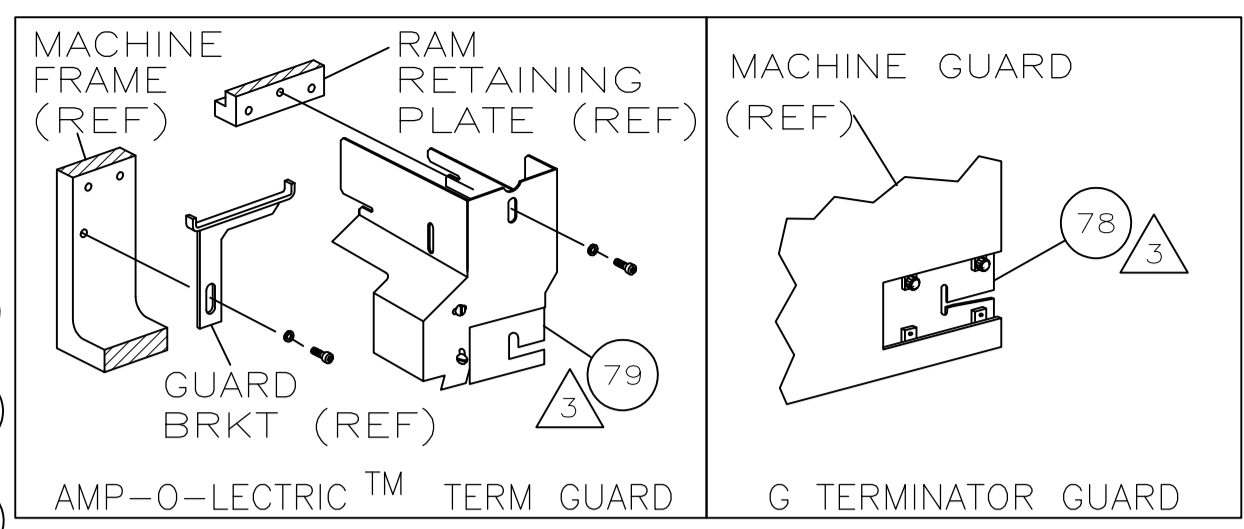


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PART NUMBER	REV	FIRST USED
466721-1	S	122500-1
466721-2	S	565435-5
466721-3	SEE DWG	466721-3
466721-4	S	354500-1



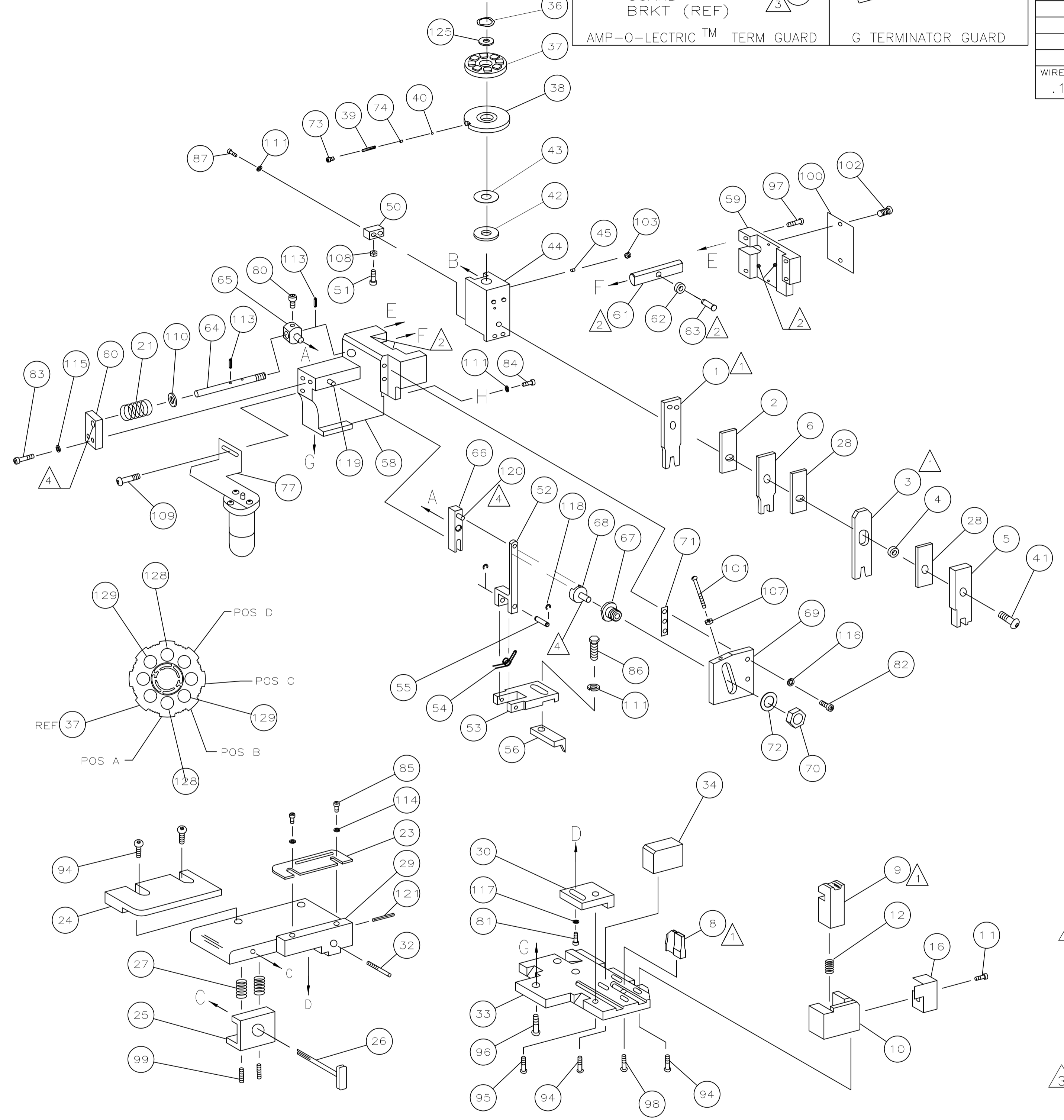
TERMINAL NAME: CONTACT ASSEMBLY

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.141 - .171	114-25006	.330	408-8040	458637-1	L574

PAD LTR	CRIMPING DATA		
	CRIMP HEIGHT	WIRE SIZE	
A	.034 ±.002 [0.86 ±0.05mm]	22	
B	.030 ±.002 [0.76 ±0.05mm]	26 or 24	
C	NOT	USED	
D	NOT	USED	
CRIMP	SIZE	TYPE	RANGE
WIRE	.055 [1.40mm]	F	26-22
INSUL	.070 [1.78mm]	0/6	Φ.038-.062

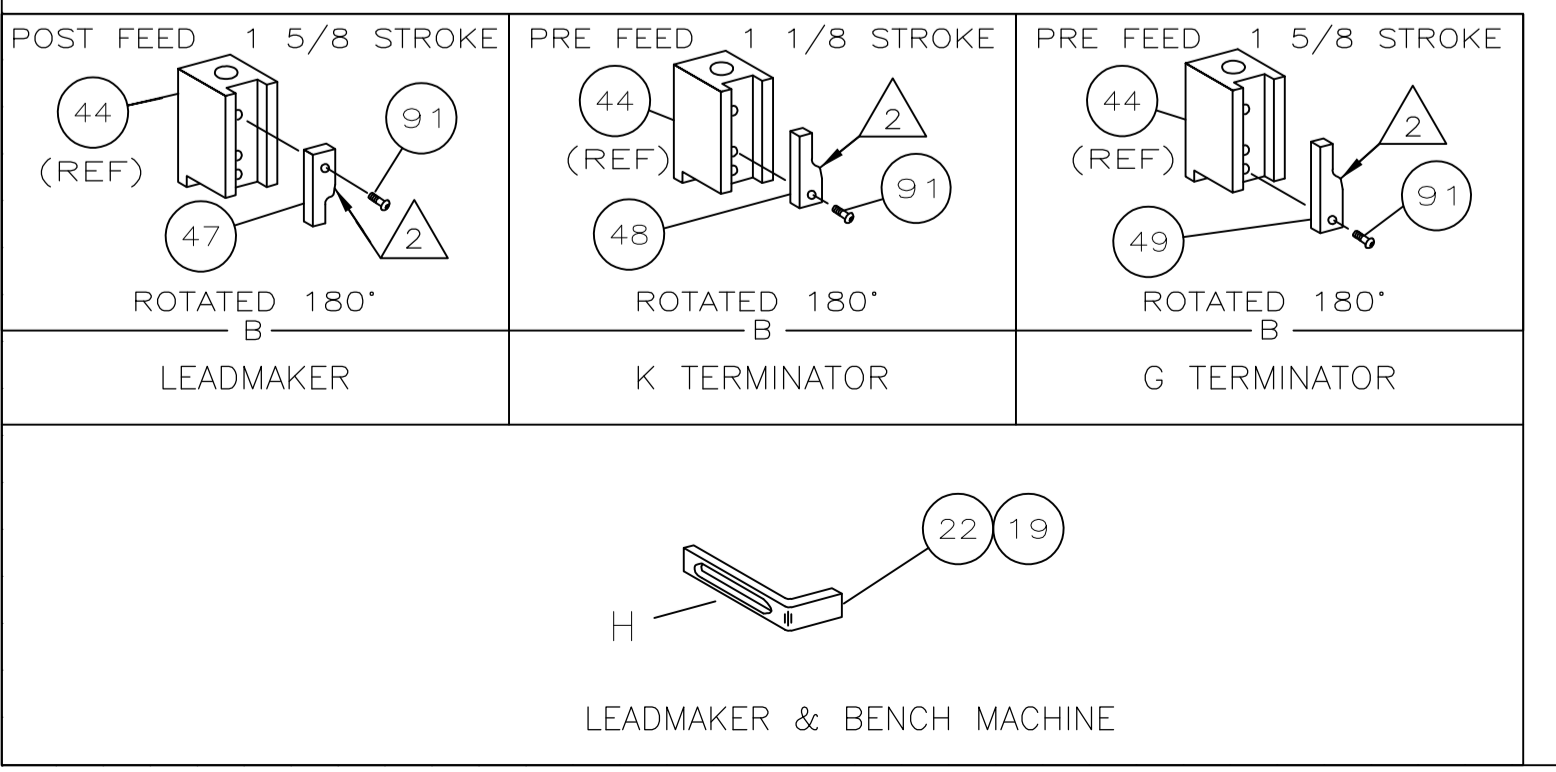
LOC	DIST	REVISIONS					
REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV
A	66	S		ECR-07-023678	10-2007	MY	GB

-1	LEADMAKER	MECH POST FEED
-2	BENCH MODEL K	MECH PRE FEED
-4	BENCH MODEL G	MECH PRE FEED



QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO			
2	2	6-354779-2	127			
2	2	5-354779-4	126			
1	1	986950-1	125			
1	1	217238-1	124			
1	1	4088040	123			
1	1	4-21028-0	121			
REF	REF	1-21030-1	120			
REF	REF	1-21030-6	119			
REF	REF	21045-3	118			
1	1	21024-5	117			
REF	REF	21024-5	116			
REF	REF	21024-5	115			
2	2	21024-2	114			
REF	REF	5-21028-1	113			
4	4	21024-4	111			
REF	REF	21899-4	110			
-	1	2-21002-6	109			
1	1	21018-5	108			
REF	REF	21018-5	107			
1	1	21009-2	103			
2	2	21017-2	102			
REF	REF	6-23715-5	101			
1	1	461264-1	100			
2	2	5-21006-6	99			
1	1	22733-8	98			
REF	REF	2-21002-9	97			
REF	REF	2-22733-8	96			
REF	REF	2-21002-7	95			
6	6	2-21002-2	94			
1	1	1-21002-7	91			
2	2	2-21000-7	87			
1	1	2-22603-0	86			
2	2	1-21000-3	85			
1	1	2-21000-7	84			
REF	REF	3-21000-7	83			
REF	REF	3-21000-6	82			
1	1	3-21000-4	81			
REF	REF	3-21000-4	80			
-	REF	455749-1	79			
REF	-	679532-1	78			
-	1	1-465184-0	77			
1	1	690603-1	76			
1	1	23030-1	74			
REF	REF	458109-1	72			
REF	REF	690517-1	71			
-4	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

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	
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	455679-1	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	459456-1	APPLICATOR, BASIC (SUBASSY)	46	
1	1	1	690191-1	PLUG, NYLON	45	
1	1	1	455673-1	RAM	44	
1	1	1	690125-1	WASHER, LAMINATED	43	
1	1	1	690124-1	WASHER, RAM	42	
1	1	1	7-21002-9	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	460712-2	SUPPORT, TERMINAL	34	
REF	REF	REF	455675-1	PLATE, BASE	33	
1	1	1	690432-3	SCREW, ADJUSTMENT	32	
REF	REF	REF	455689-1	BLOCK, STRIP GUIDE ADJ	30	
1	1	1	455671-3	PLATE, STRIP GUIDE	29	
2	2	2	455888-4	SPACER, FRONT SHEAR DEP	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	6-690504-3	GUIDE, STRIP (REAR)	24	
1	1	1	690438-1	GUIDE, STRIP (FRONT)	23	
-	-	1	690472-2	STRIPPER	22	
REF	REF	REF	4-22284-9	SPRING, FEED RETURN	21	
1	1	-	691353-1	STRIPPER	20	
1	1	1	318563-1	GUARD, CHIP, FRONT	16	
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	9-690471-5	ANVIL	8	
1	1	1	461679-3	TOOL, SIZING-075	6	
1	1	1	455889-9	DEPRESSOR, SHEAR (FRONT)	5	
1	1	1	1-238011-0	SPACER, BLOCK CRIMPER	4	
1	1	1	5-456135-1	CRIMPER, INSULATION	3	
1	1	1	455888-3	SPACER, CRIMPER	2	
1	1	1	2-456402-5	CRIMPER, WIRE	1	
-4	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO



- 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 INSULATION CRIMP HEIGHT SHALL NOT EXCEED .072.
- 7 CUT TO LENGTH AT ASSY

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES. TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC	± .005
1 PLC	± .004
2 PLC	± .003
3 PLC	± .002
4 PLC	± .001
ANGLES	± .005

MATERIAL: FINISH

APPROVED: E. KRISMAN 11-1-93

PRODUCT SPEC: 11-1-93

APPLICATION SPEC: 11-1-93

WEIGHT: A1 00779

CUSTOMER DRAWING: SCALE: SHEET 1 OF 1

Tyco Electronics Corporation
 Harrisburg, PA 17105-3608

NAME: SIDE FEED HDM APPLICATOR

DRAWING NO: 466721