| PART NUMBER | REV | FIRST USED | TERMINATOR | FEED TYPE | DESCRIPTION |
|---|---|---|---|---|---|
| 1528470-1 | D | – | LEADMAKER | MECH POST FEED | CUTS CARRIER |
| 1528470-2 | D | – | BENCH | MECH PRE FEED | CUTS CARRIER |
| 1528470-6 | D | – | LEADMAKER | MECH POST FEED | CONTINUOUS CARRIER |
| 7-1528470-1 | D | – | LEADMAKER | MECH POST FEED | -1 AND SPARE PARTS |
| 7-1528470-2 | D | – | BENCH | MECH PRE FEED | -2 AND SPARE PARTS |
| 7-1528470-6 | D | – | LEADMAKER | MECH POST FEED | -6 AND SPARE PARTS |
| 7-1528470-7 | A | – | – | – | SPARE PARTS KIT |

USED ON –

## CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: 2.3 SERIES UNSEALED TAB CONTACT

| CRIMP | SIZE | TYPE | RANGE |
|---|---|---|---|
| WIRE | 2.35 [.093 IN] | F | 0.79mm² - 1.96mm² (5) |
| INSUL | 2.85 [.112 IN] | O/V | 1.50-2.70 [.059-.106 IN]V |

WIRE STRIP LENGTH 4.50-5.50 [.177-.217 IN]

APPL INSTRUCTION 408-8322 & 408-8490

TERMINAL – – APPL SPEC 114-5324 (5) –

FEED 11.00 [.433 IN]

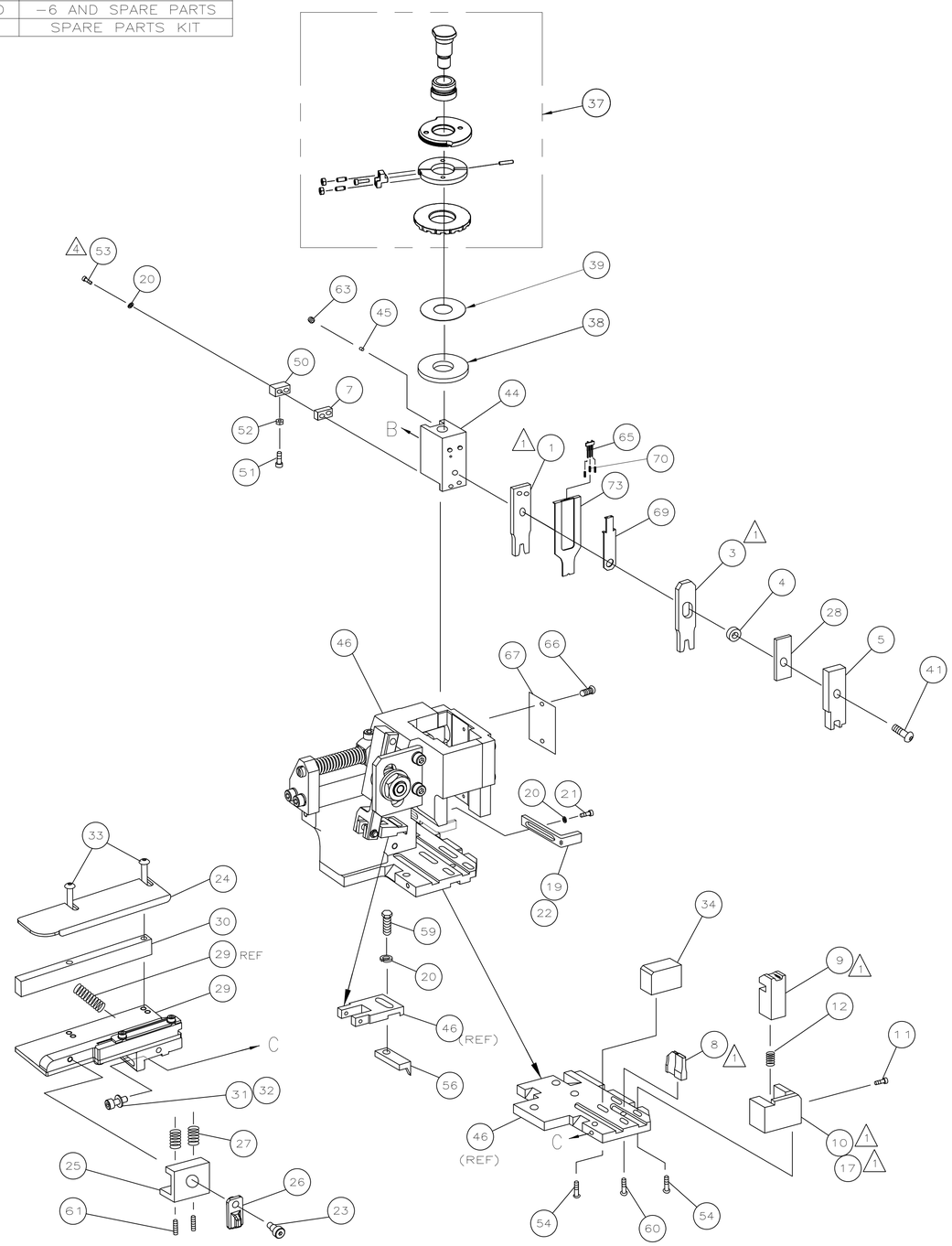
### TERMINALS APPLIED

| | | | | |
|---|---|---|---|---|
| 1612891-2 | – | – | – | – |
| – | – | – | – | – |
| – | – | – | – | – |
| – | – | – | – | – |
| – | – | – | – | – |
| – | – | – | – | – |
| – | – | – | – | – |
| – | – | – | – | – |

| WIRE SIZE mm² AWG | CRIMP HEIGHT * | REF SETTING |
|---|---|---|
| (5) 2.00mm² | 1.70 ±0.05 [.067 ±.002 IN] | B 7 |
| (5) 1.25mm² | 1.48 ±0.05 [.058 ±.002 IN] | D 2 |
| (5) 0.85mm² | 1.34 ±0.05 [.053 ±.002 IN] | E 2 |
| (5) 0.75fmm² | 1.30 ±0.05 [.051 ±.002 IN] | E 6 |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |
| – | – | – |

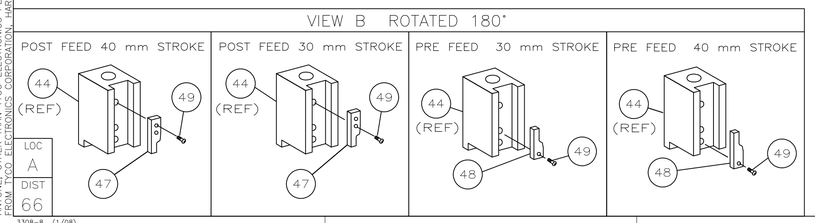
| SET UP GAGE | LAYOUT |
|---|---|
| 458637-3 | L1528468 |

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. CUT TO LENGTH AT ASSY.
5. REFER TO APPLICATION SPEC. FOR SPECIFIC WIRE DETAILS.



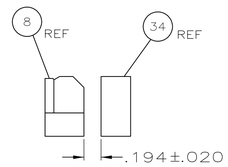

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1490525-1 | DEPRESSOR, WIRE | 73 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1528470 | PRINT, APPLICATOR LOG SHEET | 72 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1338705-3 | DOCUMENTATION PACKAGE | 71 |
| – | 3 | 3 | 3 | 3 | 3 | 3 | 1-23147-4 | SPRING, DEPRESSOR | 70 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1490524-2 | SPACER, DEPRESSOR | 69 |
| | | | | | | | | | 68 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 461264-5 | PLATE, IDENTIFICATION | 67 |
| – | 2 | 2 | 2 | 2 | 2 | 2 | 21017-2 | SCR,DRIVE(#2x.19)ID PLATE | 66 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1424350-1 | HOLDER, PIN, WIRED | 65 |
| | | | | | | | | | 64 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 3-18031-0 | SCR,SKT SET(M6X6)RAM | 63 |
| | | | | | | | | | 62 |
| – | 2 | 2 | 2 | 2 | 2 | 2 | 2-18032-5 | SCR,SKT,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 |
| | | | | | | | | | 55 |
| – | 4 | 4 | 4 | 4 | 4 | 4 | 18024-8 | SCR,BHC(M4x12)SHEAR HOLDER | 54 |
| (4) – | 2 | 2 | 2 | 2 | 2 | 2 | 1-18023-4 | SCR,SHC(M4x20)TERM HLD DWN | 53 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 18030-1 | NUT,HEX(M3)HOLD DOWN | 52 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 811242-5 | BUMPER, HOLDDOWN | 51 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 690753-2 | SPACER, TONKER | 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 |
| | | | | | | | | | 43 |
| | | | | | | | | | 42 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 992285-2 | SCR,SHC(M8X25)RAM,LOW HD | 41 |
| | | | | | | | | | 40 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 690125-1 | SHIM SUBASSY | 39 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 469367-1 | SPACER, FINE ADJUST | 38 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 879103-2 | FINE ADJUST HEAD SUBASSY | 37 |
| | | | | | | | | | 36 |
| | | | | | | | | | 35 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1320934-1 | SUPPORT, TERMINAL | 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 | 1320908-1 | SPACER, STRIP GUIDE | 30 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1633073-1 | STRIP GUIDE PLATE ASSY | 29 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 1-455888-0 | 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 |
| | | | | | | | | | 18 |
| (1) – | 1 | – | – | 1 | – | – | 1338684-2 | HOLDER, SHEAR, FRONT (NO-CUT) | 17 |
| | | | | | | | | | 16 |
| | | | | | | | | | 15 |
| | | | | | | | | | 14 |
| | | | | | | | | | 13 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 3-22280-3 | SPRING, SHEAR | 12 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 356885-5 | STOP, SHEAR | 11 |
| – | – | 1 | 1 | – | 1 | 1 | 1-1320921-0 | HOLDER, SHEAR, FRONT (CUT) | 10 |
| (1) – | 1 | 1 | 1 | 1 | 1 | 1 | 462006-6 | SHEAR, FLOAT (FRONT) | 9 |
| 1 | 2 | 2 | 2 | 1 | 1 | 1 | 6-1333225-6 | ANVIL | 8 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 2-240641-9 | SPACER, DEPRESSOR (REAR) | 7 |
| | | | | | | | | | 6 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 2-455889-0 | DEPRESSOR, SHEAR (FRONT) | 5 |
| – | 1 | 1 | 1 | 1 | 1 | 1 | 238011-9 | SPACER, BLOCK CRIMPER | 4 |
| (1) 1 | 2 | 2 | 2 | 1 | 1 | 1 | 1596587-4 | CRIMPER, INSULATION | 3 |
| | | | | | | | | | 2 |
| (1) 1 | 2 | 2 | 2 | 1 | 1 | 1 | 1463696-2 | CRIMPER, WIRE | 1 |
| | -77 | -76 | -72 | -71 | -6 | -2 | -1 | PART NO | DESCRIPTION / ITEM NO |
| | QTY REQD PER ASSY | | | | | | | | |

PARTS LIST

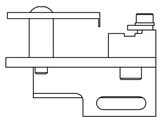



## * WARNING:

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.




ITEM 34 LOCATION



SHORT POSITION GUIDE OFF WIRE BARREL

| P | LTR | REVISION RECORD | DATE | DWN | APVD |
|---|---|---|---|---|---|
| | D | ECR-10-008734 | 4-2010 | MY | GB |

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± – ; 1 PLC ± – ; 2 PLC ± – ; 3 PLC ± – ; 4 PLC ± –

ANGLES ± – SURFACE TEXTURE –

| | | | |
|---|---|---|---|
| DWN L.LOFTHOUSE | 25NOV04 | MATERIAL – – | HEAT TREAT – – |
| CHK – | | | |
| APVD F.BACKHURST | 25NOV04 | Tyco Electronics Corporation Harrisburg, PA 17105-3608 | |
| NAME FINE ADJ SIDE FD HD-I APPL | | | |
| SCALE – | SIZE A1 | DRAWING NO 1528470 | SHEET 1 OF 1 REV D |

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

THIS DRAWING IS A CONTROLLED DOCUMENT. DWG NO 1528470

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22APR2010 12:34pm