

| PART NUMBER | REV | FIRST USED | TERMINATOR | FEED TYPE | DESCRIPTION |
|-------------|-----|------------|------------|-------------------|-----------------------------------|
| 1339520-1 | D | | - | BENCH & LEADMAKER | MECH POST FEED HD-I APPLICATOR |
| 7-1339520-1 | D | | - | BENCH & LEADMAKER | MECH POST FEED -1 AND SPARE PARTS |
| 7-1339520-7 | A | | - | - | SPARE PARTS KIT |

CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

| TERMINAL NAME: RING TONGUE | | | |
|----------------------------|----------------|------------------|---|
| CRIMP | SIZE | TYPE | RANGE |
| WIRE | 3.30 [.130 IN] | F | 1.50mm ² - 2.50mm ² |
| INSUL | 4.57 [.180 IN] | F | 2.70-4.00 [.106-.157 IN] |
| WIRE STRIP LENGTH | | APPL INSTRUCTION | |
| 4.80-5.60 [.189-.220 IN] | | 408-8323 | |
| TERMINAL APPL SPEC | 114-3118 | FEED | 21.77 [.857 IN] |

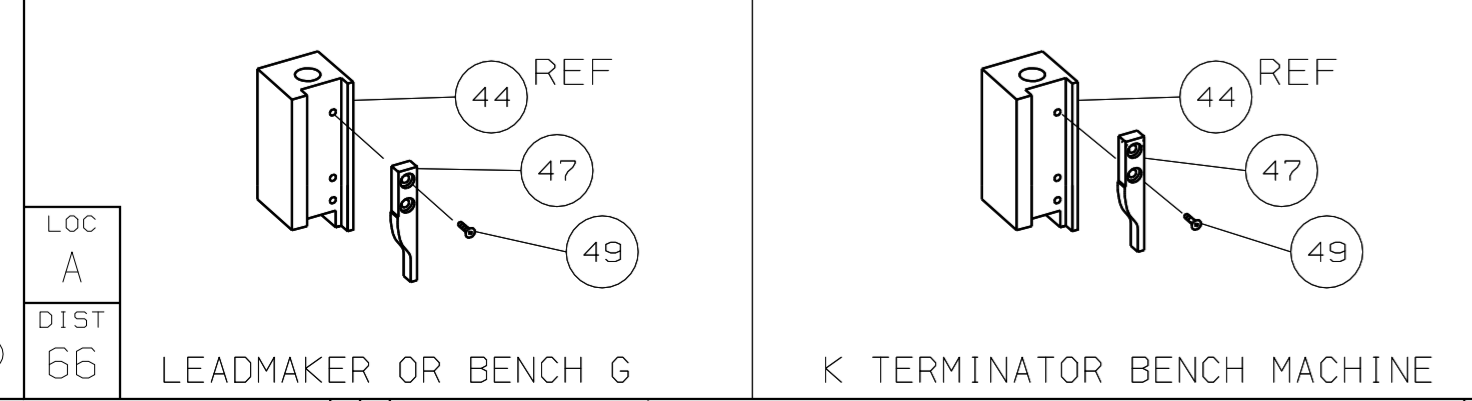
TERMINALS APPLIED

| | | | | | |
|--------|---|---|---|---|---|
| 880642 | - | - | - | - | - |
| 880623 | - | - | - | - | - |
| 880643 | - | - | - | - | - |
| - | - | - | - | - | - |
| - | - | - | - | - | - |
| - | - | - | - | - | - |
| - | - | - | - | - | - |
| - | - | - | - | - | - |
| - | - | - | - | - | - |
| - | - | - | - | - | - |

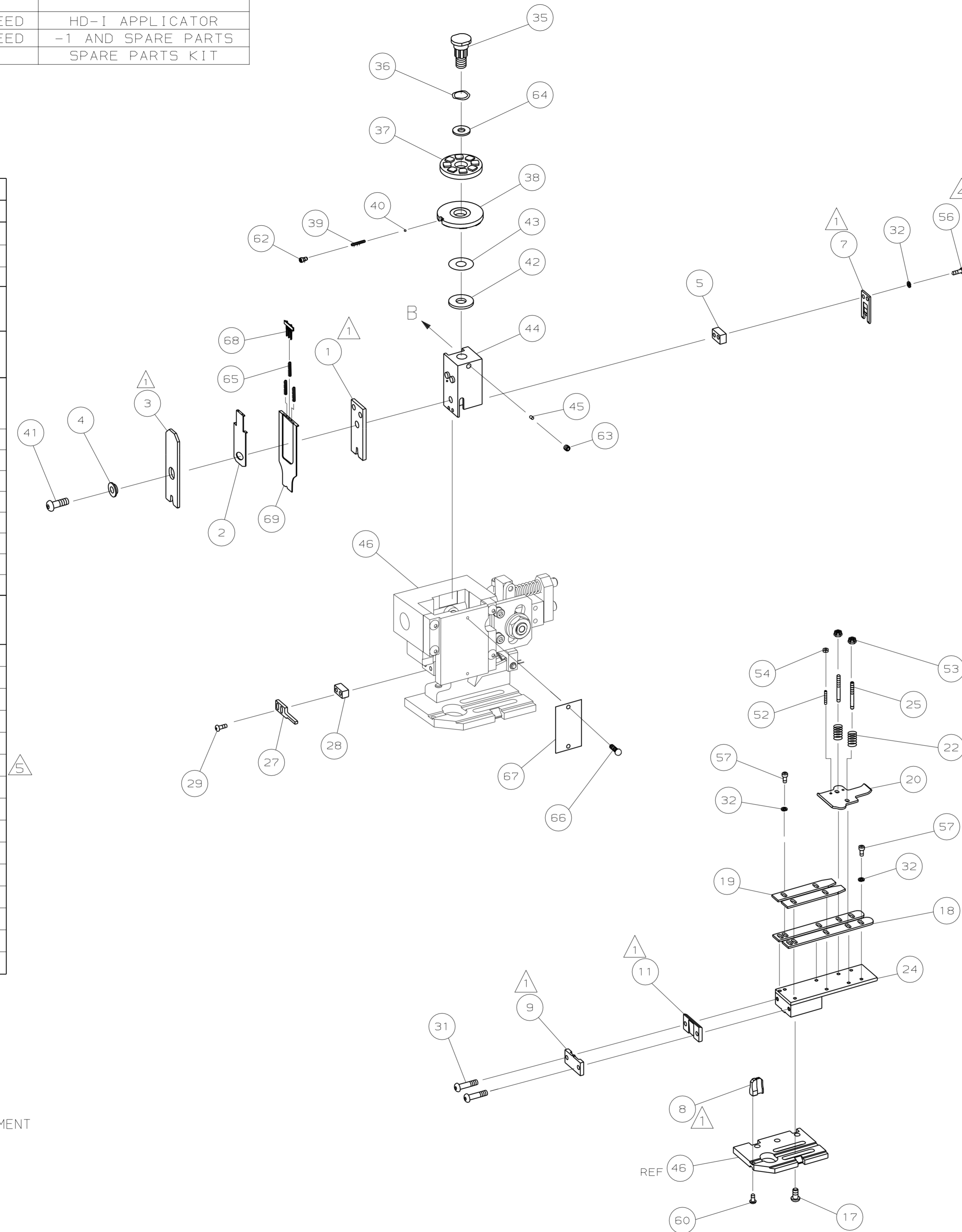
| WIRE SIZE mm ² AWG | CRIMP HEIGHT | PIN PN & LENGTH [IN] |
|----------------------------------|----------------------------|-------------------------|
| 2.50mm ² | 2.41 ±0.05 [.095 ±.002 IN] | 3-354778-9 [.2690] |
| 14 AWG | 2.26 ±0.05 [.089 ±.002 IN] | 5-354778-4 [.2765] |
| 2.00mm ² | 2.23 ±0.05 [.088 ±.002 IN] | 5-354778-7 [.2780] |
| 1.50mm ² | 2.11 ±0.05 [.083 ±.002 IN] | 6-354778-5 [.2820] |
| 16 AWG | 2.08 ±0.05 [.082 ±.002 IN] | 6-354778-8 [.2835] |
| 1.00mm ² | 2.00 ±0.05 [.079 ±.002 IN] | 7-354778-3 [.2860] |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |

- 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. CUT TO LENGTH AT ASSY.
- 5. 1.00mm² WIRE SIZE IS FOR A SPECIFIC CUSTOMER REQUIREMENT AND IS OUTSIDE THE NORMAL RANGE OF THIS APPLICATOR.

VIEW B ROTATED 180°



LOC A
D1ST 66
LEADMAKER OR BENCH G
K TERMINATOR BENCH MACHINE



| QTY | REQD | PER ASSY | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-------------|------------------------------|---------|
| - | 1 | 1 | 1339520 | PRINT, APPLICATOR LOG SHEET | 73 |
| - | 1 | 1 | 1338705-2 | DOCUMENTATION PACKAGE | 72 |
| - | 1 | 1 | | | 70 |
| - | 1 | 1 | 1490525-1 | DEPRESSOR, WIRE | 69 |
| - | 1 | 1 | 1424350-1 | HOLDER, PIN, WIRED | 68 |
| - | 1 | 1 | 461264-1 | PLATE, IDENTIFICATION | 67 |
| - | 2 | 2 | 21017-2 | SCR, DRIVE (#2X.19) ID PLATE | 66 |
| - | 2 | 2 | 1-23147-4 | SPRING, COMPRESSION | 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 |
| - | 1 | 1 | | | 61 |
| - | 1 | 1 | 18024-7 | SCR, BHC (M4X10) ANVIL | 60 |
| - | | | | | 59 |
| - | | | | | 58 |
| - | 6 | 6 | 18023-9 | SCR, SHC (M4X6) STRIP GUIDE | 57 |
| - | 2 | 2 | 1-18023-3 | SCR, SHC (M4X16) 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 | 1338662-2 | 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 | 1-1320922-0 | 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 |
| - | 8 | 8 | 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 | 1-690451-1 | SPACER, STRIPPER | 28 |
| - | 1 | 1 | 240639-1 | STRIPPER | 27 |
| - | | | | | 26 |
| - | 2 | 2 | 1320906-1 | DRAG, STUD | 25 |
| - | 1 | 1 | 1320995-1 | STRIP GUIDE | 24 |
| - | | | | | 23 |
| - | 2 | 2 | 4-22281-1 | SPRING, DRAG | 22 |
| - | | | | | 21 |
| - | 1 | 1 | 1338665-1 | DRAG, STOCK | 20 |
| - | 2 | 2 | 1338664-1 | GUIDE, UPPER STRIP | 19 |
| - | 2 | 2 | 1338663-2 | GUIDE, LOWER STRIP | 18 |
| - | 4 | 4 | 1-18024-8 | SCR, BHC (M6X12) STRIP 6D PL | 17 |
| - | | | | | 16 |
| - | | | | | 15 |
| - | | | | | 14 |
| - | | | | | 13 |
| - | | | | | 12 |
| - | 1 | 1 | 240644-1 | PLATE, REAR SHEAR | 11 |
| - | | | | | 10 |
| - | 1 | 1 | 690482-4 | PLATE, FRONT SHEAR | 9 |
| - | 1 | 2 | 1333221-1 | ANVIL | 8 |
| - | 1 | 1 | 690474-4 | BLADE, SLUG | 7 |
| - | | | | | 6 |
| - | 1 | 1 | 1-240641-5 | SPACER, SLUG BLADE | 5 |
| - | 1 | 1 | 238009-1 | SPACER, BLOCK CRIMPER | 4 |
| - | 1 | 2 | 456134-6 | CRIMPER, INSULATION | 3 |
| - | 1 | 1 | 1490524-2 | SPACER, DEPRESSOR | 2 |
| - | 1 | 2 | 456410-3 | CRIMPER, WIRE | 1 |
| - | -77 | -71 | -1 | | |

REVISION RECORD

| REV | DATE | DESCRIPTION |
|-----|-------|---|
| 01 | JAN01 | ADDITIONAL WIRE SIZES. |
| | | REMOVE BURRS, BREAK SHARP EDGES RO.38 MAX |

DR L.L.OFTHOUSE
CHK 08-02-01
M.CLIFFORD

APP 06NOV00
F.BACKHURST
REL 08-02-01
M.CLIFFORD

AMP Incorporated
Harrisburg, PA 17105-3608

END FEED HD-I APPLICATOR

SCALE: D DWG NO: 1339520

CAGE CODE: 00779

CUSTOMER AND ASSEMBLY DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT.

LAYOUT L1339520
SET UP GAGE 458638-3

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2000 .
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1339520
D
C
B
A