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SET UP GAGE 458638-3

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	1	DEVELOPMENT	10MAY2011	D.L	S.X

PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1531099-1	1	BENCH & LEADMAKER	MECH POST FEED	HDI APPLICATOR
7-1531099-1	1	BENCH & LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1531099-7	1	-	-	SPARE PARTS KIT

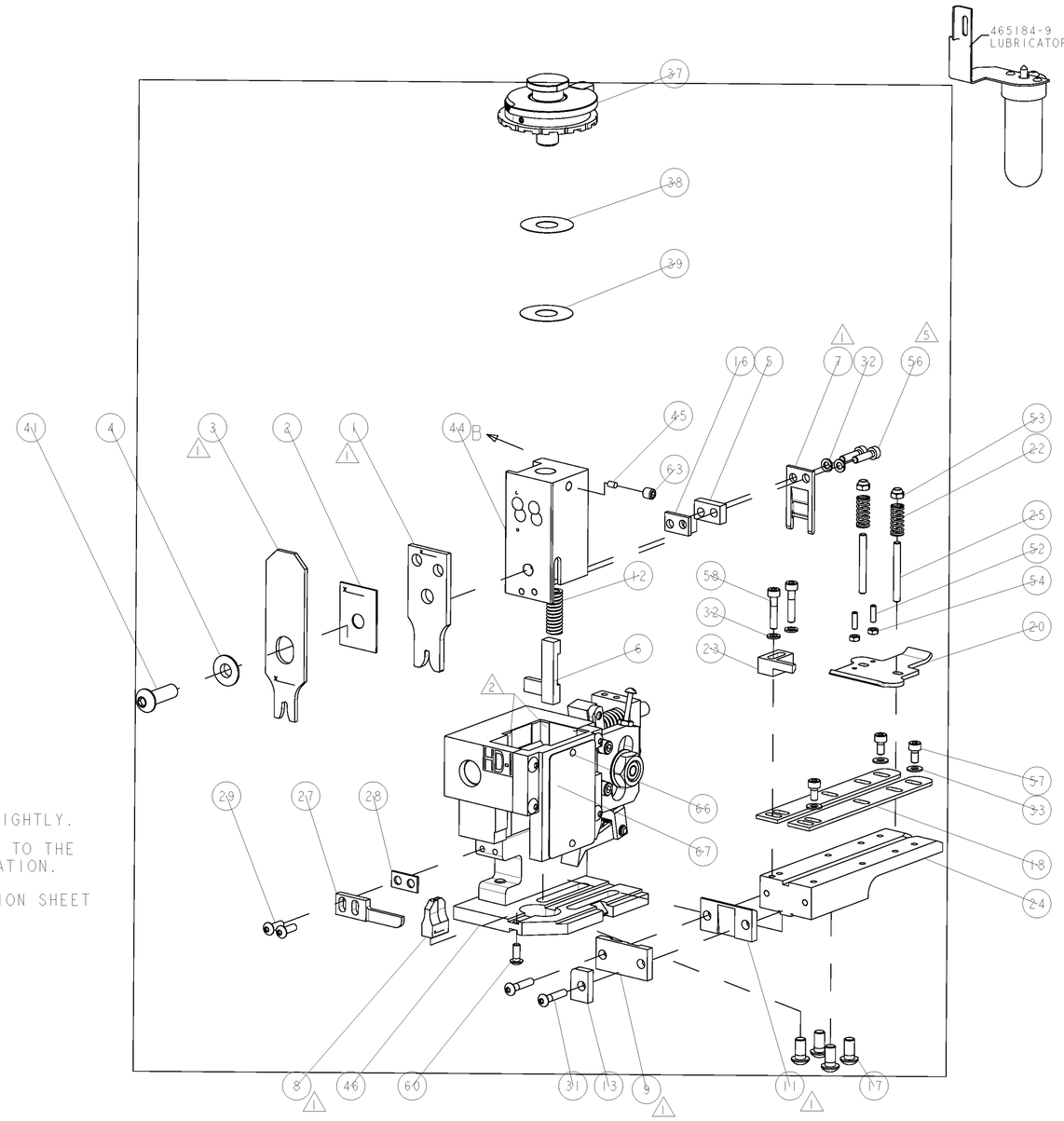
CRIMP DATA	TE TERMINAL		TE CRIMP SPECS
TERMINAL NAME: CLIP 6.35 SECURITE			
CRIMP	SIZE	TYPE	RANGE
WIRE	2.79 [.110 IN]	F	1.5-3.0 mm^2
INSUL	3.81 [.150 IN]	OV	Ø2.20-3.35 mm[.087-.132 IN]
WIRE STRIP LENGTH 5.00-5.80 [.197-.228 IN]			APPL INSTRUCTIONS 408-8323 & 408-8490
TERMINAL APPL SPEC	N/A - PRONER APPL DRG.4269 C 002		FEED 22.00 [.866 IN]

TERMINALS APPLIED

1544504	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-

WIRE SIZE	CRIMP HEIGHT *	REF SETTING *
3.00mm^2	2.40 ±0.05 [.094 ±.002 IN]	-
2.50mm^2	2.20 ±0.05 [.087 ±.002 IN]	-
2.00mm^2	1.95 ±0.05 [.077 ±.002 IN]	-
1.50mm^2	1.90 ±0.05 [.075 ±.002 IN]	-
(0.75+0.75)mm^2	1.90 ±0.05 [.075 ±.002 IN]	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

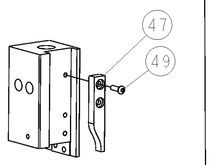
1. RECOMMENDED SPARE PARTS
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
3. CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.
4. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
5. CUT TO LENGTH AT ASSEMBLY



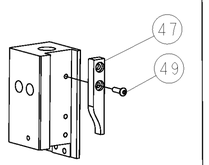
ITEM NO	DESCRIPTION	PART NO		
71	DOCUMENTATION PACKAGE	1338705-4	1	1
67	PLATE, IDENTIFICATION	461264-5	1	1
66	SCREW, DRIVE	21017-2	2	2
63	SCR, SET, CUP POINT M6 X 6.0	3-18031-0	1	1
60	SCR, BTN SKT HD CAP (M4 X 10.0)	18024-7	1	1
58	SCR, SKT HD CAP M4 X 20.0	1-18023-4	2	2
57	SCR, SKT HD CAP M4 X 8.0	1-18023-0	3	3
56	SCR, SKT HD CAP M4 X 16.0	1-18023-3	2	2
54	NUT, HEX, REG M3	18029-1	2	2
53	NUT, LOCK, HEX, TORQUE (M4)	986965-1	2	2
52	SCR, SET, FLT POINT M3 X 10.0	2-18032-2	2	2
49	SCR, BTN SKT HD CAP (M3 X 10.0)	18024-3	1	1
47	CAM, UNIVERSAL POST-FEED	1338676-1	1	1
46	SUB ASSY, APPLICATOR FRAME	1338662-1	1	1
45	PLUG,NYLON	690191-1	1	1
44	RAM	1333260-1	1	1
41	SCR, BTN SKT HD CAP (M8 X 25.0)	2-18024-6	1	1
39	SHIM SUB-ASSY	690125-1	1	1
38	SHIM	469367-1	1	1
37	FINE ADJUST HEAD ASSEMBLY	879103-3	1	1
33	WASHER, FLAT, REG M4	18027-2	3	3
32	WASHER, SPRG LOCK, REG M4	18025-2	4	4
31	SCR, BTN SKT HD CAP (M4 X 20.0)	1-18024-0	2	2
29	SCR, BTN SKT HD CAP (M4 X 12.0)	18024-8	2	2
28	SPACER, STRIPPER	2-690451-8	1	1
27	STRIPPER (MACHINING)	240639-1	1	1
25	STUD, THREADED	1320906-1	2	2
24	PLATE, STRIP GUIDE	1-1320995-3	1	1
23	PLATE, STRIP HOLD DOWN	240825-8	1	1
22	SPRING, DRAG	4-22281-1	2	2
20	DRAG	1338665-1	1	1
18	GUIDE, LOWER STRIP	1338663-4	2	2
17	SCR, BTN SKT HD CAP (M6 X 12.0)	1-18024-8	4	4
16	SPACER, SLUG BLADE	1338708-1	1	1
13	SPACER, HOLD DOWN	690481-2	1	1
12	SPRING, DIE	23846-1	1	1
11	PLATE, REAR SHEAR	240833-1	1	1
10	-	-	-	-
9	PLATE, FRONT SHEAR	690482-6	1	1
8	ANVIL, COMBINATION	3-1333219-0	2	1
7	BLADE, SLUG	690474-6	1	1
6	HOLD DOWN, TERMINAL	455892-1	1	1
5	SPACER	1-240641-4	1	1
4	BLOCK, FL CRIMPER SPACER	238009-4	1	1
3	CRIMPER, INSULATION SPECIAL	2-854830-5	2	1
2	SPACER, CRIMPER	455888-8	1	1
1	CRIMPER, WIRE PREMIUM	1-456408-8	2	1

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.

PROTOTYPE DESIGN NOT RELEASED FOR PRODUCTION

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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	D.L	10-May-11
CHK	S.X	10-May-11
APVD	S.X	10-May-11
PRODUCT SPEC	-	
APPLICATION SPEC	-	
WEIGHT	-	

TE Connectivity
Harrisburg, PA 17105-3608

PRELIMINARY

FINE ADJUST END FEED
HDI APPLICATOR
-

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1531099	-

CUSTOMER ACCESSIBLE PRODUCTION DRAWING | SCALE 3:5 | SHEET 1 OF 1 | REV 1

AMP 4805 REV 31MAR2000
Pro/ENGINEER DRAWING