PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339721-1	B	-	BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1339721-1	B	-	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339721-7	B	-	-	-	SPARE PARTS KIT

CRIMP DATA ESCUBEDO TERMINAL AMP CRIMP SPECS

TERMINAL NAME: TERMINAL HEMBRA SERIE 6.3

CRIMP	SIZE	TYPE	RANGE
WIRE	2.54 [.100 IN] △4	F	0.75-2.50mm² △6
INSUL	4.57 [.180 IN] △4	F	2.30-4.30 [.091-.169 IN] △5

WIRE STRIP LENGTH 4.60-5.35 [.181-.211 IN]

APPL INSTRUCTION 408-8323

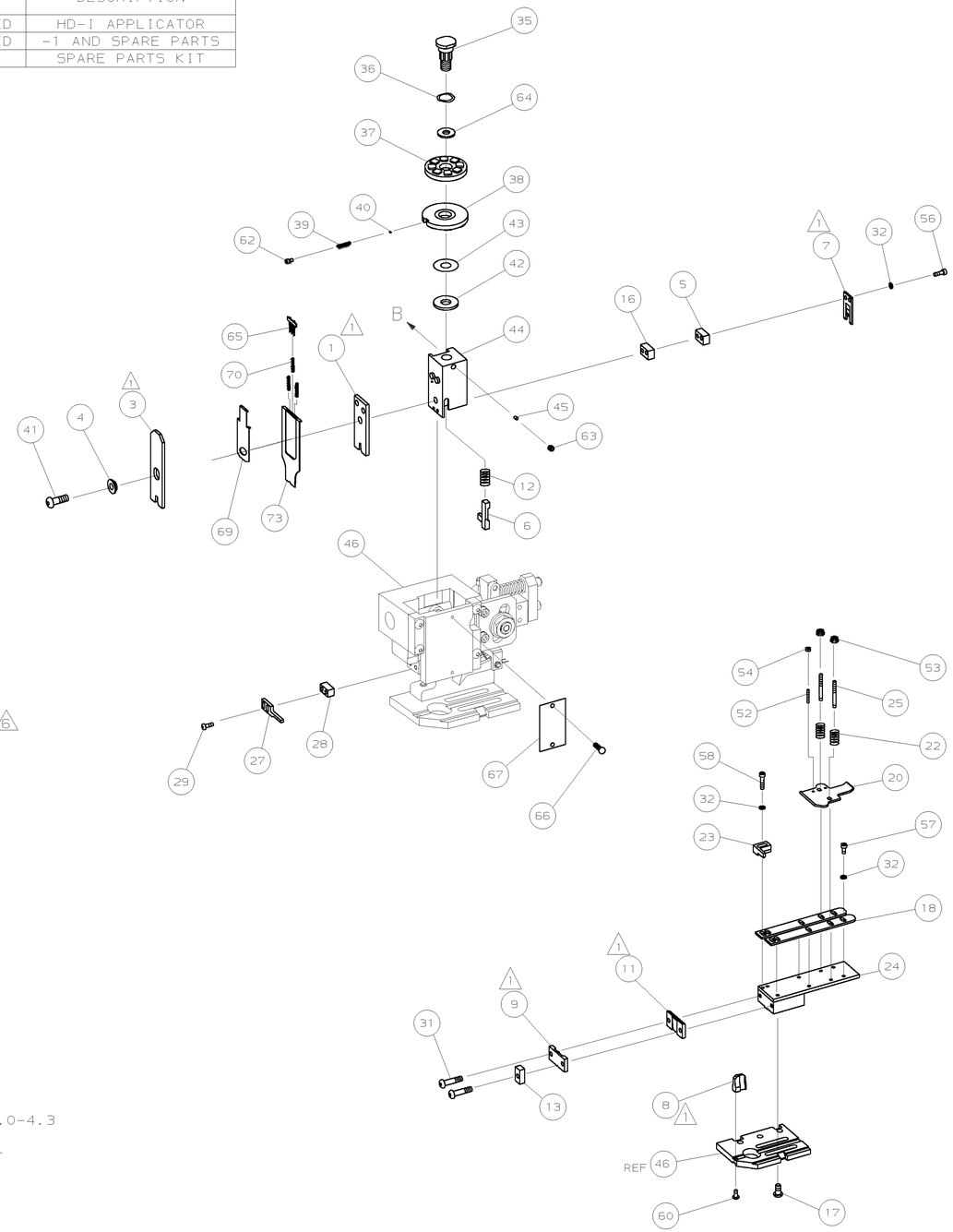
TERMINAL	-	-	FEED
APPL SPEC	-	-	18.75 [.738 IN]

TERMINALS APPLIED

AMP PN	MFR PN	-	-	-
1572353-1	4542.00	-	-	-
1572353-2	4542.02	-	-	-
1572353-3	4542.24	-	-	-
1572353-4	4542.30	-	-	-
1572353-5	4542.32	-	-	-
-	-	-	-	-
-	-	-	-	-

WIRE SIZE mm² AWG	CRIMP HEIGHT △4	PIN PN AND LENGTH [IN]
2.50mm²	2.21 ±0.05 [.087 ±.002 IN]	5-354778-5 [.2770]
1.50mm²	1.88 ±0.05 [.074 ±.002 IN]	8-354778-3 [.2910]
1.00mm²	1.73 ±0.05 [.068 ±.002 IN]	9-354778-6 [.2975]
0.75mm²	1.65 ±0.05 [.065 ±.002 IN]	354779-4 [.3010] △6
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

△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 ALL CRIMP DATA CALCULATED BY TYCO ELECTRONICS UK LTD.
△5 INSULATION RANGE STATED IS RANGE OF APPLICATOR AND NOT THAT OF TERMINAL. TERMINAL INS RANGE 3.0-4.3 [.118-.169 IN].
△6 WIRE RANGE STATED IS THAT OF THE APPLICATOR AND NOT THAT OF TERMINAL. TERMINAL WIRE RANGE 1.0-2.5mm².

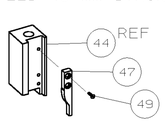


QTY REQD PER ASSY			PARTS LIST		
-	1	1	1490525-3	DEPRESSOR, WIRE	73
-	1	1	1339721	PRINT, APPLICATOR LOG SHEET	72
-	1	1	1338705-2	DOCUMENTATION PACKAGE	71
-	3	3	2-23147-2	SPRING, DEPRESSOR	70
-	1	1	1490524-1	SPACER, DEPRESSOR	69
					68
-	1	1	461264-1	PLATE, IDENTIFICATION	67
-	2	2	21017-2	SCR,DRIVE(#2X.19)ID PLATE	66
-	1	1	1424350-1	HOLDER, PIN, WIRED	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	1-18023-0	SCR,SHC(M4X8)STRIP GUIDE	57
-	2	2	1-18023-2	SCR,SHC(M4X12)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	690124-1	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	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	1320995-1	STRIP GUIDE	24
-	1	1	240825-6	PLATE, STRIP HOLD DOWN	23
-	2	2	4-22281-1	SPRING, DRAG	22
					21
-	1	1	1338665-1	DRAG, STOCK	20
					19
-	2	2	1338663-6	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	1-690481-4	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	690482-6	PLATE, FRONT SHEAR	9
△1 1	2	1	1-1333218-2	ANVIL	8
△1 -	1	1	690474-6	BLADE, SLUG	7
-	1	1	1-455892-1	HOLD DOWN, TERMINAL	6
-	1	1	240641-7	SPACER, SLUG BLADE	5
-	1	1	238009-1	SPACER, BLOCK CRIMPER	4
△1 1	2	1	4-456134-6	CRIMPER, INSULATION	3
					2
△1 1	2	1	456407-6	CRIMPER, WIRE	1
	-77	-71	-1	PART NO / DESCRIPTION	ITEM NO

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

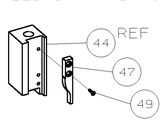
VIEW B ROTATED 180°

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
		B	SEE ECN 015A-0860-03	LJL	DEC03
		A	SEE ECN 015A-0850-03	LJL	DEC03

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 290CT03 M.CLIFFORD	APP 290CT03 F.BACKHURST	AMP Tyco Electronics Harrisburg, PA 17105-3608	
CHK - -	REL 04DEC03 L.LOFTHOUSE		
NAME END FEED HD-I APPLICATOR		MACHINE REF HD-I	APPL
SCALE -	D DWG NO 1339721	SHEET 1 OF 1	REV B
CAGE CODE 00779	CUSTOMER AND ASSEMBLY DRAWING		RESTRICTED TO —

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SET UP GAGE 458638-3
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