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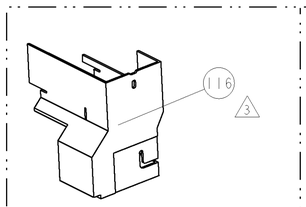
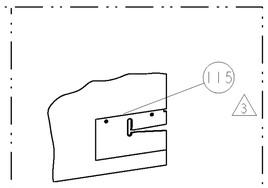
PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1855277-1	B	122500-1	LEADMAKER	POST FEED	CUTS CARRIER
1855277-2	B	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER
1855277-3	B	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER
1855277-6	B	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER
7-1855277-7	A	-	-	-	SPARE PARTS



AMP-O-LECTRIC TERM GUARD



G TERMINATOR GUARD

TERMINAL NAME: CONTACT, RECEPTACLE, .070 TYPE					
184030	-	AMP TERMINAL - AMP CRIMP SPECS			
184289	-				
-	-		CRIMP HEIGHT	WIRE SIZE	REF SETTING
-	-		1.70±0.05mm[.067±.002]	14AWG	A8
-	-		1.45±0.05mm[.057±.002]	16AWG	C6
-	-		1.24±0.05mm[.049±.002]	18AWG	E2
-	-		1.17±0.05mm[.046±.002]	20AWG	E6
-	-	CRIMP	SIZE	TYPE	RANGE
-	-				
-	-	WIRE	2.29mm [.090]	F	20-14 AWG
-	-	INSUL	3.56mm [.140]	SCROLL	1.19-2.69mm
WIRE STRIP LENGTH 3.99-4.50mm	TERM APPL SPEC 114-8004 △4	FEED 9.80mm	APPLICATOR INSTRUCTIONS 408-8040		SET UP GAGE 458637-1

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	PRODUCT RELEASE	14MAY2007	CMR	GB
	A1	ECR-08-008923	10APR2008	MY	TE
	B	ECR-09-004546	26FEB2009	MY	GB

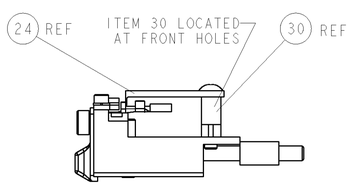
△1 RECOMMENDED SPARE PARTS

△2 GREASE LIGHTLY

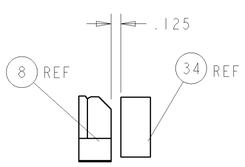
△3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE

△4 APPLICATOR APPLIES A SCROLL INSULATION CRIMP IN PLACE OF A SEAL. DISREGARD SECTION COVERING SEALS.

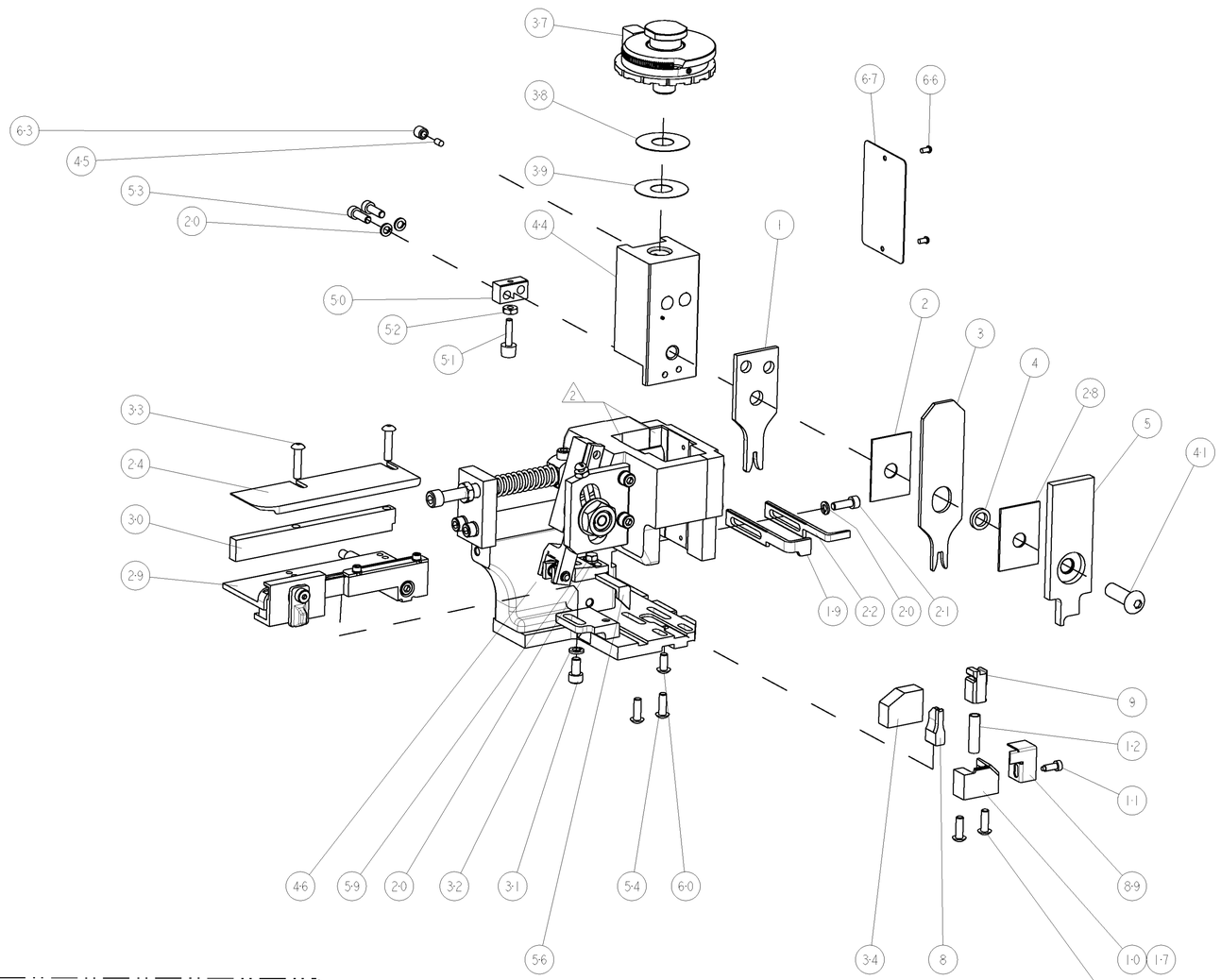
*** WARNING**
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN. REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



FEED TRACK POSITION

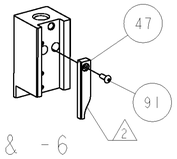


TERMINAL SUPPORT LOCATION



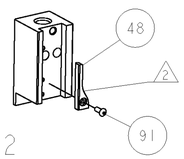
△3	-	-	-	REF	-	..	455749-1	GUARD WINDOW	116
△3	-	-	REF	-	-	..	679532-1	INSERT, GUARD	115
-	1	1	1	1	-		1-21002-7	SCR, BTN SKT HD CAP 6-32 X .375	91
-	1	1	1	1	-		318563-1	GUARD, FRONT CHIP	89
-	1	1	1	1	-		4088040	SF APPL INST 408-8040	72
-	1	1	1	1	-		217238-1	GENERAL INSTRUCTION PKG	71
-	1	1	1	1	-		461264-5	PLATE, IDENTIFICATION	67
-	2	2	2	2	-		21017-2	SCREW, DRIVE	66
-	1	1	1	1	-		21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	63
-	1	1	1	1	-		22733-8	SCR, BHSC, SELF-LOCKING, 8-32 X .375	60
-	1	1	1	1	-		2-22603-0	SCR, HEX HD CAP 8-32 X .312	59
-	1	1	1	1	-		458537-2	PAWL, FEED	56
-	4	4	4	4	-		2-21002-2	SCR, BTN SKT HD CAP 8-32 X .500	54
-	2	2	2	2	-		2-21000-7	SCR, SKT HD CAP 8-32 X .500	53
-	1	1	1	1	-		21018-5	NUT, HEX, REG 6-32	52
-	1	1	1	1	-		811242-2	BUMPER, HOLD DOWN	51
-	1	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	-	-	1	-		690501-4	CAM, POST-FEED 1 5/8	47
-	1	1	1	1	-		459456-1	APPL. BASIC SUB ASSY (SIDE WISE MQCA)	46
-	1	1	1	1	-		690191-1	PLUG,NYLON	45
-	1	1	1	1	-		455673-1	RAM, SIDE FEED	44
-	1	1	1	1	-		7-21002-9	SCR, BTN SKT HD CAP 5/16-24 X 1.00	41
-	1	1	1	1	-		690125-1	SHIM SUB-ASSY	39
-	1	1	1	1	-		1-469367-0	SHIM	38
-	1	1	1	1	-		879103-3	FINE ADJUST HEAD ASSEMBLY	37
-	1	1	1	1	-		690786-1	TERMINAL SUPPORT	34
-	2	2	2	2	-		2-21002-4	SCR, BTN SKT HD CAP 8-32 X .750	33
-	1	1	1	1	-		21024-5	WASHER, SPRG LOCK, REG NO 10	32
-	1	1	1	1	-		3-21000-4	SCR, SKT HD CAP 10-32 X .375	31
-	1	1	1	1	-		1320908-8	SPACER, STRIP GUIDE	30
-	1	1	1	1	-		1633091-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	-		1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	-		1320928-1	PLATE, STRIP GUIDE	24
-	1	-	-	1	-		690472-2	STRIPPER	22
-	1	1	1	1	-		2-21000-7	SCR, SKT HD CAP 8-32 X .500	21
-	4	4	4	4	-		21024-4	WASHER, SPRG LOCK, REG NO 8	20
-	-	1	1	-	-		691353-1	STRIPPER	19
△1	-	1	-	-	-	-	679625-1	SHEAR HOLDER, FRONT (NO CUT)	17
-	1	1	1	1	-		3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	-		690461-1	STOP, SHEAR	11
△1	-	-	1	1	1	-	690459-1	SHEAR HOLDER, FRONT	10
△1	-	1	1	1	1	-	1-454276-9	FLOATING SHEAR, FRONT	9
△1	1	1	1	1	1	-	1-189717-8	ANVIL, COMBINATION	8
-	1	1	1	1	1	-	2-455889-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	-	1-238011-0	BLOCK, CRIMPER SPACER	4
△1	1	1	1	1	1	-	1424367-2	CRIMPER, INSULATION, SCROLL	3
-	1	1	1	1	1	-	455888-7	SPACER, CRIMPER	2
△1	1	1	1	1	1	-	3-456406-3	CRIMPER, WIRE PREMIUM	1
-77	-6	-3	-2	-1	U/M		PART NO	DESCRIPTION	ITEM NO

POST-FEED 1 5/8 STROKE



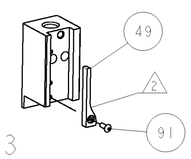
-1 & -6

PRE-FEED 1 1/8 STROKE



-2

PRE-FEED 1 5/8 STROKE



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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 -

DWN M.CLIFFORD 01MAY2007
CHK -
APVD M.CLIFFORD 01MAY2007
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

tyco Electronics
Tyco Electronics
Harrisburg, PA 17105-3608

NAME FINE ADJUST SIDE FEED HDM APPLICATOR -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1855277	-

CUSTOMER DRAWING | SCALE 3:5 | SHEET 1 OF 1 | REV B

CUSTOMER VIEWABLE ASSEMBLY