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THIS DRAWING IS UNPUBLISHED. PELEASED FOR PUBLICATION		LOC DIST REVISIONS A 66 P LTR DESCRIPTION DATE DATI
PART REV FIRST TERMINATOR FEED TYPE DESCRIPTION		L ECR-11-019491 225EP2011 LZ
1528101–1 L – LEADMAKER MECH POST FEED CUTS CARRIER		- 1 1 1 1 1 1 993111-8 PIN. SLOTTED SPRING 3.0X12.0 1
1528101-2 L – BENCH MECH PRE FEED CUTS CARRIER 1528101-6 L – LEADMAKER MECH POST FEED CONTINUOUS CARR		- 2 2 2 2 2 2 2 3-22280-7 SPRING, COMPRESSION 1
7-1528101-1 L LEADMAKER MECH POST FEED -1 AND SPARE PA 7-1528101-2 L - BENCH MECH PRE FEED -2 AND SPARE PA		- 1 1 1 1 1 1 1 1901680-1 GUIDE PIN, HOLD DOWN 1
7-1528101-6 L - LEADMAKER MECH POST FEED -6 AND SPARE PARTS K 7-1528101-7 J - - - SPARE PARTS K		- 1 1 1 1 1528101 PRINT, APPLICATOR LOG SHEET 7 - 1 1 1 1 1338705-3 DOCUMENTATION PACKAGE 7
	(37)	- 1 1 1 1 461264-5 PLATE, IDENTIFICATION 6 - 2 2 2 2 2 2 2 2 1017-2 SCR, DRIVE(#2x.19)ID PLATE 6
D		- 2 2 2 2 21017-2 SCR,DRIVE(#2x.19)ID PLATE 6 - - - - - - 6
	- 15.71 [.618]	- 1 1 1 1 1 1 3-18031-0 SCR.SKT SET(M6X6 LW)RAM 6
CRIMP DATA (AMP TERMINAL)		2 2
TERMINAL NAME, JONIOR POWER HIMER CONTACT A 4		- 1 1 1 1 18024-7 SCR,BHC(M4X10)ANVIL 6 - 1 1 1 1 5-18022-2 SCR,HEX(M4X8)FEED FINGER 5
WIRE 2.03 [.080 IN] F 0.50mm ² - 1.00mm ²		
INSUL 4.06 [.160 IN] 0 1.40-2.70 [.055106 IN] WIRE STRIP LENGTH → ← APPL INSTRUCTION ▲		- 1 1 1 1 985575-3 SCR,FHC(M3X10)DEP 5 - 1 1 1 1 1338685-1 PAWL, FEED 5
4.20-4.80 [.165189 IN] 408-8322 & 408-8490 HOLDDOWN SET-UP		- 4 4 4 4 18024-8 SCR,BHC(M4X12)SHEAR HOLDER 5
TERMINAL 114–18051 (B) 114–18387 (C) FEED APPL SPEC 114–18050 (A) – 14.00 [.551 IN]		REF - 1 1 1 1 1 1 1-18030-0 NUT, HEX, REG M3.5 5
	(44) 0.70mm [.028 IN]	- 1 1 1 1 1901681-1 HOLD DOWN, TERMINAL 5 - 1 1 1 1 2-1752354-7 STANDOFF, HOLD-DOWN 5
TERMINALS APPLIED		- 1 1 1 1 18024-3 SCR,BHC(M3X10)CAM 4 - - 1 - 1 - 1338675-1 CAM, PRE FEED 30 & 40 mm ST 4
TERMINAL SEAL - - - 964286 (A) 963294-1 - - - -		
964286 (A) 963294-1 964300 (B) 963293-1		- 1 1 1 1 1 1 690191-1 PLUG, NYLON 4
1241394 (C) - - - C - - - -		- 1 1 1 1 1 1 1 1633724-1 RAM 4
		Image: Second
		- 1 1 1 1 1 690125-1 SHIM SUBASSY 3 - 1 1 1 1 469367-9 SPACER, FINE ADJUST 3
WIRE SIZE mm ² awg		- 1 1 1 1 469367-9 SPACER, FINE ADJUST 3 - 1 1 1 1 879103-2 FINE ADJUST HEAD SUBASSY 3
1.00mm² 1.20 ±0.05 [.047 ±.002 IN] B 3 0.75mm² 1.18 ±0.05 [.046 ±.002 IN] C 1		(41) <u>- 1 1 1 1 1 1 1 1 -1752356-6 SUPPORT, TERMINAL 3</u>
0.50mm ² 1.15 ±0.05 [.045 ±.002 IN] C 8		- 2 2 2 2 2 1-18024-0 SCR,BHC(M4X20)STRIP_GUIDE 3 - 1 1 1 1 1 18027-2 WASHER, FLAT(M4) 3
		- 1 1 1 1 1 1 1 1 1-18023-2 SCR.SKT CAP(M4X12)MOUNT BLOCK 3 - 1 1 1 1 1 1 1 1 1320908-8 SPACER, STRIP GUIDE 3
		→ 1 1 1 1 1 1 1 1633073-2 STRIP GUIDE PLATE ASSY 2 → 1 1 1 1 1 1 1 −455888-6 SPACER, FRONT SHEAR DEP 2
		- 2 2 2 2 2 1-22284-0 SPRING, DRAG 2 - 1 1 1 1 356835-1 LEVER, DRAG RELEASE 2
		- 1 1 1 1 1 1 1 240792-1 DRAG, TERMINAL 2
		- 1 1 1 1 1320928-1 GUIDE, STRIP (REAR) 2 - 1 1 1 1 1 280371-4 SCR,SHC SHLD 2
		- 1 - 1 690472-2 STRIPPER 2 - 1 1 1 1 1-18023-1 SCR,SHC(M4X10)STRIPPER 2
		− 2 2 2 2 2 18025−2 WASHER,LOCK(M4)STRIPPER 2 − − 1 − 1 − 690472−1 STRIPPER 1
		1 1 - 1 1 1338684-2 HOLDER, SHEAR, FRONT (NO-CUT) 1
SET UP GAGE LAYOUT 458637-3 L1426005		
RECOMMENDED SPARE PARTS.	(11)	
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.		- 1 1 1 1 1 1 3-22280-3 SPRING, SHEAR 1
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION		- 1 1 1 1 356885-5 STOP, SHEAR 1 ∧ - - 1 1 1 - 1 1 - 1 1 - 1 1 - 1 1 1 - 1 1 1 1 1
SHEET SUPPLIED WITH THE APPLICATOR.		I I I I I I III IIII IIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIII
5 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT		
QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.		- 1 1 1 1 1338680-1 DEPRESSOR, SHEAR (FRONT) - 1 1 1 1 3-238011-3 SPACER, BLOCK CRIMPER
FEED MAY REQUIRE ADJUSTMENT WHEN CHANGING FROM ONE		1 1 2 2 2 1 1 1 1583690-9 CRIMPER, INSULATION
		1 1 2 2 2 1 1 1 1 1-456405-7 CRIMPER, WIRE
VIEW B ROTATED 180°		-77 -76 -72 -71 -6 -2 -1 PART NO DESCRIPTION
A POST FEED 40 mm STROKE POST FEED 30 mm STROKE PRE FEED 30 mm STROKE PRE FEED 40 mm STROKE		OTY REQD PER ASSY THIS DRAWING IS A CONTROLLED DOCUMENT: M.CLIFFORD 224PR02 TF TE CONNECTINTY
$\begin{pmatrix} 44\\ (REF) \end{pmatrix} \begin{pmatrix} 49\\ (REF) \end{pmatrix} \begin{pmatrix} 49\\ REF \end{pmatrix} \begin{pmatrix} 49\\ REF \end{pmatrix} \begin{pmatrix} 49\\ REF \end{pmatrix} \begin{pmatrix} 44\\ REF \end{pmatrix} \begin{pmatrix} 44\\ REF \end{pmatrix} \end{pmatrix} \begin{pmatrix} 44\\ REF $	WARNING:	DIMENSIONS: TOLETANCES LINESS TOLETANCES LINESS INCLESS TOLETANCES SPECIFICS: APO E.BACKHURST TE CONNECTIVITY
	ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE	
	HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.	
		CUSTOMER DRAWING
AMP 4805 REV 31MAR2000		

DRAWING NUMBER - 1528101 SHEET 2 OF 2 REV. L1