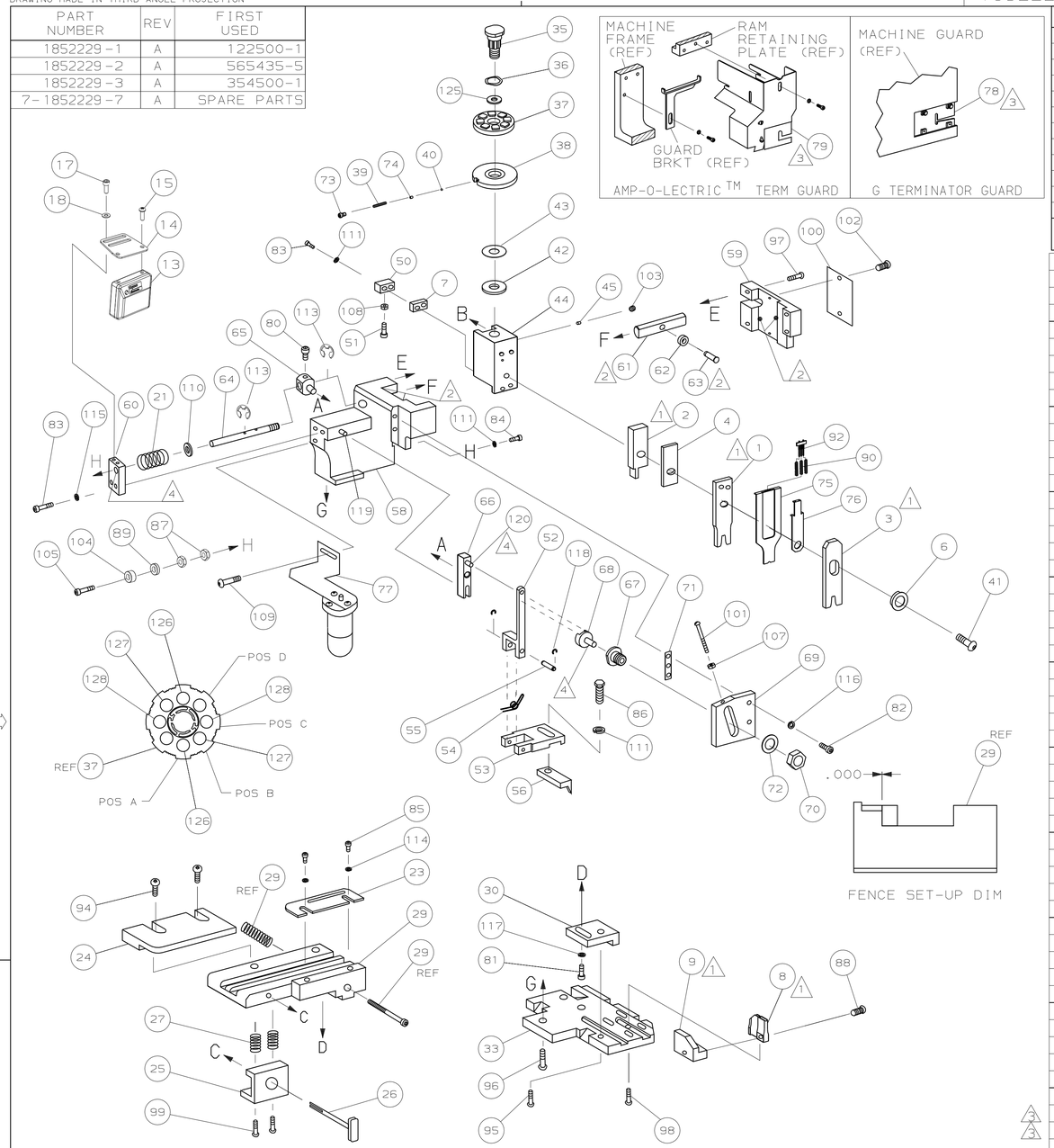
DRAWING MADE IN THIRD ANGLE PROJECTION

1852229 ⇔ 1852229

/home/us024474/tecmod

PART NUMBER	REV	FIRST USED
1852229-1	A	122500-1
1852229-2	A	565435-5
1852229-3	A	354500-1
7-1852229-7	A	SPARE PARTS



TERMINAL NAME: CRIMP TERMINAL PIN & SOCKET

AMP TERM PN	MFR TERM PN
PIN	
1949000-1	18-12-2601
1949000-2	18-12-1607
SOCKET	
1949036-1	18-12-1601
1949036-2	018-12-1603

MOLEX TERMINAL — MOLEX CRIMP SPECS

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.083 ±.002 [2.11 ±0.05mm]	10
B	.080 ±.002 [2.03 ±0.05mm]	12
C	.073 ±.002 [1.85 ±0.05mm]	14
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.148 [3.76mm]	F	14-10
INSUL	.200 [5.08mm]	F	ø.180 MAX

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.160-.220	NONE	.645	408-8040	458637-1	L4038

-1	LEADMAKER	MECH POST FEED
-2	BENCH MODEL K	MECH PRE FEED
-3	BENCH MODEL G	MECH PRE FEED

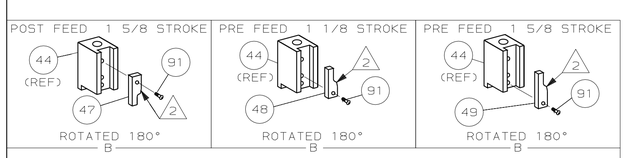
-77 SPARE PARTS KIT

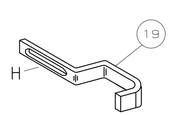
-77	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
							129
-	2	2	2	-	354779-4	PIN, WIRE DISC (.3010)C	128
-	2	2	2	-	8-354778-9	PIN, WIRE DISC (.2940)B	127
-	2	2	2	-	8-354778-3	PIN, WIRE DISC (.2910)A	126
-	1	1	1	-	986950-1	WASHER, FLAT PRECISION	125
-	1	1	1	-	217238-1	GENERAL INSTRUCTION PACKAGE	124
-	1	1	1	-	4088040	SF APPL INST 408-8040	123
							122
							121
-	REF	REF	REF	-	1-21030-1	PIN,DOWEL(ø.187x.50)LEVER	120
-	REF	REF	REF	-	1-21030-6	PIN,DOWEL(ø.187x1.25)HOUSING	119
-	REF	REF	REF	-	21045-3	RING,RET "C"(ø.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	-	1-21046-6	RING,RET E (5/16)ADJ ROD	113
							112
-	4	4	4	-	21024-4	WASHER,LOCK(#8)STRIPPER	111
-	REF	REF	REF	-	21899-4	WASHER,FLAT(ø5/16)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
-	REF	REF	REF	-	3-21081-3	SCR,SHC (1/4-20X1.25)COUNTER	105
-	REF	REF	REF	-	1804299-1	SPACER, MAGNET	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,SKT 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
-	1	1	1	-	1424350-1	HOLDER, PIN, WIRED	92
-	1	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	91
-	3	3	3	-	2-23147-2	SPRING, DEPRESSOR	90
-	REF	REF	REF	-	1804310-1	MAGNET, RING	89
-	1	1	1	-	2-21000-7	SCR,SHC(8-32x.88)SHEAR	88
-	REF	REF	REF	-	22593-1	NUT,HEX JAM(1/4-20)COUNTER	87
-	1	1	1	-	2-22603-1	SCR,HEX HD(8-32x.38)FEED FINGER	86
-	2	2	2	-	1-21000-5	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	-	2-21000-8	SCR,SHC(8-32x.62)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
-	1	1	1	-	1490524-1	SPACER, DEPRESSOR	76
-	1	1	1	-	1490525-3	DEPRESSOR, WIRE	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		

-77	-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	-	1804311-1	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	-	1804305-2	GUIDE, FEED ROD	60
-	1	1	1	-	454220-1	CAP, RAM	59
-	REF	REF	REF	-	454485-1	HOUSING	58
							57
-	1	1	1	-	2-694433-9	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	-	455679-2	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	-	459456-2	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	-	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	-	22281-9	SPRING, DRAG	27
-	1	1	1	-	690546-1	LEVER, DRAG RELEASE	26
-	1	1	1	-	2-690754-1	DRAG, TERMINAL	25
-	1	1	1	-	1-1320860-4	GUIDE, STRIP (REAR)	24
-	1	1	1	-	2-690712-1	GUIDE, STRIP (FRONT)	23
							22
-	REF	REF	REF	-	4-22284-9	SPRING, FEED RETURN	21
							20
-	1	1	1	-	1-458230-5	STRIPPER	19
-	REF	REF	REF	-	18028-2	WASHER, FLAT (M4)COUNTER	18
-	REF	REF	REF	-	9-21000-9	SCR,SHC(8-32X.44)COUNTER	17
							16
-	REF	REF	REF	-	994991-5	SCR,OVAL HD(M4X12)COUNTER	15
-	REF	REF	REF	-	1804303-1	BRACKET, COUNTER MTG	14
-	REF	REF	REF	-	1804300-1	APPLICATOR COUNTER ASSY	13
							12
							11
							10
-	1	1	1	-	3-853714-2	PLATE, REAR SHEAR	9
1	1	1	1	-	1901674-1	ANVIL	8
-	1	1	1	-	240641-7	SPACER, DEPRESSOR (REAR)	7
-	1	1	1	-	238009-1	SPACER, BLOCK CRIMPER	6
							5
-	1	1	1	-	455888-5	SPACER, CRIMPER	4
1	1	1	1	-	3-1213077-2	CRIMPER, INSULATION	3
-	1	1	1	-	2-853720-1	BLADE, SLUG	2
1	1	1	1	-	6-1633305-2	CRIMPER, WIRE	1
QTY REQD PER ASSY					PARTS LIST		

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

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.





BENCH MACHINE LEADMAKER

P	F	LTR	REVISION RECORD	APP	DATE
		A	RELEASED	RK	JUN06

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±.25, 3 PLC DEC ±.020, 4 PLC DEC ±-, ANGLES ±-, SURF TEXTURE: √, REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL – | HT TR – | FIN –

DR 23MAY06 C.ERISMAN | APP 23MAY06 T.ELBIN | CHK 23MAY06 C.ERISMAN | REL 16JUN06 R.KNEPPER

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR | MACHINE REF MINI APPL

SCALE – | D | DWG NO 1852229 | SHEET 1 OF 1 | REV A

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

LOC A | DIST 66

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