THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

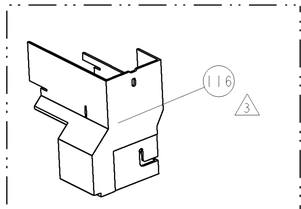
PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1852489-1	B	122500-1	LEADMAKER	POST FEED	CUTS CARRIER
1852489-2	B	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER
1852489-3	B	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER
1852489-6	B	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER
7-1852489-7	B	-	-	-	SPARE PARTS

LOC	DIST
A	66

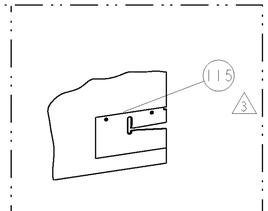
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	RELEASED	01JUN2007	RK	GB
	B	ECR 07-021996	14SEP2007	MEH	GB

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

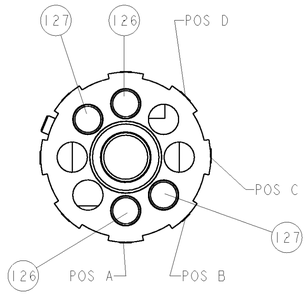


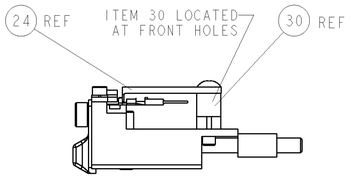
AMP-O-LECTRIC TERM GUARD



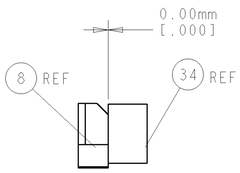
G TERMINATOR GUARD

TERMINAL NAME: TS SERIES, 025, MALE					
TE PN	SUMITOMO PN	SUMITOMO TERMINAL - TE CRIMP SPECS			
1949379	8100-3622				
-	-	PAD LTR	CRIMP HEIGHT		WIRE SIZE
-	-	A	0.91±0.05mm[.036±.002]		0.35mm² or 22AWG
-	-	B	0.84±0.05mm[.033±.002]		0.22mm² or 24AWG
-	-	C	-		-
-	-	D	-		-
-	-	CRIMP	SIZE	TYPE	RANGE
-	-	WIRE	1.40mm [.055]	F	0.22-0.35mm² or 24-22AWG
-	-	INSUL	1.57mm [.062]	F	Ø0.95-1.2mm
WIRE STRIP LENGTH 3.6-4.4mm	TERM APPL SPEC NONE	FEED 7.6mm	APPLICATOR INSTRUCTIONS 408-8040		SET UP GAGE 458637-1

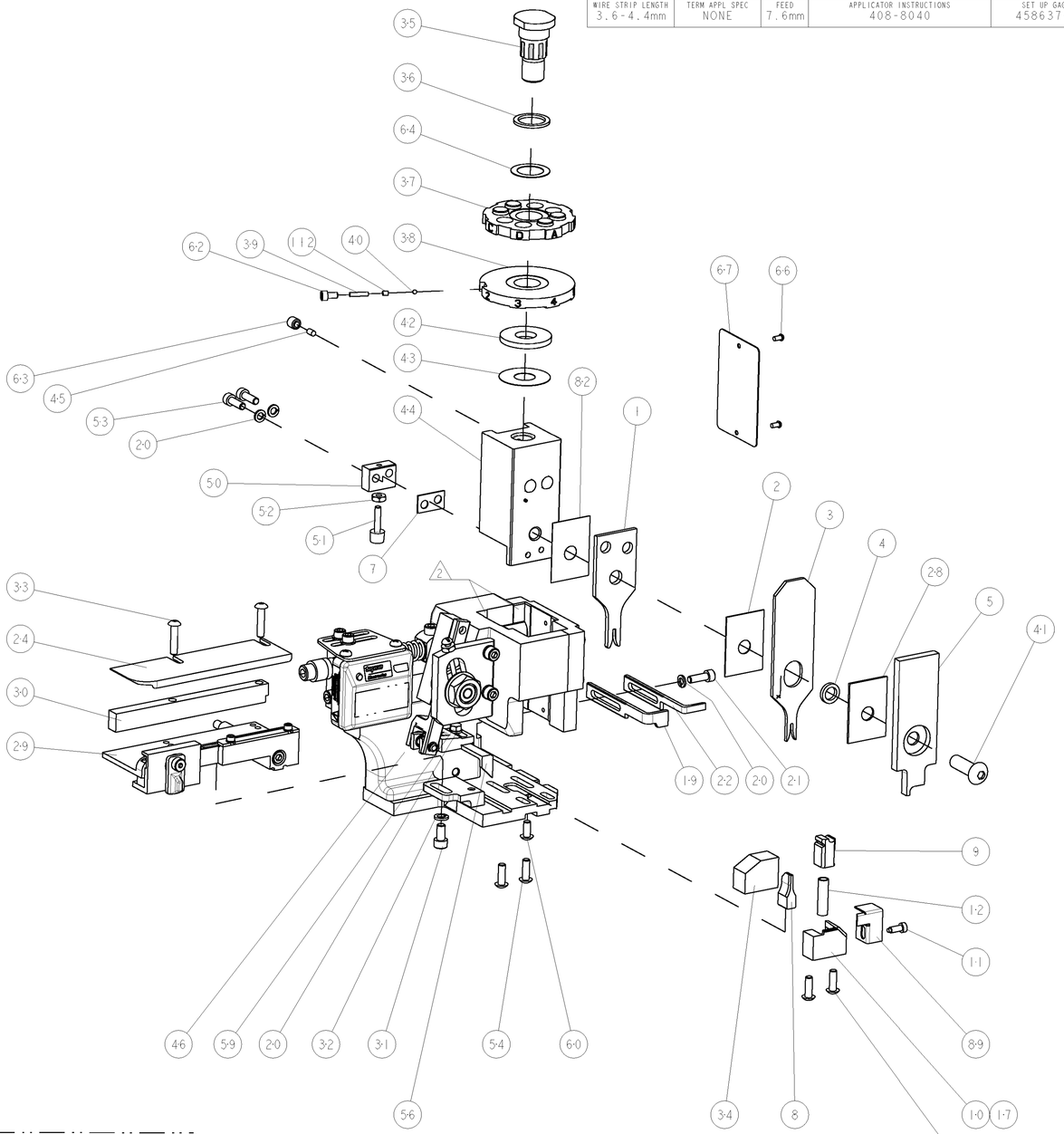




FEED TRACK POSITION

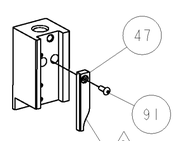


TERMINAL SUPPORT LOCATION



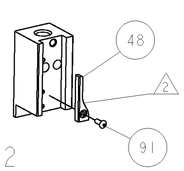
-77	-6	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
-	2	2	2	2	-	3-354779-8	PIN, WIRE DISC, .3180	127
-	2	2	2	2	-	3-354779-2	PIN, WIRE DISC, .3150	126
3 -	-	-	REF	-	..	455749-1	GUARD WINDOW	116
3 -	-	REF	-	-	..	679532-1	INSERT, GUARD	115
-	1	1	1	1	-	690603-1	SPRING ASSIST AMP-O-MATOR APPLICATOR	112
-	1	1	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	-	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	-	461264-1	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	-	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	-	690124-9	WASHER, RAM (.125)	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	-	690142-1	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	-	1-1320908-7	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	-	462006-1	FLOATING SHEAR, FRONT	9
1 1	1	1	1	1	-	1633566-3	ANVIL, COMBINATION	8
-	1	1	1	1	-	1-240641-7	SPACER	7
-	1	1	1	1	-	2-455889-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	-	238011-8	BLOCK, CRIMPER SPACER	4
1 1	1	1	1	1	-	2-683453-3	CRIMPER, INSULATION PREMIUM	3
-	1	1	1	1	-	455888-5	SPACER, CRIMPER	2
1 1	1	1	1	1	-	1-456402-4	CRIMPER, WIRE PREMIUM	1

POST-FEED 1 5/8 STROKE



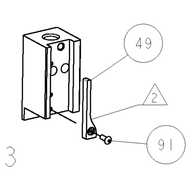
-1 & -6

PRE-FEED 1 1/8 STROKE



-2

PRE-FEED 1 5/8 STROKE



-3

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

DWN R.KNEPPER	16MAY2007	Tyco Electronics — Tyco Electronics, Harrisburg, PA 17105-3608
CHK G.BAILEY	01JUN2007	
APVD T.BENCHOFF	16MAY2007	NAME: SIDE FEED HDM APPLICATOR
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 ±-	PRODUCT SPEC -
		APPLICATION SPEC -
MATERIAL -	FINISH -	WEIGHT -
SIZE A	CAGE CODE 00779	DRAWING NO C-1852489
RESTRICTED TO -		
CUSTOMER DRAWING	SCALE 3:5	SHEET 1 OF 1 REV B

CUSTOMER VIEWABLE ASSEMBLY

AMP 4805 REV 31MAR2000

Pro/ENGINEER DRAWING