
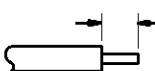


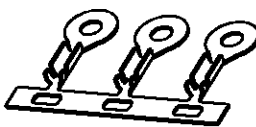
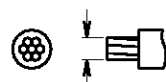

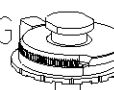
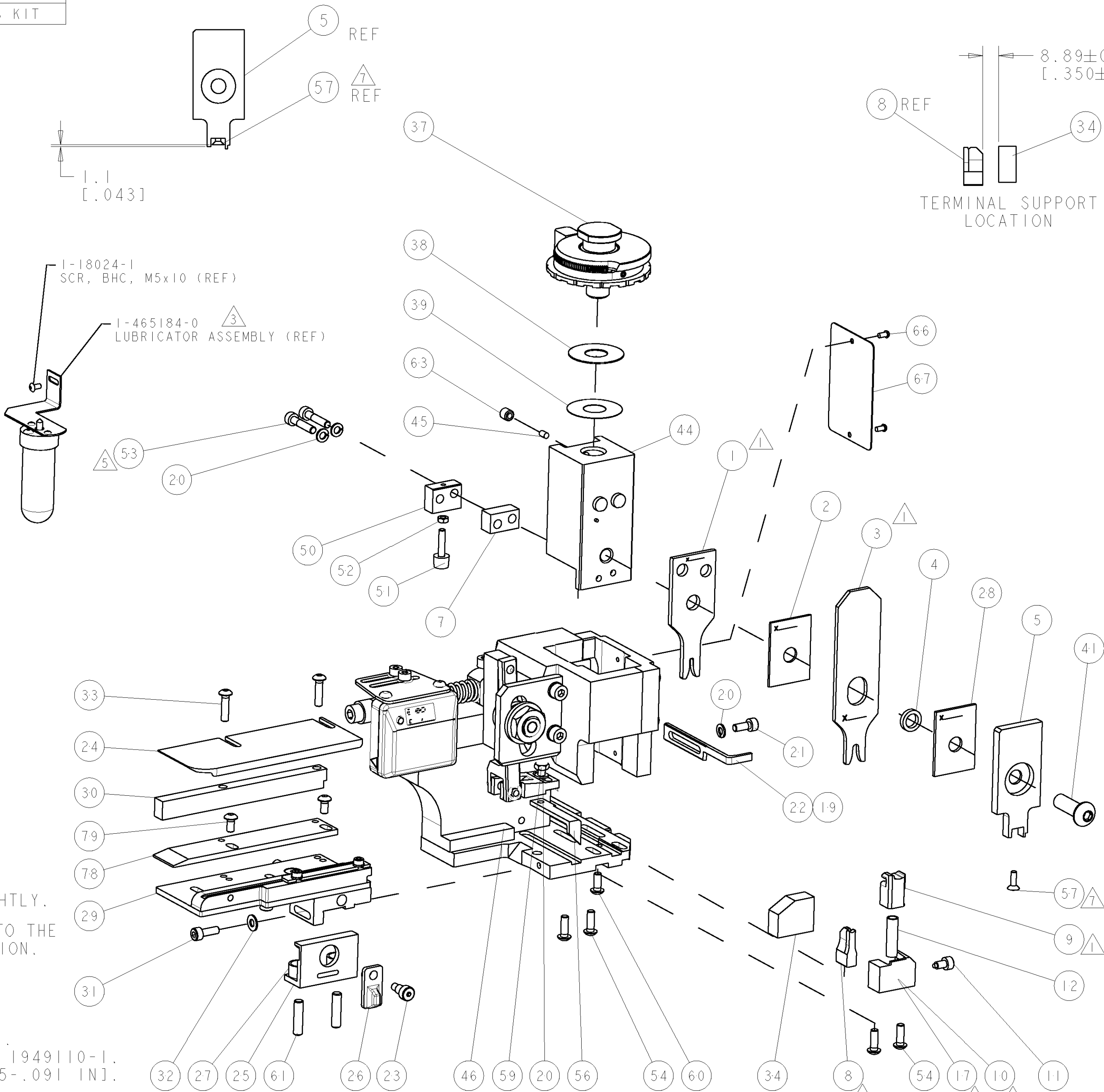


8			7		
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PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION	
1528683-1	B	LEADMAKER	MECH POST FEED	CUTS CARRIER	
1528683-2	B	BENCH	MECH PRE FEED	CUTS CARRIER	
1528683-6	B	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER	
7-1528683-1	B	LEADMAKER	MECH POST FEED	-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 12.70 [1.500 IN]	
APPL SPEC				-		-	
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		
-		-			-		
-		-			-		
-		-			-		
-		-			-		
-		-			-		
-		-			-		
-		-			-		
-		-			-		
-		-			-		
-		-			-		

- RECOMMENDED SPARE PARTS.
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
3. 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.
5. CUT TO LENGTH AT ASSEMBLY.
6. 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].
7. 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	

ITEM 30 LOCATED AT REAR HOLES

FEED TRACK POSITION GUIDE BY INS. BARREL

8.89±0.5 [1.350±.020]

TERMINAL SUPPORT LOCATION

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		Tyro Electronics Harrisburg, PA 17103-3608	
DIMENSIONS: mm [IN]		CHK	LOFHOUSE	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 B	
ANGLES FINISH		SCALE		3:5		SHEET	

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