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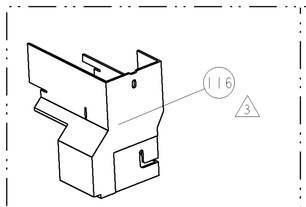
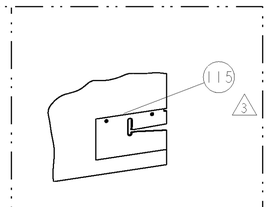
PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1852634-1	B	122500-1	LEADMAKER	POST FEED	CUTS CARRIER
1852634-2	B	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER
1852634-3	B	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER
7-1852634-7	A	-	-	-	SPARE PARTS



AMP-O-LECTRIC TERM GUARD



G TERMINATOR GUARD

TERMINAL NAME: CRIMP TERM.,FEMALE,.125/(3.05)DIA.INSUL.

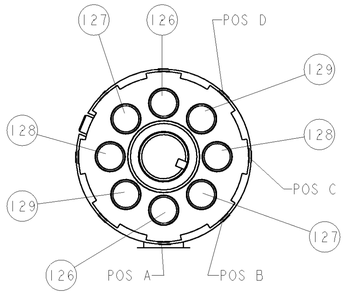
TE PN	MFR PN	MOLEX TERMINAL - MOLEX CRIMP SPECS			
1949610-1	18-12-1221				
2113042-1	18-12-2221	PAD LTR	CRIMP HEIGHT		WIRE SIZE
-	-	A	1.62±0.05mm[.064±.002]		16AWG
-	-	B	1.60±0.05mm[.063±.002]		17AWG
-	-	C	1.56±0.05mm[.062±.002]		18AWG
-	-	D	1.55±0.05mm[.061±.002]		(1)18+(1)22
-	-	CRIMP	SIZE	TYPE	RANGE
-	-				
-	-	WIRE	2.29mm [.090]	F	18+22-16 AWG
-	-	INSUL	3.81mm [.150]	F	Ø2.75-3.05
WIRE STRIP LENGTH 4.06-5.59	TERM APPL SPEC NONE	FEED 16.51mm	APPLICATOR INSTRUCTIONS 408-8040		SET UP GAGE 458637-1

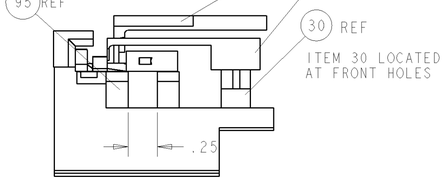
LOC	DIST
A	66

REVISIONS

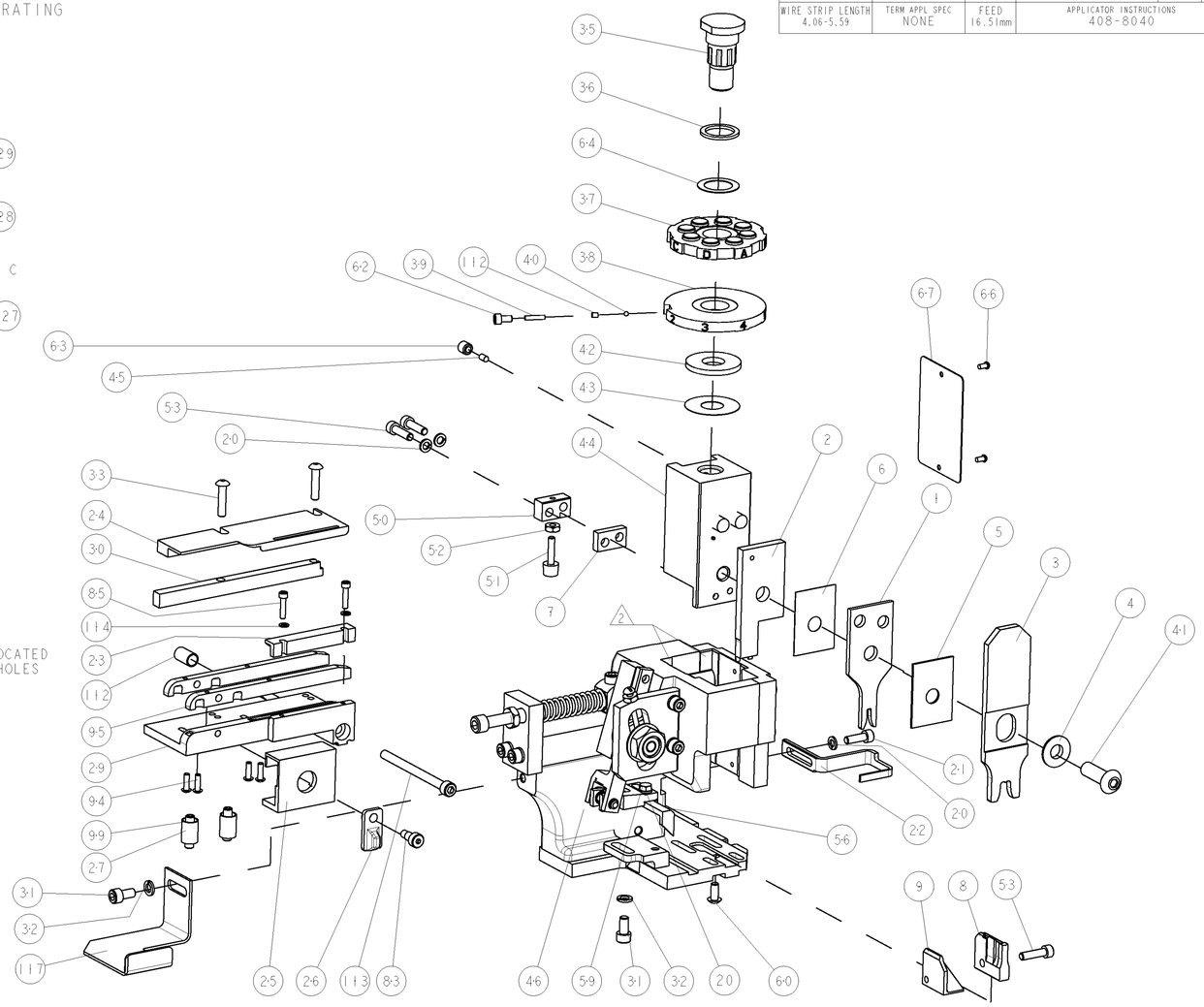
P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	RELEASED	16MAY2008	BH	BH
	B	ECR-09-022471	14OCT2009	MY	TE

1. RECOMMENDED SPARE PARTS
2. GREASE LIGHTLY
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE



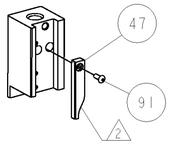


FEED TRACK POSITION

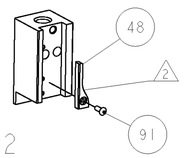


-	2	2	2	-	1-354779-0	PIN, WIRE DISC, .3040	129
-	2	2	2	-	354779-8	PIN, WIRE DISC, .3030	128
-	2	2	2	-	354779-3	PIN, WIRE DISC, .3005	127
-	2	2	2	-	354779-4	PIN, WIRE DISC, .3010	126
-	1	1	1	-	1633677-1	GUIDE, TERMINAL	117
3 -	REF	-	-	..	455749-1	GUARD WINDOW	116
3 -	REF	-	-	..	679532-1	INSERT, GUARD	115
-	2	2	2	-	21024-2	WASHER, SPRG LOCK, REG NO 4	114
-	1	1	1	-	8-21000-7	SCR, SKT HD CAP 10-32 X 2.500	113
-	1	1	1	-	690603-1	SPRING ASSIST AMP-O-MATOR APPLICATOR	112
-	1	1	1	-	1-22281-8	SPRING, COMPRESSION	112
-	2	2	2	-	5-21006-6	SCR, SET, CUP POINT 10-32 X .750	99
-	2	2	2	-	189807-9	FENCE	95
-	4	4	4	-	1-21002-4	SCR, BTN SKT HD CAP 4-40 X .375	94
-	1	1	1	-	1-21002-7	SCR, BTN SKT HD CAP 6-32 X .375	91
-	2	2	2	-	1-21000-5	SCR, SKT HD CAP 4-40 X .500	85
-	1	1	1	-	21989-8	SCR, SKT HD SHLDR 3/16 DIA X .250	83
-	1	1	1	-	4088040	SF APPL INST 408-8040	72
-	1	1	1	-	217238-1	GENERAL INSTRUCTION PKG	71
-	1	1	1	-	461264-1	PLATE, IDENTIFICATION	67
-	2	2	2	-	21017-2	SCREW, DRIVE	66
-	1	1	1	-	986950-1	WASHER, FLAT PRECISION	64
-	1	1	1	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	63
-	1	1	1	-	23030-1	SCR, SKT HD CAP 6-32 x .25	62
-	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	-	3-694433-7	FEED PAWL	56
-	3	3	3	-	2-21000-8	SCR, SKT HD CAP 8-32 X .625	53
-	1	1	1	-	21018-5	NUT, HEX, REG 6-32	52
-	1	1	1	-	811242-2	BUMPER, HOLD DOWN	51
-	1	1	1	-	690753-1	SPACER, TONKER	50
-	1	-	-	..	690602-6	CAM, PRE FEED, 1 5/8	49
-	-	1	-	..	690602-5	CAM, PRE FEED, 1 1/8	48
-	-	-	1	-	690501-4	CAM, POST-FEED 1 5/8	47
-	1	1	1	-	459456-1	APPL. BASIC SUB ASSY (SIDE WISE MQCA)	46
-	1	1	1	-	690191-1	PLUG,NYLON	45
-	1	1	1	-	455673-8	RAM, SIDE FEED	44
-	1	1	1	-	690125-1	SHIM SUB-ASSY	43
-	1	1	1	-	690124-1	WASHER, RAM (.115)	42
-	1	1	1	-	690686-1	CRIMPER, BOLT SPECIAL	41
-	1	1	1	-	23241-6	BALL, STEEL	40
-	1	1	1	-	690170-1	SPRING, COMPRESSION	39
-	1	1	1	-	1-690142-1	DISC, INSULATION	38
-	1	1	1	-	354777-1	WIRE DISC, ASSEMBLY	37
-	1	1	1	-	22480-5	SPRING, COMPRESSION	36
-	1	1	1	-	690212-1	POST, RAM	35
-	2	2	2	-	2-21002-4	SCR, BTN SKT HD CAP 8-32 X .750	33
-	2	2	2	-	21024-5	WASHER, SPRG LOCK, REG NO 10	32
-	2	2	2	-	3-21000-4	SCR, SKT HD CAP 10-32 X .375	31
-	1	1	1	-	2-1320908-4	SPACER, STRIP GUIDE	30
-	1	1	1	-	1-1633087-6	PLATE, STRIP GUIDE	29
-	2	2	2	-	22282-1	SPRING, COMPRESSION	27
-	1	1	1	-	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	-	5-690754-3	DRAG, SPECIAL	25
-	1	1	1	-	1-1320860-5	STRIP GUIDE, REAR	24
-	1	1	1	-	2-690712-6	FRONT STRIP GUIDE	23
-	-	-	1	-	1-458230-5	STRIPPER	22
-	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	-	3-853714-9	PLATE, REAR SHEAR	9
1	1	1	1	-	1633054-4	ANVIL, SPECIAL	8
1 -	1	1	1	-	1-240641-0	SPACER	7
-	1	1	1	-	455888-2	SPACER, CRIMPER	6
-	1	1	1	-	455888-9	SPACER, CRIMPER	5
-	1	1	1	-	1-238009-4	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	-	1633676-1	CRIMPER, INSULATION F	3
1 -	1	1	1	-	2-853720-3	BLADE, SLUG	2
1	1	1	1	-	4-456406-1	CRIMPER, WIRE PREMIUM	1
-77	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

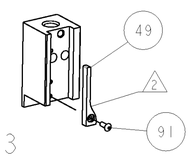
POST-FEED 1 5/8 STROKE



PRE-FEED 1 1/8 STROKE



PRE-FEED 1 5/8 STROKE



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DWN B.HIGMAN	21MAR2008	tyco Electronics — Tyco Electronics, Harrisburg, PA 17105-3608
CHK B.HIGMAN	21MAR2008	
APVD T.ELBIN	21MAR2008	NAME: SIDE FEED HDM APPLICATOR
PRODUCT SPEC: -		-
APPLICATION SPEC: -		-
WEIGHT: -		SIZE A1 · CAGE CODE 00779 · DRAWING NO C-1852634 · RESTRICTED TO -
CUSTOMER DRAWING		SCALE 3:5 · SHEET 1 OF 1 · REV B

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±0.1
2 PLC ±0.01
3 PLC ±0.001
4 PLC ±0.0001
ANGLES ±

MATERIAL: -
FINISH: -

CUSTOMER ACCESSIBLE PRODUCTION DRAWING