PART NUMBER	REV	FIRST USED	TERMINATOR	FEED TYPE	DESCRIPTION
1528173-1	C	–	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528173-2	C	–	BENCH	MECH PRE FEED	CUTS CARRIER
1528173-6	C	–	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528173-1	C	–	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528173-2	C	–	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528173-6	C	–	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528173-7	A	–	–	–	SPARE PARTS KIT

CRIMP DATA AMP TERMINAL AMP CRIMP SPECS

TERMINAL NAME: POSITIVE LOCK RECEPTACLE CONTACT

CRIMP	SIZE	TYPE	RANGE
WIRE	2.29 [.090 IN]	F	0.50mm² - 1.50mm²
INSUL	3.30 [.130 IN]	OV	1.50-2.40 [.059-.095 IN] △4

WIRE STRIP LENGTH
SEE APPL.SPECS.

APPL INSTRUCTION
408-8322 & 408-8490

TERMINAL 114-20036 (A) –
APPL SPEC 114-20029 (B) –

FEED
26.42 [1.040 IN]

TERMINALS APPLIED

282167 (A)	–	–	–	–
282162 (B)	–	–	–	–
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–
–	–	–	–	–

WIRE SIZE mm² AWG	CRIMP HEIGHT ✳	REF SETTING
1.50mm²	1.65 ±0.03 [.065 ±.001 IN]	B 9
1.00mm²	1.60 ±0.03 [.063 ±.001 IN]	C 2
0.75mm²	1.50 ±0.03 [.059 ±.001 IN]	D 0
0.50mm²	1.45 ±0.03 [.057 ±.001 IN]	D 3
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–
–	–	–

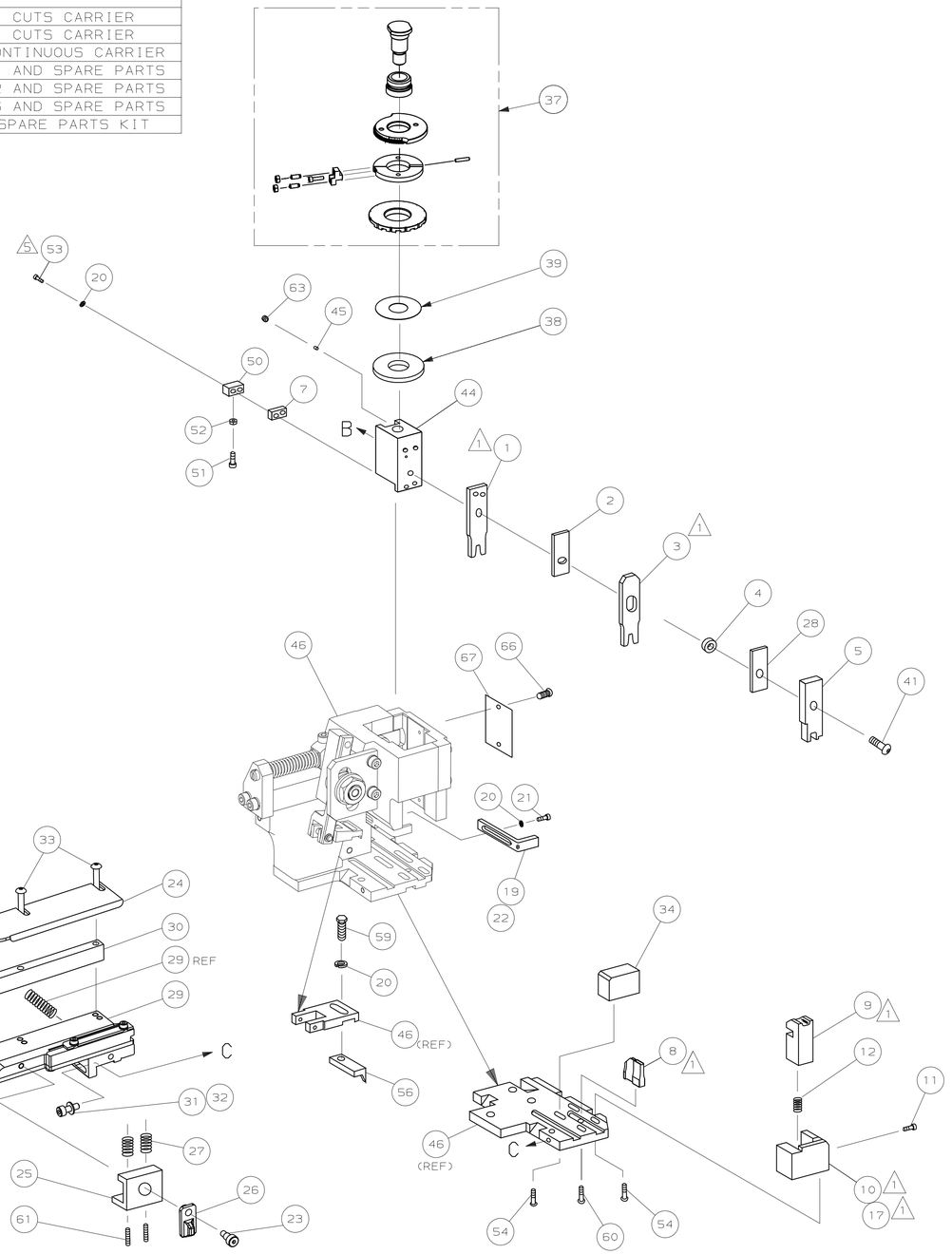
△1 RECOMMENDED SPARE PARTS.

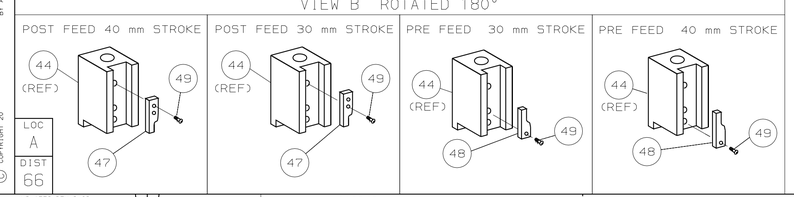
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.

3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

△4 THIS APPLICATOR HAS BEEN DESIGNED TO APPLY WIRES WITH THIN-WALL (FLR) INSULATION. THE INSULATION CRIMP AND APPLICABLE INSULATION RANGE MAY NOT CONFORM TO THE PARAMETERS LISTED IN THE APPLICATION SPEC.

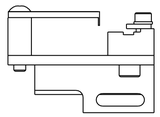
△5 CUT TO LENGTH AT ASSY.





✳ 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.



									73
–	1	1	1	1	1	1	1528173	PRINT, APPLICATOR LOG SHEET	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	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	SCR,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	1333240-1	PAWL, FEED	56
									55
–	4	4	4	4	4	4	18024-8	SCR,BHC(M4x12)SHEAR HOLDER	54
△5 –	2	2	2	2	2	2	1-18023-3	SCR,SHC(M4x16)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	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	879103-3	FINE ADJUST HEAD SUBASSY	37
									36
									35
–	1	1	1	1	1	1	1-1320934-3	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	1-1320908-0	SPACER, STRIP GUIDE	30
–	1	1	1	1	1	1	1633073-7	STRIP GUIDE PLATE ASSY	29
–	1	1	1	1	1	1	1-455888-6	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	1320928-2	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	–	–	1338684-1	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	356885-4	STOP, SHEAR	11
△1 –	–	1	1	–	1	1	1320921-1	HOLDER, SHEAR, FRONT (CUT)	10
△1 –	1	1	1	1	1	1	1-454276-7	SHEAR, FLOAT (FRONT)	9
△1 1	2	2	2	1	1	1	5-1333205-2	ANVIL	8
–	1	1	1	1	1	1	1-240641-6	SPACER, DEPRESSOR (REAR)	7
									6
–	1	1	1	1	1	1	3-455889-6	DEPRESSOR, SHEAR (FRONT)	5
–	1	1	1	1	1	1	2-238011-2	SPACER, BLOCK CRIMPER	4
△1 1	2	2	2	1	1	1	805783-3	CRIMPER, INSULATION	3
–	1	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
△1 1	2	2	2	1	1	1	1-456406-1	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

P	F	LTR	REVISION RECORD	APP	DATE
		C	ECR-06-015774	BH	JUN06
		B	SEE ECR-06-013314	MC	JUN06
		A	SEE ECN 015A-0381-03	LJL	JUL03

DIMENSIONS: mm [INCHES]
DO NOT SCALE PRINT.
TOLERANCES UNLESS OTHERWISE SPECIFIED:
1 PLC DEC ±-
2 PLC DEC ±-
3 PLC DEC ±-
ANGLES ±-
SURF TEXTURE: √
REMOVE BURRS, BREAK SHARP EDGES RO.38 MAX

MATL – | HT TR – | FIN –

DR 28MAY03 L.LOFTHOUSE | APP 28MAY03 F.BACKHURST
CHK – | REL 09JUL03 L.LOFTHOUSE

AMP Tyco Electronics Harrisburg, PA 17105-3608

NAME FINE ADJ SIDE FD HD-I APPL
MACHINE REF HD-I APPL
SCALE – | D | DWG NO 1528173 | SHEET 1 OF 1 | REV C

CAGE CODE 00779 — CUSTOMER AND ASSEMBLY DRAWING — RESTRICTED TO –

LAYOUT L1528173

SET UP GAGE 458637-3

THIS DRAWING IS A CONTROLLED DOCUMENT.

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20

© COPYRIGHT 20 BY AMP INCORPORATED. ALL RIGHTS RESERVED.