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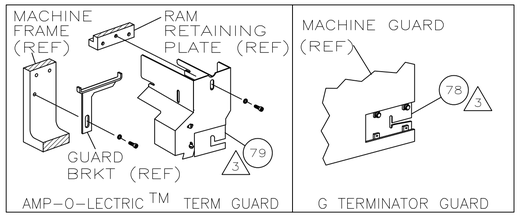
PART NUMBER	REV	FIRST USED
1385025-1	E	854400-1
1385025-2	E	565435-5
1385025-3	E	354500-1
7-1385025-7	E	-



TERMINAL NAME: Ø.140 SOCKET & PIN

△7 927841
△8 927843

CRIMPING DATA

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.056 ±.002 [1.42 ±0.05mm]	1.00mm²
B	.052 ±.002 [1.33 ±0.05mm]	.75mm²
C	.049 ±.002 [1.24 ±0.05mm]	.50mm²
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.080 [2.03mm]	F	.50-1.00mm²
INSUL	.110 [2.79mm]	OVL	Ø1.20-2.40mm

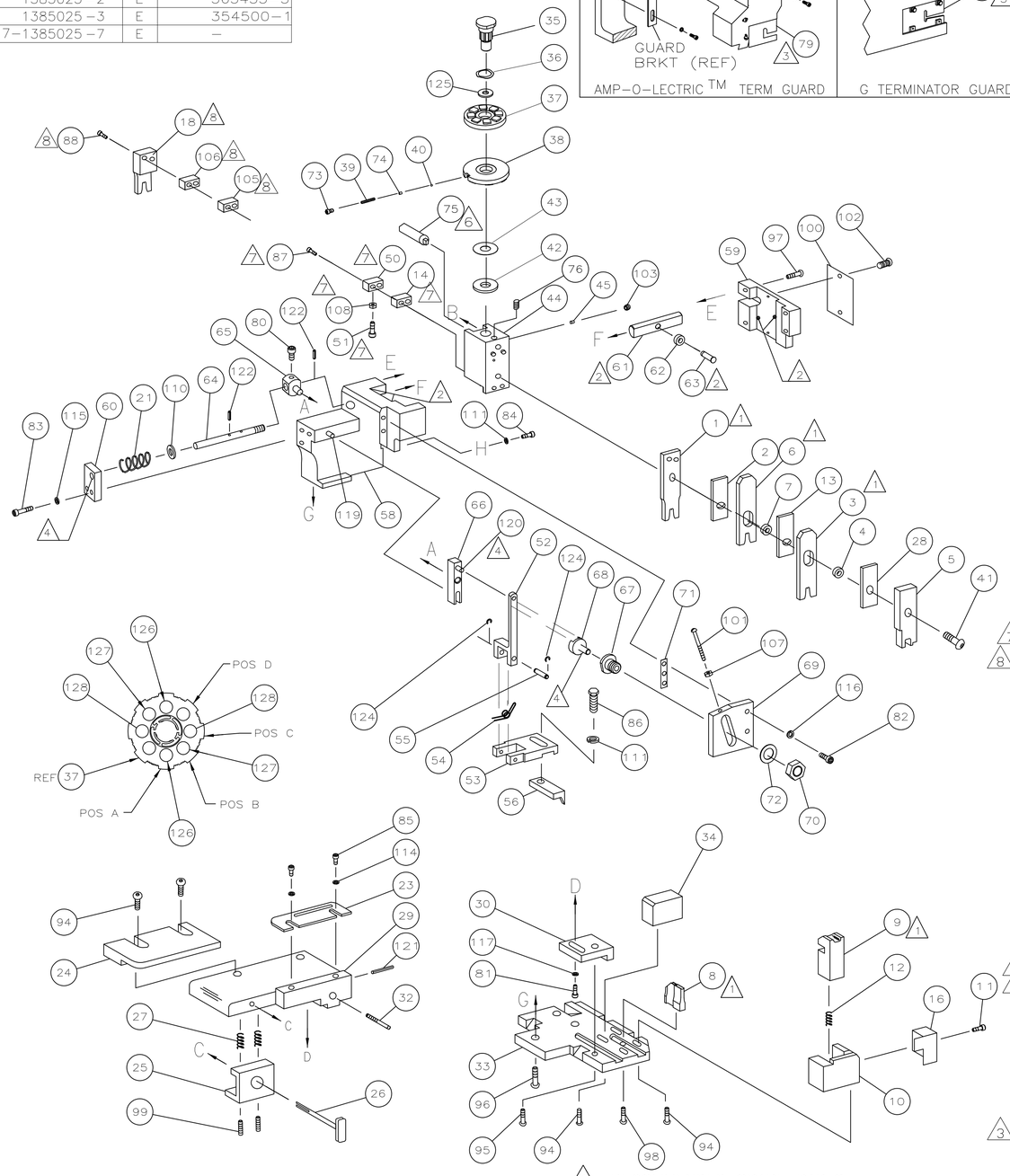
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INST	SET UP GAGE	LAYOUT
.234-.250	114-1007	.590	408-8040	458637-1	L2338

LOC	DIST
A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	E	ECR-09-014162	6-2007	MY	TE

-1	LEADMAKER	MECH POST FEED
-2	BENCH MODEL K	MECH PRE FEED
-3	BENCH MODEL G	MECH PRE FEED
-77	-	SPARE PARTS KIT

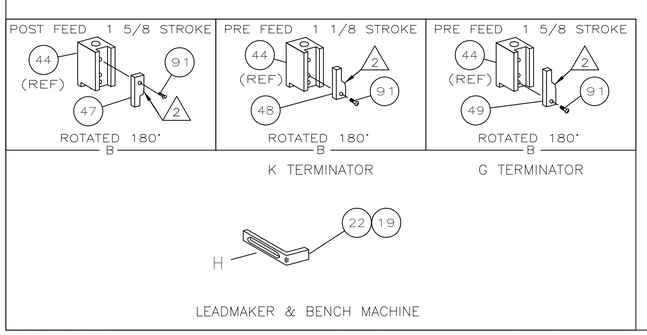


-77	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
							129
-	2	2	2	-	2-354779-6	PIN, WIRE DISC (.3120)C	128
-	2	2	2	-	2-354779-0	PIN, WIRE DISC (.3090)B	127
-	2	2	2	-	1-354779-1	PIN, WIRE DISC (.3045)A	126
-	1	1	1	-	986950-1	WASHER, FLAT PRECISION	125
-	REF	REF	REF	-	21045-3	RING,RET "C"(Ø.187)FD FING PIN	124
							123
-	REF	REF	REF	-	5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	122
-	1	1	1	-	4-21028-0	PIN,SLT SPR(Ø.093x.75)ST GDE PL	121
-	REF	REF	REF	-	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	120
-	REF	REF	REF	-	1-21030-6	PIN,DOWEL(Ø.187x1.25)HOUSING	119
							118
-	1	1	1	-	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
-	REF	REF	REF	-	21024-5	WASHER,LOCK(#10)ADJ PLATE	116
-	REF	REF	REF	-	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115
-	2	2	2	-	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
							113
							112
							111
-	REF	REF	REF	-	21899-4	WASHER,FLAT(Ø5/16)SCREW ADJ	110
							109
-	1	1	1	-	21018-5	NUT,HEX (6-32)	108
-	REF	REF	REF	-	21018-5	NUT,HEX(6-32)FEED ADJ	107
-	1	1	1	-	4-240641-0	SPACER	106
-	1	1	1	-	2-240641-1	SPACER	105
							104
-	1	1	1	-	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
-	2	2	2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
-	REF	REF	REF	-	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
-	1	1	1	-	461264-1	PLATE, IDENTIFICATION	100
-	2	2	2	-	5-21006-6	SCR,SET(10-32x.75)DRAG	99
-	1	1	1	-	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
-	REF	REF	REF	-	2-21002-9	SCR,BHC(10-32x.75)CAP	97
-	REF	REF	REF	-	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
-	REF	REF	REF	-	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
-	4	4	4	-	2-21002-2	HOLDER, INSULATION	94
							93
							92
-	1	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	91
							90
							89
-	2	2	2	-	3-21000-0	SCR,SHC(8-32x.88)	88
-	2	2	2	-	2-21000-8	SCR,SHC(8-32x.62)	87
-	1	1	1	-	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
-	2	2	2	-	1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	85
-	1	1	1	-	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
-	REF	REF	REF	-	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
-	REF	REF	REF	-	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	82
-	1	1	1	-	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
-	REF	REF	REF	-	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	80
-	-	REF	-	-	455749-1	GUARD, WINDOW	79
-	REF	-	-	-	679532-1	INSERT, GUARD	78
							77
-	1	1	1	-	22859-7	PLUNGER, SPRING	76
-	1	1	1	-	1-453412-6	SHAFT, STABILIZER	75
-	1	1	1	-	690603-1	SPRING, ASSIST	74
-	1	1	1	-	23030-1	SCR,SHC(6-32x.25 SL)INS DISC	73
-	REF	REF	REF	-	458109-1	WASHER, SPECIAL	72
-	REF	REF	REF	-	690517-1	SPACER	71

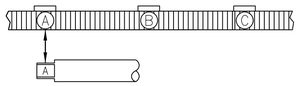
QTY REQD PER ASSY — PARTS LIST

-77	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
-	REF	REF	REF	-	22594-8	NUT,HEX(1/2-20)	70
-	REF	REF	REF	-	240628-1	PLATE, ADJUSTMENT	69
-	REF	REF	REF	-	240626-1	SHAFT, PIVOT	68
-	REF	REF	REF	-	240633-1	BUSHING	67
-	REF	REF	REF	-	455680-1	LEVER, INTERMEDIATE	66
-	REF	REF	REF	-	240629-1	BLOCK, PIVOT	65
-	REF	REF	REF	-	240632-2	SCREW, ADJ FEED ROD	64
-	REF	REF	REF	-	240659-3	PIN, CAM ROLLER	63
-	REF	REF	REF	-	240658-1	ROLLER, CAM	62
-	REF	REF	REF	-	454398-2	ROD, FEED	61
-	REF	REF	REF	-	454178-1	GUIDE, FEED ROD	60
-	REF	REF	REF	-	454220-1	CAP, RAM	59
-	REF	REF	REF	-	454485-1	HOUSING	58
							57
-	1	1	1	-	458537-2	PAWL, FEED	56
-	REF	REF	REF	-	240624-1	PIN, FEED FINGER	55
-	REF	REF	REF	-	691499-1	SPRING, FEED FINGER	54
-	REF	REF	REF	-	690541-1	HOLDER, FEED FINGER	53
-	REF	REF	REF	-	455679-2	LEVER, TERMINAL FEED ARM	52
-	1	1	1	-	811242-2	BUMPER, HOLDDOWN	51
-	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	-	690501-4	CAM, POST-FEED 1 5/8 ST	47
-	1	1	1	-	459456-2	APPLICATOR, BASIC (SUBASSY)	46
-	1	1	1	-	690191-1	PLUG, NYLON	45
-	1	1	1	-	817855-4	RAM	44
-	1	1	1	-	690125-1	WASHER, LAMINATED	43
-	1	1	1	-	690124-1	WASHER, RAM	42
-	1	1	1	-	690686-1	BOLT, CRIMPER(5/16x1.00)	41
-	1	1	1	-	23241-6	BALL, STEEL	40
-	1	1	1	-	690170-1	SPRING, COMPRESSION	39
-	1	1	1	-	690142-1	DISC, INSULATION	38
-	1	1	1	-	354777-1	WIRE DISC, PLASTIC	37
-	1	1	1	-	22480-5	WASHER, SPRING	36
-	1	1	1	-	690212-1	POST, RAM	35
-	1	1	1	-	690786-1	SUPPORT, TERMINAL	34
-	REF	REF	REF	-	455675-1	PLATE, BASE	33
-	1	1	1	-	690432-3	SCREW, ADJUSTMENT	32
							31
-	REF	REF	REF	-	455689-1	BLOCK, STRIP GUIDE ADJ	30
-	1	1	1	-	455671-1	PLATE, STRIP GUIDE	29
-	1	1	1	-	2-455888-0	SPACER,CRIMPER	28
-	2	2	2	-	1-22284-0	SPRING, DRAG	27
-	1	1	1	-	690546-1	LEVER, DRAG RELEASE	26
-	1	1	1	-	240792-1	DRAG, TERMINAL	25
-	1	1	1	-	8-690504-9	GUIDE, STRIP (REAR)	24
-	1	1	1	-	690438-1	GUIDE, STRIP (FRONT)	23
-	-	-	1	-	690472-9	STRIPPER	22
-	REF	REF	REF	-	4-22284-9	SPRING, FEED RETURN	21
							20
-	1	1	-	-	691353-1	STRIPPER	19
-	1	1	1	-	1338766-1	TOOL SIZING	18
							17
-	1	1	1	-	691667-1	GUARD, CHIP (FRONT)	16
							15
-	1	1	1	-	2-240641-9	SPACER, DEPRESSOR (REAR)	14
-	1	1	1	-	455888-4	SPACER, CRIMPER	13
-	1	1	1	-	3-22280-3	SPRING, SHEAR	12
-	1	1	1	-	690461-1	STOP, SHEAR	11
-	1	1	1	-	690459-1	HOLDER, SHEAR (FRONT)	10
-	1	1	1	-	454276-1	SHEAR, FLOAT (FRONT)	9
1	1	1	1	-	1338767-1	ANVIL	8
-	1	1	1	-	238011-2	SPACER, BLOCK CRIMPER	7
-	1	1	1	-	817852-4	CRIMPER, STABILIZER	6
-	1	1	1	-	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	-	238011-7	SPACER, BLOCK CRIMPER	4
1	1	1	1	-	854830-1	CRIMPER, INSULATION	3
-	1	1	1	-	455888-6	SPACER, CRIMPER	2
1	1	1	1	-	1-817854-9	CRIMPER, WIRE	1

QTY REQD PER ASSY — PARTS LIST



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. STABILIZER CRIMPER SHAFT MUST BE TURNED SO THAT LETTER SHOWING (RIGHT SIDE OF RAM) MATCHES WIRE DISC PAD BEING USED (A,B OR C) AS SHOWN:



7. ITEMS 14, 50, 51, 87 AND 108 REQ'D FOR 927841.
8. ITEMS 18, 88, 105 & 106 REQ'D FOR 927843.

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± - ; 1 PLC ± - ; 2 PLC ± - ; 3 PLC ± - ; 4 PLC ± - ; ANGLES ± -
MATERIAL -
FINISH -

DWN W.HOOVER 2/21/00
CHK C.ERISMAN 2/21/00
APVD T.ELBIN 2/21/00
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

Tyco Electronics Corporation
Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1385025	-

CUSTOMER DRAWING — SCALE - — SHEET 1 OF 1 — REV E

AMP 4805 REV 31MAR2000

23JUN2009 10:06am

Mouser Electronics

Authorized Distributor

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TE Connectivity:

1385025-2