

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339785-1	A		BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1339785-1	A		BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339785-7	A		-	-	SPARE PARTS KIT

CRIMP DATA JST TERMINAL AMP CRIMP SPECS

CRIMP	SIZE	TYPE	RANGE
WIRE	2.54 [1.00 IN]	F	0.50mm ² -2.00mm ² (20-14 AWG)
INSUL	4.57 [1.80 IN]	F	2.60-3.80 [1.02-.150 IN]

WIRE STRIP LENGTH: 4.29-5.05 [1.169-.199 IN]

APPL INSTRUCTION: 408-8323

TERMINAL APPL SPEC: NONE

FEED: 19.50 [1.768 IN]

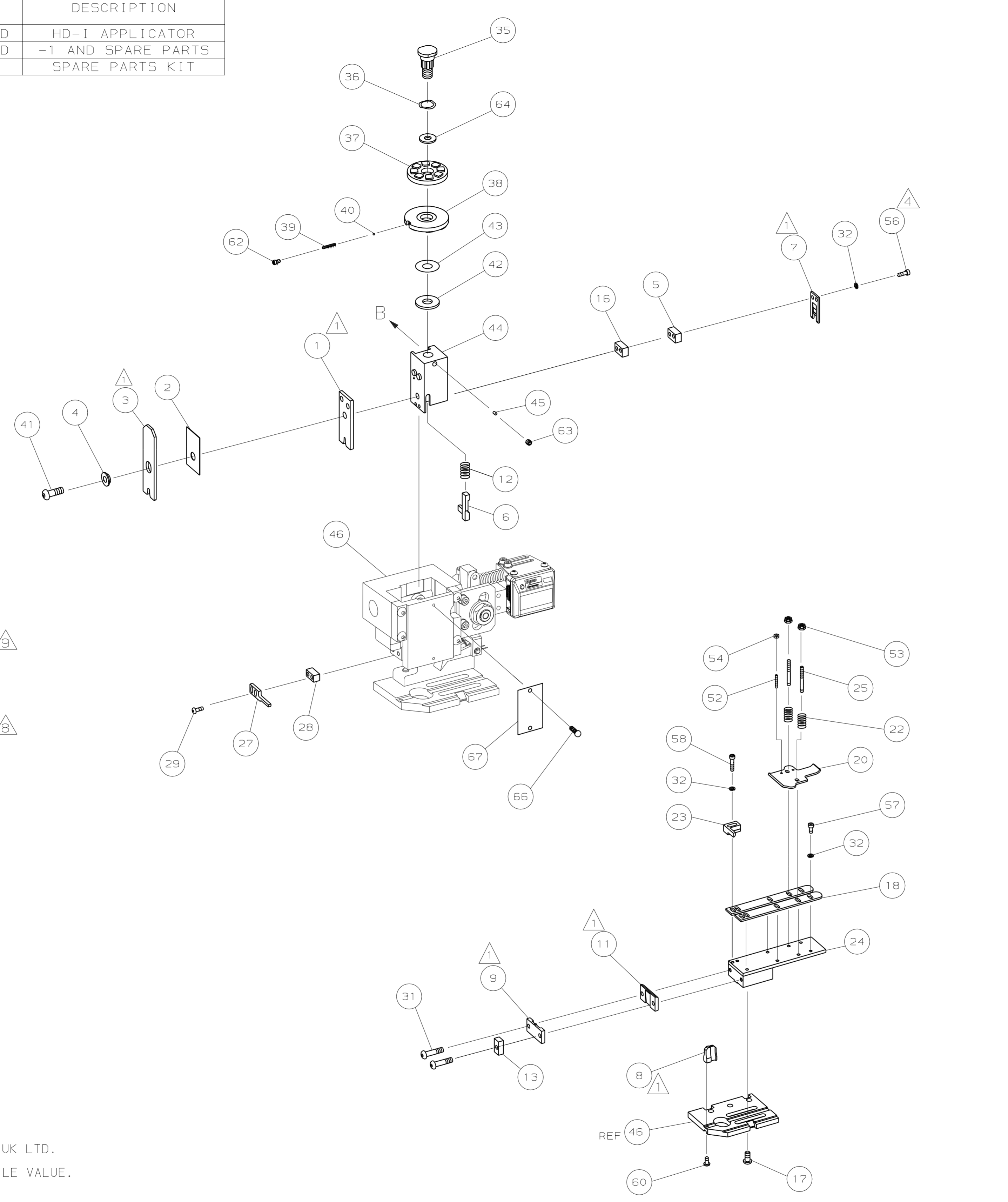
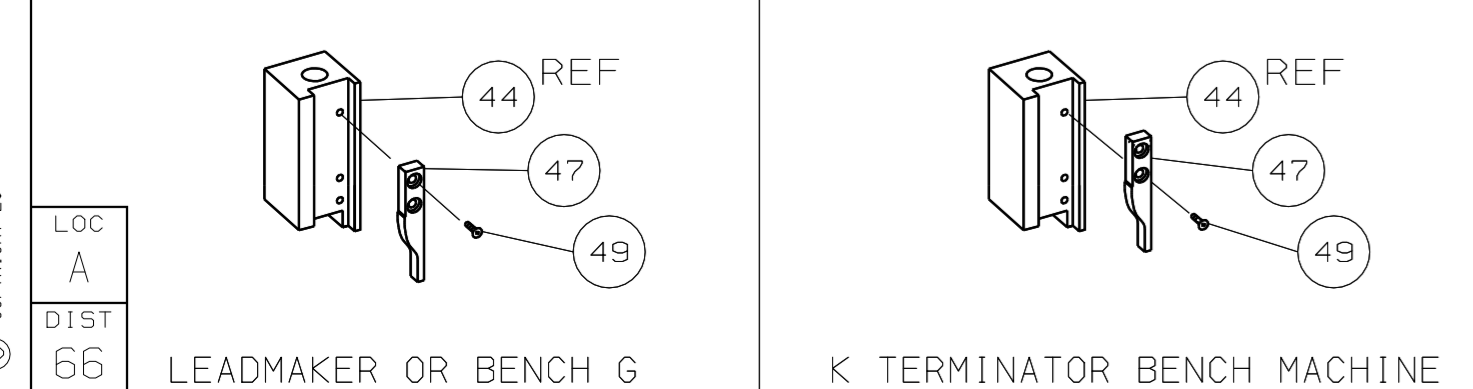
TERMINALS APPLIED

AMP PN	MFR PN	-	-	-
1572820-1	SGF-51-5	-	-	-
1572820-2	SGF-51T-5	-	-	-
1572820-3	SGF-51-5A	-	-	-

WIRE SIZE	CRIMP HEIGHT	PIN PN AND LENGTH [IN]
mm ² AWG	mm	
2.00mm ²	1.85 ±0.05 [0.073 ±0.002 IN]	8-354778-0 [1.2895]
1.50mm ²	1.75 ±0.05 [0.069 ±0.002 IN]	8-354778-8 [1.2935]
1.00mm ²	1.58 ±0.05 [0.062 ±0.002 IN]	354779-5 [1.3015]
0.75mm ²	1.50 ±0.05 [0.059 ±0.002 IN]	1-354779-2 [1.3050]
0.50mm ²	1.45 ±0.05 [0.057 ±0.002 IN]	1-354779-6 [1.3070]

- RECOMMENDED SPARE PARTS.
- GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
 - LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- CUT TO LENGTH AT ASSEMBLY.
- ALL CRIMP DATA CALCULATED BY TYCO ELECTRONICS UK LTD.
- FEED OFF TERMINAL BODY.
- WIRE RANGE SHOWN IS THAT OF THE TERMINAL.
- 0.5MM² WIRE SIZE IS NOT RECOMMENDED BY TYCO ELECTRONICS UK LTD.
- 2.00MM² WIRE SIZE DOES NOT MEET TYCO STANDARDS FOR TENSILE VALUE.

VIEW B ROTATED 180°



QTY	REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO		
-	1	1	1339785	PRINT, APPLICATOR LOG SHEET	73	
-	1	1	1338705-2	DOCUMENTATION PACKAGE	72	
-					70	
-					68	
-	1	1	461264-1	PLATE, IDENTIFICATION	67	
-	2	2	21017-2	SCR,DRIVE (#2X.19) ID PLATE	66	
-					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	
-					61	
-	1	1	18024-7	SCR,BHC (M4X10) ANVIL	60	
-					59	
-	2	2	1-18023-4	SCR,SHC (M4X20) HOLD DOWN	58	
-	5	5	1-18023-0	SCR,SHC (M4X8) STRIP GUIDE	57	
-	2	2	9-18023-6	SCR,SHC (M4X14) 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	1338662-1	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	1320922-1	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	
-	9	9	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	3-690451-2	SPACER, STRIPPER	28	
-	1	1	240639-1	STRIPPER	27	
-					26	
-	2	2	1320906-1	DRAG, STUD	25	
-	1	1	1320995-1	PLATE, STRIP GUIDE	24	
-	1	1	240825-9	PLATE, STRIP HOLD DOWN	23	
-	2	2	4-22281-1	SPRING, DRAG	22	
-					21	
-	1	1	1338665-1	DRAG, STOCK	20	
-					19	
-	2	2	1338663-8	GUIDE, LOWER STRIP	18	
-	4	4	1-18024-8	SCR,BHC (M6X12) STRIP GD PL	17	
-	1	1	1338708-1	SPACER, SLUG BLADE	16	
-					15	
-					14	
-	1	1	690481-7	SPACER, HOLD DOWN	13	
-	1	1	23846-1	SPRING, HOLD DOWN	12	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-					10	
-	1	1	690482-4	PLATE, FRONT SHEAR	9	
-	1	2	2-1333218-3	ANVIL	8	
-	1	1	690474-4	BLADE, SLUG	7	
-	1	1	455892-8	HOLD DOWN, TERMINAL	6	
-	1	1	3-240641-0	SPACER, SLUG BLADE	5	
-	1	1	238009-1	SPACER, BLOCK CRIMPER	4	
-	1	2	3-1424909-0	CRIMPER, INSULATION	3	
-	1	1	455888-9	SPACER, CRIMPER	2	
-	1	2	1	456407-5	CRIMPER, WIRE	1
-	-77	-71	-1			

QTY REQD PER ASSY	PARTS LIST
	MATL: - HT TR: - FIN: -

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

DR: 040CT05

F: BACKHURST

REL: 17NOV05

L: LOFTHOUSE

AMP Tyco Electronics Harrisburg, PA 17105-3608

NAME: END FEED HD-I APPLICATOR

MACHINE REF: HD-I APPL

SCALE: -

DWG NO: 1339785

SHEET 1 OF 1

REV: A

CAGE CODE: 00779

CUSTOMER AND ASSEMBLY DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT.

LAYOUT L1339785

SET UP GAGE 458638-3

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LOC A

DIST 66

AMP 1756 REV 3-92