PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339520-1	D	-	BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1339520-1	D	-	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339520-7	A	-	-	-	SPARE PARTS KIT

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]

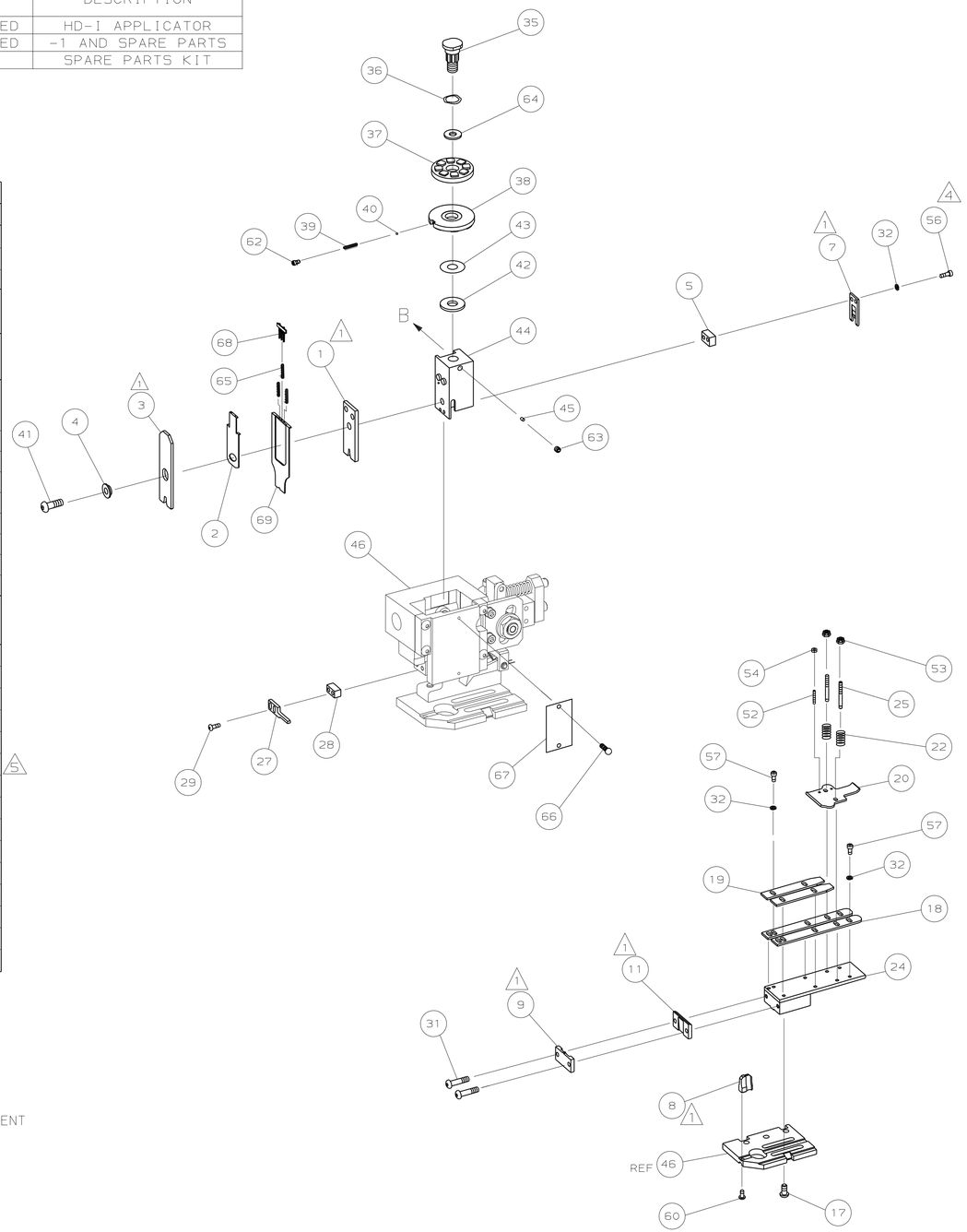
APPL INSTRUCTION
408-8323

TERMINAL	-	-	FEED
APPL SPEC	114-3118	-	21.77 [.857 IN]

TERMINALS APPLIED

880642	-	-	-	-
880623	-	-	-	-
880643	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-

WIRE SIZE mm² AWG	CRIMP HEIGHT	PIN PN & LENGTH [IN]
2.50mm²	2.41 ±0.05 [.095 ±.002 IN]	3-354778-9 [.2690]
14 AWG	2.26 ±0.05 [.089 ±.002 IN]	5-354778-4 [.2765]
2.00mm²	2.23 ±0.05 [.088 ±.002 IN]	5-354778-7 [.2780]
1.50mm²	2.11 ±0.05 [.083 ±.002 IN]	6-354778-5 [.2820]
16 AWG	2.08 ±0.05 [.082 ±.002 IN]	6-354778-8 [.2835]
1.00mm²	2.00 ±0.05 [.079 ±.002 IN]	7-354778-3 [.2860] △5
-		-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

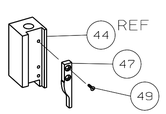


△1 RECOMMENDED SPARE PARTS.
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
△4 CUT TO LENGTH AT ASSY.

△5 1.00mm² WIRE SIZE IS FOR A SPECIFIC CUSTOMER REQUIREMENT AND IS OUTSIDE THE NORMAL RANGE OF THIS APPLICATOR.

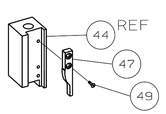
VIEW B ROTATED 180°

POST-FEED 40 mm STROKE



LEADMAKER OR BENCH G

POST-FEED 30 mm STROKE



K TERMINATOR BENCH MACHINE

LOC A
DIST 66

						73
-	1	1	1339520	PRINT, APPLICATOR LOG SHEET		72
-	1	1	1338705-2	DOCUMENTATION PACKAGE		71
						70
-	1	1	1490525-1	DEPRESSOR, WIRE		69
-	1	1	1424350-1	HOLDER, PIN, WIRED		68
-	1	1	461264-1	PLATE, IDENTIFICATION		67
-	2	2	21017-2	SCR,DRIVE(#2X.19)ID PLATE		66
-	2	2	1-23147-4	SPRING, COMPRESSION		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	18023-9	SCR,SHC(M4X6)STRIP GUIDE		57
-	2	2	1-18023-3	SCR,SHC(M4X16)SLUG BLADE	△4	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	1-1320922-0	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	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	240644-1	PLATE, REAR SHEAR	△1	11
						10
-	1	1	690482-4	PLATE, FRONT SHEAR	△1	9
1	2	1	1333221-1	ANVIL	△1	8
-	1	1	690474-4	BLADE, SLUG	△1	7
						6
-	1	1	1-240641-5	SPACER, SLUG BLADE		5
-	1	1	238009-1	SPACER, BLOCK CRIMPER		4
1	2	1	456134-6	CRIMPER, INSULATION	△1	3
-	1	1	1490524-2	SPACER, DEPRESSOR		2
1	2	1	456410-3	CRIMPER, WIRE	△1	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

P	F	LTR	REVISION RECORD	APP	DATE
		D	ECR-06-022382	BH	SEP06
		C	0150-0625-03	RK	JUN03
		B	ECN 0150-0970-01	TE	10-01
		A	SEE ECN 015A-0121-01	MC	FEB01
		01	ADDITIONAL WIRE SIZES.	LJL	JAN01

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 R0.38 MAX

MATL - - | HT TR - - | FIN - -

DR 06NOV00 L.LOFTHOUSE | APP 06NOV00 F.BACKHURST
CHK 08-02-01 M.CLIFFORD | REL 08-02-01 M.CLIFFORD

AMP Incorporated Harrisburg, PA 17105-3608

NAME END FEED HD-I APPLICATOR | MACHINE REF HD-I APPL
SCALE - | D | DWG NO 1339520 | SHEET 1 OF 1 | REV D

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LAYOUT L1339520
SET UP GAGE 458638-3