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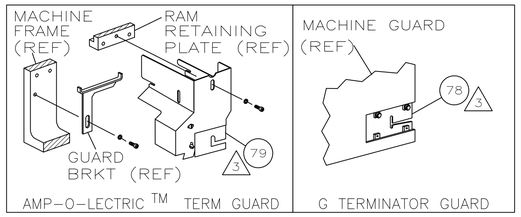
PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE
1852701-1	A	122500-1	LEADMAKER	POST FEED
1852701-2	A	565435-5	BENCH MODEL K	PRE FEED
1852701-3	A	354500-1	BENCH MODEL G	PRE FEED



TERMINAL NAME: ∅.093 SOCKET

AMP TERM PN	MFR TERM PN
PIN	
940318-1	02-09-2116
940318-2	02-09-6122
940318-3	02-09-6125
940318-4	02-09-1151
940318-5	02-09-8103
SOCKET	
940319-1	02-09-1117
940319-2	02-09-5143
940319-3	02-09-5130
940319-4	02-09-1122
940319-5	02-09-1203
940319-6	02-09-1208

MOLEX TERMINAL — CRIMP SPECS

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.057 ±.002 [1.45 ±0.05mm]	18
B	.053 ±.002 [1.35 ±0.05mm]	20
C	.050 ±.002 [1.27 ±0.05mm]	22
D	NOT	USED

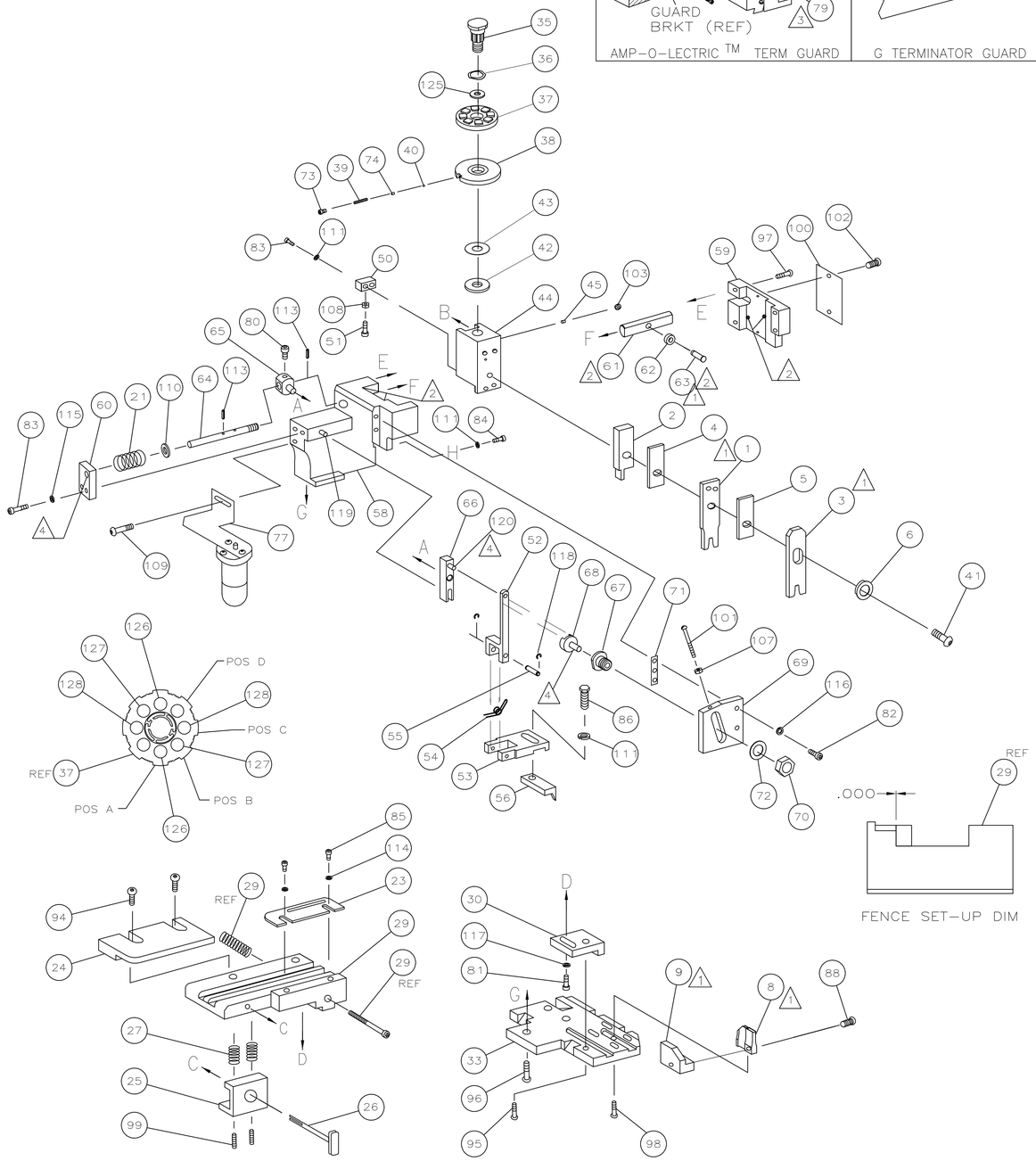
CRIMP	SIZE	TYPE	RANGE
WIRE	.080 [2.03mm]	F	22-18
INSUL	.090 [2.29mm]	F	∅.051-.091

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.156-.188	NONE	.498	408-8040	458637-1	L1676Q

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	ORIGINAL	-	-	-

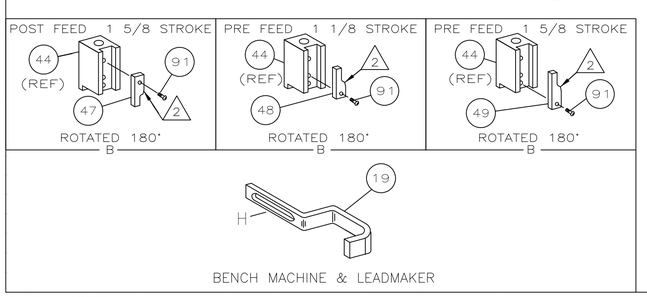


-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
						129
2	2	2	-	3-354779-9	PIN, WIRE DISC (.3185)C	128
2	2	2	-	3-354779-3	PIN, WIRE DISC (.3155)B	127
2	2	2	-	2-354779-5	PIN, WIRE DISC (.3115)A	126
1	1	1	-	986950-1	WASHER, FLAT PRECISION	125
1	1	1	-	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	1	-	4088040	SF APPL INST 408-8040	123
						122
						121
REF	REF	REF	-	1-21030-1	PIN,DOWEL(∅.187x.50)LEVER	120
REF	REF	REF	-	1-21030-6	PIN,DOWEL(∅.187x1.25)HOUSING	119
REF	REF	REF	-	21045-3	RING,RET "C"(∅.187)FD FING PIN	118
3	3	3	-	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
REF	REF	REF	-	21024-5	WASHER,LOCK(#10)ADJ PLATE	116
REF	REF	REF	-	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115
2	2	2	-	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
REF	REF	REF	-	5-21028-1	PIN,SLT SPR(∅.125x.50)ADJ ROD	113
						112
4	4	4	-	21024-4	WASHER,LOCK(#8)STRIPPER	111
REF	REF	REF	-	21899-4	WASHER,FLAT(∅5/16)SCREW ADJ	110
-	1	-	-	2-21002-6	SCR,BHC(10-32x.38)LUBE ASSY	109
1	1	1	-	21018-5	NUT,HEX(6-32)	108
REF	REF	REF	-	21068-5	NUT,HEX(6-32)FEED ADJ	107
						106
						105
						104
1	1	1	-	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
2	2	2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
REF	REF	REF	-	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
1	1	1	-	461264-1	PLATE, IDENTIFICATION	100
2	2	2	-	5-21006-6	SCR,SET(10-32x.75)DRAG	99
1	1	1	-	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
REF	REF	REF	-	2-21002-9	SCR,BHC(10-32x.75)CAP	97
REF	REF	REF	-	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
REF	REF	REF	-	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
2	2	2	-	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
						93
						92
1	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	91
						90
						89
1	1	-	-	2-21000-7	SCR,SHC(8-32x.88)SHEAR	88
						87
1	1	1	-	2-22603-1	SCR,HEX HD(8-32x.38)FEED FINGER	86
2	2	2	-	1-21000-4	SCR,SHC(4-40x.50)FR ST GUIDE	85
1	1	1	-	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
2	2	2	-	2-21000-7	SCR,SHC(8-32x.38)HOLDDOWN	83
REF	REF	REF	-	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	82
1	1	1	-	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
REF	REF	REF	-	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	80
-	1	-	-	462992-7	GUARD ASSY	79
REF	-	-	-	679532-1	INSERT, GUARD	78
-	1	-	-	1-465184-0	LUBRICATOR ASSY	77
						76
						75
1	1	1	-	690603-1	SPRING, ASSIST	74
1	1	1	-	23030-1	SCR,SHC(6-32x.25 SL)INS DISC	73
REF	REF	REF	-	458109-1	WASHER, SPECIAL	72
REF	REF	REF	-	690517-1	SPACER	71

QTY REQD PER ASSY — PARTS LIST

-3	-2	-1	U/M	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
1	1	1	-	454220-1	CAP, RAM	59
REF	REF	REF	-	454485-1	HOUSING	58
						57
1	1	1	-	3-694433-2	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	-	455673-8	RAM	44
1	1	1	-	690125-1	WASHER, LAMINATED	43
1	1	1	-	690124-1	WASHER, RAM	42
1	1	1	-	690686-2	BOLT, CRIMPER(5/16x1.10)	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
						34
REF	REF	REF	-	455675-1	PLATE, BASE	33
						32
						31
REF	REF	REF	-	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	1-318756-4	PLATE, STRIP GUIDE	29
						28
2	2	2	-	8-22281-7	SPRING, DRAG	27
1	1	1	-	690546-1	LEVER, DRAG RELEASE	26
1	1	1	-	2-690754-1	DRAG, TERMINAL	25
1	1	1	-	1320860-2	GUIDE, STRIP (REAR)	24
1	1	1	-	1-690712-8	GUIDE, STRIP (FRONT)	23
						22
REF	REF	REF	-	4-22284-9	SPRING, FEED RETURN	21
						20
1	1	1	-	1-458230-5	STRIPPER	19
						18
						17
						16
						15
						14
						13
						12
						11
						10
1	1	1	-	2-853714-0	PLATE, REAR SHEAR	9
1	1	1	-	1633054-3	ANVIL	8
						7
1	1	1	-	238009-4	SPACER, BLOCK CRIMPER	6
1	1	1	-	455888-6	SPACER, CRIMPER	5
1	1	1	-	455888-2	SPACER, CRIMPER	4
1	1	1	-	5-1424909-4	CRIMPER, INSULATION	3
1	1	1	-	1-853720-4	BLADE, SLUG	2
1	1	1	-	3-456405-9	CRIMPER, WIRE	1

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.

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ± -
1 PLC ± -
2 PLC ± .25
3 PLC ± .020
4 PLC ± -
ANGLES ± -

MATERIAL -
FINISH -

DWN B.HIGMAN 23SEPT02
CHK B.HIGMAN 23SEPT02
APVD T.BENCHOFF 23SEPT02
PRODUCT SPEC —
APPLICATION SPEC —
WEIGHT —

Tyco Electronics — Tyco Electronics Corporation, Harrisburg, PA 17105-3608

NAME: SIDE FEED HDM APPLICATOR

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1852701	—

CUSTOMER DRAWING — SCALE — — SHEET 1 OF 1 — REV A

AMP 4805 REV 31MAR2000

13MAY2008 9:10am