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

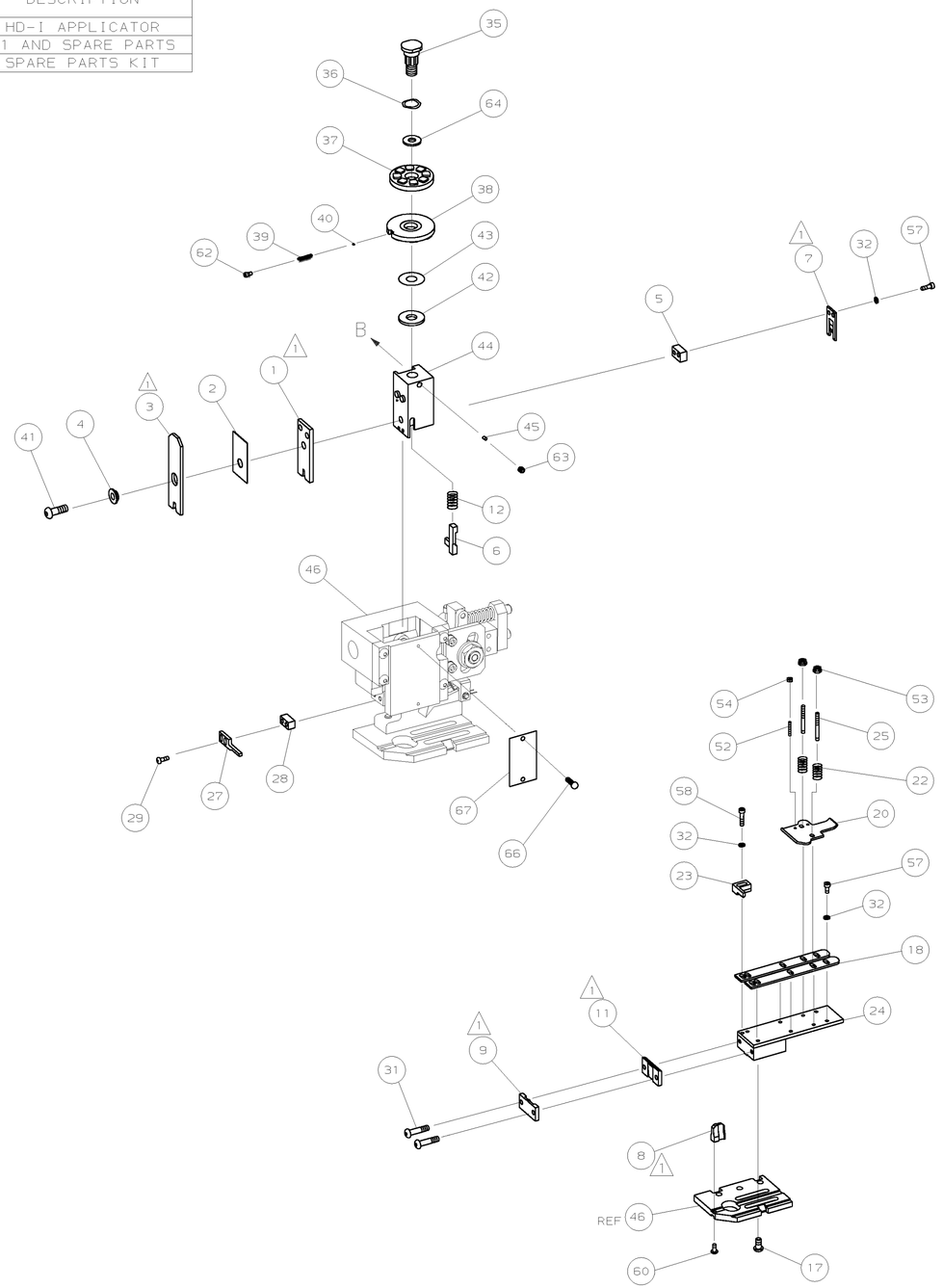
TERMINAL	-	-	FEED
APPL SPEC	NONE	-	14.61 [.575 IN]

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.



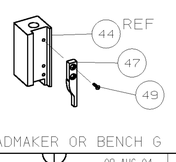
ITEM NO	QTY REQD PER ASSY		PARTS LIST		
					73
-	1	1	1239046	PRINT, APPLICATOR LOG SHEET	72
-	1	1	1338705-2	DOCUMENTATION PACKAGE	71
					70
					69
					68
-	1	1	461264-1	PLATE, IDENTIFICATION	67
-	2	2	21017-2	SCR,DRIVE(#2X.19)ID PLATE	66
					65
-	1	1	986950-1	WASHER, FLAT PRECISION	64
-	1	1	3-18031-0	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)

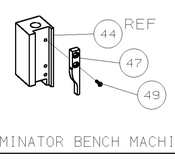
VIEW B ROTATED 180°

POST-FEED 40 mm STROKE



LEADMAKER OR BENCH G

POST-FEED 30 mm STROKE



K TERMINATOR BENCH MACHINE

LOC A
DIST 66

LTR	REVISION RECORD	APP	DATE
A	REVISED	TK	9-00
A1	ECN 0150-1036-04	TE	8-04

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 — AMP Incorporated, Harrisburg, PA 17105-3608

NAME END FEED HD-I APPLICATOR | MACHINE REF HD-I APPL

SCALE - | SIZE D | DWG NO 1239046 | SHEET 1 of 1 | REV A1

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO -

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LAYOUT L2425

SET UP GAGE 458638-3