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| PART NUMBER | REV | TERMINATOR | FEED TYPE | DESCRIPTION |
|---|---|---|---|---|
| 1528639-1 | A | LEADMAKER | MECH POST FEED | CUTS CARRIER |
| 1528639-2 | A | BENCH | MECH PRE FEED | CUTS CARRIER |
| 1528639-6 | A | LEADMAKER | MECH POST FEED | CONTINUOUS CARRIER |
| 7-1528639-1 | A | LEADMAKER | MECH POST FEED | -1 AND SPARE PARTS |
| 7-1528639-2 | A | BENCH | MECH PRE FEED | -2 AND SPARE PARTS |
| 7-1528639-6 | A | LEADMAKER | MECH POST FEED | -6 AND SPARE PARTS |
| 7-1528639-7 | A | - | - | SPARE PARTS KIT |

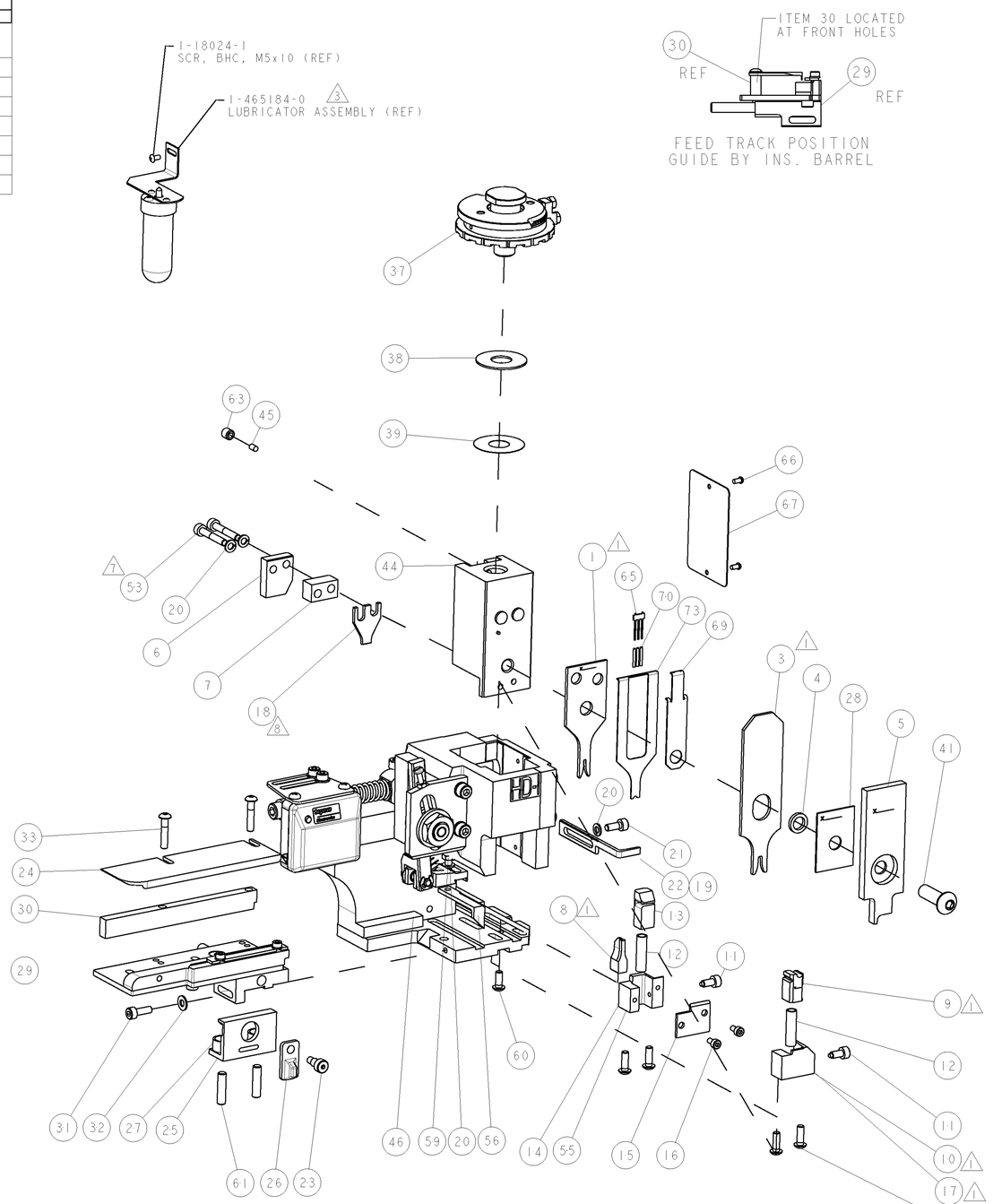
| CRIMP DATA MOLEX TERMINAL TE CRIMP SPEC | | | |
|---|---|---|---|
| TERMINAL NAME: CRIMP TERMINAL .062" DIAMETER | | | |
| CRIMP | SIZE | TYPE | RANGE |
| WIRE | 1.40 [.055 IN] | F | 24-18 AWG △6 |
| INSUL | 2.54 [.100 IN] | F | 1.52-2.30 [.060-.090 IN] |
| WIRE STRIP LENGTH 3.17-3.96 [.125-.156 IN] | | | APPL INSTRUCTIONS 408-8322 & 408-8490 |
| TERMINAL - - APPL SPEC - - | | | FEED 9.55 [.376 IN] |

TERMINALS APPLIED

| TYCO PN (PIN) | MFR PN (PIN) | TYCO PN (SKT) | MFR PN (SKT) |
|---|---|---|---|
| 1572015-1 | 02-06-2101 | 1572015-7 | 02-06-1101 |
| 1572015-2 | 02-06-6101 | 1572015-8 | 02-06-5101 |
| 1572015-3 | 02-06-6118 | 1572015-9 | 02-06-5108 |
| 1572015-4 | 02-06-6116 | 1-1572015-0 | 02-06-5100 |
| 1572015-5 | 02-06-6100 | 1-1572015-1 | 02-06-5105 |
| 1572015-6 | 02-06-6105 | 1-1572015-2 | 02-06-1118 |

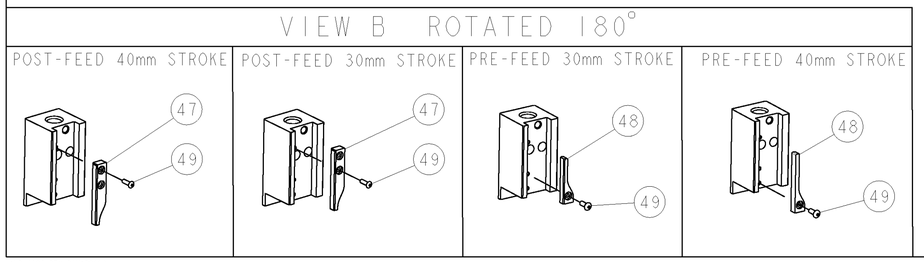
| WIRE SIZE | CRIMP HEIGHT * △5 | REF SETTING * |
|---|---|---|
| 0.75 $mm^2$ | 01.02 ±0.05 [.040 ±.002 IN] | A2 |
| 0.50 $mm^2$ | 0.86 ±0.05 [.034 ±.002 IN] | B0 |
| 0.25 $mm^2$ | 0.74 ±0.05 [.029 ±.002 IN] | B9 |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| | | |

△1 RECOMMENDED SPARE PARTS.
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
△3 CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.
4. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
△5 CRIMP DATA CALCULATED BY TYCO ELECTRONICS UK LTD. TENSILE VALUES (BASED UPON MOLEX AWG TENSILE VALUES);
0.75$mm^2$ = 85N
0.50$mm^2$ = 64N
0.25$mm^2$ = 43N
△6 WIRE RANGE QUOTED IS THAT OF THE TERMINAL AND NOT THAT OF THE APPLICATOR.
△7 CUT TO LENGTH AT ASSEMBLY.
△8 [ITEM 18] TERMINAL HOLD DOWN, WILL REQUIRE ADJUSTMENT WHEN CHANGING BETWEEN PIN & SOCKET TYPE TERMINALS.




* WARNING
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN. REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

VIEW B ROTATED 180°




| ITEM NO | DESCRIPTION | PART NO | -1 | -2 | -6 | -71 | -72 | -76 | -77 |
|---|---|---|---|---|---|---|---|---|---|
| 83 | - | - | - | - | - | - | - | - | - |
| 82 | - | - | - | - | - | - | - | - | - |
| 81 | - | - | - | - | - | - | - | - | - |
| 80 | - | - | - | - | - | - | - | - | - |
| 79 | - | - | - | - | - | - | - | - | - |
| 78 | - | - | - | - | - | - | - | - | - |
| 77 | - | - | - | - | - | - | - | - | - |
| 76 | - | - | - | - | - | - | - | - | - |
| 75 | - | - | - | - | - | - | - | - | - |
| 74 | - | - | - | - | - | - | - | - | - |

SET UP GAGE 458637-3

LOC A DIST 66

REVISIONS

| P | LTR | DESCRIPTION | DATE | DWN | APVD |
|---|---|---|---|---|---|
| | A | SEE ECO-06-009795 | 26APR2006 | DP | MC |
| | A1 | ECR-08-017422 | 18JUL2008 | MY | TE |

| ITEM NO | DESCRIPTION | PART NO | -1 | -2 | -6 | -71 | -72 | -76 | -77 |
|---|---|---|---|---|---|---|---|---|---|
| 73 | DEPRESSOR, WIRE | 1490525-3 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 72 | - | - | - | - | - | - | - | - | - |
| 71 | DOCUMENTATION PACKAGE | 1338705-3 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 70 | SPRING, COMPRESSION | 2-23147-2 | 3 | 3 | 3 | 3 | 3 | 3 | - |
| 69 | DEPRESSOR, SPACER | 1490524-1 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 68 | - | - | - | - | - | - | - | - | - |
| 67 | PLATE, IDENTIFICATION | 461264-5 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 66 | SCREW, DRIVE | 21017-2 | 2 | 2 | 2 | 2 | 2 | 2 | - |
| 65 | HOLDER, PIN, WIRED | 1424350-1 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 64 | - | - | - | - | - | - | - | - | - |
| 63 | SCR, SET, CUP POINT M6 X 6.0 | 3-18031-0 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 62 | - | - | - | - | - | - | - | - | - |
| 61 | SCR, SET, FLT POINT M5 X 20.0 | 2-18032-5 | 2 | 2 | 2 | 2 | 2 | 2 | - |
| 60 | SCR, BTN SKT HD CAP (M4 X 10.0) | 18024-7 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 59 | SCR, HEX HD CAP M4 X 8.0 | 5-18022-2 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 58 | - | - | - | - | - | - | - | - | - |
| 57 | - | - | - | - | - | - | - | - | - |
| 56 | PAWL, FEED | 1338685-1 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 55 △1 | HOLDER, SHEAR, REAR [NO CUT] | 1338723-1 | 1 | - | - | 1 | - | - | - |
| 54 | SCR, BTN SKT HD CAP (M4 X 12.0) | 18024-8 | 4 | 4 | 4 | 4 | 4 | 4 | - |
| 53 △7 | SCR, SKT HD CAP M4 X 25.0 | 1-18023-5 | 2 | 2 | 2 | 2 | 2 | 2 | - |
| 52 | - | - | - | - | - | - | - | - | - |
| 51 | - | - | - | - | - | - | - | - | - |
| 50 | - | - | - | - | - | - | - | - | - |
| 49 | SCR, BTN SKT HD CAP (M3 X 10.0) | 18024-3 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 48 | CAM, UNIVERSAL PRE FEED | 1338675-1 | 1 | - | - | 1 | - | 1 | - |
| 47 | CAM, UNIVERSAL POST-FEED | 1338676-1 | 1 | - | 1 | 1 | - | 1 | - |
| 46 | APPLICATOR SUBASSEMBLY, HDI | 1320999-3 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 45 | PLUG,NYLON | 690191-1 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 44 | RAM | 1338660-3 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 43 | - | - | - | - | - | - | - | - | - |
| 42 | - | - | - | - | - | - | - | - | - |
| 41 | SCR, BTN SKT HD CAP (M8 X 25.0) | 2-18024-6 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 40 | - | - | - | - | - | - | - | - | - |
| 39 | SHIM SUB-ASSY | 690125-1 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 38 | SHIM | 469367-7 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 37 | FINE ADJUST HEAD SUBASSY | 879103-3 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 36 | - | - | - | - | - | - | - | - | - |
| 35 | - | - | - | - | - | - | - | - | - |
| 34 | - | - | - | - | - | - | - | - | - |
| 33 | SCR, BTN SKT HD CAP (M4 X 20.0) | 1-18024-0 | 2 | 2 | 2 | 2 | 2 | 2 | - |
| 32 | WASHER, FLAT, REG M4 | 18027-2 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 31 | SCR, SKT HD CAP M4 X 12.0 | 1-18023-2 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 30 | SPACER, STRIP GUIDE | 1320908-4 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 29 | STRIP GUIDE ASSEMBLY | 1633073-1 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 28 | SPACER, CRIMPER | 455888-8 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 27 | SPRING, COMPRESSION | 1-22284-0 | 2 | 2 | 2 | 2 | 2 | 2 | - |
| 26 | LEVER, DRAG RELEASE | 356835-1 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 25 | DRAG, TERMINAL | 240792-1 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 24 | PLATE, STRIP GUIDE | 1320928-1 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 23 | SCR, SKT HD SHLDR 5.0 DIA X 6.0 | 980371-4 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 22 | STRIPPER | 690472-2 | 1 | 1 | - | 1 | - | 1 | - |
| 21 | SCR, SKT HD CAP M4 X 10.0 | 1-18023-1 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 20 | WASHER, SPRG LOCK, REG M4 | 18025-2 | 4 | 4 | 4 | 4 | 4 | 4 | - |
| 19 | STRIPPER | 690472-1 | 1 | - | - | 1 | - | - | - |
| 18 △8 | HOLD DOWN, TERMINAL | 690518-2 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 17 △1 | HOLDER, SHEAR, NO-CUT | 1338684-1 | 1 | - | 1 | - | - | - | - |
| 16 | SCR, SKT HD CAP M3 X 6.0 | 18023-2 | 2 | 2 | 2 | 2 | 2 | 2 | - |
| 15 △1 | SHEAR PLATE, REAR | 1-690464-5 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 14 △1 | SHEAR HOLDER, REAR [CUTTING] | 1320920-1 | 1 | - | 1 | 1 | 1 | 1 | - |
| 13 △1 | FLOATING SHEAR, REAR | 690463-2 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 12 | SPRING, COMPRESSION | 3-22280-3 | 2 | 2 | 2 | 2 | 2 | 2 | - |
| 11 | STOP, SHEAR | 356885-4 | 2 | 2 | 2 | 2 | 2 | 2 | - |
| 10 △1 | SHEAR HOLDER, FRONT, CUT | 1320921-1 | 1 | 1 | - | 1 | 1 | - | - |
| 9 △1 | FLOATING SHEAR, FRONT | 462006-1 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 8 △1 | ANVIL, COMBINATION | 3-1333201-5 | 1 | 2 | 2 | 2 | 1 | 1 | - |
| 7 | SPACER | 5-240641-6 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 6 | DEPRESSOR SHEAR, REAR | 690468-1 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 5 | DEPRESSOR, SHEAR | 2-455889-0 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 4 | BLOCK, CRIMPER SPACER | 2-238011-2 | 1 | 1 | 1 | 1 | 1 | 1 | - |
| 3 △1 | CRIMPER, INSULATION F PREMIUM | 4-456134-8 | 1 | 2 | 2 | 2 | 1 | 1 | - |
| 2 | - | - | - | - | - | - | - | - | - |
| 1 △1 | CRIMPER, WIRE PREMIUM | 1-456402-5 | 1 | 2 | 2 | 2 | 1 | 1 | - |
| ITEM NO | DESCRIPTION | PART NO | -1 | -2 | -6 | -71 | -72 | -76 | -77 |

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

DWN 28MAR06 L LOFTHOUSE
CHK -
APVD 28MAR06 M.CLIFFORD
PRODUCT SPEC -
APPLICATION SPEC See Table
WEIGHT -
MATERIAL - -
FINISH - -
DIMENSIONS: mm [IN]
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±- 1 PLC ±- 2 PLC ±- 3 PLC ±- 4 PLC ±- ANGLES ±-

tyco Electronics
Tyco Electronics
Harrisburg, PA 17105-3608

NAME FINE ADJUST SIDE FEED HDI APPLICATOR -

| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|---|---|---|---|
| A1 | 00779 | C-1528639 | - |

CUSTOMER DRAWING SCALE 3:5 SHEET 1 OF 1 REV A1