOG SHEET	72
-	1	1	1338705-2	DOCUMENTATION PACKAGE	71
					70
					69
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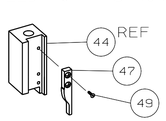
-	1	1	461264-1	PLATE, IDENTIFICATION	67
-	2	2	21017-2	SCR,DRIVE(#2X.19)ID PLATE	66
					65
-	1	1	986950-1	WASHER, FLAT PRECISION	64
-	1	1	3-18031-0	SCR,SKT SET(M6X6)RAM	63
-	1	1	18023-9	SCR,SKT CAP(M4X6)CP DSC	62
					61
-	1	1	18024-7	SCR,BHC(M4X10)ANVIL	60
					59
-	2	2	1-18023-3	SCR,SHC(M4X16)HOLD DOWN	58
-	5	5	18023-9	SCR,SHC(M4X6)STRIP GUIDE	57
-	2	2	9-18023-6	SCR,SHC(M4X14)SLUG BLADE	56
					55
-	2	2	18029-1	NUT,HEX(M3)DRAG	54
-	2	2	986965-1	NUT,HEX SL(M4)DRAG STUD	53
-	2	2	2-18032-2	SCR,SKT SET(M3X10)DRAG	52
					51
					50
-	1	1	18024-3	SCR,BHC(M3X10)CAM	49
					48
-	1	1	1338676-1	CAM, POST-FEED 30 & 40 mm ST	47
-	1	1	1338662-1	APPLICATOR, BASIC (SUBASSY)	46
-	1	1	690191-1	PLUG, NYLON	45
-	1	1	1320998-1	RAM	44
-	1	1	690125-1	WASHER, LAMINATED	43
-	1	1	690124-4	WASHER, RAM	42
-	1	1	2-18024-6	SCREW,BHC(M8X25)CRIMPER	41
-	1	1	23241-1	BALL, STEEL	40
-	1	1	2-22278-7	SPRING, COMPRESSION	39
-	1	1	1320922-1	DISC, INSULATION	38
-	1	1	354777-1	WIRE DISC, PLASTIC	37
-	1	1	22480-5	WASHER, SPRING	36
-	1	1	690212-1	POST, RAM	35
					34
					33
-	9	9	18025-2	WASHER,LOCK(M4)SHEAR BL	32
-	2	2	1-18024-0	SCR,BHC(M4X20)SHEAR PL	31
					30
-	2	2	18024-8	SCR,BHC(M4X12)STRIPPER	29
-	1	1	3-690451-2	SPACER, STRIPPER	28
-	1	1	240639-1	STRIPPER	27
					26
-	2	2	1320906-1	DRAG, STUD	25
-	1	1	1-1320995-5	PLATE, STRIP GUIDE	24
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	4-22281-1	SPRING, DRAG	22
					21
-	1	1	1338665-1	DRAG, STOCK	20
					19
-	2	2	1338663-5	GUIDE, LOWER STRIP	18
-	4	4	1-18024-8	SCR,BHC(M6X12)STRIP GD PL	17
-	1	1	1338708-1	SPACER, SLUG BLADE	16
					15
					14
-	1	1	690481-2	SPACER, HOLD DOWN	13
-	1	1	23846-1	SPRING, HOLD DOWN	12
△1 -	1	1	240644-1	PLATE, REAR SHEAR	11
					10
△1 -	1	1	690496-1	PLATE, FRONT SHEAR	9
△1 1	2	1	1333226-8	ANVIL	8
△1 -	1	1	690474-6	BLADE, SLUG	7
-	1	1	455892-1	HOLD DOWN, TERMINAL	6
-	1	1	240641-3	SPACER, SLUG BLADE	5
-	1	1	238009-8	SPACER, BLOCK CRIMPER	4
△1 1	2	1	7-1213077-3	CRIMPER, INSULATION	3
-	1	1	455888-5	SPACER, CRIMPER	2
△1 1	2	1	3-1490019-3	CRIMPER, WIRE	1
	-77	-71	-1	PART NO / DESCRIPTION	ITEM NO

← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

QTY REQD PER ASSY — PARTS LIST

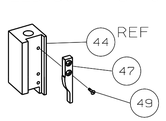
VIEW B ROTATED 180°

POST-FEED 40 mm STROKE



LEADMAKER OR BENCH G

POST-FEED 30 mm STROKE



K TERMINATOR BENCH MACHINE

LOC A

DIST 66

P	F	LTR	REVISION RECORD	APP	DATE
		A	SEE ECO-05-006966	MC	AUG05

DIMENSIONS: mm [INCHES]
DO NOT SCALE PRINT.
TOLERANCES UNLESS OTHERWISE SPECIFIED:
1 PLC DEC ±-
2 PLC DEC ±-
3 PLC DEC ±-
ANGLES ± -
SURF TEXTURE: √
REMOVE BURRS, BREAK SHARP EDGES R0.38 MAX

MATL - HT TR - FIN -

DR M.CLIFFORD 29JUN05 APP F.BACKHURST 29JUN05

CHK - REL 04-08-05 M.CLIFFORD

AMP Tyco Electronics Harrisburg, PA 17105-3608

NAME END FEED HD-I APPLICATOR

MACHINE REF HD-I APPL

SCALE - D DWG NO 1339621 SHEET 1 OF 1 REV A

CAGE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING

RESTRICTED TO -

THIS DRAWING IS A CONTROLLED DOCUMENT.

LAYOUT L1339621

SET UP GAGE 458638-3

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