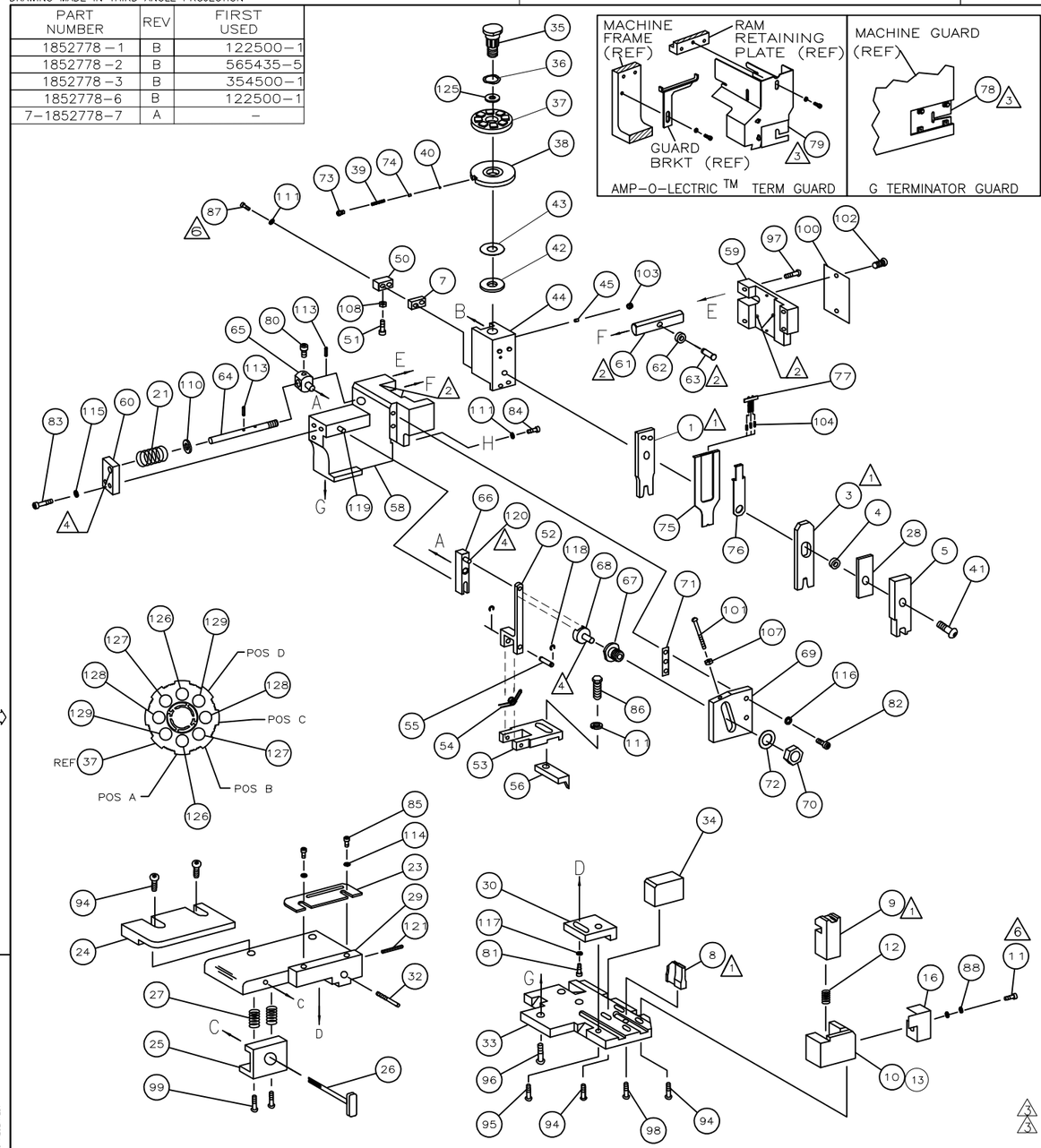
DRAWING MADE IN THIRD ANGLE PROJECTION

PART NUMBER	REV	FIRST USED
1852778–1	B	122500–1
1852778–2	B	565435–5
1852778–3	B	354500–1
1852778–6	B	122500–1
7–1852778–7	A	–



TERMINAL NAME: CONTACT, JUNIOR POWER TIMER

144432

CRIMP DATA (AMP TERMINAL)

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	2.05 ±.05 [.081 ±0.002 IN]	3mm² (12)
B	1.76 ±.05 [.069 ±0.002 IN]	2mm² (14)
C	1.58 ±.05 [.062 ±0.002 IN]	1.4mm² (16)
D	1.46 ±.05 [.057 ±0.002 IN]	1mm²

	SIZE	TYPE	RANGE
CRIMP			
WIRE	2.79 [.110 IN]	F	1mm² –3mm²
INSUL	3.84 [.151 IN]	F	3.5 MAX

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
4.16–4.58	114–15051	.551	408–8040	458637–1	L2407

–77	–6	–3	–2	–1	PART NO	DESCRIPTION	ITEM NO
–	2	2	2	2	2–354779–4	PIN, WIRE DISC (.3110)D	129
–	2	2	2	2	1–354779–3	PIN, WIRE DISC (.3055)C	128
–	2	2	2	2	9–354778–7	PIN, WIRE DISC (.2980)B	127
–	2	2	2	2	7–354778–4	PIN, WIRE DISC (.2865)A	126
–	1	1	1	1	986950–1	WASHER, FLAT PRECISION	125
–	1	1	1	1	217238–1	GENERAL INSTRUCTION PACKAGE	124
–	1	1	1	1	4088040	SF APPL INST 408–8040	123
							122
–	1	1	1	1	4–21028–0	PIN,SLT SPR(Ø.093x.75)ST GDE PL	121
–	REF	REF	REF	REF	1–21030–1	PIN,DOWEL(Ø.187x.50)LEVER	120
–	REF	REF	REF	REF	1–21030–6	PIN,DOWEL(Ø.187x1.25)HOUSING	119
–	REF	REF	REF	REF	21045–3	RING,RET "C"(Ø.187)FD FING PIN	118
–	1	1	1	1	21024–5	WASHER, LOCK(#10)ADJ BLOCK	117
–	REF	REF	REF	REF	21024–5	WASHER,LOCK(#10)ADJ PLATE	116
–	REF	REF	REF	REF	21024–5	WASHER,LOCK(#10)FEED GDE ROD	115
–	2	2	2	2	21024–2	WASHER,LOCK(#4)FRONT STP GUIDE	114
–	REF	REF	REF	REF	5–21028–1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	113
							112
–	4	4	4	4	21024–4	WASHER,LOCK(#8)STRIPPER	111
–	REF	REF	REF	REF	21899–4	WASHER,FLAT(Ø5/16)SCREW ADJ	110
							109
–	1	1	1	1	21018–5	NUT,HEX(NO.6)HOLDDOWN	108
–	REF	REF	REF	REF	21068–5	NUT,HEX(6–32)FEED ADJ	107
							106
							105
–	3	3	3	3	2–23147–2	SPRING	104
–	1	1	1	1	21009–2	SCR,SKT SET(1/4–20x.25 LW)RAM	103
–	2	2	2	2	21017–2	SCR,DRIVE(#2x.19)ID PLATE	102
–	REF	REF	REF	REF	6–23715–5	SCR,PAN HD(6–32x1.50)FEED ADJ	101
–	1	1	1	1	461264–1	PLATE, IDENTIFICATION	100
–	2	2	2	2	5–21006–6	SCR,SKT SET(10–32x.75)DRAG	99
–	1	1	1	1	22733–8	SCR,BHC(8–32x.38 LW)ANVIL	98
–	REF	REF	REF	REF	2–21002–9	SCR,BHC(10–32x.75)CAP	97
–	REF	REF	REF	REF	2–22733–8	SCR,BHC(1/4–20x.62)HOUSING	96
–	REF	REF	REF	REF	2–21002–7	SCR,BHC(10–32x.50)SG ADJ BLOCK	95
–	6	6	6	6	2–21002–2	SCR,BHC(8–32x.50)TERM H DWN	94
							93
							92
–	1	1	1	1	1–21002–7	SCR,BHC(6–32x.38)CAM	91
							90
							89
–	2	2	2	2	21055–3	WASHER, FLAT (#2x.032) SHR STOP	88
–	2	2	2	2	2–21000–8	SCR,SHC(8–32x.62)HOLD DOWN	87
–	1	1	1	1	2–22603–0	SCR,HEX HD(8–32x.31)FEED FINGER	86
–	2	2	2	2	1–21000–3	SCR,SHC(4–40x.25)F ST GUIDE	85
–	1	1	1	1	2–21000–7	SCR,SHC(8–32x.50)STRIPPER	84
–	REF	REF	REF	REF	3–21000–7	SCR,SHC(10–32x.75)FEED ROD GD	83
–	REF	REF	REF	REF	3–21000–6	SCR,SHC(10–32x.62)FD ADJ BLK	82
–	1	1	1	1	3–21000–4	SCR,SHC(10–32x.38)SG ADJ BL	81
–	REF	REF	REF	REF	3–21000–4	SCR,SHC(10–32x.38)PIVOT BLK	80
–	–	–	REF	–	455749–1	GUARD, WINDOW	79
–	–	REF	–	–	679532–1	INSERT, GUARD	78
–	1	1	1	1	1424350	HOLDER, PIN, WIRED	77
–	1	1	1	1	1490524–1	SPACER, DEPRESSOR	76
–	1	1	1	1	1490525–3	DEPRESSOR, WIRE	75
–	1	1	1	1	690603–1	SPRING, ASSIST	74
–	1	1	1	1	23030–1	SCR,SHC(6–32x.25 SL)INS DISC	73
–	REF	REF	REF	REF	458109–1	WASHER, SPECIAL	72
–	REF	REF	REF	REF	690517–1	SPACER	71
–77	–6	–3	–2	–1	PART NO	DESCRIPTION	ITEM NO

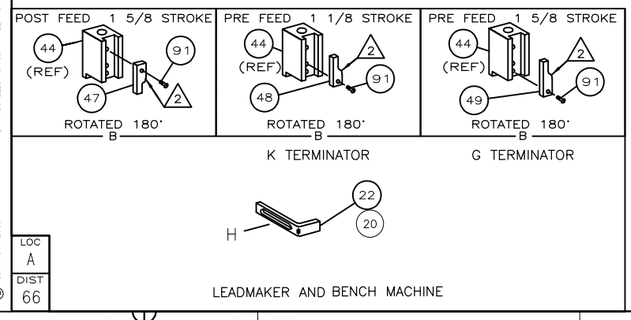
QTY REQD PER ASSY | PARTS LIST

–1	LEADMAKER	MECH POST FEED	–6	LEADMAKER	POST FEED(CONTINOUS)
–2	BENCH MODEL K	MECH PRE FEED	–77	SPARE PARTS	SPARE PARTS KIT
–3	BENCH MODEL G	MECH PRE FEED			

–77	–6	–3	–2	–1	PART NO	DESCRIPTION	ITEM NO
–	REF	REF	REF	REF	22594–8	NUT,HEX(1/2–20)	70
–	REF	REF	REF	REF	240628–1	PLATE, ADJUSTMENT	69
–	REF	REF	REF	REF	240626–1	SHAFT, PIVOT	68
–	REF	REF	REF	REF	240633–1	BUSHING	67
–	REF	REF	REF	REF	455680–1	LEVER, INTERMEDIATE	66
–	REF	REF	REF	REF	240629–1	BLOCK, PIVOT	65
–	REF	REF	REF	REF	240632–2	SCREW, ADJ FEED ROD	64
–	REF	REF	REF	REF	240659–3	PIN, CAM ROLLER	63
–	REF	REF	REF	REF	240658–1	ROLLER, CAM	62
–	REF	REF	REF	REF	454398–2	ROD, FEED	61
–	REF	REF	REF	REF	454178–1	GUIDE, FEED ROD	60
–	REF	REF	REF	REF	454220–1	CAP, RAM	59
–	REF	REF	REF	REF	454485–1	HOUSING	58
							57
–	1	1	1	1	458537–2	PAWL, FEED	56
–	REF	REF	REF	REF	240624–1	PIN, FEED FINGER	55
–	REF	REF	REF	REF	691499–1	SPRING, FEED FINGER	54
–	REF	REF	REF	REF	690541–1	HOLDER, FEED FINGER	53
–	REF	REF	REF	REF	455679–1	LEVER, TERMINAL FEED ARM	52
–	1	1	1	1	811242–2	BUMPER, HOLDDOWN	51
–	1	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	–	–	1	690501–4	CAM, POST–FEED 1 5/8 ST	47
–	1	1	1	1	459456–1	APPLICATOR, BASIC (SUBASSY)	46
–	1	1	1	1	690191–1	PLUG, NYLON	45
–	1	1	1	1	455673–1	RAM	44
–	1	1	1	1	690125–1	WASHER, LAMINATED	43
–	1	1	1	1	690124–1	WASHER, RAM	42
–	1	1	1	1	7–21002–9	BOLT, CRIMPER(5/16x1.00)	41
–	1	1	1	1	23241–6	BALL, STEEL	40
–	1	1	1	1	690170–1	SPRING, COMPRESSION	39
–	1	1	1	1	690142–4	DISC, INSULATION	38
–	1	1	1	1	354777–1	WIRE DISC, PLASTIC	37
–	1	1	1	1	22480–5	WASHER, SPRING	36
–	1	1	1	1	690212–1	POST, RAM	35
–	1	1	1	1	690786–6	SUPPORT, TERMINAL	34
–	REF	REF	REF	REF	455675–1	PLATE, BASE	33
–	1	1	1	1	690432–3	SCREW, ADJUSTMENT	32
							31
–	REF	REF	REF	REF	455689–1	BLOCK, STRIP GUIDE ADJ	30
–	1	1	1	1	455671–1	PLATE, STRIP GUIDE	29
–	1	1	1	1	1–455888–7	SPACER, FRONT SHEAR DEP	28
–	2	2	2	2	1–22284–0	SPRING, DRAG	27
–	1	1	1	1	690546–1	LEVER, DRAG RELEASE	26
–	1	1	1	1	240792–1	DRAG, TERMINAL	25
–	1	1	1	1	1–90765–2	GUIDE, STRIP (REAR)	24
–	1	1	1	1	690438–1	GUIDE, STRIP (FRONT)	23
–	1	–	–	1	690472–2	STRIPPER	22
–	REF	REF	REF	REF	4–22284–9	SPRING, FEED RETURN	21
–	–	1	1	–	691353–1	STRIPPER	20
							19
							18
							17
–	1	1	1	1	318563–1	GUARD, CHIP, FRONT	16
							15
							14
1 –	1	–	–	–	679625–2	HOLDER, SHEAR (NO CUT)	13
–	1	1	1	1	3–22280–3	SPRING, SHEAR	12
–	1	1	1	1	1–21000–9	SCR, SHC(6–32x.375)SHR STOP	11
–	–	1	1	1	1–690459–0	HOLDER, SHEAR (FRONT)	10
1 –	1	1	1	1	454276–5	SHEAR, FLOAT (FRONT)	9
1 1	1	1	1	1	5–854014–9	ANVIL	8
–	1	1	1	1	3–240641–3	SPACER, DEPRESSOR (REAR)	7
							6
–	1	1	1	1	2–455889–0	DEPRESSOR, SHEAR (FRONT)	5
–	1	1	1	1	238011–7	SPACER, BLOCK CRIMPER	4
1	1	1	1	1	8–1633471–8	CRIMPER, INSULATION	3
							2
1	1	1	1	1	456408–3	CRIMPER, WIRE	1
–77	–6	–3	–2	–1	PART NO	DESCRIPTION	ITEM NO

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

QTY REQD PER ASSY | PARTS LIST



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. CUT TO LENGTH AT ASSEMBLY

P F	LTR	REVISION RECORD	APP	DATE
	B	ECR–09–001238	DM	01/09
	A	ECR–08–023017	DM	11/08

DIMENSIONS IN INCHES.
DO NOT SCALE PRINT.
TOLERANCES UNLESS OTHERWISE SPECIFIED:
2 PLC DEC ± –
3 PLC DEC ± –
4 PLC DEC ± –
ANGLES ±
SURF TEXTURE: √
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL – | HT TR – | FIN –

DR 04NOV08 D.MORRIS | APP 04NOV08 N.DEMING | CHK 04NOV08 G.BAILEY | REL –

Tyco Electronics
Tyco Electronics Harrisburg, PA 17105–3608

NAME SIDE FEED HDM APPLICATOR | MACHINE REF MINI APPL

SCALE – | D | DWG NO 1852778 | SHEET 1 of 1 | REV B

CAGE CODE 00779 | CUSTOMER AND ASSEMBLY DRAWING | RESTRICTED TO –

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