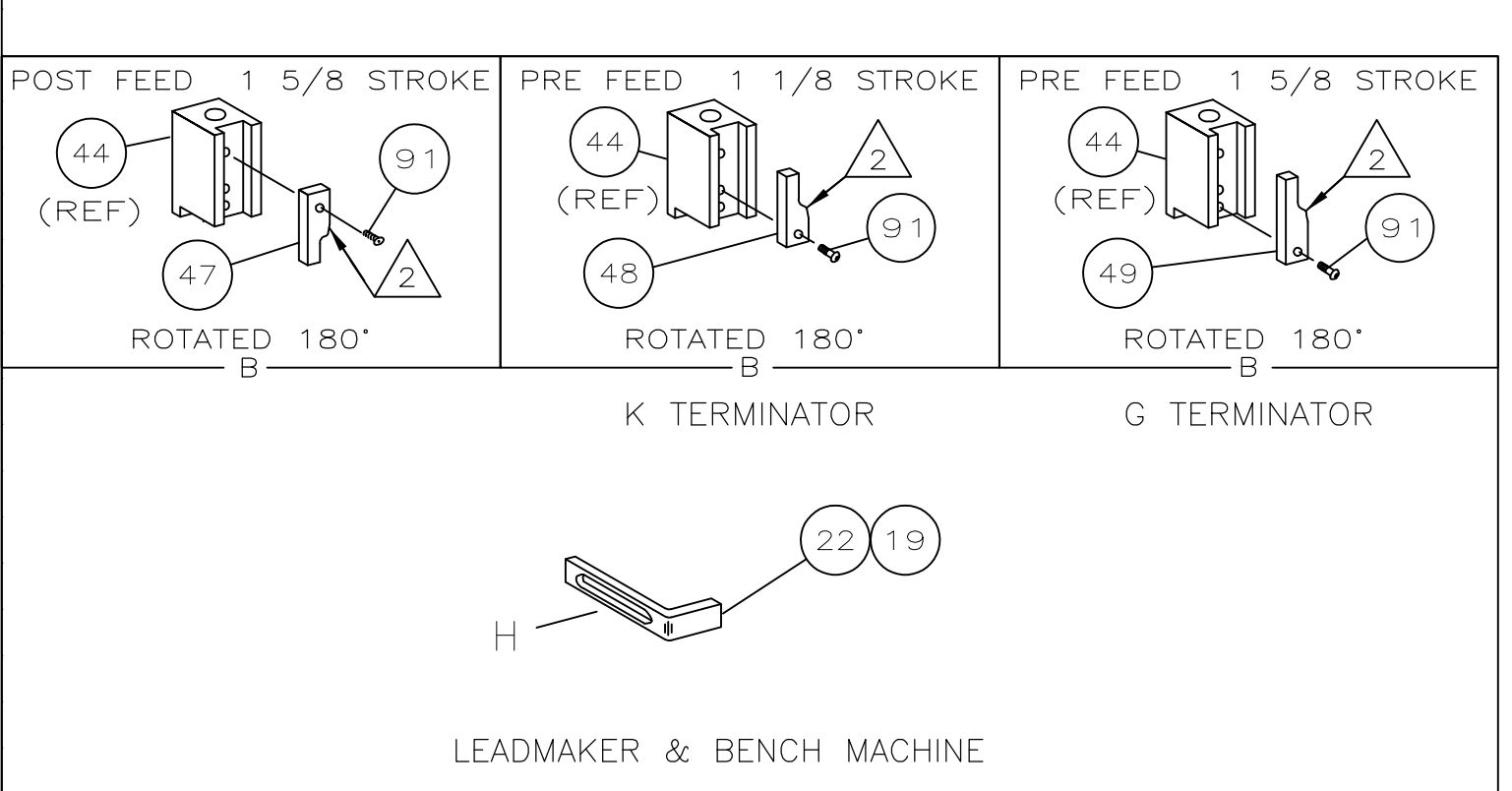
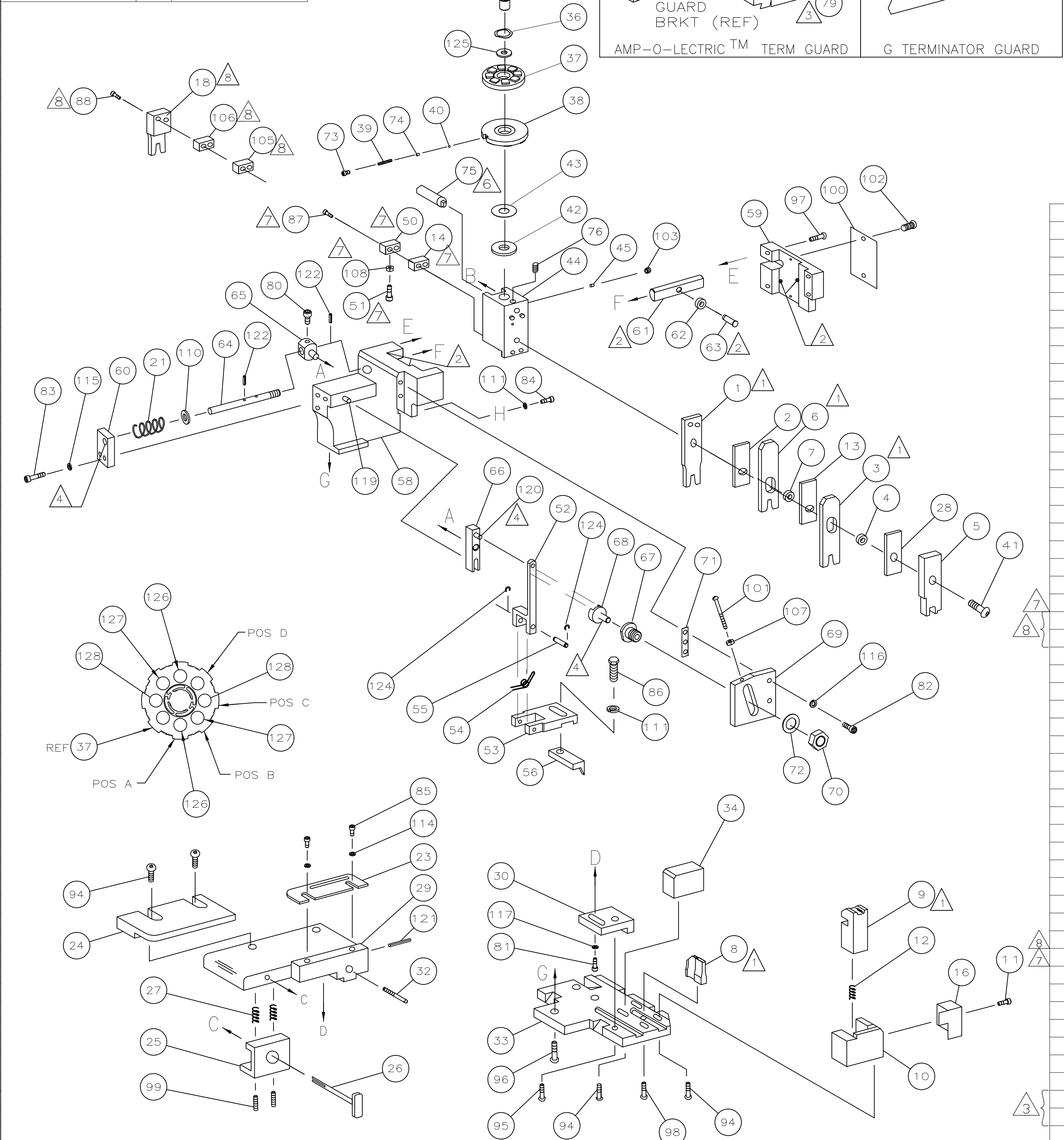
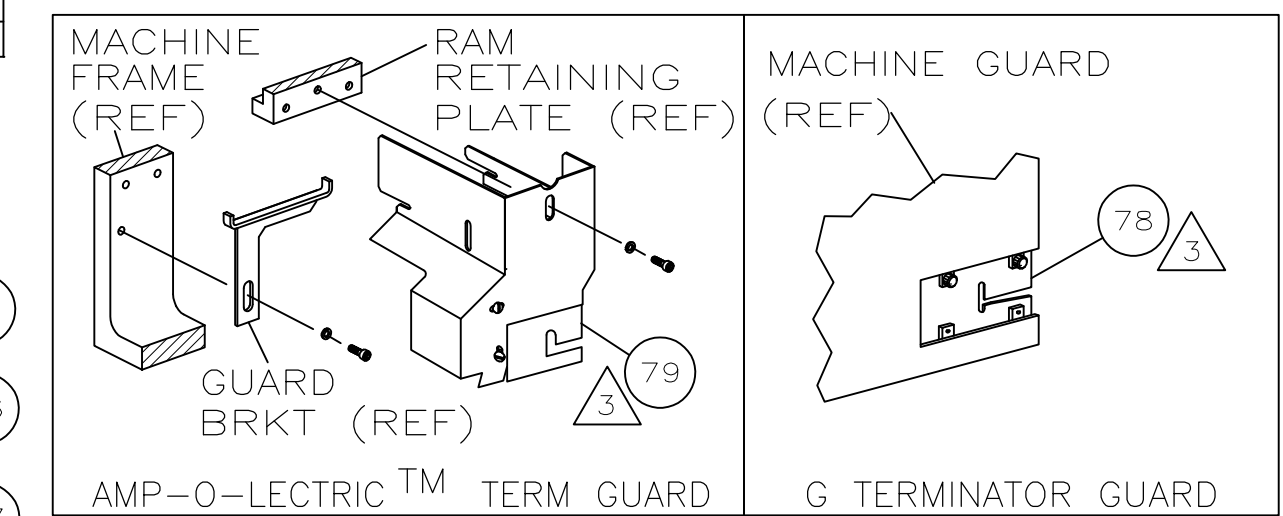


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PART NUMBER	REV	FIRST USED			
1385025-1	E	854400-1			
1385025-2	E	565435-5			
1385025-3	E	354500-1			
7-1385025-7	E	-			



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.
6 STABILIZER CRIMPER SHAFT MUST BE TURNED SO THAT LETTER SHOWING (RIGHT SIDE OF RAM) MATCHES WIRE DISC PAD BEING USED (A,B OR C) AS SHOWN:



TERMINAL NAME: Ø.140 SOCKET & PIN					
CRIMPING DATA					
PAD LTR	CRIMP HEIGHT			WIRE SIZE	
	A	.056 ±.002	[1.42 ±0.05mm]	1.00mm ²	
	B	.052 ±.002	[1.33 ±0.05mm]	.75mm ²	
	C	.049 ±.002	[1.24 ±0.05mm]	.50mm ²	
	D	NOT			USED
CRIMP		SIZE		TYPE	RANGE
WIRE		.080 [2.03mm]		F	.50-1.00mm ²
INSUL		.110 [2.79mm]		OVL	Ø1.20-2.40mm
WIRE STRIP LENGTH		TERM APPL SPEC	FEED	APPL INST	SET UP GAGE LAYOUT
.234-.250		114-1007	.590	408-8040	458637-1 L2338

-	2	2	2	-	2-354779-6	PIN, WIRE DISC (.3120)C	129
-	2	2	2	-	2-354779-0	PIN, WIRE DISC (.3090)B	127
-	2	2	2	-	1-354779-1	PIN, WIRE DISC (.3045)A	126
-	1	1	1	-	986950-1	WASHER, FLAT PRECISION	125
-	REF	REF	REF	-	21045-3	RING,RET "C"(Ø.187)FD FING PIN	124
-	REF	REF	REF	-			123
-	REF	REF	REF	-	5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	122
-	1	1	1	-	4-21028-0	PIN,SLT SPR(Ø.093x.75)ST GDE PL	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
-	1	1	1	-			118
-	REF	REF	REF	-	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	-			113
-	REF	REF	REF	-	21899-4	WASHER,FLAT(Ø5/16)SCREW ADJ	110
-	1	1	1	-			109
-	REF	REF	REF	-	21018-5	NUT,HEX (6-32)	108
-	1	1	1	-	21018-5	NUT,HEX(6-32)FEED ADJ	107
-	1	1	1	-	4-240641-0	SPACER	106
-	1	1	1	-	2-240641-1	SPACER	105
-	1	1	1	-			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
-	4	4	4	-	2-21002-2	HOLDER, INSULATION	94
-	1	1	1	-			93
-	1	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	91
-	2	2	2	-			90
-	2	2	2	-	3-21000-0	SCR,SHC(8-32x.88)	88
-	1	1	1	-	2-21000-8	SCR,SHC(8-32x.62)	87
-	2	2	2	-	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
-	2	2	2	-	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	85
-	1	1	1	-	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
-	REF	REF	REF	-	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	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
-	REF	REF	REF	-	455749-1	GUARD, WINDOW	79
-	REF	REF	REF	-	679532-1	INSERT, GUARD	78
-	1	1	1	-			77
-	1	1	1	-	22859-7	PLUNGER, SPRING	76
-	1	1	1	-	1-453412-6	SHAFT, STABILIZER	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
-77	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY				PARTS LIST			

1 ITEMS 14, 50, 51, 87 AND 108 REQ'D FOR 927841.
2 ITEMS 18, 88, 105 & 106 REQ'D FOR 927843.

LOC		DIST		REVISIONS			
A		66		F LTR	DESCRIPTION	DATE	DWN T APVD
				E	ECR-09-014162	6-2007	MY TE
-1	REF	REF	REF	-	LEADMAKER	MECH POST FEED	
-2	REF	REF	REF	-	BENCH MODEL K	MECH PRE FEED	
-3	REF	REF	REF	-	BENCH MODEL G	MECH PRE FEED	
-77	-	-	-	-	-	SPARE PARTS KIT	
-	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
-	REF	REF	REF	-	454220-1	CAP, RAM	59
-	REF	REF	REF	-	454485-1	HOUSING	58
-	1	1	1	-			57
-	REF	REF	REF	-	458537-2	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	-	455679-2	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	-	817855-4	RAM	44
-	1	1	1	-	690125-1	WASHER, LAMINATED	43
-	1	1	1	-	690124-1	WASHER, RAM	42
-	1	1	1	-	690686-1	BOLT, CRIMPER(5/16x1.00)	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
-	1	1	1	-	690786-1	SUPPORT, TERMINAL	34
-	REF	REF	REF	-	455675-1	PLATE, BASE	33
-	1	1	1	-	690432-3	SCREW, ADJUSTMENT	32
-	REF	REF	REF	-			31
-	REF	REF	REF	-	455689-1	BLOCK, STRIP GUIDE ADJ	30
-	1	1	1	-	455671-1	PLATE, STRIP GUIDE	29
-	1	1	1	-	2-455888-0	SPACER,CRIMPER	28
-	2	2	2	-	1-22284-0	SPRING, DRAG	27
-	1	1	1	-	690546-1	LEVER, DRAG RELEASE	26
-	1	1	1	-	240792-1	DRAG, TERMINAL	25
-	1	1	1	-	8-690504-9	GUIDE, STRIP (REAR)	24
-	1	1	1	-	690438-1	GUIDE, STRIP (FRONT)	23
-	-	-	1	-	690472-9	STRIPPER	22
-	REF	REF	REF	-	4-22284-9	SPRING, FEED RETURN	21
-	1	1	-	-			20
-	1	1	1	-	691353-1	STRIPPER	19
-	1	1	1	-	1338766-1	TOOL SIZING	18
-	1	1	1	-			17
-	1	1	1	-	691667-1	GUARD, CHIP (FRONT)	16
-	1	1	1	-			15
-	1	1	1	-	2-240641-9	SPACER, DEPRESSOR (REAR)	14
-	1	1	1	-	455888-4	SPACER, CRIMPER	13
-	1	1	1	-	3-22280-3	SPRING, SHEAR	12
-	1	1	1	-	690461-1	STOP, SHEAR	11
-	1	1	1	-	690459-1	HOLDER, SHEAR (FRONT)	10
-	1	1	1	-	454276-1	SHEAR, FLOAT (FRONT)	9
1	1	1	1	-	1338767-1	ANVIL	8
-	1	1	1	-	238011-2	SPACER, BLOCK CRIMPER	7
-	1	1	1	-	817852-4	CRIMPER, STABILIZER	6
-	1	1	1	-	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	-	238011-7	SPACER, BLOCK CRIMPER	4
1	1	1	1	-	854830-1	CRIMPER, INSULATION	3
-	1	1	1	-	455888-6	SPACER, CRIMPER	2
1	1	1	1	-	1-817854-9	CRIMPER, WIRE	1
-77	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY				PARTS LIST			

THIS DRAWING IS A CONTROLLED DOCUMENT.				Tyco Electronics Corporation Harrisburg, PA 17105-3608			
DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		SIDE FEED HDM APPLICATOR	
0 PLC ± .005		1 PLC ± .005		2 PLC ± .005		3 PLC ± .005	
4 PLC ± .005		5 PLC ± .005		6 PLC ± .005		7 PLC ± .005	
8 PLC ± .005		9 PLC ± .005		10 PLC ± .005		11 PLC ± .005	
12 PLC ± .005		13 PLC ± .005		14 PLC ± .005		15 PLC ± .005	
16 PLC ± .005		17 PLC ± .005		18 PLC ± .005		19 PLC ± .005	
20 PLC ± .005		21 PLC ± .005		22 PLC ± .005		23 PLC ± .005	
24 PLC ± .005		25 PLC ± .005		26 PLC ± .005		27 PLC ± .005	
28 PLC ± .005		29 PLC ± .005		30 PLC ± .005		31 PLC ± .005	
32 PLC ± .005		33 PLC ± .005		34 PLC ± .005		35 PLC ± .005	
36 PLC ± .005		37 PLC ± .005		38 PLC ± .005		39 PLC ± .005	