DRAWING MADE IN THIRD ANGLE PROJECTION

1528491 ⇔ 1528491

/home/eb003420/edmmod

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1528491-1	A	–	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528491-2	A	–	BENCH	MECH PRE FEED	CUTS CARRIER
1528491-6	A	–	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528491-1	A	–	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528491-2	A	–	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528491-6	A	–	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528491-7	A	–	–	–	SPARE PARTS KIT

CRIMP DATA ITT CANNON TERMINAL TYCO CRIMP SPECS

TERMINAL NAME: CONTACT PIN & SOCKET (SEALED) △4

CRIMP	SIZE	TYPE	RANGE
WIRE	1.78 [.070 IN] △7	F	0.35mm²-0.75mm² △8
INSUL	3.81 [.150 IN] △7	O	2.75 MAX [.108 IN MAX]

WIRE STRIP LENGTH 3.91-4.67 [.154-.184 IN]

APPL INSTRUCTION 408-8322 & 408-8490

TERMINAL	–	–	FEED
APPL SPEC	–	–	11.43 [.450 IN]

TERMINALS APPLIED

AMP TERM PN	MFR TERM PN	TYPE	AMP SEAL PN	MFR SEAL PN
1572684-1	121668-0265	PIN	1572686-1	121667-0023
1572685-1	121668-0266	SOCKET	–	
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–

WIRE SIZE mm² AWG	CRIMP HEIGHT ✳△7	REF SETTING
0.75mm²	1.28 ±0.03 [.050 ±.001 IN]	B9
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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.

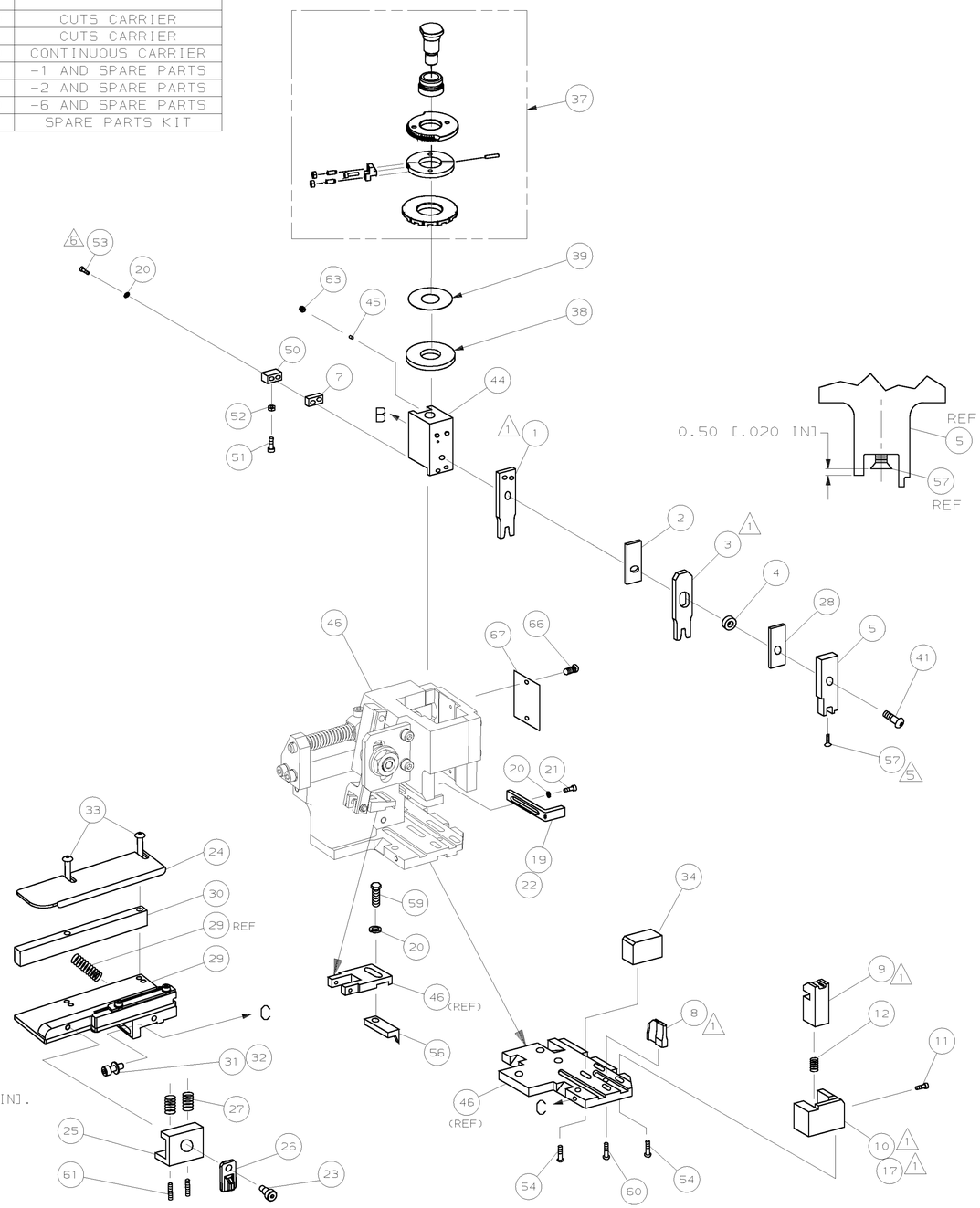
△4 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION DIA QUOTED IS OUTSIDE DIAMETER OF SEAL. WIRE INSULATION DIA IS DEPENDENT ON SEAL BEING APPLIED. INS RANGE FOR SEAL P/N 1572686-1 IS 1.9-2.1 [.075-.083 IN].

△5 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

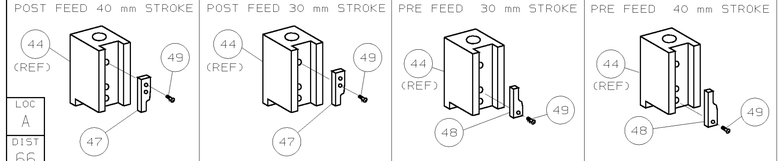
△6 CUT TO LENGTH AT ASSY.

△7 ALL CRIMP DATA CALCULATED BY TYCO ELECTRONICS UK LTD.

△8 WIRE RANGE SHOWN IS WIRE RANGE OF TERMINAL. WHEN USING FULL WIRE RANGE APPROPRIATE SEALS SHALL BE USED.

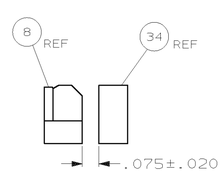


VIEW B ROTATED 180°

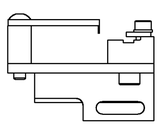


✳ WARNING:

ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



ITEM 34 LOCATION



									73
–	1	1	1	1	1	1	1528491	PRINT, APPLICATOR LOG SHEET	72
–	1	1	1	1	1	1	1338705-3	DOCUMENTATION PACKAGE	71
									70
									69
									68
–	1	1	1	1	1	1	461264-5	PLATE, IDENTIFICATION	67
–	2	2	2	2	2	2	21017-2	SCR,DRIVE(#2x.19)ID PLATE	66
									65
									64
–	1	1	1	1	1	1	3-18031-0	SCR,SKT SET(M6X6)RAM	63
									62
–	2	2	2	2	2	2	2-18032-5	SCR,SKT SET (M5X20)DRAG	61
–	1	1	1	1	1	1	18024-7	SCR,BHC(M4X10)ANVIL	60
–	1	1	1	1	1	1	5-18022-2	SCR,HEX(M4X8)FEED FINGER	59
									58
–	1	1	1	1	1	1	985575-3	SCR,FHC(M3X10)DEP	57
–	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
									55
–	4	4	4	4	4	4	18024-8	SCR,BHC(M4x12)SHEAR HOLDER	54
△6 –	2	2	2	2	2	2	1-18023-3	SCR,SHC(M4x16)TERM HLD DWN	53
–	1	1	1	1	1	1	18030-1	NUT,HEX(M3)HOLD DOWN	52
–	1	1	1	1	1	1	811242-5	BUMPER, HOLDDOWN	51
–	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
–	1	1	1	1	1	1	18024-3	SCR,BHC(M3X10)CAM	49
–	–	1	–	–	1	–	1338675-1	CAM, PRE FEED 30 & 40 mm ST	48
–	1	–	1	1	–	1	1338676-1	CAM, POST FEED 30 & 40 mm ST	47
–	1	1	1	1	1	1	1320999-3	APPLICATOR BASIC SUBASSY	46
–	1	1	1	1	1	1	690191-1	PLUG, NYLON	45
–	1	1	1	1	1	1	1338660-1	RAM	44
									43
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–	1	1	1	1	1	1	2-18024-6	SCR,BHC(M8X25)RAM	41
									40
–	1	1	1	1	1	1	690125-1	SHIM SUBASSY	39
–	1	1	1	1	1	1	469367-9	SPACER, FINE ADJUST	38
–	1	1	1	1	1	1	879103-3	FINE ADJUST HEAD SUBASSY	37
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									35
–	1	1	1	1	1	1	1-1424186-1	SUPPORT, TERMINAL	34
–	2	2	2	2	2	2	1-18024-0	SCR,BHC(M4X20)STRIP GUIDE	33
–	1	1	1	1	1	1	18027-2	WASHER, FLAT(M4)	32
–	1	1	1	1	1	1	1-18023-2	SCR,SKT CAP(M4X12)MOUNT BLOCK	31
–	1	1	1	1	1	1	1320908-8	SPACER, STRIP GUIDE	30
–	1	1	1	1	1	1	1633073-4	STRIP GUIDE PLATE ASSY	29
–	1	1	1	1	1	1	1-455888-0	SPACER, FRONT SHEAR DEP	28
–	2	2	2	2	2	2	1-22284-0	SPRING, DRAG	27
–	1	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
–	1	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
–	1	1	1	1	1	1	1320928-1	PLATE, STRIP GUIDE	24
–	1	1	1	1	1	1	980371-4	SCR,SHC SHLD	23
–	1	–	1	1	–	1	690472-2	STRIPPER	22
–	1	1	1	1	1	1	1-18023-1	SCR,SHC(M4X10)STRIPPER	21
–	4	4	4	4	4	4	18025-2	WASHER,LOCK(M4)STRIPPER	20
–	–	1	–	–	1	–	690472-1	STRIPPER	19
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△1 –	1	–	–	1	–	–	1338684-2	HOLDER, SHEAR, FRONT (NO-CUT)	17
									16
									15
									14
									13
–	1	1	1	1	1	1	5-22280-0	SPRING, SHEAR	12
–	1	1	1	1	1	1	356885-5	STOP, SHEAR	11
△1 –	–	1	1	–	1	1	1-1320921-0	HOLDER, SHEAR, FRONT (CUT)	10
△1 –	1	1	1	1	1	1	1-318707-0	SHEAR, FLOAT (FRONT)	9
△1 1	2	2	2	1	1	1	7-1333203-7	ANVIL	8
–	1	1	1	1	1	1	1-240641-3	SPACER, DEPRESSOR (REAR)	7
									6
–	1	1	1	1	1	1	1338680-5	DEPRESSOR, SHEAR (FRONT)	5
–	1	1	1	1	1	1	238011-4	SPACER, BLOCK CRIMPER	4
△1 1	2	2	2	1	1	1	5-904741-6	CRIMPER, INSULATION	3
–	1	1	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
△1 1	2	2	2	1	1	1	1-456404-0	CRIMPER, WIRE	1
-77	-76	-72	-71	-6	-2	-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
		A	SEE ECN 015A-0251-05	MC	MAR05

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 RO.38 MAX

MATL – –	HT TR – –	FIN – –	
DR 25FEB05 L.LOFTHOUSE	APP 25FEB05 F.BACKHURST	AMP Tyco Electronics Harrisburg, PA 17105-3608	
CHK –	REL 29-03-05 M.CLIFFORD		
NAME FINE ADJ SIDE FD HD-I APPL		MACHINE REF HD-I APPL	
SCALE –	D DWG NO 1528491	SHEET 1 OF 1	REV A
CAGE CODE 00779	CUSTOMER AND ASSEMBLY DRAWING	RESTRICTED TO –	

LOC A DIST 66

LAYOUT L1528491

SET UP GAGE 458637-3

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