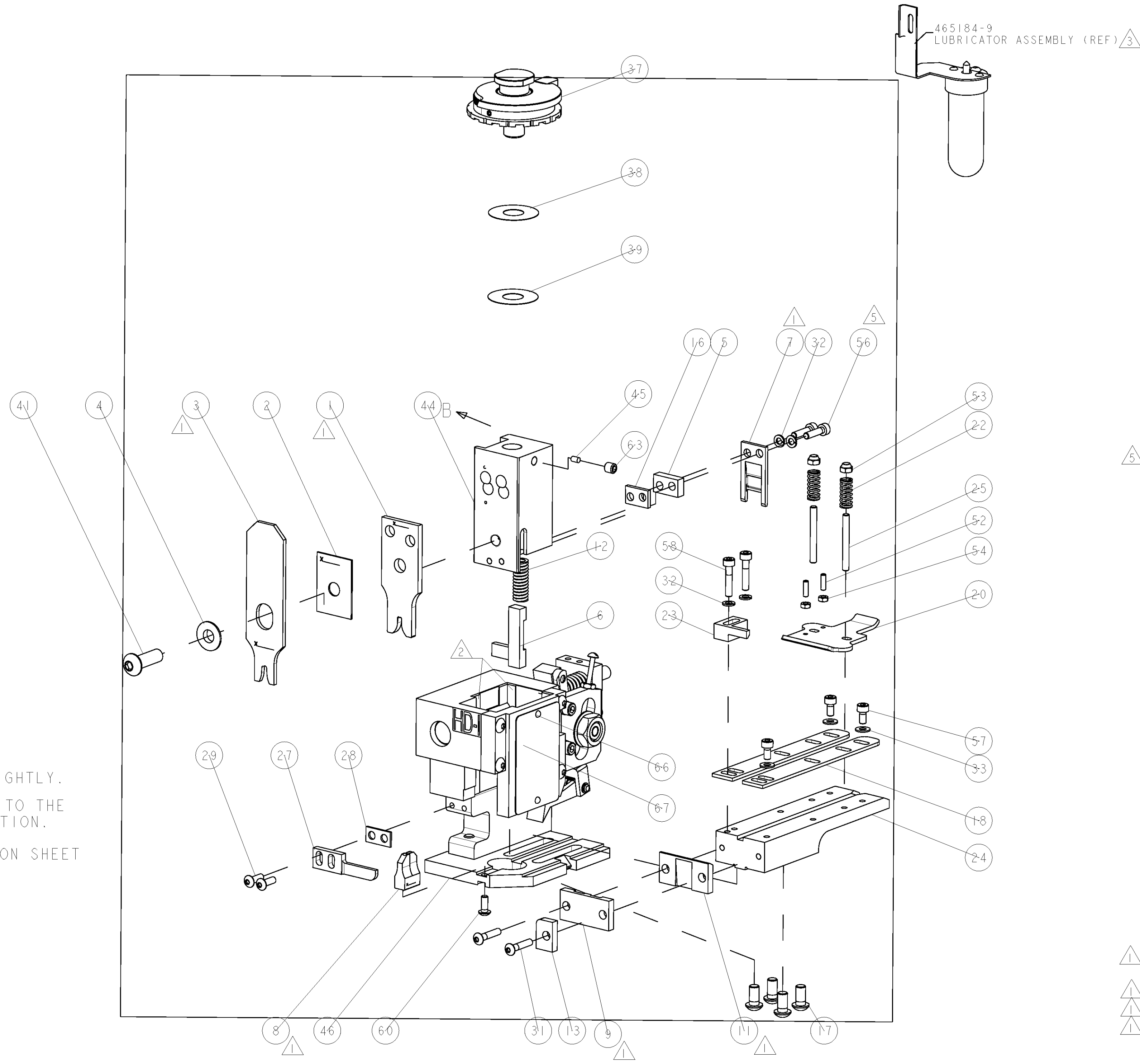


THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		
COPYRIGHT 2010 BY TICO ELECTRONICS CORPORATION, ALL RIGHTS RESERVED.		20		
PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1531099-1	1	BENCH & LEADMAKER	MECH POST FEED	HDI APPLICATOR
7-1531099-1	1	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1531099-7	1	-	-	SPARE PARTS KIT

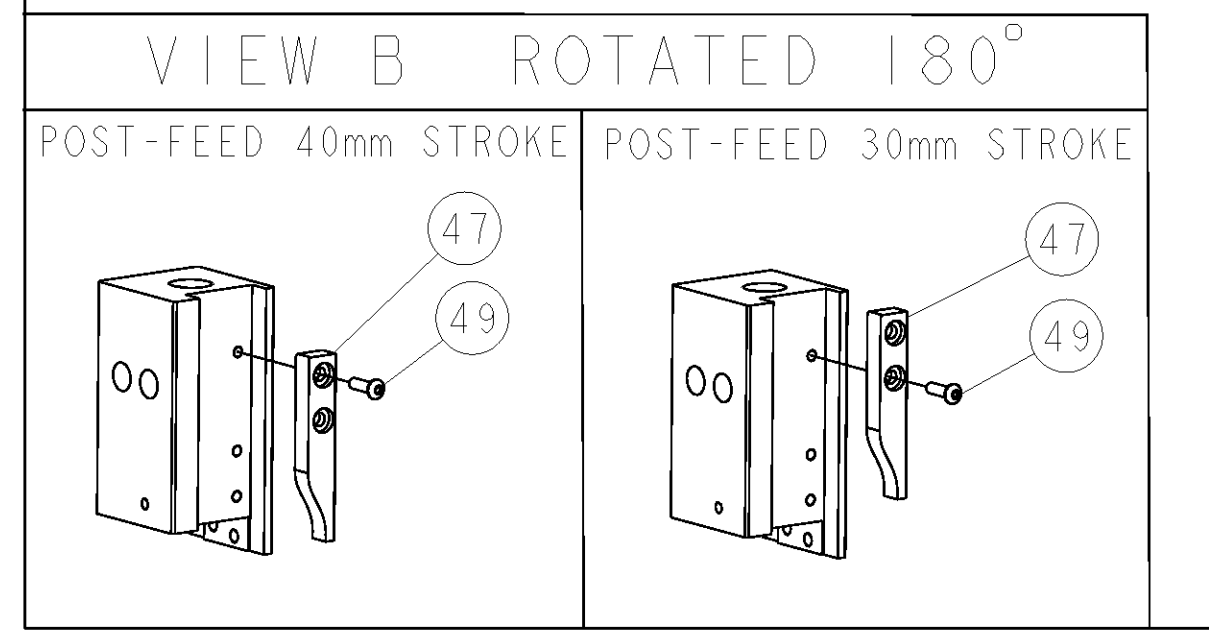
SET UP GAGE 458638-3	LOC A	DIST 66	REV	DATE	DWN	APVD
			1	10MAY2011	D.L	S.X

CRIMP DATA	TE TERMINAL	TE CRIMP SPECS	
TERMINAL NAME: CLIP 6.35 SECURITE			
CRIMP	SIZE	TYPE	RANGE
WIRE	2.79 [.110 IN]	F	1.5-3.0 mm <sup>2</sup>
INSUL	3.81 [.150 IN]	OV	∅2.20-3.35 mm [.087-.132 IN]
WIRE STRIP LENGTH 5.00-5.80 [.197-.228 IN]		APPL INSTRUCTIONS 408-8323 & 408-8490	
TERMINAL APPL SPEC	N/A	FEED 22.00 [.866 IN]	

TERMINALS APPLIED			
1544504	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-
WIRE SIZE	CRIMP HEIGHT	REF SETTING	
3.00mm <sup>2</sup>	2.40 ±0.05 [.094 ±.002 IN]	-	
2.50mm <sup>2</sup>	2.20 ±0.05 [.087 ±.002 IN]	-	
2.00mm <sup>2</sup>	1.95 ±0.05 [.077 ±.002 IN]	-	
1.50mm <sup>2</sup>	1.90 ±0.05 [.075 ±.002 IN]	-	
(0.75±0.75)mm <sup>2</sup>	1.90 ±0.05 [.075 ±.002 IN]	-	



- △ 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.
- △ CUT TO LENGTH AT ASSEMBLY



**\* 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.

PROTOTYPE DESIGN NOT RELEASED FOR PRODUCTION

-	1	1	1338705-4	DOCUMENTATION PACKAGE	71
-	1	1	461264-5	PLATE, IDENTIFICATION	67
-	2	2	21017-2	SCREW, DRIVE	66
-	1	1	3-18031-0	SCR, SET, CUP POINT M6 X 6.0	63
-	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	1333260-1	RAM	44
-	1	1	2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)	41
-	1	1	690125-1	SHIM SUB-ASSY	39
-	1	1	469367-1	SHIM	38
-	1	1	879103-3	FINE ADJUST HEAD ASSEMBLY	37
-	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	2-690451-8	SPACER, STRIPPER	28
-	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	1320906-1	STUD, THREADED	25
-	1	1	1-1320995-3	PLATE, STRIP GUIDE	24
-	1	1	240825-8	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	240833-1	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-6	PLATE, FRONT SHEAR	9
-	1	2	3-1333219-0	ANVIL, COMBINATION	8
-	1	1	690474-6	BLADE, SLUG	7
-	1	1	455892-1	HOLD DOWN, TERMINAL	6
-	1	1	1-240641-4	SPACER	5
-	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4
-	1	2	2-854830-5	CRIMPER, INSULATION SPECIAL	3
-	1	1	455888-8	SPACER, CRIMPER	2
-	1	2	1-456408-8	CRIMPER, WIRE PREMIUM	1
-	77	71	-1	PART NO	ITEM NO

DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN D.L. 10-May-11		CHK S.X.I. 10-May-11		APVD S.X.I. 10-May-11		NAME		TE Connectivity Harrisburg, PA 17105-3608	
9 PLC	±	3 PLC	±0.1	PRODUCT SPEC		FINE ADJUST END FEED		HDI APPLICATOR		SIZE		RESTRICTED TO	
3 PLC	±0.01	4 PLC	±0.001	APPLICATION SPEC		A1 00779		C=1531099		SCALE		SHEET 1 OF 1	
4 PLC	±0.0001	ANGLES		WEIGHT		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 3:5		SHEET 1 OF 1		REV	