PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339732-1	A		- BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1339732-1	A		- BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339732-7	A		-	-	SPARE PARTS KIT

CRIMP DATA STOCKO TERMINAL AMP CRIMP SPECS

TERMINAL NAME: STOCKO FORK TONGUE

CRIMP	SIZE	TYPE	RANGE
WIRE	3.56 [.140 IN] △4	F	2.50mm²
INSUL	5.08 [.200 IN] △4	F	3.56 MAX [.140 IN MAX]

WIRE STRIP LENGTH 5.25-6.05 [.207-.238 IN]

APPL INSTRUCTION 408-8323

TERMINAL	-	-	FEED
APPL SPEC	NONE	-	24.20 [.953 IN]

TERMINALS APPLIED

AMP PN	MFR PN	-	-
1572409-1	RSB 7843.001 C 4-2.5	-	-
1572409-2	RSB 7843.001 C 3.5-2.5	-	-
1572409-3	RSB 7843.001 C 3-2.5	-	-
-	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-

WIRE SIZE mm² AWG	CRIMP HEIGHT △4	PIN PN AND LENGTH [IN]
2.50mm²	2.26 ±0.05 [.089 ±.002 IN]	5-354778-8 [.2785]
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

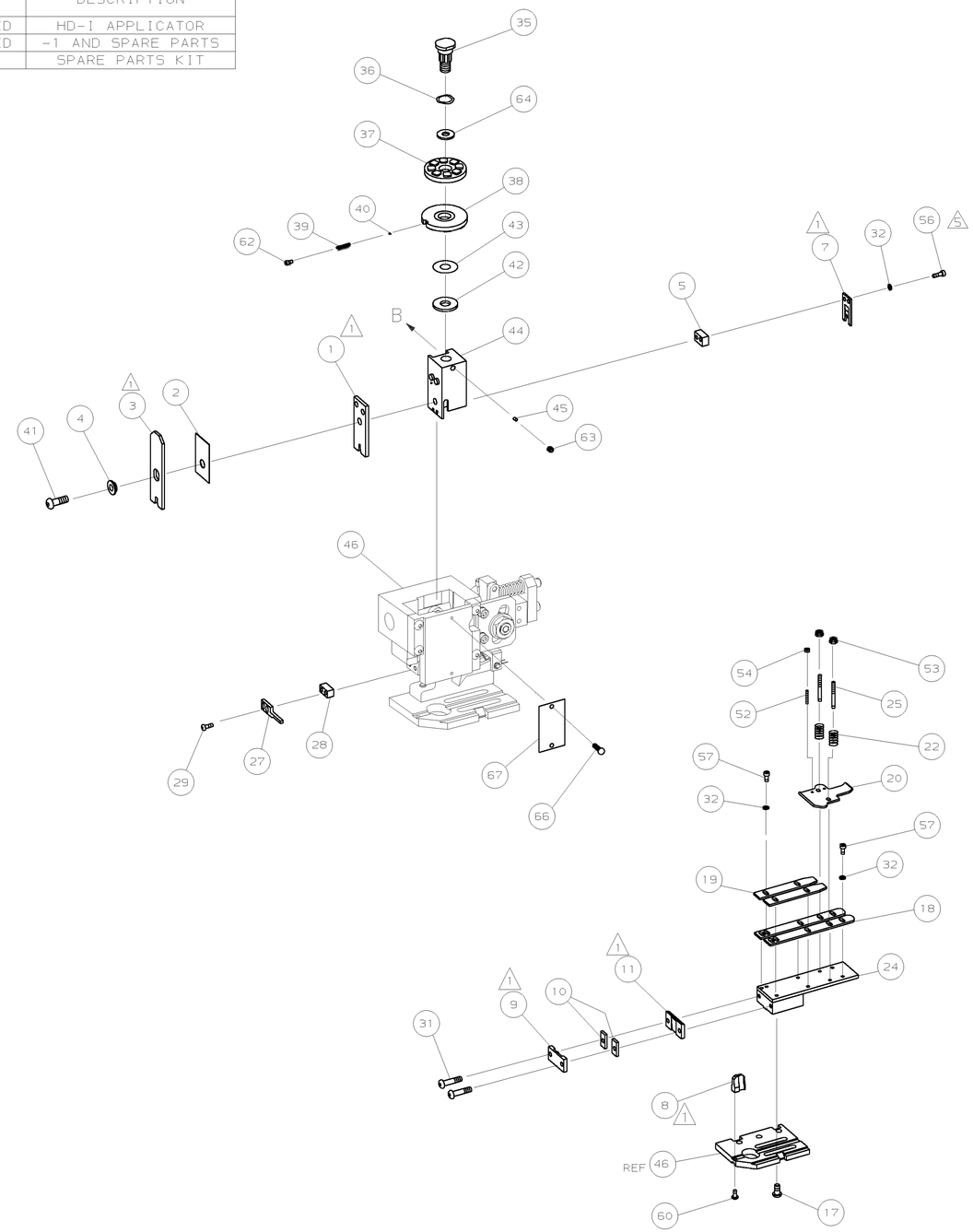
△1 RECOMMENDED SPARE PARTS.

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

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

△4 ALL CRIMP DATA CALCULATED BY TYCO ELECTRONICS UK LTD.

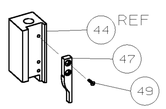
△5 CUT TO LENGTH AT ASSY.



ITEM NO	QTY REQD PER ASSY		PARTS LIST		
	-77	-71	-1	PART NO	DESCRIPTION
				← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)	
73					
72	–	1	1	1339732	PRINT, APPLICATOR LOG SHEET
71	–	1	1	1338705-2	DOCUMENTATION PACKAGE
70					
69					
68					
67	–	1	1	461264-1	PLATE, IDENTIFICATION
66	–	2	2	21017-2	SCR,DRIVE(#2X.19)ID PLATE
65					
64	–	1	1	986950-1	WASHER, FLAT PRECISION
63	–	1	1	3-18031-0	SCR,SKT SET(M6X6)RAM
62	–	1	1	18023-9	SCR,SKT CAP(M4X6)CP DSC
61					
60	–	1	1	18024-7	SCR,BHC(M4X10)ANVIL
59					
58					
57	–	6	6	18023-9	SCR,SHC(M4X6)STRIP GUIDE
56	△5 –	2	2	1-18023-3	SCR,SHC(M4X16)SLUG BLADE
55					
54	–	2	2	18029-1	NUT,HEX(M3)DRAG
53	–	2	2	986965-1	NUT,HEX SL(M4)DRAG STUD
52	–	2	2	2-18032-2	SCR,SKT SET(M3X10)DRAG
51					
50					
49	–	1	1	18024-3	SCR,BHC(M3X10)CAM
48					
47	–	1	1	1338676-1	CAM, POST-FEED 30 & 40 mm ST
46	–	1	1	1338662-1	APPLICATOR, BASIC (SUBASSY)
45	–	1	1	690191-1	PLUG, NYLON
44	–	1	1	1320998-1	RAM
43	–	1	1	690125-1	WASHER, LAMINATED
42	–	1	1	690124-1	WASHER, RAM
41	–	1	1	2-18024-6	SCREW,BHC(M8X25)CRIMPER
40	–	1	1	23241-1	BALL, STEEL
39	–	1	1	2-22278-7	SPRING, COMPRESSION
38	–	1	1	1320922-1	DISC, INSULATION
37	–	1	1	354777-1	WIRE DISC, PLASTIC
36	–	1	1	22480-5	WASHER, SPRING
35	–	1	1	690212-1	POST, RAM
34					
33					
32	–	8	8	18025-2	WASHER,LOCK(M4)SHEAR BL
31	–	2	2	1-18024-0	SCR,BHC(M4X20)SHEAR PL
30					
29	–	2	2	18024-8	SCR,BHC(M4X12)STRIPPER
28	–	1	1	3-690451-2	SPACER, STRIPPER
27	–	1	1	240639-1	STRIPPER
26					
25	–	2	2	1320906-1	DRAG, STUD
24	–	1	1	1320995-1	PLATE, STRIP GUIDE
23					
22	–	2	2	4-22281-1	SPRING, DRAG
21					
20	–	1	1	1338665-1	DRAG, STOCK
19	–	2	2	1338664-1	GUIDE, UPPER STRIP
18	–	2	2	1338663-2	GUIDE, LOWER STRIP
17	–	4	4	1-18024-8	SCR,BHC(M6X12)STRIP GD PL
16					
15					
14					
13					
12					
11	△1 –	1	1	240644-1	PLATE, REAR SHEAR
10	–	2	2	240645-7	SPACER, SHEAR PLATE
9	△1 –	1	1	240642-1	PLATE, FRONT SHEAR
8	△1 1	2	1	1-1333222-4	ANVIL
7	△1 –	1	1	1-240651-3	BLADE, SLUG
6					
5	–	1	1	8-240641-5	SPACER, SLUG BLADE
4	–	1	1	3-238009-3	SPACER, BLOCK CRIMPER
3	△1 1	2	1	6-1213077-0	CRIMPER, INSULATION
2	–	1	1	455888-9	SPACER, CRIMPER
1	△1 1	2	1	456411-6	CRIMPER, WIRE

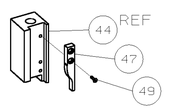
VIEW B ROTATED 180°

POST-FEED 40 mm STROKE



LEADMAKER OR BENCH G

POST-FEED 30 mm STROKE



K TERMINATOR BENCH MACHINE

LOC A

DIST 66

	A1	ECN 0150-1228-04	TE	9-04	
	A	SEE ECN 015A-0319-04	MC	APR04	
P	F	LTR REVISION RECORD	APP	DATE	

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 RO.38 MAX

MATL – | HT TR – | FIN –

DR 24FEB04 M.CLIFFORD | APP 24FEB04 F.BACKHURST

CHK – – | REL 23-04-04 M.CLIFFORD

AMP Tyco Electronics Harrisburg, PA 17105-3608

NAME END FEED HD-I APPLICATOR | MACHINE REF HD-I APPL

SCALE – | D | DWG NO 1339732 | SHEET 1 of 1 | REV A1

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO –

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LAYOUT 1339732

SET UP GAGE 458638-3