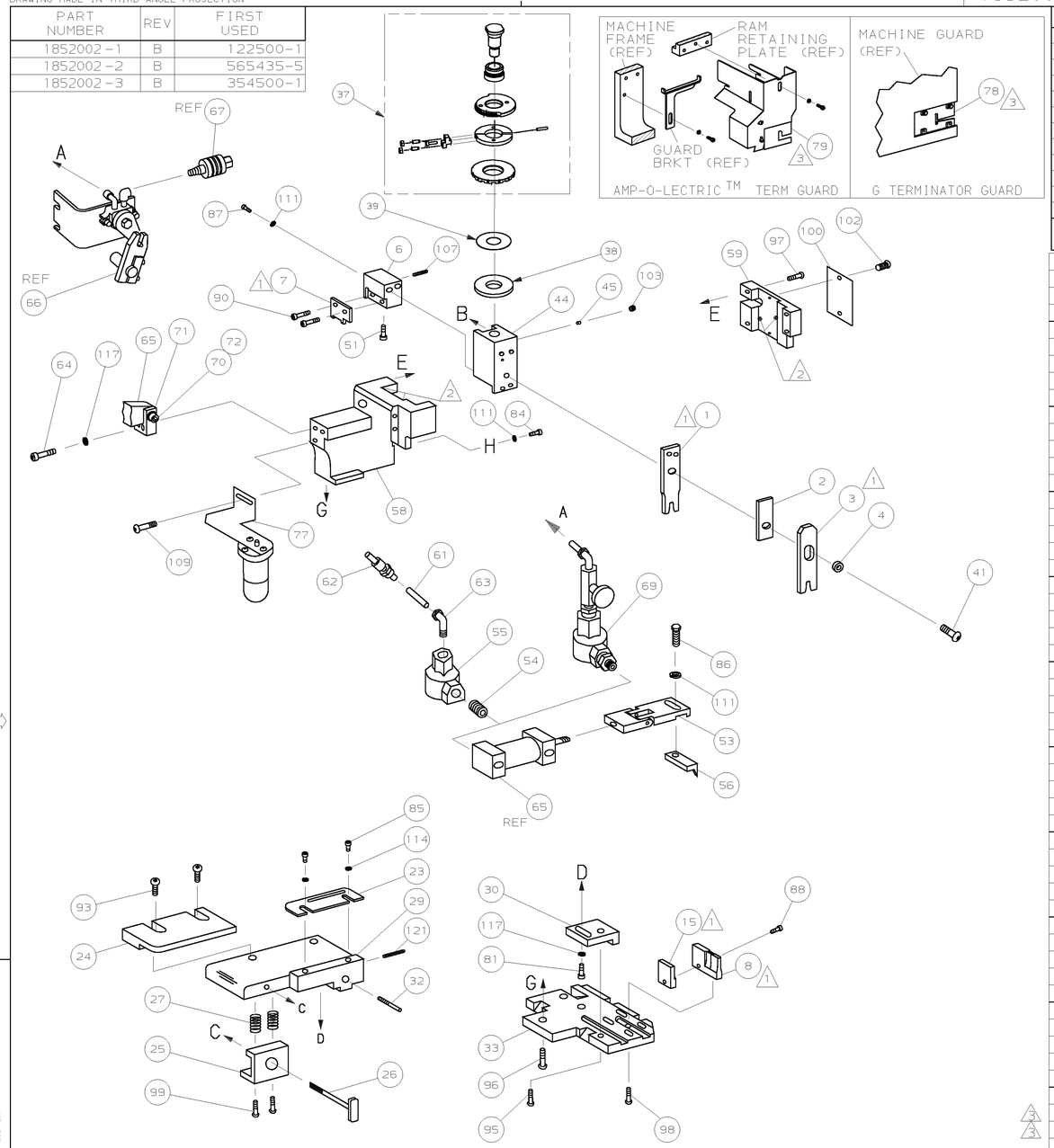
DRAWING MADE IN THIRD ANGLE PROJECTION

/home/us016926/DMTECmod

PART NUMBER	REV	FIRST USED
1852002-1	B	122500-1
1852002-2	B	565435-5
1852002-3	B	354500-1



TERMINAL NAME: RING						
AMP TERM PN	MFR TERM PN	REF SETTING	DELPHI TERMINAL	DELPHI CRIMP SPECS		
1572664	12103519		CRIMP HEIGHT		WIRE SIZE	
		C3	.094 ±.002 [2.39 ±0.05mm]		(2)16	
		C8	.091 ±.002 [2.31 ±0.05mm]		(1)16 & (1)18	
		D5	.087 ±.002 [2.21 ±0.05mm]		(2)18	
		-	NOT		USED	
		CRIMP	SIZE	TYPE	RANGE	
		WIRE	.165 [4.19mm]	F	(2)18-(2)16	
		INSUL	.230 [5.84mm]	F	ø.141 MAX	

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.266-.281	NONE	.683	408-8040	458637-1	L3082

-1	-2	-3	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
							129
							128
							127
							126
							125
1	1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	1	-	-	4088040	SF APPL INST 408-8040	123
							122
1	1	1	-	A	3-21028-5	PIN,SLT SPR(ø.093x.44)ST GDE PL	121
							120
							119
							118
3	3	3	-	A	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
							116
							115
2	2	2	-	A	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
							113
							112
4	4	4	-	A	21024-4	WASHER,LOCK(#8)STRIPPER	111
							110
-	1	-	-	A	2-21002-6	SCR,BHC(10-32x.38)LUBE ASSY	109
1	1	1	-	A	21018-5	NUT,HEX(NO.6)HOLDDOWN	108
1	1	1	-	A	2-21008-1	SCR,SET(4-40X.25)HOLD DOWN	107
							106
							105
1	1	-	-	A	992031-1	PIN, CLEVIS	104
1	1	1	-	A	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
2	2	2	-	A	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
							101
1	1	1	-	B	461264-5	PLATE, IDENTIFICATION	100
2	2	2	-	A	3-21002-0	SCR,BHC(10-32x.88)DRAG	99
1	1	1	-	A	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
4	4	4	-	A	2-21002-9	SCR,BHC(10-32x.75)CAP	97
3	3	3	-	A	2-22733-8	SCR,BHC(1/4-20x.62)HSG	96
1	1	1	-	A	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLK	95
							94
2	2	2	-	A	2-21002-1	SCR,BHC(8-32x.38)R STP GDE	93
							92
							91
2	2	-	-	A	2-21002-3	SCR,BHC(8-32X.62)SLUG BL	90
1	1	-	-	A	7-21000-9	SCR,SHC(4-40x.19)STRIPPER	89
1	1	1	-	C	3-21000-0	SCR,SHC(8-32X.88)SH PLATE	88
2	2	2	-	A	3-21000-1	SCR,SHC(8-32x1.00)DEP-HOLD	87
1	1	1	-	A	2-22603-1	SCR,HEX HD(8-32x.38)FEED FINGER	86
2	2	2	-	A	1-21000-3	SCR,SHC(4-40x.25)FR ST GUIDE	85
1	1	1	-	A	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
							83
							82
1	1	1	-	A	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
							80
3 -	1	-	-	B	462992-7	GUARD ASSY	79
3 REF	-	-	-	B	679532-1	INSERT, GUARD	78
-	1	-	-	C	1-465184-0	LUBRICATOR ASSY	77
							76
							75
							74
							73
1	1	1	-	A	3-21001-5	SCR,SHC(3/8-16X1.00)AIR FEED	72
1	1	1	-	B	459610-1	MOUNT, FEED BRACKET	71
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY — PARTS LIST

-1	-2	-3	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
LEADMAKER	BENCH MODEL K	BENCH MODEL G			AIRFEED	AIRFEED	AIRFEED
1	1	1	-	A	21024-8	WASHER, LOCK 3/8	70
4 -	1	-	-	C	692655-5	AIR FEED VALVE ASSY	69
							68
-	REF	-	-	A	24042-2	VALVE, SHUT OFF	67
4 -	REF	-	-	C	692655-6	AIR FEED VALVE ASSY	66
4 1	1	1	-	B	461065-1	AIR FEED ASSY (1 INCH)	65
2	2	2	-	A	3-21000-9	SCR,SHC(10-32x1.00)AIR ASSY	64
1	-	1	-	A	980285-2	ELBOW, SWIVEL 1/8 NPT - 1/4 T	63
1	-	1	-	A	23238-1	QUICK DISCONNECT	62
21.00	-	21.00	IN	A	27319-4	TUBING, POLY-FLO ø.25	61
							60
1	1	1	-	C	454220-1	CAP, RAM	59
1	1	1	-	D	454485-1	HOUSING	58
							57
1	1	1	-	B	1-694433-5	PAWL, FEED	56
1	-	1	-	A	22374-7	VALVE, QUICK EXHAUST	55
1	-	1	-	A	22304-1	NIPPLE, HEX	54
4 1	1	1	-	B	461062-1	FEED FINGER ASSY	53
							52
1	1	1	-	A	811242-2	BUMPER, HOLD DOWN	51
							50
							49
							48
							47
							46
1	1	1	-	A	690191-1	PLUG, NYLON	45
1	1	1	-	C	1-455673-5	RAM	44
							43
							42
1	1	1	-	A	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41
							40
1	1	1	-	D	690125-1	SHIM SUBASSY	39
1	1	1	-	D	469367-1	SPACER, FINE ADJUST	38
1	1	1	-	D	879103-2	FINE ADJUST HEAD ASSY	37
							36
							35
							34
1	1	1	-	D	1633145-1	PLATE, BASE	33
1	1	1	-	A	690432-3	SCREW, ADJUSTMENT	32
							31
1	1	1	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	-	C	4-455671-8	PLATE, STRIP GUIDE	29
							28
2	2	2	-	A	1-22284-0	SPRING, DRAG	27
1	1	1	-	B	690546-1	LEVER, DRAG RELEASE	26
1	1	1	-	B	4-690754-8	DRAG, TERMINAL	25
1	1	1	-	D	8-690440-2	GUIDE, STRIP (REAR)	24
1	1	1	-	A	2-189124-0	GUIDE, STRIP (FRONT)	23
-	-	1	-	B	690472-2	STRIPPER	22
							21
1	1	-	-	A	679218-1	STRIPPER WIRE STOP ASSY	20
1	1	-	-	B	458949-1	STRIPPER	19
							18
							17
							16
1 1	1	1	-	C	1752737-3	PLATE, REAR SHEAR	15
							14
							13
							12
							11
							10
							9
1 1	1	1	-	C	1804387-1	ANVIL	8
1 1	1	1	-	C	1583859-2	BLADE, SLUG	7
1	1	1	-	C	1583893-5	HOLDER, SLUG BLADE	6
							5
1	1	1	-	B	238009-1	SPACER, BLOCK CRIMPER	4
1 1	1	1	-	C	6-1213077-3	CRIMPER, INSULATION	3
1	1	1	-	C	1-455888-8	SPACER, CRIMPER	2
1 1	1	1	-	C	5-1490019-9	CRIMPER, WIRE	1
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

QTY REQD PER ASSY — PARTS LIST

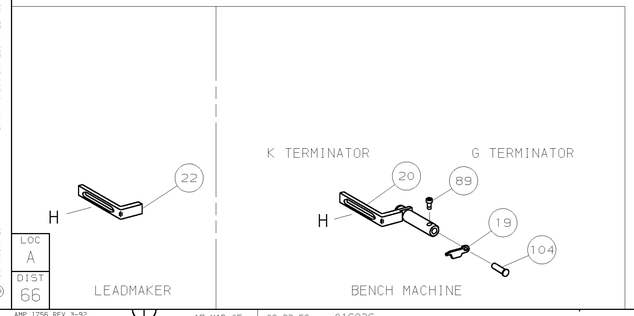
1 RECOMMENDED SPARE PARTS.

2 GREASE LIGHTLY.

3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.

4 SEE DRAWING FOR COMPONENTS

✳ 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.



P	F	LTR	REVISION RECORD	APP	DATE
		B	ECN 0150-0277-05	TE	3-05
		A	REVD	CE	MAR05

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±.25 3 PLC DEC ±- 4 PLC DEC ±- ANGLES ± - SURF TEXTURE, √ REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL – HT TR – FIN –

DR 04FEB05 C.ERISMAN APP 04FEB05 T.ELBIN CHK – REL –

AMP Tyco Electronics Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL

SCALE – D DWG NO 1852002 SHEET 1 OF 1 REV B

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