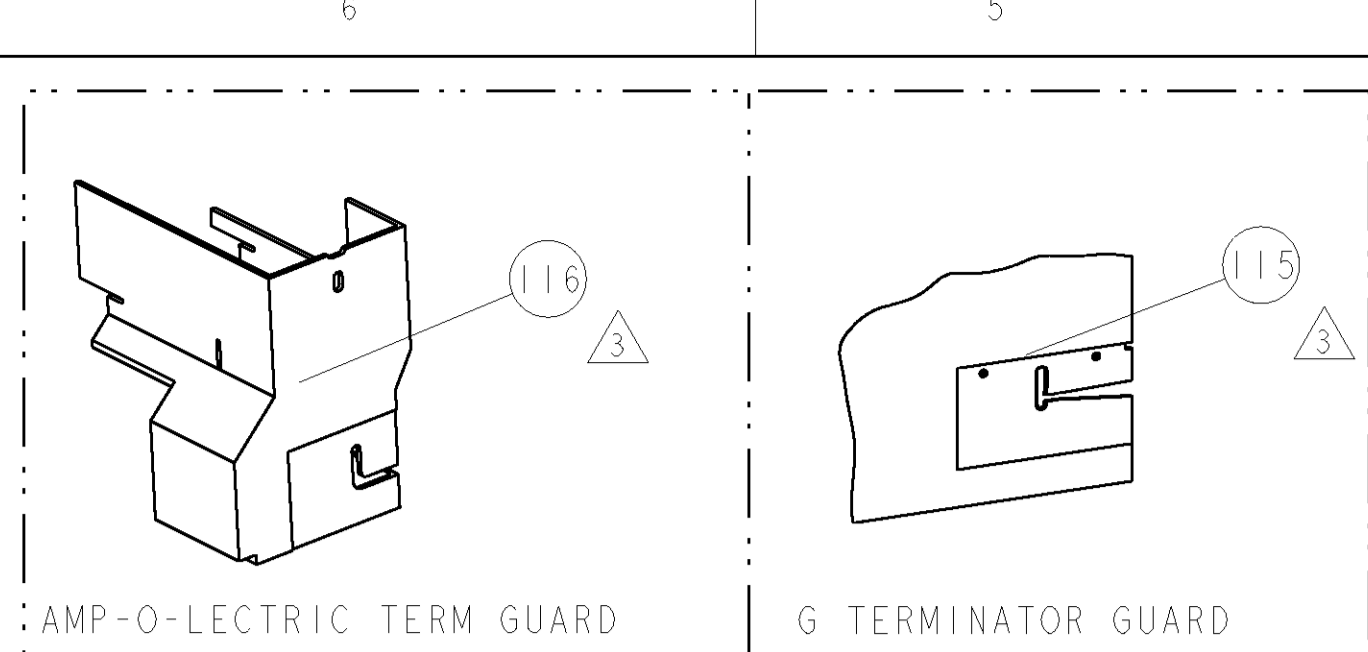


| PART NUMBER | REV | FIRST USED | POWER UNIT | FEED TYPE | DESCRIPTION |
|-------------|-----|------------|---------------|-----------|--------------------|
| 1855380-1 | A | 122500-1 | LEADMAKER | POST FEED | CUTS CARRIER |
| 1855380-2 | A | 565435-5 | BENCH MODEL K | PRE FEED | CUTS CARRIER |
| 1855380-3 | A | 354500-1 | BENCH MODEL G | PRE FEED | CUTS CARRIER |
| 1855380-6 | A | 122500-1 | LEADMAKER | POST FEED | CONTINUOUS CARRIER |
| 7-1855380-7 | A | - | - | - | SPARE PARTS |

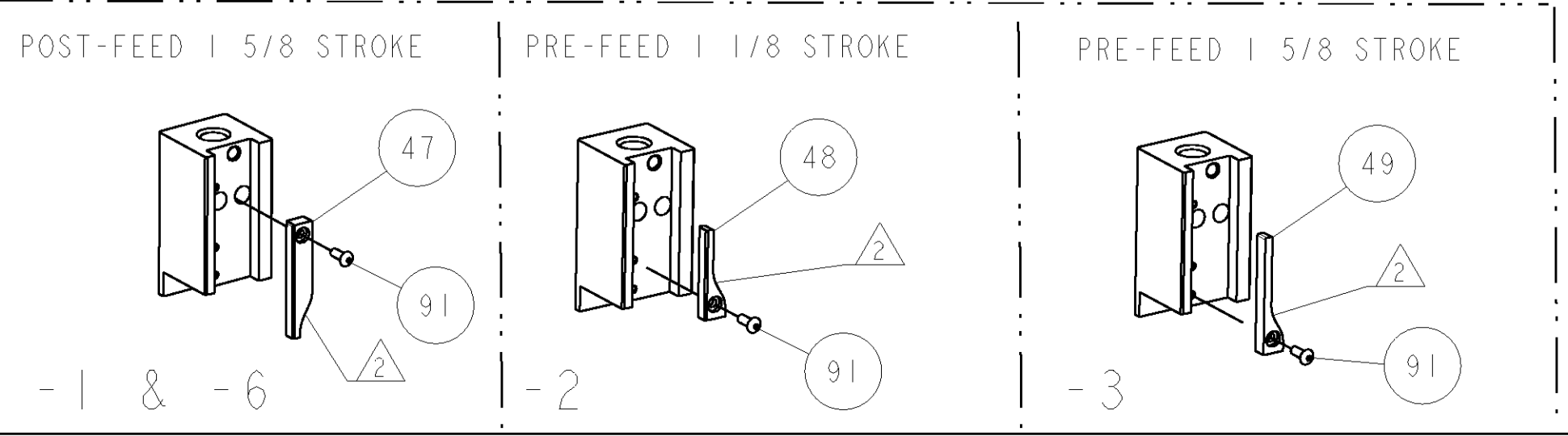
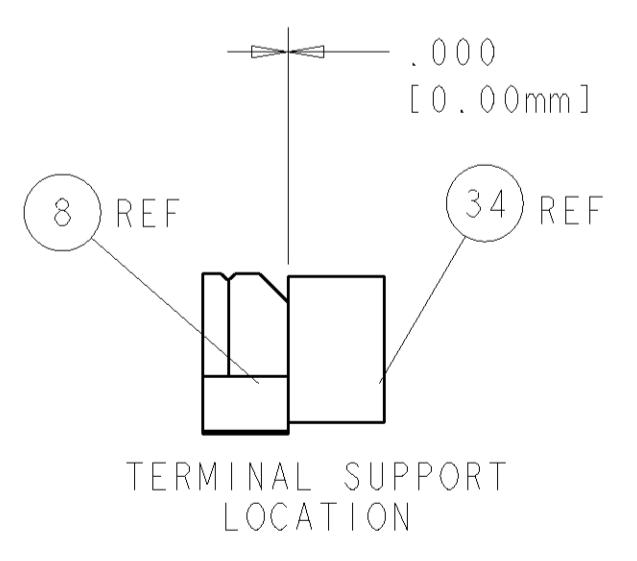
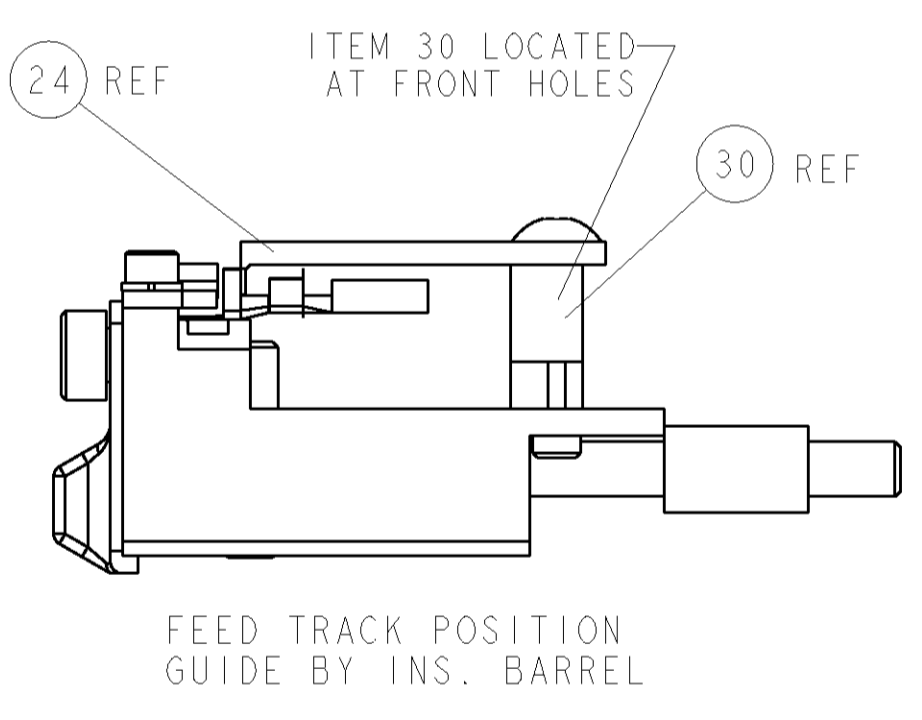
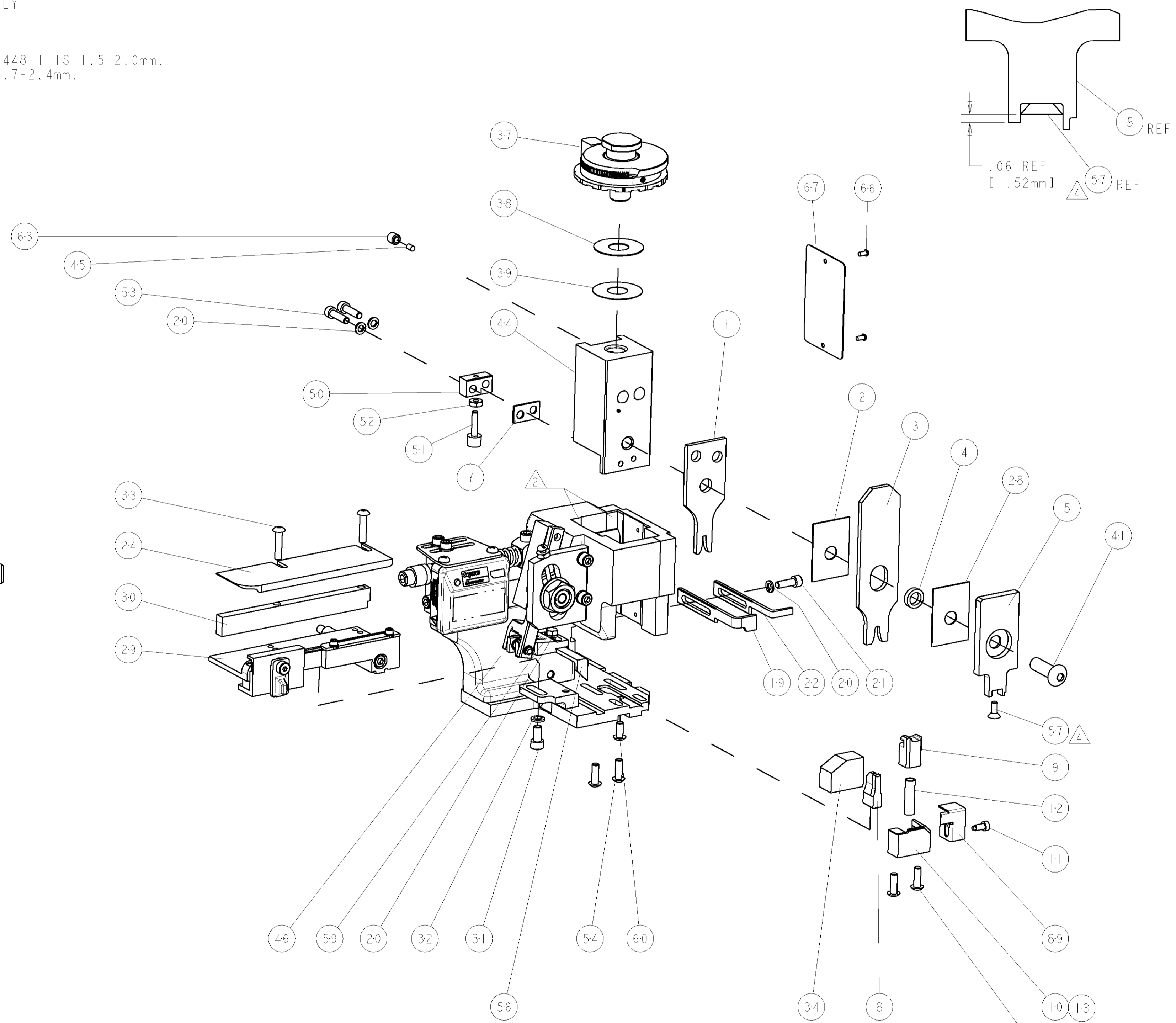


| TEAL | | COMP PN | | SUMITOMO TERMINAL - TE CRIMP SPECS | | REF SETTING | |
|-------------------|----------------|---------|-------------------------|---------------------------------------|-----------------|-------------|--|
| 1572445 | 8240-4992 | | | | | | |
| | | | | CRIMP HEIGHT | WIRE SIZE | REF SETTING | |
| | | | | 1.20mm+.05/-0.05 [.047+.002/-0.002] | 1mm2 | C9 | |
| | | | | 1.14mm+.05/-0.05 [.045+.002/-0.002] | 18AWG or 0.8mm2 | D4 | |
| TE SEAL | COMP SEAL | CRIMP | SIZE | TYPE | RANGE | | |
| 1572448-1 | 7165-0194 | WIRE | 2.29mm [.090] | F | .80mm-1mm | | |
| 1572081-1 | 7165-0118 | INSUL | 3.81mm [.150] | O | Ø 3.300 MAX | | |
| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPLICATOR INSTRUCTIONS | | SET UP GAGE | | |
| 4.550-4.980 | NONE | 12.570 | 408-8040 | | 458637-1 | | |

| LOC | DIST | REV | DESCRIPTION | DATE | BY | APPV |
|-----|------|-----|-------------|-----------|----|------|
| A | 66 | | RELEASED | 04APR2008 | BH | BH |

- △ RECOMMENDED SPARE PARTS
- △ GREASE LIGHTLY
- △ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
- △ APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY PN 1-23419-5 LOC-TITE TO THREADS.
- △ THE INSULATION RANGE LISTED IS FOR THE SEAL. THE INS. RANGE FOR SEAL #1572448-1 IS 1.5-2.0mm. THE INS. RANGE FOR SEAL #1572081-1 IS 1.7-2.4mm.

*** 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.



| QTY | REF | DESCRIPTION | ITEM NO |
|-----|-----|---------------------------------------|----------|
| - | - | REF | 455749-1 |
| - | - | REF | 679532-1 |
| - | 1 | SCR, BTN SKT HD CAP 6-32 X .375 | 91 |
| - | 1 | GUARD, FRONT CHIP | 89 |
| - | 1 | SF APPL INST 408-8040 | 72 |
| - | 1 | GENERAL INSTRUCTION PKG | 71 |
| - | 1 | PLATE, IDENTIFICATION | 67 |
| - | 2 | SCREW, DRIVE | 66 |
| - | 1 | SCR, SET, SELF LOCKING 1/4-20 X .250 | 63 |
| - | 1 | SCR, BHSC, SELF-LOCKING, 8-32 X .375 | 60 |
| - | 1 | SCR, HEX HD CAP 8-32 X .312 | 59 |
| - | 1 | SCR, FLT SKT HD CAP 6-32 X .375 | 57 |
| - | 1 | PAWL, FEED | 56 |
| - | 4 | SCR, BTN SKT HD CAP 8-32 X .500 | 54 |
| - | 2 | SCR, SKT HD CAP 8-32 X .625 | 53 |
| - | 1 | NUT, HEX, REG 6-32 | 52 |
| - | 1 | BUMPER, HOLD DOWN | 51 |
| - | 1 | SPACER, TONKER | 50 |
| - | - | CAM, PRE FEED, 1 5/8 | 49 |
| - | - | CAM, PRE FEED, 1 1/8 | 48 |
| - | - | CAM, POST FEED, 1 5/8 | 47 |
| - | 1 | APPL. BASIC SUB ASSY (SIDE WISE MOCA) | 46 |
| - | 1 | PLUG, NYLON | 45 |
| - | 1 | RAM, SIDE FEED | 44 |
| - | 1 | SCR, BTN SKT HD CAP 5/16-24 X 1.00 | 41 |
| - | 1 | SHIM SUB-ASSY | 39 |
| - | 1 | SHIM | 38 |
| - | 1 | FINE ADJUST HEAD ASSEMBLY | 37 |
| - | 1 | TERMINAL SUPPORT | 34 |
| - | 2 | SCR, BTN SKT HD CAP 8-32 X .750 | 33 |
| - | 1 | WASHER, SPRG LOCK, REG NO 10 | 32 |
| - | 1 | SCR, SKT HD CAP 10-32 X .375 | 31 |
| - | 1 | SPACER, STRIP GUIDE | 30 |
| - | 1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | SPACER, CRIMPER | 28 |
| - | 1 | PLATE, STRIP GUIDE | 24 |
| - | 1 | STRIPPER | 22 |
| - | 1 | SCR, SKT HD CAP 8-32 X .500 | 21 |
| - | 4 | WASHER, SPRG LOCK, REG NO 8 | 20 |
| - | - | STRIPPER | 19 |
| - | 1 | SHEAR HOLDER, FRONT (NO CUT) | 13 |
| - | 1 | SPRING, COMPRESSION | 12 |
| - | 1 | STOP, SHEAR | 11 |
| - | - | SHEAR HOLDER, FRONT | 10 |
| - | 1 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | ANVIL, COMBINATION .090 | 8 |
| - | 1 | SPACER | 7 |
| - | - | - | 6 |
| - | 1 | DEPRESSOR, SHEAR | 5 |
| - | 1 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | CRIMPER, INSUL O PREMIUM | 3 |
| - | 1 | SPACER, CRIMPER | 2 |
| - | 1 | CRIMPER, WIRE PREMIUM | 1 |

| DIMENSIONS: | TOLERANCES UNLESS OTHERWISE SPECIFIED: | DATE | BY | APPV |
|-------------|---|------------------|---|------------------------|
| INCHES | 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.001 4 PLC ±.0001 | 06JAN2008 | B. HIGMAN | B. HIGMAN |
| MATERIAL: | FINISH: | NAME | Tyco Electronics Harrisburg, PA 17105-3608 | |
| | | PRODUCT SPEC | FINE ADJUST SIDE FEED HDM APPLICATOR | |
| | | APPLICATION SPEC | SIZE | CAGE CODE DRAWING NO |
| | | WEIGHT | A1 | 00779 C=1855380 |
| | | CUSTOMER DRAWING | SCALE | 3:5 SHEET 1 OF 1 REV A |

CUSTOMER VIEWABLE ASSEMBLY