

DRAWING MADE IN THIRD ANGLE PROJECTION

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1339581-1	B		BENCH & LEADMAKER	MECH POST FEED	HD-I APPLICATOR
7-1339581-1	B		BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339581-7	B		-	-	SPARE PARTS KIT

CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: .250 L.I.F. POSITIVE LOCK REC MK II

CRIMP	SIZE	TYPE	RANGE
WIRE	3.30 [.130 IN]	F	3.00mm ² -4.00mm ²
INSUL	4.06 [.160 IN]	F	3.00-4.20 [.118-.165 IN]
WIRE STRIP LENGTH	APPL INSTRUCTION		
5.10-5.90 [.200-.232 IN]	408-8323		

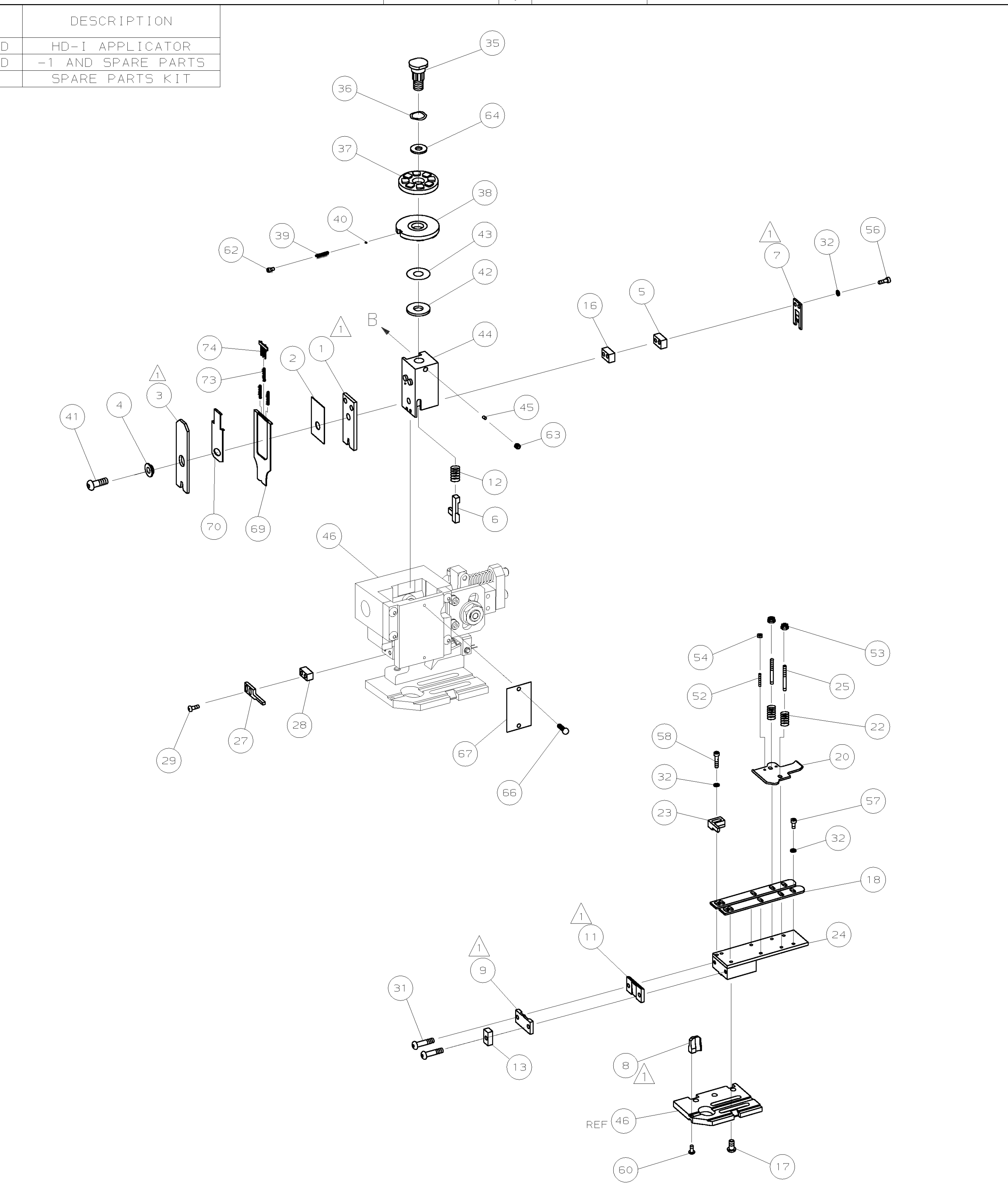
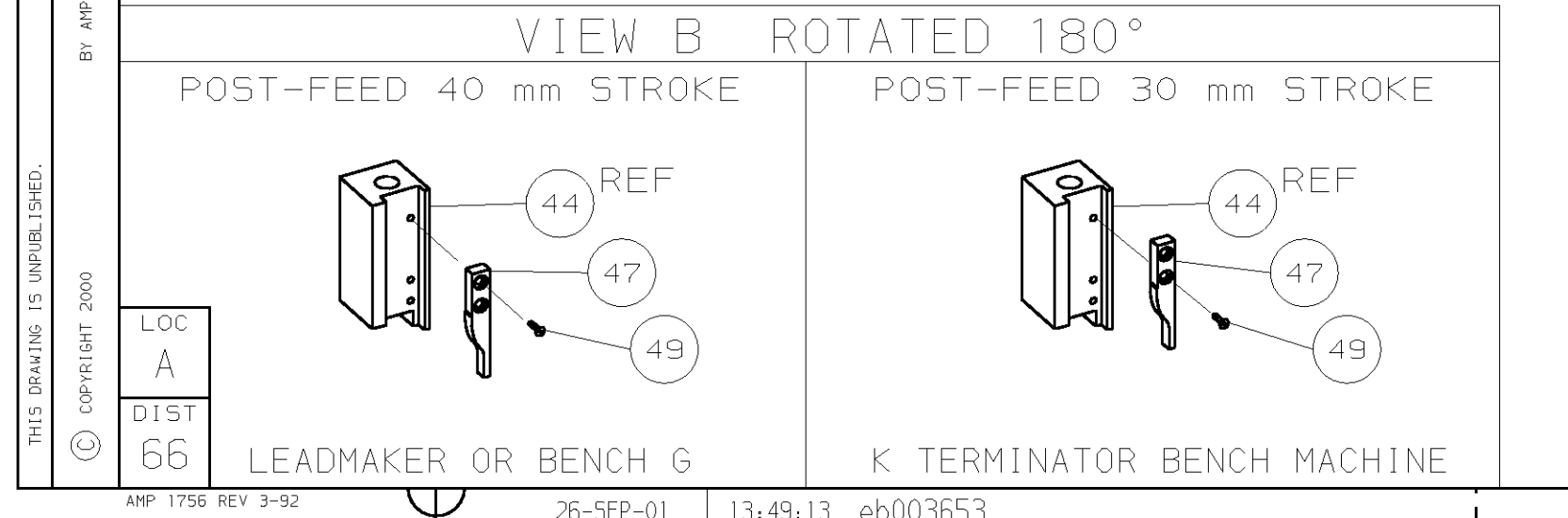
TERMINAL APPL SPEC	114-19023	FEED	23.90 [.941 IN]
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TERMINALS APPLIED

Terminal Part No.	Quantity	Notes
216331	-	
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WIRE SIZE mm ² AWG	CRIMP HEIGHT	PIN PN AND LENGTH [IN]
4.00mm ²	2.38 ± 0.05 [.094 ± .002 IN]	4-354778-6 [.2725]
3.50mm ²	2.27 ± 0.05 [.089 ± .002 IN]	5-354778-8 [.2785]
3.00mm ²	2.16 ± 0.05 [.085 ± .002 IN]	6-354778-6 [.2825]
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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.



QTY REQD PER ASSY	REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)	PART NO	DESCRIPTION	ITEM NO		
-	1	1	1424350-1	HOLDER, PIN, WIRED	74	
-	3	3	2-23147-2	SPRING, DEPRESSOR	73	
-	1	1	1339581	PRINT, APPLICATOR LOG SHEET	72	
-	1	1	1338705-2	DOCUMENTATION PACKAGE	71	
-	1	1	1490524-1	SPACER, DEPRESSOR	70	
-	1	1	1490525-3	DEPRESSOR, WIRE	69	
-	1	1	461264-1	PLATE, IDENTIFICATION	67	
-	2	2	21017-2	SCR, DRIVE (#2X.19) ID PLATE	66	
-	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 D5C	62	
-	1	1	18024-7	SCR, BHC (M4X10) ANVIL	60	
-	2	2	1-18023-3	SCR, SHC (M4X16) HOLD DOWN	58	
-	5	5	1-18023-0	SCR, SHC (M4X8) STRIP GUIDE	57	
-	2	2	1-18023-3	SCR, SHC (M4X16) SLUG BLADE	56	
-	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	
-	1	1	18024-3	SCR, BHC (M3X10) CAM	49	
-	1	1	1338676-1	CAM, POST-FEED 30 & 40 mm ST	47	
-	1	1	1338662-1	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	
-	9	9	18025-2	WASHER, LOCK (M4) SHEAR BL	32	
-	2	2	4-18024-7	SCR, BHC (M4X25) SHEAR PL	31	
-	2	2	18024-8	SCR, BHC (M4X12) STRIPPER	29	
-	1	1	3-690451-2	SPACER, STRIPPER	28	
-	1	1	240639-1	STRIPPER	27	
-	2	2	1320906-1	DRAG, STUD	25	
-	1	1	1320995-1	STRIP GUIDE	24	
-	1	1	240825-3	PLATE, STRIP HOLD DOWN	23	
-	2	2	4-22281-1	SPRING, DRAG	22	
-	1	1	1338665-1	DRAG, STOCK	20	
-	2	2	1338663-6	GUIDE, LOWER STRIP	18	
-	4	4	1-18024-8	SCR, BHC (M6X12) STRIP 6D PL	17	
-	1	1	1338708-1	SPACER, SLUG BLADE	16	
-	1	1	1-690481-0	SPACER, HOLD DOWN	13	
-	1	1	23846-1	SPRING, HOLD DOWN	12	
-	1	1	240833-3	PLATE, REAR SHEAR	11	
-	1	1	690482-3	PLATE, FRONT SHEAR	9	
-	1	2	1	1333221-7	ANVIL	8
-	1	1	690474-3	BLADE, SLUG	7	
-	1	1	1-455892-4	HOLD DOWN, TERMINAL	6	
-	1	1	2-240641-2	SPACER, SLUG BLADE	5	
-	1	1	238009-1	SPACER, BLOCK CRIMPER	4	
-	1	2	1	8-683453-1	CRIMPER, INSULATION	3
-	1	1	455888-1	SPACER, CRIMPER	2	
-	1	2	1	456410-4	CRIMPER, WIRE	1
-	77	71	-1			

DIMENSIONS: mm [INCHES]	MATL	HT TR	FIN
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			
DR 20AUG01	APP 20AUG01	AMP Incorporated Harrisburg, PA 17105-3608	
L. LOTHOUSE	F. BACKHURST		
CHK -	REL 19-09-01	M. CLIFFORD	
NAME		MACHINE REF	
END FEED HD-I APPLICATOR		HD-I APPL	
SCALE	DWG NO	SHEET	REV
	1339581	1 OF 1	B
CASE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING			

THIS DRAWING IS A CONTROLLED DOCUMENT.

LAYOUT L1339581
SET UP GAGE 458638-3

2000
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