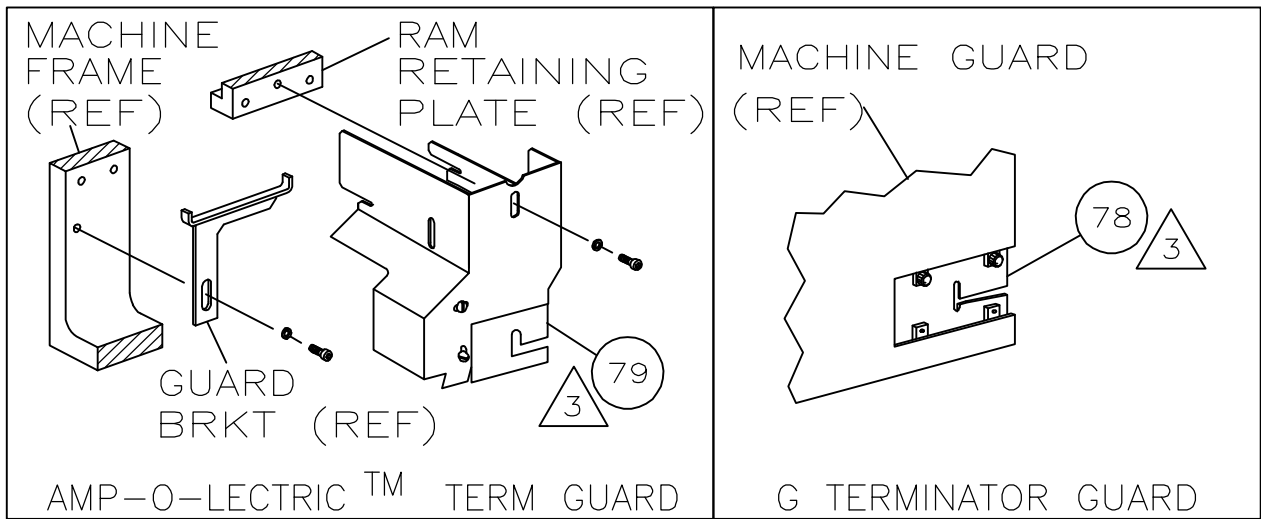


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PART NUMBER	REV	FIRST USED	CARRIER TYPE
680832-1	C	122500-1	CUT
680832-2	C	565435-5	CUT
680832-3	C	354500-1	CUT
680832-4	C	354500-1	NON-CUT



-1	LEADMAKER	POST FEED	-4	LEADMAKER	POST FEED
-2	BENCH MODEL K	PRE FEED	-	-	-
-3	BENCH MODEL G	PRE FEED	-	-	-

LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			C	ECR-07-008457	4-2007	MY	GB

REF	REF	REF	REF	—	22594-8	NUT, HEX(1/2-20)	70
REF	REF	REF	REF	—	240628-1	PLATE, ADJUSTMENT	69
REF	REF	REF	REF	—	240626-1	SHAFT, PIVOT	68
REF	REF	REF	REF	—	240633-1	BUSHING	67
REF	REF	REF	REF	—	455680-1	LEVER, INTERMEDIATE	66
REF	REF	REF	REF	—	240629-1	BLOCK, PIVOT	65
REF	REF	REF	REF	—	240632-2	SCREW, ADJ FEED ROD	64
REF	REF	REF	REF	—	240659-3	PIN, CAM ROLLER	63
REF	REF	REF	REF	—	240658-1	ROLLER, CAM	62
REF	REF	REF	REF	—	454398-2	ROD, FEED	61
REF	REF	REF	REF	—	454178-1	GUIDE, FEED ROD	60
REF	REF	REF	REF	—	454220-1	CAP, RAM	59
REF	REF	REF	REF	—	454485-1	HOUSING	58

							57
1	1	1	1	—	458537-2	PAWL, FEED	56
REF	REF	REF	REF	—	240624-1	PIN, FEED FINGER	55
REF	REF	REF	REF	—	691499-1	SPRING, FEED FINGER	54
REF	REF	REF	REF	—	690541-1	HOLDER, FEED FINGER	53
REF	REF	REF	REF	—	455679-1	LEVER, TERMINAL FEED ARM	52
1	1	1	1	—	811242-2	BUMPER, HOLDDOWN	51
1	1	1	1	—	690753-1	SPACER, TONKER	50
—	1	—	—	—	690602-6	CAM, PRE-FEED 1 5/8 ST	49
—	—	1	—	—	690602-5	CAM, PRE-FEED 1 1/8 ST	48
1	—	—	1	—	690501-4	CAM, POST-FEED 1 5/8 ST	47
1	1	1	1	—	459456-1	APPLICATOR, BASIC (SUBASSY)	46
1	1	1	1	—	690191-1	PLUG, NYLON	45
1	1	1	1	—	455673-1	RAM	44
1	1	1	1	—	690125-1	WASHER, LAMINATED	43
1	1	1	1	—	690124-1	WASHER, RAM	42
1	1	1	1	—	7-21002-9	BOLT, CRIMPER(5/16x1.00)	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, PLASTIC	37
1	1	1	1	—	22480-5	WASHER, SPRING	36
1	1	1	1	—	690212-1	POST, RAM	35
1	1	1	1	—	690786-1	SUPPORT, TERMINAL	34
REF	REF	REF	REF	—	455675-1	PLATE, BASE	33

							32
REF	REF	REF	REF	—	455689-1	BLOCK, STRIP GUIDE ADJ	31
1	1	1	1	—	318756-5	STRIP GUIDE PLATE ASSY	30
1	1	1	1	—	1-455888-9	SPACER, FRONT SHEAR DEP	29
2	2	2	2	—	1-22284-0	SPRING, DRAG	28
1	1	1	1	—	690546-1	LEVER, DRAG RELEASE	27
1	1	1	1	—	217233-1	DRAG, TERMINAL	26
1	1	1	1	—	7-690504-6	GUIDE, STRIP (REAR)	25
1	1	1	1	—	1-690438-1	GUIDE, STRIP (FRONT)	24
1	—	—	1	—	690472-2	STRIPPER	23
REF	REF	REF	REF	—	4-22284-9	SPRING, FEED RETURN	22
							21
—	1	1	—	—	691353-1	STRIPPER	20

							18
1	1	1	1	—	318563-1	GUARD, CHIP, FRONT	17
1	—	—	—	—	679625-2	SHEAR HOLDER (NON-CUT)	16
							15
1	1	1	1	—	3-22280-3	SPRING, SHEAR	14
1	1	1	1	—	690461-2	STOP, SHEAR	13
—	1	1	1	—	1-690459-0	HOLDER, SHEAR (FRONT)	12
1	1	1	1	—	318707-3	SHEAR, FLOAT (FRONT)	11
1	1	1	1	—	3-662186-4	ANVIL	10
							9
							8

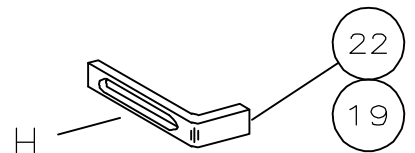
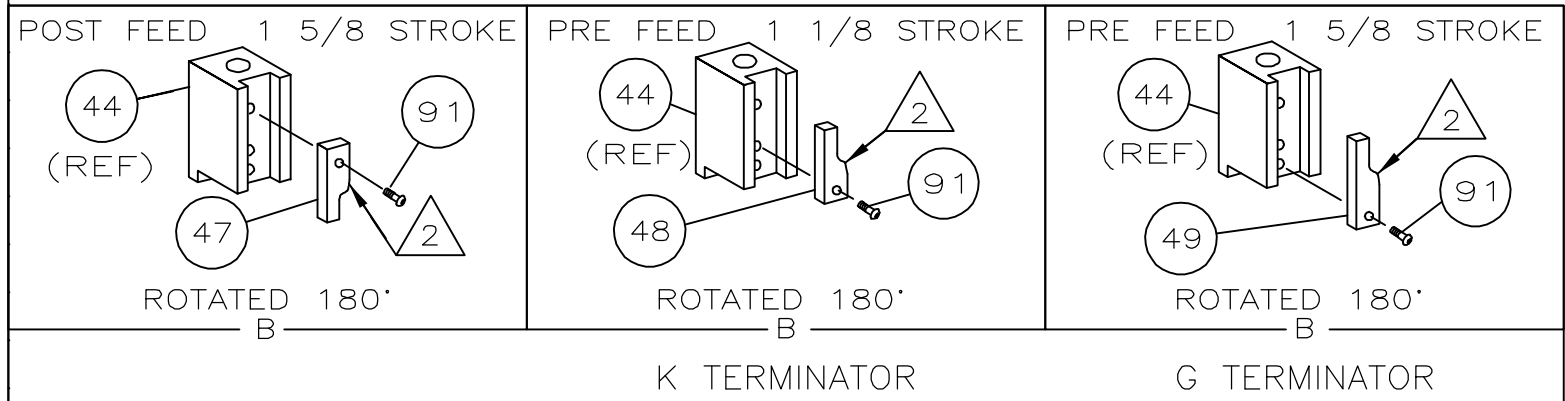
							7
							6
1	1	1	1	—	318701-1	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	1	—	1-238011-0	SPACER, BLOCK CRIMPER	4
1	1	1	1	—	5-683454-0	CRIMPER, INSULATION	3
1	1	1	1	—	1-455888-2	SPACER, CRIMPER	2
1	1	1	1	—	2-456405-9	CRIMPER, WIRE	1

-4	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
					PARTS LIST		
QTY REQD PER ASSY							

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		CHK. B-HIGMAN	19MAY99	Electronics		Harrisburg, PA 17105-3608	
DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	SIDE FEED HDM APPLICATOR		
		0 PLC ± -	1 PLC ± -	PRODUCT SPEC	-		
		2 PLC ± .02	3 PLC ± .02	APPLICATION SPEC	-		
		4 PLC ± -	5 PLC ± -	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
FINISH		WEIGHT		A1	00779	C=680832	-
CUSTOMER DRAWING				SCALE	SHEET	1 OF 2	REV C

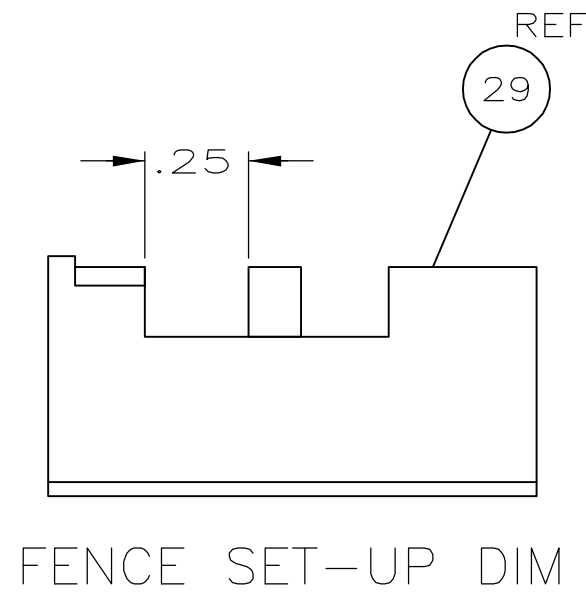
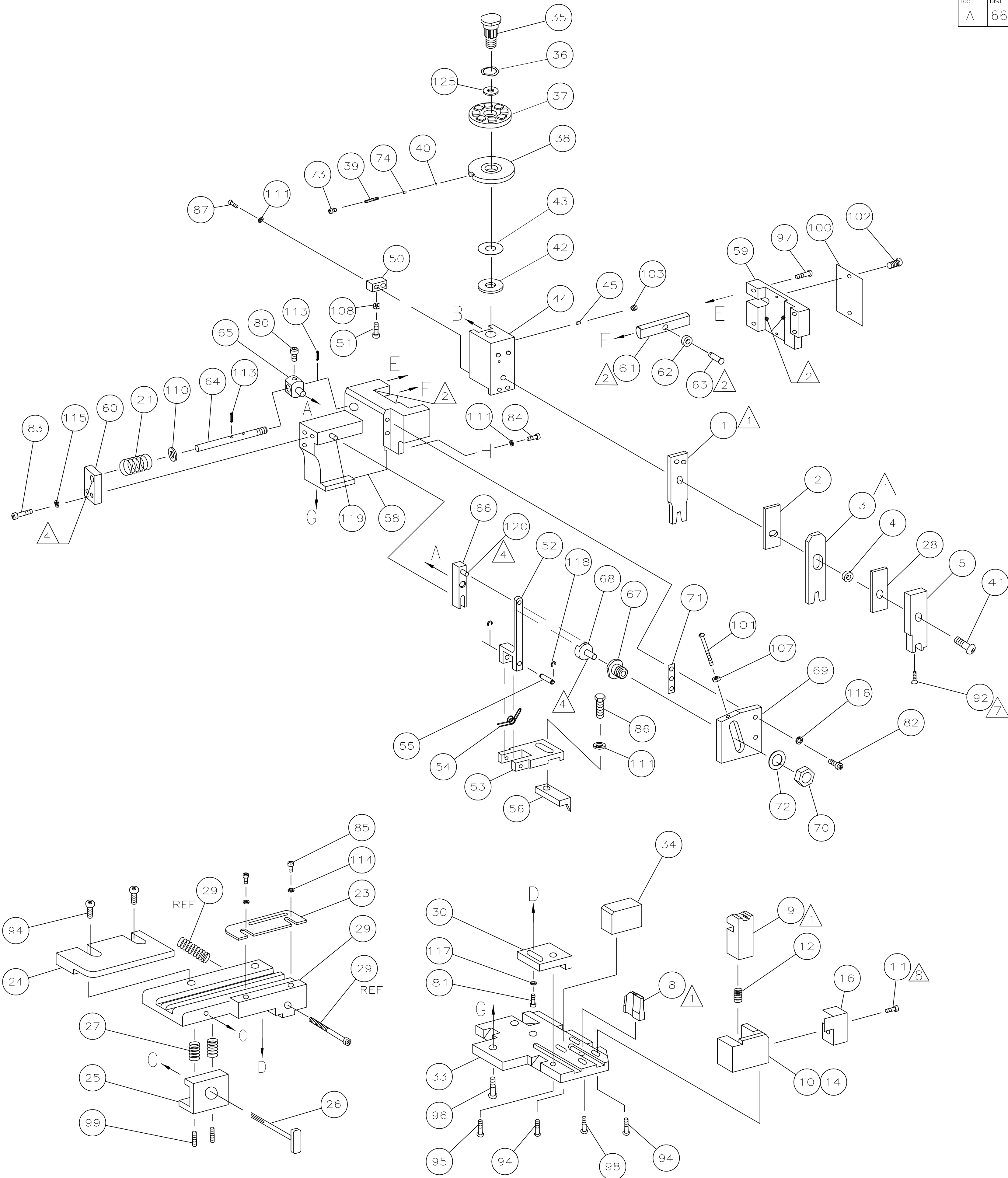
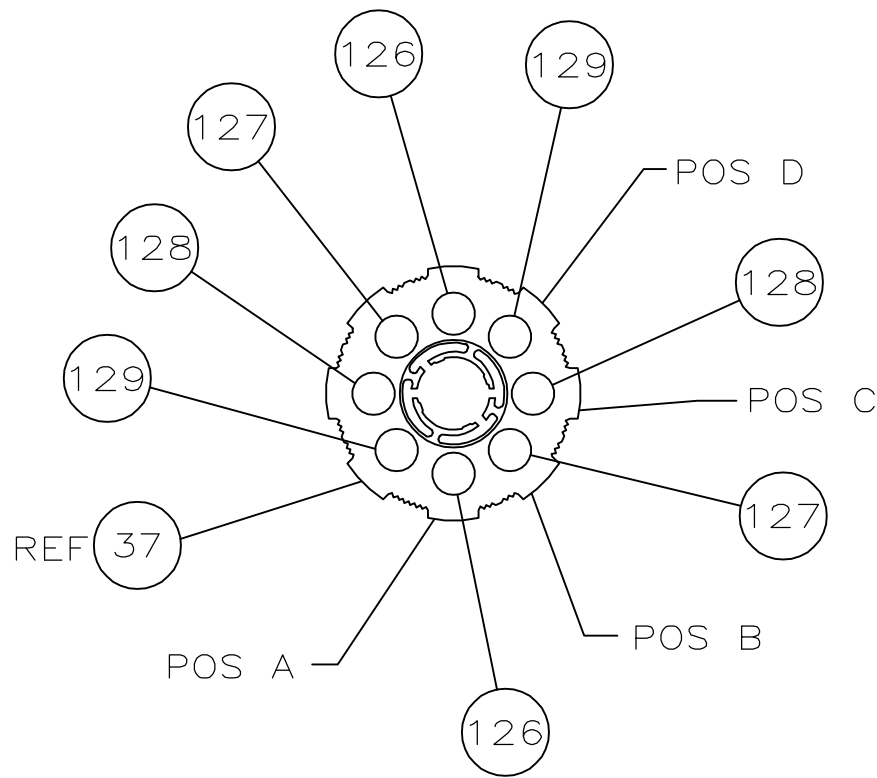
TERMINAL NAME: 1.5 SYSTEM SEALED CONNECTOR										6	
SEAL		TERMINAL		CRIMP DATA (NON-AMP TERMINAL-MFR SPEC)							
286814		286813		PAD LTR		CRIMP HEIGHT			WIRE SIZE		
				A		.051 ±.002 [1.30 ±0.05mm]			1.25 mm		
				B		.049 ±.002 [1.24 ±0.05mm]			1 mm		
				C		.045 ±.002 [1.14 ±0.05mm]			0.85 mm		
				D		.043 ±.002 [1.09 ±0.05mm]			0.6 mm		
				CRIMP		SIZE		TYPE		RANGE	
				WIRE		.080 [2.03mm]		F		0.6-1.25mm	
				INSUL		.140 [3.56mm]		0		1.6-2.34mm	
WIRE STRIP LENGTH				TERM APPL SPEC		FEED		APPL INSTRUCTION		SET UP GAGE LAYOUT	
.203—.234				NONE		.450		408-8040		458637-1 L2245	

1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
4. LUBRICATE DAILY USING NO. 20 MACHINE OIL.
5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
6. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL
7. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
8. CUT TO LENGTH AT ASSY



LEADMAKER & BENCH MACHINE

LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		—		SEE SHEET 1	—	—	—



THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN B. HIGMAN	19MAY99	Tyco Electronics Corporation Harrisburg, PA 17105-3608		
		CHK B. HIGMAN	19MAY99			
		APVD T. ELBIN	19MAY99	NAME SIDE FEED HDM APPLICATOR		
DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		
		0. PLC	± .	APPLICATION SPEC		
		1. PLC	± .			
		2. PLC	± .02			
		3. PLC	± .			
		4. PLC	± .			
		ANGLES	± .			
MATERIAL		FINISH	—	WEIGHT	F	RESTRICTED TO
				SIZE	A1	
				CAGE CODE	00779	
				DRAWING NO	680832	
				SCALE	—	
				SHEET	2	
				OF	2	
				REV	C	

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