

DRAWING MADE IN THIRD ANGLE PROJECTION

| PART NUMBER | REV | FIRST USED | TERMINATOR        | FEED TYPE      | DESCRIPTION        |
|-------------|-----|------------|-------------------|----------------|--------------------|
| 1339621-1   | A   |            | BENCH & LEADMAKER | MECH POST FEED | HD-I APPLICATOR    |
| 7-1339621-1 | A   |            | BENCH & LEADMAKER | MECH POST FEED | -1 AND SPARE PARTS |
| 7-1339621-7 | A   |            | -                 | -              | SPARE PARTS KIT    |

CRIMP DATA

AMP TERMINAL

AMP CRIMP SPECS

TERMINAL NAME: CLIP SECURITE 4.8 A ENFICHAGE DOUX

| CRIMP | SIZE            | TYPE | RANGE                     |
|-------|-----------------|------|---------------------------|
| WIRE  | 2.40 [ .094 IN] | F    | 0.50-1.50mm <sup>2</sup>  |
| INSUL | 3.60 [ .142 IN] | F    | 2.60-3.50 [ .102-.138 IN] |

WIRE STRIP LENGTH

4.00-4.80 [ .157-.189 IN]

APPL INSTRUCTION

408-8323

TERMINAL

APPL SPEC

C1544291

FEED

19.50 [ .768 IN]

TERMINALS APPLIED

| WIRE SIZE           | CRIMP HEIGHT                | PIN PN AND LENGTH [IN] |
|---------------------|-----------------------------|------------------------|
| mm <sup>2</sup> AWG |                             |                        |
| 1.50mm <sup>2</sup> | 1.64 ±0.05 [ .065 ±.002 IN] | 5-354778-2 [ .2755]    |
| 1.00mm <sup>2</sup> | 1.48 ±0.05 [ .058 ±.002 IN] | 6-354778-7 [ .2830]    |
| 0.75mm <sup>2</sup> | 1.41 ±0.03 [ .056 ±.001 IN] | 7-354778-1 [ .2850]    |
| 0.50mm <sup>2</sup> | 1.33 ±0.03 [ .052 ±.001 IN] | 8-354778-1 [ .2900]    |

RECOMMENDED SPARE PARTS.

GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

CONTRADICTIONARY TO INSULATION CRIMP HEIGHT SPECIFIED ON C1544291, MAXIMUM INSULATION CRIMP HEIGHT TO BE 3.50mm FOR ALL WIRE SIZES.

TENSILE VALUE STATED ON C1544291 FOR 1.50mm<sup>2</sup> WILL NOT ACHIEVE CAPABILITY IF A STUDY IS COMPLETED.

VIEW B

ROTATED 180°

POST-FEED 40 mm STROKE

POST-FEED 30 mm STROKE

LOC

A

DIST

66

LEADMAKER OR BENCH G

K TERMINATOR BENCH MACHINE

|                                                         |    |     |             |                              |                     |         |
|---------------------------------------------------------|----|-----|-------------|------------------------------|---------------------|---------|
| -                                                       | 1  | 1   | 1339621     | PRINT, APPLICATOR LOG SHEET  | 73                  |         |
| -                                                       | 1  | 1   | 1338705-2   | DOCUMENTATION PACKAGE        | 72                  |         |
|                                                         |    |     |             |                              | 71                  |         |
|                                                         |    |     |             |                              | 70                  |         |
|                                                         |    |     |             |                              | 69                  |         |
|                                                         |    |     |             |                              | 68                  |         |
| -                                                       | 1  | 1   | 461264-1    | PLATE, IDENTIFICATION        | 67                  |         |
| -                                                       | 2  | 2   | 21017-2     | SCR,DRIVE (#2X.19) ID PLATE  | 66                  |         |
|                                                         |    |     |             |                              | 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                  |         |
| -                                                       | 2  | 2   | 1-18023-3   | SCR,SHC (M4X16) HOLD DOWN    | 58                  |         |
| -                                                       | 5  | 5   | 18023-9     | SCR,SHC (M4X6) STRIP GUIDE   | 57                  |         |
| -                                                       | 2  | 2   | 9-18023-6   | SCR,SHC (M4X14) 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 (SUBA55Y)  | 46                  |         |
| -                                                       | 1  | 1   | 690191-1    | PLUG, NYLON                  | 45                  |         |
| -                                                       | 1  | 1   | 1320998-1   | RAM                          | 44                  |         |
| -                                                       | 1  | 1   | 690125-1    | WASHER, LAMINATED            | 43                  |         |
| -                                                       | 1  | 1   | 690124-4    | 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                  |         |
| -                                                       | 9  | 9   | 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   | 1-1320995-5 | PLATE, STRIP GUIDE           | 24                  |         |
| -                                                       | 1  | 1   | 240825-1    | PLATE, STRIP HOLD DOWN       | 23                  |         |
| -                                                       | 2  | 2   | 4-22281-1   | SPRING, DRAG                 | 22                  |         |
|                                                         |    |     |             |                              | 21                  |         |
| -                                                       | 1  | 1   | 1338665-1   | DRAG, STOCK                  | 20                  |         |
|                                                         |    |     |             |                              | 19                  |         |
| -                                                       | 2  | 2   | 1338663-5   | GUIDE, LOWER STRIP           | 18                  |         |
| -                                                       | 4  | 4   | 1-18024-8   | SCR,BHC (M6X12) STRIP GD PL  | 17                  |         |
| -                                                       | 1  | 1   | 1338708-1   | SPACER, SLUG BLADE           | 16                  |         |
|                                                         |    |     |             |                              | 15                  |         |
|                                                         |    |     |             |                              | 14                  |         |
| -                                                       | 1  | 1   | 690481-2    | SPACER, HOLD DOWN            | 13                  |         |
| -                                                       | 1  | 1   | 23846-1     | SPRING, HOLD DOWN            | 12                  |         |
| -                                                       | 1  | 1   | 240644-1    | PLATE, REAR SHEAR            | 11                  |         |
|                                                         |    |     |             |                              | 10                  |         |
| -                                                       | 1  | 1   | 690496-1    | PLATE, FRONT SHEAR           | 9                   |         |
| -                                                       | 1  | 2   | 1           | 1333226-8                    | ANVIL               | 8       |
| -                                                       | 1  | 1   | 690474-6    | BLADE, SLUG                  | 7                   |         |
| -                                                       | 1  | 1   | 455892-1    | HOLD DOWN, TERMINAL          | 6                   |         |
| -                                                       | 1  | 1   | 240641-3    | SPACER, SLUG BLADE           | 5                   |         |
| -                                                       | 1  | 1   | 238009-8    | SPACER, BLOCK CRIMPER        | 4                   |         |
| -                                                       | 1  | 2   | 1           | 7-1213077-3                  | CRIMPER, INSULATION | 3       |
| -                                                       | 1  | 1   | 455888-5    | SPACER, CRIMPER              | 2                   |         |
| -                                                       | 1  | 2   | 1           | 3-1490019-3                  | CRIMPER, WIRE       | 1       |
| -                                                       | 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]                                 |    |     |             |                              |                     |         |
| 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               |    |     |             |                              |                     |         |
| CAGE CODE 00779                                         |    |     |             |                              |                     |         |
| CUSTOMER AND ASSEMBLY DRAWING                           |    |     |             |                              |                     |         |
| RESTRICTED TO                                           |    |     |             |                              |                     |         |