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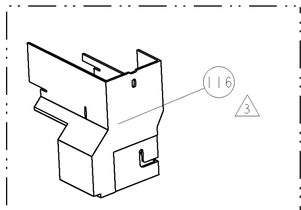
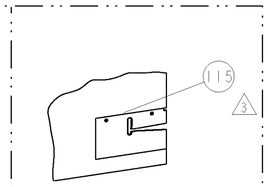
| PART NUMBER | REV | FIRST USED | POWER UNIT | FEED TYPE | DESCRIPTION |
|---|---|---|---|---|---|
| 1855271-1 | B | 122500-1 | LEADMAKER | POST FEED | CUTS CARRIER |
| 1855271-2 | B | 565435-5 | BENCH MODEL K | PRE FEED | CUTS CARRIER |
| 1855271-3 | B | 354500-1 | BENCH MODEL G | PRE FEED | CUTS CARRIER |
| 1855271-6 | B | 122500-1 | LEADMAKER | POST FEED | CONTINUOUS CARRIER |
| 7-1855271-7 | A | - | - | - | SPARE PARTS |

1. RECOMMENDED SPARE PARTS
2. GREASE LIGHTLY
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE



AMP-O-LECTRIC TERM GUARD



G TERMINATOR GUARD

TERMINAL NAME: MULTIWAY, SNAP TOGETHER, CONTACT

| TE PN | ITT CANNON PN | ITT CANNON TERMINAL - AMP CRIMP SPECS | | |
|---|---|---|---|---|
| 1949366-1 | 192900-0001 | | | |
| 1949366-2 | 192900-0003 | CRIMP HEIGHT | WIRE SIZE | REF SETTING |
| 1949559 | 192900-0408 | .056±.002[1.42±0.05mm] | 16AWG | C2 |
| - | - | .049±.002[1.24±0.05mm] | 18AWG | D5 |
| - | - | .044±.002[1.12±0.05mm] | 20AWG | E4 |
| - | - | - | - | - |

| CRIMP | SIZE | TYPE | RANGE |
|---|---|---|---|
| WIRE | .082 [2.08mm] | F | 16-20 AWG |
| INSUL | .110 [2.79mm] | F | Ø.078-.118 |

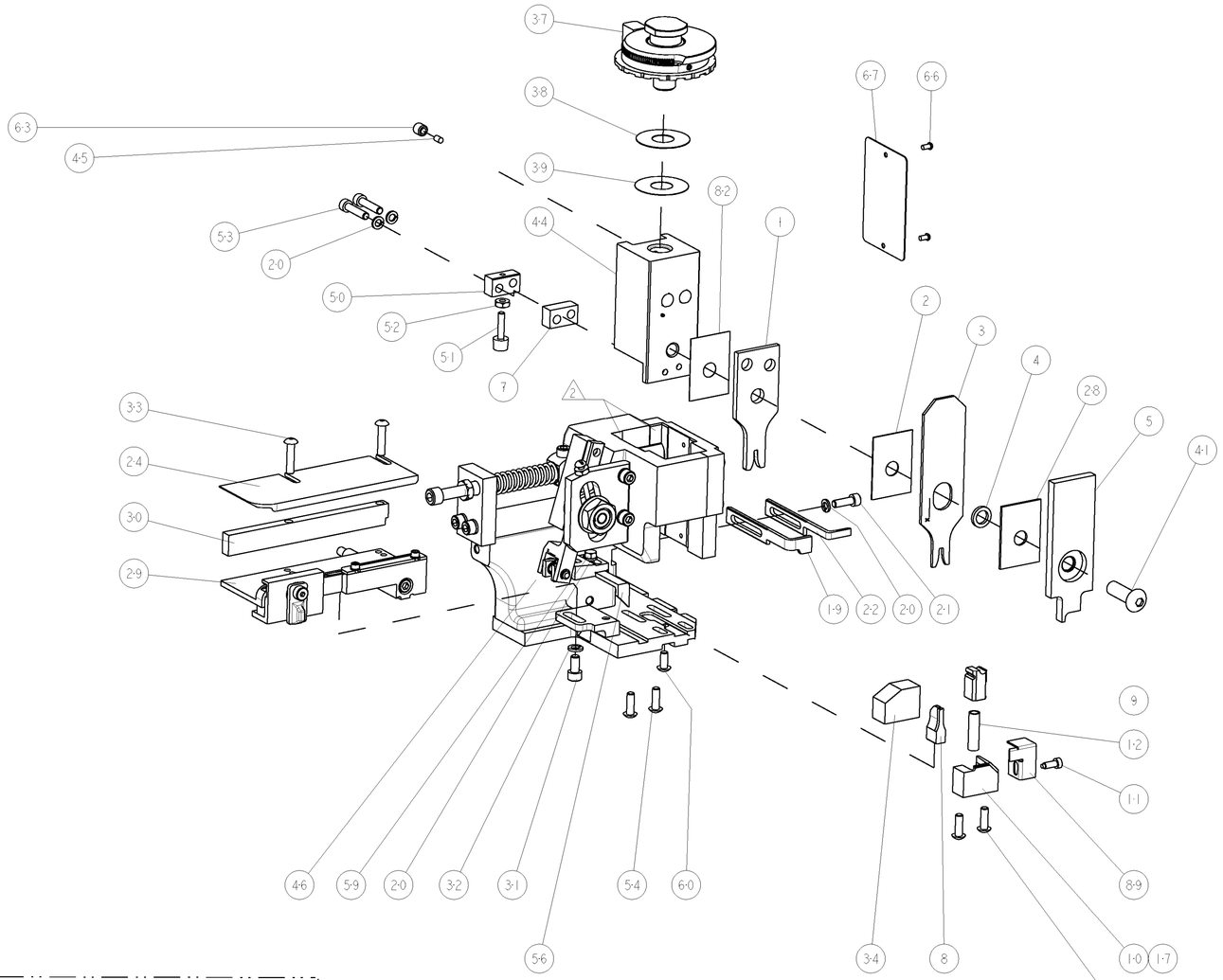
| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPLICATOR INSTRUCTIONS | SET UP GAGE |
|---|---|---|---|---|
| .146-.164 | NONE | .350 | 408-8040 | 458637-1 |

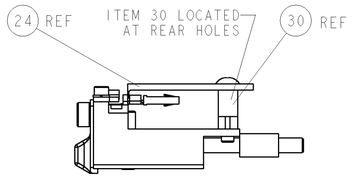
| LOC | DIST |
|---|---|
| A | 66 |

REVISIONS

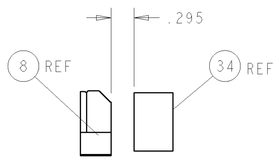
| P | LTR | DESCRIPTION | DATE | DWN | APVD |
|---|---|---|---|---|---|
| | A | RELEASED | 15MAY2007 | LG | TE |
| | A1 | ECR-09-001931 | 27JAN2009 | MY | GB |
| | B | ECR-09-005847 | 12MAR2009 | MY | TE |

* 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.



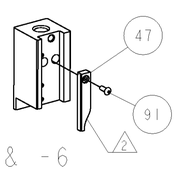
FEED TRACK POSITION



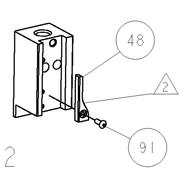
TERMINAL SUPPORT LOCATION

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| 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 | - | 455888-1 | SPACER, CRIMPER | 82 |
| | - | 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 | - | 2-21000-9 | SCR, SKT HD CAP 8-32 X .750 | 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 | - | 879103-2 | FINE ADJUST HEAD ASSEMBLY | 37 |
| | - | 1 | 1 | 1 | 1 | - | 690786-6 | 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 | - | 1320908-1 | 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 | - | 1320928-3 | 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 | - | - | - | - | 679625-1 | SHEAR HOLDER, FRONT (NO CUT) | 17 |
| 1 | - | 1 | 1 | 1 | 1 | - | 3-22280-3 | SPRING, COMPRESSION | 12 |
| | - | 1 | 1 | 1 | 1 | - | 690461-1 | STOP, SHEAR | 11 |
| | - | - | 1 | 1 | 1 | - | 690459-1 | SHEAR HOLDER, FRONT | 10 |
| 1 | - | 1 | 1 | 1 | 1 | - | 462006-1 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 1 | 1 | 1 | 1 | - | 1-1633535-9 | ANVIL, COMBINATION | 8 |
| 1 | - | 1 | 1 | 1 | 1 | - | 2-240641-7 | SPACER | 7 |
| | - | 1 | 1 | 1 | 1 | - | 1-455889-4 | DEPRESSOR, SHEAR | 5 |
| | - | 1 | 1 | 1 | 1 | - | 238011-6 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 1 | 1 | 1 | - | 4-683453-3 | CRIMPER, INSULATION PREMIUM | 3 |
| | - | 1 | 1 | 1 | 1 | - | 455888-5 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 1 | 1 | 1 | - | 1-1633305-3 | CRIMPER, WIRE PREMIUM | 1 |
| | -77 | -6 | -3 | -2 | -1 | U/M | PART NO | DESCRIPTION | ITEM NO |

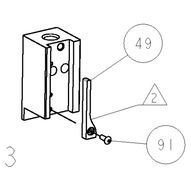
POST-FEED 1 5/8 STROKE




PRE-FEED 1 1/8 STROKE




PRE-FEED 1 5/8 STROKE

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| | | |
|---|---|---|
| DWN L.GROSS | 28APR2007 | tyco Electronics — Tyco Electronics, Harrisburg, PA 17105-3608 |
| CHK B.HIGMAN | 28APR2007 | |
| APVD T.ELBIN | 28APR2007 | NAME: FINE ADJUST SIDE FEED HDM APPLICATOR |
| PRODUCT SPEC - | | |
| APPLICATION SPEC - | | SIZE A1 · CAGE CODE 00779 · DRAWING NO C-1855271 · RESTRICTED TO - |
| WEIGHT - | | |
| CUSTOMER DRAWING | | SCALE 3:5 · SHEET 1 OF 1 · REV B |

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 - -

CUSTOMER VIEWABLE ASSEMBLY