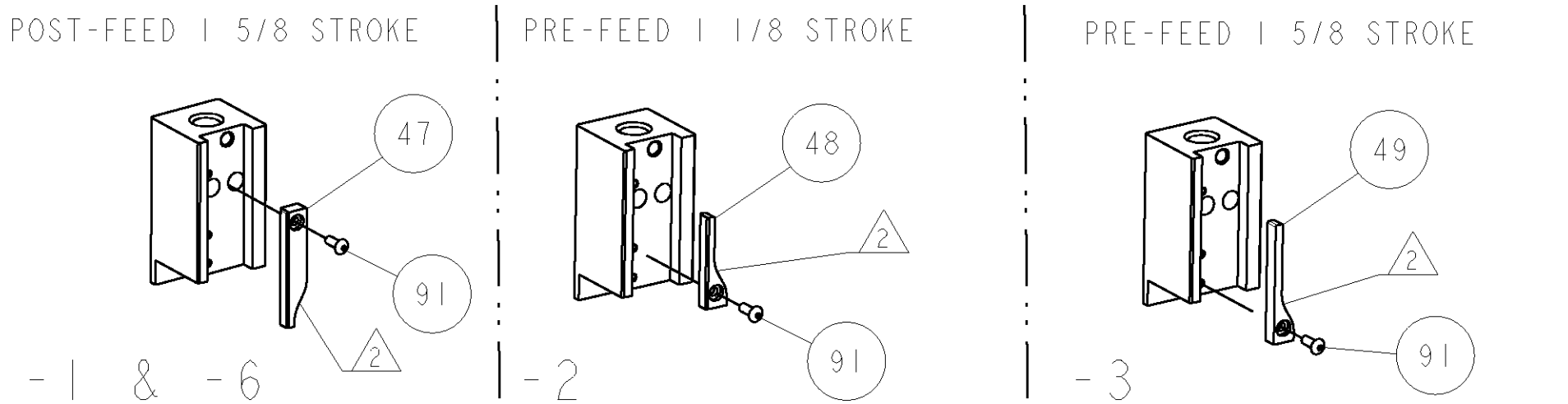
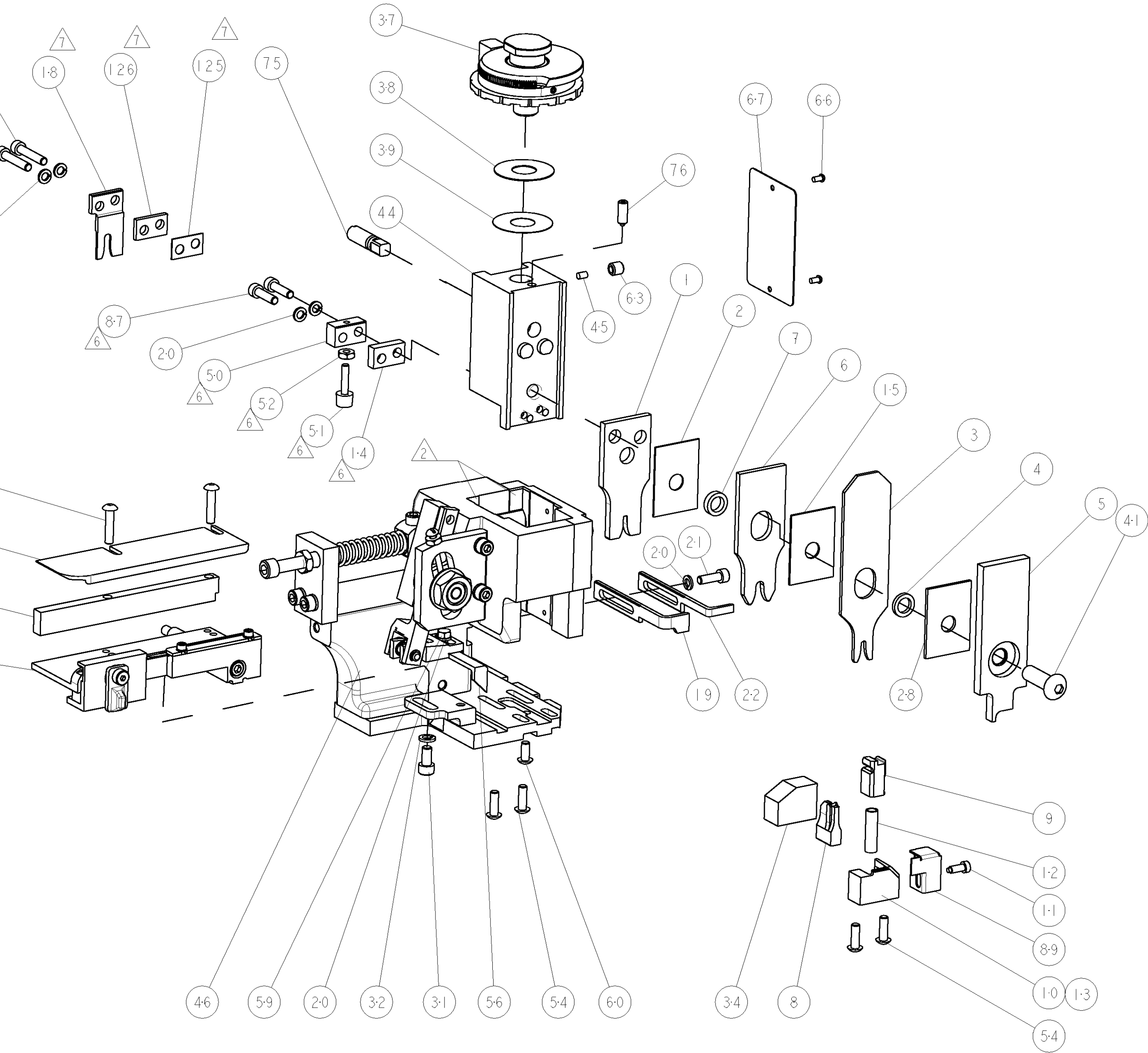
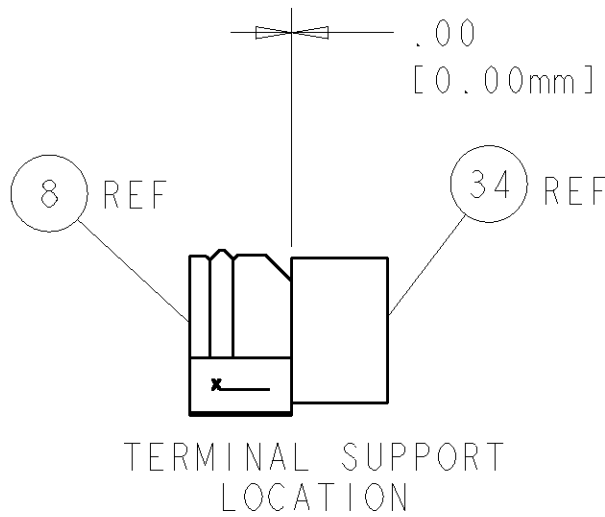
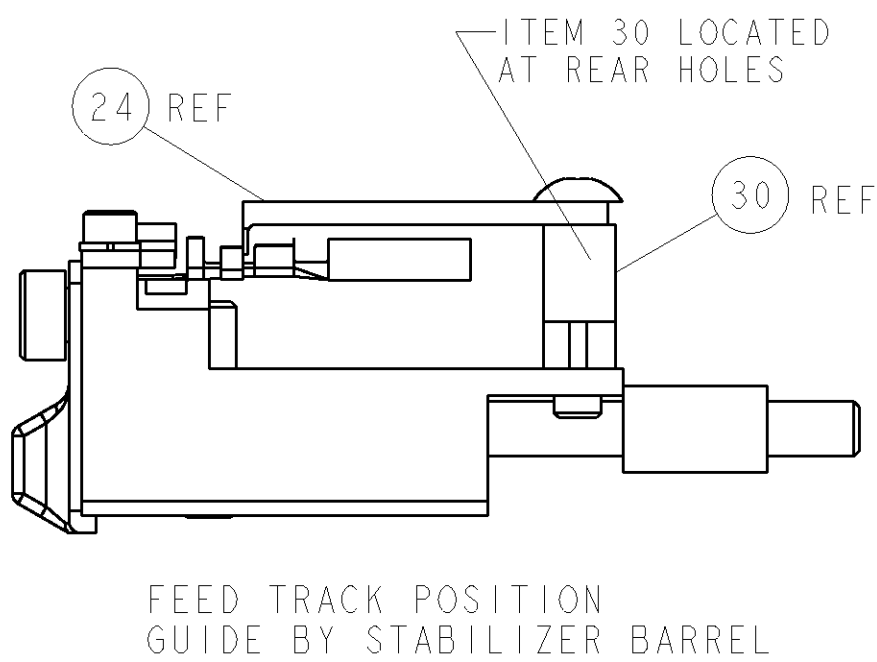


|                              |  |     |            |                                                       |           |                    |  |
|------------------------------|--|-----|------------|-------------------------------------------------------|-----------|--------------------|--|
| 8                            |  |     |            | 7                                                     |           |                    |  |
| THIS DRAWING IS UNPUBLISHED. |  |     |            | RELEASED FOR PUBLICATION                              |           |                    |  |
| © COPYRIGHT 20               |  |     |            | BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. |           |                    |  |
| PART NUMBER                  |  | REV | FIRST USED | POWER UNIT                                            | FEED TYPE | DESCRIPTION        |  |
| 1855490-1                    |  | A   | 122500-1   | LEADMAKER                                             | POST FEED | CUTS CARRIER       |  |
| 1855490-2                    |  | A   | 565435-5   | BENCH MODEL K                                         | PRE FEED  | CUTS CARRIER       |  |
| 1855490-3                    |  | A   | 354500-1   | BENCH MODEL G                                         | PRE FEED  | CUTS CARRIER       |  |
| 1855490-6                    |  | A   | 122500-1   | LEADMAKER                                             | POST FEED | CONTINUOUS CARRIER |  |
| 7-1855490-7                  |  | A   | -          | -                                                     | -         | SPARE PARTS        |  |

- △ RECOMMENDED SPARE PARTS
- △ GREASE LIGHTLY
- △ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
- △ CUT TO LENGTH AT ASSEMBLY
- △ STABILIZER CRIMPER SHAFT MUST BE TURNED SO THAT LETTER SHOWING (RIGHT SIDE OF RAM) MATCHES WIRE BEING USED.
- △ ITEMS 14, 50, 51, 52 & 87 REQUIRED FOR 927841.
- △ ITEMS 18, 88, 125 & 126 REQUIRED FOR 927843.

**\* 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.



|                                        |     |                              |               |                                     |      |                         |             |
|----------------------------------------|-----|------------------------------|---------------|-------------------------------------|------|-------------------------|-------------|
| TERMINAL NAME: .140 DIA PIN AND SOCKET |     |                              |               |                                     |      |                         |             |
| TE PN                                  |     | TE TERMINAL - TE CRIMP SPECS |               |                                     |      |                         |             |
| 927841                                 | △ 6 |                              |               |                                     |      |                         |             |
| 927843                                 | △ 7 | -                            | △ 5           | CRIMP HEIGHT                        |      | WIRE SIZE               | REF SETTING |
| -                                      | -   | -                            | B             | 1.42mm±.05/- .05[.056±.002/- .002]  |      | 16AWG or 1mm2           | B5          |
| -                                      | -   | -                            | C             | 1.33mm±.05/- .05[.052±.002/- .002]  |      | 18AWG or 0.75mm2        | C3          |
| -                                      | -   | -                            | D             | 1.24mm±.05/- .05[.049±.002/- .002]  |      | 20AWG or 0.5mm2         | C9          |
| -                                      | -   | -                            | -             |                                     |      | -                       | -           |
| -                                      | -   | -                            | CRIMP         | SIZE                                | TYPE | RANGE                   |             |
| -                                      | -   | -                            |               |                                     |      |                         |             |
| -                                      | -   | -                            | WIRE          | 2.03mm [.080]                       | F    | 0.50-1.00 mm2           |             |
| -                                      | -   | -                            | INSUL         | 2.79mm [.110]                       | OVL  | Ø1.200 - 2.400          |             |
| WIRE STRIP LENGTH<br>5.94-6.35         |     | TERM APPL SPEC<br>114-1007   | FEED<br>15.00 | APPLICATOR INSTRUCTIONS<br>408-8040 |      | SET UP GAGE<br>458637-1 |             |

|   |   |   |     |     |   |            |                                       |     |
|---|---|---|-----|-----|---|------------|---------------------------------------|-----|
|   | - | - | -   | -   | - | 4-240641-0 | SPACER                                | 126 |
|   | - | - | -   | -   | - | 2-240641-1 | SPACER                                | 125 |
| 3 | - | - | -   | REF | - | 455749-1   | GUARD WINDOW                          | 116 |
| 3 | - | - | REF | -   | - | 679532-1   | INSERT, GUARD                         | 115 |
|   | - | - | -   | -   | - | 1-21002-7  | SCR, BTN SKT HD CAP 6-32 X .375       | 91  |
|   | - | - | -   | -   | - | 691667-1   | GUARD, FRONT CHIP                     | 89  |
|   | - | 2 | 2   | 2   | 2 | 3-21000-0  | SCR, SKT HD CAP 8-32 X .875           | 88  |
|   | - | 2 | 2   | 2   | 2 | 2-21000-8  | SCR, SKT HD CAP 8-32 X .625           | 87  |
|   | - | - | -   | -   | - | 22859-7    | SPRING PLUNGER                        | 76  |
|   | - | - | -   | -   | - | 1-453412-6 | SHAFT, STABILIZER CRIMPER ADJUSTER    | 75  |
|   | - | - | -   | -   | - | 4088040    | SF APPL INST 408-8040                 | 71  |
|   | - | - | -   | -   | - | 217238-1   | GENERAL INSTRUCTION PKG               | 71  |
|   | - | - | -   | -   | - | 461264-5   | PLATE, IDENTIFICATION                 | 67  |
|   | - | 2 | 2   | 2   | 2 | 21017-2    | SCREW, DRIVE                          | 66  |
|   | - | - | -   | -   | - | 21009-2    | SCR, SET, SELF LOCKING 1/4-20 X .250  | 63  |
|   | - | - | -   | -   | - | 22733-8    | SCR, BHSC, SELF-LOCKING, 8-32 X .375  | 60  |
|   | - | - | -   | -   | - | 2-22603-0  | SCR, HEX HD CAP 8-32 X .312           | 59  |
|   | - | - | -   | -   | - | 458537-2   | PAWL, FEED                            | 56  |
|   | - | 4 | 4   | 4   | 4 | 2-21002-2  | SCR, BTN SKT HD CAP 8-32 X .500       | 54  |
|   | - | - | -   | -   | - | 21018-5    | NUT, HEX, REG 6-32                    | 52  |
|   | - | - | -   | -   | - | 811242-2   | BUMPER, HOLD DOWN                     | 51  |
|   | - | - | -   | -   | - | 690753-1   | SPACER, TONKER                        | 50  |
|   | - | - | -   | -   | - | 690602-6   | CAM, PRE FEED, 1 5/8                  | 49  |
|   | - | - | -   | -   | - | 690602-5   | CAM, PRE FEED, 1 1/8                  | 48  |
|   | - | - | -   | -   | - | 690501-4   | CAM, POST-FEED 1 5/8                  | 47  |
|   | - | - | -   | -   | - | 459456-1   | APPL. BASIC SUB ASSY (SIDE WISE MQCA) | 46  |
|   | - | - | -   | -   | - | 690191-1   | PLUG,NYLON                            | 45  |
|   | - | - | -   | -   | - | 817855-4   | RAM, SIDE FEED                        | 44  |
|   | - | - | -   | -   | - | 7-21002-9  | SCR, BTN SKT HD CAP 5/16-24 X 1.00    | 41  |
|   | - | - | -   | -   | - | 690125-1   | SHIM SUB-ASSY                         | 39  |
|   | - | - | -   | -   | - | 469367-9   | SHIM                                  | 38  |
|   | - | - | -   | -   | - | 879103-3   | FINE ADJUST HEAD ASSEMBLY             | 37  |
|   | - | - | -   | -   | - | 3-690786-3 | TERMINAL SUPPORT                      | 34  |
|   | - | 2 | 2   | 2   | 2 | 2-21002-4  | SCR, BTN SKT HD CAP 8-32 X .750       | 33  |
|   | - | - | -   | -   | - | 21024-5    | WASHER, SPRG LOCK, REG NO 10          | 32  |
|   | - | - | -   | -   | - | 3-21000-4  | SCR, SKT HD CAP 10-32 X .375          | 31  |
|   | - | - | -   | -   | - | 1320908-1  | SPACER, STRIP GUIDE                   | 30  |
|   | - | - | -   | -   | - | 1633091-1  | ASSEMBLY, STRIP GUIDE                 | 29  |
|   | - | - | -   | -   | - | 1-455888-4 | SPACER, CRIMPER                       | 28  |
|   | - | - | -   | -   | - | 1320928-1  | PLATE, STRIP GUIDE                    | 24  |
|   | - | - | -   | -   | - | 690472-2   | STRIPPER                              | 22  |
|   | - | - | -   | -   | - | 2-21000-7  | SCR, SKT HD CAP 8-32 X .500           | 21  |
|   | - | 6 | 6   | 6   | 6 | 21024-4    | WASHER, SPRG LOCK, REG NO 8           | 20  |
|   | - | - | -   | -   | - | 691353-1   | STRIPPER                              | 19  |
|   | - | - | -   | -   | - | 1338766-1  | TOOL, SIZING                          | 18  |
|   | - | - | -   | -   | - | 455888-8   | SPACER, CRIMPER                       | 15  |
|   | - | - | -   | -   | - | 2-240641-9 | SPACER                                | 14  |
| 1 | - | - | -   | -   | - | 679625-1   | SHEAR HOLDER, FRONT (NO CUT)          | 13  |
|   | - | - | -   | -   | - | 3-22280-3  | SPRING, COMPRESSION                   | 12  |
| 1 | - | - | -   | -   | - | 690461-1   | STOP, SHEAR                           | 11  |
| 1 | - | - | -   | -   | - | 690459-1   | SHEAR HOLDER, FRONT                   | 10  |
| 1 | - | - | -   | -   | - | 454276-1   | FLOATING SHEAR, FRONT                 | 9   |
|   | - | - | -   | -   | - | 1338767-1  | ANVIL                                 | 8   |
|   | - | - | -   | -   | - | 238011-2   | BLOCK, CRIMPER SPACER                 | 7   |
|   | - | - | -   | -   | - | 817852-9   | CRIMPER, STABILIZER                   | 6   |
|   | - | - | -   | -   | - | 1-455889-4 | DEPRESSOR, SHEAR                      | 5   |
|   | - | - | -   | -   | - | 238011-7   | BLOCK, CRIMPER SPACER                 | 4   |
| 1 | - | - | -   | -   | - | 854830-1   | CRIMPER, INSULATION SPECIAL           | 3   |
|   | - | - | -   | -   | - | 455888-6   | SPACER, CRIMPER                       | 2   |
| 1 | - | - | -   | -   | - | 1-817854-9 | CRIMPER, WIRE PREMIUM                 | 1   |

# Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[1855490-3](#)