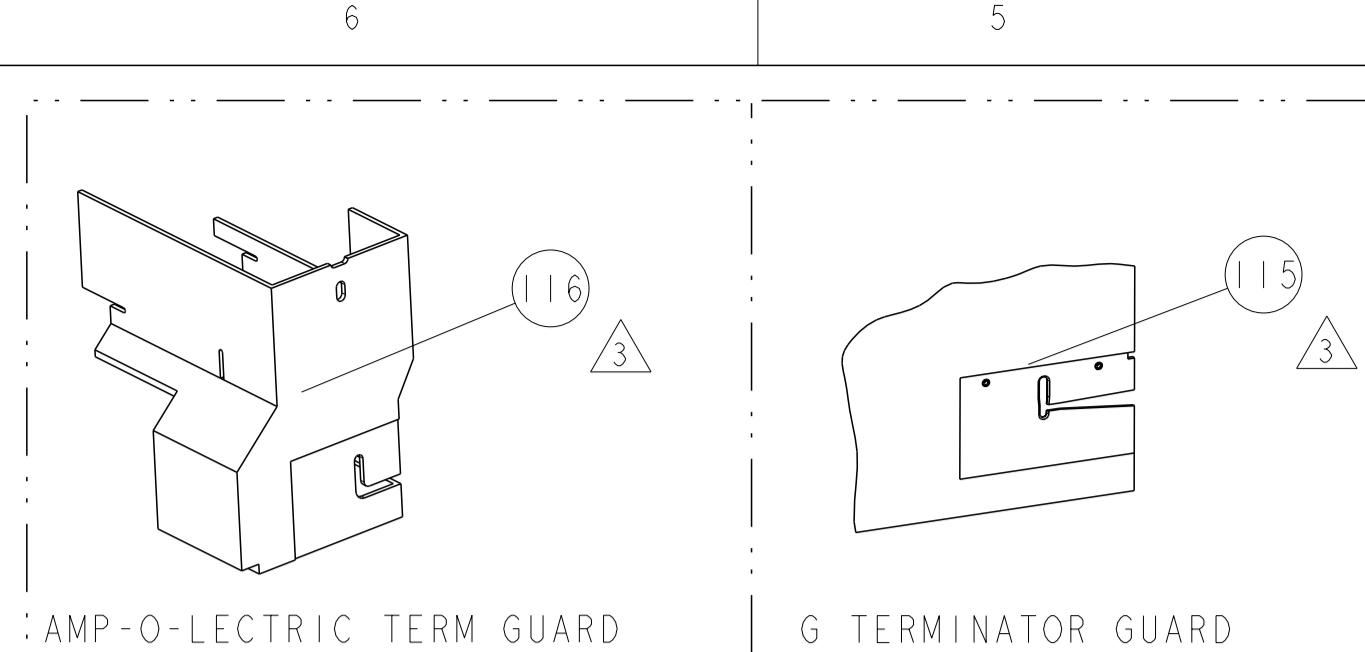


PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1855451-1	C	122500-1	LEADMAKER	AIR FEED	CUTS CARRIER
1855451-2	C	565435-5	BENCH MODEL K	AIR FEED	CUTS CARRIER
1855451-3	C	354500-1	BENCH MODEL G	AIR FEED	CUTS CARRIER
7-1855451-7	A	-	-	-	SPARE PARTS

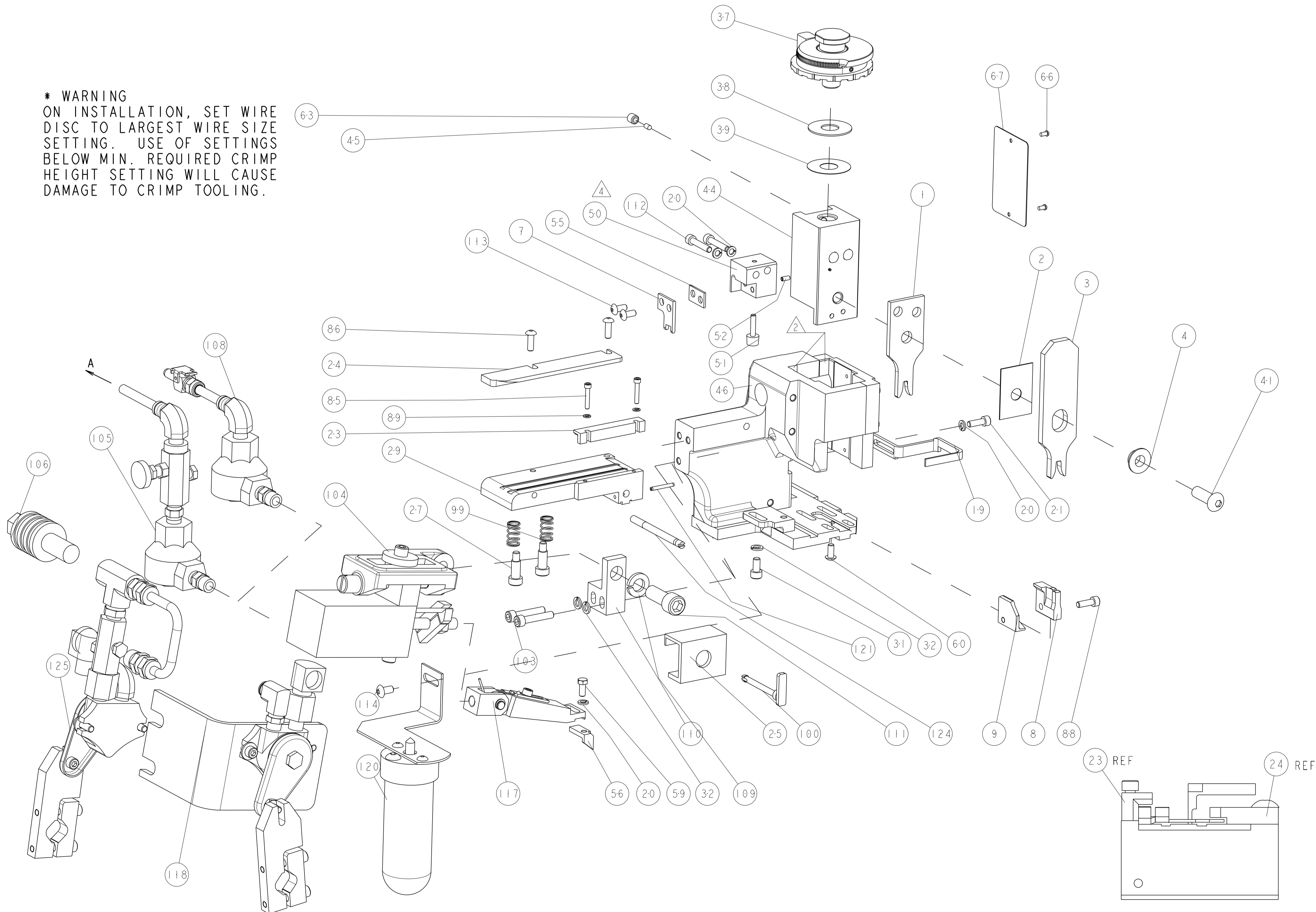


TERMINAL NAME: RING TONGUE		DELPHI TERMINAL - TE CRIMP SPECS		REF SETTING	
TE PN	DELPHI	CRIMP HEIGHT	WIRE SIZE		
1949828-2	2984576			A8	
1949828-3	2973375			B9	
-	-	2.67mm+ .05/- .05 [ .105+ .002/- .002 ]	14AWG or 2mm2	C4	
-	-	2.53mm+ .05/- .05 [ .100+ .002/- .002 ]	1.5mm2	C9	
-	-	2.47mm+ .05/- .05 [ .097+ .002/- .002 ]	16AWG or 1.25mm2		
-	-	2.41mm+ .05/- .05 [ .095+ .002/- .002 ]	1mm2		
		CRIMP	SIZE	TYPE	RANGE
-	-	-	3.30mm [ .130 ]	F	1mm2-2mm2
-	-	INSUL	4.20mm [ .165 ]	F	Ø 3.050 MAX
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPLICATOR INSTRUCTIONS		SET UP GAGE
4.47-4.85	NONE	13.89	408-8040		458637-1

LOC	DIST	REVISIONS			
REV	LYR	DESCRIPTION	DATE	OWN	APVD
A	66	RELEASED	30JAN2009	BH	BH
B		ECR-09-007141	30MAR2009	MY	GB
C		ECR-10-009696	12MAY2010	MY	TE

- △ RECOMMENDED SPARE PARTS
- △ GREASE LIGHTLY
- △ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
- △ GRIND AT ASSEMBLY.
- 5. TERMINAL LUBRICANT IS RECOMMENDED.
- △ INSTALL ITEMS 101, 102 & 119 ON SIDE OF STRIPPER ON APPLICATOR HOUSING USING ITEM 21.

**\* 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.



-	-	1	-	-	455350-4	AIR BLAST ASS'Y	125	
-	-	1	1	1	690432-6	ADJUSTMENT SCREW	124	
-	-	1	1	1	4-21028-0	PIN, SLOTTED SPRING .094 X .750	121	
-	-	1	-	-	1-465184-0	LUBRICATOR ASSY	120	
△	-	18	24	18	IN	27319-4 TUBING 1/4" O.D.	119	
-	-	1	-	-	692655-6	AIR FEED VALVE ASSEMBLY	118	
-	-	1	1	1	461062-1	FEED FINGER ASSEMBLY	117	
△	-	-	REF	-	455749-1	GUARD WINDOW	116	
△	-	REF	-	-	679532-1	INSERT, GUARD	115	
-	-	1	-	-	2-21002-6	SCR, BTN SKT HD CAP 10-32 X .375	114	
-	2	2	2	-	2-21002-1	SCR, BTN SKT HD CAP 8-32 X .375	113	
△	-	2	2	2	-	3-21000-0	SCR, SKT HD CAP 8-32 X .875	112
-	1	1	1	-	3-21001-5	SCR, SKT HD CAP 3/8-16 X 1.000	111	
-	1	1	1	-	459610-1	MOUNT, FEED BRACKET	110	
-	1	1	1	-	21024-8	WASHER, SPRG LOCK, REG 3/8	109	
-	1	-	1	-	692655-7	AIR FEED VALVE ASSEMBLY	108	
-	-	1	-	-	24042-2	VALVE, SLEEVE, 3-WAY	106	
-	-	1	-	-	692655-5	AIR FEED VALVE ASSEMBLY	105	
-	1	1	1	-	461065-1	ASSEMBLY, AIR FEED	104	
-	2	2	2	-	3-21000-9	SCR, SKT HD CAP 10-32 X 1.000	103	
△	-	1	1	1	-	986220-3	CLAMP, CABLE, BLACK	102
△	-	1	1	1	-	23238-1	INSERT, COUPLING	101
-	1	1	1	-	690546-1	LEVER, DRAG RELEASE	100	
-	2	2	2	-	1-22282-3	SPRING, COMPRESSION	99	
-	2	2	2	-	21024-2	WASHER, SPRG LOCK, REG NO 4	89	
-	1	1	1	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	88	
-	2	2	2	-	2-21002-2	SCR, BTN SKT HD CAP 8-32 X .500	86	
-	2	2	2	-	1-21000-6	SCR, SKT HD CAP 4-40 X .625	85	
-	1	1	1	-	4088040	SF APPL INST 408-8040	72	
-	1	1	1	-	217238-1	GENERAL INSTRUCTION PKG	71	
-	1	1	1	-	461264-5	PLATE, IDENTIFICATION	67	
-	2	2	2	-	21017-2	SCREW, DRIVE	66	
-	1	1	1	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	63	
-	1	1	1	-	22733-8	SCR, BHSC, SELF-LOCKING, 8-32 X .375	60	
-	1	1	1	-	2-22603-1	SCREW, MACH, HEX HD, 8-32 X .375	59	
-	1	1	1	-	1-694433-5	FEED PAWL	56	
-	1	1	1	-	5-240641-4	SPACER	55	
-	1	1	1	-	2-21008-1	SCR, SET, SELF LOCKING 1/4-20 X .250	52	
-	1	1	1	-	811242-7	BUMPER, HOLD DOWN	51	
-	1	1	1	-	1633513-1	HOLDER, SLUG BLADE	50	
-	1	1	1	-	1633399-1	APPL., BASIC AIR FEED SUB ASSY	46	
-	1	1	1	-	690191-1	PLUG, NYLON	45	
-	1	1	1	-	1-455673-4	RAM, SIDE FEED	44	
-	1	1	1	-	7-21002-9	SCR, BTN SKT HD CAP 5/16-24 X 1.00	41	
-	1	1	1	-	690125-1	SHIM SUB-ASSY	39	
-	1	1	1	-	469367-7	SHIM	38	
-	1	1	1	-	879103-3	FINE ADJUST HEAD ASSEMBLY	37	
-	3	3	3	-	21024-5	WASHER, SPRG LOCK, REG NO 10	32	
-	1	1	1	-	3-21000-4	SCR, SKT HD CAP 10-32 X .375	31	
-	1	1	1	-	3-455671-3	PLATE, STRIP GUIDE	29	
-	2	2	2	-	27210-3	SCR, SHLD, HEX HD, 1/4 DIA	27	
-	1	1	1	-	6-690754-0	DRAG, SPECIAL	25	
-	1	1	1	-	8-690440-5	GUIDE, REAR STRIP	24	
-	1	1	1	-	2-690712-6	FRONT STRIP GUIDE	23	
-	1	1	1	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	21	
-	4	4	4	-	21024-4	WASHER, SPRG LOCK, REG NO 8	20	
-	1	1	1	-	1-456468-1	STRIPPER, SPECIAL	19	
△	1	1	1	-	1633742-2	PLATE, REAR SHEAR	9	
△	1	1	1	-	1633758-1	ANVIL, SPECIAL, COMBINATION	8	
△	1	1	1	-	1-1583859-4	BLADE, SLUG	7	
-	-	-	-	-	-	-	6	
-	-	-	-	-	-	-	5	
-	1	1	1	-	238009-5	BLOCK, FL CRIMPER SPACER	4	
△	1	1	1	-	1633471-9	CRIMPER, INSULATION F	3	
-	1	1	1	-	455888-5	SPACER, CRIMPER	2	
△	1	1	1	-	8-1633305-9	CRIMPER, WIRE PREMIUM	1	

DIMENSIONS: INCHES 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.01 2 PLC ±.001 3 PLC ±.0001 4 PLC ±.0001 ANGLES FINISH		THIS DRAWING IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE KEPT IN CONFIDENTIALITY AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.		OWN: B. HIGMAN 14DEC2008 CHK: T. ELBIN 14DEC2008 APVD: N. DEMING 14DEC2008		Tyco Electronics Harrisburg, PA 17105-3608	
MATERIAL:		WEIGHT:		SIZE: A CAGE CODE: 00779 DRAWING NO: 1855451		RESTRICTED TO:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 3:5 SHEET 1 OF 1 REV C	