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| LOC | DIST |
|---|---|
| A | 66 |

REVISIONS

| P | LTR | DESCRIPTION | DATE | DWN | APVD |
|---|---|---|---|---|---|
| | E | ECR-07-008028 | 4-2007 | MY | GB |

| PART NUMBER | REV | FIRST USED | TERMINATOR | FEED TYPE | DESCRIPTION |
|---|---|---|---|---|---|
| 1238065-1 | E | - | LEADMAKER | MECH POST FEED | CUTS CARRIER |
| 1238065-2 | E | - | BENCH | MECH PRE FEED | CUTS CARRIER |
| 1238065-6 | E | - | LEADMAKER | MECH POST FEED | CONTINUOUS CARRIER |
| 7-1238065-1 | E | - | LEADMAKER | MECH POST FEED | -1 AND SPARE PARTS |
| 7-1238065-2 | E | - | BENCH | MECH PRE FEED | -2 AND SPARE PARTS |
| 7-1238065-6 | E | - | LEADMAKER | MECH POST FEED | -6 AND SPARE PARTS |
| 7-1238065-7 | A | - | - | - | SPARE PARTS KIT |

## CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: CONTACT, MOD IV RECEPTACLE, CRIMP SNAP-IN

| CRIMP | SIZE | TYPE | RANGE |
|---|---|---|---|
| WIRE | 1.27 [.050 IN] | F | 22-26 |
| INSUL | 1.57 [.062 IN] | 0 | .061 MAX |

WIRE STRIP LENGTH 2.77-4.37 [.109-.172 IN]

APPL INSTRUCTION 408-8322

TERMINAL - -
APPL SPEC 114-25003 -

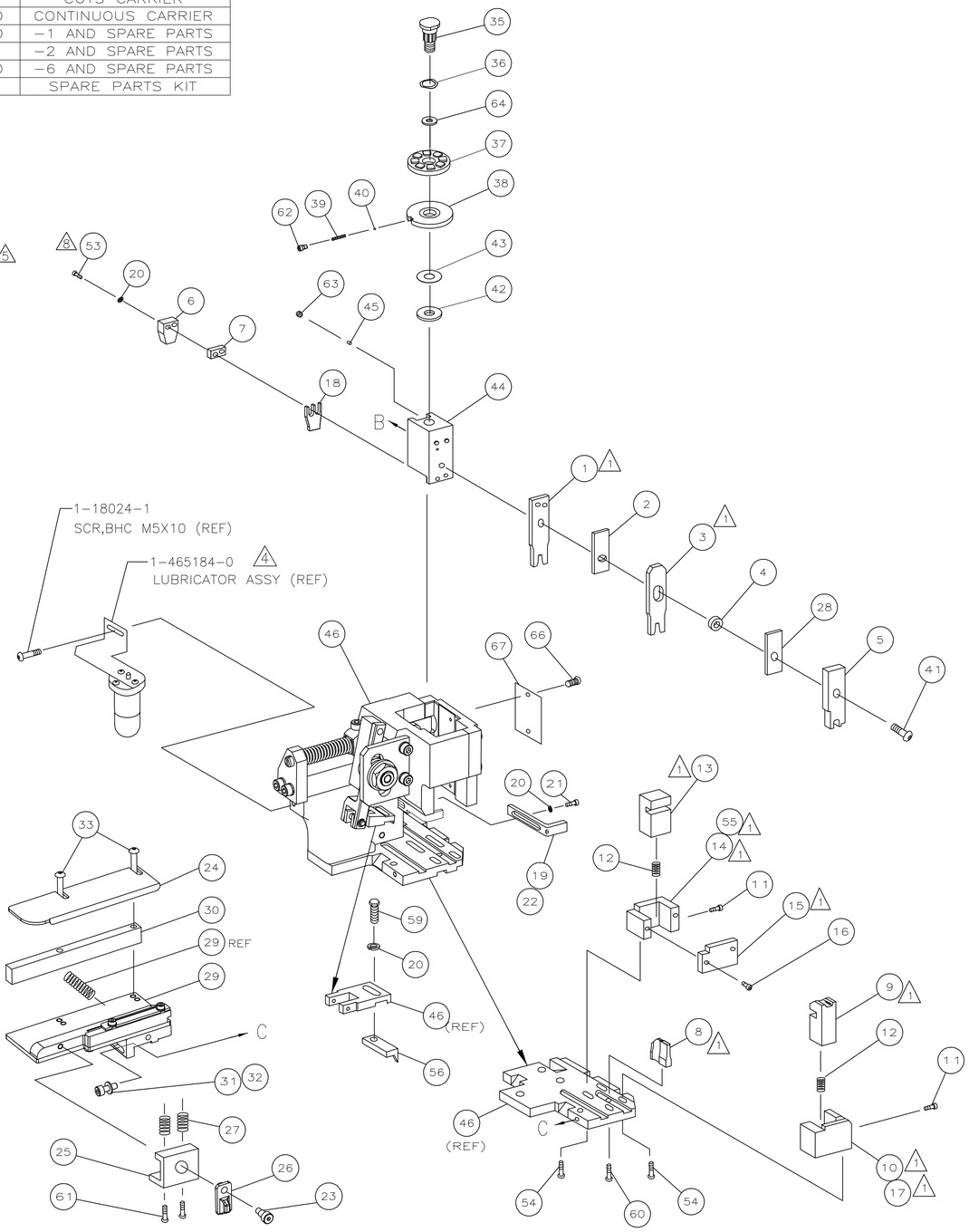
FEED 7.62[.300 IN]

### TERMINALS APPLIED

| | | | | |
|---|---|---|---|---|
| 87756 | - | - | - | - |
| 87666 | - | - | - | - |
| 87809 | - | - | - | - |
| 102548 | - | - | - | - |
| - | - | - | - | - |
| - | - | - | - | - |
| - | - | - | - | - |
| - | - | - | - | - |

| WIRE SIZE mm² AWG | CRIMP HEIGHT | PIN PN & LENGTH [IN] |
|---|---|---|
| 22 | 0.74 ±0.05 [.029 ±.002 IN] | 3-354779-2 [.3150] |
| 24 | 0.66 ±0.05 [.026 ±.002 IN] | 3-354779-9 [.3185] |
| 26 | 0.64 ±0.05 [.025 ±.002 IN] | 4-354779-2 [.3200] |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |
| - | - | - |

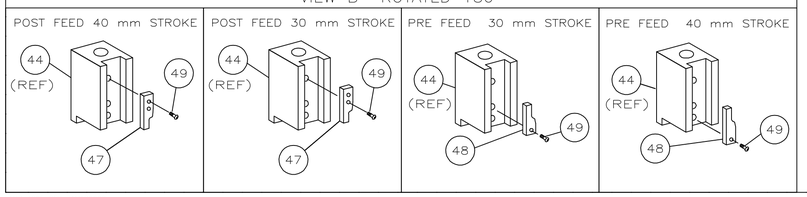
| SET UP GAGE | LAYOUT |
|---|---|
| 458637-3 | L2496 |



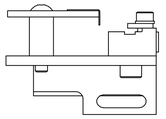

1. RECOMMENDED SPARE PARTS.
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
4. CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.
5. SPECIAL CUSTOMER REQUEST FOR CRIMP WIDTH

8. CUT TO LENGTH AT ASSY.

VIEW B ROTATED 180°




| -77 | -76 | -72 | -71 | -6 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | 73 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1238065 | PRINT, APPLICATOR LOG SHEET | 72 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1338705-1 | DOCUMENTATION PACKAGE | 71 |
| | | | | | | | | | 70 |
| | | | | | | | | | 69 |
| | | | | | | | | | 68 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 461264-1 | PLATE, IDENTIFICATION | 67 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 21017-2 | SCR,DRIVE(#2x.19)ID PLATE | 66 |
| | | | | | | | | | 65 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 986950-1 | WASHER, FLAT PRECISION | 64 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 3-18031-0 | SCR,SKT SET(M6X6)RAM | 63 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 18023-9 | SCR,SHC(M4X6)INS DISC | 62 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 2-18032-5 | SCR,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 |
| | | | | | | | | | 57 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 1 | - | - | 1 | - | - | 1338723-1 | HOLDER,SHEAR, REAR (NO CUT) | 55 |
| - | 4 | 4 | 4 | 4 | 4 | 4 | 18024-8 | SCR,BHC(M4x12)SHEAR HOLDER | 54 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 1-18023-3 | SCR,SHC(M4x16)TERM HLD DWN | 53 |
| | | | | | | | | | 52 |
| | | | | | | | | | 51 |
| | | | | | | | | | 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 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 690125-1 | WASHER, LAMINATED | 43 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 690124-4 | WASHER, RAM | 42 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2-18024-6 | SCR,BHC(M8X25)RAM | 41 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 23241-1 | BALL, STEEL | 40 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2-22278-7 | SPRING, COMPRESSION | 39 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1320922-1 | DISC, INSULATION | 38 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 354777-1 | WIRE DISC, PLASTIC | 37 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 22480-5 | WASHER, SPRING | 36 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 690212-1 | POST, RAM | 35 |
| | | | | | | | | | 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 | 1320908-9 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1633073-1 | STRIP GUIDE PLATE ASSY | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-455888-6 | 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 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 690518-2 | HOLDER, TERMINAL | 18 |
| - | 1 | - | - | 1 | - | - | 1338684-1 | HOLDER, SHEAR, FRONT (NO-CUT) | 17 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 18023-2 | SCR,SHC(M3X6)REAR SHEAR PL | 16 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-690691-1 | PLATE, SHEAR (REAR) | 15 |
| - | - | 1 | 1 | - | 1 | 1 | 1320920-1 | HOLDER, SHEAR, REAR (CUT) | 14 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 690463-1 | SHEAR, FLOAT (REAR) | 13 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 3-22280-3 | SPRING, SHEAR | 12 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 356885-4 | STOP, SHEAR | 11 |
| - | - | 1 | 1 | - | 1 | 1 | 1320921-1 | HOLDER, SHEAR, FRONT (CUT) | 10 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 462006-1 | SHEAR, FLOAT (FRONT) | 9 |
| 1 | 2 | 2 | 2 | 1 | 1 | 1 | 1338701-3 | ANVIL | 8 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 240641-5 | SPACER, DEPRESSOR (REAR) | 7 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 690468-1 | DEPRESSOR, SHEAR (REAR) | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2-455889-0 | DEPRESSOR, SHEAR (FRONT) | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 238011-7 | SPACER, BLOCK CRIMPER | 4 |
| 1 | 2 | 2 | 2 | 1 | 1 | 1 | 8-456135-3 | CRIMPER, INSULATION | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 |
| 1 | 2 | 2 | 2 | 1 | 1 | 1 | 5-568176-3 | CRIMPER, WIRE | 1 |
| | | | | | | | QTY REQD PER ASSY | PARTS LIST | |



THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ± -
1 PLC ± -
2 PLC ± 0.5 [.02 IN]
3 PLC ± -
4 PLC ± -
ANGLES ± -

MATERIAL -
FINISH -

DWN C.REICHELDERFER 31JAN01
CHK -
APVD T.ELBIN 31JAN01 NAME
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

tyco Electronics
Tyco Electronics Corporation
Harrisburg, PA 17105-3608

SIDE FEED HD-1 APPLICATOR

SIZE A1 | CAGE CODE 00779 | DRAWING NO C-1238065 | RESTRICTED TO -

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

OBSOLETE
NOT the LATEST
REVISION

AMP 4805 REV 31MAR2000