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LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	B	ECR-07-007952	4-2007	MY	TE

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339794-1	B	-	BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1339794-1	B	-	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339794-7	B	-	-	-	SPARE PARTS KIT

CRIMP DATA GENCO TERMINAL TYCO CRIMP SPECS △5

TERMINAL NAME: FASTON 3.05 SIR EST

CRIMP	SIZE	TYPE	RANGE
WIRE	1.78 [.070 IN]	F	0.50mm² - 1.00mm² △6
INSUL	2.79 [.110 IN]	F	1.80-2.40 [.071-.094 IN] △6

WIRE STRIP LENGTH 3.90-4.70 [.154-.185 IN]

APPL INSTRUCTION 408-8323

TERMINAL APPL SPEC NONE - - -

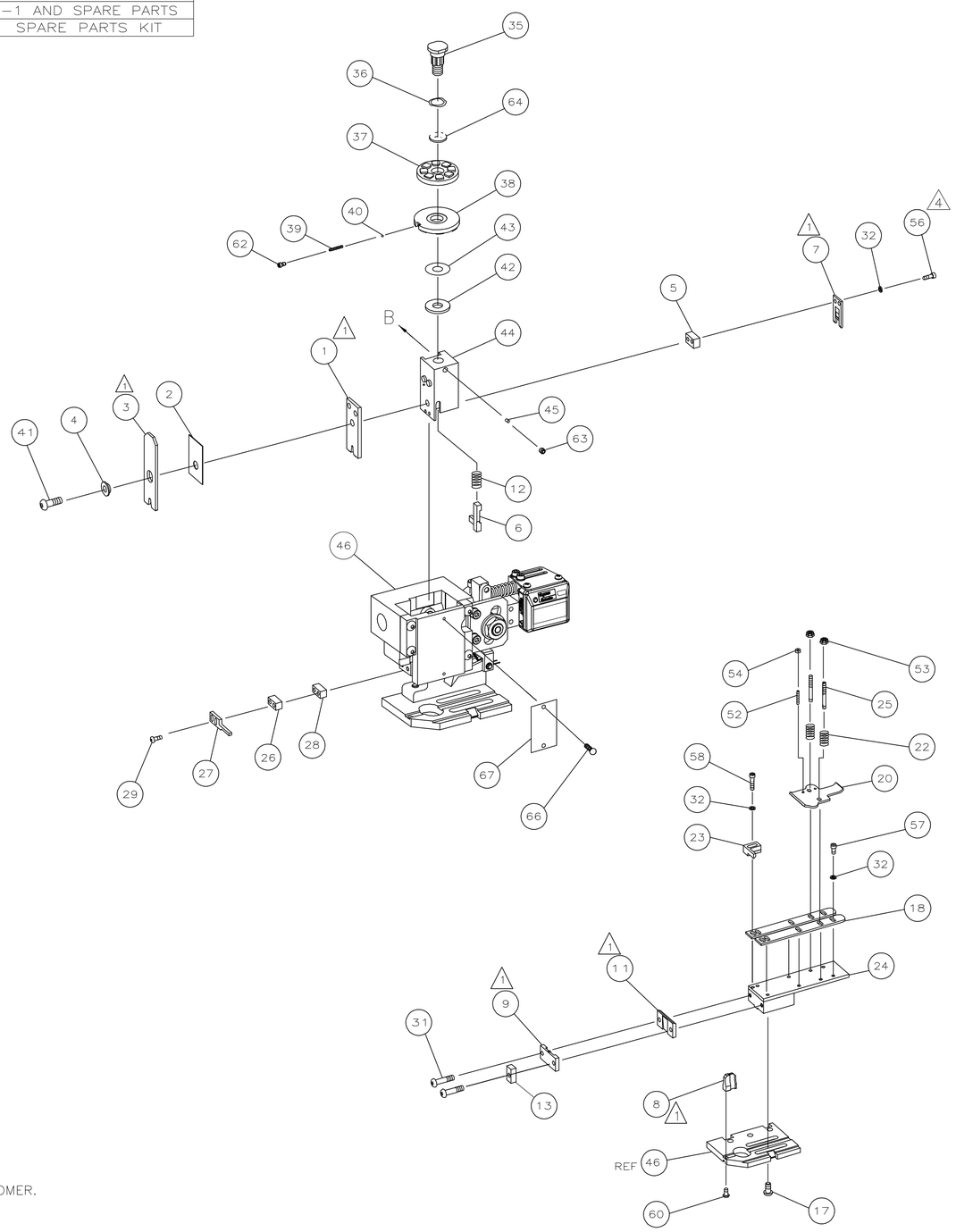
FEED 408-8323

TERMINALS APPLIED

AMP PN	MFR PN	-	-	-
1572831-1	1739BS-2	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-
-	-	-	-	-

WIRE SIZE mm² AWG	CRIMP HEIGHT △5	PIN PN AND LENGTH [IN]
1.00mm²	1.26 ±0.05 [.050 ±.002 IN]	1-354779-9 [.3085]
0.75mm²	1.15 ±0.05 [.045 ±.002 IN]	3-354779-0 [.3140]
0.50mm²	1.03 ±0.05 [.041 ±.002 IN]	3-354779-9 [.3185]
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

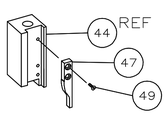
SET UP GAGE	LAYOUT
458638-3	L1339794



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 ASSEMBLY.
5. ALL CRIMP DATA CALCULATED BY TYCO ELECTRONICS UK LTD.
6. WIRE AND INSULATION RANGE REQUESTED BY THE ORIGINAL CUSTOMER.

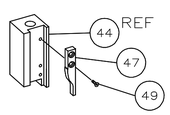
VIEW B ROTATED 180°

POST-FEED 40 mm STROKE



LEADMAKER OR BENCH G

POST-FEED 30 mm STROKE



K TERMINATOR BENCH MACHINE

ITEM NO	QTY REQD PER ASSY			PART NO	DESCRIPTION
	-77	-71	-1		
1	1	2	1	1-456404-8	CRIMPER, WIRE
2	-	1	1	455888-8	SPACER, CRIMPER
3	1	2	1	8-456134-7	CRIMPER, INSULATION
4	-	1	1	2-238009-3	SPACER, BLOCK CRIMPER
5	-	1	1	3-240641-4	SPACER, SLUG BLADE
6	-	1	1	8-455892-3	HOLD DOWN, TERMINAL
7	-	1	1	690474-5	BLADE, SLUG
8	1	2	1	3-1333215-0	ANVIL
9	-	1	1	690482-5	PLATE, FRONT SHEAR
10					
11	-	1	1	240644-1	PLATE, REAR SHEAR
12	-	1	1	23846-1	SPRING, HOLD DOWN
13	-	1	1	690481-3	SPACER, HOLD DOWN
14					
15					
16					
17	-	4	4	1-18024-8	SCR,BHC(M6X12)STRIP GD PL
18	-	2	2	1338663-2	GUIDE, LOWER STRIP
19					
20	-	1	1	1338665-1	DRAG, STOCK
21					
22	-	2	2	4-22281-1	SPRING, DRAG
23	-	1	1	240825-1	PLATE, STRIP HOLD DOWN
24	-	1	1	1320995-1	PLATE, STRIP GUIDE
25	-	2	2	1320906-1	DRAG, STUD
26	-	1	1	1-690451-2	SPACER, STRIPPER
27	-	1	1	240639-3	STRIPPER
28	-	1	1	1-690451-7	SPACER, STRIPPER
29	-	2	2	18024-8	SCR,BHC(M4X12)STRIPPER
30					
31	-	2	2	1-18024-0	SCR,BHC(M4X20)SHEAR PL
32	-	9	9	18025-2	WASHER,LOCK(M4)SHEAR BL
33					
34					
35	-	2	2	1320922-1	DISC, INSULATION
36	-	1	1	690212-1	POST, RAM
37	-	1	1	22480-5	WASHER, SPRING
38	-	1	1	354777-1	WIRE DISC, PLASTIC
39	-	1	1	690191-1	PLUG, NYLON
40	-	1	1	23241-1	BALL, STEEL
41	-	1	1	2-18024-6	SCREW,BHC(M8X25)CRIMPER
42	-	1	1	690124-1	WASHER, RAM
43	-	1	1	690125-1	WASHER, LAMINATED
44	-	1	1	1320998-1	RAM
45	-	1	1	2-22278-7	SPRING, COMPRESSION
46	-	1	1	1338676-1	CAM, POST-FEED 30 & 40 mm ST
47					
48					
49	-	1	1	18024-3	SCR,BHC(M3X10)CAM
50					
51					
52	-	2	2	2-18032-2	SCR,SKT SET(M3X10)DRAG
53	-	2	2	986965-1	NUT,HEX SL(M4)DRAG STUD
54	-	2	2	18029-1	NUT,HEX(M3)DRAG
55					
56	-	2	2	1-18023-1	SCR,SHC(M4X10)SLUG BLADE △4
57	-	5	5	18023-9	SCR,SHC(M4X6)STRIP GUIDE
58	-	2	2	1-18023-3	SCR,SHC(M4X16)HOLD DOWN
59					
60	-	1	1	18024-7	SCR,BHC(M4X10)ANVIL
61					
62	-	1	1	3-18031-0	SCR,SKT SET(M6X6)RAM
63	-	1	1	18023-9	SCR,SKT CAP(M4X6)CP DSC
64	-	1	1	986950-1	WASHER, FLAT PRECISION
65					
66	-	2	2	21017-2	SCR,DRIVE(#2X.19)ID PLATE
67	-	1	1	461264-1	PLATE, IDENTIFICATION
68					
69					
70					
71	-	1	1	1338705-2	DOCUMENTATION PACKAGE
72	-	1	1	1339794	PRINT, APPLICATOR LOG SHEET
73					

PARTS LIST

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ± -
1 PLC ± -
2 PLC ± -
3 PLC ± -
4 PLC ± -
ANGLES ± -

MATERIAL -

FINISH -

DWN 130CT05 L.LOFTHOUSE
CHK - -
APVD 130CT05 F.BACKHURST
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

Tyco Electronics Corporation
Harrisburg, PA 17105-3608

NAME END FEED HD-I APPLICATOR - -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1339794	-

CUSTOMER DRAWING | SCALE - | SHEET 1 OF 1 | REV B

AMP 4805 REV 31MAR2000
Translated 070404,124743 (YYMMDD:HHMMSS) from Computervision, Inc., Meduso Revision 12.2.ST
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