USED ON —

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339752 – 1	B	–	BENCH & LEADMAKER	MECH POST FEED	HD–I APPLICATOR
7–1339752 – 1	B	–	BENCH & LEADMAKER	MECH POST FEED	–1 AND SPARE PARTS
7–1339752 – 7	B	–	–	–	SPARE PARTS KIT

CRIMP DATA ESCUBEDO TERMINAL AMP CRIMP SPECS

TERMINAL NAME: FASTON TYPE 6.3MM SERIES.

CRIMP	SIZE	TYPE	RANGE
WIRE	3.94 [.155 IN]	F	2.5mm² – 6.0mm² △4
INSUL	5.08 [.200 IN]	F	3.80–5.00[.150–.197 IN] △4

WIRE STRIP LENGTH 4.80–5.60 [.189–.220 IN]

APPL INSTRUCTION 408–8323

TERMINAL – – APPL SPEC NONE –

FEED 21.40 [.843 IN]

TERMINALS APPLIED

AMP PN	MFR PN	AMP PN	MFR PN	–
1572583–1	4346.00	1572584–1	4425.00	–
1572583–2	4346.02	1572584–2	4425.02	–
1572583–3	4346.30	1572584–3	4425.30	–
1572583–4	4346.32	1572584–4	4425.32	–
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–

WIRE SIZE mm² AWG	CRIMP HEIGHT △5	PIN PN AND LENGTH [IN]
6.0mm²	2.79 ±0.05 [.110 ±.002 IN]	1–354778–7 [.2580]
4.0mm²	2.41 ±0.05 [.095 ±.002 IN]	5–354778–1 [.2750]
2.5mm²	2.13 ±0.05 [.084 ±.002 IN]	7–354778–1 [.2850]
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–

SET UP GAGE	LAYOUT
458638–3	L1339752

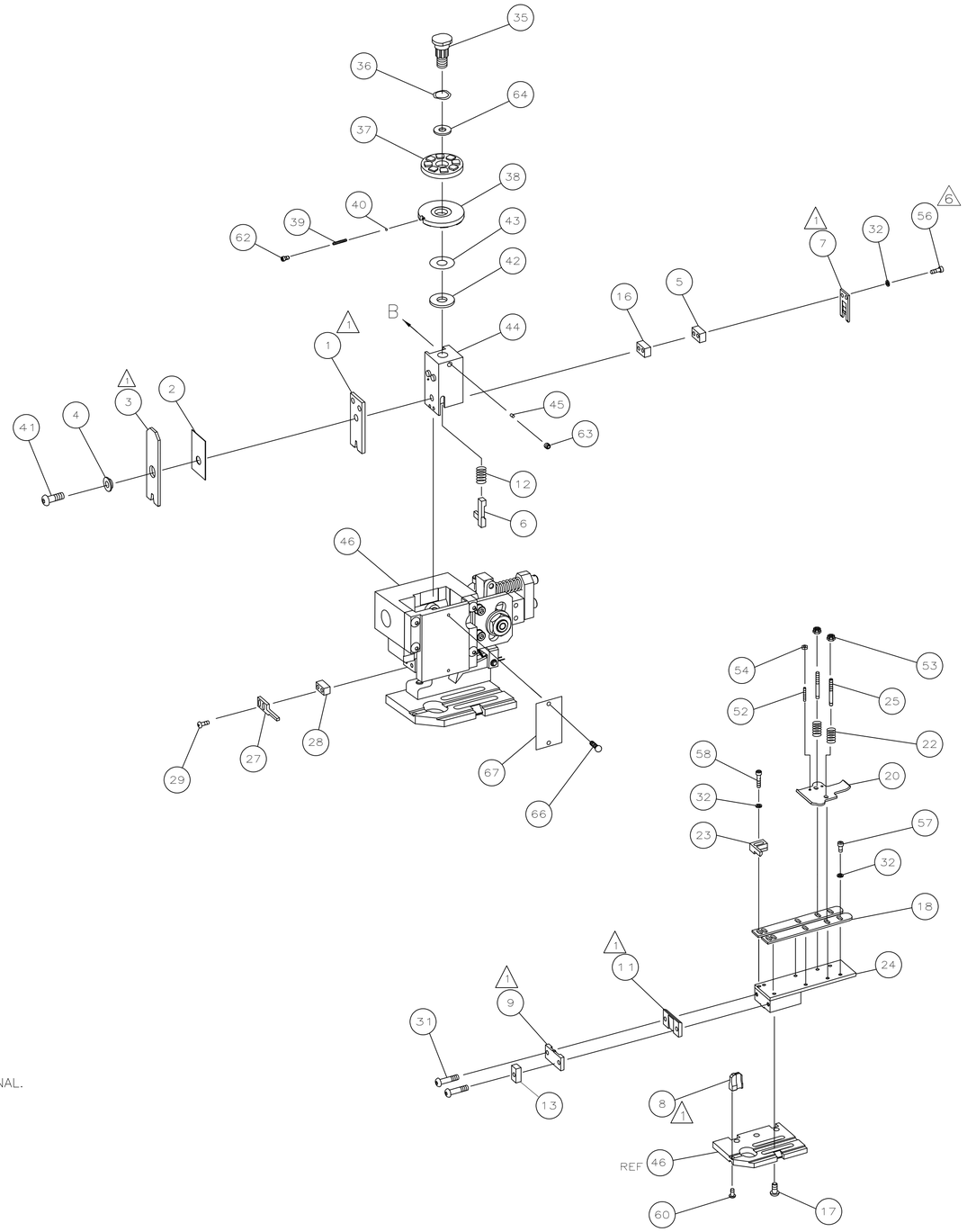
△1 RECOMMENDED SPARE PARTS.

2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

△4 WIRE AND INSULATION RANGES QUOTED ARE THAT OF THE TERMINAL.

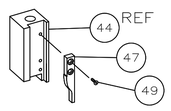
△5 CRIMP DATA CALCULATED BY TYCO.

△6 CUT TO LENGTH AT ASSEMBLY.



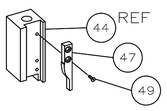
VIEW B ROTATED 180°

POST–FEED 40 mm STROKE



LEADMAKER OR BENCH G

POST–FEED 30 mm STROKE



K TERMINATOR BENCH MACHINE

LOC A DIST 66

							73
–	1	1	1339752	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	1–18023–4	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	△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	1338662–2	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
–	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	2–576128–2	STRIPPER			27
							26
–	2	2	1320906–1	DRAG, STUD			25
–	1	1	1320995–3	PLATE, STRIP GUIDE			24
–	1	1	240825–3	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	690481–2	SPACER, HOLD DOWN			13
–	1	1	23846–1	SPRING, HOLD DOWN			12
–	1	1	240833–2	PLATE, REAR SHEAR	△1		11
							10
–	1	1	3–690495–2	PLATE, FRONT SHEAR			9
1	2	1	2–1333223–7	ANVIL	△1		8
–	1	1	690474–7	BLADE, SLUG			7
–	1	1	1–455892–1	HOLD DOWN, TERMINAL			6
–	1	1	6–240641–9	SPACER, SLUG BLADE			5
–	1	1	238009–1	SPACER, BLOCK CRIMPER			4
1	2	1	6–1213077–8	CRIMPER, INSULATION	△1		3
–	1	1	1–455888–1	SPACER, CRIMPER			2
1	2	1	456426–1	CRIMPER, WIRE	△1		1
–77	–71	–1	PART NO	DESCRIPTION			ITEM NO

QTY REQD PER ASSY — PARTS LIST

P	LTR	REVISION RECORD	DATE	DWN	APVD
	B1	ECR–10–004430	27FEB2010	LG	TE

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± – ; 1 PLC ± – ; 2 PLC ± – ; 3 PLC ± – ; 4 PLC ± –

ANGLES ± – SURFACE TEXTURE –√

DWN L.LOFTHOUSE 14SEP04 | CHK – | APVD F.BACKHURST 14SEP04

MATERIAL – – | HEAT TREAT – –

Tyco Electronics — Tyco Electronics Corporation Harrisburg, PA 17105–3608

NAME END FEED HD–I APPLICATOR –

SCALE – | SIZE A1 | DRAWING NO 1339752 | SHEET 1 OF 1 | REV B1

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT. DWG NO 1339752

THIS INFORMATION IS CONFIDENTIAL AND PROPRIETARY TO TYCO ELECTRONICS CORPORATION AND ITS WORLDWIDE SUBSIDIARIES AND AFFILIATES. IT MAY NOT BE DISCLOSED TO ANYONE OTHER THAN TYCO ELECTRONICS PERSONNEL WITHOUT WRITTEN AUTHORIZATION FROM TYCO ELECTRONICS CORPORATION, HARRISBURG, PENNSYLVANIA USA.

3308–8 (1/08)