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| LOC | DIST |
|---|---|
| A | 66 |

REVISIONS

| P | LTR | DESCRIPTION | DATE | DWN | APVD |
|---|---|---|---|---|---|
| | B | ECR-08-006284 | 3-2008 | MY | TE |

| PART NUMBER | REV | FIRST USED | TERMINATOR | FEED TYPE | DESCRIPTION |
|---|---|---|---|---|---|
| 1339720-1 | B | - | BENCH & LEADMAKER | MECH POST FEED | HD-I APPLICATOR |
| 7-1339720-1 | B | - | BENCH & LEADMAKER | MECH POST FEED | -1 AND SPARE PARTS |
| 7-1339720-7 | A | - | - | - | SPARE PARTS KIT |

## CRIMP DATA ESCUBEDO TERMINAL AMP CRIMP SPECS

TERMINAL NAME: RING TONGUE

| CRIMP | SIZE | TYPE | RANGE |
|---|---|---|---|
| WIRE | 2.79 [.110 IN] △4 | F | 0.75-2.00mm² |
| INSUL | 4.32 [.170 IN] △4 | F | 2.30-3.50 [.091-.138 IN] △6 |

WIRE STRIP LENGTH 4.50-5.25 [.177-.207 IN]

APPL INSTRUCTION 408-8323

| | | |
|---|---|---|
| TERMINAL | - | - |
| APPL SPEC | - | - |

FEED 22.00 [.866 IN]

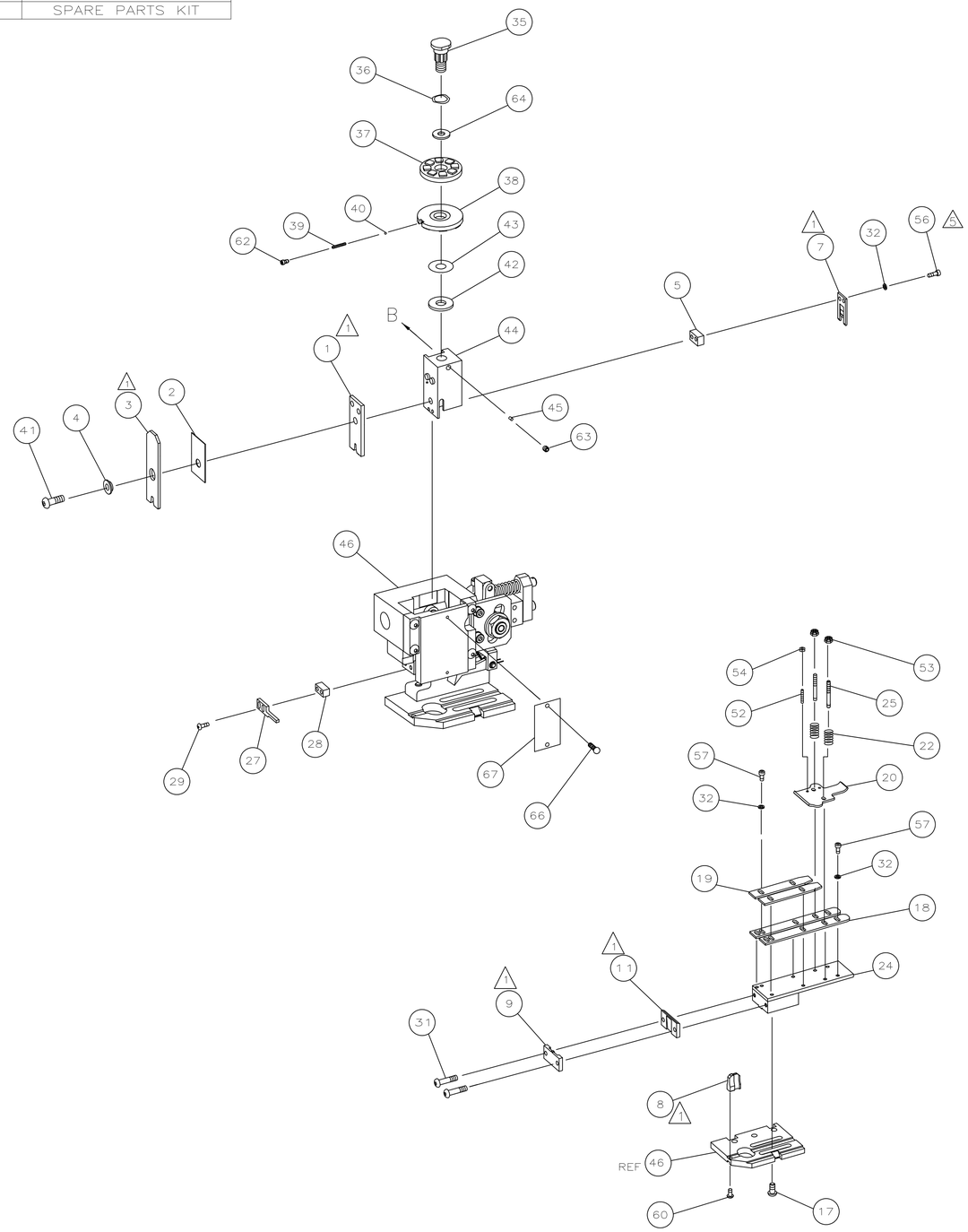
### TERMINALS APPLIED

| AMP PN | MFR PN | - | - | - |
|---|---|---|---|---|
| 1572352-1 | 3382.00 | - | - | - |
| 1572352-2 | 3382.02 | - | - | - |
| 1572352-3 | 3382.04 | - | - | - |
| 1572352-4 | 3382.24 | - | - | - |
| 1572352-5 | 3382.30 | - | - | - |
| 1572352-6 | 3382.32 | - | - | - |
| - | - | - | - | - |

| WIRE SIZE mm² AWG | CRIMP HEIGHT △4 | PIN PN AND LENGTH [IN] |
|---|---|---|
| 2.00mm² | 2.17 ±0.05 [.085 ±.002 IN] | 6-354778-7 [.2830] |
| 1.50mm² | 2.02 ±0.05 [.080 ±.002 IN] | 7-354778-8 [.2885] |
| 1.00mm² | 1.88 ±0.05 [.074 ±.002 IN] | 9-354778-1 [.2950] |
| 0.75mm² | 1.80 ±0.05 [.071 ±.002 IN] | 9-354778-7 [.2980] |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |

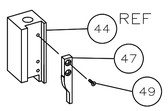
| SET UP GAGE | LAYOUT |
|---|---|
| 458638-3 | L1339720 |

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. CUT TO LENGTH AT ASSY.
6. INSULATION RANGE QUOTED IS THAT OF THE APPLICATOR, NOT THE TERMINAL.



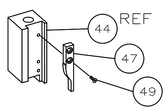

### VIEW B ROTATED 180°

POST-FEED 40 mm STROKE




LEADMAKER OR BENCH G

POST-FEED 30 mm STROKE




K TERMINATOR BENCH MACHINE

| QTY REQD PER ASSY | | | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|---|---|
| | | | | | 73 |
| - | 1 | 1 | 1339720 | 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 |
| | | | | | 58 |
| - | 6 | 6 | 18023-9 | SCR,SHC(M4X6)STRIP GUIDE | 57 |
| △5 - | 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 | 1338662-1 | 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 |
| - | 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 |
| | | | | | 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 | 1338663-1 | 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 | 1-690482-8 | PLATE, FRONT SHEAR | 9 |
| △1 1 | 2 | 1 | 3-1333219-7 | ANVIL | 8 |
| - | 1 | 1 | 690474-5 | BLADE, SLUG | 7 |
| | | | | | 6 |
| - | 1 | 1 | 2-240641-7 | SPACER, SLUG BLADE | 5 |
| - | 1 | 1 | 238009-2 | SPACER, BLOCK CRIMPER | 4 |
| △1 1 | 2 | 1 | 2-1424909-6 | CRIMPER, INSULATION | 3 |
| - | 1 | 1 | 455888-5 | SPACER, CRIMPER | 2 |
| △1 1 | 2 | 1 | 456408-6 | CRIMPER, WIRE | 1 |
| -77 | -71 | -1 | | | |

PARTS LIST

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ± -
1 PLC ± -
2 PLC ± -
3 PLC ± -
4 PLC ± -
ANGLES ± -

MATERIAL -
FINISH -

DWN M.CLIFFORD 270CT03
CHK -
APVD F.BACKHURST 270CT03
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

Tyco Electronics
Tyco Electronics Corporation
Harrisburg, PA 17105-3608

NAME END FEED HD-I APPLICATOR

| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|---|---|---|---|
| A1 | 00779 | C-1339720 | - |

CUSTOMER DRAWING SCALE - SHEET 1 OF 1 REV B