

PART NUMBER	REV	FIRST USED
1157050-1	H	

### CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: CRIMP CONTACT			
CRIMP	SIZE	TYPE	RANGE
WIRE	1.78 [.070 IN]	F	200-1855 CMA
INSUL	-	-	-
WIRE STRIP LENGTH 5.00-5.50 [.197-.217 IN]		APPL INSTRUCTION 408-8322	
TERMINAL APPL SPEC	C-160631	FEED	8.38 [.330 IN]

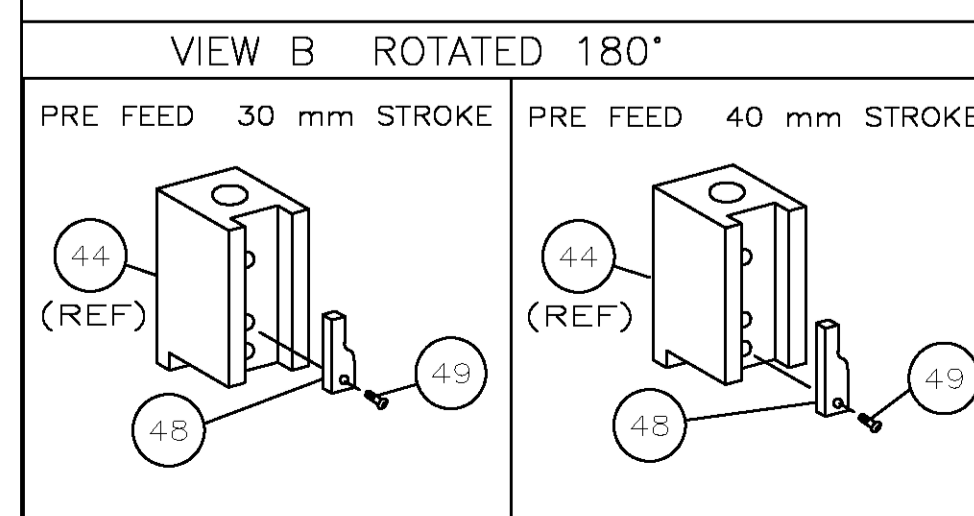
### TERMINALS APPLIED

TERMINAL	APPL SPEC	CRIMP	SIZE	TYPE	RANGE
160631-6	-	-	-	-	-
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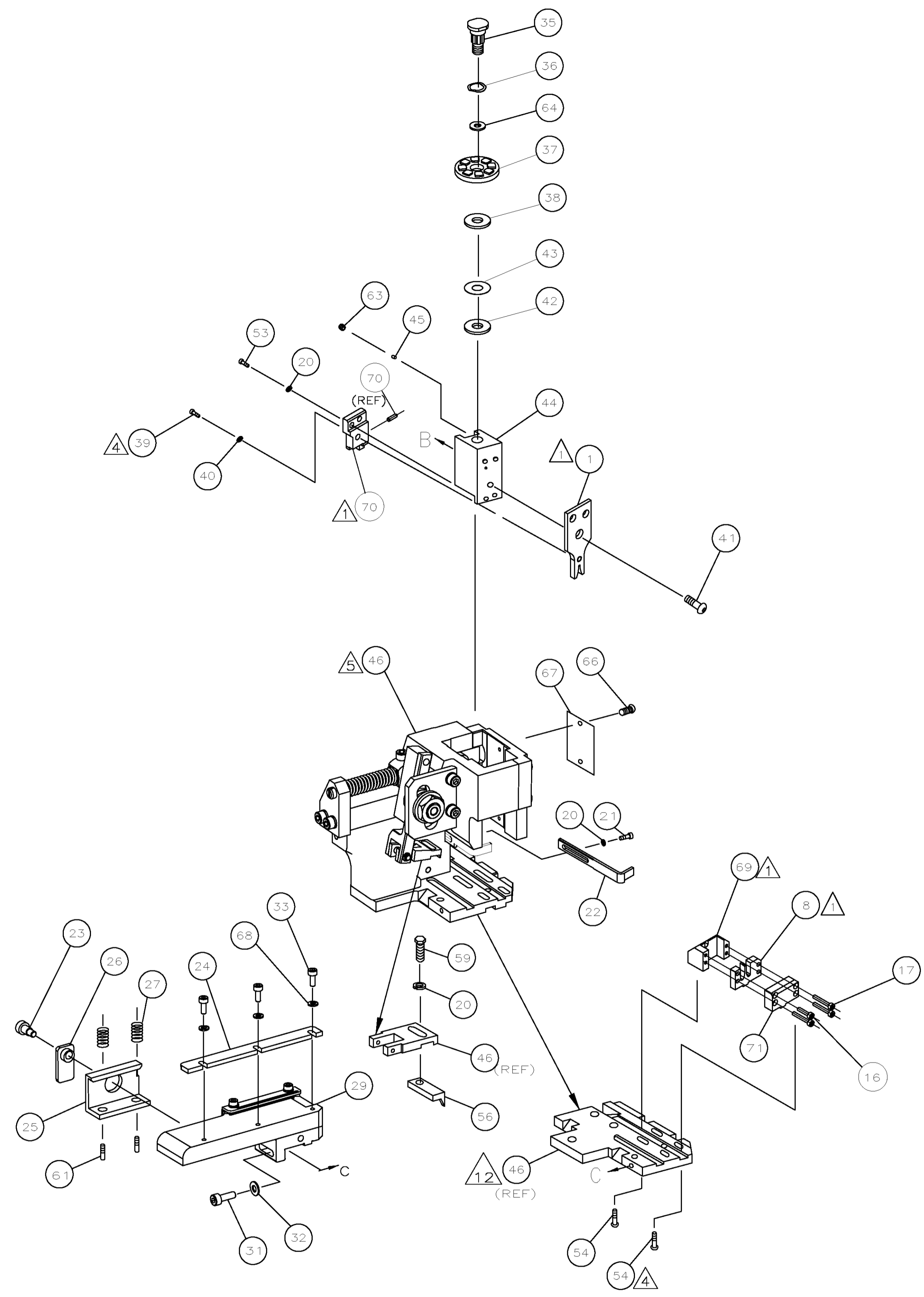
WIRE SIZE mm² AWG	CRIMP HEIGHT	PIN PN AND LENGTH [IN]
1200-1855 CMA	1.30 ± 0.05 [.051 ± .002 IN]	4-354779-6 [.3220]
800-1200 CMA	1.22 ± 0.05 [.048 ± .002 IN]	5-354779-2 [.3250]
255-800 CMA	1.17 ± 0.02 [.046 ± .001 IN]	5-354779-6 [.3270]
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SET UP GAGE 458637-3	LAYOUT L1157050
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- RECOMMENDED SPARE PARTS.
  - GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
  - LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
  - CUT TO LENGTH AT ASSY.
  - ASSEMBLY NOTE: APPLICATOR HOUSING PART N° 1320991-1 (SUPPLIED AS PART OF BASIC APPLICATOR, ITEM 46) TO BE RE-WORKED AS PER PRODUCTION DRAWING 525917-1.
  - CRIMP HEIGHT TO BE MEASURED AT POINT SHOWN IN C-160631.
  - GUARD KIT PART N° 525916-1 (NOT SHOWN) TO BE USED ONLY WITH ELT TERMINATOR PART N° 1338600-6 (NOT SHOWN).
  - FOR DOUBLE WIRE-ON-WIRE COMBINATION (0.50+0.50mm ONLY) UPPER WIRE TO BE TERMINATED AS DETAILED BELOW;
- 
- 0.50 [.020 IN] MIN
- THESE ITEMS ARE NOT SHOWN FOR CLARITY.
  - STORE APPLICATOR WITH A SMALL STRIP OF TERMINALS IN CRIMP ZONE.



- CORRECT FEED ADJUSTMENT IS CRITICAL TO ENSURE OPTIMUM CRIMP AND CUT-OFF TAB / BURR.
- BASE PLATE P/N 525895-1 (ITEM 81) TO BE EXCHANGED WITH BASE PLATE P/N 1320992-1, AS SUPPLIED ON BASIC APPL. 1320999-3 (ITEM 46). BASE PLATE TO BE DOWELLED TO APPLICATOR HOUSING UPON SET-UP USING DOWEL PINS P/N 992946-3 (ITEM 82).



LOC	DIST	REVISIONS			
TR	LTR	DESCRIPTION	DATE	DN	APVO
A	66	H	ECR-09-027461	17DEC2009	L.Z S.X

2	992946-3	DOWEL PIN	82
1	525895-1	BASE PLATE	81
1	1-18027-0	WASHER, FLAT	80
1	6-18023-7	SCR,CAP SKT HD (M2.5X6.0)	79
2	18023-3	SCR,CAP SKT HD (M3X8)	78
			77
			76
			75
			74
1	525915-4	GUARD, FRONT TOOLING	73
1	525915-3	GUARD, BACK TOOLING	72
1	1157050	PRINT, APPLICATOR LOG SHEET	71
1	525901-1	BLOCK, SUPPORT	70
1	525913-1	BLADE, SHEAR, ASSEMBLY	69
1	525892-1	PLATE, SHEAR	68
3	18025-1	WASHER, LOCK (M3)	67
1	461264-1	PLATE, IDENTIFICATION	66
2	21017-2	SCR,DRIVE(#2x.19)ID PLATE	64
1	986950-1	WASHER, FLAT PRECISION	63
1	3-18031-0	SCR,SKT SET(M6X6)RAM	61
2	2-18032-5	SCR,SET(M5X20)DRAG	59
1	5-18022-2	SCR,HEX(M4X8)FEED FINGER	56
1	1338683-2	PAWL, FEED	54
4	18024-8	SCR,BHC(M4x12)SHEAR HOLDER	53
2	1-18023-1	SCR,SHC(M4x10)	49
1	18024-3	SCR,BHC(M3X10)CAM	48
1	1338675-1	CAM, PRE FEED 30 & 40 mm ST	47
1	1320999-3	APPLICATOR BASIC SUBASSY	46
1	690191-1	PLUG, NYLON	45
1	525894-1	RAM	44
1	690125-1	WASHER, LAMINATED	43
1	690124-1	WASHER, RAM	42
1	2-18024-6	SCR,BHC(M8X25)RAM	41
1	18027-3	WASHER,SUPPORT BLOCK	40
1	1-18024-3	SCR,BHC(M5x16)SUPPORT BLOCK	39
1	690223-2	DISC SPACER, INSULATION	38
1	354777-1	WIRE DISC, PLASTIC	37
1	22480-5	WASHER, SPRING	36
1	690212-1	POST, RAM	35
			34
3	18023-5	SCREW,SHC(M3X12)FRT STRP GDE	33
1	18027-2	WASHER, FLAT(M4)	32
1	1-18023-2	SCR,SKT CAP(M4X12)MOUNT BLOCK	31
			30
1	525911-1	STRIP GUIDE PLATE ASSY	29
			28
2	1-22284-0	SPRING, DRAG	27
1	356835-1	LEVER, DRAG RELEASE	26
1	240792-5	DRAG, TERMINAL	25
1	525896-1	GUIDE, STRIP (FRONT)	24
1	980371-4	SCR,SHC SHLD	23
1	525900-1	STRIPPER	22
1	1-18023-1	SCR,SHC(M4X10)STRIPPER	21
4	18025-2	WASHER,LOCK(M4)STRIPPER	20
			19
			18
3	18023-7	SCR,SHC(M3X20)SHEAR PL	17
1	18023-6	SCR,SHC(M3X16)SHEAR PL	16
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1	525889-2	ANVIL	8
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1	525888-2	CRIMPER, WIRE	1

QTY REQD PER ASSY

THIS DRAWING IS A CONTROLLED DOCUMENT. DIMENSIONS: INCHES. TOLERANCES UNLESS OTHERWISE SPECIFIED: 0. PLC ± .001, 1. PLC ± .002, 2. PLC ± .003, 3. PLC ± .004, 4. PLC ± .005, ANGLES ± .001.

APPLICATOR SPEC: A1 00779 C=1157050

MATERIAL: FINISH: WEIGHT: SCALE: SHEET 1 OF 1 REV H

THIS DRAWING IS A CONTROLLED DOCUMENT. DWN: M. CLIFFORD 22JAN03. CHK: F. BACKHURST 22JAN03. NAME: F. BACKHURST. Tyco Electronics Corporation, Harrisburg, PA 17105-3608. SIDE FEED HDM APPLICATOR.

CUSTOMER DRAWING