

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339651-1	B		BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1339651-1	B		BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339651-7	A		-	-	SPARE PARTS KIT

D

CRIMP DATA AMP TERMINAL AMP CRIMP SPECS			
TERMINAL NAME: RING TONGUE WITH INSULATION SUPPORT			
CRIMP	SIZE	TYPE	RANGE
WIRE	4.57 [.180 IN]	F	12-10 AWG △5
INSUL	6.10 [.240 IN]	F	3.80-5.35 [.150-.210 IN]
WIRE STRIP LENGTH		APPL INSTRUCTION	
5.80-6.60 [.228-.260 IN]		408-8323	
TERMINAL APPL SPEC	-	-	FEED 27.80 [1.095 IN]
TERMINALS APPLIED			
280261	-	-	-
280267	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-
WIRE SIZE mm ² AWG	CRIMP HEIGHT	PIN PN AND LENGTH [IN]	
6.00mm ² △6	3.20 ±0.05 [.126 ±.002 IN]	2-354778-5 [.2620]	
4.00mm ² △7	3.00 ±0.05 [.118 ±.002 IN]	4-354778-1 [.2700]	
-	-	-	
-	-	-	
-	-	-	
-	-	-	
-	-	-	
-	-	-	
-	-	-	
-	-	-	
-	-	-	
-	-	-	
-	-	-	
-	-	-	
-	-	-	
SET UP GAGE 458638-3	LAYOUT L1339651		

-
- 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

CUT TO LENGTH AT ASSY.

5

WIRE RANGE QUOTED IS THAT OF THE TERMINAL, NOT THE APPLICATOR.

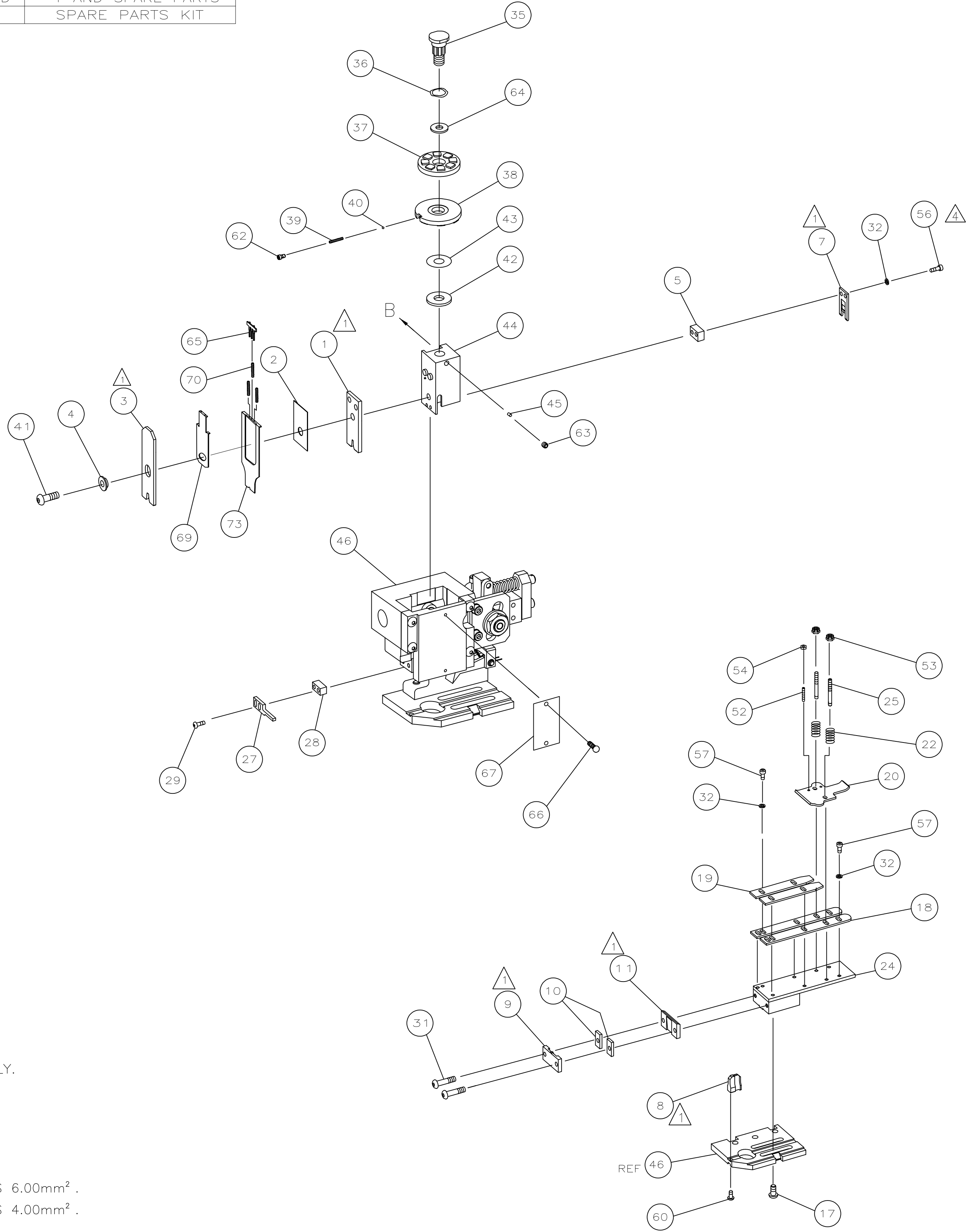
6

WIRE SIZE 5.00mm² TO BE USED AT SAME CRIMP HEIGHT AS 6.00mm².

7

WIRE SIZE 3.00mm² TO BE USED AT SAME CRIMP HEIGHT AS 4.00mm².

VIEW B ROTATED 180°	
POST-FEED 40 mm STROKE	POST-FEED 30 mm STROKE
LEADMAKER OR BENCH G	K TERMINATOR BENCH MACHINE



LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
			B	ECR-07-010186	5-2007	MY	TE

	-	1	1	1490525-2	DEPRESSOR, WIRE	73
	-	1	1	1339651	PRINT, APPLICATOR LOG SHEET	72
	-	1	1	1338705-2	DOCUMENTATION PACKAGE	71
	-	3	3	2-23147-2	SPRING, DEPRESSOR	70
	-	1	1	1490524-2	SPACER, DEPRESSOR	69
						68
	-	1	1	461264-1	PLATE, IDENTIFICATION	67
	-	2	2	21017-2	SCR,DRIVE(#2X.19)ID PLATE	66
	-	1	1	1424350-1	HOLDER, PIN, WIRED	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
						58
	-	6	6	1-18023-0	SCR,SHC(M4X8)STRIP GUIDE	57
	-	2	2	1-18023-4	SCR,SHC(M4X20)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	1338662-2	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
	-	8	8	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	STRIP GUIDE	24
						23
	-	2	2	4-22281-1	SPRING, DRAG	22
						21
	-	1	1	1338665-1	DRAG, STOCK	20
	-	2	2	1338664-1	GUIDE, UPPER STRIP	19
	-	2	2	1338663-8	GUIDE, LOWER STRIP	18
	-	4	4	1-18024-8	SCR,BHC(M6X12)STRIP GD PL	17
						16
						15
						14
						13
						12
	-	1	1	240644-1	PLATE, REAR SHEAR	11
	-	2	2	1-240645-4	SPACER, SHEAR PLATE	10
	-	1	1	240642-1	PLATE, FRONT SHEAR	9
	1	2	1	1-1333223-1	ANVIL	8
	-	1	1	1-240651-8	BLADE, SLUG	7
						6
	-	1	1	5-240641-3	SPACER, SLUG BLADE	5
	-	1	1	238009-3	SPACER, BLOCK CRIMPER	4
	1	2	1	1-1424909-6	CRIMPER, INSULATION	3
	-	1	1	455888-3	SPACER, CRIMPER	2
1	1	2	1	456412-7	CRIMPER, WIRE	1

QTY REQD PER ASSY		PARTS LIST			
THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN M. CLIFFORD 25JUN02	Tyco Electronics Corporation		
		CHK -	Harrisburg, PA 17105-3608		
DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD F. BACKHURST 25JUN02	NAME	
			PRODUCT SPEC	END FEED HD-I APPLICATOR	
		0 PLC ± - 1 PLC ± - 2 PLC ± - 3 PLC ± - 4 PLC ± - ANGLES ± -	APPLICATION SPEC	-	
			WEIGHT	-	
MATERIAL -		FINISH -	SIZE A1	CAGE CODE 00779	DRAWING NO 1339651
CUSTOMER DRAWING			SCALE -	SHEET 1	OF 1 REV