PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339586-1	B	-	BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1339586-1	B	-	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339586-7	A	-	-	-	SPARE PARTS KIT

CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: .250 SERIES TAB WITH LATCH

CRIMP	SIZE	TYPE	RANGE
WIRE	2.79 [.110 IN]	F	0.85mm² - 2.0mm² (18-14AWG)
INSUL	4.57 [.180 IN]	F	1.9-3.4 [.075-.135 IN] △5

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

APPL INSTRUCTION
408-8323

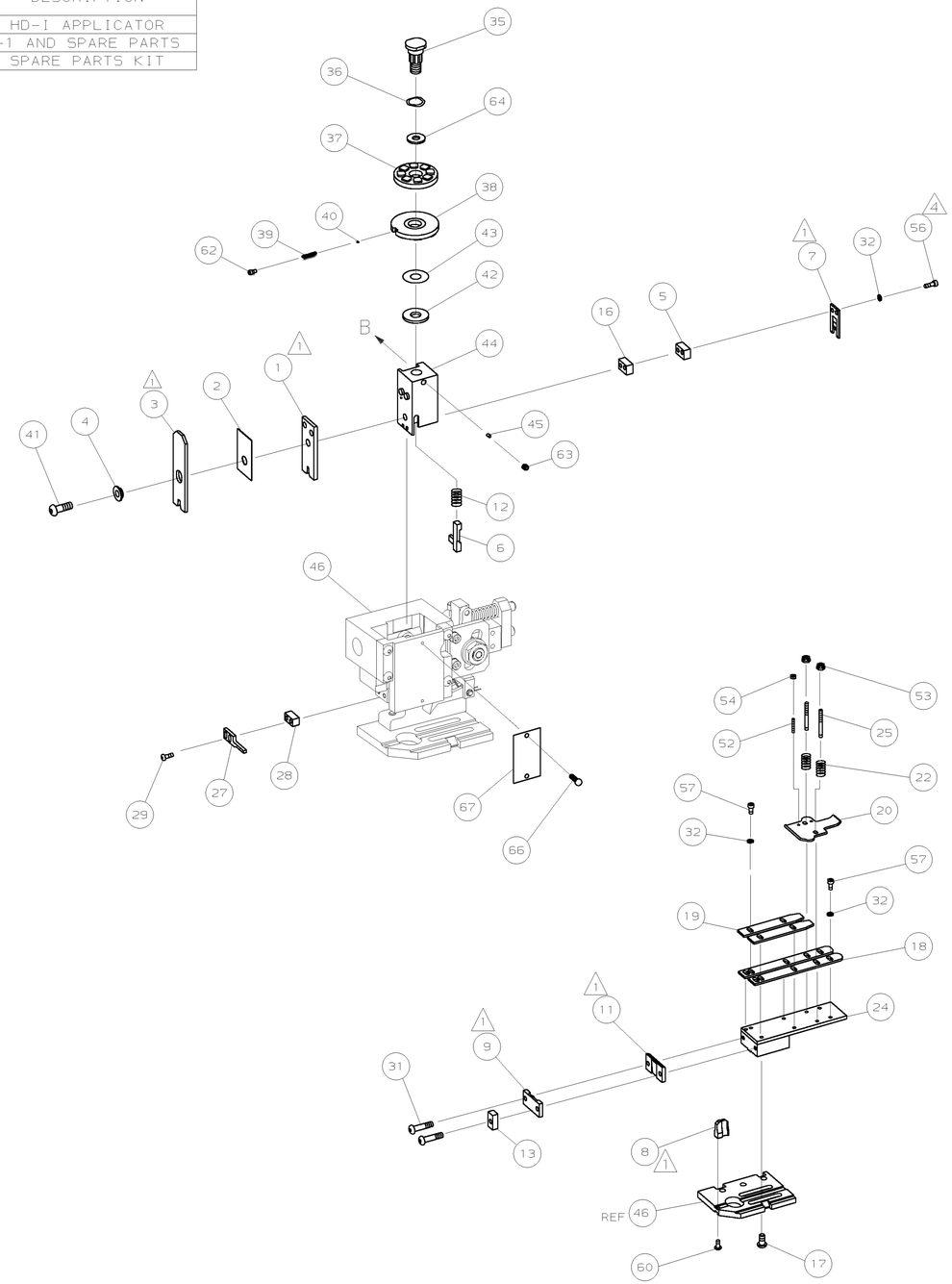
TERMINAL	-	-	FEED
APPL SPEC	114-5052	-	26.50 [1.043 IN]

TERMINALS APPLIED

170030	-	-	-	-
170256	-	-	-	-
170340	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-

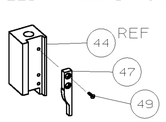
WIRE SIZE mm² AWG	CRIMP HEIGHT	REF SETTING
2.00mm² (14 AWG)	1.68 ±0.05 [.066 ±.002 IN]	6-354778-4 [.2815]
1.50mm²	1.63 ±0.05 [.064 ±.002 IN]	6-354778-5 [.2820]
1.25mm² (16 AWG)	1.55 ±0.05 [.061 ±.002 IN]	7-354778-4 [.2865]
0.85mm² (18 AWG)	1.42 ±0.05 [.056 ±.002 IN]	8-354778-5 [.2920]
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

△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 ASSEMBLY.
△5 THE INSULATION CRIMP REQUIRED BY THE CUSTOMER AND APPLICABLE INSULATION RANGE MAY NOT CONFORM TO THE PARAMETERS LISTED IN THE APPLICATION SPEC.



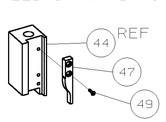
VIEW B ROTATED 180°

POST-FEED 40 mm STROKE



LEADMAKER OR BENCH G

POST-FEED 30 mm STROKE



K TERMINATOR BENCH MACHINE

LOC A
DIST 66

					73
-	1	1	1339586	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
-	2	2	1-18023-4	SCR,SHC(M4X20)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	690124-4	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	4-18024-7	SCR,BHC(M4X25)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	1338663-3	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	1-690481-0	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	690482-4	PLATE, FRONT SHEAR	9
△1 1	2	1	1-1333219-1	ANVIL	8
△1 -	1	1	690474-4	BLADE, SLUG	7
-	1	1	1-455892-5	HOLD DOWN, TERMINAL	6
-	1	1	5-240641-7	SPACER, SLUG BLADE	5
-	1	1	238009-1	SPACER, BLOCK CRIMPER	4
△1 1	2	1	456134-6	CRIMPER, INSULATION	3
-	1	1	455888-5	SPACER, CRIMPER	2
△1 1	2	1	456408-6	CRIMPER, WIRE	1
	-77	-71	-1	PART NO / DESCRIPTION	ITEM NO

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

QTY REQD PER ASSY — PARTS LIST

P	F	LTR	REVISION RECORD	APP	DATE
		B	SEE ECN 015A-0022-05	MC	JAN05
		A	SEE ECN 015A-0808-01	MC	SEP01

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 03SEP01 M.CLIFFORD	APP 03SEP01 F.BACKHURST	AMP Incorporated Harrisburg, PA 17105-3608	
CHK - -	REL 28-09-01 M.CLIFFORD		
NAME END FEED HD-I APPLICATOR		MACHINE REF HD-I APPL	
SCALE -	D DWG NO 1339586	SHEET 1 OF 1	REV B
CAGE CODE 00779	CUSTOMER AND ASSEMBLY DRAWING	RESTRICTED TO —	

THIS DRAWING IS A CONTROLLED DOCUMENT.
LAYOUT L1529003
SET UP GAGE 458638-3
THIS DRAWING IS UNPUBLISHED. © COPYRIGHT 2000 BY AMP INCORPORATED. ALL RIGHTS RESERVED. RELEASED FOR PUBLICATION .2000 .