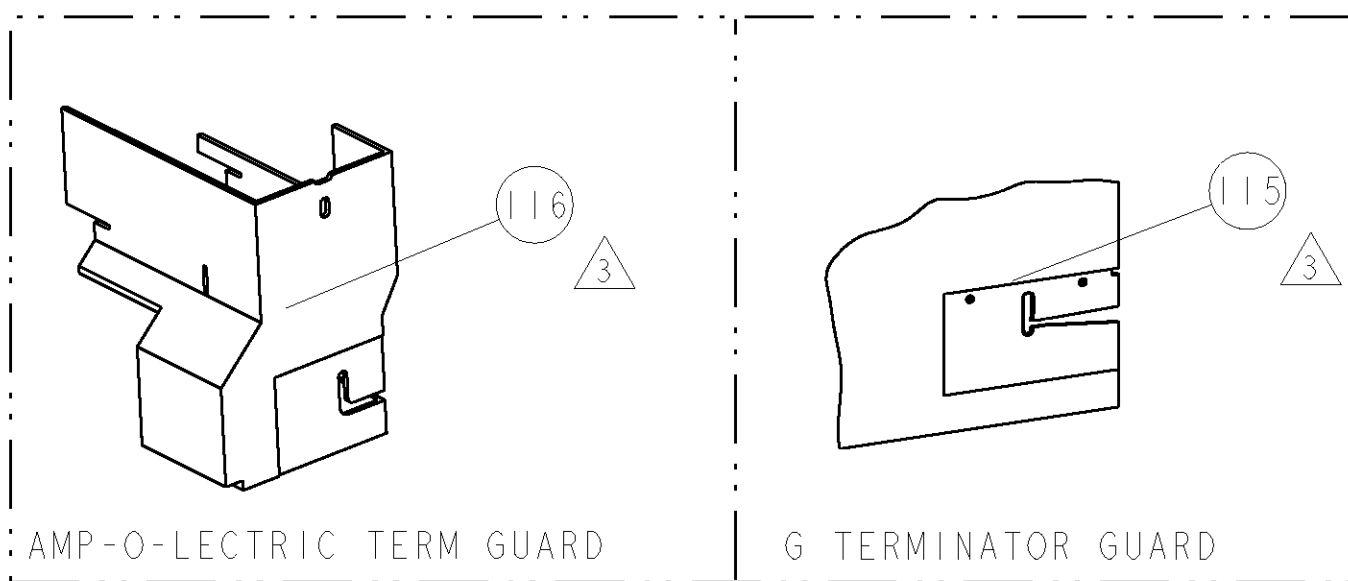


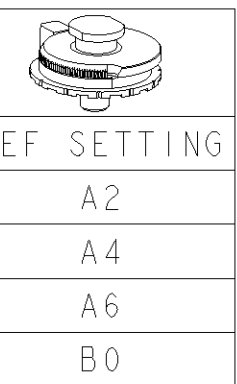
8				7			
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20				20			
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PART NUMBER		REV	FIRST USED	POWER UNIT		FEED TYPE	DESCRIPTION
1855400-1		A	122500-1	LEADMAKER		POST FEED	CUTS CARRIER
1855400-2		A	565435-5	BENCH MODEL K		PRE FEED	CUTS CARRIER
1855400-3		A	354500-1	BENCH MODEL G		PRE FEED	CUTS CARRIER
1855400-6		A	122500-1	LEADMAKER		POST FEED	CONTINUOUS CARRIER
7-1855400-7		A	-	-		-	SPARE PARTS

- △ RECOMMENDED SPARE PARTS
- △ GREASE LIGHTLY
- △ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE

*** 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.

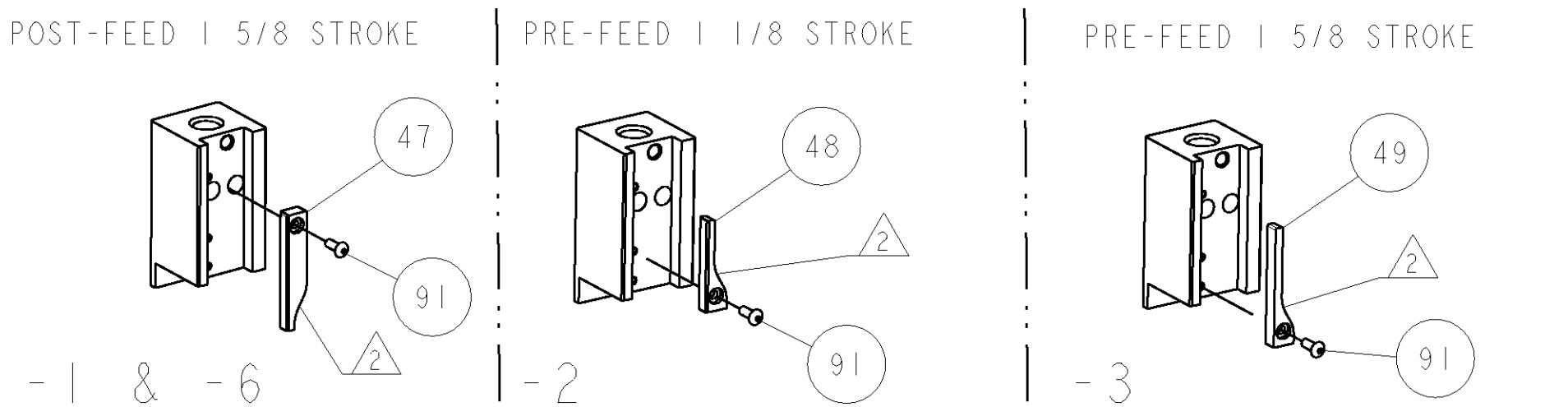
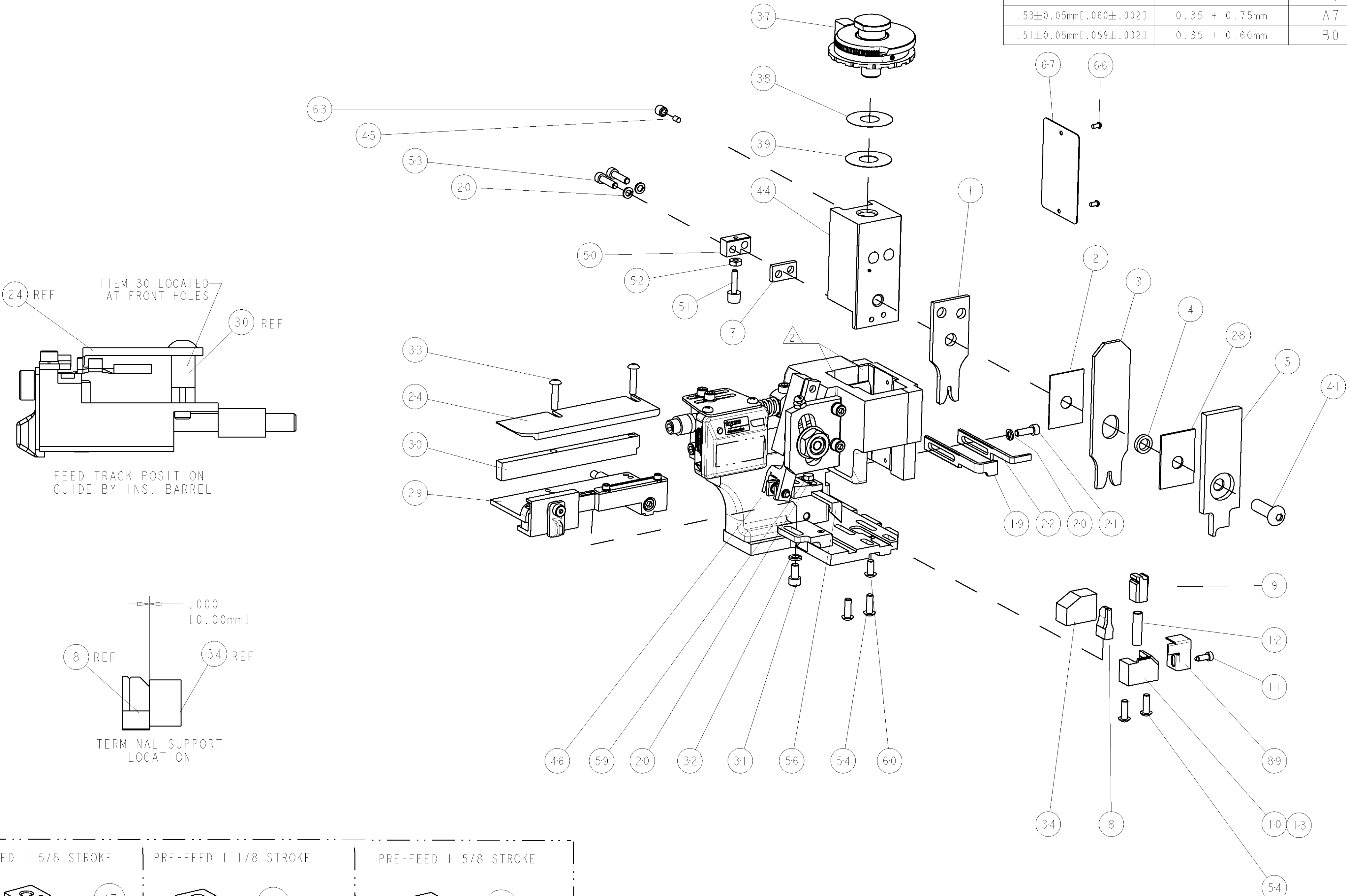


TERMINAL NAME: 1.5 X 0.8 FEMALE SICMA 2 TERMINAL					
TE PN	MANF PN	FCI TERMINAL - FCI CRIMP SPECS			
1949410-1	211CC252120				
-	-	CRIMP HEIGHT		WIRE SIZE	
-	-	1.61mm+.04/-.04[.063+.002/-.002]		14AWG or 2mm2	
-	-	1.58mm+.04/-.04[.062+.002/-.002]		16AWG or 1.5mm2	
-	-	1.56mm+.04/-.04[.061+.002/-.002]		18AWG or 1.4mm2	
-	-	1.51mm+.04/-.04[.059+.002/-.002]		20AWG or 1mm2	
-	-	CRIMP	SIZE	TYPE	RANGE
-	-	WIRE	2.25mm [.089]	F	14-16 AWG
-	-	INSUL	3.15mm [.124]	OV	Ø 2.450 MAX
WIRE STRIP LENGTH 4.200-4.500		TERM APPL SPEC -	FEED 15.200	APPLICATOR INSTRUCTIONS 408-8040	
				SET UP GAGE 458637-1	



REF SETTING

ADDITIONAL CRIMP HEIGHTS		
CRIMP HEIGHT	WIRE SIZE	REF SETTING
1.57±0.05mm[.062±.002]	0.75 + 0.75mm	A4
1.54±0.05mm[.061±.002]	0.60 + 0.60mm	A6
1.57±0.05mm[.062±.002]	0.50 + 1.0mm	A5
1.55±0.05mm[.061±.002]	0.50 + 0.75mm	A6
1.52±0.05mm[.060±.002]	0.50 + 0.50mm	B0
1.55±0.05mm[.061±.002]	0.35 + 1.00mm	A6
1.53±0.05mm[.060±.002]	0.35 + 0.75mm	A7
1.51±0.05mm[.059±.002]	0.35 + 0.60mm	B0



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
-	-	-	-	-	-	..	318563-1	GUARD, FRONT CHIP	89
-	-	-	-	-	-	..	4088040	SF APPL INST 408-8040	72
-	-	-	-	-	-	..	217238-1	GENERAL INSTRUCTION PKG	71
-	-	-	-	-	-	..	461264-5	PLATE, IDENTIFICATION	67
-	-	-	-	-	-	..	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
-	-	-	-	-	-	..	2-21002-2	SCR, BTN SKT HD CAP 8-32 X .500	54
-	-	-	-	-	-	..	2-21000-8	SCR, SKT HD CAP 8-32 X .625	53
-	-	-	-	-	-	..	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
-	-	-	-	-	-	..	455673-1	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
-	-	-	-	-	-	..	469367-2	SHIM	38
-	-	-	-	-	-	..	879103-2	FINE ADJUST HEAD ASSEMBLY	37
-	-	-	-	-	-	..	3-690786-5	TERMINAL SUPPORT	34
-	-	-	-	-	-	..	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
-	-	-	-	-	-	..	1-455888-0	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
-	-	-	-	-	-	..	21024-4	WASHER, SPRG LOCK, REG NO 8	20
-	-	-	-	-	-	..	691353-1	STRIPPER	19
△	-	-	-	-	-	..	679625-1	SHEAR HOLDER, FRONT (NO CUT)	13
△	-	-	-	-	-	..	3-22280-3	SPRING, COMPRESSION	12
△	-	-	-	-	-	..	690461-1	STOP, SHEAR	11
△	-	-	-	-	-	..	690459-1	SHEAR HOLDER, FRONT	10
△	-	-	-	-	-	..	462006-1	FLOATING SHEAR, FRONT	9
△	-	-	-	-	-	..	7-1633535-3	ANVIL, COMBINATION	8
△	-	-	-	-	-	..	240641-5	SPACER	7
△	-	-	-	-	-	..	-	-	6
△	-	-	-	-	-	..	2-455889-0	DEPRESSOR, SHEAR	5
△	-	-	-	-	-	..	238011-9	BLOCK, CRIMPER SPACER	4
△	-	-	-	-	-	..	9-854830-0	CRIMPER, INSULATION SPECIAL	3
△	-	-	-	-	-	..	455888-5	SPACER, CRIMPER	2
△	-	-	-	-	-	..	4-1673600-0	CRIMPER, WIRE	1

-77		-6	-3	-2	-1	U/M	PART NO	DESCRIPTION		ITEM NO
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DIMENSIONS: INCHES							APPROVED N. DEMING 12MAY2008	NAME FINE ADJUST SIDE FEED HDM APPLICATOR		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 9 PLC ±.01 1 PLC ±.01 3 PLC ±.01 4 PLC ±.0001 ANGLES ±.0001							PRODUCT SPEC APPLICATION SPEC	SIZE CAGE CODE DRAWING NO 00779 C=1855400		
MATERIAL FINISH							WEIGHT CUSTOMER DRAWING	RESTRICTED TO SCALE 3:5 SHEET 1 OF 1 REV A		

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