

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339772-1	A		-	BENCH & LEADMAKER	MECH POST FEED HD-I APPLICATOR
7-1339772-1	A		-	BENCH & LEADMAKER	MECH POST FEED -1 AND SPARE PARTS
7-1339772-7	A		-		SPARE PARTS KIT

CRIMP DATA AMP TERMINAL AMP CRIMP SPECS			
TERMINAL NAME: TAB WITH LANCE MULTI-INTERLOCK CONN			
CRIMP	SIZE	TYPE	RANGE
WIRE	2.29 [.090 IN]	F	20-14 AWG or 0.50-2.27mm ² $\triangle 5$
INSUL	3.56 [.140 IN]	F	2.16-3.43 [.085-.135 IN]
WIRE STRIP LENGTH		APPL INSTRUCTION	
3.50-4.50 [.138-.177 IN]		408-8323 $\triangle 6$	
TERMINAL APPL SPEC	114-5018 $\triangle 6$	FEED	26.66 [.1050 IN]

TERMINALS APPLIED				
170221	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-

WIRE SIZE	CRIMP HEIGHT	PIN PN AND LENGTH [IN]
mm ² AWG		
2.00mm ²	1.78 ±0.05 [.070 ±.002 IN]	8-354778-1 [.2900]
1.25mm ²	1.50 ±0.05 [.059 ±.002 IN]	354779-4 [.3010]
0.85mm ²	1.34 ±0.05 [.053 ±.002 IN]	1-354779-7 [.3075]
0.50mm ²	1.30 ±0.05 [.051 ±.002 IN]	2-354779-1 [.3095]
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

LAYOUT	L1339772
SET UP GAGE	458638-3

$\triangle 1$ RECOMMENDED SPARE PARTS.

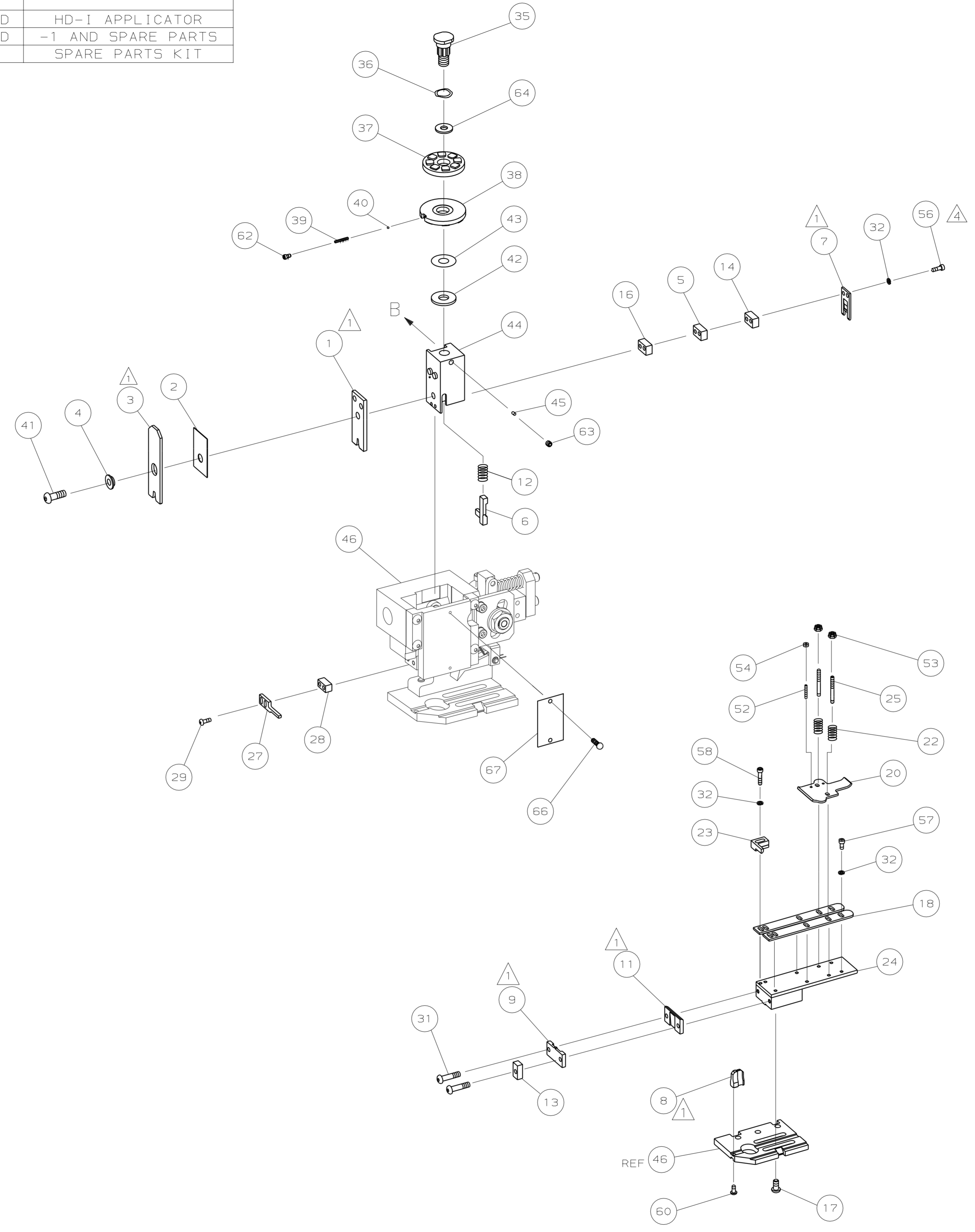
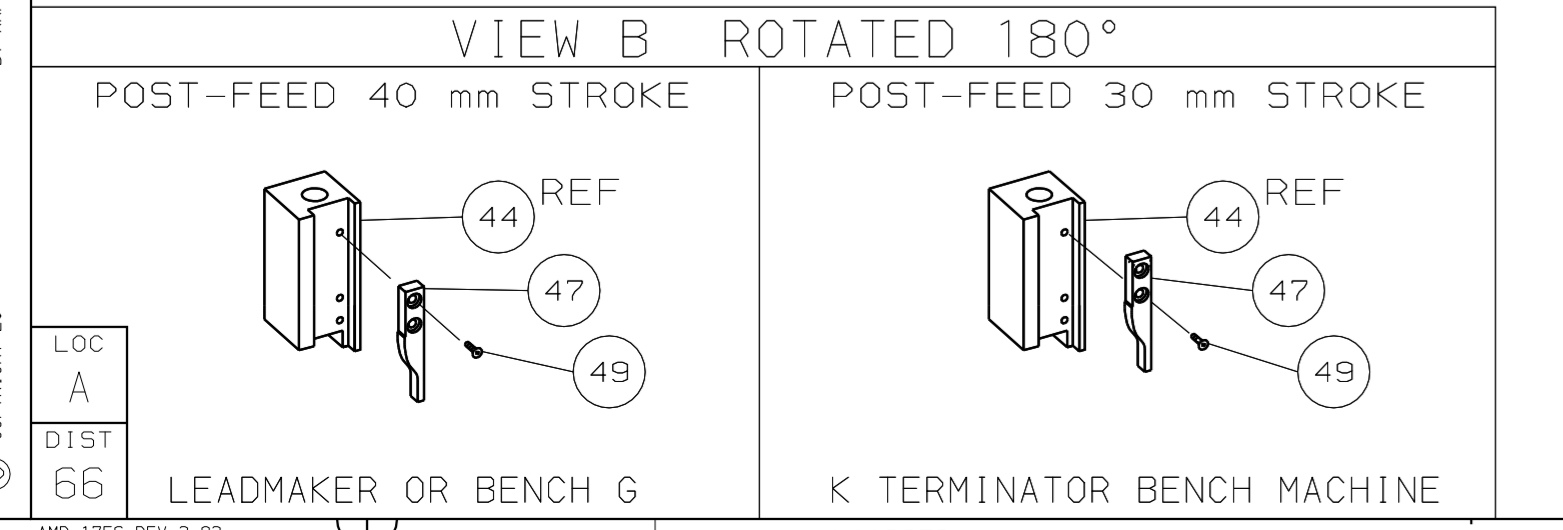
$\triangle 2$ GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.

$\triangle 3$ LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

$\triangle 4$ CUT TO LENGTH AT ASSY.

$\triangle 5$ RANGE QUOTED IS THAT OF THE TERMINAL, NOT THE APPLICATOR.

$\triangle 6$ SEE APPLICATION SPECIFICATION FOR SPECIFIC WIRE DETAILS.



QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
-	1	1		1339772	PRINT, APPLICATOR LOG SHEET	73
-	1	1		1338705-2	DOCUMENTATION PACKAGE	72
-						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 (M4X16) HOLD DOWN	58
-	5	5		1-18023-0	SCR,SHC (M4X8) STRIP GUIDE	57
-	2	2		1-18023-5	SCR,SHC (M4X25) 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
-	9	9		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	PLATE, 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		1338663-6	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
-	1	1		2-240641-0	SPACER, SLUG BLADE	14
-	1	1		1-690481-0	SPACER, HOLD DOWN	13
-	1	1		23846-1	SPRING, HOLD DOWN	12
-	1	1		240644-1	PLATE, REAR SHEAR	11
-						10
-	1	1		690482-5	PLATE, FRONT SHEAR	9
-	1	2	1	4-1333217-3	ANVIL	8
-	1	1		690474-5	BLADE, SLUG	7
-	1	1		5-455892-0	HOLD DOWN, TERMINAL	6
-	1	1		6-240641-8	SPACER, SLUG BLADE	5
-	1	1		238009-1	SPACER, BLOCK CRIMPER	4
-	1	2	1	1-456134-4	CRIMPER, INSULATION	3
-	1	1		455888-6	SPACER, CRIMPER	2
-	1	2	1	4-456406-7	CRIMPER, WIRE	1
-	-77	-71	-1			

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

DIMENSIONS: mm [INCHES]	MATL	HT TR	FIN
DO NOT SCALE PRINT.			
TOLERANCES UNLESS OTHERWISE SPECIFIED:			
1 PLC DEC ±			
2 PLC DEC ±			
3 PLC DEC ±			
ANGLES ±			
SURF TEXTURE: \checkmark			
REMOVE BURRS, BREAK SHARP EDGES RO.38 MAX			

DR M. CLIFFORD 28 JUN 05 APP F. BACKHURST 28 JUN 05

CHK - REL 26 JUL 05 L. LOFTHOUSE

AMP Tyco Electronics Harrisburg, PA 17105-3608

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

SCALE DWG NO 1339772 SHEET 1 OF 1 REV A

00779 CUSTOMER AND ASSEMBLY DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT.

RELEASABLE FOR PUBLICATION BY AMP INCORPORATED. ALL RIGHTS RESERVED.

THIS DRAWING IS UNRELEASABLE. COPYRIGHT © 2012 AMP INCORPORATED.

1339772