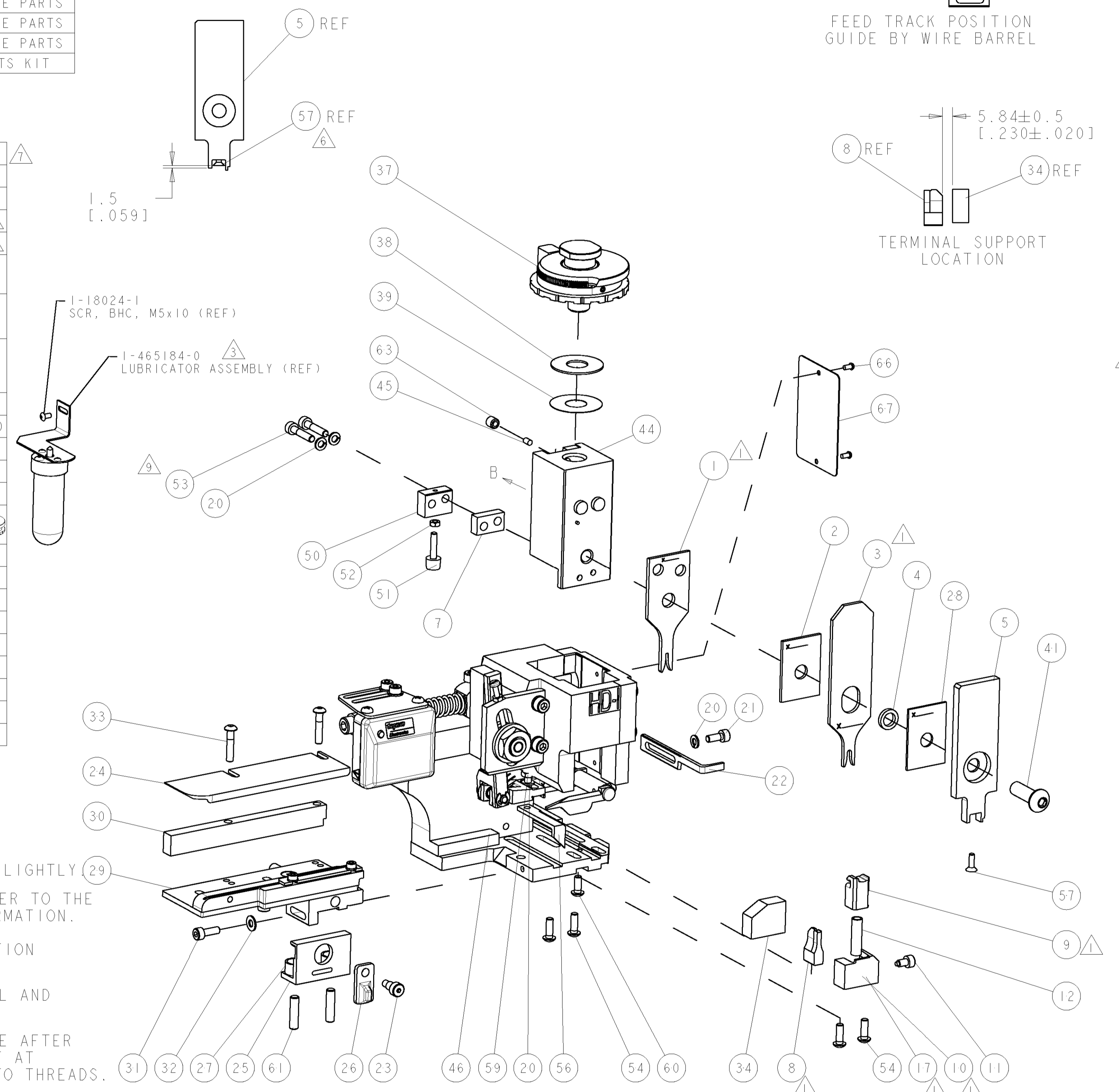


PART NUMBER	REV	TERMINATOR	FEED TYPE	DESCRIPTION
1528843-1	A	LEADMAKER	MECH POST FEED	CUTS CARRIER
1528843-2	A	BENCH	MECH PRE FEED	CUTS CARRIER
1528843-6	A	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-1528843-1	A	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-1528843-2	A	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-1528843-6	A	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-1528843-7	A	-	-	SPARE PARTS KIT

CRIMP DATA		KOSTAL TERMINAL		KOSTAL CRIMP SPECS	
TERMINAL NAME: MLK 1.2 CONTACT (SEALED)					
CRIMP	SIZE	TYPE	RANGE		
WIRE	1.40 [1.055 IN]	F	0.22-0.50mm ²		
INSUL	2.90 [1.114 IN]	O	1.10-1.60 [1.043-1.063 IN]		
WIRE STRIP LENGTH		APPL INSTRUCTIONS			
3.10-3.40 [1.22-1.34 IN]		408-8322 & 408-8490			
TERMINAL APPL SPEC		KOSTAL APPL SPEC		FEED	
DOC00061540 MAY03		DOC00061540 MAY03		8.00 [3.15 IN]	
TERMINALS APPLIED					
TE TERM PN	MANUF TERM PN	TE SEAL PN	MANUF SEAL PN		
1949519-1	3 21 24 65181 0	1949520-1	1 08 00 50725 0		
1949519-2	3 21 25 65181 0	-	-		
1949519-3	3 21 40 65181 0	-	-		
WIRE SIZE	CRIMP HEIGHT	REF SETTING			
0.50mm ²	0.90 ± 0.03 [0.035 ± 0.001 IN]	B0			
0.35mm ²	0.80 ± 0.03 [0.031 ± 0.001 IN]	B7			
0.25mm ²	0.75 ± 0.03 [0.030 ± 0.001 IN]	C0			

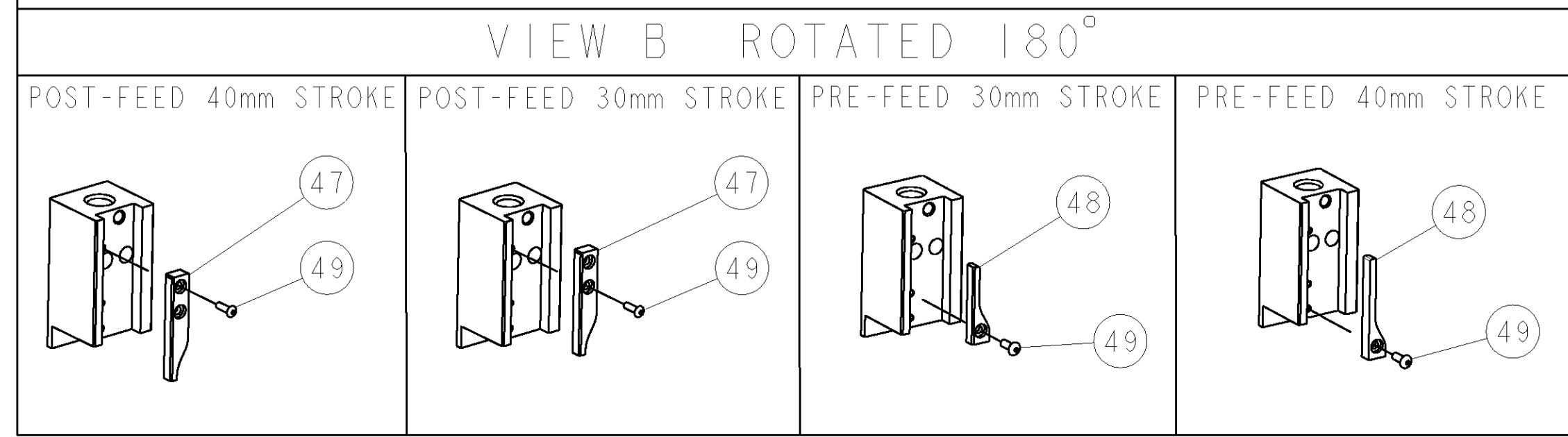
- △ RECOMMENDED SPARE PARTS.
- 2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY (29)
- △ CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.
- 4. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- △ THIS APPLICATOR APPLIES TERMINAL WITH A SEAL AND IS DESIGNED TO APPLY FLRY INSULATION TYPE.
- △ APPLY TORQ-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.
- △ CRIMP DATA SUPPLIED BY TERMINAL MANUFACTURER.
- △ WIRE AND INSULATION RANGES SHOWN ARE THAT OF THE TERMINAL.
- △ CUT TO LENGTH AT ASSEMBLY.
- △ INSULATION CRIMP HEIGHTS NOT RECOMMENDED BY TYCO ELECTRONICS UK LTD.



SET UP GAGE
458637-3

LOC	DIST	REV	DESCRIPTION	DATE	BY	APPD
A	66		SEE ECO-07-024109	12OCT2007	DP	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	1	1	1	1	1338675-1	CAM, UNIVERSAL PRE FEED		48
-	1	1	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	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	469367-7	SHIM		38
-	1	1	1	1	1	1	879103-3	FINE ADJUST HEAD ASSEMBLY		37
-	-	-	-	-	-	-	-	-	-	36
-	-	-	-	-	-	-	-	-	-	35
-	1	1	1	1	1	1	2-1320934-2	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	1320908-1	SPACER, STRIP GUIDE		30
-	1	1	1	1	1	1	1633073-2	STRIP GUIDE ASSEMBLY		29
-	1	1	1	1	1	1	1-455888-0	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	1320928-1	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	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	1	1	1	1	1424364-1	STRIPPER/ WIRE STOP ASSY		19
-	-	-	-	-	-	-	-	-	-	18
-	1	1	1	1	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	1	1-1320921-0	SHEAR HOLDER, FRONT, CUT		10
-	1	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT		9
1	2	2	2	1	1	1	1-1633128-8	ANVIL, COMBINATION .055		8
-	1	1	1	1	1	1	6-240641-5	SPACER		7
-	-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	1338680-1	DEPRESSOR, SHEAR		5
-	1	1	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER		4
1	2	2	2	1	1	1	1-904741-4	CRIMPER, INSUL O PREMIUM		3
-	1	1	1	1	1	1	1-455888-6	SPACER, CRIMPER		2
1	2	2	2	1	1	1	456402-1	CRIMPER, WIRE PREMIUM		1



* 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.

-	-	-	-	-	-	-	-	-	-	84
-	-	-	-	-	-	-	-	-	-	83
-	-	-	-	-	-	-	-	-	-	82
-	-	-	-	-	-	-	-	-	-	81
-	-	-	-	-	-	-	-	-	-	80
-	-	-	-	-	-	-	-	-	-	79
-	-	-	-	-	-	-	-	-	-	78
-	-	-	-	-	-	-	-	-	-	77
-	-	-	-	-	-	-	-	-	-	76
-	-	-	-	-	-	-	-	-	-	75
-	-	-	-	-	-	-	-	-	-	74
-77	-76	-72	-71	-6	-2	-1	PART NO	DESCRIPTION	ITEM NO	

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APPROVED:	NAME:
mm [IN]	0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	M. CLIFFORD	FINE ADJUST SIDE FEED HDI APPLICATOR
MATERIAL:	FINISH:	WEIGHT:	RESTRICTED TO:
			SIZE: CAGE CODE: DRAWING NO: 00779 C=1528843
CUSTOMER DRAWING		SCALE: 3:5	SHEET 1 OF 1 REV A