

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339754-1	A	-	BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1339754-1	A	-	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339754-7	A	-	-	-	SPARE PARTS KIT

**CRIMP DATA** ESCUBEDO TERMINAL AMP CRIMP SPECS

TERMINAL NAME: 6.3 FASTON TAB

CRIMP	SIZE	TYPE	RANGE
WIRE	3.94 [.155 IN]	F	6.00mm <sup>2</sup>
INSUL	5.08 [.200 IN]	F	5.10 MAX [.201 IN MAX]
WIRE STRIP LENGTH	4.85-5.65 [.191-.222 IN]		APPL INSTRUCTION 408-8323

TERMINAL	FEED
APPL SPEC	30.00 [.181 IN]

**TERMINALS APPLIED**

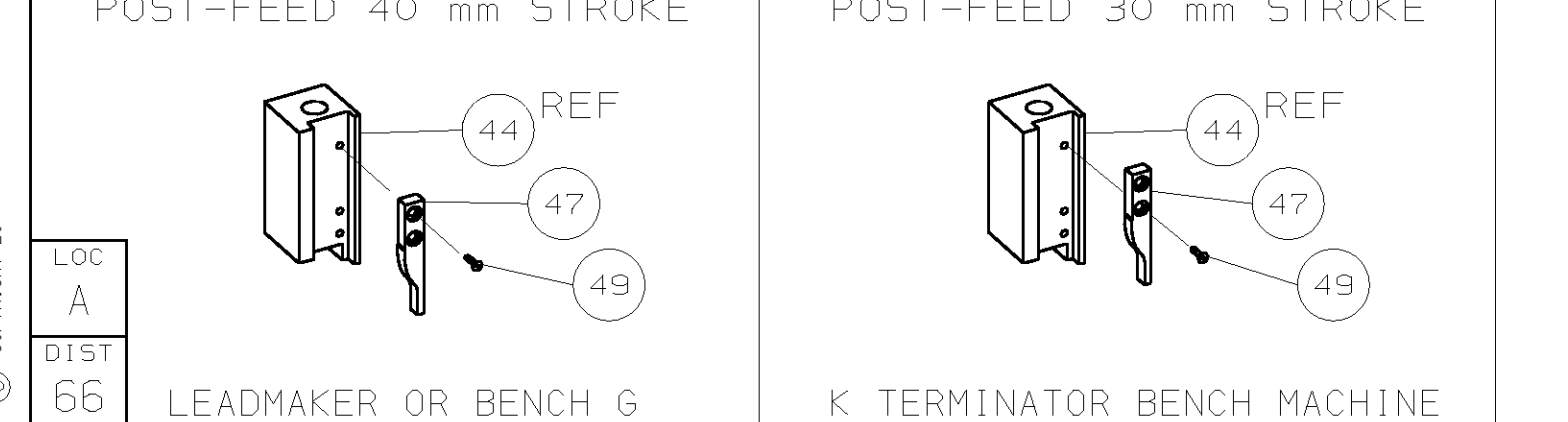
AMP PN	MFR PN	-	-	-
1572586-1	6440.00	-	-	-
1572586-2	6440.01	-	-	-
1572586-3	6440.02	-	-	-
1572586-4	6440.30	-	-	-
1572586-5	6440.31	-	-	-
1572586-6	6440.32	-	-	-

WIRE SIZE	CRIMP HEIGHT	PIN PN AND LENGTH [IN]
6.00mm <sup>2</sup>	2.59 ±0.05 [.102 ±.002 IN]	2-354778-1 [.2600]

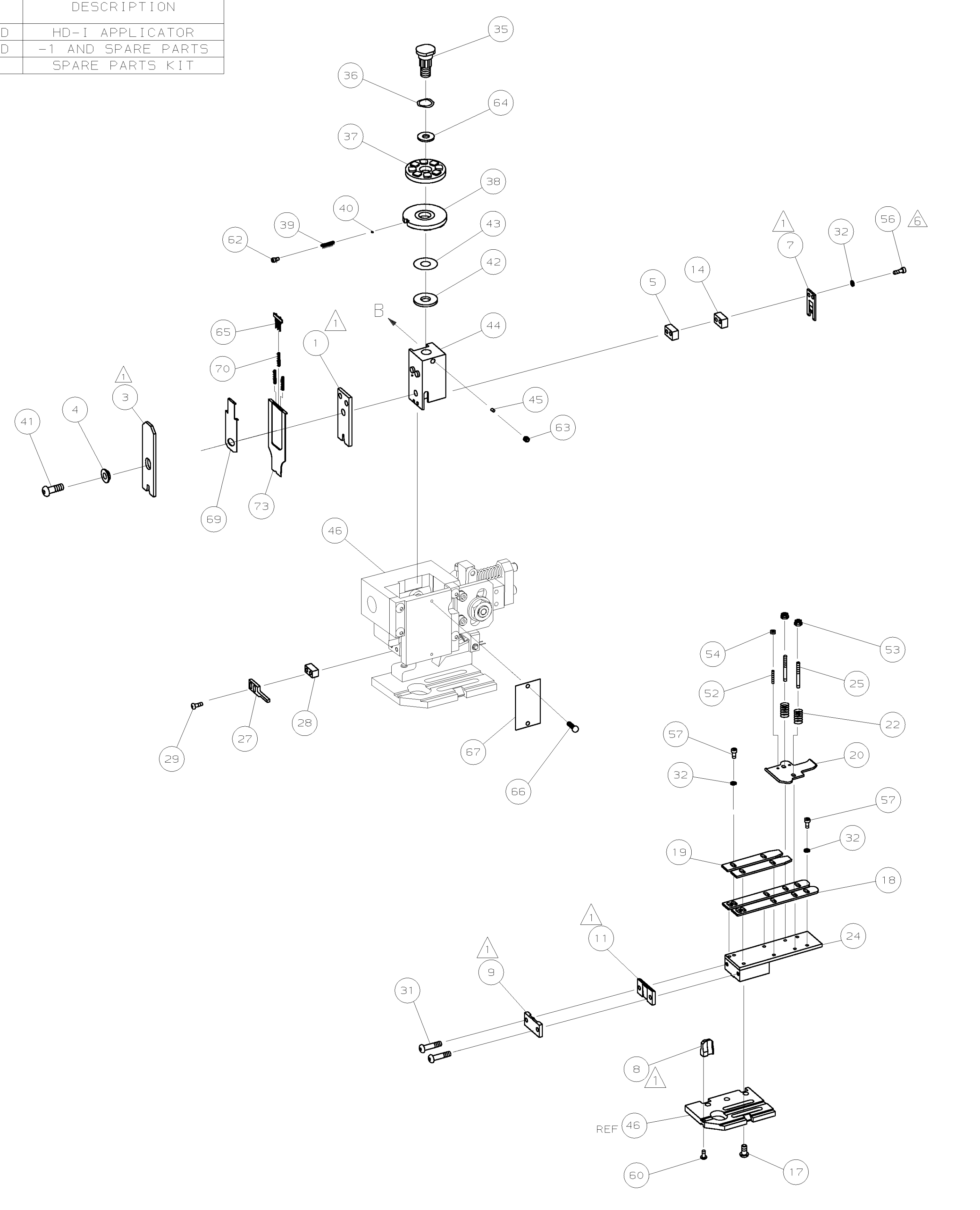
SET UP GAGE	LAYOUT
458638-3	L1339754

- 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. ALL CRIMP DATA CALCULATED BY TYCO ELECTRONICS UK LTD.
- 5. RANGE QUOTED IS THAT OF THE APPLICATOR, NOT THE TERMINAL.
- 6. CUT TO LENGTH AT ASSY.

**VIEW B ROTATED 180°**



LOC A  
D1ST 66  
LEADMAKER OR BENCH G  
K TERMINATOR BENCH MACHINE



QTY	REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO		
-	1	1	1490525-1	DEPRESSOR, WIRE	73	
-	1	1	1339754	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	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 D5C	62	
-	1	1	18024-7	SCR,BHC (M4X10) ANVIL	60	
-	6	6	18023-9	SCR,SHC (M4X6) STRIP GUIDE	57	
-	2	2	1-18023-5	SCR,SHC (M4X25) SLUG BLADE	56	
-	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	
-	1	1	18024-3	SCR,BHC (M3X10) CAM	49	
-	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	
-	8	8	18025-2	WASHER, LOCK (M4) SHEAR BL	32	
-	2	2	1-18024-0	SCR,BHC (M4X20) SHEAR PL	31	
-	2	2	18024-8	SCR,BHC (M4X12) STRIPPER	29	
-	1	1	3-690451-2	SPACER, STRIPPER	28	
-	1	1	240639-1	STRIPPER	27	
-	2	2	1320906-1	DRAG, STUD	25	
-	1	1	1320995-1	PLATE, STRIP GUIDE	24	
-	2	2	4-22281-1	SPRING, DRAG	22	
-	1	1	1338665-1	DRAG, STOCK	20	
-	2	2	1338664-1	GUIDE, UPPER STRIP	19	
-	2	2	1338663-3	GUIDE, LOWER STRIP	18	
-	4	4	1-18024-8	SCR,BHC (M6X12) STRIP 6D PL	17	
-	1	1	2-240641-6	SPACER, SLUG BLADE	14	
-	1	1	240644-1	PLATE, REAR SHEAR	11	
-	1	1	690482-4	PLATE, FRONT SHEAR	9	
-	1	2	1	2-1333223-6	ANVIL	8
-	1	1	690474-4	BLADE, SLUG	7	
-	1	1	240641-2	SPACER, SLUG BLADE	5	
-	1	1	3-238009-3	SPACER, BLOCK CRIMPER	4	
-	1	2	1	6-1213077-0	CRIMPER, INSULATION	3
-	1	2	1	456426-1	CRIMPER, WIRE	1

DR	M. CLIFFORD	APP	F. BACKHURST
CHK	-	REL	M. CLIFFORD
NAME	END FEED HD-I APPLICATOR		
SCALE	DWG NO	1339754	SHEET 1 OF 1
DIMENSIONS: mm [INCHES]		MATL	HT TR
DO NOT SCALE PRINT.		FIN	-
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	15SEP04	APP	15SEP04
CHK	-	REL	08-10-04
Tyco Electronics		Harrisburg, PA 17105-3608	
MACHINE REF		HD-I APPL	
CASE CODE		00779	
CUSTOMER AND ASSEMBLY DRAWING			

THIS DRAWING IS A CONTROLLED DOCUMENT.

LAYOUT L1339754

RELEASED FOR PUBLICATION

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1339754