DRAWING MADE IN THIRD ANGLE PROJECTION

1339771 ⇔ 1339771

/home/eb003653/edmmod

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339771-1	A	-	BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1339771-1	A	-	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339771-7	A	-	-	-	SPARE PARTS KIT

CRIMP DATA TYCO TERMINAL TYCO [UTILUX] CRIMP SPECS

TERMINAL NAME: RECEPTACLE, QC6.3 PIVOT LOCK

CRIMP	SIZE	TYPE	RANGE
WIRE	3.05 [.120 IN]	F	1.00-1.50mm²
INSUL	3.94 [.155 IN]	F	2.60-3.00 [.102-.118 IN] △7

WIRE STRIP LENGTH 5.50 [.217 IN]

APPL INSTRUCTION 408-8323

TERMINAL - -
APPL SPEC 114-3118 △4 -

FEED 22.10 [.870 IN]

TERMINALS APPLIED

1-1627095-0	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-

WIRE SIZE mm² AWG	CRIMP HEIGHT △5	PIN PN AND LENGTH [IN]
1.50mm²	1.65 ±0.05 [.065 ±.002 IN]	5-354778-9 [.2790]
1.30mm²	1.60 ±0.05 [.063 ±.002 IN]	6-354778-3 [.2810]
1.00mm²	1.50 ±0.05 [.059 ±.002 IN]	7-354778-1 [.2850]
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

△1 RECOMMENDED SPARE PARTS.

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

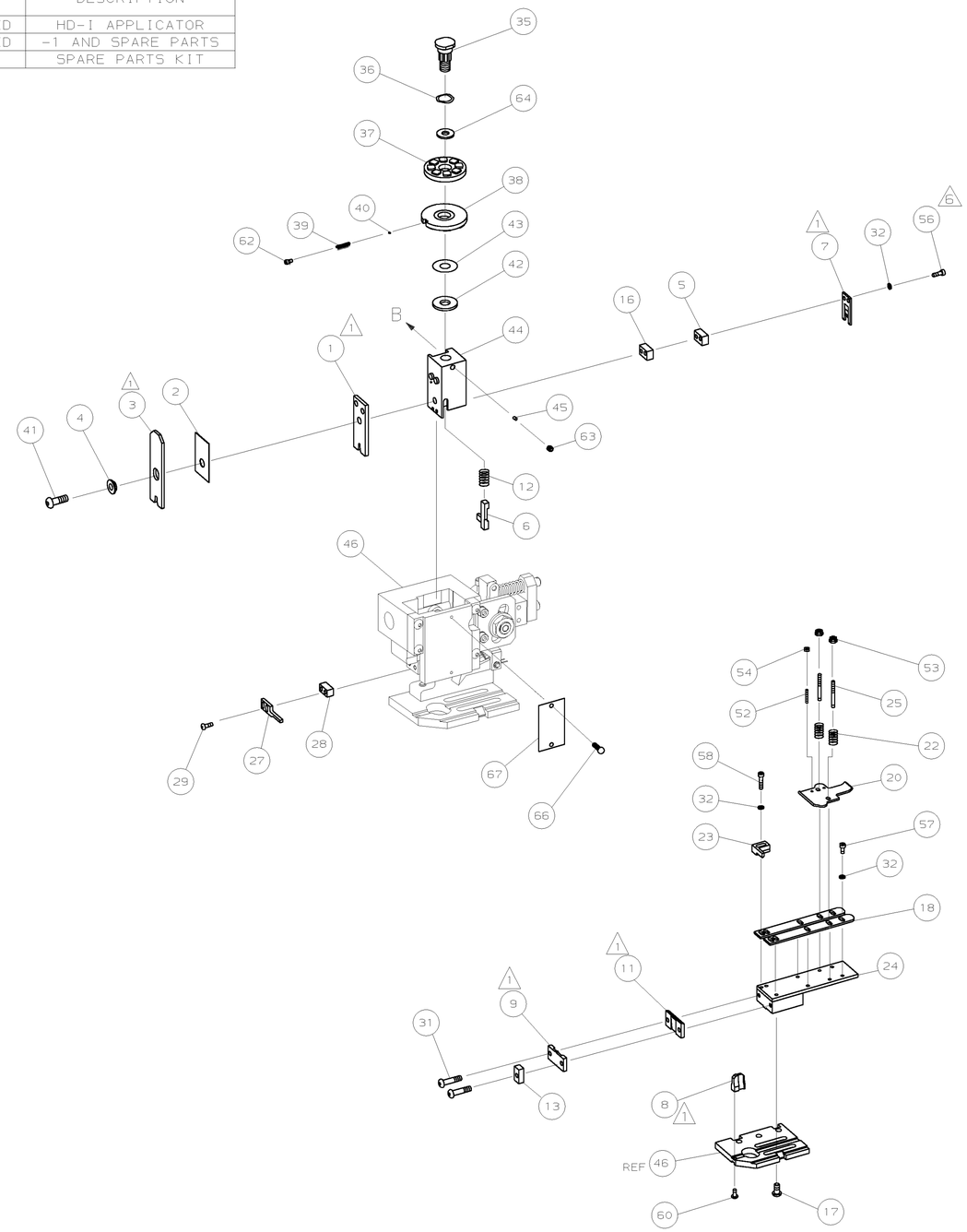
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

△4 CRIMP TENSILES VALUES TO EXCEED;
1.50mm² = 200N
1.30mm² = 190N
1.00mm² = 160N

△5 TYCO ELECTRONICS UK LTD RECOMMENDED CRIMP HEIGHTS.

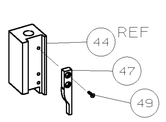
△6 CUT TO LENGTH AT ASSEMBLY.

△7 MIN INSULATION CRIMP HEIGHT 3.70 [.146 IN] TO PREVENT PIERCING OF INSULATION COATING.



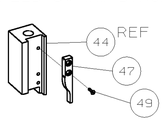
VIEW B ROTATED 180°

POST-FEED 40 mm STROKE



LEADMAKER OR BENCH G

POST-FEED 30 mm STROKE



K TERMINATOR BENCH MACHINE

						ITEM NO
						73
-	1	1	1339771	PRINT, APPLICATOR LOG SHEET		72
-	1	1	1338705-2	DOCUMENTATION PACKAGE		71
						70
						69
						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	1-18023-3	SCR,SHC(M4X16)HOLD DOWN		58
-	5	5	1-18023-0	SCR,SHC(M4X8)STRIP GUIDE		57
-	2	2	1-18023-3	SCR,SHC(M4X16)SLUG BLADE	△6	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	690124-4	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	240825-1	PLATE, STRIP HOLD DOWN		23
-	2	2	4-22281-1	SPRING, DRAG		22
						21
-	1	1	1338665-1	DRAG, STOCK		20
						19
-	2	2	1338663-6	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	690481-2	SPACER, HOLD DOWN		13
-	1	1	23846-1	SPRING, HOLD DOWN		12
-	1	1	240644-1	PLATE, REAR SHEAR	△1	11
						10
-	1	1	690482-3	PLATE, FRONT SHEAR	△1	9
1	2	1	2-1333220-5	ANVIL	△1	8
-	1	1	690474-3	BLADE, SLUG	△1	7
-	1	1	455892-1	HOLD DOWN, TERMINAL		6
-	1	1	3-240641-2	SPACER, SLUG BLADE		5
-	1	1	238009-1	SPACER, BLOCK CRIMPER		4
1	2	1	3-456134-6	CRIMPER, INSULATION	△1	3
-	1	1	455888-7	SPACER, CRIMPER		2
1	2	1	1-456409-2	CRIMPER, WIRE	△1	1
	-77	-71	-1	PART NO	DESCRIPTION	ITEM NO

← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

QTY REQD PER ASSY — PARTS LIST

P	F	LTR	REVISION RECORD	APP	DATE
		A	SEE ECR-05-005147	LJL	JUL05

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 R0.38 MAX

MATL - HT TR - FIN -
- - -

DR 09JUN05 M.CLIFFORD APP 09JUN05 F.BACKHURST
CHK - - REL 07JUL05 L.LOFTHOUSE

AMP Tyco Electronics Harrisburg, PA 17105-3608

NAME END FEED HD-I APPLICATOR
MACHINE REF HD-I APPL
SCALE - D DWG NO 1339771 SHEET 1 OF 1 REV A

CAGE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO -

LOC A DIST 66

LAYOUT L1339771

SET UP GAGE 458638-3

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