DRAWING MADE IN THIRD ANGLE PROJECTION

1339771 ⇔ 1339771

/home/eb003653/edmmod

| PART NUMBER | REV | FIRST USED | TERMINATOR | FEED TYPE | DESCRIPTION |
|---|---|---|---|---|---|
| 1339771-1 | A | - | BENCH & LEADMAKER | MECH POST FEED | HD-I APPLICATOR |
| 7-1339771-1 | A | - | BENCH & LEADMAKER | MECH POST FEED | -1 AND SPARE PARTS |
| 7-1339771-7 | A | - | - | - | SPARE PARTS KIT |

## CRIMP DATA TYCO TERMINAL TYCO [UTILUX] CRIMP SPECS

TERMINAL NAME: RECEPTACLE, QC6.3 PIVOT LOCK

| CRIMP | SIZE | TYPE | RANGE |
|---|---|---|---|
| WIRE | 3.05 [.120 IN] | F | 1.00-1.50mm² |
| INSUL | 3.94 [.155 IN] | F | 2.60-3.00 [.102-.118 IN] △7 |

WIRE STRIP LENGTH 5.50 [.217 IN]

APPL INSTRUCTION 408-8323

TERMINAL - -
APPL SPEC 114-3118 △4 -

FEED 22.10 [.870 IN]

### TERMINALS APPLIED

| | | | | |
|---|---|---|---|---|
| 1-1627095-0 | - | - | - | - |
| - | - | - | - | - |
| - | - | - | - | - |
| - | - | - | - | - |
| - | - | - | - | - |
| - | - | - | - | - |
| - | - | - | - | - |
| - | - | - | - | - |

| WIRE SIZE mm² AWG | CRIMP HEIGHT △5 | PIN PN AND LENGTH [IN] |
|---|---|---|
| 1.50mm² | 1.65 ±0.05 [.065 ±.002 IN] | 5-354778-9 [.2790] |
| 1.30mm² | 1.60 ±0.05 [.063 ±.002 IN] | 6-354778-3 [.2810] |
| 1.00mm² | 1.50 ±0.05 [.059 ±.002 IN] | 7-354778-1 [.2850] |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |

△1 RECOMMENDED SPARE PARTS.

2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.

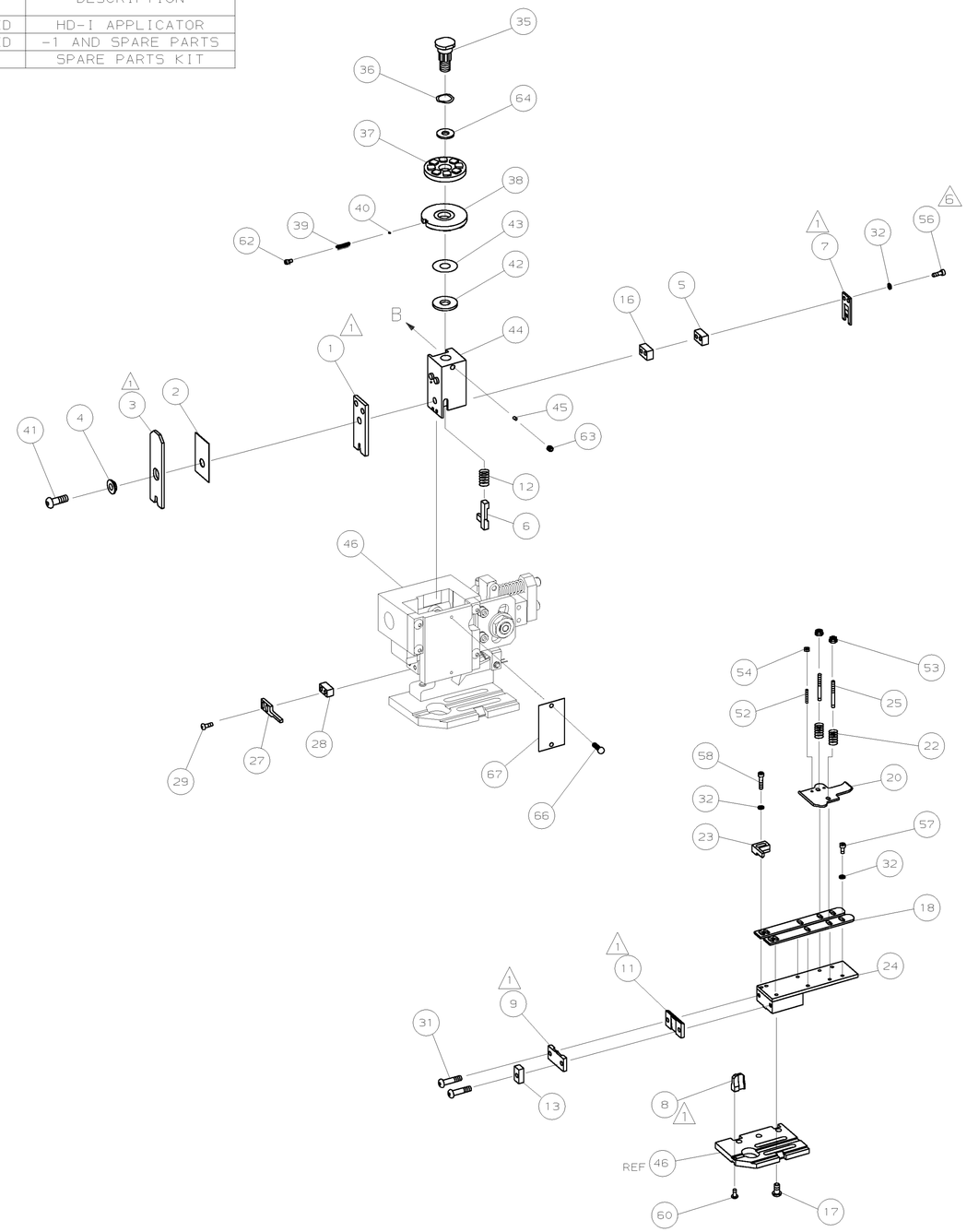
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

△4 CRIMP TENSILES VALUES TO EXCEED;
1.50mm² = 200N
1.30mm² = 190N
1.00mm² = 160N

△5 TYCO ELECTRONICS UK LTD RECOMMENDED CRIMP HEIGHTS.

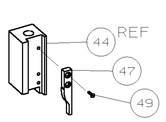
△6 CUT TO LENGTH AT ASSEMBLY.

△7 MIN INSULATION CRIMP HEIGHT 3.70 [.146 IN] TO PREVENT PIERCING OF INSULATION COATING.



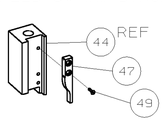

### VIEW B ROTATED 180°

POST-FEED 40 mm STROKE




LEADMAKER OR BENCH G

POST-FEED 30 mm STROKE




K TERMINATOR BENCH MACHINE

| | | | | | | ITEM NO |
|---|---|---|---|---|---|---|
| | | | | | | 73 |
| - | 1 | 1 | 1339771 | PRINT, APPLICATOR LOG SHEET | | 72 |
| - | 1 | 1 | 1338705-2 | DOCUMENTATION PACKAGE | | 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 | 1-18023-3 | SCR,SHC(M4X16)SLUG BLADE | △6 | 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 | 690124-4 | 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 | 1-18024-0 | SCR,BHC(M4X20)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 | 240825-1 | 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 |
| | | | | | | 14 |
| - | 1 | 1 | 690481-2 | SPACER, HOLD DOWN | | 13 |
| - | 1 | 1 | 23846-1 | SPRING, HOLD DOWN | | 12 |
| - | 1 | 1 | 240644-1 | PLATE, REAR SHEAR | △1 | 11 |
| | | | | | | 10 |
| - | 1 | 1 | 690482-3 | PLATE, FRONT SHEAR | △1 | 9 |
| 1 | 2 | 1 | 2-1333220-5 | ANVIL | △1 | 8 |
| - | 1 | 1 | 690474-3 | BLADE, SLUG | △1 | 7 |
| - | 1 | 1 | 455892-1 | HOLD DOWN, TERMINAL | | 6 |
| - | 1 | 1 | 3-240641-2 | SPACER, SLUG BLADE | | 5 |
| - | 1 | 1 | 238009-1 | SPACER, BLOCK CRIMPER | | 4 |
| 1 | 2 | 1 | 3-456134-6 | CRIMPER, INSULATION | △1 | 3 |
| - | 1 | 1 | 455888-7 | SPACER, CRIMPER | | 2 |
| 1 | 2 | 1 | 1-456409-2 | CRIMPER, WIRE | △1 | 1 |
| | -77 | -71 | -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 |
|---|---|---|---|---|---|
| | | A | SEE ECR-05-005147 | LJL | JUL05 |

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

MATL - HT TR - FIN -
- - -

DR 09JUN05 M.CLIFFORD APP 09JUN05 F.BACKHURST
CHK - - REL 07JUL05 L.LOFTHOUSE

AMP Tyco Electronics Harrisburg, PA 17105-3608

NAME END FEED HD-I APPLICATOR
MACHINE REF HD-I APPL
SCALE - D DWG NO 1339771 SHEET 1 OF 1 REV A

CAGE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO -

LOC A DIST 66

LAYOUT L1339771

SET UP GAGE 458638-3

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