

PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1339826-1	A	BENCH & LEADMAKER	MECH POST FEED	HDI APPLICATOR
7-1339826-1	A	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339826-7	A	-	-	SPARE PARTS KIT

SET UP GAGE		LOC	DIST	REVISIONS			
458638-3		A	66	REV	DATE	BY	APPV
		A		SEE ECO-08-009688	17APR2008	MC	MC

CRIMP DATA ESCUBEDO TERMINAL ESCUBEDO CRIMP SPECS

CRIMP	SIZE	TYPE	RANGE
WIRE	2.29 [.090 IN]	F	0.50-1.00mm ²
INSUL	3.30 [.130 IN]	F	1.80-2.50 [.071-.098 IN]

WIRE STRIP LENGTH 5.00-6.00 [.197-.236 IN] APPL INSTRUCTIONS 408-8323

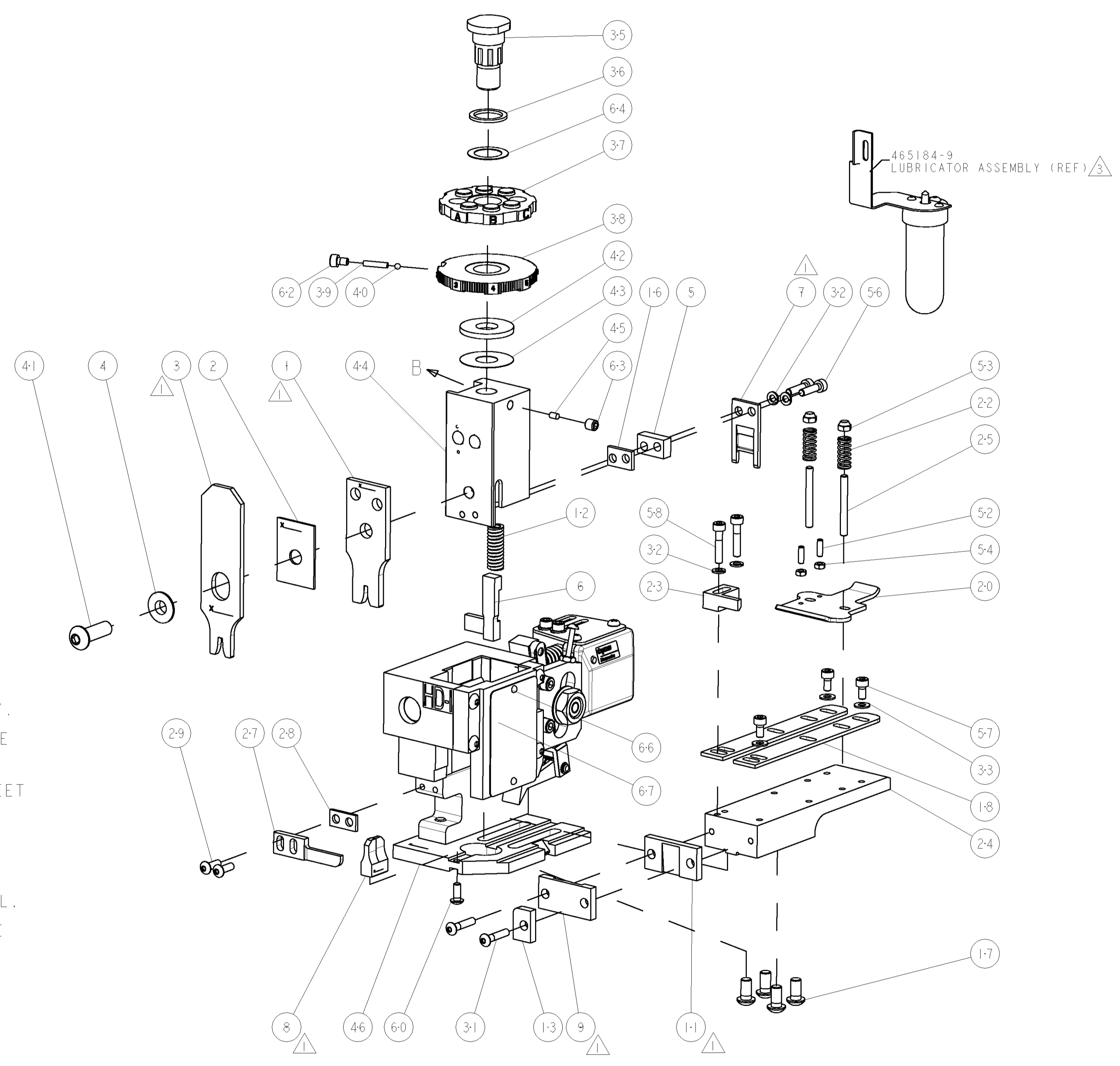
TERMINAL APPL SPEC	ESCUBEDO DATA SHT	FEED
4830.24	-	21.40 [.843 IN]

TERMINALS APPLIED

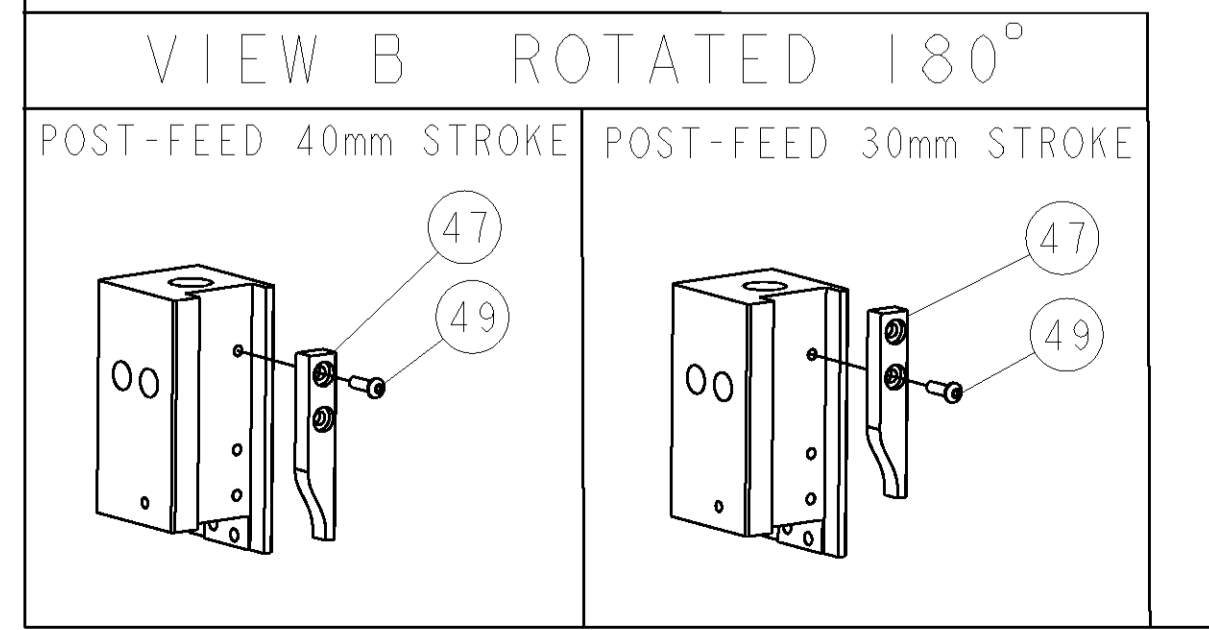
TE TERM PN	MANUF TERM PN	TE TERM PN	MANUF TERM PN
1949637-1	4830.00	1949637-5	4830.30
1949637-2	4830.01	1949637-6	4830.31
1949637-3	4830.02	1949637-7	4830.32
1949637-4	4830.24	1949637-8	4830.70

WIRE SIZE	CRIMP HEIGHT	PIN PN & LENGTH [IN]
1.00mm ²	1.50 ± 0.05 [.059 ± .002 IN]	2-354779-0 [.3090]
0.75mm ²	1.40 ± 0.05 [.055 ± .002 IN]	2-354779-8 [.3130]
0.50mm ²	1.30 ± 0.05 [.051 ± .002 IN]	3-354779-8 [.3180]

- 1 RECOMMENDED SPARE PARTS
- 2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
- 3 CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.
- 4. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 5 CRIMP DATA SUPPLIED BY THE TERMINAL MANUFACTURER. INSULATION CRIMP HEIGHTS SPECIFIED BY TERMINAL MANUFACTURER NOT RECOMMENDED BY TYCO ELECTRONICS.
- 6 WIRE AND INSULATION RANGES ARE THAT OF THE TERMINAL.
- 7 0.50mm² WIRE SIZE ACHIEVES ESCUBEDO MINIMUM TENSILE VALUE, BUT MAY NOT PASS A CAPABILITY STUDY.



QTY	REV	LOC	DIST	DESCRIPTION	DATE	BY	APPV
-	1	1		1338705-2	DOCUMENTATION PACKAGE		71
-	1	1		461264-1	PLATE, IDENTIFICATION		67
-	2	2		21017-2	SCREW, DRIVE		66
-	1	1		986950-1	WASHER, FLAT PRECISION		64
-	1	1		3-18031-0	SCR, SET, CUP POINT M6 X 6.0		63
-	1	1		18023-9	SCR, SKT HD CAP M4 X 6.0		62
-	1	1		18024-7	SCR, BTN SKT HD CAP (M4 X 10.0)		60
-	2	2		1-18023-4	SCR, SKT HD CAP M4 X 20.0		58
-	3	3		1-18023-0	SCR, SKT HD CAP M4 X 8.0		57
-	2	2		1-18023-3	SCR, SKT HD CAP M4 X 16.0		56
-	2	2		18029-1	NUT, HEX, REG M3		54
-	2	2		986965-1	NUT, LOCK, HEX, TORQUE (M4)		53
-	2	2		2-18032-2	SCR, SET, FLT POINT M3 X 10.0		52
-	1	1		18024-3	SCR, BTN SKT HD CAP (M3 X 10.0)		49
-	1	1		1338676-1	CAM, UNIVERSAL POST-FEED		47
-	1	1		1338662-1	SUB ASSY, APPLICATOR FRAME		46
-	1	1		690191-1	PLUG, NYLON		45
-	1	1		1320998-1	RAM		44
-	1	1		690125-1	SHIM SUB-ASSY		43
-	1	1		690124-1	WASHER, RAM (.115)		42
-	1	1		2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)		41
-	1	1		23241-1	BALL, STEEL		40
-	1	1		2-22278-7	SPRING, COMPRESSION		39
-	1	1		1320922-1	DISC, ADJUST, INSULATION CRIMP		38
-	1	1		354777-1	WIRE DISC, ASSEMBLY		37
-	1	1		22480-5	SPRING, COMPRESSION		36
-	1	1		690212-1	POST, RAM		35
-	3	3		18027-2	WASHER, FLAT, REG M4		33
-	4	4		18025-2	WASHER, SPRG LOCK, REG M4		32
-	2	2		1-18024-0	SCR, BTN SKT HD CAP (M4 X 20.0)		31
-	2	2		18024-8	SCR, BTN SKT HD CAP (M4 X 12.0)		29
-	1	1		3-690451-2	SPACER, STRIPPER		28
-	1	1		240639-1	STRIPPER (MACHINING)		27
-	2	2		1320906-1	STUD, THREADED		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
-	1	1		1338665-1	DRAG		20
-	2	2		1338663-4	GUIDE, LOWER STRIP		18
-	4	4		1-18024-8	SCR, BTN SKT HD CAP (M6 X 12.0)		17
-	1	1		1338708-1	SPACER, SLUG BLADE		16
-	1	1		690481-2	SPACER, HOLD DOWN		13
-	1	1		23846-1	SPRING, DIE		12
-	1	1		240644-1	PLATE, REAR SHEAR		11
-	-	-		-	-		10
-	1	1		690482-3	PLATE, FRONT SHEAR		9
-	1	2		3-1633384-7	ANVIL, COMBINATION		8
-	1	1		690474-3	BLADE, SLUG		7
-	1	1		3-455892-4	HOLD DOWN, TERMINAL		6
-	1	1		2-240641-3	SPACER		5
-	1	1		238009-1	BLOCK, FL CRIMPER SPACER		4
-	1	2		1424909-2	CRIMPER, INSULATION F		3
-	1	1		1-455888-0	SPACER, CRIMPER		2
-	1	2		1-456406-0	CRIMPER, WIRE PREMIUM		1



DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN L. LOETHOUSE 26FEB2008	
0 PLC	±	1 PLC	±0.1	CHK M. CLIFFORD 26FEB2008	NAME
2 PLC	±0.01	3 PLC	±0.001	NAME	END FEED HDI APPLICATOR
4 PLC	±0.0001	ANGLES	±	PRODUCT SPEC	
MATERIAL	FINISH	WEIGHT	SCALE	SIZE	CAGE CODE
			3:5	A1	00779
CUSTOMER DRAWING		SHEET 1 OF 1		REV A	