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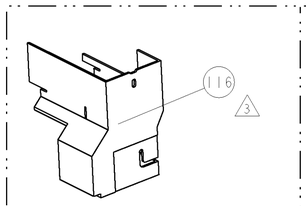
PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1852684-1	A	122500-1	LEADMAKER	POST FEED	CUTS CARRIER
1852684-2	A	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER
1852684-3	A	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER
1852684-6	A	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER
7-1852684-7	A	-	-	-	SPARE PARTS

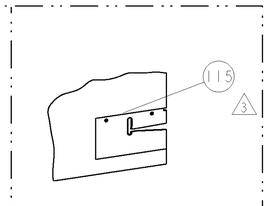
LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A	RELEASED	30APR2008	LG	TE



AMP-O-LECTRIC TERM GUARD



G TERMINATOR GUARD

TERMINAL NAME: CONTACT - TWIN LEAF

SOCKET	PIN
583649	-
-	-
-	-
-	-
-	-
-	-
-	-
-	-
-	-

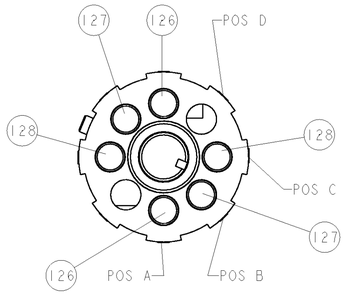
TE TERMINAL - TE CRIMP SPECS

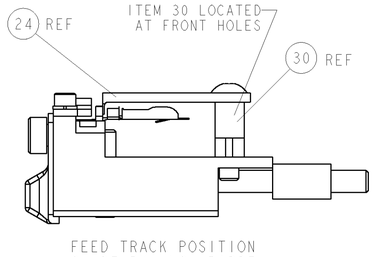
PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	1.17mm+.05/-.05[.046+.002/-.002]	18AWG
B	1.02mm+.05/-.05[.040+.002/-.002]	20AWG
C	.94mm+.05/-.05[.037+.002/-.002]	22AWG
D		-

CRIMP	SIZE	TYPE	RANGE
WIRE	1.57mm [.062]	F	18-22 AWG
INSUL	2.29mm [.090]	O	Ø1.24-2.16

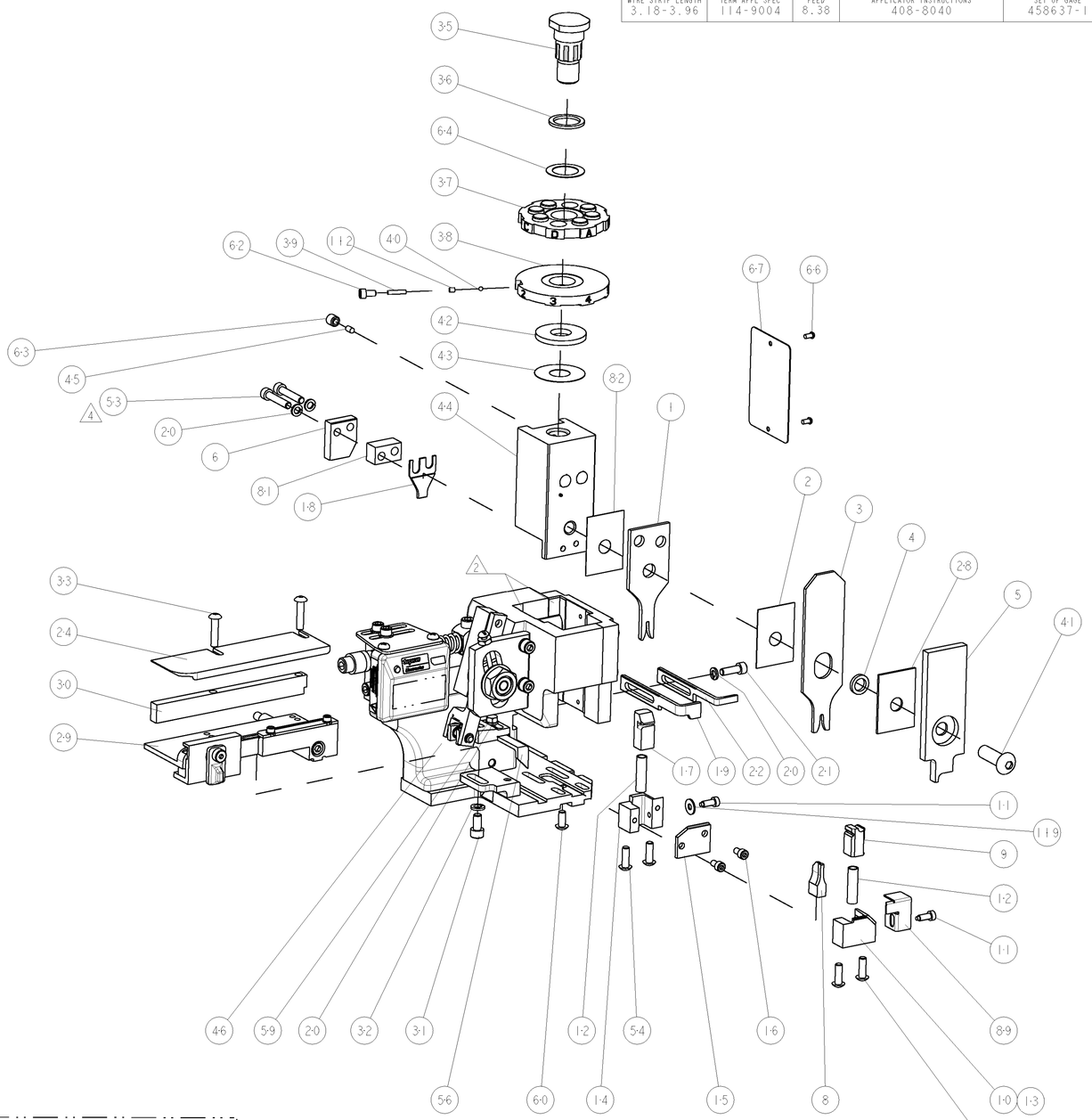
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPLICATOR INSTRUCTIONS	SET UP GAGE
3.18-3.96	114-9004	8.38	408-8040	458637-1

1. RECOMMENDED SPARE PARTS
2. GREASE LIGHTLY
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
4. CUT TO LENGTH AT ASSEMBLY.



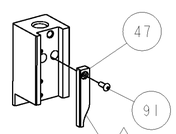


FEED TRACK POSITION GUIDE BY INS. BARREL



						PART NO	DESCRIPTION	ITEM NO
	-	2	2	2	2	-	4-354779-2	PIN, WIRE DISC, .3200	128
	-	2	2	2	2	-	3-354779-5	PIN, WIRE DISC, .3165	127
	-	2	2	2	2	-	2-354779-2	PIN, WIRE DISC, .3100	126
	-	1	1	1	1	-	21055-5	WASHER, FLAT, REG NO 6	119
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	-	5-240641-6	SPACER	81
	-	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
4	-	2	2	2	2	-	3-21000-0	SCR, SKT HD CAP 8-32 X .875	53
	-	-	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	-	1-690124-4	WASHER, RAM (.120)	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
	-	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	-	1320908-4	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	1	1	-	1-690518-1	HOLD DOWN, TERMINAL	18
	-	1	1	1	1	-	690463-1	FLOATING SHEAR, REAR	17
	-	2	2	2	2	-	1-21000-8	SCR, SKT HD CAP 6-32 X .250	16
	-	1	1	1	1	-	690691-9	PLATE,REAR SHEAR	15
	-	-	1	1	1	-	690462-1	SHEAR HOLDER, REAR	14
1	-	1	-	-	-	-	679625-1	SHEAR HOLDER, FRONT (NO CUT)	13
	-	2	2	2	2	-	3-22280-3	SPRING, COMPRESSION	12
	-	2	2	2	2	-	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	-	4-1633107-0	ANVIL, COMBINATION .062	8
	-	-	-	-	-	..	-	-	7
	-	1	1	1	1	-	690468-1	DEPRESSOR SHEAR, REAR	6
	-	1	1	1	1	-	455889-9	DEPRESSOR, SHEAR	5
	-	1	1	1	1	-	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	-	4-456135-4	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	-	455888-3	SPACER, CRIMPER	2
1	1	1	1	1	1	-	2-456403-6	CRIMPER, WIRE PREMIUM	1
	-77	-6	-3	-2	-1	U/M			

POST-FEED 1 5/8 STROKE



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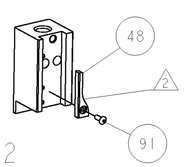
PRE-FEED 1 1/8 STROKE



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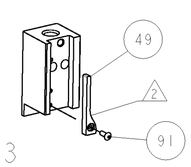
PRE-FEED 1 5/8 STROKE



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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 GROSS 15APR2008
CHK G BAILEY 15APR2008
APVD N DEMING 15APR2008
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

Tyco Electronics
Tyco Electronics
Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR
-
-

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1852684	-

CUSTOMER DRAWING SCALE 3:5 SHEET 1 OF 1 REV A

CUSTOMER VIEWABLE ASSEMBLY