PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1529074 – 1	B	–	BENCH & LEADMAKER	MECH POST FEED	HD–I APPLICATOR
7–1529074 – 1	B	–	BENCH & LEADMAKER	MECH POST FEED	–1 AND SPARE PARTS
7–1529074 – 7	A	–	–	–	SPARE PARTS KIT

USED ON –

THIS DRAWING IS A CONTROLLED DOCUMENT. DWG NO 1529074

CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: RING TONGUE

CRIMP	SIZE	TYPE	RANGE
WIRE	3.30 [.130 IN]	F	1.50mm² – 2.50mm²
INSUL	4.57 [.180 IN]	F	2.70–4.00 [.106–.157 IN]

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

APPL INSTRUCTION 408–8323 & 408–8490

TERMINAL – – APPL SPEC 114–3118 –

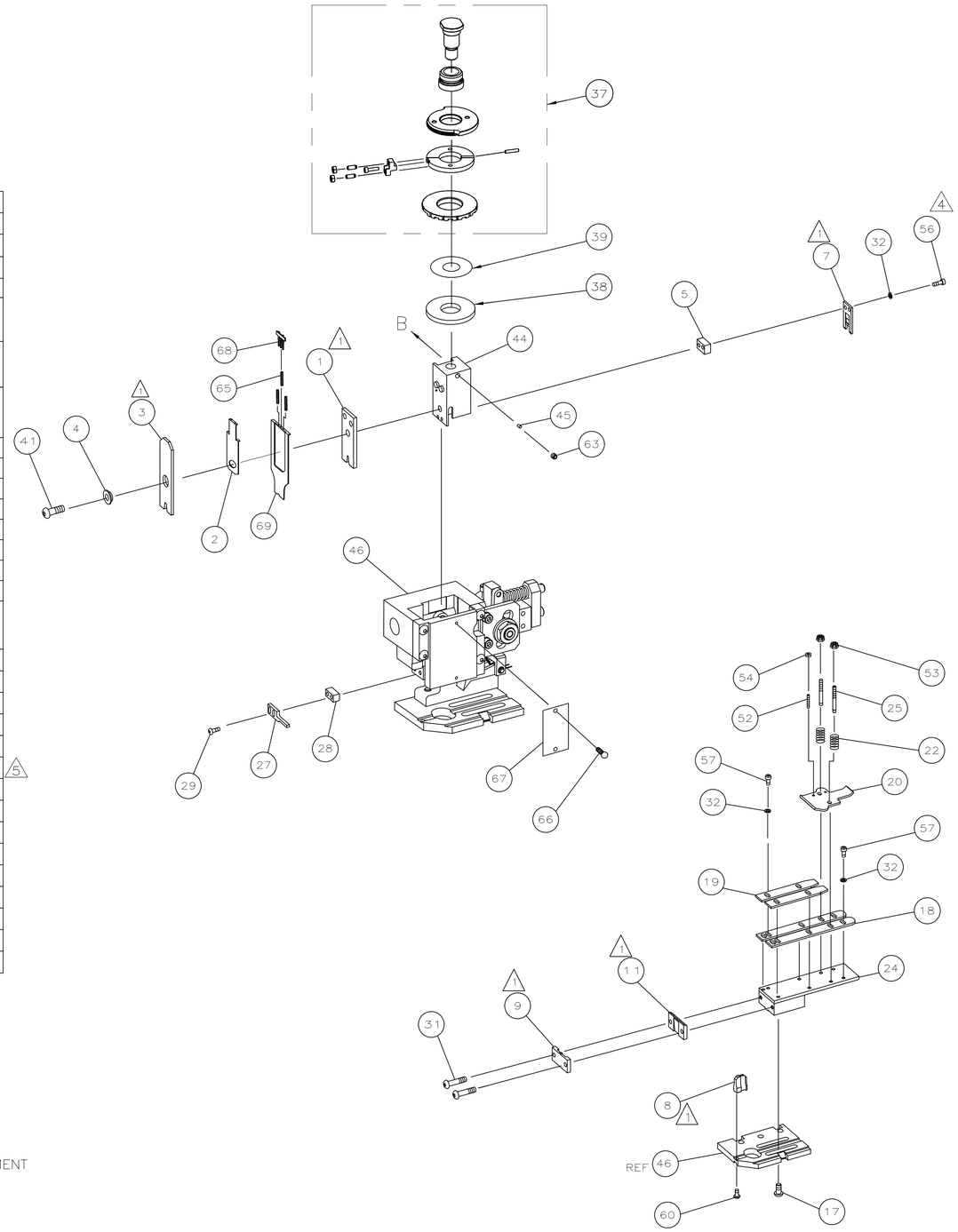
FEED 21.77 [.857 IN]

TERMINALS APPLIED

880642	–	–	–	–
880623	–	–	–	–
880643	–	–	–	–
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–

WIRE SIZE mm² AWG	CRIMP HEIGHT *	REF SETTING *
2.50mm²	2.41 ±0.05 [.095 ±.002 IN]	B3
14 AWG	2.26 ±0.05 [.089 ±.002 IN]	C4
2.00mm²	2.23 ±0.05 [.088 ±.002 IN]	C6
1.50mm²	2.11 ±0.05 [.083 ±.002 IN]	D4
16 AWG	2.08 ±0.05 [.082 ±.002 IN]	D6
1.00mm²	2.00 ±0.05 [.079 ±.002 IN]	E1 △5
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–

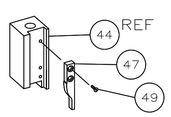
SET UP GAGE	LAYOUT
458638–3	L1339520



△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 1.00mm² WIRE SIZE IS FOR A SPECIFIC CUSTOMER REQUIREMENT AND IS OUTSIDE THE NORMAL RANGE OF THIS APPLICATOR.

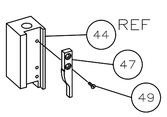
VIEW B ROTATED 180°

POST–FEED 40 mm STROKE



LEADMAKER OR BENCH G

POST–FEED 30 mm STROKE



K TERMINATOR BENCH MACHINE

LOC A DIST 66

3308–8 (1/08)

* WARNING:
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING.
USE OF SETTINGS BELOW MIN REQ'D CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

QTY REQD PER ASSY			PARTS LIST		
					73
–	1	1	1529074	PRINT, APPLICATOR LOG SHEET	72
–	1	1	1338705–4	DOCUMENTATION PACKAGE	71
					70
–	1	1	1490525–1	DEPRESSOR, WIRE	69
–	1	1	1424350–1	HOLDER, PIN, WIRED	68
–	1	1	461264–5	PLATE, IDENTIFICATION	67
–	2	2	21017–2	SCR,DRIVE(#2X.19)ID PLATE	66
–	2	2	1–23147–4	SPRING, COMPRESSION	65
					64
–	1	1	3–18031–0	SCR,SKT SET(M6X6)RAM	63
					62
					61
–	1	1	18024–7	SCR,BHC(M4X10)ANVIL	60
					59
					58
–	6	6	18023–9	SCR,SHC(M4X6)STRIP GUIDE	57
△4 –	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	1338662–2	APPLICATOR, BASIC (SUBASSY)	46
–	1	1	690191–1	PLUG, NYLON	45
–	1	1	1333260–1	RAM	44
					43
					42
–	1	1	2–18024–6	SCREW,BHC(M8X25)CRIMPER	41
					40
–	1	1	690125–1	SHIM SUBASSY	39
–	1	1	469367–1	SPACER, FINE ADJUST	38
–	1	1	879103–2	FINE ADJUST HEAD SUBASSY	37
					36
					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	1–690451–1	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	1338663–2	GUIDE, LOWER STRIP	18
–	4	4	1–18024–8	SCR,BHC(M6X12)STRIP GD PL	17
					16
					15
					14
					13
					12
△1 –	1	1	240644–1	PLATE, REAR SHEAR	11
					10
–	1	1	690482–4	PLATE, FRONT SHEAR	9
△1 1	2	1	1333221–1	ANVIL	8
–	1	1	690474–4	BLADE, SLUG	7
					6
–	1	1	1–240641–5	SPACER, SLUG BLADE	5
–	1	1	238009–1	SPACER, BLOCK CRIMPER	4
1	2	1	4–456134–6	CRIMPER, INSULATION	3
–	1	1	1490524–2	SPACER, DEPRESSOR	2
△1 1	2	1	456410–3	CRIMPER, WIRE	1
–77	–71	–1	PART NO	DESCRIPTION	ITEM NO

P	LTR	REVISION RECORD	DATE	DWN	APVD
	B	ECR–09–024781	11–2009	MY	TE

DIMENSIONS: INCHES

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

ANGLES ± – SURFACE TEXTURE √

DWN M.CLIFFORD 21AUG03
CHK –
APVD F.BACKHURST 21AUG03

MATERIAL – – HEAT TREAT – –

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

NAME FINE ADJ END FD HD–I APPL

SCALE – SIZE A1 DRAWING NO 1529074 SHEET 1 OF 1 REV B

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

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