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SET UP GAGE 458637-3

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	RELEASED	29JAN2010	LG	TE

PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1530207-1	A	LEADMAKER	MECH POST FEED	CUTS CARRIER
1530207-2	A	BENCH	MECH PRE FEED	CUTS CARRIER
1530207-6	A	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1530207-1	A	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1530207-2	A	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1530207-6	A	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1530207-7	A	-	-	SPARE PARTS KIT

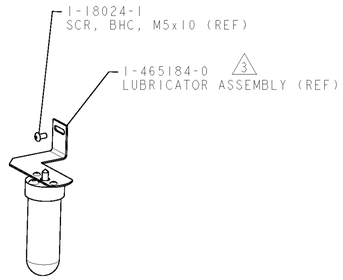
CRIMP DATA	TE TERMINAL		TE CRIMP SPECS
TERMINAL NAME: PIN CONTACT, SIZE 16 1.5 SQ. MM TO 25 SQ MM WIRE			
CRIMP	SIZE	TYPE	RANGE
WIRE	.100 IN [2.54]	F	1.5-2.5mm²
INSUL	.130 IN [3.30]	O	Ø.083-.128 IN [2.10-3.25]
WIRE STRIP LENGTH .185-.215 [4.70-5.46]			APPL INSTRUCTIONS 408-8322 & 408-8490
TERMINAL APPL SPEC	114-13045 -		FEED .500 IN [12.70]

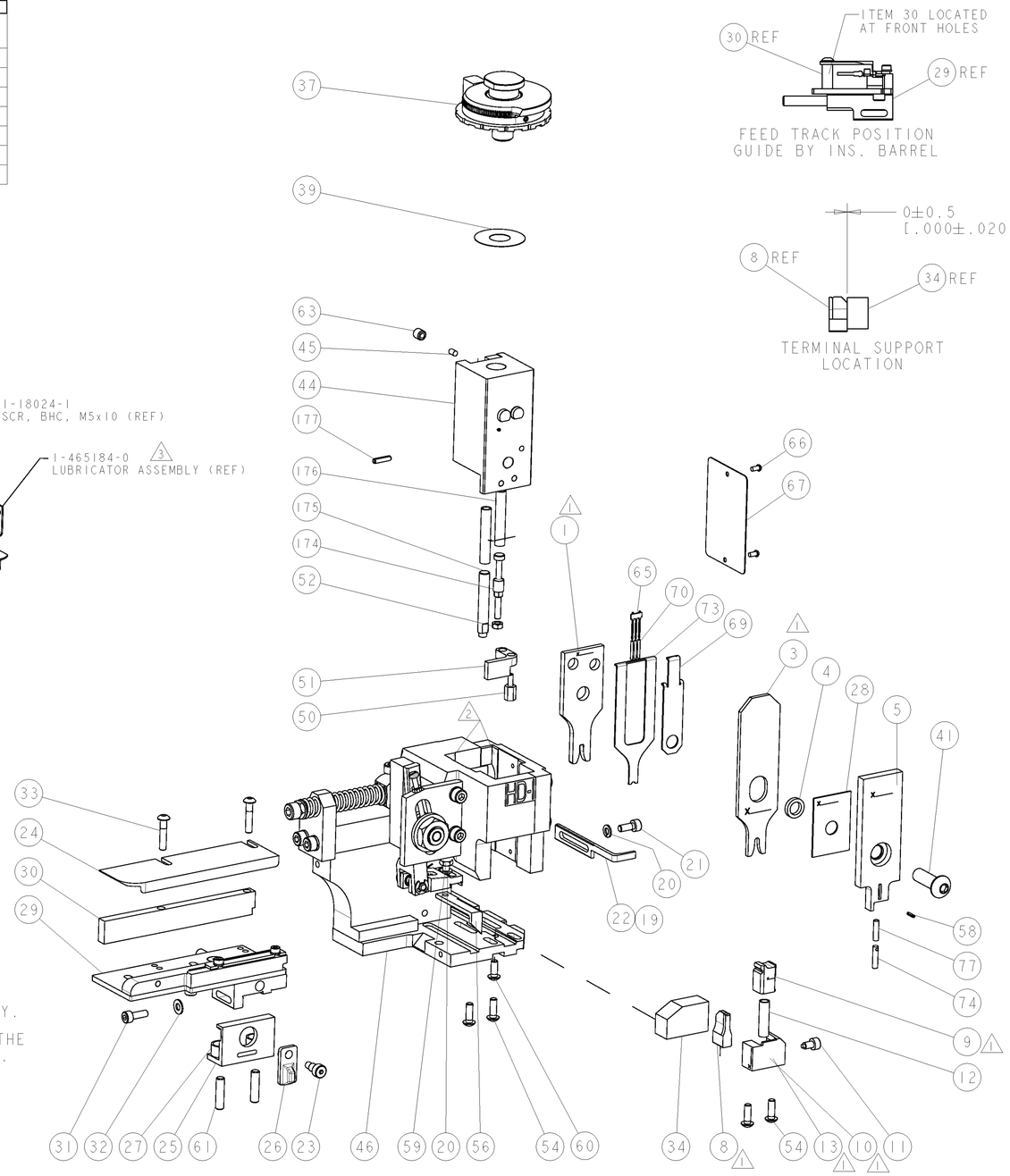
TERMINALS APPLIED

2098252	-	-	-
2098253	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-

WIRE SIZE	CRIMP HEIGHT *	REF SETTING *
2.50mm²	.072 ±.002 IN [1.83 ±0.05]	B7
14 AWG	.069 ±.002 IN [1.75 ±0.05]	C3
2.00mm²	.067 ±.002 IN [1.70 ±0.05]	C6
1.50mm²	.061 ±.002 IN [1.55 ±0.05]	D7
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-
-	-	-

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.



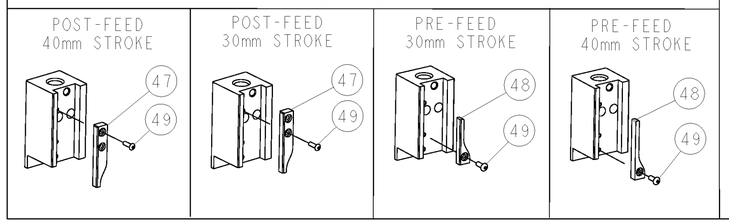


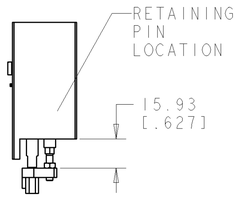
FEED TRACK POSITION GUIDE BY INS. BARREL

TERMINAL SUPPORT LOCATION

-	1	1	1	1	1	1	993111-8	PIN, SLOTTED SPRING 3.0 X 12.0	177
-	2	2	2	2	2	2	3-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1	1752353-1	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1	1	1901680-1	GUIDE PIN,HOLDDOWN	174
-	1	1	1	1	1	1	1-22278-0	SPRING, COMPRESSION	77
-	1	1	1	1	1	1	854769-1	HOLDER, INS	74
-	1	1	1	1	1	1	1490525-1	DEPRESSOR, WIRE	73
-	1	1	1	1	1	1	1338705-3	DOCUMENTATION PACKAGE	71
-	3	3	3	3	3	3	2-23147-2	SPRING, COMPRESSION	70
-	1	1	1	1	1	1	1490524-2	DEPRESSOR, SPACER	69
-	1	1	1	1	1	1	461264-5	PLATE, IDENTIFICATION	67
-	2	2	2	2	2	2	21017-2	SCREW, DRIVE	66
-	1	1	1	1	1	1	1424350-1	HOLDER, PIN, WIRED	65
-	1	1	1	1	1	1	3-18031-0	SCR, SET, CUP POINT M6 X 6.0	63
-	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
-	1	1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	18024-8	SCR, BTN SKT HD CAP (M4 X 12.0)	54
-	1	1	1	1	1	1	1-18030-0	NUT, HEX, REG M3.5	52
-	1	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1	1	1-1752354-9	STANDOFF,HOLD-DOWN	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	-	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	1633724-1	RAM, (SIDE FEED)	44
-	1	1	1	1	1	1	2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)	41
-	1	1	1	1	1	1	690125-1	SHIM SUB-ASSY	39
-	1	1	1	1	1	1	879103-2	FINE ADJUST HEAD ASSEMBLY	37
-	1	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	1-18024-0	SCR, BTN SKT HD CAP (M4 X 20.0)	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	1-1320908-0	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1	1633073-1	STRIP GUIDE ASSEMBLY	29
-	1	1	1	1	1	1	455888-7	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	1320928-2	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
-	2	2	2	2	2	2	18025-2	WASHER, SPRG LOCK, REG M4	20
-	-	1	-	-	1	-	690472-1	STRIPPER	19
1	1	-	-	1	-	-	1338684-2	SHEAR HOLDER, FRONT	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	1-1320921-0	SHEAR HOLDER, FRONT, CUT	10
1	-	1	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
1	1	2	2	2	1	1	4-1633133-1	ANVIL, COMBINATION .100	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	854772-3	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	2	2	2	1	1	1	6-456135-2	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	-	-	-	-	-	2
1	2	2	2	1	1	1	3-456407-6	CRIMPER, WIRE PREMIUM	1
-77	-76	-72	-71	-6	-2	-1	PART NO	DESCRIPTION	ITEM NO

VIEW B ROTATED 180°





HOLDDOWN SET-UP

* 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.

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS: mm [IN]

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±

MATERIAL - -
FINISH - -

DWN L.GROSS 17OCT2009
CHK T.ELBIN 17OCT2009
APVD N.DEMING 17OCT2009
PRODUCT SPEC
APPLICATION SPEC See Table
WEIGHT -

Tyco Electronics
Tyco Electronics
Harrisburg, PA 17105-3608

NAME FINE ADJUST SIDE FEED HDI APPLICATOR -

SIZE A1 | CAGE CODE 00779 | DRAWING NO C-1530207 | RESTRICTED TO -

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

AMP 4805 REV 31MAR2000

Pro/ENGINEER DRAWING