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PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1528736-1	A	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528736-2	A	BENCH	MECH PRE FEED	CUTS CARRIER
1528736-6	A	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528736-1	A	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528736-2	A	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528736-6	A	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528736-7	A	-	-	SPARE PARTS KIT

CRIMP DATA KOSTAL TERMINAL KOSTAL CRIMP SPECS △6			
TERMINAL NAME: MLK 1.2M RECEPTACLE			
CRIMP	SIZE	TYPE	RANGE
WIRE	1.17 [.046 IN]	F	0.10-0.25mm² or 26-24 AWG △8
INSUL	1.57 [.062 IN]	O	1.00-1.50 [.039-.059 IN] △7
WIRE STRIP LENGTH 3.10-3.40 [.122-.134 IN]			APPL INSTRUCTIONS 408-8322 & 408-8490
TERMINAL APPL SPEC	KOSTAL SPECS △7 - -		FEED 8.00 [.315 IN]

TERMINALS APPLIED

TE TERM PN	MANUF TERM PN	TE TERM PN	MANUF TERM PN
1949203-1	3 21 24 73405 0	1949203-4	3 21 24 73400 0
1949203-2	3 21 25 73405 0	1949203-5	3 21 40 73400 0
1949203-3	3 21 40 73405 0	-	-
-	-	-	-

WIRE SIZE	CRIMP HEIGHT *	REF SETTING *
0.35mm² △8	0.84 ±0.03 [.033 ±.001 IN]	C 7
0.25mm²	0.81 ±0.03 [.032 ±.001 IN]	C 8
0.22mm² or 24AWG	0.78 ±0.03 [.031 ±.001 IN]	D 1
0.14mm² or 26AWG	0.73 ±0.03 [.029 ±.001 IN]	D 5
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

△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.

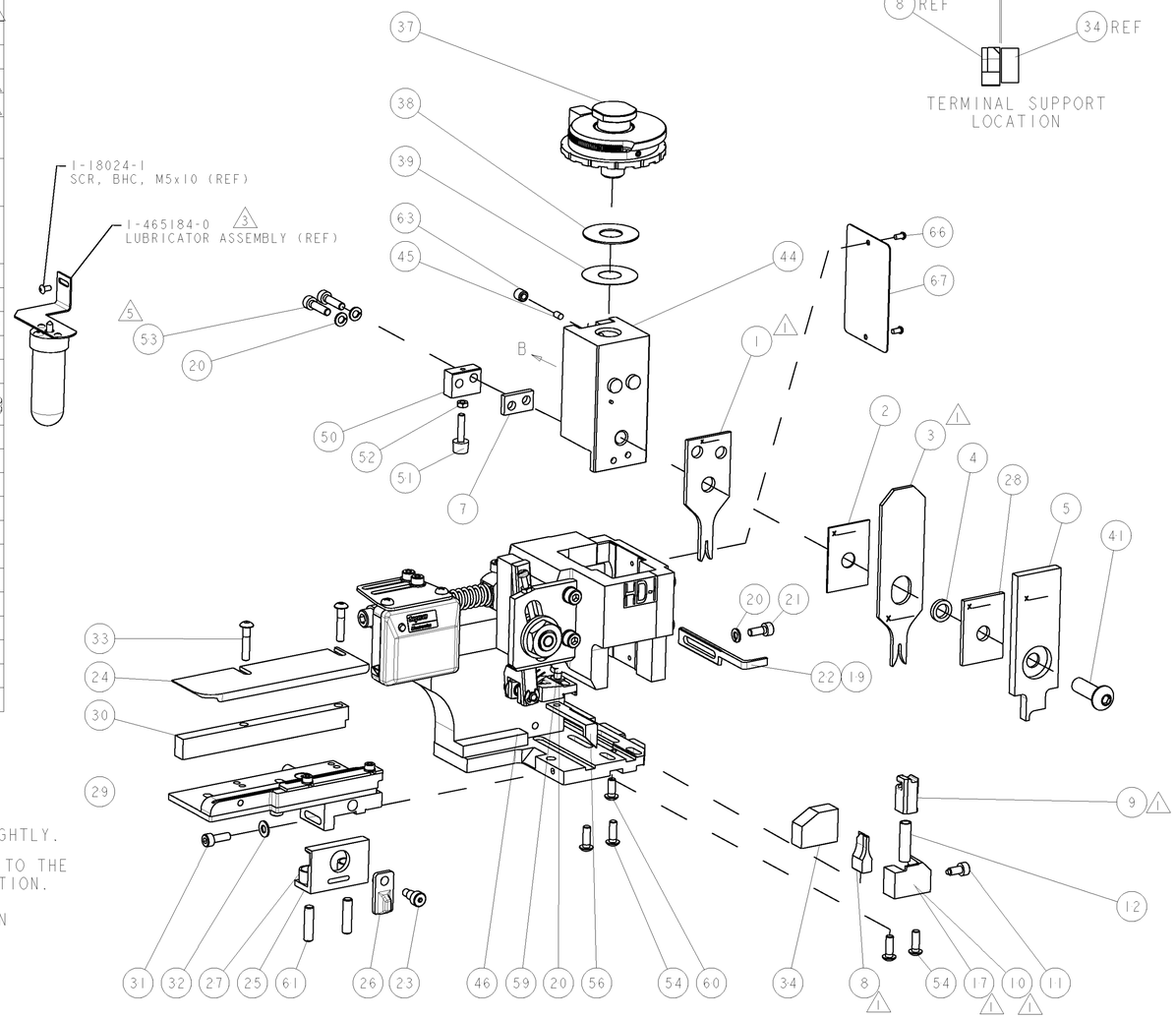
4. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

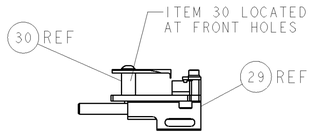
△5 CUT TO LENGTH AT ASSEMBLY.

△6 CRIMP DATA SUPPLIED BY TERMINAL MANUFACTURER.

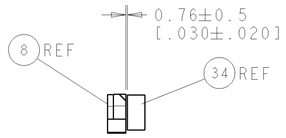
△7 SEE KOSTAL CRIMP SPECIFICATION SHT MLK1.2m FOR FLRY TYPE WIRE, OR CRIMP SPECIFICATION SHT. MLK1.2m FOR AWG TYPE WIRE FOR APPROPRIATE INSULATION RANGES.

△8 WIRE RANGE SHOWN IS THAT OF THE TERMINAL, SEE KOSTAL CRIMP SPECIFICATION SHEET FOR EXTENDED RANGE.





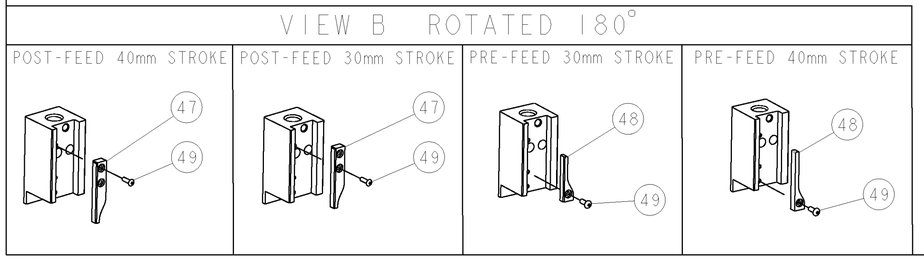
FEED TRACK POSITION GUIDE BY WIRE BARREL



TERMINAL SUPPORT LOCATION

* 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.

VIEW B ROTATED 180°



ITEM NO	PART NO	DESCRIPTION	-77	-76	-72	-71	-6	-2	-1
84	-	-	-	-	-	-	-	-	-
83	-	-	-	-	-	-	-	-	-
82	-	-	-	-	-	-	-	-	-
81	-	-	-	-	-	-	-	-	-
80	-	-	-	-	-	-	-	-	-
79	-	-	-	-	-	-	-	-	-
78	-	-	-	-	-	-	-	-	-
77	-	-	-	-	-	-	-	-	-
76	-	-	-	-	-	-	-	-	-
75	-	-	-	-	-	-	-	-	-
74	-	-	-	-	-	-	-	-	-
73	-	-	-	-	-	-	-	-	-
72	-	-	-	-	-	-	-	-	-
71	1338705-3	DOCUMENTATION PACKAGE	-	1	1	1	1	1	1
70	-	-	-	-	-	-	-	-	-
69	-	-	-	-	-	-	-	-	-
68	-	-	-	-	-	-	-	-	-
67	461264-5	PLATE, IDENTIFICATION	-	1	1	1	1	1	1
66	21017-2	SCREW, DRIVE	-	2	2	2	2	2	2
65	-	-	-	-	-	-	-	-	-
64	-	-	-	-	-	-	-	-	-
63	3-18031-0	SCR, SET, CUP POINT M6 X 6.0	-	1	1	1	1	1	1
62	-	-	-	-	-	-	-	-	-
61	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	-	2	2	2	2	2	2
60	18024-7	SCR, BTN SKT HD CAP (M4 X 10.0)	-	1	1	1	1	1	1
59	5-18022-2	SCR, HEX HD CAP M4 X 8.0	-	1	1	1	1	1	1
58	-	-	-	-	-	-	-	-	-
57	-	-	-	-	-	-	-	-	-
56	1338685-1	PAWL, FEED	-	1	1	1	1	1	1
55	-	-	-	-	-	-	-	-	-
54	18024-8	SCR, BTN SKT HD CAP (M4 X 12.0)	-	4	4	4	4	4	4
53 △5	1-18023-3	SCR, SKT HD CAP M4 X 16.0	-	2	2	2	2	2	2
52	18030-1	NUT, HEX, REG M3	-	1	1	1	1	1	1
51	811242-5	BUMPER, HOLD DOWN	-	1	1	1	1	1	1
50	690753-2	SPACER, TONKER	-	1	1	1	1	1	1
49	18024-3	SCR, BTN SKT HD CAP (M3 X 10.0)	-	1	1	1	1	1	1
48	1338675-1	CAM, UNIVERSAL PRE FEED	-	1	-	-	1	-	1
47	1338676-1	CAM, UNIVERSAL POST-FEED	-	1	-	1	1	-	1
46	1320999-3	APPLICATOR SUBASSEMBLY, HDI	-	1	1	1	1	1	1
45	690191-1	PLUG,NYLON	-	1	1	1	1	1	1
44	1338660-1	RAM	-	1	1	1	1	1	1
43	-	-	-	-	-	-	-	-	-
42	-	-	-	-	-	-	-	-	-
41	2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)	-	1	1	1	1	1	1
40	-	-	-	-	-	-	-	-	-
39	690125-1	SHIM SUB-ASSY	-	1	1	1	1	1	1
38	469367-8	SHIM	-	1	1	1	1	1	1
37	879103-3	FINE ADJUST HEAD ASSEMBLY	-	1	1	1	1	1	1
36	-	-	-	-	-	-	-	-	-
35	-	-	-	-	-	-	-	-	-
34	2-1320934-5	SUPPORT, TERMINAL	-	1	1	1	1	1	1
33	1-18024-0	SCR, BTN SKT HD CAP (M4 X 20.0)	-	2	2	2	2	2	2
32	18027-2	WASHER, FLAT, REG M4	-	1	1	1	1	1	1
31	1-18023-2	SCR, SKT HD CAP M4 X 12.0	-	1	1	1	1	1	1
30	1320908-4	SPACER, STRIP GUIDE	-	1	1	1	1	1	1
29	1-1633073-3	STRIP GUIDE ASSEMBLY	-	1	1	1	1	1	1
28	2-455888-2	SPACER, CRIMPER	-	1	1	1	1	1	1
27	1-22284-0	SPRING, COMPRESSION	-	2	2	2	2	2	2
26	356835-1	LEVER, DRAG RELEASE	-	1	1	1	1	1	1
25	240792-1	DRAG, TERMINAL	-	1	1	1	1	1	1
24	1320928-1	PLATE, STRIP GUIDE	-	1	1	1	1	1	1
23	98037I-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	-	1	1	1	1	1	1
22	690472-2	STRIPPER	-	1	-	1	1	-	1
21	1-18023-1	SCR, SKT HD CAP M4 X 10.0	-	1	1	1	1	1	1
20	18025-2	WASHER, SPRG LOCK, REG M4	-	4	4	4	4	4	4
19	690472-1	STRIPPER	-	-	1	-	-	1	-
18	-	-	-	-	-	-	-	-	-
17 △1	1338684-1	SHEAR HOLDER, FRONT	-	1	-	1	-	-	1
16	-	-	-	-	-	-	-	-	-
15	-	-	-	-	-	-	-	-	-
14	-	-	-	-	-	-	-	-	-
13	-	-	-	-	-	-	-	-	-
12	3-22280-3	SPRING, COMPRESSION	-	1	1	1	1	1	1
11	356885-4	STOP, SHEAR	-	1	1	1	1	1	1
10 △1	1320921-1	SHEAR HOLDER, FRONT, CUT	-	-	1	1	-	1	1
9 △1	217234-1	FLOATING SHEAR, FRONT	-	1	1	1	1	1	1
8 △1	2-1633138-5	ANVIL, COMBINATION	1	2	2	2	1	1	1
7	240641-5	SPACER	-	1	1	1	1	1	1
6	-	-	-	-	-	-	-	-	-
5	1-455889-4	DEPRESSOR, SHEAR	-	1	1	1	1	1	1
4	1-238011-0	BLOCK, CRIMPER SPACER	-	1	1	1	1	1	1
3 △1	4-904741-3	CRIMPER, INSUL O PREMIUM	1	2	2	2	1	1	1
2	455888-7	SPACER, CRIMPER	-	1	1	1	1	1	1
1 △1	5-568176-2	CRIMPER, WIRE	1	2	2	2	1	1	1
ITEM NO	PART NO	DESCRIPTION	-77	-76	-72	-71	-6	-2	-1

SET UP GAGE 458637-3

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	SEE ECO-06-029320	14DEC2006	LJL	MC
	A1	SEE ECR-07-019624	06SEP2007	LJL	MC

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Tyco Electronics
Harrisburg, PA 17105-3608

DWN 09NOV2006 L LOFTHOUSE
CHK -
APVD 09NOV2006 M CLIFFORD
PRODUCT SPEC -
APPLICATION SPEC See Table
WEIGHT -

NAME FINE ADJUST SIDE FEED HDI APPLICATOR

SIZE A1 | CAGE CODE 00779 | DRAWING NO C-1528736 | RESTRICTED TO -

CUSTOMER DRAWING | SCALE 3:5 | SHEET 1 OF 1 | REV A1

DIMENSIONS: mm [IN]
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±, 1 PLC ±, 2 PLC ±, 3 PLC ±, 4 PLC ±, ANGLES ±
MATERIAL -
FINISH -

AMP 4805 REV 31MAR2000

Pro/ENGINEER DRAWING