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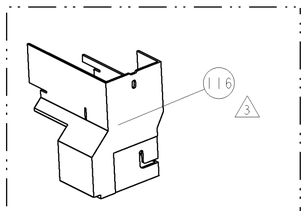
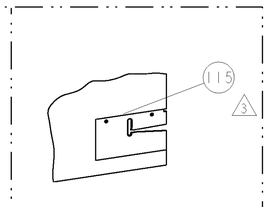
PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1852806-1	A	122500-1	LEADMAKER	POST FEED	CUTS CARRIER
1852806-2	A	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER
1852806-3	A	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER
1852806-6	A	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER
7-1852806-7	A	-	-	-	SPARE PARTS



AMP-O-LECTRIC TERM GUARD



G TERMINATOR GUARD

TERMINAL NAME: TERM F M/P 280 SEALED TANGLESS

TE PN	MANUF PN	DELPHI/PACKARD TERMINAL DELPHI/PACKARD CRIMP SPECS		
1949863	12110845			
-	-	PAD LTR	CRIMP HEIGHT	WIRE SIZE
-	-	A	1.65mm+.05/-.05[.065+.002/-.002]	3mm2
-	-	B	1.55mm+.05/-.05[.061+.002/-.002]	2.5mm2
-	-	C	1.50mm+.05/-.05[.059+.002/-.002]	2mm2
-	-	D		-

SEAL PN	MANUF PN	CRIMP	SIZE	TYPE	RANGE
1949806	15324980	WIRE	3.18mm [.125]	F	2.00-3.00mm²
-	-	INSUL	4.95mm [.195]	O	Ø2.500 - 3.650 (5)

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPLICATOR INSTRUCTIONS	SET UP GAGE
5.60	NONE	14.57	408-8040	458637-1

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	1	DEVELOPMENT	26DEC2008	L.Z	N.D
	A	RELEASED	13FEB2009	MEH	A

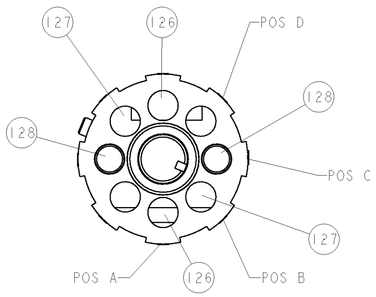
(1) RECOMMENDED SPARE PARTS

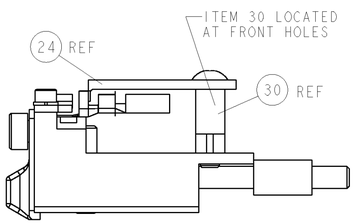
(2) GREASE LIGHTLY

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

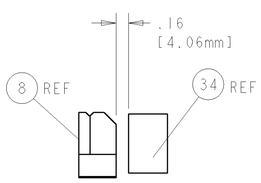
(4) APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY PN 1-23419-5 LOC-TITE TO THREADS.

(5) THE INSULATION RANGE LISTED IS FOR THE TERMINAL. THE INSULATION RANGE FOR THE SEAL IS Ø2.81mm-3.49mm.

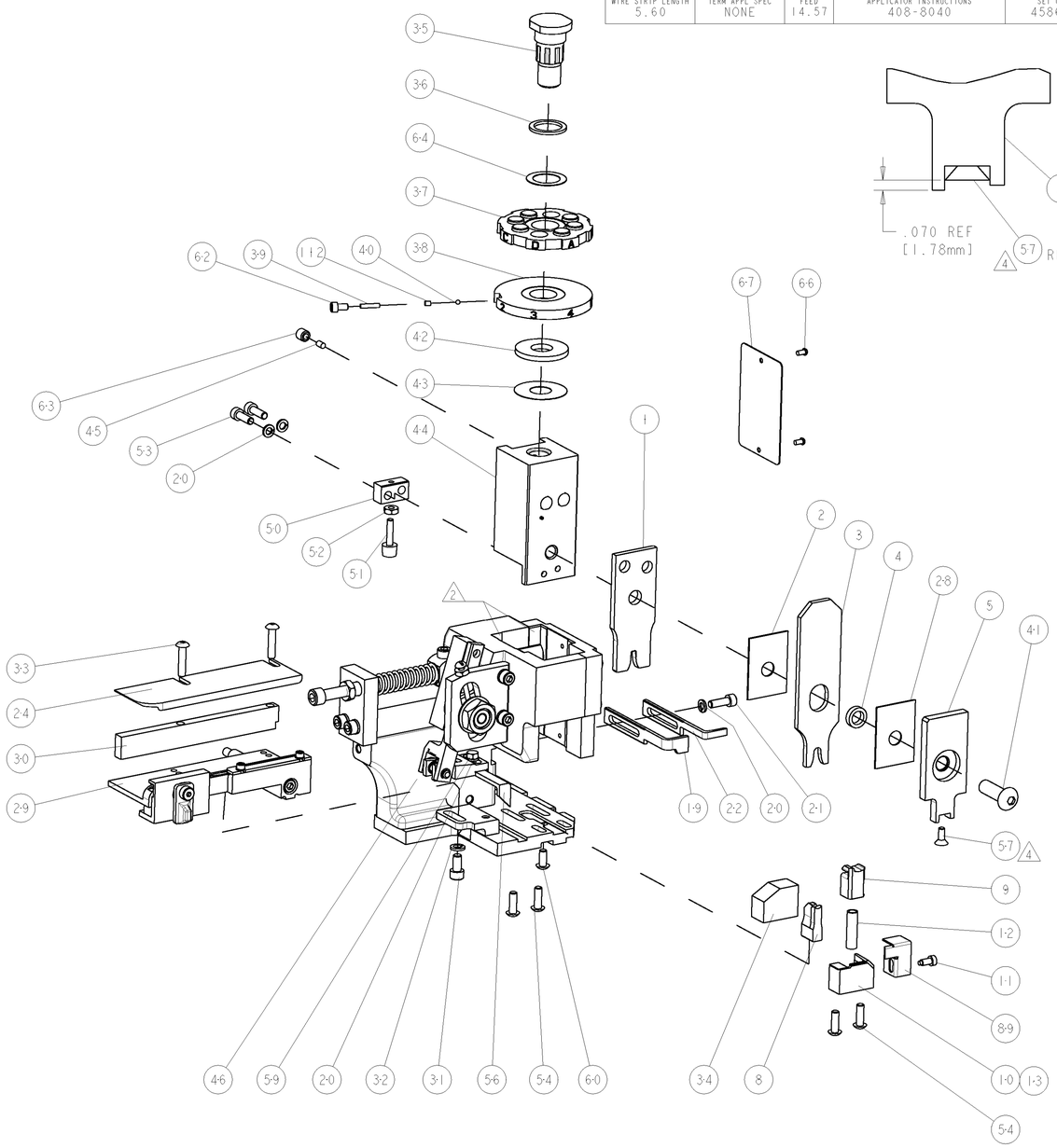




FEED TRACK POSITION GUIDE BY INS. BARREL

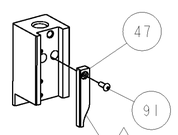


TERMINAL SUPPORT LOCATION



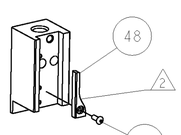
-	2	2	2	2	-	1-354779-6	PIN, WIRE DISC, .3070	128
-	2	2	2	2	-	1-354779-2	PIN, WIRE DISC, .3050	127
-	2	2	2	2	-	354779-6	PIN, WIRE DISC, .3020	126
(3) -	-	-	REF	-	..	455749-1	GUARD WINDOW	116
(3) -	-	REF	-	-	..	679532-1	INSERT, GUARD	115
-	1	1	1	1	-	690603-1	SPRING ASSIST AMP-O-MATOR APPLICATOR	112
-	1	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	-	461264-1	PLATE, IDENTIFICATION	67
-	2	2	2	2	-	21017-2	SCREW, DRIVE	66
-	1	1	1	1	-	986950-1	WASHER, FLAT PRECISION	64
-	1	1	1	1	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	63
-	1	1	1	1	-	23030-1	SCR, SKT HD CAP 6-32 x .25	62
-	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	-	1-21003-9	SCR, FLT SKT HD CAP 6-32 X .375	57
-	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	-	690125-1	SHIM SUB-ASSY	43
-	1	1	1	1	-	690124-1	WASHER, RAM (.115)	42
-	1	1	1	1	-	7-21002-9	SCR, BTN SKT HD CAP 5/16-24 X 1.00	41
-	1	1	1	1	-	23241-6	BALL, STEEL	40
-	1	1	1	1	-	690170-1	SPRING, COMPRESSION	39
-	1	1	1	1	-	1-690142-0	DISC, INSULATION	38
-	1	1	1	1	-	354777-1	WIRE DISC, ASSEMBLY	37
-	1	1	1	1	-	22480-5	SPRING, COMPRESSION	36
-	1	1	1	1	-	690212-1	POST, RAM	35
-	1	1	1	1	-	690786-3	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	-	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	-	1633091-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	-	455888-6	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	-	-	-	-	679625-2	SHEAR HOLDER, FRONT (NO CUT)	13
-	1	1	1	1	-	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	-	690461-2	STOP, SHEAR	11
(1) -	-	1	1	1	-	1-690459-0	SHEAR HOLDER, FRONT	10
(1) -	1	1	1	1	-	318707-4	FLOATING SHEAR, FRONT	9
(1) 1	1	1	1	1	-	9-1633535-5	ANVIL, COMBINATION	8
-	-	-	-	-	..	-	-	7
-	-	-	-	-	..	-	-	6
-	1	1	1	1	-	318701-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	-	238011-2	BLOCK, CRIMPER SPACER	4
(1) 1	1	1	1	1	-	9-904741-2	CRIMPER, INSUL O PREMIUM	3
-	1	1	1	1	-	455888-7	SPACER, CRIMPER	2
(1) 1	1	1	1	1	-	2-568176-2	CRIMPER, WIRE	1
-77	-6	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

POST-FEED 1 5/8 STROKE



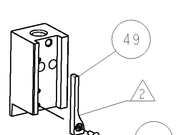
-1 & -6

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	L ZHANG	26DEC2008
CHK	M HERR	31DEC2008
APVD	N DEMING	31DEC2008

PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -
CUSTOMER DRAWING

Tyco Electronics
Tyco Electronics
Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR

SIZE A CAGE CODE DRAWING NO 1852806 RESTRICTED TO -

SCALE 3:5 SHEET 1 OF 1 REV A

OBSOLETE
NOT the LATEST REVISION

CUSTOMER VIEWABLE ASSEMBLY