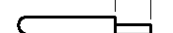


8			7	
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20			20	
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PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1531032-1	A	BENCH & LEADMAKER	MECH POST FEED	HDI APPLICATOR
7-1531032-1	A	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1531032-7	A	-	-	SPARE PARTS KIT

CRIMP DATA		TE TERMINAL		TE CRIMP SPECS	
TERMINAL NAME: .250 SRS FASTIN-ON REC. CONTACT					
CRIMP	SIZE	TYPE	RANGE		
WIRE	2.03 [.080 IN]	F	0.35-0.75mm ² or 20-22 AWG		
INSUL	3.05 [.120 IN]	F	1.45-1.91 [.057-.075 IN]		
WIRE STRIP LENGTH 4.77-5.54 [.188-.218 IN]			APPL INSTRUCTIONS 408-8323 & 408-8490		
TERMINAL APPL SPEC		114-20021 -			FEED 21.29 [.838 IN]

TERMINALS APPLIED

282178-1	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-

WIRE SIZE	CRIMP HEIGHT *	REF SETTING *
0.75mm ²	1.30 ±0.05 [.051 ±.002 IN]	B-4
0.50mm ² or 20AWG	1.24 ±0.05 [.049 ±.002 IN]	B-9
0.35mm ² or 22AWG	1.17 ±0.05 [.046 ±.002 IN]	C-4
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

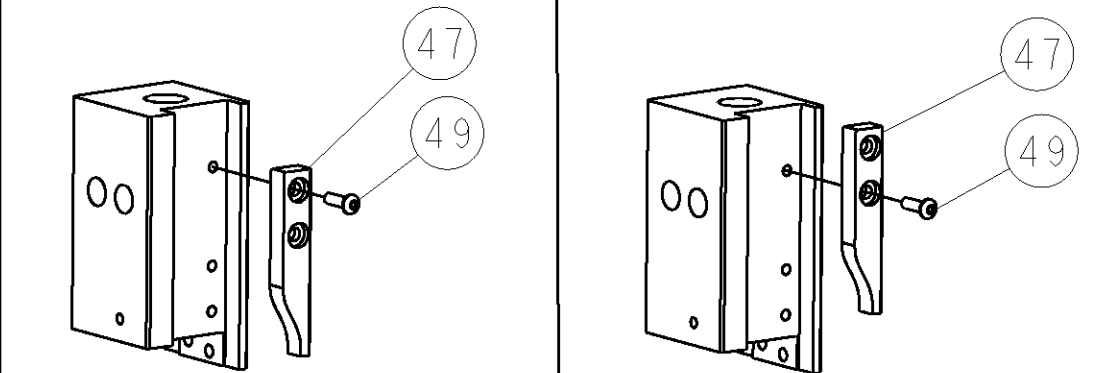


RECOMMENDED SPARE PARTS

- GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
- CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.
- LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

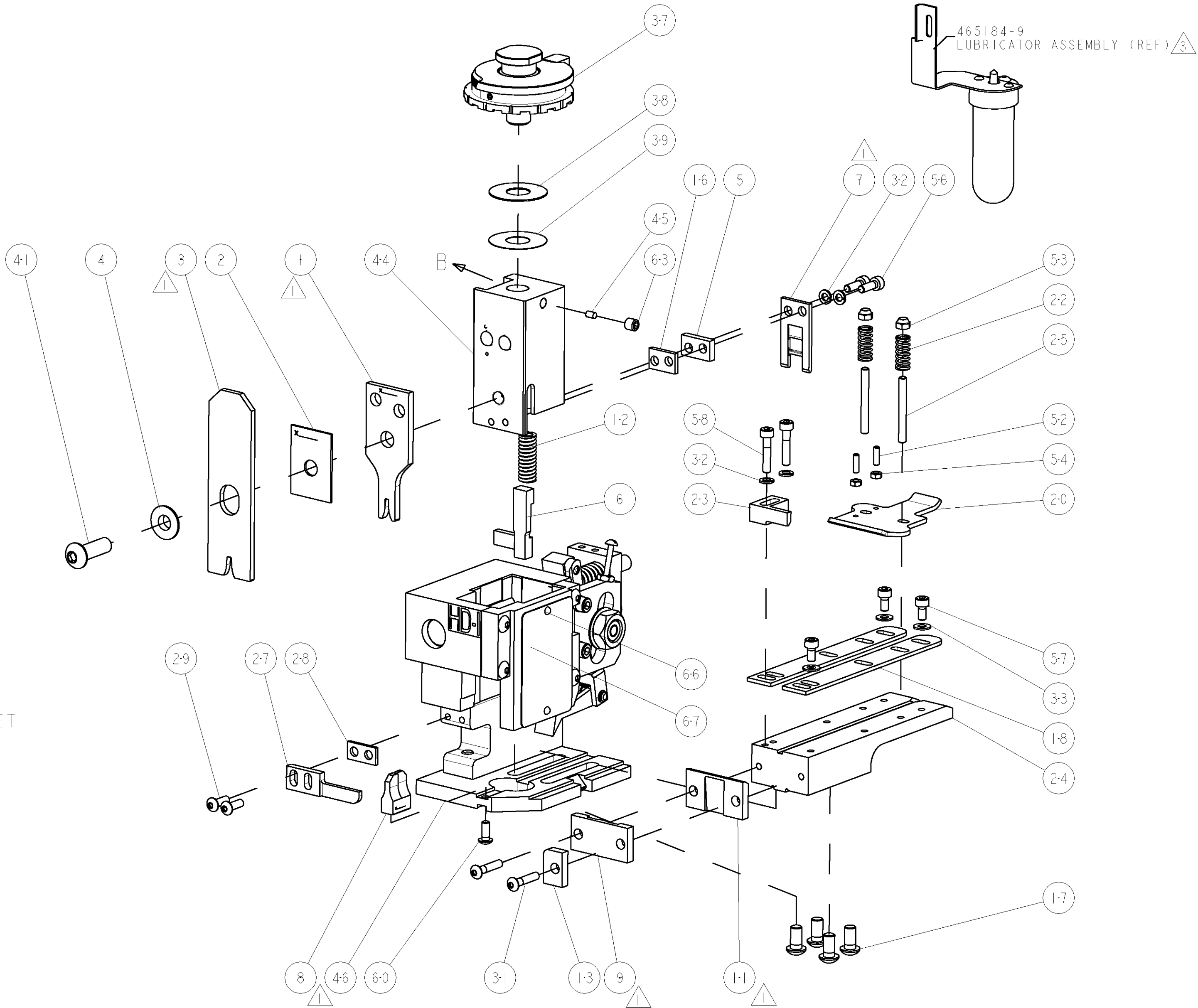
VIEW B ROTATED 180°

POST-FEED 40mm STROKE POST-FEED 30mm 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.



SET UP GAGE
458638-3

LOC		DIST		REVISONS			
F	LTR	DESCRIPTION		DATE	DWN	APVD	
A		RELEASED		27MAR2009	DWW	GB	

-	1	1	1338705-4	DOCUMENTATION PACKAGE	71
-	1	1	461264-5	PLATE, IDENTIFICATION	67
-	2	2	21017-2	SCREW, DRIVE	66
-	1	1	3-18031-0	SCR, SET, CUP POINT M6 X 6.0	63
-	1	1	18024-7	SCR, BTN SKT HD CAP (M4 X 10.0)	60
-	2	2	1-18023-4	SCR, SKT HD CAP M4 X 20.0	58
-	3	3	1-18023-0	SCR, SKT HD CAP M4 X 8.0	57
-	2	2	1-18023-2	SCR, SKT HD CAP M4 X 12.0	56
-	2	2	18029-1	NUT, HEX, REG M3	54
-	2	2	986965-1	NUT, LOCK, HEX, TORQUE (M4)	53
-	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	52
-	1	1	18024-3	SCR, BTN SKT HD CAP (M3 X 10.0)	49
-	1	1	1338676-1	CAM, UNIVERSAL POST-FEED	47
-	1	1	1338662-1	SUB ASSY, APPLICATOR FRAME	46
-	1	1	690191-1	PLUG, NYLON	45
-	1	1	1320998-1	RAM	44
-	1	1	2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)	41
-	1	1	690125-1	SHIM SUB-ASSY	39
-	1	1	1-469367-2	SHIM	38
-	1	1	879103-3	FINE ADJUST HEAD ASSEMBLY	37
-	3	3	18027-2	WASHER, FLAT, REG M4	33
-	4	4	18025-2	WASHER, SPRG LOCK, REG M4	32
-	2	2	1-18024-0	SCR, BTN SKT HD CAP (M4 X 20.0)	31
-	2	2	18024-8	SCR, BTN SKT HD CAP (M4 X 12.0)	29
-	1	1	3-690451-2	SPACER, STRIPPER	28
-	1	1	240639-1	STRIPPER (MACHINING)	27
-	2	2	1320906-1	STUD, THREADED	25
-	1	1	1320995-3	PLATE, STRIP GUIDE	24
-	1	1	240825-7	PLATE, STRIP HOLD DOWN	23
-	2	2	4-22281-1	SPRING, DRAG	22
-	1	1	1338665-1	DRAG	20
-	2	2	1338663-4	GUIDE, LOWER STRIP	18
-	4	4	1-18024-8	SCR, BTN SKT HD CAP (M6 X 12.0)	17
-	1	1	1338708-1	SPACER, SLUG BLADE	16
-	1	1	690481-2	SPACER, HOLD DOWN	13
-	1	1	23846-1	SPRING, DIE	12
-	1	1	240833-2	PLATE, REAR SHEAR	11
-	-	-	-	-	10
-	1	1	690482-4	PLATE, FRONT SHEAR	9
-	1	2	5-1633383-2	ANVIL, COMBINATION	8
-	1	1	690474-4	BLADE, SLUG	7
-	1	1	2-455892-1	HOLD DOWN, TERMINAL	6
-	1	1	6-240641-9	SPACER	5
-	1	1	238009-1	BLOCK, FL CRIMPER SPACER	4
-	1	2	1-456134-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	455888-9	SPACER, CRIMPER	2
-	1	2	2-456405-5	CRIMPER, WIRE PREMIUM	1
-	77	-71	-1	PART NO	ITEM NO

DWN D. WRIGHT 05FEB2009		Tyco Electronics Harrisburg, PA 17105-3608	
CHK G. BAILEY 05FEB2009		NAME	
APVD T. ELBIN 05FEB2009		PRODUCT SPEC	
DIMENSIONS: INCHES		APPLICATION SPEC	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		WEIGHT	
3 PLC ±.01		CUSTOMER DRAWING	
1 PLC ±0.01		SCALE 3:5	
2 PLC ±0.01		SHEET 1 OF 1	
3 PLC ±0.001		REV A	
4 PLC ±0.0001			
ANGLES ±			
FINISH			

CUSTOMER VIEWABLE ASSEMBLY

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[1531032-1](#)