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LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	B	ECR-07-013305	6-2007	MY	GB

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1528474-1	B	-	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528474-2	B	-	BENCH	MECH PRE FEED	CUTS CARRIER
1528474-6	B	-	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528474-1	B	-	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528474-2	B	-	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528474-6	B	-	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528474-7	A	-	-	-	SPARE PARTS KIT

CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: 2.3 UNSEALED RECEPTACLE CONTACT

CRIMP	SIZE	TYPE	RANGE
WIRE	2.35 [.093 IN]	F	0.79mm² - 1.96mm² △4
INSUL	2.90 [.114 IN]	O/V	1.5-2.7 [.059-.106 IN]

WIRE STRIP LENGTH 4.50-5.50 [.177-.217 IN]

APPL INSTRUCTION 408-8322 & 408-8490

TERMINAL - - APPL SPEC 114-5325 △4 -

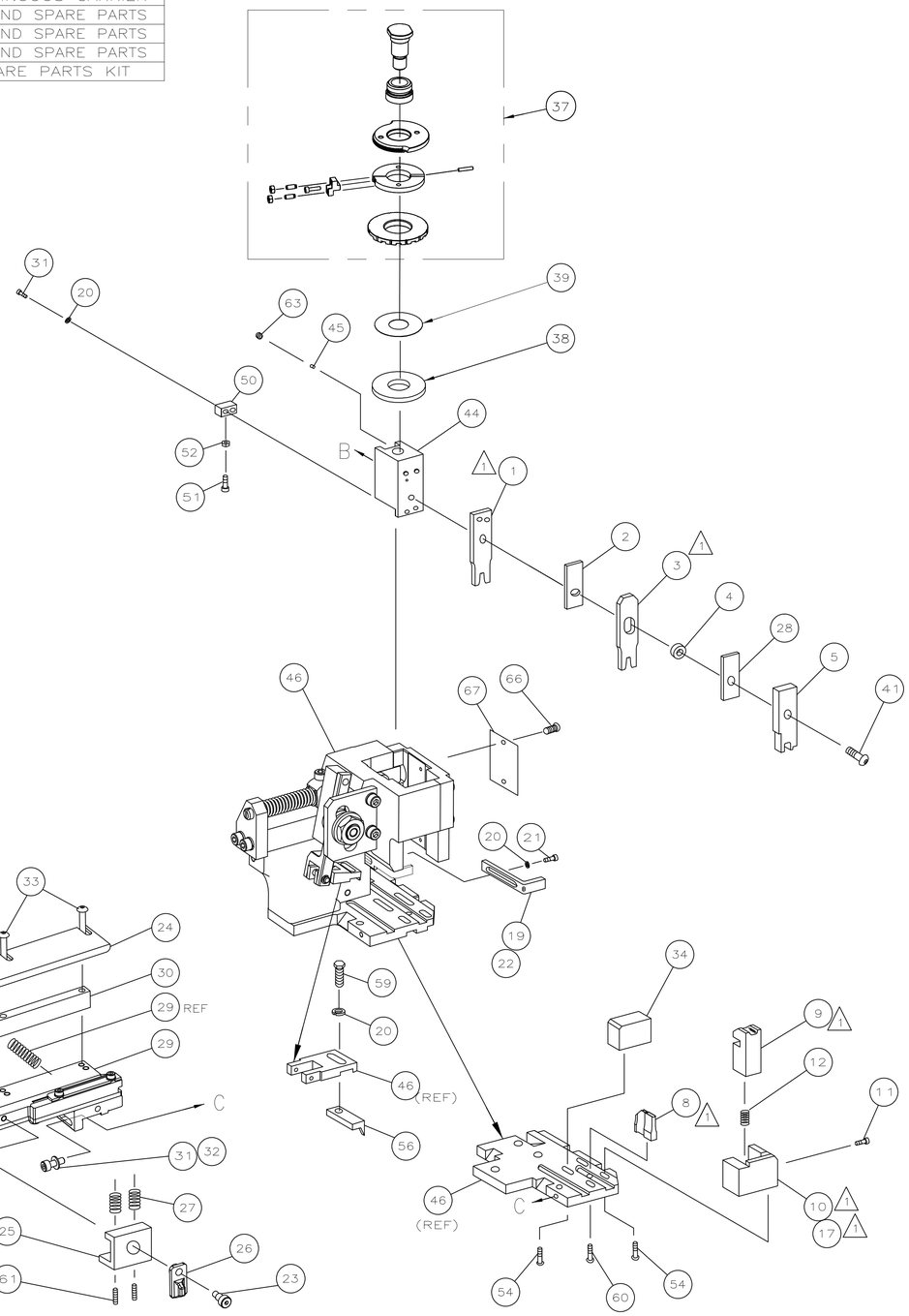
FEED 13.00 [5.12 IN]

TERMINALS APPLIED

1612892-2	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-

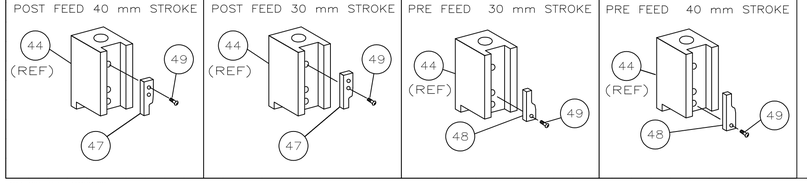
WIRE SIZE mm² AWG	CRIMP HEIGHT *	REF SETTING
△4 2.00mm²	1.47 ±0.05 [.058 ±.002 IN]	B 6
△4 1.00mm²	1.19 ±0.05 [.047 ±.002 IN]	D 6
△4 1.25mm²	1.28 ±0.05 [.050 ±.002 IN]	C 9
△4 0.85mm²	1.14 ±0.05 [.045 ±.002 IN]	E 1
△4 0.75fmm²	1.11 ±0.05 [.044 ±.002 IN]	E 1
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

SET UP GAGE	LAYOUT
458637-3	L1528475



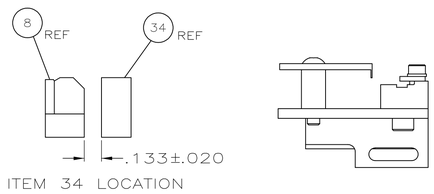
△1 RECOMMENDED SPARE PARTS.
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
△4 SEE APPLICATION SPEC. FOR SPECIFIC WIRE DETAILS.

VIEW B ROTATED 180°



* 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.



ITEM 34 LOCATION

QTY REQD PER ASSY							PART NO	DESCRIPTION	ITEM NO
									73
-	1	1	1	1	1	1	1528474	PRINT, APPLICATOR LOG SHEET	72
-	1	1	1	1	1	1	1338705-3	DOCUMENTATION PACKAGE	71
									70
									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
									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,SKT,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
									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	1338660-1	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 SUBASSY	39
-	1	1	1	1	1	1	469367-9	SPACER, FINE ADJUST	38
-	1	1	1	1	1	1	879103-2	FINE ADJUST HEAD SUBASSY	37
									36
									35
-	1	1	1	1	1	1	1320934-1	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
-	3	3	3	3	3	3	1-18023-2	SCR,SKT CAP(M4X12)MOUNT BLOCK	31
-	1	1	1	1	1	1	1320908-1	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1	1633073-1	STRIP GUIDE PLATE ASSY	29
-	1	1	1	1	1	1	1-455888-6	SPACER, FRONT SHEAR DEP	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	-	-	1	-	-	1338684-1	HOLDER, SHEAR, FRONT (NO-CUT)	17
									16
									15
									14
									13
-	1	1	1	1	1	1	3-22280-3	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	454276-1	SHEAR, FLOAT (FRONT)	9
1	2	2	2	1	1	1	6-1333225-7	ANVIL	8
									7
									6
-	1	1	1	1	1	1	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	1	1	1	238011-4	SPACER, BLOCK CRIMPER	4
△1 1	2	2	2	1	1	1	1596587-2	CRIMPER, INSULATION	3
-	1	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
△1 1	2	2	2	1	1	1	1463696-2	CRIMPER, WIRE	1
-77	-76	-72	-71	-6	-2	-1			

PARTS LIST

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ± -
1 PLC ± -
2 PLC ± -
3 PLC ± -
4 PLC ± -
ANGLES ± -

MATERIAL -

FINISH -

DWN 18JAN05 L.LOFTHOUSE
CHK -
APVD 18JAN05 F.BACKHURST
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

Tyco Electronics
Tyco Electronics Corporation
Harrisburg, PA 17105-3608

NAME FINE ADJ SIDE FD HD-I APPL
-
-

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1528474	-

CUSTOMER DRAWING SCALE - SHEET 1 OF 1 REV B

AMP 4805 REV 31MAR2000