PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1529074 – 1	B	–	BENCH & LEADMAKER	MECH POST FEED	HD–I APPLICATOR
7–1529074 – 1	B	–	BENCH & LEADMAKER	MECH POST FEED	–1 AND SPARE PARTS
7–1529074 – 7	A	–	–	–	SPARE PARTS KIT

USED ON –

THIS DRAWING IS A CONTROLLED DOCUMENT. DWG NO 1529074

CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: RING TONGUE

CRIMP	SIZE	TYPE	RANGE
WIRE	3.30 [.130 IN]	F	1.50mm² – 2.50mm²
INSUL	4.57 [.180 IN]	F	2.70–4.00 [.106–.157 IN]

WIRE STRIP LENGTH 4.80–5.60 [.189–.220 IN]

APPL INSTRUCTION 408–8323 & 408–8490

TERMINAL – –
APPL SPEC 114–3118 –

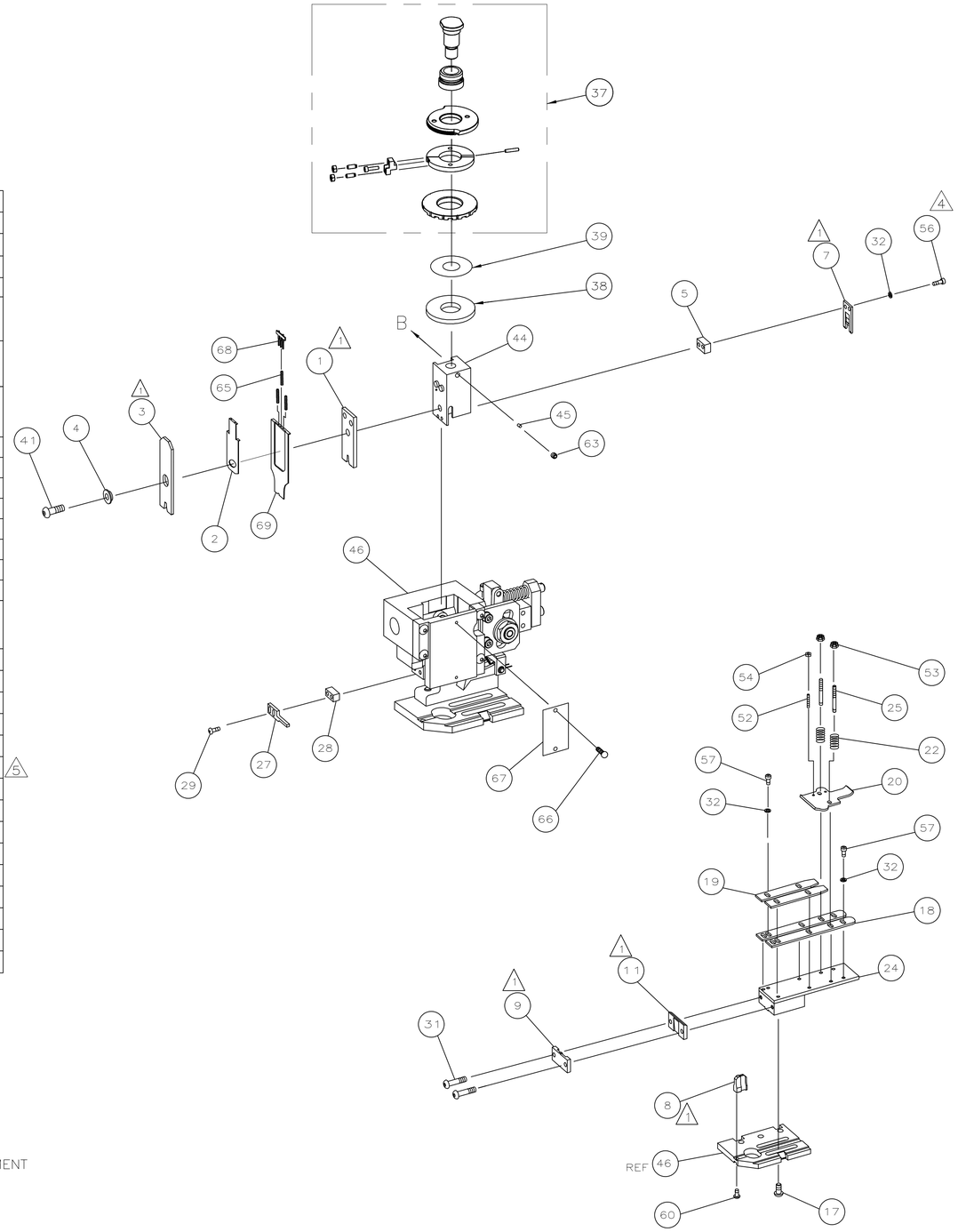
FEED 21.77 [.857 IN]

TERMINALS APPLIED

880642	–	–	–	–
880623	–	–	–	–
880643	–	–	–	–
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–

WIRE SIZE mm² AWG	CRIMP HEIGHT *	REF SETTING *
2.50mm²	2.41 ±0.05 [.095 ±.002 IN]	B3
14 AWG	2.26 ±0.05 [.089 ±.002 IN]	C4
2.00mm²	2.23 ±0.05 [.088 ±.002 IN]	C6
1.50mm²	2.11 ±0.05 [.083 ±.002 IN]	D4
16 AWG	2.08 ±0.05 [.082 ±.002 IN]	D6
1.00mm²	2.00 ±0.05 [.079 ±.002 IN]	E1 △5
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–

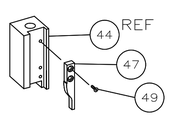
SET UP GAGE	LAYOUT
458638–3	L1339520



△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 CUT TO LENGTH AT ASSY.
△5 1.00mm² WIRE SIZE IS FOR A SPECIFIC CUSTOMER REQUIREMENT AND IS OUTSIDE THE NORMAL RANGE OF THIS APPLICATOR.

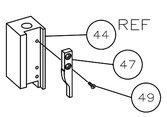
VIEW B ROTATED 180°

POST–FEED 40 mm STROKE



LEADMAKER OR BENCH G

POST–FEED 30 mm STROKE



K TERMINATOR BENCH MACHINE

LOC A
DIST 66

3308–8 (1/08)

* 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.

QTY REQD PER ASSY			PARTS LIST		ITEM NO
					73
–	1	1	1529074	PRINT, APPLICATOR LOG SHEET	72
–	1	1	1338705–4	DOCUMENTATION PACKAGE	71
					70
–	1	1	1490525–1	DEPRESSOR, WIRE	69
–	1	1	1424350–1	HOLDER, PIN, WIRED	68
–	1	1	461264–5	PLATE, IDENTIFICATION	67
–	2	2	21017–2	SCR,DRIVE(#2X.19)ID PLATE	66
–	2	2	1–23147–4	SPRING, COMPRESSION	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	18023–9	SCR,SHC(M4X6)STRIP GUIDE	57
△4 –	2	2	1–18023–3	SCR,SHC(M4X16)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	1338662–2	APPLICATOR, BASIC (SUBASSY)	46
–	1	1	690191–1	PLUG, NYLON	45
–	1	1	1333260–1	RAM	44
					43
					42
–	1	1	2–18024–6	SCREW,BHC(M8X25)CRIMPER	41
					40
–	1	1	690125–1	SHIM SUBASSY	39
–	1	1	469367–1	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	1–690451–1	SPACER, STRIPPER	28
–	1	1	240639–1	STRIPPER	27
					26
–	2	2	1320906–1	DRAG, STUD	25
–	1	1	1320995–1	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	1338663–2	GUIDE, LOWER STRIP	18
–	4	4	1–18024–8	SCR,BHC(M6X12)STRIP GD PL	17
					16
					15
					14
					13
					12
△1 –	1	1	240644–1	PLATE, REAR SHEAR	11
					10
–	1	1	690482–4	PLATE, FRONT SHEAR	9
△1 1	2	1	1333221–1	ANVIL	8
–	1	1	690474–4	BLADE, SLUG	7
					6
–	1	1	1–240641–5	SPACER, SLUG BLADE	5
–	1	1	238009–1	SPACER, BLOCK CRIMPER	4
1	2	1	4–456134–6	CRIMPER, INSULATION	3
–	1	1	1490524–2	SPACER, DEPRESSOR	2
△1 1	2	1	456410–3	CRIMPER, WIRE	1
–77	–71	–1	PART NO	DESCRIPTION	ITEM NO

P	LTR	REVISION RECORD	DATE	DWN	APVD
B		ECR–09–024781	11–2009	MY	TE

DIMENSIONS: INCHES
TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ± –
1 PLC ± –
2 PLC ± –
3 PLC ± –
4 PLC ± –
ANGLES ± –
SURFACE TEXTURE √

DWN M.CLIFFORD 21AUG03
CHK –
APVD F.BACKHURST 21AUG03
MATERIAL – – –
HEAT TREAT – – –

Tyco Electronics — Tyco Electronics Corporation, Harrisburg, PA 17105–3608

NAME FINE ADJ END FD HD–I APPL –
SCALE – SIZE A1 DRAWING NO 1529074 SHEET 1 OF 1 REV B

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

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