PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1239046-1	A	-	BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1239046-1	A	-	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1239046-7	A	-	-	-	SPARE PARTS KIT

CRIMP DATA (NON-AMP TERMINAL-AMP SPEC)

TERMINAL NAME: TERMINAL

CRIMP	SIZE	TYPE	RANGE
WIRE	2.03 [.080 IN]	F	22-20
INSUL	3.81 [.150 IN]	F	1.83 MAX [.072 IN MAX]

WIRE STRIP LENGTH 3.58-3.96 [.141-.156 IN]

APPL INSTRUCTION 408-8323

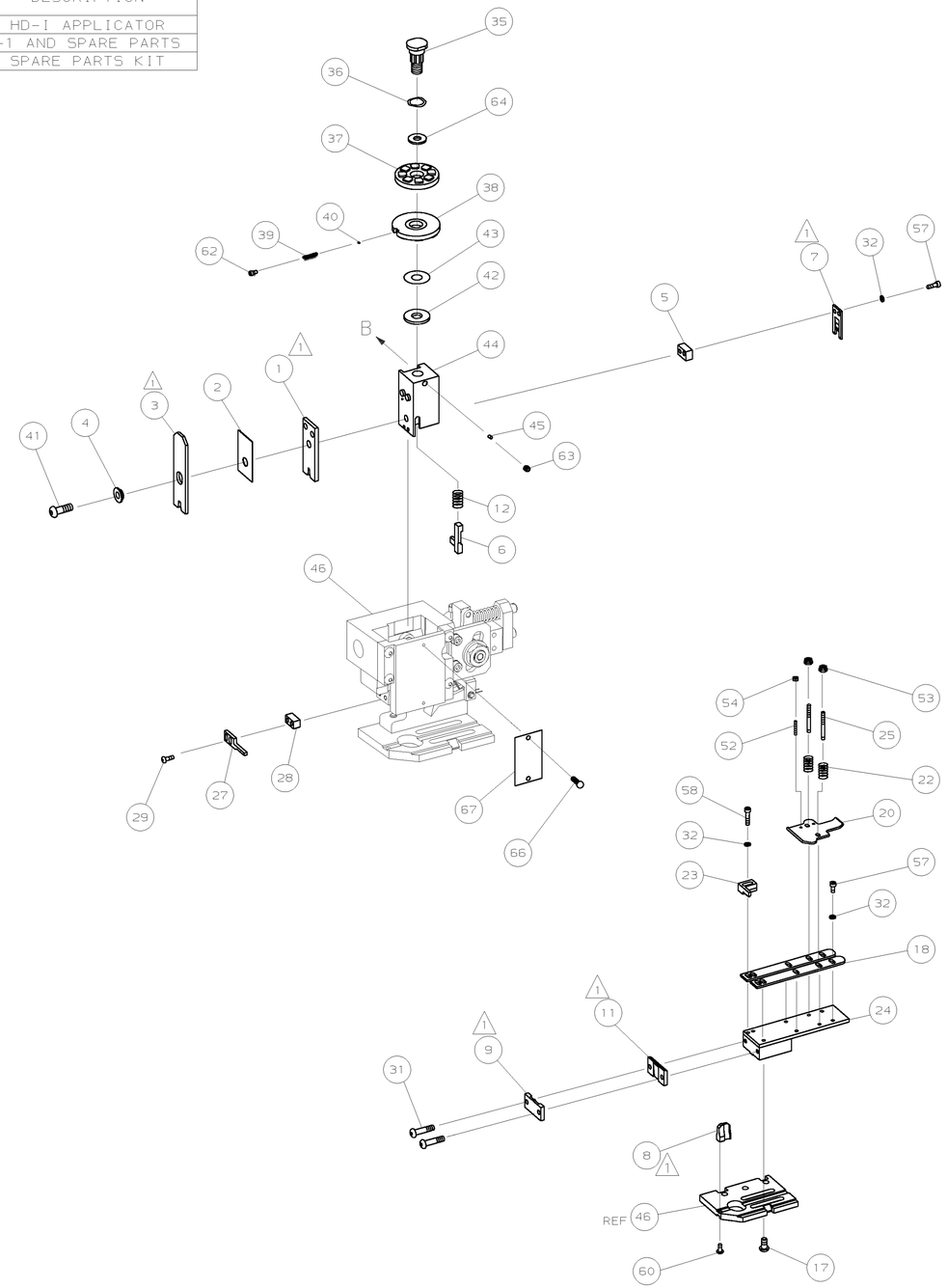
TERMINAL	-	-	FEED
APPL SPEC	NONE	-	14.61 [.575 IN]

TERMINALS APPLIED

AMP P/N	MFG P/N	-	-	-
286794	K25144.123.111	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-

WIRE SIZE mm² AWG	CRIMP HEIGHT	PIN PN & LENGTH [IN]
20	1.32 ±0.05 [.052 ±.002 IN]	2-354779-1 [.3095]
22	1.24 ±0.05 [.049 ±.002 IN]	2-354779-8 [.3130]
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

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.



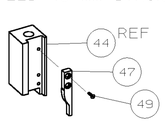
					73
-	1	1	1239046	PRINT, APPLICATOR LOG SHEET	72
-	1	1	1338705-2	DOCUMENTATION PACKAGE	71
					70
					69
					68
-	1	1	461264-1	PLATE, IDENTIFICATION	67
-	2	2	21017-2	SCR,DRIVE(#2X.19)ID PLATE	66
					65
-	1	1	986950-1	WASHER, FLAT PRECISION	64
-	1	1	3-18031-0	SCR,SKT SET(M6X6)RAM	63
-	1	1	18023-9	SCR,SKT CAP(M4X6)CP DSC	62
					61
-	1	1	18024-7	SCR,BHC(M4X10)ANVIL	60
					59
-	2	2	1-18023-3	SCR,SHC(M4)HOLD DOWN	58
-	7	7	1-18023-0	SCR,SHC(M4X10)STRIP GUIDE	57
					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	690124-1	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	1-1320922-0	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
-	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	1320995-1	STRIP GUIDE	24
-	1	1	240825-2	PLATE, STRIP HOLD DOWN	23
-	2	2	4-22281-1	SPRING, DRAG	22
					21
-	1	1	1338665-1	DRAG, STOCK	20
					19
-	2	2	1338663-4	GUIDE, LOWER STRIP	18
-	4	4	1-18024-8	SCR,BHC(M6X12)STRIP GD PL	17
					16
					15
					14
					13
-	1	1	23846-1	SPRING, HOLD DOWN	12
1 -	1	1	240644-1	PLATE, REAR SHEAR	11
					10
1 -	1	1	690482-4	PLATE, FRONT SHEAR	9
1 1	2	1	1338686-2	ANVIL	8
1 -	1	1	690474-4	BLADE, SLUG	7
-	1	1	5-455892-8	HOLD DOWN, TERMINAL	6
-	1	1	4-240641-0	SPACER, SLUG BLADE	5
-	1	1	238009-8	SPACER, BLOCK CRIMPER	4
1 1	2	1	1-683453-8	CRIMPER, INSULATION	3
-	1	1	455888-6	SPACER, CRIMPER	2
1 1	2	1	1-456405-8	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

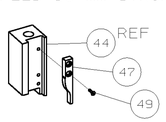
VIEW B ROTATED 180°

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
		A1	ECN 0150-1036-04	TE	8-04
		A	REVISED	TK	9-00

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 RO.38 MAX

MATL	-	HT TR	-	FIN	-
	-		-		-

DR T.KINT 21AUG00 APP T.ELBIN 21AUG00
CHK - - REL - -

AMP Incorporated Harrisburg, PA 17105-3608

NAME END FEED HD-I APPLICATOR
MACHINE REF HD-I APPL
SCALE - D DWG NO 1239046 SHEET 1 OF 1 REV A1

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SET UP GAGE 458638-3
LAYOUT L2425