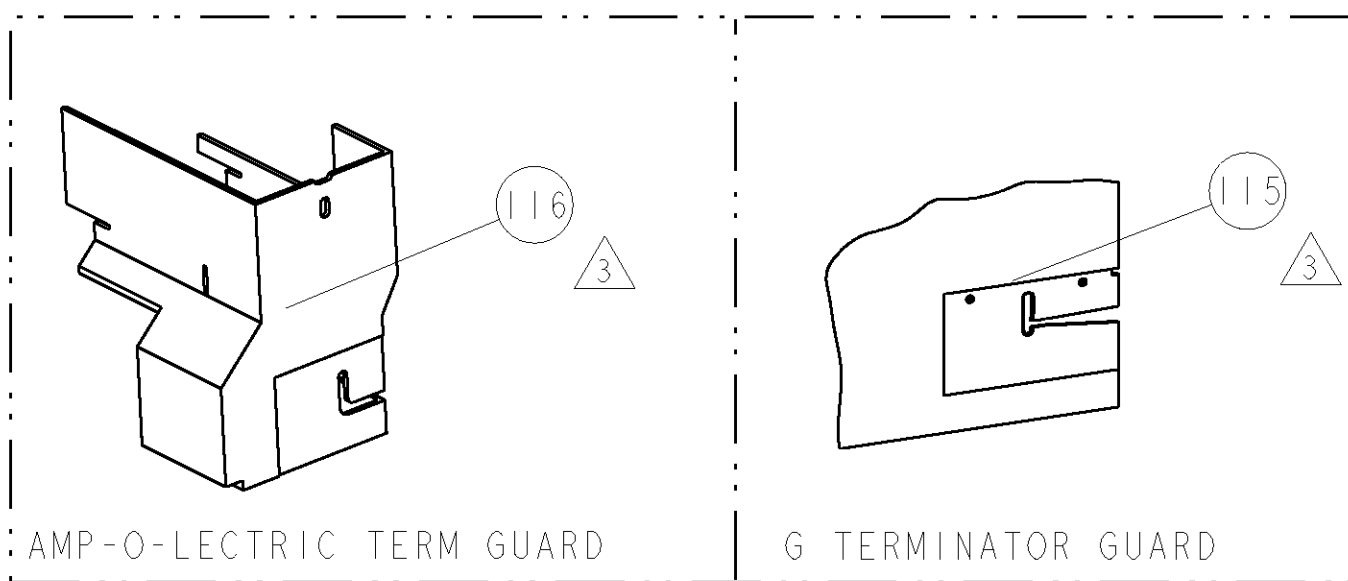


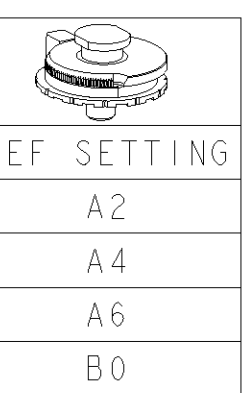
8				7			
THIS DRAWING IS UNPUBLISHED.				RELEASED FOR PUBLICATION			
20				20			
© COPYRIGHT 20				BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER		REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION	
1855400-1		A	122500-1	LEADMAKER	POST FEED	CUTS CARRIER	
1855400-2		A	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER	
1855400-3		A	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER	
1855400-6		A	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER	
7-1855400-7		A	-	-	-	SPARE PARTS	

- △ RECOMMENDED SPARE PARTS
- △ GREASE LIGHTLY
- △ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE

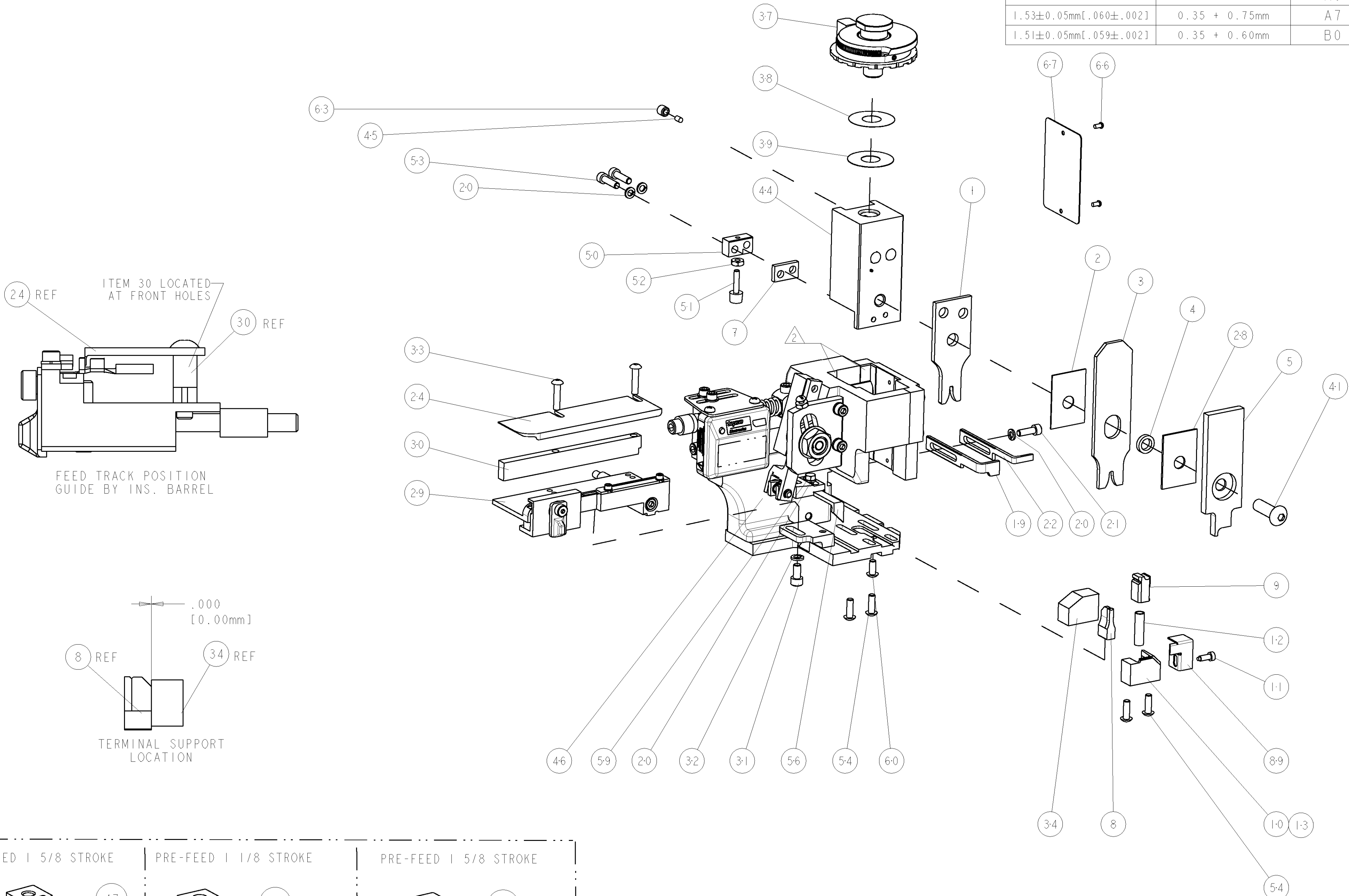
*** WARNING**
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN. REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



TERMINAL NAME: 1.5 X 0.8 FEMALE SICMA 2 TERMINAL					
TE PN	MANF PN	FCI TERMINAL - FCI CRIMP SPECS			
1949410-1	211CC252120				
-	-	CRIMP HEIGHT		WIRE SIZE	
-	-	1.61mm+.04/-.04[.063+.002/-.002]		14AWG or 2mm2	
-	-	1.58mm+.04/-.04[.062+.002/-.002]		16AWG or 1.5mm2	
-	-	1.56mm+.04/-.04[.061+.002/-.002]		18AWG or 1.4mm2	
-	-	1.51mm+.04/-.04[.059+.002/-.002]		20AWG or 1mm2	
-	-	CRIMP	SIZE	TYPE	RANGE
-	-	WIRE	2.25mm [.089]	F	14-16 AWG
-	-	INSUL	3.15mm [.124]	OV	Ø 2.450 MAX
WIRE STRIP LENGTH 4.200-4.500		TERM APPL SPEC -	FEED 15.200	APPLICATOR INSTRUCTIONS 408-8040	
				SET UP GAGE 458637-1	



ADDITIONAL CRIMP HEIGHTS		
CRIMP HEIGHT	WIRE SIZE	REF SETTING
1.57±0.05mm[.062±.002]	0.75 + 0.75mm	A4
1.54±0.05mm[.061±.002]	0.60 + 0.60mm	A6
1.57±0.05mm[.062±.002]	0.50 + 1.0mm	A5
1.55±0.05mm[.061±.002]	0.50 + 0.75mm	A6
1.52±0.05mm[.060±.002]	0.50 + 0.50mm	B0
1.55±0.05mm[.061±.002]	0.35 + 1.00mm	A6
1.53±0.05mm[.060±.002]	0.35 + 0.75mm	A7
1.51±0.05mm[.059±.002]	0.35 + 0.60mm	B0



3	-	-	-	REF	-	..	455749-1	GUARD WINDOW	116
3	-	-	REF	-	-	..	679532-1	INSERT, GUARD	115
-	-	-	-	-	-	..	1-21002-7	SCR, BTN SKT HD CAP 6-32 X .375	91
-	-	-	-	-	-	..	318563-1	GUARD, FRONT CHIP	89
-	-	-	-	-	-	..	4088040	SF APPL INST 408-8040	72
-	-	-	-	-	-	..	217238-1	GENERAL INSTRUCTION PKG	71
-	-	-	-	-	-	..	461264-5	PLATE, IDENTIFICATION	67
-	-	-	-	-	-	..	21017-2	SCREW, DRIVE	66
-	-	-	-	-	-	..	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	63
-	-	-	-	-	-	..	22733-8	SCR, BHSC, SELF-LOCKING, 8-32 X .375	60
-	-	-	-	-	-	..	2-22603-0	SCR, HEX HD CAP 8-32 X .312	59
-	-	-	-	-	-	..	458537-2	PAWL, FEED	56
-	-	-	-	-	-	..	2-21002-2	SCR, BTN SKT HD CAP 8-32 X .500	54
-	-	-	-	-	-	..	2-21000-8	SCR, SKT HD CAP 8-32 X .625	53
-	-	-	-	-	-	..	21018-5	NUT, HEX, REG 6-32	52
-	-	-	-	-	-	..	811242-2	BUMPER, HOLD DOWN	51
-	-	-	-	-	-	..	690753-1	SPACER, TONKER	50
-	-	-	-	-	-	..	690602-6	CAM, PRE FEED, 1 5/8	49
-	-	-	-	-	-	..	690602-5	CAM, PRE FEED, 1 1/8	48
-	-	-	-	-	-	..	690501-4	CAM, POST FEED, 1 5/8	47
-	-	-	-	-	-	..	459456-1	APPL. BASIC SUB ASSY (SIDE WISE MQCA)	46
-	-	-	-	-	-	..	690191-1	PLUG, NYLON	45
-	-	-	-	-	-	..	455673-1	RAM, SIDE FEED	44
-	-	-	-	-	-	..	7-21002-9	SCR, BTN SKT HD CAP 5/16-24 X 1.00	41
-	-	-	-	-	-	..	690125-1	SHIM SUB-ASSY	39
-	-	-	-	-	-	..	469367-2	SHIM	38
-	-	-	-	-	-	..	879103-2	FINE ADJUST HEAD ASSEMBLY	37
-	-	-	-	-	-	..	3-690786-5	TERMINAL SUPPORT	34
-	-	-	-	-	-	..	2-21002-4	SCR, BTN SKT HD CAP 8-32 X .750	33
-	-	-	-	-	-	..	21024-5	WASHER, SPRG LOCK, REG NO 10	32
-	-	-	-	-	-	..	3-21000-4	SCR, SKT HD CAP 10-32 X .375	31
-	-	-	-	-	-	..	1320908-1	SPACER, STRIP GUIDE	30
-	-	-	-	-	-	..	1633091-1	ASSEMBLY, STRIP GUIDE	29
-	-	-	-	-	-	..	1-455888-0	SPACER, CRIMPER	28
-	-	-	-	-	-	..	1320928-1	PLATE, STRIP GUIDE	24
-	-	-	-	-	-	..	690472-2	STRIPPER	22
-	-	-	-	-	-	..	2-21000-7	SCR, SKT HD CAP 8-32 X .500	21
-	-	-	-	-	-	..	21024-4	WASHER, SPRG LOCK, REG NO 8	20
-	-	-	-	-	-	..	691353-1	STRIPPER	19
△	-	-	-	-	-	..	679625-1	SHEAR HOLDER, FRONT (NO CUT)	13
△	-	-	-	-	-	..	3-22280-3	SPRING, COMPRESSION	12
△	-	-	-	-	-	..	690461-1	STOP, SHEAR	11
△	-	-	-	-	-	..	690459-1	SHEAR HOLDER, FRONT	10
△	-	-	-	-	-	..	462006-1	FLOATING SHEAR, FRONT	9
△	-	-	-	-	-	..	7-1633535-3	ANVIL, COMBINATION	8
△	-	-	-	-	-	..	240641-5	SPACER	7
△	-	-	-	-	-	..	-	-	6
△	-	-	-	-	-	..	2-455889-0	DEPRESSOR, SHEAR	5
△	-	-	-	-	-	..	238011-9	BLOCK, CRIMPER SPACER	4
△	-	-	-	-	-	..	9-854830-0	CRIMPER, INSULATION SPECIAL	3
△	-	-	-	-	-	..	455888-5	SPACER, CRIMPER	2
△	-	-	-	-	-	..	4-1673600-0	CRIMPER, WIRE	1
-	-	-	-	-	-	U/M	PART NO	DESCRIPTION	ITEM NO

THIS IS A CUSTOMER DRAWING. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED FOR THE CUSTOMER'S INTERNAL USE ONLY. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION. SHOULD BE CONSIDERED FOR THE LATEST EDITION.		DWN C. REICHELDERFER 12MAY2008	Tyco Electronics Harrisburg, PA 17105-3608	
DIMENSIONS: INCHES		APVD N. DEMING 12MAY2008	NAME FINE ADJUST SIDE FEED HDM APPLICATOR	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 9 PLC ±.01 1 PLC ±.01 3 PLC ±.01 4 PLC ±.0001 ANGLES ±.0001		PRODUCT SPEC APPLICATION SPEC	SIZE A1	
MATERIAL -		WEIGHT -	CAGE CODE 00779	
FINISH -		CUSTOMER DRAWING	SCALE 3:5	
			SHEET 1 OF 1	
			REV A	

CUSTOMER VIEWABLE ASSEMBLY

Mouser Electronics

Authorized Distributor

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

[TE Connectivity:](#)

[1855400-3](#)