PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339580-1	A	-	BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1339580-1	A	-	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339580-7	A	-	-	-	SPARE PARTS KIT

CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: .250 SERIES POS-LOK REC. CONTACT

CRIMP	SIZE	TYPE	RANGE
WIRE	2.03 [.080 IN]	F	0.50-1.00mm²
INSUL	2.79 [.110 IN]	F	1.40-2.30 [.055-.090 IN]

WIRE STRIP LENGTH 4.60-5.40 [.181-.212 IN]

APPL INSTRUCTION 408-8323

TERMINAL - - FEED
APPL SPEC 114-19023 - 23.90 [.941 IN]

TERMINALS APPLIED

216329	-	-	-	-
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-	-	-	-	-
-	-	-	-	-
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-	-	-	-	-
-	-	-	-	-

WIRE SIZE mm² AWG	CRIMP HEIGHT	PIN PN AND LENGTH [IN]
1.00mm²	1.61 ±0.05 [.063 ±.002 IN]	9-354778-7 [.2980]
0.75mm²	1.52 ±0.05 [.060 ±.002 IN]	354779-5 [.3015]
0.50mm²	1.43 ±0.05 [.056 ±.002 IN]	1-354779-4 [.3060]
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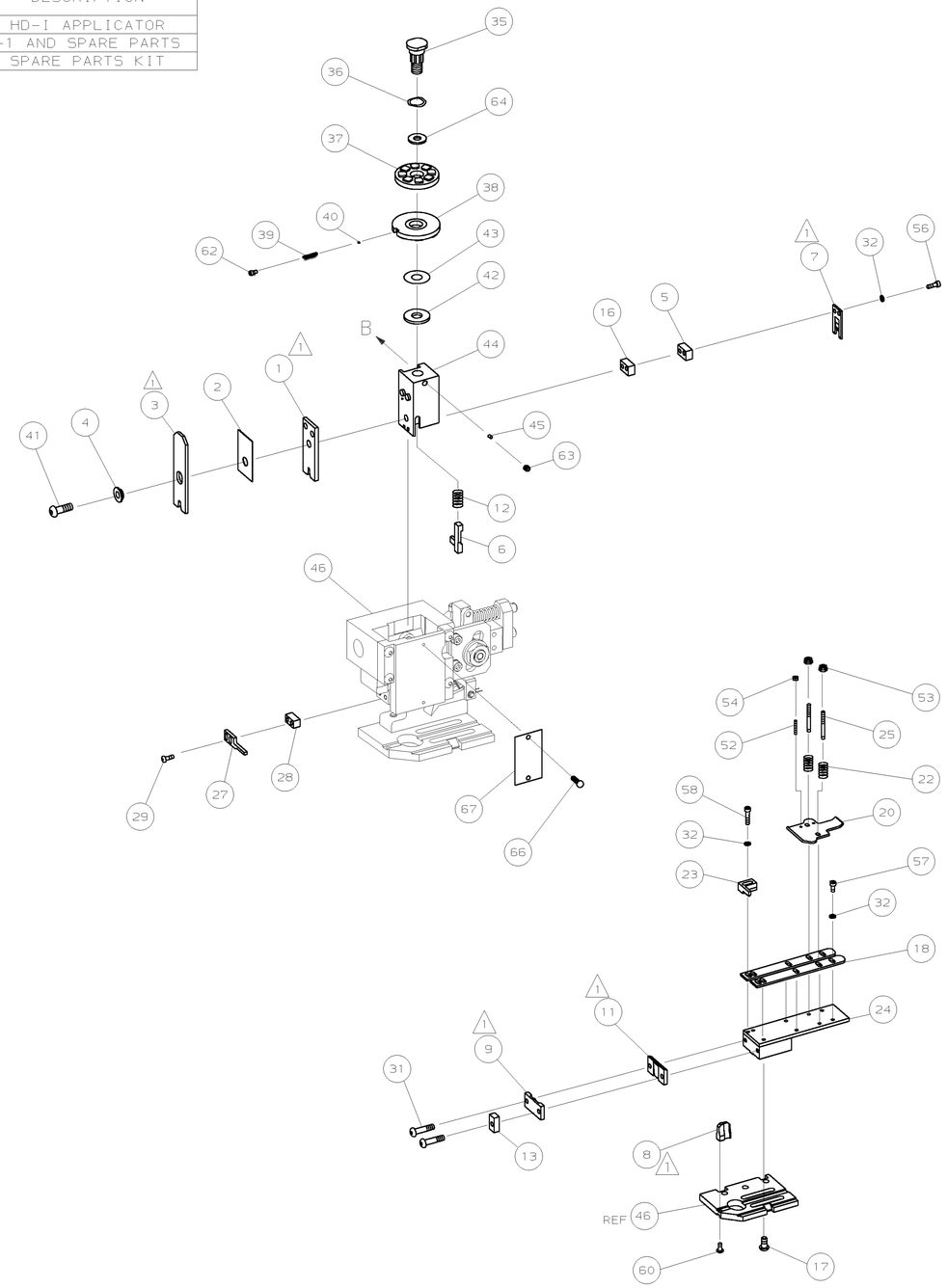
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

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.



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-	1	1	1339580	PRINT, APPLICATOR LOG SHEET	72
-	1	1	1338705-2	DOCUMENTATION PACKAGE	71
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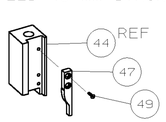
-	1	1	461264-1	PLATE, IDENTIFICATION	67
-	2	2	21017-2	SCR,DRIVE(#2X.19)ID PLATE	66
					65
-	1	1	986950-1	WASHER, FLAT PRECISION	64
-	1	1	3-18031-0	SCR,SKT SET(M6X6)RAM	63
-	1	1	18023-9	SCR,SKT CAP(M4X6)CP DSC	62
					61
-	1	1	18024-7	SCR,BHC(M4X10)ANVIL	60
					59
-	2	2	1-18023-3	SCR,SHC(M4X16)HOLD DOWN	58
-	5	5	18023-9	SCR,SHC(M4X6)STRIP GUIDE	57
-	2	2	1-18023-3	SCR,SHC(M4X16)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	1-1320922-2	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	4-18024-7	SCR,BHC(M4X25)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	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	1-690481-0	SPACER, HOLD DOWN	13
-	1	1	23846-1	SPRING, HOLD DOWN	12
1 -	1	1	240833-1	PLATE, REAR SHEAR	11
					10
1 -	1	1	690482-3	PLATE, FRONT SHEAR	9
1 1	2	1	1333216-7	ANVIL	8
1 -	1	1	690474-3	BLADE, SLUG	7
-	1	1	1-455892-4	HOLD DOWN, TERMINAL	6
-	1	1	6-240641-8	SPACER, SLUG BLADE	5
-	1	1	238009-1	SPACER, BLOCK CRIMPER	4
1 1	2	1	1-456134-5	CRIMPER, INSULATION	3
-	1	1	455888-8	SPACER, CRIMPER	2
1 1	2	1	2-456405-4	CRIMPER, WIRE	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

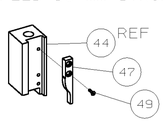
VIEW B ROTATED 180°

POST-FEED 40 mm STROKE



LEADMAKER OR BENCH G

POST-FEED 30 mm STROKE



K TERMINATOR BENCH MACHINE

P	F	LTR	REVISION RECORD	APP	DATE
		A	SEE ECN 015A-0769-01	MC	SEP01

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

MATL	HT TR	FIN
-	-	-
-	-	-

DR 20AUG01 M.CLIFFORD | APP 20AUG01 F.BACKHURST
CHK - - | REL 17-09-01 M.CLIFFORD

AMP Incorporated Harrisburg, PA 17105-3608

NAME END FEED HD-I APPLICATOR | MACHINE REF HD-I APPL

SCALE - | D | DWG NO 1339580 | SHEET 1 OF 1 | REV A

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO -

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LAYOUT L1339580
SET UP GAGE 458638-3
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LOC A
DIST 66