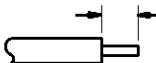
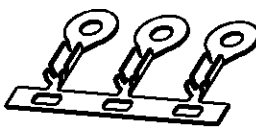
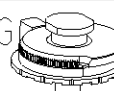
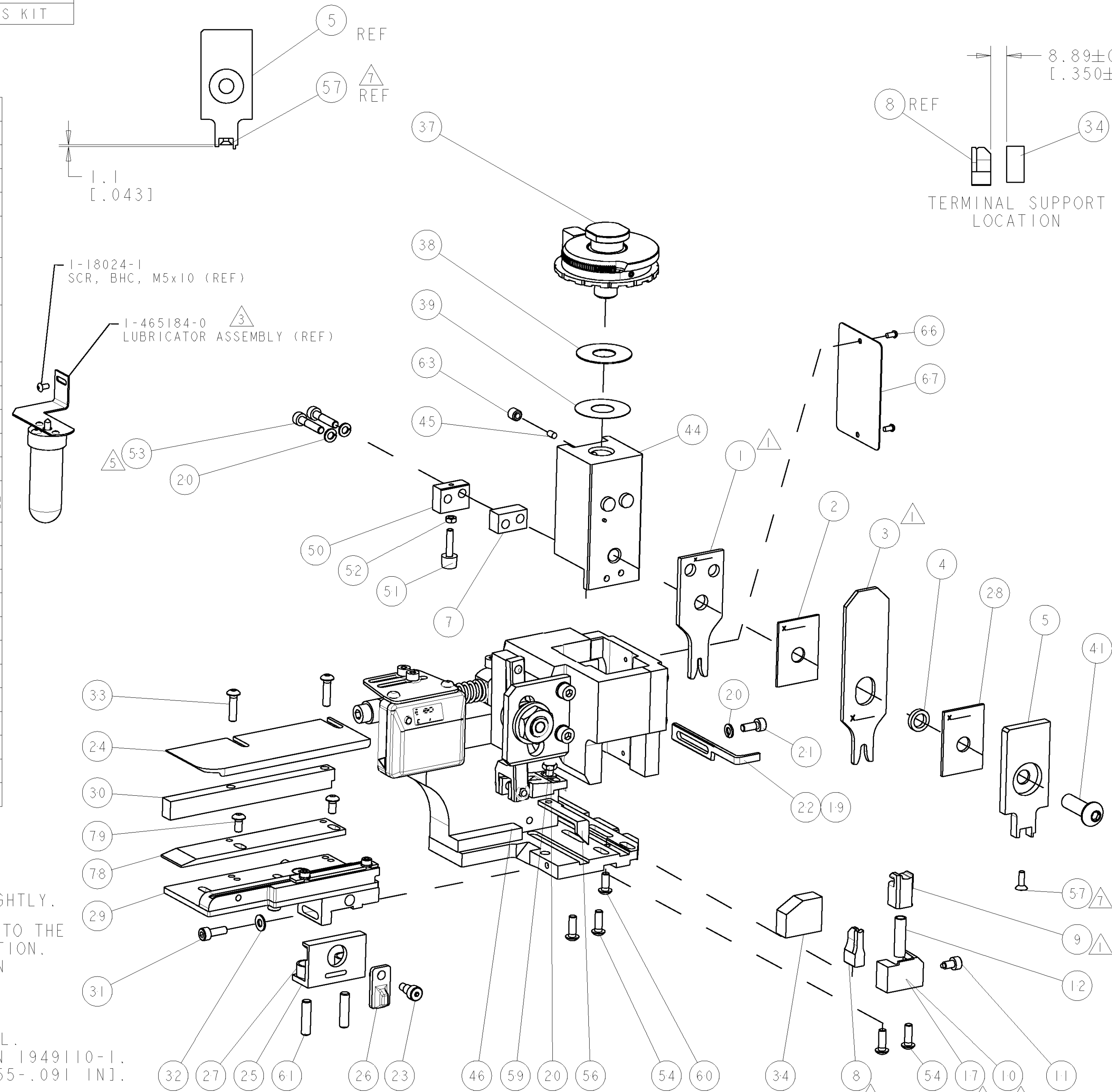


8			7		
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PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION	
1528683-1	B	LEADMAKER	MECH POST FEED	CUTS CARRIER	
1528683-2	B	BENCH	MECH PRE FEED	CUTS CARRIER	
1528683-6	B	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER	
7-1528683-1	B	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS	
7-1528683-2	B	BENCH	MECH PRE FEED	-2 AND SPARE PARTS	
7-1528683-6	B	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS	
7-1528683-7	A	-	-	SPARE PARTS KIT	

CRIMP DATA				LEAR/GHW TERMINAL		LEAR CRIMP SPECS	
TERMINAL NAME: RSA 2 PLUS PIN							
CRIMP		SIZE		TYPE		RANGE	
WIRE		2.03 [1.080 IN]		F		0.50-1.00mm ²	
INSUL		3.94 [1.155 IN]		O		1.70-2.10 [1.067-1.083 IN] 	
WIRE STRIP LENGTH SEE LEAR DATA SHT 				APPL INSTRUCTIONS 408-8322 & 408-8490 			
TERMINAL LEAR DATA SHT 26135						FEED	
APPL SPEC - -				12.70 [1.500 IN] 			
TERMINALS APPLIED 							
TYCO TERM PN		MANUF TERM PN		TYCO SEAL PN		MANUF SEAL PN	
1949109-1		26135.201.179		1949110-1		14448.627.621	
-		-		-		-	
-		-		-		-	
-		-		-		-	
WIRE SIZE 		CRIMP HEIGHT 		REF SETTING 			
1.00mm ²		1.25 ±0.05 [1.049 ±.002 IN]		B2			
0.75mm ²		1.20 ±0.05 [1.047 ±.002 IN]		B6			
0.50mm ²		1.15 ±0.05 [1.045 ±.002 IN]		C0			
-		-		-			
-		-		-			
-		-		-			
-		-		-			
-		-		-			
-		-		-			
-		-		-			
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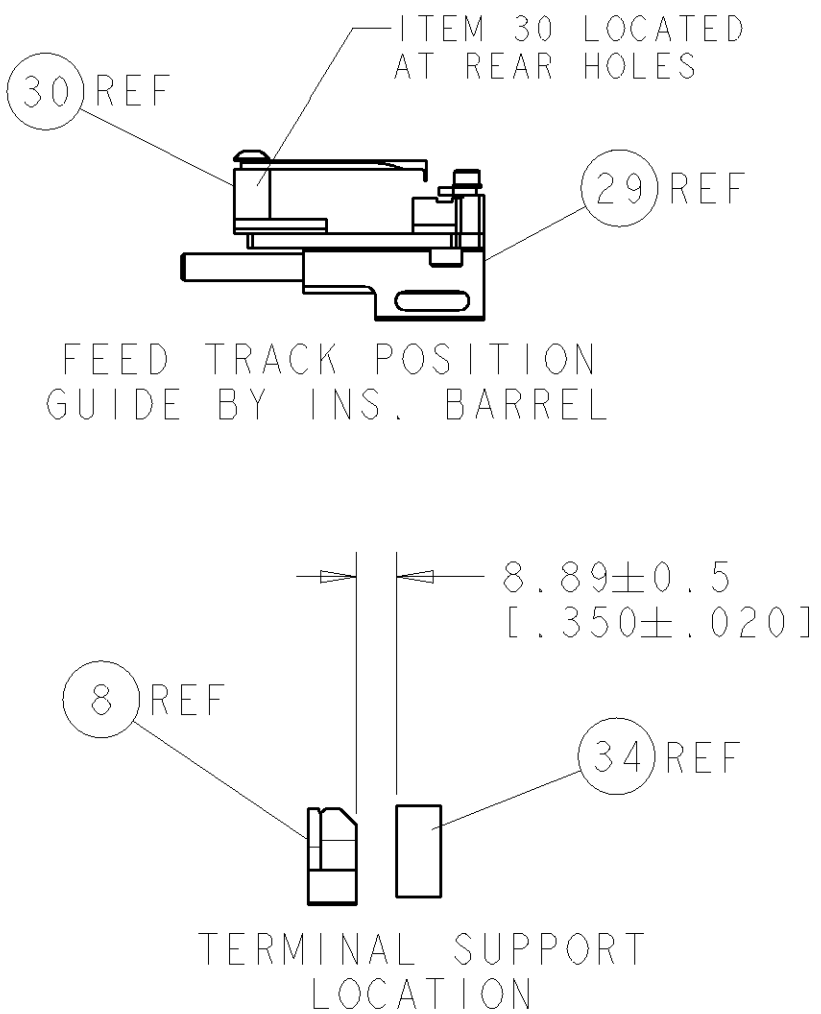
- RECOMMENDED SPARE PARTS.
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
- CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.
4. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- CUT TO LENGTH AT ASSEMBLY.
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION RANGE QUOTED IS RANGE OF SEAL PN 1949110-1. TERMINAL INSULATION RANGE IS 1.40-2.30 [1.055-1.091 IN].
- APPLY TORO-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.

VIEW B ROTATED 180°			
POST-FEED 40mm STROKE	POST-FEED 30mm STROKE	PRE-FEED 30mm STROKE	PRE-FEED 40mm STROKE



* 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.

-	-	-	-	-	-	-	-	-	-	83
-	-	-	-	-	-	-	-	-	-	82
-	-	-	-	-	-	-	-	-	-	81
-	-	-	-	-	-	-	-	-	-	80
-	2	2	2	2	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	-	79
-	1	1	1	1	1	1	525891-1	EXTENSION PLATE STRIP GUIDE ASSEMBLY	-	78
-	-	-	-	-	-	-	-	-	-	77
-	-	-	-	-	-	-	-	-	-	76
-	-	-	-	-	-	-	-	-	-	75
-	-	-	-	-	-	-	-	-	-	74
-77	-76	-72	-71	-6	-2	-1	PART NO	DESCRIPTION	ITEM NO	



SET UP GAGE
458637-3

LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		A		SEE ECO-06-020862	31AUG2006	DP	MC
		B		SEE ECR-06-022369	20SEP2006	MC	MC

-	-	-	-	-	-	-	-	-	-	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	1-18023-4	SCR, SKT HD CAP M4 X 20.0	-	53
-	1	1	1	1	1	1	18030-1	NUT, HEX, REG M3	-	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	-	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	-	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	-	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	1-469367-2	SHIM	-	38
-	1	1	1	1	1	1	879103-2	FINE ADJUST HEAD ASSEMBLY	-	37
-	-	-	-	-	-	-	-	-	-	36
-	-	-	-	-	-	-	-	-	-	35
-	1	1	1	1	1	1	1320934-9	SUPPORT, TERMINAL	-	34
-	2	2	2	2	2	2	18024-9	SCR, BTN SKT HD CAP (M4 X 16.0)	-	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	1320908-5	SPACER, STRIP GUIDE	-	30
-	1	1	1	1	1	1	1633073-2	STRIP GUIDE ASSEMBLY	-	29
-	1	1	1	1	1	1	1-455888-5	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	1320928-3	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
-	-	-	-	-	-	-	-	-	-	18
-	1	-	-	1	-	-	1338684-2	SHEAR HOLDER, FRONT	-	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	1-1320921-0	SHEAR HOLDER, FRONT, CUT	-	10
-	1	1	1	1	1	1	1-318707-0	FLOATING SHEAR, FRONT	-	9
1	2	2	2	1	1	1	2-1633131-5	ANVIL, COMBINATION .080	-	8
-	1	1	1	1	1	1	5-240641-1	SPACER	-	7
-	-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	1338680-1	DEPRESSOR, SHEAR	-	5
-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	-	4
1	2	2	2	1	1	1	683454-1	CRIMPER, INSULATION O	-	3
-	1	1	1	1	1	1	1-455888-1	SPACER, CRIMPER	-	2
1	2	2	2	1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	-	1

THIS IS DRAWING TO CHANGE THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN	01-Aug-06	Tyco Electronics		Tyco Electronics Harrisburg, PA 17103-3608	
DIMENSIONS: mm [IN]		CHK	LOFTHOUSE	NAME		FINE ADJUST SIDE FEED HDI APPLICATOR	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	M. CLIFFORD	PRODUCT SPEC		SIZE	
9 PLC ±		APPLICATION SPEC		See Table		CAGE CODE	
3 PLC ±		WEIGHT		A		DRAWING NO	
4 PLC ±		CUSTOMER DRAWING		00779		REV	
ANGLES FINISH		SCALE		3:5		SHEET	
MATERIAL		REV		B		OF	

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