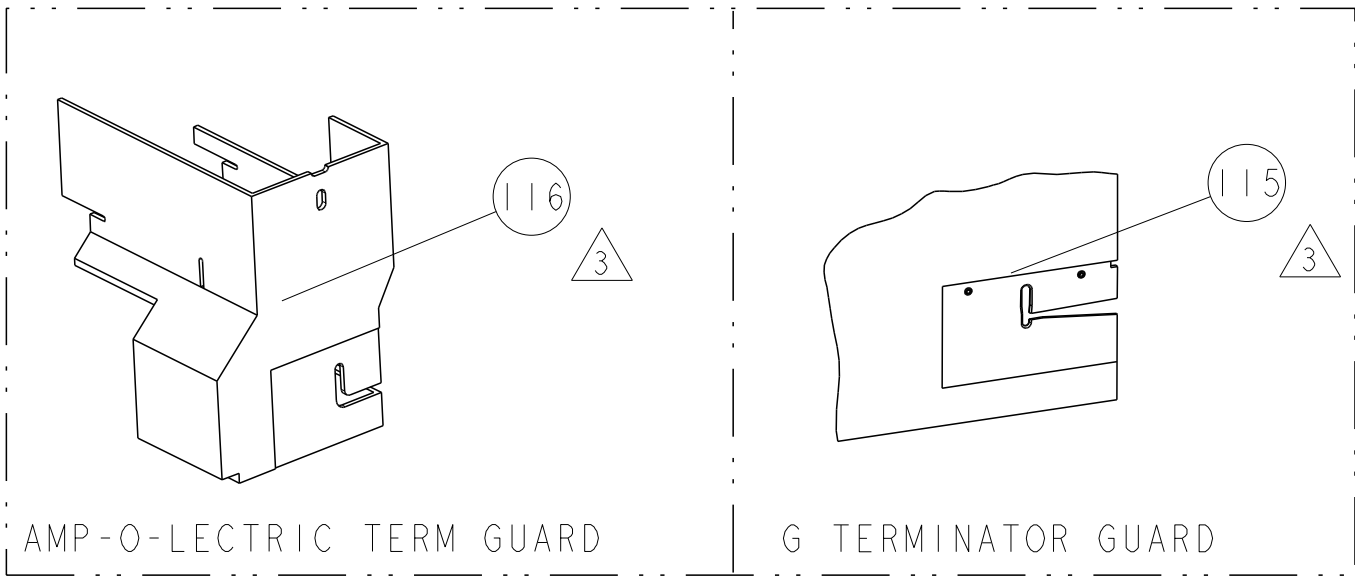


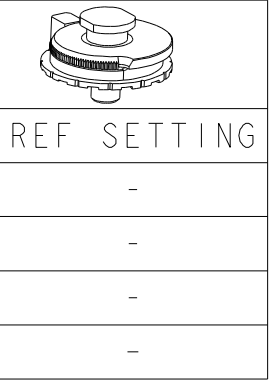
8			7		
THIS DRAWING IS UNPUBLISHED.			RELEASED FOR PUBLICATION		
20			20		
© COPYRIGHT 20			BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.		
PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1855289-1	B	122500-1	LEADMAKER	AIR FEED	CUTS CARRIER
1855289-2	A	565435-5	BENCH MODEL K	AIR FEED	CUTS CARRIER
1855289-3	A	354500-1	BENCH MODEL G	AIR FEED	CUTS CARRIER
7-1855289-7	A	-	-	-	SPARE PARTS

- △1 RECOMMENDED SPARE PARTS
- △2 GREASE LIGHTLY
- △3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
- △4 INSTALL ITEMS 101, 102, & 119 ON SIDE OF STRIPPER ON APPL HOUSING USING ITEM 21.
- △5 FOR LARGE INSULATION DIAMETER PER TERMINAL MANUFACTURER .043-.067[1.09-1.70mm].

* 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.



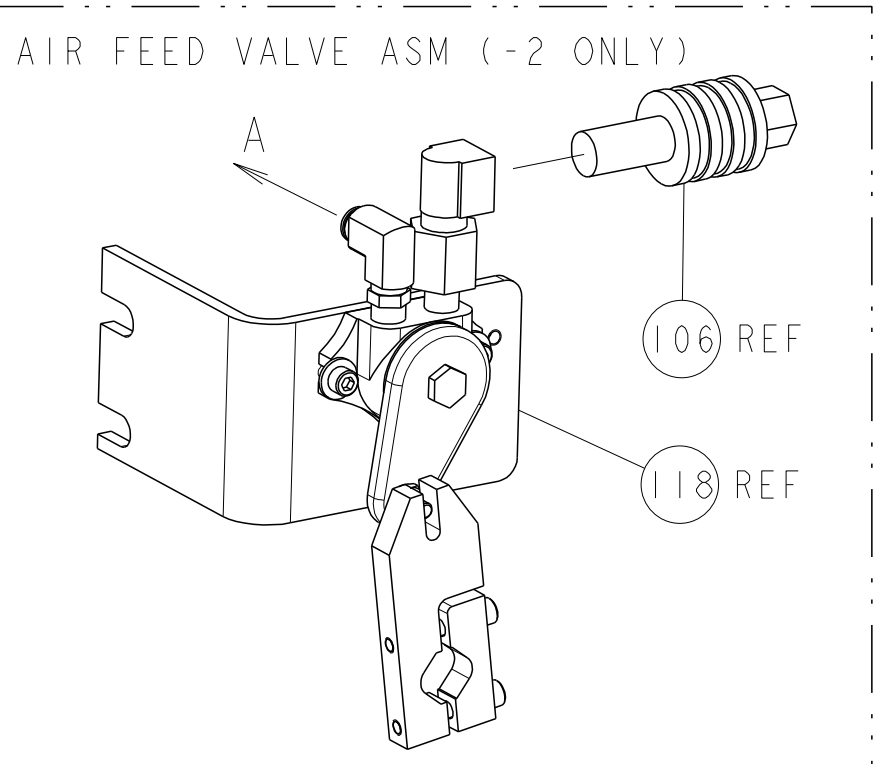
TERMINAL NAME: KK® Crimp Terminal					
TE P/N	MOLEX P/N	MOLEX TERMINAL - MOLEX CRIMP SPECS			
286698-1	08-50-0113				
286698-2	08-55-0101	CRIMP HEIGHT		WIRE SIZE	
286698-3	08-56-0109	SEE CRIMP HEIGHTS TABLES ON SHEET 2			
286698-4	08-52-0101				
286698-5	08-65-0815				
286698-6	08-65-0813				
286698-7	97-00-0444	CRIMP	SIZE	TYPE	RANGE
1949741-1	08-70-0048				
1949741-2	08-70-0064	WIRE	.054 [1.37mm]	F	SEE SHEET 2
-	-	INSUL	.077 [1.96mm]	F	SEE SHEET 2
WIRE STRIP LENGTH 100 - 125 [2.54-3.18mm]	TERM APPL SPEC NONE	FEED 900 [5.08mm]	APPLICATOR INSTRUCTIONS 408-8040		SET UP GAGE 458637-1



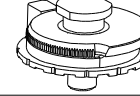
LOC		DIST		REVISONS			
A		66		P	LTR	DESCRIPTION	DATE
				B1	ECR-12-013912		03AUG2012
							L.Z
							S.X

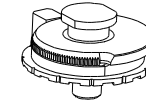
△4	-	1	1	1	-	1-22281-8	SPRING, COMPRESSION	121
-	-	42	21	42	IN	27319-4	TUBING, POLY-FLO, NATURAL	119
-	-	REF	-	-	-	692655-6	AIR FEED VALVE ASSEMBLY	118
-	-	1	1	1	-	461062-1	FEED FINGER ASSEMBLY	117
△3	-	REF	-	-	-	455749-1	GUARD WINDOW	116
△3	-	REF	-	-	-	679532-1	INSERT, GUARD	115
-	-	1	1	1	-	3-21001-5	SCR, SKT HD CAP 3/8-16 X 1.000	111
-	-	1	1	1	-	459610-1	MOUNT, FEED BRACKET	110
-	-	1	1	1	-	21024-8	WASHER, SPRG LOCK, REG 3/8	109
-	-	1	-	1	-	692655-7	AIR FEED VALVE ASSEMBLY	108
-	-	REF	-	-	-	24024-2	VALVE, SHUT OFF	106
-	-	1	-	-	-	692655-5	AIR FEED VALVE ASSEMBLY	105
-	-	1	1	1	-	461065-1	ASSEMBLY, AIR FEED	104
-	-	2	2	2	-	3-21000-9	SCR, SKT HD CAP 10-32 X 1.000	103
△4	-	1	1	1	-	986220-3	CLAMP, CABLE, BLACK	102
△4	-	1	-	1	-	23238-1	INSERT, COUPLING	101
-	-	2	2	2	-	2-21002-1	SCR, BTN SKT HD CAP 8-32 X .375	98
-	-	1	1	1	-	2-690712-4	FRONT STRIP GUIDE	96
-	-	2	2	2	-	1-21000-4	SCR, SKT HD CAP 4-40 X .375	95
-	-	1	1	1	-	8-21000-7	SCR, SKT HD CAP 10-32 X 2.500	93
-	-	1	1	1	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	88
-	-	1	1	1	-	1-455888-3	SPACER, CRIMPER	82
-	-	2	2	2	-	1-21002-4	SCR, BTN SKT HD CAP 4-40 X .375	79
-	-	1	1	1	-	1-189807-5	FENCE	78
-	-	1	1	1	-	4088040	SF APPL INST 408-8040	72
-	-	1	1	1	-	217238-1	GENERAL INSTRUCTION PKG	71
-	-	2	2	2	-	21024-2	WASHER, SPRG LOCK, REG NO 4	68
-	-	1	1	1	-	461264-5	PLATE, IDENTIFICATION	67
-	-	2	2	2	-	21017-2	SCREW, DRIVE	66
-	-	1	1	1	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	63
-	-	2	2	2	-	5-21006-6	SCR, SET, CUP POINT 10-32 X .750	61
-	-	1	1	1	-	22733-8	SCR, BHSC, SELF-LOCKING, 8-32 X .375	60
-	-	1	1	1	-	2-22603-0	SCR, HEX HD CAP 8-32 X .312	59
-	-	1	1	1	-	3-694433-7	FEED PAWL	56
-	-	2	2	2	-	3-21000-0	SCR, SKT HD CAP 8-32 X .875	53
-	-	1	1	1	-	1583893-8	HOLDER, SLUG BLADE	50
-	-	1	1	1	-	1633399-1	APPL., BASIC AIR FEED SUB ASSY	46
-	-	1	1	1	-	690191-1	PLUG, NYLON	45
-	-	1	1	1	-	455673-6	RAM, SIDE FEED	44
-	-	1	1	1	-	7-21002-9	SCR, BTN SKT HD CAP 5/16-24 X 1.00	41
-	-	1	1	1	-	690125-1	SHIM SUB-ASSY	39
-	-	1	1	1	-	469367-7	SHIM	38
-	-	1	1	1	-	879103-3	FINE ADJUST HEAD ASSEMBLY	37
-	-	2	2	2	-	2-21002-4	SCR, BTN SKT HD CAP 8-32 X .750	33
-	-	3	3	3	-	21024-5	WASHER, SPRG LOCK, REG NO 10	32
-	-	1	1	1	-	3-21000-4	SCR, SKT HD CAP 10-32 X .375	31
-	-	1	1	1	-	1320908-5	SPACER, STRIP GUIDE	30
-	-	1	1	1	-	1-1633087-1	PLATE, STRIP GUIDE	29
-	-	2	2	2	-	8-22281-7	SPRING, COMPRESSION	27
-	-	1	1	1	-	356835-1	LEVER, DRAG RELEASE	26
-	-	1	1	1	-	5-690754-2	DRAG, SPECIAL	25
-	-	1	1	1	-	1-1320928-0	STRIP GUIDE	24
-	-	1	1	1	-	22353-8	SCR, SHLD, SLOT HD, 3/16 DIA	23
-	-	1	1	1	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	21
-	-	2	2	2	-	21024-4	WASHER, SPRG LOCK, REG NO 8	20
-	-	1	1	1	-	1-456468-4	STRIPPER, SPECIAL	19
△1	-	1	1	1	-	1633578-2	PLATE, REAR SHEAR	15
-	-	-	-	-	-	-	-	13
-	-	-	-	-	-	-	-	12
△1	-	1	1	1	-	1633579-2	BLADE, SLUG	10
-	-	-	-	-	-	-	-	9
△1	1	1	1	1	-	1633610-1	ANVIL, SPECIAL	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	-	1	1	1	-	4-240641-9	SPACER	5
-	-	1	1	1	-	3-238009-5	BLOCK, FL CRIMPER SPACER	4
△1	1	1	1	1	-	1633511-8	CRIMPER, INSULATION F	3
△1	1	1	1	1	-	455888-2	SPACER, CRIMPER	2
△1	1	1	1	1	-	2-1633305-2	CRIMPER, WIRE PREMIUM	1
-77	-3	-2	-1	U/M	PART NO	DESCRIPTION		ITEM NO

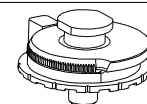
THIS DRAWING IS A CONTROLLED DOCUMENT FOR PROTECTING THE PROPRIETARY INFORMATION OF THE COMPANY. IT IS UNPUBLISHED. IT IS THE PROPERTY OF THE COMPANY. IT IS TO BE KEPT IN THE COMPANY'S POSSESSION. IT IS TO BE USED ONLY FOR THE PURPOSES FOR WHICH IT WAS ISSUED. IT IS TO BE RETURNED TO THE COMPANY WHEN NO LONGER NEEDED. IT IS TO BE DESTROYED WHEN NO LONGER NEEDED.				OWN				TE Connectivity			
DIMENSIONS:				R. KNEPPER				Harrisburg, PA 17105-3608			
INCHES				T. ELBIN				FINE ADJUST SIDE FEED			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				N. DEMING				HDM APPLICATOR			
0 PLC ±.001				PRODUCT SPEC				-			
1 PLC ±.01				APPLICATION SPEC				-			
2 PLC ±.01				WEIGHT				-			
3 PLC ±.001				CUSTOMER DRAWING				-			
4 PLC ±.0001				SCALE				3:5			
ANGLES ±				SHEET				1 OF 2			
MATERIAL				REV				B1			
FINISH				CUSTOMER DRAWING				-			

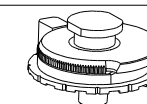


LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66		-	SEE SHEET 1	-	-	-

TERMINAL NAME: RK® Crimp Terminal					
TE P/N	MOLEX P/N	MOLEX TERMINAL - MOLEX CRIMP SPECS			
286698-1	08-50-0113				
286698-2	08-55-0101	CRIMP HEIGHT		WIRE SIZE	REF SETTING
286698-3	08-56-0109	.032±.001[0.81±0.03mm]		22AWG or 0.35mm ²	B8
-	-	.030±.001[0.76±0.03mm]		24AWG or 0.20mm ²	C2
-	-	.029±.001[0.74±0.03mm]		26AWG or 0.12mm ²	C2
-	-	.028±.001[0.71±0.03mm]		28AWG or 0.08mm ²	C4
-	-	.027±.001[0.69±0.03mm]		30AWG or 0.05mm ²	C6
-	-	CRIMP	SIZE	TYPE	RANGE
-	-				
-	-	WIRE	.054 [1.37mm]	F	30-22AWG[0.05-0.35mm ²]
-	-	INSUL	.077 [1.96mm]	F	Ø.043-.062[1.09-1.57mm]
WIRE STRIP LENGTH .100 - .125 [2.54-3.18mm]	TERM APPL SPEC NONE	FEED .900 [5.08mm]	APPLICATOR INSTRUCTIONS 408-8040		SET UP GAGE 458637-1

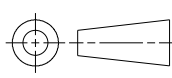
TERMINAL NAME: K® Crimp Terminal					
TE P/N	MOLEX P/N	MOLEX TERMINAL - MOLEX CRIMP SPECS			
1949741-1	08-70-0048				
1949741-2	08-70-0064	CRIMP HEIGHT		WIRE SIZE	REF SETTING
-	-	.032±.001[0.81±0.03mm]		22AWG or 0.35mm ²	B8
-	-	.030±.001[0.76±0.03mm]		24AWG or 0.20mm ²	C2
-	-	.028±.001[0.71±0.03mm]		26AWG or 0.12mm ²	C4
-	-	.027±.001[0.69±0.03mm]		28AWG or 0.08mm ²	C6
-	-	CRIMP	SIZE	TYPE	RANGE
-	-				
-	-	WIRE	.054 [1.37mm]	F	28-22AWG[0.08-0.35mm ²]
-	-	INSUL	.077 [1.96mm]	F	Ø.047-.067[1.20-1.70mm]
WIRE STRIP LENGTH .100 - .125 [2.54-3.18mm]	TERM APPL SPEC NONE	FEED .900 [5.08mm]	APPLICATOR INSTRUCTIONS 408-8040		SET UP GAGE 458637-1

TERMINAL NAME: KK® Crimp Terminal						
TE P/N	MOLEX P/N	MOLEX TERMINAL - MOLEX CRIMP SPECS				
286698-4	08-52-0101					
286698-5	08-65-0815	CRIMP HEIGHT		WIRE SIZE		REF SETTING
286698-6	08-65-0813	.032±.001[0.81±0.03mm]		22AWG or 0.35mm ²		B8
286698-9	08-70-0046	.030±.001[0.76±0.03mm]		24AWG or 0.20mm ²		C2
I-286698-0	08-52-0118	.028±.001[0.71±0.03mm]		26AWG or 0.12mm ²		C4
I-286698-1	08-52-0121	.027±.001[0.69±0.03mm]		28AWG or 0.08mm ²		C6
I-286698-2	08-50-0321	.0255±.0005[0.645±0.015]		30AWG or 0.05mm ²		C9
I-286698-3	08-65-0804	CRIMP	SIZE	TYPE	RANGE	
I-286698-4	08-65-0801					
I-286698-5	08-65-0811	WIRE	.054 [1.37mm]	F	30-22AWG[0.05-0.35mm ²]	
I-286698-6	08-65-0817	INSUL	.077 [1.96mm]	F	Ø.043-.062[1.09-1.57mm]	
I-286698-7	40-07-0815					
I-286698-8	97-00-0920					
WIRE STRIP LENGTH .100 - .125 [2.54-3.18mm]	TERM APPL SPEC NONE	FEED .900 [5.08mm]	APPLICATOR INSTRUCTIONS 408-8040		SET UP GAGE 458637-1	

TERMINAL NAME: KK® Crimp Terminal					
TE P/N	MOLEX P/N	MOLEX TERMINAL - MOLEX CRIMP SPECS			
286698-7	97-00-0444				
-	-	CRIMP HEIGHT		WIRE SIZE	REF SETTING
-	-	.032±.001[0.81±0.03mm]		22AWG or 0.35mm ²	B8
-	-	.030±.001[0.76±0.03mm]		24AWG or 0.20mm ²	C2
-	-	.028±.001[0.71±0.03mm]		26AWG or 0.12mm ²	C4
-	-	.027±.001[0.69±0.03mm]		28AWG or 0.08mm ²	C6
-	-	.0255±.0005[0.645±0.015]		30AWG or 0.05mm ²	C9
-	-	CRIMP	SIZE	TYPE	RANGE
-	-				
-	-	WIRE	.054 [1.37mm]	F	30-22AWG[0.05-0.35mm ²]
-	-	INSUL	.077 [1.96mm]	F	Ø.043-.062[1.09-1.57mm]
WIRE STRIP LENGTH .100 - .125 (2.54-3.18mm)	TERM APPL SPEC NONE	FEED .900 (5.08mm)	APPLICATOR INSTRUCTIONS 408-8040		SET UP GAGE 458637-1

THIS DRAWING IS A CONTROLLED DOCUMENT FOR PROTECTIVE INFORMATION
IT IS UNPUBLISHED AND NOT TO BE RELEASED FOR THE LATEST REVISION.

DIMENSIONS:
INCHES



MATERIAL
-

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±.
1 PLC ±0.1
2 PLC ±0.01
3 PLC ±0.001
4 PLC ±0.0001
ANGLES ±.

FINISH
-

DWN
R. KNEPPER 02JUL2007
CHW
T. ELBIN 16JAN2008
APVD
N. DEMING 16JAN2008

PRODUCT SPEC
APPLICATION SPEC
WEIGHT
-

CUSTOMER DRAWING

TE Connectivity
Harrisburg, PA 17105-3608

NAME
FINE ADJUST SIDE FEED
HDM APPLICATOR
-

SIZE
A

CAGE CODE
00779

DRAWING NO
C=1855289

RESTRICTED TO
-

SCALE
3:5

SHEET
2

OF
2

REV
B1

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

[TE Connectivity:](#)

[1855289-1](#)