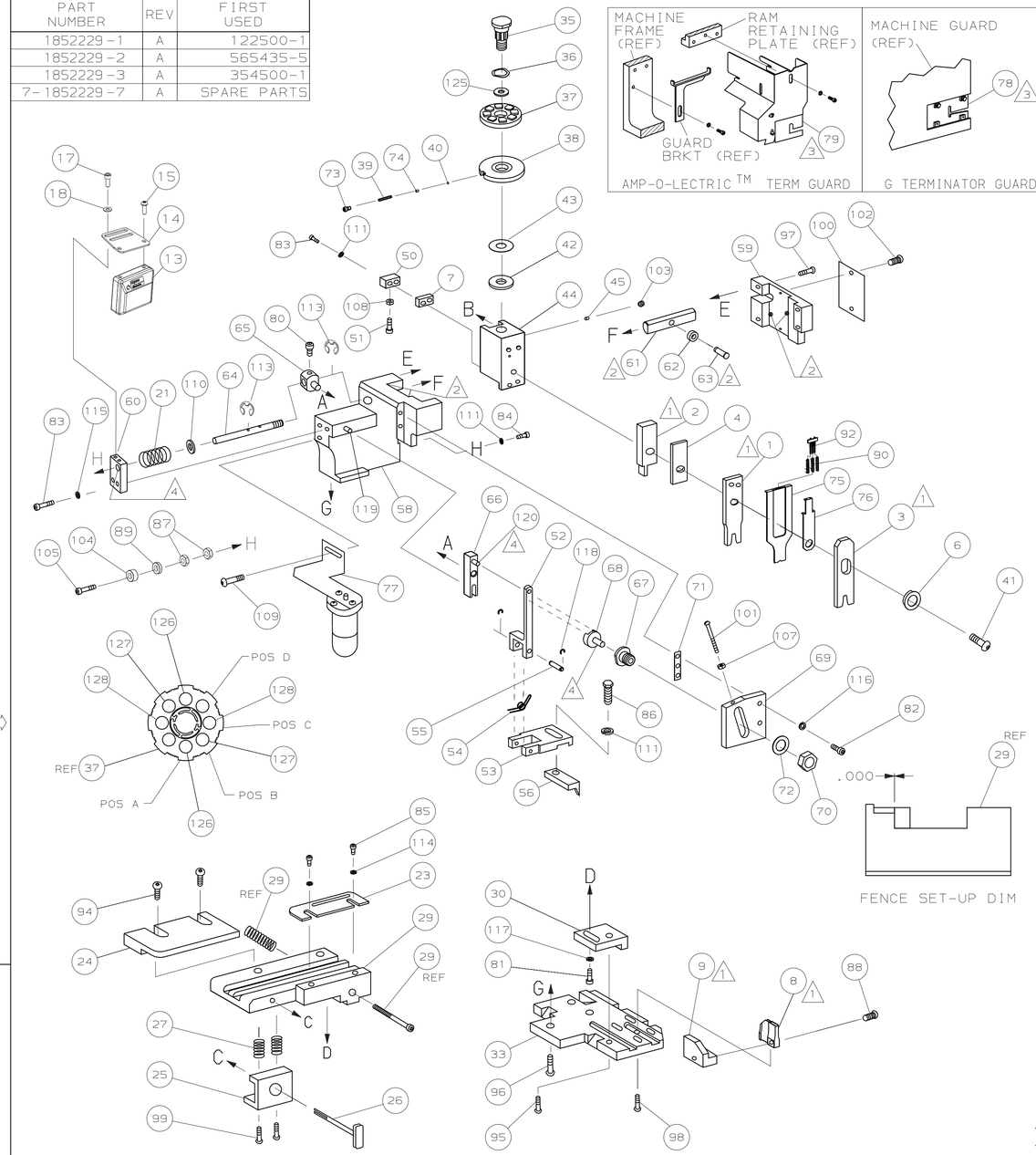
DRAWING MADE IN THIRD ANGLE PROJECTION

1852229 ⇔ 1852229

/home/us024474/tecmod

| PART NUMBER | REV | FIRST USED |
|---|---|---|
| 1852229-1 | A | 122500-1 |
| 1852229-2 | A | 565435-5 |
| 1852229-3 | A | 354500-1 |
| 7-1852229-7 | A | SPARE PARTS |




TERMINAL NAME: CRIMP TERMINAL PIN & SOCKET

| AMP TERM PN | MFR TERM PN |
|---|---|
| PIN | |
| 1949000-1 | 18-12-2601 |
| 1949000-2 | 18-12-1607 |
| SOCKET | |
| 1949036-1 | 18-12-1601 |
| 1949036-2 | 018-12-1603 |

MOLEX TERMINAL — MOLEX CRIMP SPECS

| PAD LTR | CRIMP HEIGHT | WIRE SIZE |
|---|---|---|
| A | .083 ±.002 [2.11 ±0.05mm] | 10 |
| B | .080 ±.002 [2.03 ±0.05mm] | 12 |
| C | .073 ±.002 [1.85 ±0.05mm] | 14 |
| D | NOT | USED |

| CRIMP | SIZE | TYPE | RANGE |
|---|---|---|---|
| WIRE | .148 [3.76mm] | F | 14-10 |
| INSUL | .200 [5.08mm] | F | ø.180 MAX |

| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPL INSTRUCTION | SET UP GAGE | LAYOUT |
|---|---|---|---|---|---|
| .160-.220 | NONE | .645 | 408-8040 | 458637-1 | L4038 |

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

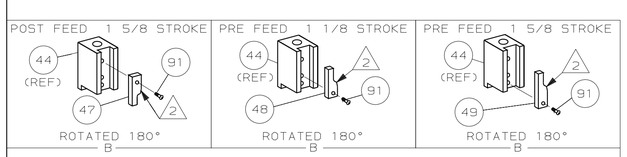
-77 SPARE PARTS KIT

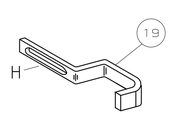
| -77 | -3 | -2 | -1 | U/M | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|---|---|---|---|
| | | | | | | | 129 |
| - | 2 | 2 | 2 | - | 354779-4 | PIN, WIRE DISC (.3010)C | 128 |
| - | 2 | 2 | 2 | - | 8-354778-9 | PIN, WIRE DISC (.2940)B | 127 |
| - | 2 | 2 | 2 | - | 8-354778-3 | PIN, WIRE DISC (.2910)A | 126 |
| - | 1 | 1 | 1 | - | 986950-1 | WASHER, FLAT PRECISION | 125 |
| - | 1 | 1 | 1 | - | 217238-1 | GENERAL INSTRUCTION PACKAGE | 124 |
| - | 1 | 1 | 1 | - | 4088040 | SF APPL INST 408-8040 | 123 |
| | | | | | | | 122 |
| | | | | | | | 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 |
| - | REF | REF | REF | - | 21045-3 | RING,RET "C"(ø.187)FD FING PIN | 118 |
| - | 3 | 3 | 3 | - | 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 |
| - | REF | REF | REF | - | 1-21046-6 | RING,RET E (5/16)ADJ ROD | 113 |
| | | | | | | | 112 |
| - | 4 | 4 | 4 | - | 21024-4 | WASHER,LOCK(#8)STRIPPER | 111 |
| - | REF | REF | REF | - | 21899-4 | WASHER,FLAT(ø5/16)SCREW ADJ | 110 |
| - | - | 1 | - | - | 2-21002-6 | SCR,BHC(10-32x.38)LUBE ASSY | 109 |
| - | 1 | 1 | 1 | - | 21018-5 | NUT,HEX(6-32) | 108 |
| - | REF | REF | REF | - | 21068-5 | NUT,HEX(6-32)FEED ADJ | 107 |
| | | | | | | | 106 |
| - | REF | REF | REF | - | 3-21081-3 | SCR,SHC (1/4-20X1.25)COUNTER | 105 |
| - | REF | REF | REF | - | 1804299-1 | SPACER, MAGNET | 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,SKT 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 |
| - | 2 | 2 | 2 | - | 2-21002-2 | SCR,BHC(8-32x.50)TERM H DWN | 94 |
| | | | | | | | 93 |
| - | 1 | 1 | 1 | - | 1424350-1 | HOLDER, PIN, WIRED | 92 |
| - | 1 | 1 | 1 | - | 1-21002-7 | SCR,BHC(6-32x.38)CAM | 91 |
| - | 3 | 3 | 3 | - | 2-23147-2 | SPRING, DEPRESSOR | 90 |
| - | REF | REF | REF | - | 1804310-1 | MAGNET, RING | 89 |
| - | 1 | 1 | 1 | - | 2-21000-7 | SCR,SHC(8-32x.88)SHEAR | 88 |
| - | REF | REF | REF | - | 22593-1 | NUT,HEX JAM(1/4-20)COUNTER | 87 |
| - | 1 | 1 | 1 | - | 2-22603-1 | SCR,HEX HD(8-32x.38)FEED FINGER | 86 |
| - | 2 | 2 | 2 | - | 1-21000-5 | SCR,SHC(4-40x.50)FR ST GUIDE | 85 |
| - | 1 | 1 | 1 | - | 2-21000-7 | SCR,SHC(8-32x.50)STRIPPER | 84 |
| - | 2 | 2 | 2 | - | 2-21000-8 | SCR,SHC(8-32x.62)HOLDDOWN | 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 |
| - | - | 1 | - | - | 462992-7 | GUARD ASSY | 79 |
| - | REF | - | - | - | 679532-1 | INSERT, GUARD | 78 |
| - | - | 1 | - | - | 1-465184-0 | LUBRICATOR ASSY | 77 |
| - | 1 | 1 | 1 | - | 1490524-1 | SPACER, DEPRESSOR | 76 |
| - | 1 | 1 | 1 | - | 1490525-3 | DEPRESSOR, WIRE | 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 | - | 1804311-1 | 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 | - | 1804305-2 | GUIDE, FEED ROD | 60 |
| - | 1 | 1 | 1 | - | 454220-1 | CAP, RAM | 59 |
| - | REF | REF | REF | - | 454485-1 | HOUSING | 58 |
| | | | | | | | 57 |
| - | 1 | 1 | 1 | - | 2-694433-9 | 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 | - | 455673-8 | RAM | 44 |
| - | 1 | 1 | 1 | - | 690125-1 | WASHER, LAMINATED | 43 |
| - | 1 | 1 | 1 | - | 690124-1 | WASHER, RAM | 42 |
| - | 1 | 1 | 1 | - | 690686-2 | BOLT, CRIMPER(5/16x1.10) | 41 |
| - | 1 | 1 | 1 | - | 23241-6 | BALL, STEEL | 40 |
| - | 1 | 1 | 1 | - | 690170-1 | SPRING, COMPRESSION | 39 |
| - | 1 | 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 |
| | | | | | | | 34 |
| - | REF | REF | REF | - | 455675-1 | PLATE, BASE | 33 |
| | | | | | | | 32 |
| | | | | | | | 31 |
| - | REF | REF | REF | - | 455689-1 | BLOCK, STRIP GUIDE ADJ | 30 |
| - | 1 | 1 | 1 | - | 1-318756-4 | PLATE, STRIP GUIDE | 29 |
| | | | | | | | 28 |
| - | 2 | 2 | 2 | - | 22281-9 | SPRING, DRAG | 27 |
| - | 1 | 1 | 1 | - | 690546-1 | LEVER, DRAG RELEASE | 26 |
| - | 1 | 1 | 1 | - | 2-690754-1 | DRAG, TERMINAL | 25 |
| - | 1 | 1 | 1 | - | 1-1320860-4 | GUIDE, STRIP (REAR) | 24 |
| - | 1 | 1 | 1 | - | 2-690712-1 | GUIDE, STRIP (FRONT) | 23 |
| | | | | | | | 22 |
| - | REF | REF | REF | - | 4-22284-9 | SPRING, FEED RETURN | 21 |
| | | | | | | | 20 |
| - | 1 | 1 | 1 | - | 1-458230-5 | STRIPPER | 19 |
| - | REF | REF | REF | - | 18028-2 | WASHER, FLAT (M4)COUNTER | 18 |
| - | REF | REF | REF | - | 9-21000-9 | SCR,SHC(8-32X.44)COUNTER | 17 |
| | | | | | | | 16 |
| - | REF | REF | REF | - | 994991-5 | SCR,OVAL HD(M4X12)COUNTER | 15 |
| - | REF | REF | REF | - | 1804303-1 | BRACKET, COUNTER MTG | 14 |
| - | REF | REF | REF | - | 1804300-1 | APPLICATOR COUNTER ASSY | 13 |
| | | | | | | | 12 |
| | | | | | | | 11 |
| | | | | | | | 10 |
| - | 1 | 1 | 1 | - | 3-853714-2 | PLATE, REAR SHEAR | 9 |
| 1 | 1 | 1 | 1 | - | 1901674-1 | ANVIL | 8 |
| - | 1 | 1 | 1 | - | 240641-7 | SPACER, DEPRESSOR (REAR) | 7 |
| - | 1 | 1 | 1 | - | 238009-1 | SPACER, BLOCK CRIMPER | 6 |
| | | | | | | | 5 |
| - | 1 | 1 | 1 | - | 455888-5 | SPACER, CRIMPER | 4 |
| 1 | 1 | 1 | 1 | - | 3-1213077-2 | CRIMPER, INSULATION | 3 |
| - | 1 | 1 | 1 | - | 2-853720-1 | BLADE, SLUG | 2 |
| 1 | 1 | 1 | 1 | - | 6-1633305-2 | CRIMPER, WIRE | 1 |
| QTY REQD PER ASSY | | | | | PARTS LIST | | |

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

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.



BENCH MACHINE LEADMAKER

| P | F | LTR | REVISION RECORD | APP | DATE |
|---|---|---|---|---|---|
| | | A | RELEASED | RK | JUN06 |

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±.25 3 PLC DEC ±.020 4 PLC DEC ±- ANGLES ± - SURF TEXTURE: √ REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL – HT TR – FIN –

DR 23MAY06 C.ERISMAN APP 23MAY06 T.ELBIN

CHK 23MAY06 C.ERISMAN REL 16JUN06 R.KNEPPER

AMP Incorporated Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL

SCALE – D DWG NO 1852229 SHEET 1 OF 1 REV A

CAGE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING RESTRICTED TO –

LOC A DIST 66

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AMP 1756 REV 3-92 16-JUN-06 11:12:50 us024474

# Mouser Electronics

Authorized Distributor

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TE Connectivity:

1852229-1