

DRAWING MADE IN THIRD ANGLE PROJECTION

PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1528217-1	B	-	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528217-2	B	-	BENCH	MECH PRE FEED	CUTS CARRIER
1528217-6	B	-	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528217-1	B	-	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528217-2	B	-	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528217-6	B	-	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528217-7	A	-	-	-	SPARE PARTS KIT

THIS DRAWING IS A CONTROLLED DOCUMENT.

CRIMP DATA ITT CANNON TERMINAL AMP CRIMP SPECS

TERMINAL NAME: AP SERIES CONTACT, MALE DIA 2.5MM PIN.

CRIMP	SIZE	TYPE	RANGE	
WIRE	2.03 [.080 IN]	F	0.5mm ² – 1.0mm ²	
INSUL	4.06 [.160 IN]	0	1.40–2.00 [.055–.079 IN]	
WIRE STRIP LENGTH		APPL INSTRUCTION		
4.80–5.60 [.189–.220 IN]		408–8322 & 408–8490		
TERMINAL	–	–		FEED
APPL SPEC	NONE	–		14.50 [.571 IN]
TERMINALS APPLIED				
AMP TERM PN	MFR TERM PN	AMP SEAL PN	MFR SEAL PN	–
1572321–1	121668–0026	1572322–1	121668–0032	–
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WIRE SIZE	CRIMP HEIGHT		REF SETTING	
mm ² AWG	*			
1.00mm ²	1.42 ±0.05 [.056 ±.002 IN]		C7	
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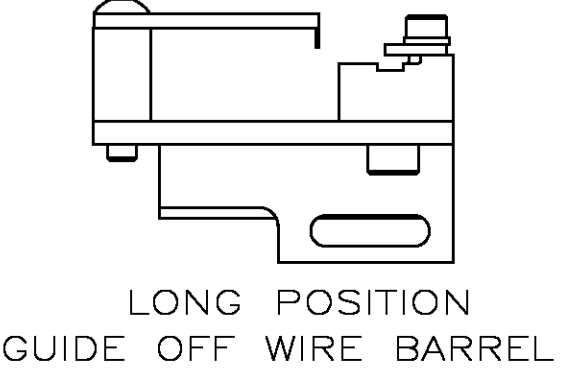
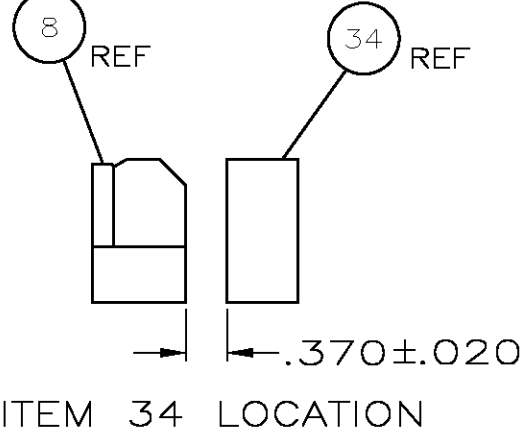
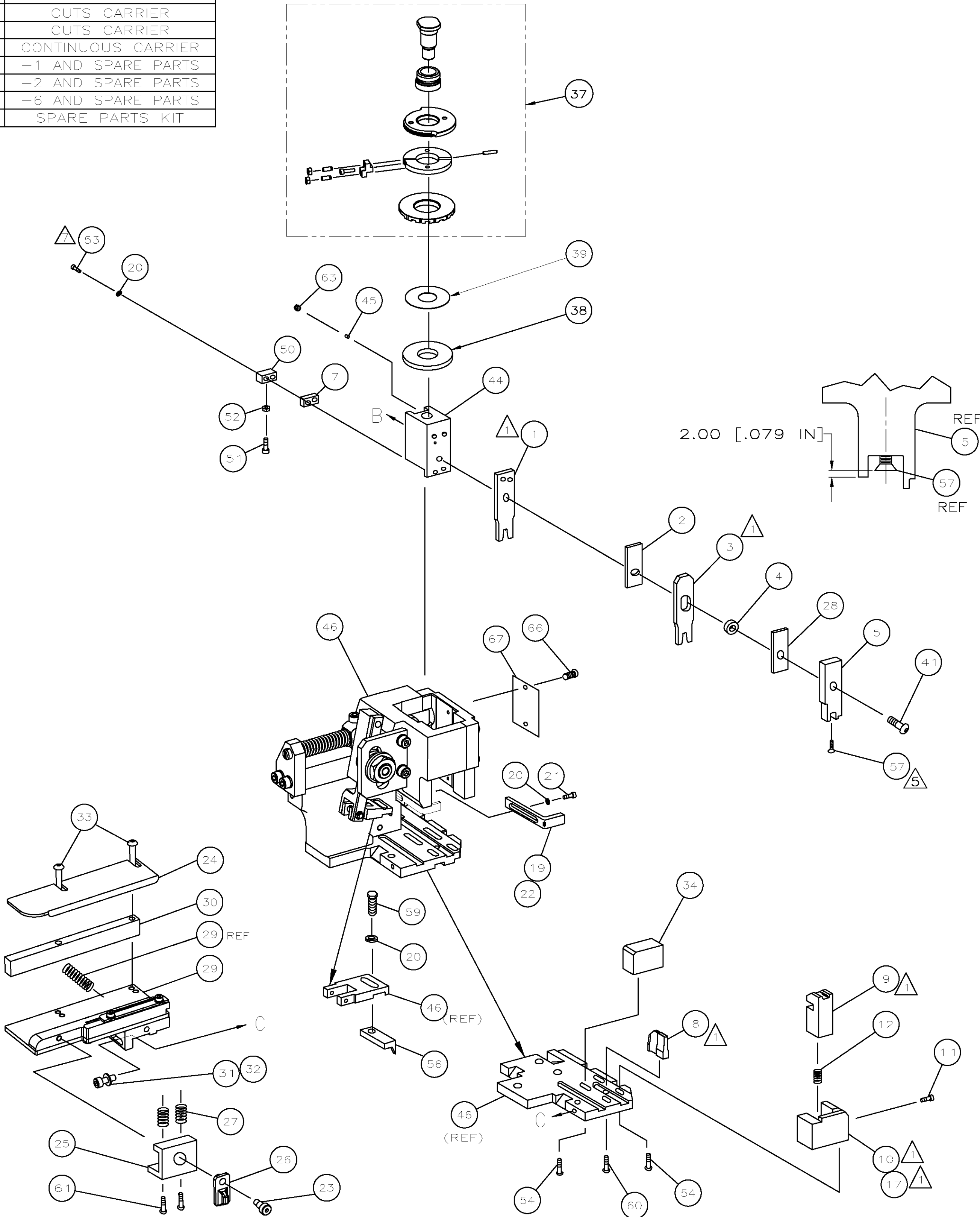
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- RECOMMENDED SPARE PARTS.
- GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
- LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- WIRE & INSULATION RANGE QUOTED IS RANGE OF TERMINAL.
- CUT TO LENGTH AT ASSY.
- CRIMP DATA CALCULATED BY TYCO.

VIEW B ROTATED 180°

POST FEED 40 mm STROKE	POST FEED 30 mm STROKE	PRE FEED 30 mm STROKE	PRE FEED 40 mm STROKE
LOC A			
DIST 66			

*** 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.



B	ECR-10-009642	SX	05MAY2010
P	REVISION	APP	DATE
F	RECORD		
L			
T			

-	1	1	1	1	1	1	1528217	PRINT, APPLICATOR LOG SHEET	72	
-	1	1	1	1	1	1	1338705-3	DOCUMENTATION PACKAGE	71	
									70	
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									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	
									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	SET,BHC(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	
-	1	1	1	1	1	1	985575-3	SCR,FHC(M3X10)DEP	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	
-	2	2	2	2	2	2	1-18023-5	SCR,SHC(M4x25)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	
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-	1	1	1	1	1	1	2-18024-6	SCR,BHC(M8X25)RAM	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	1424186-6	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	1320908-2	SPACER, STRIP GUIDE	30	
-	1	1	1	1	1	1	1633073-1	STRIP GUIDE PLATE ASSY	29	
-	1	1	1	1	1	1	1-455888-7	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	-	-	1338684-2	HOLDER, SHEAR, FRONT (NO-CUT)	17	
									16	
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									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	318707-7	SHEAR, FLOAT (FRONT)	9	
1	2	2	2	1	1	1	7-1333204-4	ANVIL	8	
-	1	1	1	1	1	1	6-240641-0	SPACER, DEPRESSOR (REAR)	7	
									6	
-	1	1	1	1	1	1	1338680-5	DEPRESSOR, SHEAR (FRONT)	5	
-	1	1	1	1	1	1	238011-4	SPACER, BLOCK CRIMPER	4	
1	2	2	2	1	1	1	9-683454-7	CRIMPER, INSULATION	3	
-	1	1	1	1	1	1	455888-8	SPACER, CRIMPER	2	
1	2	2	2	1	1	1	1-456405-3	CRIMPER, WIRE	1	
-77	-76	-72	-71	-6	-2	-1	PART NO	DESCRIPTION	ITEM NO	
							REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)			
QTY REQD PER ASSY							PARTS LIST			
SX APP	05MAY2010 DATE	DIMENSIONS: mm [INCHES] DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 1 PLC DEC ±- 2 PLC DEC ±- 3 PLC DEC ±- ANGLES ±- SURF TEXTURE:	MATL		HT TR		FIN			
			-		-		-			
			DR 29JUL03		APP 29JUL03					
			L.L.OFHOUSE		F.BACKHURST					
			CHK -		REL 18-09-03		AMP Tyco Electronics Harrisburg, PA 17105-3608			
			NAME		FINE ADJ SIDE FD HD-I APPL				MACHINE REF	
			SCALE -		D		DWG NO 1528217		SHEET 1 of 1	
CAGE CODE 00779		CUSTOMER AND ASSEMBLY DRAWING						RESTRICTED TO -		

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