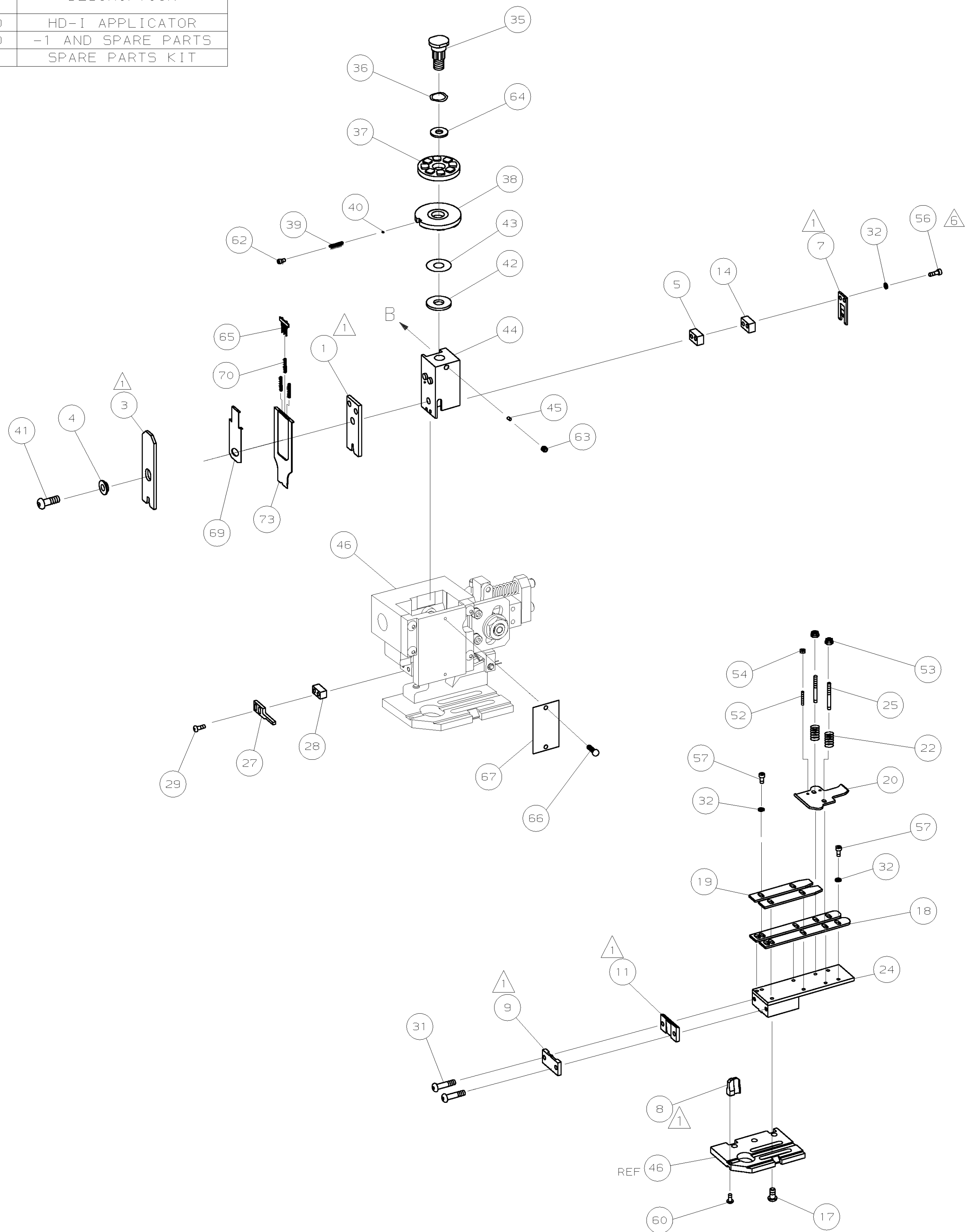




1. RECOMMENDED SPARE PARTS.
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
4. ALL CRIMP DATA CALCULATED BY TYCO ELECTRONICS UK LTD.
5. RANGE QUOTED IS THAT OF THE APPLICATOR, NOT THE TERMINAL.
6. CUT TO LENGTH AT ASSY.



|     |     |    |             |                              |         |
|-----|-----|----|-------------|------------------------------|---------|
| -   | 1   | 1  | 1490525-1   | DEPRESSOR, WIRE              | 73      |
| -   | 1   | 1  | 1339754     | PRINT, APPLICATOR LOG SHEET  | 72      |
| -   | 1   | 1  | 1338705-2   | DOCUMENTATION PACKAGE        | 71      |
| -   | 3   | 3  | 2-23147-2   | SPRING, DEPRESSOR            | 70      |
| -   | 1   | 1  | 1490524-2   | SPACER, DEPRESSOR            | 69      |
|     |     |    |             |                              | 68      |
| -   | 1   | 1  | 461264-1    | PLATE, IDENTIFICATION        | 67      |
| -   | 2   | 2  | 21017-2     | SCR,DRIVE (#2X.19) ID PLATE  | 66      |
| -   | 1   | 1  | 1424350-1   | HOLDER, PIN, WIRED           | 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  | 1-18023-5   | SCR,SHC (M4X25) SLUG BLADE   | 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  | 1338662-1   | 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  | 1320922-1   | 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  | 3-690451-2  | SPACER, STRIPPER             | 28      |
| -   | 1   | 1  | 240639-1    | STRIPPER                     | 27      |
|     |     |    |             |                              | 26      |
| -   | 2   | 2  | 1320906-1   | DRAG, STUD                   | 25      |
| -   | 1   | 1  | 1320995-1   | PLATE, 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  | 1338663-3   | GUIDE, LOWER STRIP           | 18      |
| -   | 4   | 4  | 1-18024-8   | SCR,BHC (M6X12) STRIP GD PL  | 17      |
|     |     |    |             |                              | 16      |
|     |     |    |             |                              | 15      |
| -   | 1   | 1  | 2-240641-6  | SPACER, SLUG BLADE           | 14      |
|     |     |    |             |                              | 13      |
|     |     |    |             |                              | 12      |
| -   | 1   | 1  | 240644-1    | PLATE, REAR SHEAR            | 11      |
|     |     |    |             |                              | 10      |
| -   | 1   | 1  | 690482-4    | PLATE, FRONT SHEAR           | 9       |
| 1   | 2   | 1  | 2-1333223-6 | ANVIL                        | 8       |
| 1   | 1   | 1  | 690474-4    | BLADE, SLUG                  | 7       |
|     |     |    |             |                              | 6       |
| -   | 1   | 1  | 240641-2    | SPACER, SLUG BLADE           | 5       |
| -   | 1   | 1  | 3-238009-3  | SPACER, BLOCK CRIMPER        | 4       |
| 1   | 2   | 1  | 6-1213077-0 | CRIMPER, INSULATION          | 3       |
|     |     |    |             |                              | 2       |
| 1   | 2   | 1  | 456426-1    | CRIMPER, WIRE                | 1       |
| -77 | -71 | -1 | PART NO     | DESCRIPTION                  | ITEM NO |

← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

|                   |  |                                        |  |                                                           |  |                          |  |                                                |  |
|-------------------|--|----------------------------------------|--|-----------------------------------------------------------|--|--------------------------|--|------------------------------------------------|--|
|                   |  | -77-71 -1                              |  | PART NO                                                   |  | DESCRIPTION              |  | ITEM NO                                        |  |
|                   |  |                                        |  | ← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION) |  |                          |  |                                                |  |
| QTY REQD PER ASSY |  |                                        |  |                                                           |  |                          |  |                                                |  |
| PARTS LIST        |  |                                        |  |                                                           |  |                          |  |                                                |  |
|                   |  | DIMENSIONS: mm [INCHES]                |  | MATERIAL                                                  |  | HT TR                    |  | FIN                                            |  |
|                   |  | DO NOT SCALE PRINT.                    |  |                                                           |  |                          |  |                                                |  |
|                   |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | DR 155EP04                                                |  | APP 155EP04              |  |                                                |  |
|                   |  | 1 PLC DEC ±                            |  | M.CLIFFORD                                                |  | BACKHURST                |  |                                                |  |
|                   |  | 2 PLC DEC ±                            |  | CHK -                                                     |  | REL 08-10-04             |  | AMP Tyco Electronics Harrisburg, PA 17105-3608 |  |
|                   |  | 3 PLC DEC ±                            |  |                                                           |  | M.CLIFFORD               |  |                                                |  |
|                   |  | ANGLES ±                               |  | NAME                                                      |  | END FEED HD-I APPLICATOR |  | MACHINE REF                                    |  |
|                   |  | SURF TEXTURE: ✓                        |  | SCALE                                                     |  | D                        |  | HD-I APPL                                      |  |
| MC APP            |  | OCT04 DATE                             |  | REMOVE BURRS, BREAK SHARP EDGES RO.38 MAX                 |  | DWG NO                   |  | 1339754                                        |  |
|                   |  | CAGE CODE                              |  | 00779                                                     |  |                          |  | SHEET 1 of 1                                   |  |
|                   |  |                                        |  | CUSTOMER AND ASSEMBLY DRAWING                             |  |                          |  |                                                |  |
|                   |  |                                        |  | RESTRICTED TO -                                           |  |                          |  |                                                |  |