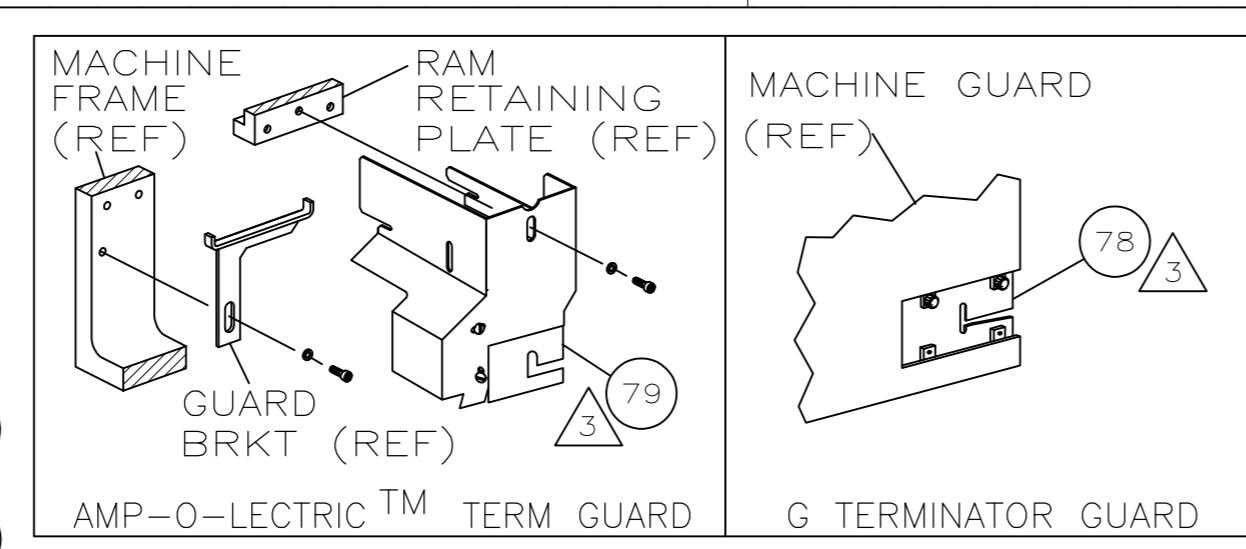
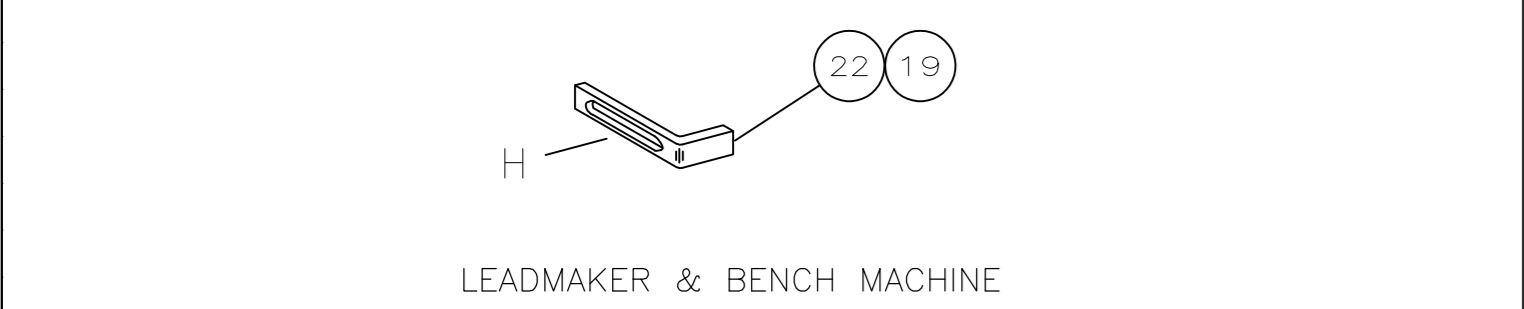
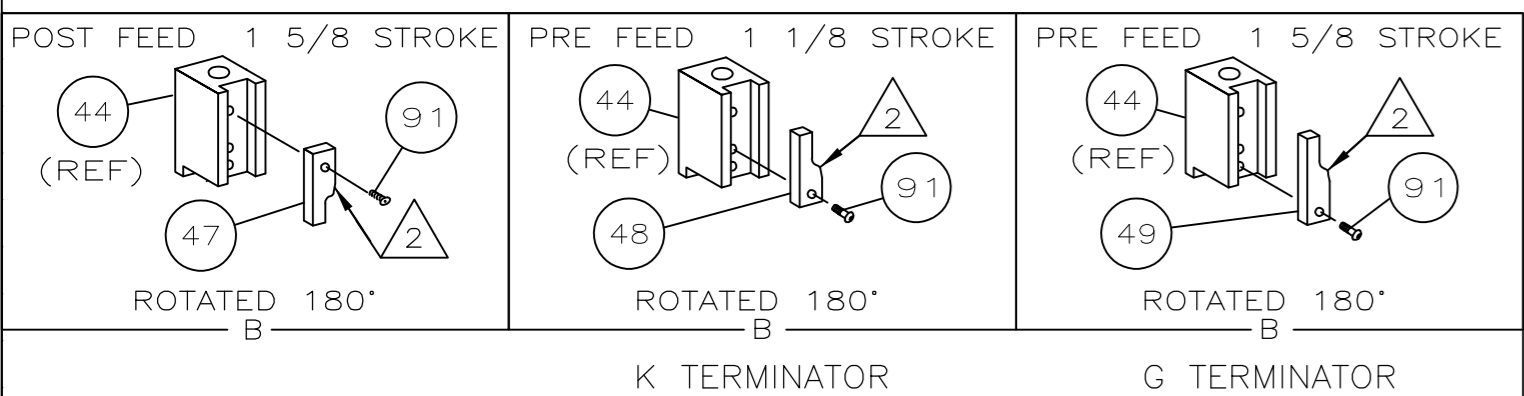
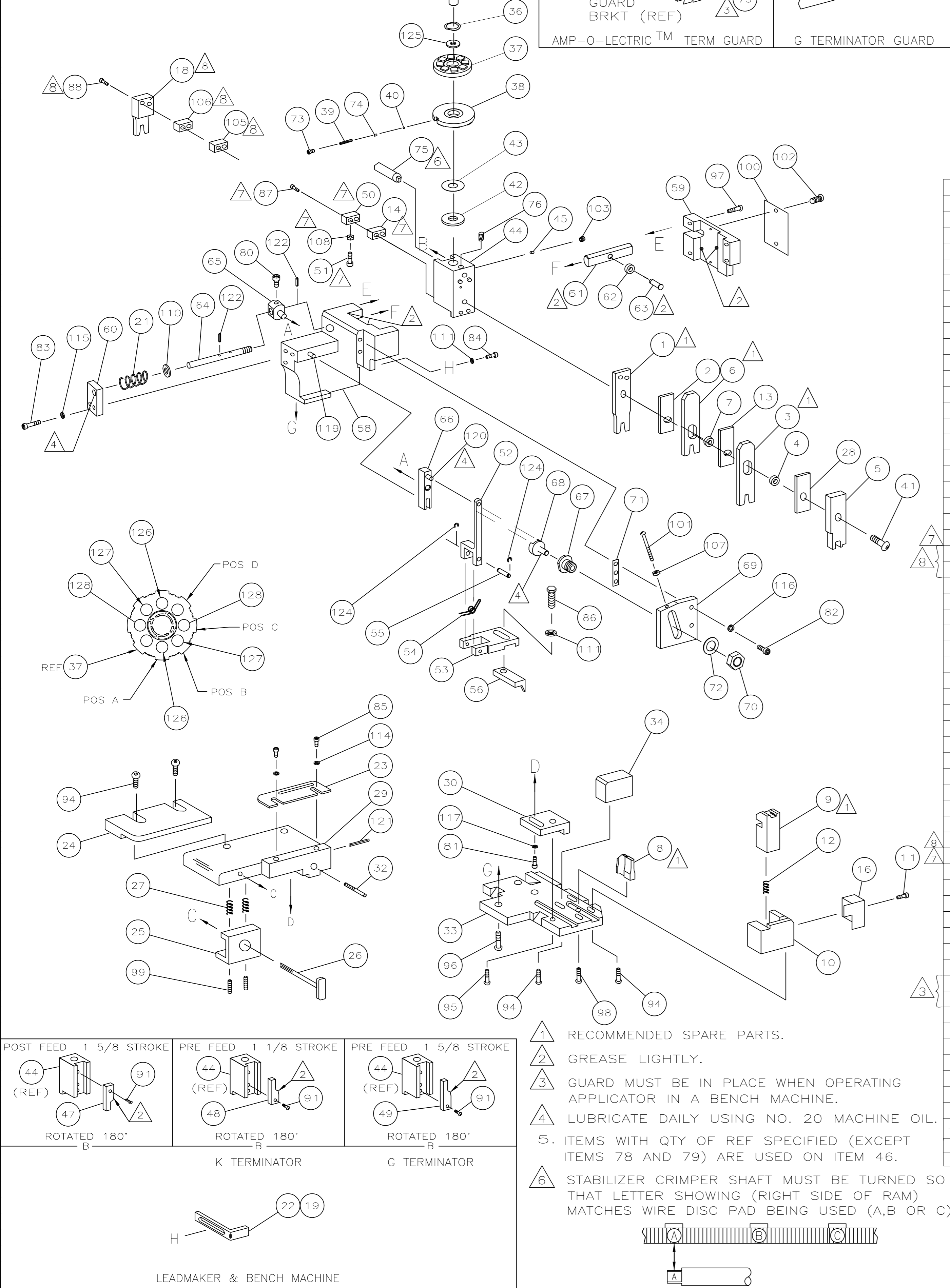


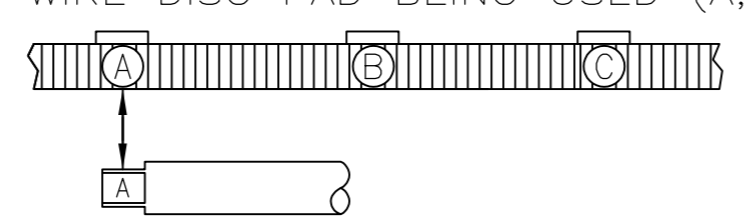
PART NUMBER	REV	FIRST USED
1385025-1	E	854400-1
1385025-2	E	565435-5
1385025-3	E	354500-1
7-1385025-7	E	-



CRIMPING DATA			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	
A	.056 ±.002 [1.42 ±0.05mm]	1.00mm <sup>2</sup>	
B	.052 ±.002 [1.33 ±0.05mm]	.75mm <sup>2</sup>	
C	.049 ±.002 [1.24 ±0.05mm]	.50mm <sup>2</sup>	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.080 [2.03mm]	F	.50-1.00mm <sup>2</sup>
INSUL	.110 [2.79mm]	OVL	Ø1.20-2.40mm
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INST
.234-.250	114-1007	.590	408-8040
			SET UP GAGE
			458637-1
			LAYOUT
			L2338

QTY REQD	PER ASSY	PART NO	DESCRIPTION	ITEM NO	
2	2	2	2-354779-6	PIN, WIRE DISC (.3120)C	129
2	2	2	2-354779-0	PIN, WIRE DISC (.3090)B	128
2	2	2	1-354779-1	PIN, WIRE DISC (.3045)A	126
1	1	1	986950-1	WASHER, FLAT PRECISION	125
REF	REF	REF	21045-3	RING, RET "C"(Ø.187)FD FING PIN	124
					123
REF	REF	REF	5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	122
1	1	1	4-21028-0	PIN,SLT SPR(Ø.093x.75)ST GDE PL	121
REF	REF	REF	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	120
REF	REF	REF	1-21030-6	PIN,DOWEL(Ø.187x1.25)HOUSING	119
					118
1	1	1	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
REF	REF	REF	21024-5	WASHER,LOCK(#10)ADJ PLATE	116
REF	REF	REF	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115
2	2	2	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
					113
					112
					111
REF	REF	REF	21899-4	WASHER,FLAT(Ø5/16)SCREW ADJ	110
					109
1	1	1	21018-5	NUT,HEX (6-32)	108
REF	REF	REF	21018-5	NUT,HEX(6-32)FEED ADJ	107
1	1	1	4-240641-0	SPACER	106
1	1	1	2-240641-1	SPACER	105
					104
1	1	1	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
2	2	2	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
REF	REF	REF	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
1	1	1	461264-1	PLATE, IDENTIFICATION	100
2	2	2	5-21006-6	SCR,SET(10-32x.75)DRAG	99
1	1	1	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
REF	REF	REF	2-21002-9	SCR,BHC(10-32x.75)CAP	97
REF	REF	REF	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
REF	REF	REF	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
4	4	4	2-21002-2	HOLDER, INSULATION	94
					93
					92
1	1	1	1-21002-7	SCR,BHC(6-32x.38)CAM	91
					90
					89
2	2	2	3-21000-0	SCR,SHC(8-32x.88)	88
2	2	2	2-21000-8	SCR,SHC(8-32x.62)	87
1	1	1	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
2	2	2	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	85
1	1	1	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
REF	REF	REF	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
REF	REF	REF	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	82
1	1	1	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
REF	REF	REF	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	80
REF	REF	REF	455749-1	GUARD, WINDOW	79
REF	REF	REF	679532-1	INSERT, GUARD	78
					77
1	1	1	22859-7	PLUNGER, SPRING	76
1	1	1	1-453412-6	SHAFT, STABILIZER	75
1	1	1	690603-1	SPRING, ASSIST	74
1	1	1	23030-1	SCR,SHC(6-32x.25 SL)INS DISC	73
REF	REF	REF	458109-1	WASHER, SPECIAL	72
REF	REF	REF	690517-1	SPACER	71
-77	-3	-2	-1	U/M	

- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 4 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
- 6 STABILIZER CRIMPER SHAFT MUST BE TURNED SO THAT LETTER SHOWING (RIGHT SIDE OF RAM) MATCHES WIRE DISC PAD BEING USED (A,B OR C) AS SHOWN:



- △ ITEMS 14, 50, 51, 87 AND 108 REQ'D FOR 927841.
- △ ITEMS 18, 88, 105 & 106 REQ'D FOR 927843.

LOC	DIST	REVISIONS
A	66	
F	LTR	DESCRIPTION
E	ECR-09-014162	6-2007 MY TE

-1	LEADMAKER	MECH POST FEED
-2	BENCH MODEL K	MECH PRE FEED
-3	BENCH MODEL G	MECH PRE FEED
-77	-	SPARE PARTS KIT

QTY REQD	PER ASSY	PART NO	DESCRIPTION	ITEM NO		
-	REF	REF	REF	22594-8	NUT,HEX(1/2-20)	70
-	REF	REF	REF	240628-1	PLATE, ADJUSTMENT	69
-	REF	REF	REF	240626-1	SHAFT, PIVOT	68
-	REF	REF	REF	240633-1	BUSHING	67
-	REF	REF	REF	455680-1	LEVER, INTERMEDIATE	66
-	REF	REF	REF	240629-1	BLOCK, PIVOT	65
-	REF	REF	REF	240632-2	SCREW, ADJ FEED ROD	64
-	REF	REF	REF	240659-3	PIN, CAM ROLLER	63
-	REF	REF	REF	240658-1	ROLLER, CAM	62
-	REF	REF	REF	454398-2	ROD, FEED	61
-	REF	REF	REF	454178-1	GUIDE, FEED ROD	60
-	REF	REF	REF	454220-1	CAP, RAM	59
-	REF	REF	REF	454485-1	HOUSING	58
					57	
-	1	1	1	458537-2	PAWL, FEED	56
-	REF	REF	REF	240624-1	PIN, FEED FINGER	55
-	REF	REF	REF	691499-1	SPRING, FEED FINGER	54
-	REF	REF	REF	690541-1	HOLDER, FEED FINGER	53
-	REF	REF	REF	455679-2	LEVER, TERMINAL FEED ARM	52
-	1	1	1	811242-2	BUMPER, HOLDDOWN	51
-	1	1	1	690753-1	SPACER, TONKER	50
-	1	-	-	690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	-	1	-	690602-5	CAM, PRE-FEED 1 1/8 ST	48
-	-	1	-	690501-4	CAM, POST-FEED 1 5/8 ST	47
-	1	1	1	459456-2	APPLICATOR, BASIC (SUBASSY)	46
-	1	1	1	690191-1	PLUG, NYLON	45
-	1	1	1	817855-4	RAM	44
-	1	1	1	690125-1	WASHER, LAMINATED	43
-	1	1	1	690124-1	WASHER, RAM	42
-	1	1	1	690686-1	BOLT, CRIMPER(5/16x1.00)	41
-	1	1	1	23241-6	BALL, STEEL	40
-	1	1	1	690170-1	SPRING, COMPRESSION	39
-	1	1	1	690142-1	DISC, INSULATION	38
-	1	1	1	354777-1	WIRE DISC, PLASTIC	37
-	1	1	1	22480-5	WASHER, SPRING	36
-	1	1	1	690212-1	POST, RAM	35
-	1	1	1	690786-1	SUPPORT, TERMINAL	34
-	REF	REF	REF	455675-1	PLATE, BASE	33
-	1	1	1	690432-3	SCREW, ADJUSTMENT	32
					31	
-	REF	REF	REF	455689-1	BLOCK, STRIP GUIDE ADJ	30
-	1	1	1	455671-1	PLATE, STRIP GUIDE	29
-	1	1	1	2-455888-0	SPACER,CRIMPER	28
-	2	2	2	1-22284-0	SPRING, DRAG	27
-	1	1	1	690546-1	LEVER, DRAG RELEASE	26
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	8-690504-9	GUIDE, STRIP (REAR)	24
-	1	1	1	690438-1	GUIDE, STRIP (FRONT)	23
-	-	-	-	690472-9	STRIPPER	22
-	REF	REF	REF	4-22284-9	SPRING, FEED RETURN	21
					20	
-	1	1	-	691353-1	STRIPPER	19
-	1	1	1	1338766-1	TOOL SIZING	18
					17	
-	1	1	1	691667-1	GUARD, CHIP (FRONT)	16
					15	
-	1	1	1	2-240641-9	SPACER, DEPRESSOR (REAR)	14
-	1	1	1	455888-4	SPACER, CRIMPER	13
-	1	1	1	3-22280-3	SPRING, SHEAR	12
-	1	1	1	690461-1	STOP, SHEAR	11
-	1	1	1	690459-1	HOLDER, SHEAR (FRONT)	10
-	1	1	1	454276-1	SHEAR, FLOAT (FRONT)	9
1	1	1	1	1338767-1	ANVIL	8
-	1	1	1	238011-2	SPACER, BLOCK CRIMPER	7
-	1	1	1	817852-4	CRIMPER, STABILIZER	6
-	1	1	1	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	238011-7	SPACER, BLOCK CRIMPER	4
-	1	1	1	854830-1	CRIMPER, INSULATION	3
-	1	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1	1-817854-9	CRIMPER, WIRE	1
-77	-3	-2	-1	U/M		

THIS DRAWING IS A CONTROLLED DOCUMENT. DWN W.HOOVER 2/21/00 Tyco Electronics Corporation Tyco Electronics Harrisburg, PA 17105-3608

DIMENSIONS: INCHES TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± .010 1 PLC ± .005 2 PLC ± .002 3 PLC ± .001 4 PLC ± .0005 ANGLES ± .010 FINISH -

APPROVED: J.ELBIN 2/21/00 NAME: SIDE FEED HDM APPLICATOR

APPLICATION SPEC: - WEIGHT: - SIZE: A1 DATE CODE: 00779 DRAWING NO: 1385025 RESTRICTED TO: -

MATERIAL: - FINISH: - CUSTOMER DRAWING: SCALE: - SHEET: 1 OF 1 REV: E