

| PART NUMBER | REV | TERMINATOR | FEED TYPE | DESCRIPTION |
|-------------|-----|-------------------|----------------|--------------------|
| 1531063-1 | B | BENCH & LEADMAKER | MECH POST FEED | HDI APPLICATOR |
| 7-1531063-1 | B | BENCH & LEADMAKER | MECH POST FEED | -1 AND SPARE PARTS |
| 7-1531063-7 | B | - | - | SPARE PARTS KIT |

| SET UP GAGE | | LOC | DIST | REVISIONS | | | |
|-------------|--|-----|------|-----------|---------------|-----------|----|
| 458638-3 | | A | 66 | REV | DESCRIPTION | DATE | BY |
| | | | | B | ECR-11-005451 | 23MAR2011 | RK |

CRIMP DATA TE TERMINAL TE CRIMP SPECS

TERMINAL NAME: .250 SERIES FASTON TAB SHORT (AMPLIVAR)

| CRIMP | SIZE | TYPE | RANGE |
|-------|----------------|------|----------------------------|
| WIRE | 2.54 [.100 IN] | F | Ø 0.9-1.6 [Ø .035-.063 IN] |
| INSUL | 4.06 [.160 IN] | OV | 2.2-3.3 [.087-.130 IN] |

WIRE STRIP LENGTH 6.6 [.260 IN] APPL INSTRUCTIONS 408-8323 & 408-8490

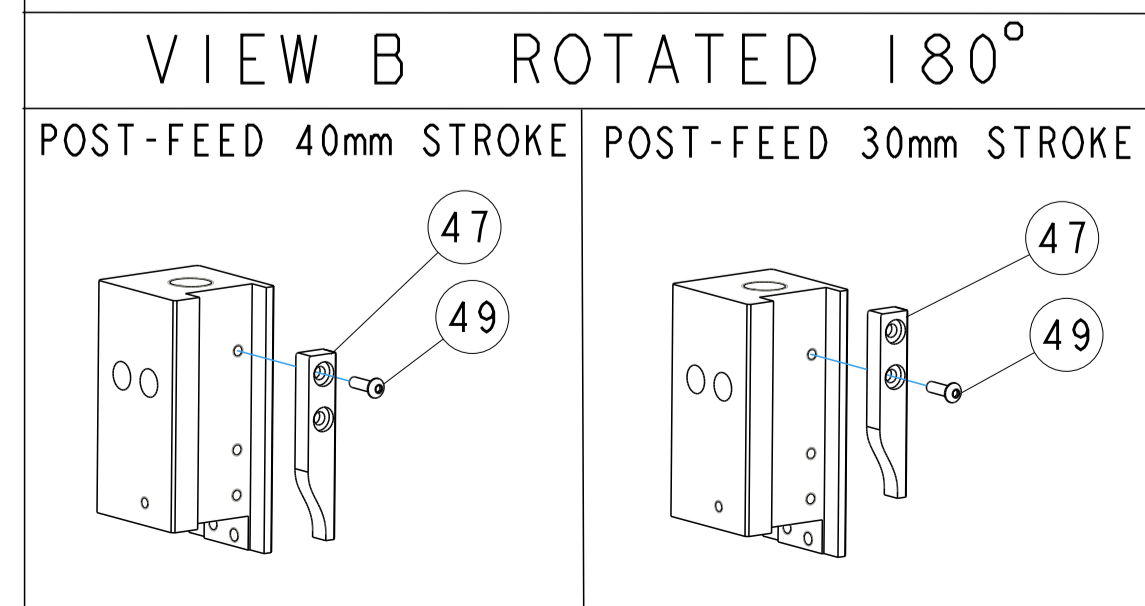
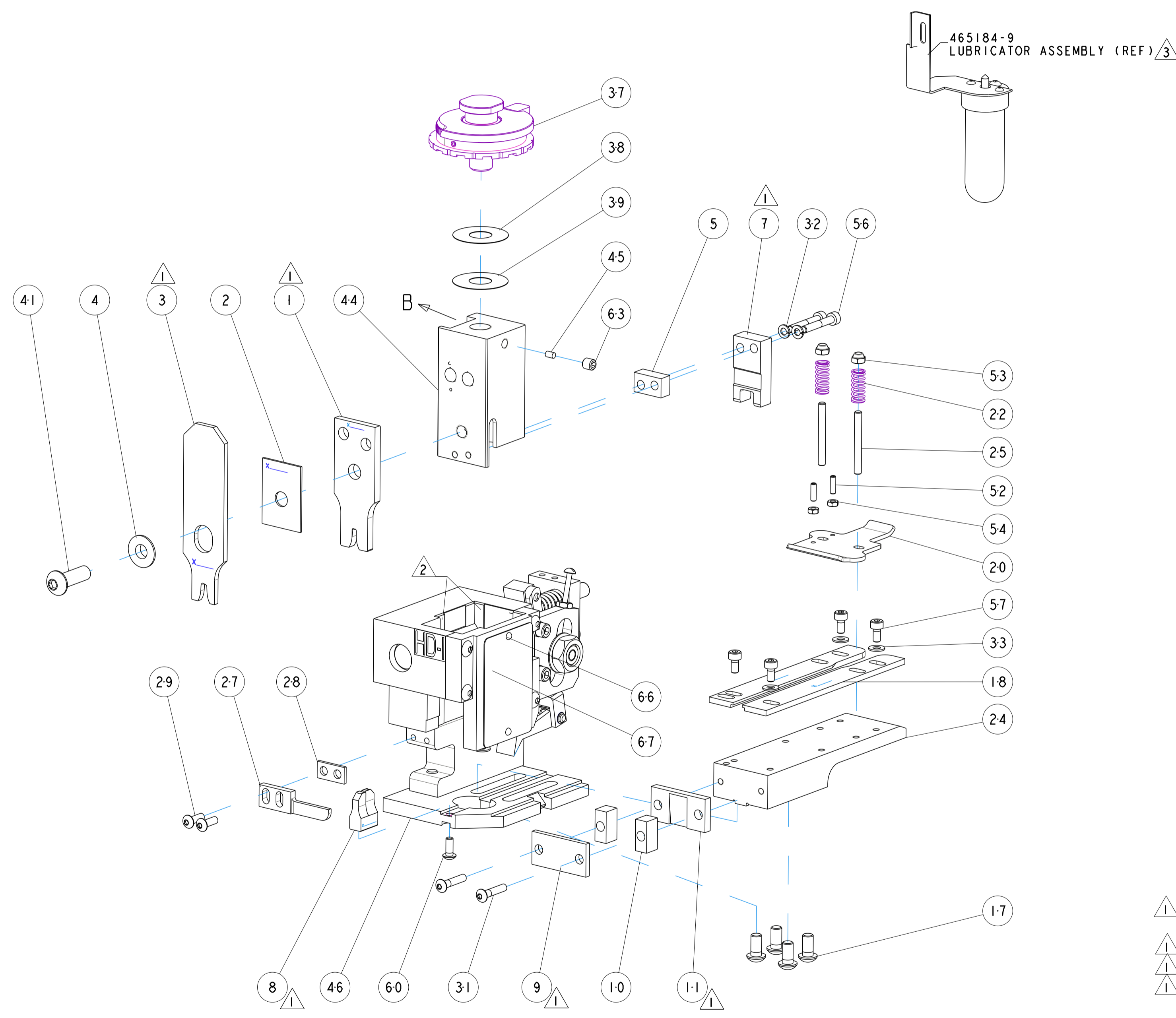
| TERMINAL | NONE | FEED |
|-----------|------|-----------------|
| APPL SPEC | - | 30.30 [.193 IN] |

TERMINALS APPLIED

| 1955414 | - | - | - |
|---------|---|---|---|
| - | - | - | - |
| - | - | - | - |
| - | - | - | - |
| - | - | - | - |

| WIRE SIZE | CRIMP HEIGHT | REF SETTING |
|-----------|------------------------------|-------------|
| 4360 | 1.83 ± 0.05 [.072 ± .002 IN] | B0 |
| 3869 | 1.79 ± 0.05 [.070 ± .002 IN] | B2 |
| 3810 | 1.75 ± 0.05 [.069 ± .002 IN] | B5 |
| 3215 | 1.67 ± 0.05 [.066 ± .002 IN] | C1 |
| 2665 | 1.58 ± 0.05 [.062 ± .002 IN] | D7 |
| 2390 | 1.54 ± 0.05 [.061 ± .002 IN] | C9 |
| 2150 | 1.51 ± 0.05 [.059 ± .002 IN] | D0 |
| 1935 | 1.48 ± 0.05 [.058 ± .002 IN] | D3 |
| 1640 | 1.44 ± 0.05 [.057 ± .002 IN] | D5 |
| 1520 | 1.42 ± 0.05 [.056 ± .002 IN] | D7 |
| 1391 | 1.40 ± 0.05 [.055 ± .002 IN] | E0 |

- 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.



*** 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.

| | | | | | |
|---|---|---|------------|-----------------------------------|----|
| - | 1 | 1 | 1338705-4 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 461264-5 | PLATE, IDENTIFICATION | 67 |
| - | 2 | 2 | 21017-2 | SCREW, DRIVE | 66 |
| - | 1 | 1 | 3-18031-0 | SCR, SET, CUP POINT M6 X 6.0 | 63 |
| - | 1 | 1 | 18024-7 | SCR, BTN SKT HD CAP (M4 X 10.0) | 60 |
| - | 4 | 4 | 1-18023-0 | SCR, SKT HD CAP M4 X 8.0 | 57 |
| - | 2 | 2 | 1-18023-5 | SCR, SKT HD CAP M4 X 25.0 | 56 |
| - | 2 | 2 | 18029-1 | NUT, HEX, REG M3 | 54 |
| - | 2 | 2 | 986965-1 | NUT, LOCK, HEX, TORQUE (M4) | 53 |
| - | 2 | 2 | 2-18032-2 | SCR, SET, FLT POINT M3 X 10.0 | 52 |
| - | 1 | 1 | 18024-3 | SCR, BTN SKT HD CAP (M3 X 10.0) | 49 |
| - | 1 | 1 | 1338676-1 | CAM, UNIVERSAL POST-FEED | 47 |
| - | 1 | 1 | 1338662-1 | SUB ASSY, APPLICATOR FRAME | 46 |
| - | 1 | 1 | 690191-1 | PLUG, NYLON | 45 |
| - | 1 | 1 | 1320998-1 | RAM | 44 |
| - | 1 | 1 | 2-18024-6 | SCR, BTN SKT HD CAP (M8 X 25.0) | 41 |
| - | 1 | 1 | 690125-1 | SHIM SUB-ASSY | 39 |
| - | 1 | 1 | 469367-1 | SHIM | 38 |
| - | 1 | 1 | 879103-2 | FINE ADJUST HEAD ASSEMBLY | 37 |
| - | 4 | 4 | 18027-2 | WASHER, FLAT, REG M4 | 33 |
| - | 2 | 2 | 18025-2 | WASHER, SPRG LOCK, REG M4 | 32 |
| - | 2 | 2 | 1-18024-0 | SCR, BTN SKT HD CAP (M4 X 20.0) | 31 |
| - | 2 | 2 | 18024-8 | SCR, BTN SKT HD CAP (M4 X 12.0) | 29 |
| - | 1 | 1 | 3-690451-2 | SPACER, STRIPPER | 28 |
| - | 1 | 1 | 240639-1 | STRIPPER (MACHINING) | 27 |
| - | 2 | 2 | 1320906-1 | STUD, THREADED | 25 |
| - | 1 | 1 | 1320995-1 | PLATE, STRIP GUIDE | 24 |
| - | 2 | 2 | 4-22281-1 | SPRING, DRAG | 22 |
| - | 1 | 1 | 1338665-1 | DRAG | 20 |
| - | 1 | 1 | 458030-4 | STRIP GUIDE, REAR | 18 |
| - | 1 | 1 | 458031-4 | STRIP GUIDE, FRONT | 18 |
| - | 4 | 4 | 1-18024-8 | SCR, BTN SKT HD CAP (M6 X 12.0) | 17 |
| - | 1 | 1 | 240644-1 | PLATE, REAR SHEAR | 11 |
| - | 2 | 2 | 6-240645-9 | SPACER, SHEAR PLATE | 10 |
| - | 1 | 1 | 240642-1 | PLATE, FRONT SHEAR | 9 |
| - | 1 | 2 | 1333218-1 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 8-240651-4 | BLADE, SLUG | 7 |
| - | - | - | - | - | 6 |
| - | 1 | 1 | 2-240641-7 | SPACER | 5 |
| - | 1 | 1 | 238009-1 | BLOCK, FL CRIMPER SPACER | 4 |
| - | 1 | 2 | 2-655621-5 | OVERLAPPING CRIMPER, INSUL HD TYP | 3 |
| - | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 2 |
| - | 1 | 2 | 456407-7 | CRIMPER, WIRE PREMIUM | 1 |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | MATERIAL: | |
|-------------|--------|--|--|-----------|--|
| MM [INCHES] | 0 PLC | ± | | WEIGHT | |
| | 1 PLC | ±0.1 | | | |
| | 2 PLC | ±0.01 | | | |
| | 3 PLC | ±0.001 | | | |
| | 4 PLC | ±0.0001 | | | |
| | ANGLES | ± | | | |
| | FINISH | | | | |

| REV | DESCRIPTION | DATE | BY |
|-----------|-------------|-----------|----|
| 02NOV2009 | L. ZHANG | 02NOV2009 | |
| 02NOV2009 | S. ZOU | 02NOV2009 | |
| 02NOV2009 | N. DEMING | 02NOV2009 | |

| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|------|-----------|------------|---------------|
| A1 | 00779 | C=1531063 | |

CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 3:5 SHEET 1 OF 1 REV B