| PART NUMBER | REV | FIRST USED | TERMINATOR | FEED TYPE | DESCRIPTION |
|---|---|---|---|---|---|
| 1528438-1 | D | – | LEADMAKER | MECH POST FEED | CUTS CARRIER |
| 1528438-2 | D | – | BENCH | MECH PRE FEED | CUTS CARRIER |
| 1528438-6 | D | – | LEADMAKER | MECH POST FEED | CONTINUOUS CARRIER |
| 7-1528438-1 | D | – | LEADMAKER | MECH POST FEED | -1 AND SPARE PARTS |
| 7-1528438-2 | D | – | BENCH | MECH PRE FEED | -2 AND SPARE PARTS |
| 7-1528438-6 | D | – | LEADMAKER | MECH POST FEED | -6 AND SPARE PARTS |
| 7-1528438-7 | A | – | – | – | SPARE PARTS KIT |

## CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: 025 RECEPTACLE CONTACT

| CRIMP | SIZE | TYPE | RANGE |
|---|---|---|---|
| WIRE | 1.40 [.055 IN] | F | 0.22 - 0.50mm² |
| INSUL | 1.40 [.055 IN] | F | 0.95-1.70 [.037-.067 IN] |

WIRE STRIP LENGTH 3.00-3.50 [.118-.138 IN]

APPL INSTRUCTION 408-8322 & 408-8490

TERMINAL 114-5250-2 – FEED

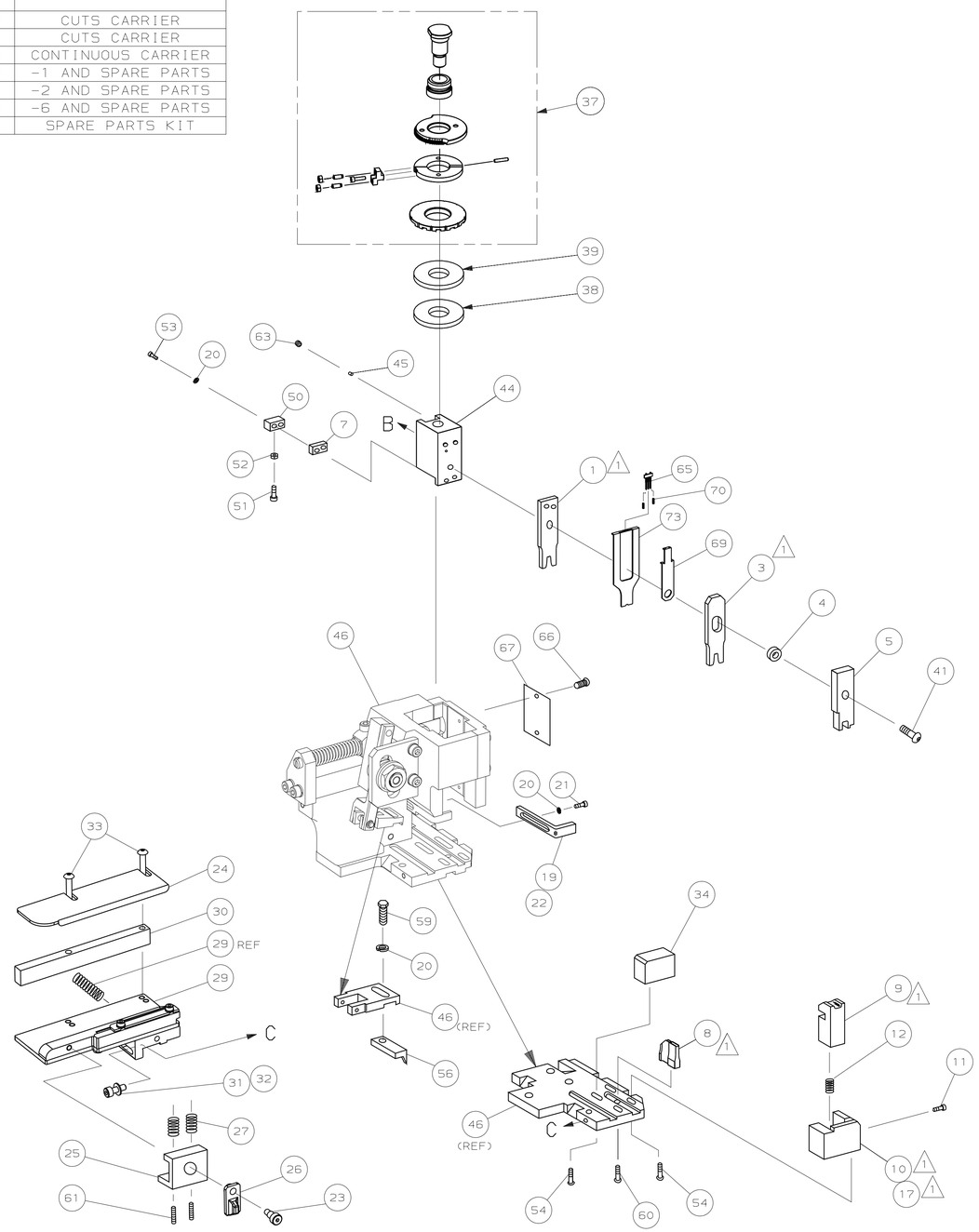
APPL SPEC – 7.50 [.295 IN]

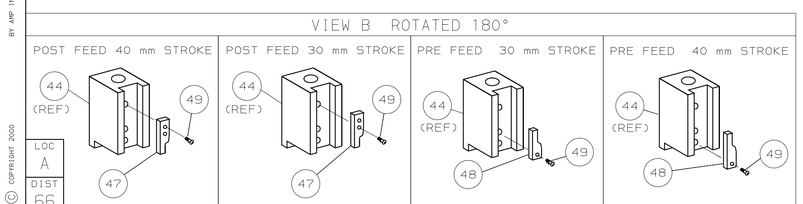
### TERMINALS APPLIED

| | | | | |
|---|---|---|---|---|
| 1123343 | – | – | – | – |
| 1674298 | – | – | – | – |
| – | – | – | – | – |
| – | – | – | – | – |
| – | – | – | – | – |
| – | – | – | – | – |
| – | – | – | – | – |
| – | – | – | – | – |

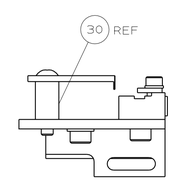
| WIRE SIZE mm² AWG | CRIMP HEIGHT ✳ | SETTING ✳ |
|---|---|---|
| 0.50mm² | 1.01 ±0.05 [.040 ±.002 IN] | C8 |
| 0.30mm² | 0.96 ±0.05 [.038 ±.002 IN] | D1 |
| 0.22mm² | 0.84 ±0.05 [.033 ±.002 IN] | D9 |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |

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.




✳ WARNING:
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN REQ'D CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.




ITEM 30
SHORT POSITION

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1490525-3 | DEPRESSOR, WIRE | 73 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1528438 | PRINT, APPLICATOR LOG SHEET | 72 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1338705-3 | DOCUMENTATION PACKAGE | 71 |
| – | 2 | 2 | 2 | 2 | 2 | 2 | 23147-7 | SPRING, DEPRESSOR | 70 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1490524-1 | SPACER, DEPRESSOR | 69 |
| | | | | | | | | | 68 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 461264-5 | PLATE, IDENTIFICATION | 67 |
| – | 2 | 2 | 2 | 2 | 2 | 2 | 21017-2 | SCR,DRIVE(#2x.19)ID PLATE | 66 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1424350-1 | HOLDER, PIN, WIRED | 65 |
| | | | | | | | | | 64 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 3-18031-0 | SCR,SKT SET(M6X6)RAM | 63 |
| | | | | | | | | | 62 |
| – | 2 | 2 | 2 | 2 | 2 | 2 | 2-18032-5 | SCR,SET(M5X20)DRAG | 61 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 18024-7 | SCR,BHC(M4X10)ANVIL | 60 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 5-18022-2 | SCR,HEX(M4X8)FEED FINGER | 59 |
| | | | | | | | | | 58 |
| | | | | | | | | | 57 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| | | | | | | | | | 55 |
| – | 4 | 4 | 4 | 4 | 4 | 4 | 18024-8 | SCR,BHC(M4x12)SHEAR HOLDER | 54 |
| – | 2 | 2 | 2 | 2 | 2 | 2 | 9-18023-6 | SCR,SHC(M4x14)TERM HLD DWN | 53 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 18030-1 | NUT,HEX(M3)HOLD DOWN | 52 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 811242-5 | BUMPER, HOLDDOWN | 51 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 690753-2 | SPACER, TONKER | 50 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 18024-3 | SCR,BHC(M3X10)CAM | 49 |
| – | – | 1 | – | – | 1 | – | 1338675-1 | CAM, PRE FEED 30 & 40 mm ST | 48 |
| – | 1 | – | 1 | 1 | – | 1 | 1338676-1 | CAM, POST FEED 30 & 40 mm ST | 47 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1320999-3 | APPLICATOR BASIC SUBASSY | 46 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 690191-1 | PLUG, NYLON | 45 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1338660-3 | RAM | 44 |
| | | | | | | | | | 43 |
| | | | | | | | | | 42 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 2-18024-6 | SCR,BHC(M8X25)RAM | 41 |
| | | | | | | | | | 40 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 690125-1 | SHIM, LAMINATED | 39 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 469367-8 | SPACER, FINE ADJUST | 38 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 879103-3 | FINE ADJUST HEAD SUBASSY | 37 |
| | | | | | | | | | 36 |
| | | | | | | | | | 35 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1320934-6 | SUPPORT, TERMINAL | 34 |
| – | 2 | 2 | 2 | 2 | 2 | 2 | 1-18024-0 | SCR,BHC(M4X20)STRIP GUIDE | 33 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 18027-2 | WASHER, FLAT(M4) | 32 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1-18023-2 | SCR,SKT CAP(M4X12)MOUNT BLOCK | 31 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1320908-4 | SPACER, STRIP GUIDE | 30 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1633073-1 | STRIP GUIDE PLATE ASSY | 29 |
| | | | | | | | | | 28 |
| – | 2 | 2 | 2 | 2 | 2 | 2 | 1-22284-0 | SPRING, DRAG | 27 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 356835-1 | LEVER, DRAG RELEASE | 26 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 240792-1 | DRAG, TERMINAL | 25 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1320928-1 | PLATE, STRIP GUIDE | 24 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 980371-4 | SCR,SHC SHLD | 23 |
| – | 1 | – | 1 | 1 | – | 1 | 690472-2 | STRIPPER | 22 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1-18023-1 | SCR,SHC(M4X10)STRIPPER | 21 |
| – | 4 | 4 | 4 | 4 | 4 | 4 | 18025-2 | WASHER,LOCK(M4)STRIPPER | 20 |
| – | – | 1 | – | – | 1 | – | 690472-1 | STRIPPER | 19 |
| | | | | | | | | | 18 |
| – | 1 | – | – | 1 | – | – | 1338684-1 | HOLDER, SHEAR, FRONT (NO-CUT) | 17 |
| | | | | | | | | | 16 |
| | | | | | | | | | 15 |
| | | | | | | | | | 14 |
| | | | | | | | | | 13 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 5-22280-0 | SPRING, SHEAR | 12 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 356885-4 | STOP, SHEAR | 11 |
| – | – | 1 | 1 | – | 1 | 1 | 1320921-1 | HOLDER, SHEAR, FRONT (CUT) | 10 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1-462006-0 | SHEAR, FLOAT (FRONT) | 9 |
| 1 | 2 | 2 | 2 | 1 | 1 | 1 | 1-1333201-2 | ANVIL | 8 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 240641-2 | SPACER, DEPRESSOR (REAR) | 7 |
| | | | | | | | | | 6 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 2-455889-0 | DEPRESSOR, SHEAR (FRONT) | 5 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 238011-7 | SPACER, BLOCK CRIMPER | 4 |
| 1 | 2 | 2 | 2 | 1 | 1 | 1 | 1366753-1 | CRIMPER, INSULATION | 3 |
| | | | | | | | | | 2 |
| 1 | 2 | 2 | 2 | 1 | 1 | 1 | 1-456402-7 | CRIMPER, WIRE | 1 |
| -77 | -76 | -72 | -71 | -6 | -2 | -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 |
|---|---|---|---|---|---|
| | | D | ECR-06-006386 | CE | FEB06 |
| | | C | ECR-06-004277 | CE | FEB06 |

DIMENSIONS: mm [INCHES]
DO NOT SCALE PRINT.
TOLERANCES UNLESS OTHERWISE SPECIFIED:
1 PLC DEC ±0.5 [.02 IN]
2 PLC DEC ±-
3 PLC DEC ±-
ANGLES ±-
SURF TEXTURE: √
REMOVE BURRS, BREAK SHARP EDGES R0.38 MAX

MATL – – HT TR – – FIN – –

DR 23JAN06 M.CLIFFORD APP 23JAN06 M.CLIFFORD
CHK – – REL 23-01-06 M.CLIFFORD

AMP Incorporated Harrisburg, PA 17105-3608

NAME FINE ADJ SIDE FD HD-I APPL
MACHINE REF HD-I APPL
SCALE – D DWG NO 1528438 SHEET 1 OF 1 REV D

CAGE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO –

LAYOUT L1426125
SET UP GAGE 458637-3

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