PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1529153-1	A	-	BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1529153-1	A	-	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1529153-7	A	-	-	-	SPARE PARTS KIT

CRIMP DATA GROTE & HARTMANN TERMINAL GHW CRIMP SPECS

TERMINAL NAME: CLAW TERMINAL RING TYPE

CRIMP	SIZE	TYPE	RANGE
WIRE	3.30 [.130 IN]	F △4	1.00-2.50mm²
INSUL	4.57 [.180 IN]	OV △5	1.90-3.00 [.075-.118 IN]

WIRE STRIP LENGTH 5.25-6.05 [.207-.239 IN]

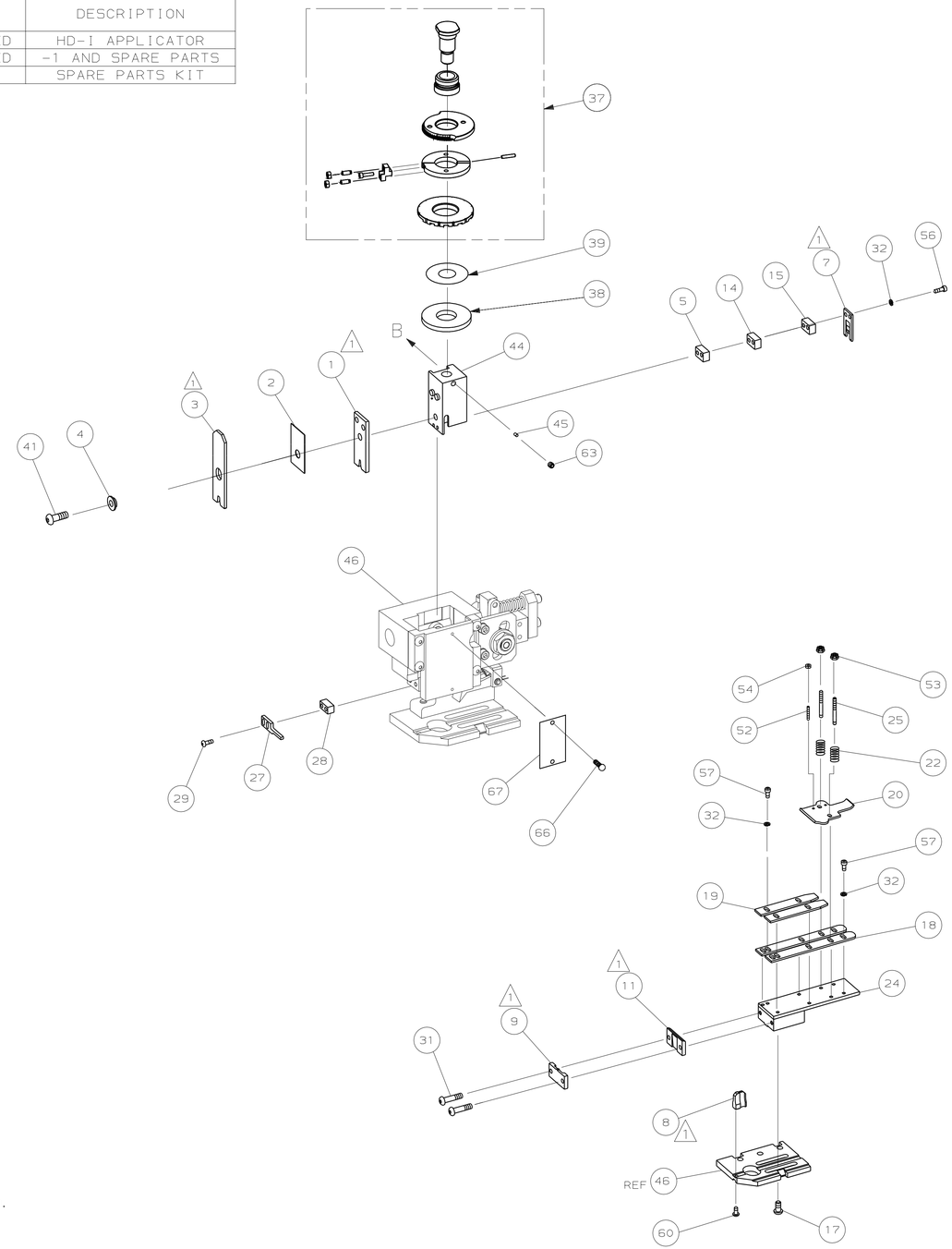
APPL INSTRUCTION 408-8323 & 408-8490

TERMINAL	-	-	FEED
APPL SPEC	-	-	29.90 [1.177 IN]

TERMINALS APPLIED

AMP PN	MFR PN	AMP PN	MFR PN	-
1572499-1	25219.213.004	1572900-1	25221.123.011	-
1572499-2	25219.213.320	1572900-2	25221.213.011	-
1572499-3	25219.123.014	1572900-3	25221.212.179	-
1572499-4	25219.123.011	1572900-4	25221.214.009	-
1572499-5	25219.123.322	1572900-5	25221.214.321	-
1572499-6	25219.123.009	1572900-6	25221.122.323	-
1572499-7	25219.411.031	1572900-7	25221.123.014	-
		1572900-8	25221.123.009	

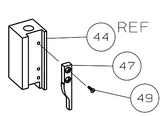
WIRE SIZE mm² AWG	CRIMP HEIGHT ✳	REF SETTING
2.50mm²	2.25 ±0.05 [.089 ±.002 IN]	B 0
2.00mm²	2.15 ±0.05 [.085 ±.002 IN]	C 0
1.50mm²	2.10 ±0.05 [.083 ±.002 IN]	C 5
1.00mm²	1.95 ±0.05 [.077 ±.002 IN]	D 1
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-



△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 WIRE CRIMP DATA SUPPLIED BY TERMINAL MANUFACTURER.
△5 INSULATION CRIMP DATA CALCULATED BY TYCO ELECTRONICS LTD.

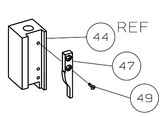
VIEW B ROTATED 180°

POST-FEED 40 mm STROKE



LEADMAKER OR BENCH G

POST-FEED 30 mm STROKE



K TERMINATOR BENCH MACHINE

LOC A
DIST 66

✳ WARNING:
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING.
USE OF SETTINGS BELOW MIN REQ'D CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

					73
-	1	1	1529153	PRINT, APPLICATOR LOG SHEET	72
-	1	1	1338705-4	DOCUMENTATION PACKAGE	71
					70
					69
					68
-	1	1	461264-5	PLATE, IDENTIFICATION	67
-	2	2	21017-2	SCR,DRIVE(#2X.19)ID PLATE	66
					65
					64
-	1	1	3-18031-0	SCR,SKT SET(M6X6)RAM	63
					62
					61
-	1	1	18024-7	SCR,BHC(M4X10)ANVIL	60
					59
					58
-	6	6	1-18023-0	SCR,SHC(M4X8)STRIP GUIDE	57
-	2	2	1-18023-4	SCR,SHC(M4X20)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
					43
					42
-	1	1	2-18024-6	SCREW,BHC(M8X25)CRIMPER	41
					40
-	1	1	690125-1	SHIM SUBASSY	39
-	1	1	1-469367-0	SPACER, FINE ADJUST	38
-	1	1	879103-2	FINE ADJUST HEAD SUBASSY	37
					36
					35
					34
					33
-	8	8	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	1-1320995-2	PLATE, STRIP GUIDE	24
					23
-	2	2	4-22281-1	SPRING, DRAG	22
					21
-	1	1	1338665-1	DRAG, STOCK	20
-	2	2	1338664-1	GUIDE, UPPER STRIP	19
-	2	2	1338663-4	GUIDE, LOWER STRIP	18
-	4	4	1-18024-8	SCR,BHC(M6X12)STRIP GD PL	17
					16
-	1	1	7-240641-1	SPACER, SLUG BLADE	15
-	1	1	1-240641-1	SPACER, SLUG BLADE	14
					13
					12
△1 -	1	1	240644-9	PLATE, REAR SHEAR	11
					10
△1 -	1	1	690482-4	PLATE, FRONT SHEAR	9
△1 1	2	1	1-1333221-6	ANVIL	8
△1 -	1	1	690474-4	BLADE, SLUG	7
					6
-	1	1	2-240641-5	SPACER, SLUG BLADE	5
-	1	1	238009-2	SPACER, BLOCK CRIMPER	4
△1 1	2	1	1-854830-9	CRIMPER, INSULATION	3
-	1	1	455888-5	SPACER, CRIMPER	2
△1 1	2	1	3-456410-2	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

A1	SEE ECR-06-024568	LJL	OCT06
A	FIRST RELEASE	LJL	MAY05
P F	LTR REVISION RECORD	APP	DATE

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 10MAY05 L.LOFTHOUSE | APP 10MAY05 F.BACKHURST
CHK - - | REL 17MAY05 L.LOFTHOUSE

AMP Tyco Electronics Harrisburg, PA 17105-3608

NAME FINE ADJ END FD HD-I APPL | MACHINE REF HD-I APPL
SCALE - | D | DWG NO 1529153 | SHEET 1 OF 1 | REV A1

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO -

LAYOUT L1529106
SET UP GAGE 458638-3

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