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PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1339687-1	E	BENCH & LEADMAKER	MECH POST FEED	HDI APPLICATOR
7-1339687-1	E	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1339687-7	A	-	-	SPARE PARTS KIT

SET UP GAGE 458638-3

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	E	ECR-12-013836	02AUG2012	L.Z	S.X

CRIMP DATA	TE TERMINAL	TE CRIMP SPECS

TERMINAL NAME: 6.3 CLIP WITH LOCKING LATCH

CRIMP	SIZE	TYPE	RANGE
WIRE	3.40 [.134 IN]	F	2.50-4.00mm²
INSUL	4.19 [.165 IN]	F	2.70-3.70 [.106-.146 IN]

WIRE STRIP LENGTH 5.00-5.80 [.197-.228 IN]

APPL INSTRUCTIONS 408-8323

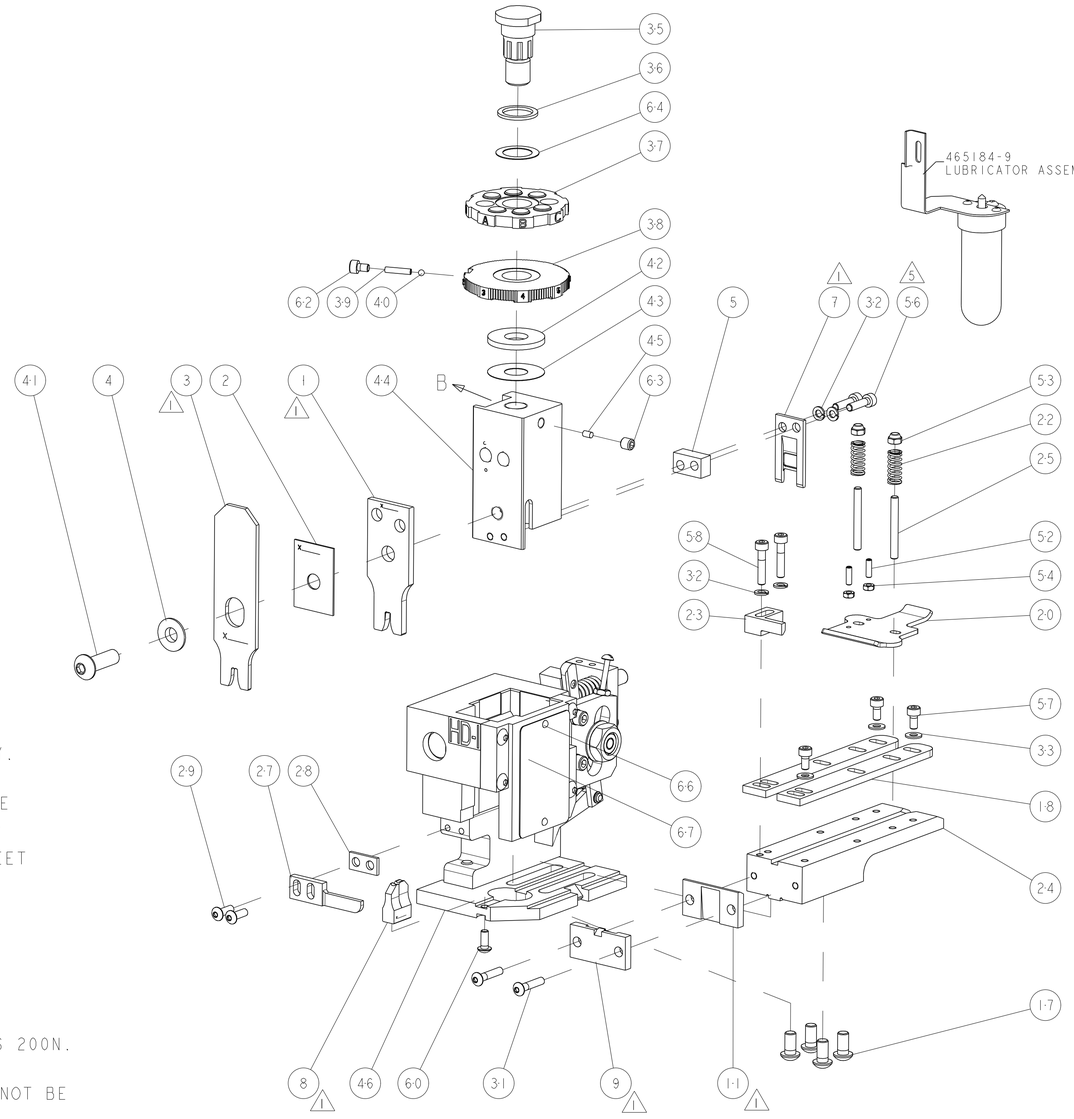
TERMINAL APPL SPEC C1544454 △6 △8 - - -

FEED 22.00 [.866 IN]

TERMINALS APPLIED

1544454	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-

WIRE SIZE	CRIMP HEIGHT	PIN PN & LENGTH [IN]
4.00mm² △7	2.61 ±0.05 [.103 ±.002 IN]	2-354778-1[.2600]
3.00mm² △6	2.39 ±0.05 [.094 ±.002 IN]	3-354778-9[.2690]
2.50mm²	2.25 ±0.05 [.089 ±.002 IN]	5-354778-0[.2745]
-	-	
-	-	
-	-	
-	-	
-	-	
-	-	
-	-	



-	1	1	1338705-2	DOCUMENTATION PACKAGE	71
-	1	1	461264-1	PLATE, IDENTIFICATION	67
-	2	2	21017-2	SCREW, DRIVE	66
-	1	1	986950-1	WASHER, FLAT PRECISION	64
-	1	1	3-18031-0	SCR, SET, CUP POINT M6 X 6.0	63
-	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	62
-	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
△5 -	2	2	1-18023-3	SCR, SKT HD CAP M4 X 16.0	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	1338662-9	SUB ASSY, APPLICATOR FRAME	46
-	1	1	690191-1	PLUG,NYLON	45
-	1	1	1320998-1	RAM	44
-	1	1	690125-1	SHIM SUB-ASSY	43
-	1	1	690124-1	WASHER, RAM (.115)	42
-	1	1	2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)	41
-	1	1	23241-1	BALL, STEEL	40
-	1	1	2-22278-7	SPRING, COMPRESSION	39
-	1	1	1320922-1	DISC, ADJUST, INSULATION CRIMP	38
-	1	1	354777-1	WIRE DISC, ASSEMBLY	37
-	1	1	22480-5	SPRING, COMPRESSION	36
-	1	1	690212-1	POST, RAM	35
-	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	1320995-6	PLATE, STRIP GUIDE	24
-	1	1	240825-1	PLATE, STRIP HOLD DOWN	23
-	2	2	4-22281-1	SPRING, DRAG	22
-	1	1	1338665-1	DRAG	20
-	2	2	1338663-8	GUIDE, LOWER STRIP	18
-	4	4	1-18024-8	SCR, BTN SKT HD CAP (M6 X 12.0)	17
△1 -	1	1	240833-4	PLATE, REAR SHEAR	11
-	-	-	-	-	10
△1 -	1	1	4-690495-6	PLATE, FRONT SHEAR	9
△1 1	2	1	4-1633383-1	ANVIL, COMBINATION	8
△1 -	1	1	690474-2	BLADE, SLUG	7
-	-	-	-	-	6
-	1	1	7-240641-2	SPACER	5
-	1	1	238009-4	BLOCK, FL CRIMPER SPACER	4
△1 1	2	1	7-1633471-1	CRIMPER, INSULATION F	3
-	1	1	455888-7	SPACER, CRIMPER	2
△1 1	2	1	9-1673600-8	CRIMPER, WIRE	1
-77	-71	-1	PART NO	DESCRIPTION	ITEM NO

△1 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.

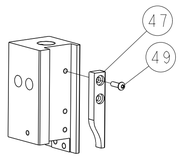
△6 SEE DRG C1544454 FOR SPECIFIC WIRE DETAILS.

△7 4.00mm² WIRE SIZE WILL NOT MEET TENSILE VALUE SHOWN ON DRG C1544454. ACHIEVABLE TENSILE VALUE IS 200N.

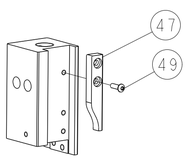
△8 INSULATION CRIMP HEIGHTS SHOWN ON DRG C1544454 CANNOT BE RECOMMENDED BY TYCO ELECTRONICS UK LTD.

VIEW B ROTATED 180°

POST-FEED 40mm STROKE



POST-FEED 30mm STROKE



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DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±0.1
2 PLC ±0.01
3 PLC ±0.001
4 PLC ±0.0001
ANGLES ±

MATERIAL - -

FINISH - -

DWN 24JAN2008 L.LOFTHOUSE
CHK - -
APVD 24JAN2008 M.CLIFFORD
PRODUCT SPEC - -
APPLICATION SPEC - -
WEIGHT -

TE Connectivity
Harrisburg, PA 17105-3608

NAME END FEED HDI APPLICATOR - -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1339687	-

CUSTOMER DRAWING | SCALE 3:5 | SHEET 1 OF 1 | REV E

CUSTOMER VIEWABLE ASSEMBLY