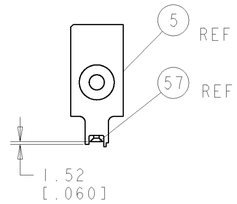
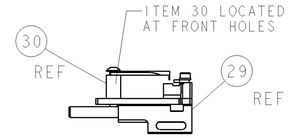
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1528569-1	B	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528569-2	B	BENCH	MECH PRE FEED	CUTS CARRIER
1528569-6	B	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528569-1	B	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528569-2	B	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528569-6	B	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528569-7	A	-	-	SPARE PARTS KIT





FEED TRACK POSITION
GUIDE BY INS. BARREL

TERMINAL SUPPORT
LOCATION

CRIMP DATA	KOSTAL TERMINAL	KOSTAL CRIMP SPEC	△6
TERMINAL NAME: SLK 2,8 STECKHULSE			

CRIMP	SIZE	TYPE	RANGE
WIRE	2.54 [.100 IN]	F	1.50-2.50mm² or 16-14 AWG
INSUL	3.94 [.155 IN]	O	2.20-3.00 [.087-.118 IN] △4

WIRE STRIP LENGTH
4.00-4.60mm [.157-.181 IN]

APPL INSTRUCTIONS
408-8322 & 408-8490

TERMINAL APPL SPEC — KOSTAL - / SLK2,8 -

FEED
13.00 [.512 IN]

TERMINALS APPLIED

TYCO TERM PN	MANU TERM PN	TYCO SEAL PN	MANU SEAL PN
1572792-1	2 21 40 49207 0	1572798-1	1 08 00 44452 3
1572792-2	2 21 24 49207 0	-	-
-	-	-	-
-	-	-	-

WIRE SIZE	CRIMP HEIGHT *	REF SETTING *
△7 2.50mm²	1.80 ±0.05 [.071 ±.002 IN]	A8
14 AWG	1.60 ±0.05 [.063 ±.002 IN]	C4
1.50mm²	1.50 ±0.05 [.059 ±.002 IN]	D1
16 AWG	1.42 ±0.05 [.056 ±.002 IN]	D7
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

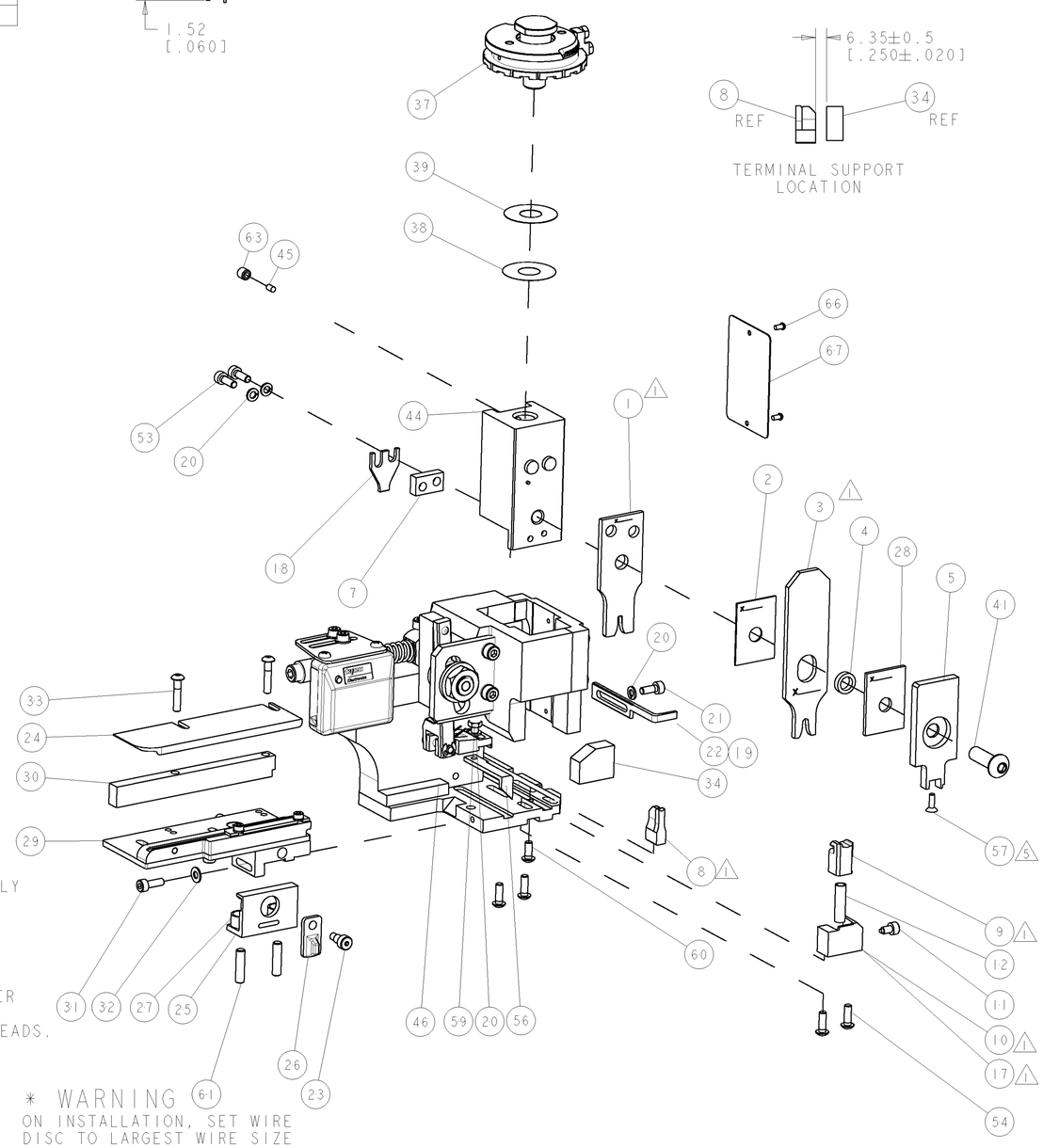
△1 RECOMMENDED SPARE PARTS
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR

△4 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL, RANGE QUOTED IS THAT OF THE TERMINAL.

△5 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

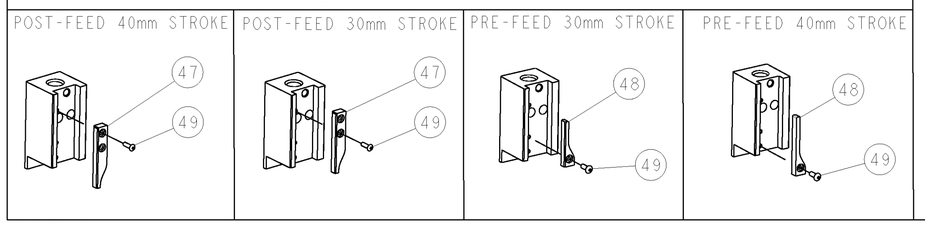
△6 ALL CRIMP DATA PROVIDED BY KOSTAL.

△7 2.5mm² CRIMP HEIGHT NOT RECOMMENDED BY TYCO ELECTRONICS.



* WARNING
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN. REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

VIEW B ROTATED 180°



-77	-76	-72	-71	-6	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	-	-	-	-				
-	-	-	-	-	-	-	-	-	83
-	-	-	-	-	-	-	-	-	82
-	-	-	-	-	-	-	-	-	81
-	-	-	-	-	-	-	-	-	80
-	-	-	-	-	-	-	-	-	79
-	-	-	-	-	-	-	-	-	78
-	-	-	-	-	-	-	-	-	77
-	-	-	-	-	-	-	-	-	76
-	-	-	-	-	-	-	-	-	75
-	-	-	-	-	-	-	-	-	74
-77	-76	-72	-71	-6	-2	-1	PART NO	DESCRIPTION	ITEM NO

SET UP GAGE
458637-3

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	SEE ECO-05-012003	21OCT2005	DP	MC
	B	ECR 06-019897	17AUG2006	MEH	GB
	B1	REVISION CORRECTION	28AUG2006	MEH	GB

-77	-76	-72	-71	-6	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	-	-	-	-	-	-	-	73
-	-	-	-	-	-	-	-	-	72
-	1	1	1	1	1	1	1338705-3	DOCUMENTATION PACKAGE	71
-	-	-	-	-	-	-	-	-	70
-	-	-	-	-	-	-	-	-	69
-	-	-	-	-	-	-	-	-	68
-	1	1	1	1	1	1	461264-5	PLATE, IDENTIFICATION	67
-	2	2	2	2	2	2	21017-2	SCREW, DRIVE	66
-	-	-	-	-	-	-	-	-	65
-	-	-	-	-	-	-	-	-	64
-	1	1	1	1	1	1	3-18031-0	SCR, SET, CUP POINT M6 X 6.0	63
-	-	-	-	-	-	-	-	-	62
-	2	2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	1	1	1	1	1	1	18024-7	SCR, BTN SKT HD CAP (M4 X 10.0)	60
-	1	1	1	1	1	1	5-18022-2	SCR, HEX HD CAP M4 X 8.0	59
-	-	-	-	-	-	-	-	-	58
-	1	1	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	-	-	-	-	-	-	-	-	55
-	4	4	4	4	4	4	18024-8	SCR, BTN SKT HD CAP (M4 X 12.0)	54
-	2	2	2	2	2	2	1-18023-2	SCR, SKT HD CAP M4 X 12.0	53
-	-	-	-	-	-	-	-	-	52
-	-	-	-	-	-	-	-	-	51
-	-	-	-	-	-	-	-	-	50
-	1	1	1	1	1	1	18024-3	SCR, BTN SKT HD CAP (M3 X 10.0)	49
-	-	1	-	-	1	-	1338675-1	CAM, UNIVERSAL PRE FEED	48
-	1	-	1	1	-	1	1338676-1	CAM, UNIVERSAL POST-FEED	47
-	1	1	1	1	1	1	1320999-3	APPLICATOR SUBASSEMBLY, HDI	46
-	1	1	1	1	1	1	690191-1	PLUG,NYLON	45
-	1	1	1	1	1	1	1338660-1	RAM	44
-	-	-	-	-	-	-	-	-	43
-	-	-	-	-	-	-	-	-	42
-	1	1	1	1	1	1	2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)	41
-	-	-	-	-	-	-	-	-	40
-	1	1	1	1	1	1	690125-1	SHIM SUB-ASSY	39
-	1	1	1	1	1	1	469367-2	SHIM	38
-	1	1	1	1	1	1	879103-2	FINE ADJUST HEAD SUBASSY	37
-	-	-	-	-	-	-	-	-	36
-	-	-	-	-	-	-	-	-	35
-	1	1	1	1	1	1	2-1320934-2	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	1-18024-0	SCR, BTN SKT HD CAP (M4 X 20.0)	33
-	1	1	1	1	1	1	18027-2	WASHER, FLAT, REG M4	32
-	1	1	1	1	1	1	1-18023-2	SCR, SKT HD CAP M4 X 12.0	31
-	1	1	1	1	1	1	1320908-1	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1	1633073-2	STRIP GUIDE ASSEMBLY	29
-	1	1	1	1	1	1	1-455888-8	SPACER, CRIMPER	28
-	2	2	2	2	2	2	1-22284-0	SPRING, COMPRESSION	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, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	-	1	1	-	1	690472-2	STRIPPER	22
-	1	1	1	1	1	1	1-18023-1	SCR, SKT HD CAP M4 X 10.0	21
-	4	4	4	4	4	4	18025-2	WASHER, SPRG LOCK, REG M4	20
-	-	1	-	-	1	-	690472-1	STRIPPER	19
-	1	1	1	1	1	1	690518-2	HOLD DOWN, TERMINAL	18
△1 -	1	-	-	1	-	-	1338684-2	HOLDER, SHEAR, NO-CUT	17
-	-	-	-	-	-	-	-	-	16
-	-	-	-	-	-	-	-	-	15
-	-	-	-	-	-	-	-	-	14
-	-	-	-	-	-	-	-	-	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	356885-5	STOP, SHEAR	11
△1 -	-	1	1	-	1	1	1-1320921-0	SHEAR HOLDER, FRONT, CUT	10
△1 -	1	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
△1 1	2	2	2	1	1	1	1633133-3	ANVIL, COMBINATION .100	8
-	1	1	1	1	1	1	1-240641-8	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	1338680-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
△1 1	2	2	2	1	1	1	3-456135-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1	455888-7	SPACER, CRIMPER	2
△1 1	2	2	2	1	1	1	2-456407-9	CRIMPER, WIRE PREMIUM	1
-77	-76	-72	-71	-6	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS: mm [IN]

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±-
1 PLC ±-
2 PLC ±-
3 PLC ±-
4 PLC ±-
ANGLES ±-

MATERIAL - -
FINISH - -

DWN M CLIFFORD 07SEP2005
CHK -
APVD F BACKHURST 07SEP2005
PRODUCT SPEC -
APPLICATION SPEC See Table
WEIGHT -
CUSTOMER DRAWING

tyco Electronics
Tyco Electronics
Harrisburg, PA 17105-3608

FINE ADJUST SIDE FEED
HDI APPLICATOR

SIZE A CAGE CODE 00779 DRAWING NO 1528569
RESTRICTED TO -
SCALE 3:5 SHEET 1 OF 1 REV B1

OBSOLETE
NOT the LATEST
REVISION