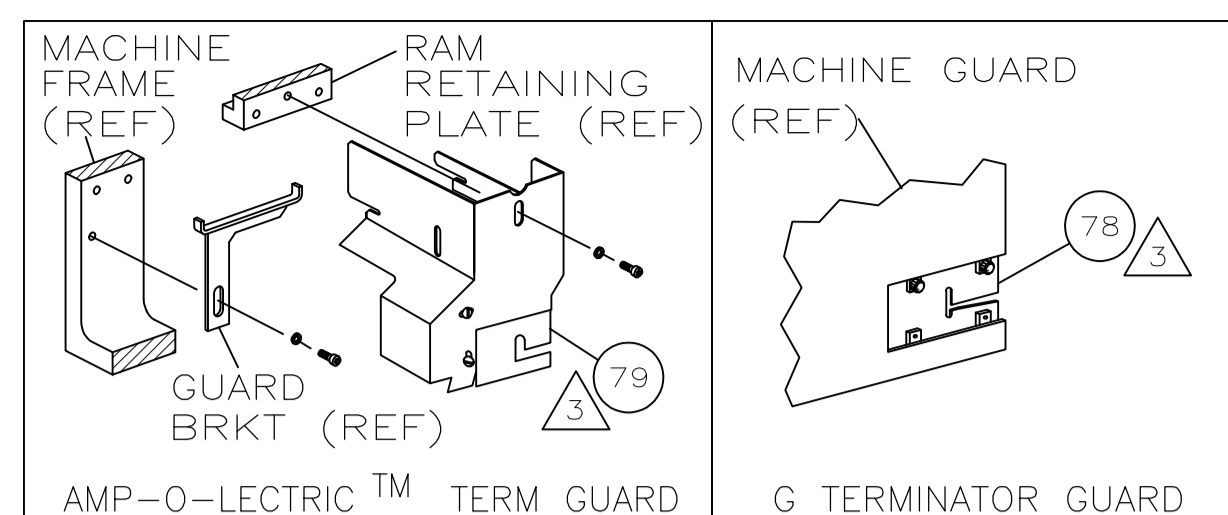


PART NUMBER	REV	FIRST USED
1855122-1	A	122500-1
1855122-2	A	565435-5
1855122-3	A	354500-1
1855122-6	A	122500-1
7-1855122-7	A	-



TERMINAL NAME: JUMBO PV RECEPTAL R/A FOR .040/1.02 PIN					
1448272-1 CRIMP DATA (NON-AMP TERMINAL-CUST SPEC)					
REF SETTING	CRIMP HEIGHT	WIRE SIZE			
B8	.047 ±.001 [1.19 ±0.05mm]	18			
C5	.043 ±.001 [1.09 ±0.05mm]	20			
-	NOT	USED			
-	NOT	USED			
CRIMP	SIZE	TYPE	RANGE		
WIRE	.070 [1.78mm]	F	20-18		
INSUL	.110 [2.79mm]	0	.042-.103		
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.148-.168	NONE	.600	408-8040	458637-1	L2520

-1	LEADMAKER	MECH POST FEED	-6	LEADMAKER	NO CUT CARRIER	
-2	BENCH MODEL K	MECH PRE FEED	-77	SPARE TOOLING	-	
-3	BENCH MODEL G	MECH PRE FEED				

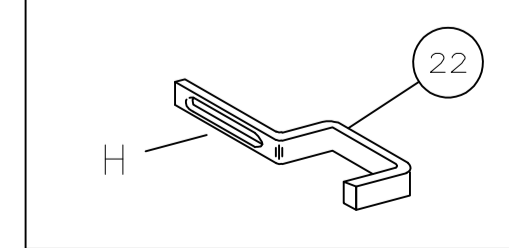
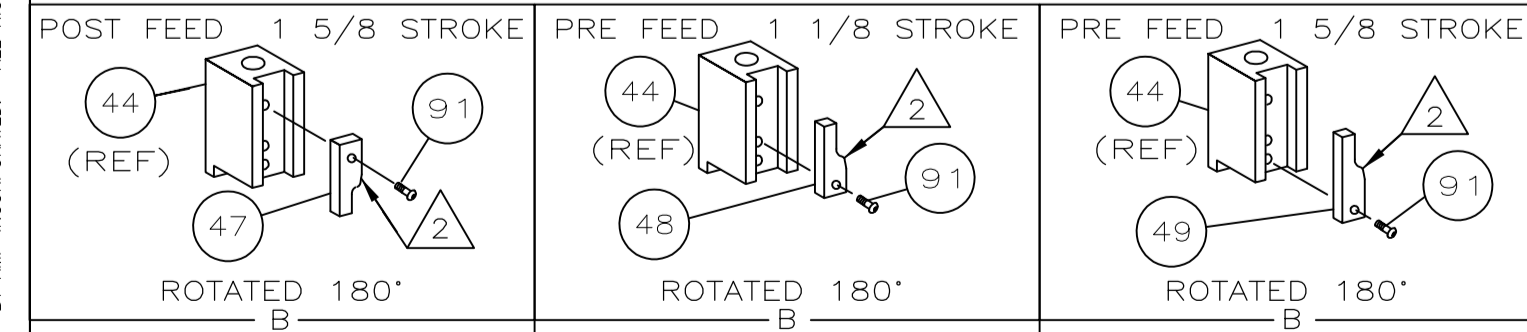
QTY	REQD PER ASSY	PARTS LIST	ITEM NO				
1	1	1	1	B	22594-8	NUT, HEX(1/2-20)	70
1	1	1	1	B	240628-1	PLATE, ADJUSTMENT	69
1	1	1	1	B	240626-1	SHAFT, PIVOT	68
1	1	1	1	B	240633-1	BUSHING	67
1	1	1	1	A	455680-1	LEVER, INTERMEDIATE	66
1	1	1	1	B	240629-1	BLOCK, PIVOT	65
1	1	1	1	A	1804311-1	SCREW, ADJ FEED ROD	64
1	1	1	1	B	240659-3	PIN, CAM ROLLER	63
1	1	1	1	B	240658-1	ROLLER, CAM	62
1	1	1	1	B	454398-2	ROD, FEED	61
1	1	1	1	A	1804305-2	GUIDE, FEED ROD	60
1	1	1	1	C	454220-1	CAP, RAM	59
1	1	1	1	D	454485-8	HOUSING	58
							57
1	1	1	1	B	458537-2	PAWL, FEED	56
1	1	1	1	B	240624-1	PIN, FEED FINGER	55
1	1	1	1	B	691499-1	SPRING, FEED FINGER	54
1	1	1	1	B	690541-1	HOLDER, FEED FINGER	53
1	1	1	1	A	455679-2	LEVER, TERMINAL FEED ARM	52
							51
							50
-	1	-	-	B	690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	-	1	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST	48
1	-	-	1	B	690501-4	CAM, POST-FEED 1 5/8 ST	47
							46
1	1	1	1	A	690191-1	PLUG, NYLON	45
1	1	1	1	C	455673-4	RAM	44
1	1	1	1	A	690125-1	SHIM SUB-ASSEMBLY	43
1	1	1	1	A	469367-9	SHIM	42
1	1	1	1	A	690686-1	BOLT, CRIMPER(5/16x1.00)	41
							40
							39
							38
1	1	1	1	B	879103-2	FINE ADJ. HEAD ASSY.	37
1	1	1	1	D	9-21000-9	SCR, SKT HD CAP 8-32	36
1	1	1	1	D	18028-2	WASHER FLAT REG 4M	35
1	1	1	1	D	1804300-1	ASSEMBLY COUNTER	34
1	1	1	1	D	1583361-1	PLATE, BASE	33
1	1	1	1	A	690432-3	SCREW, ADJUSTMENT	32
							31
1	1	1	1	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	1	C	3-455671-9	PLATE, STRIP GUIDE	29
							28
2	2	2	2	A	1-22284-0	SPRING, DRAG	27
1	1	1	1	B	690546-1	LEVER, DRAG RELEASE	26
1	1	1	1	B	240792-1	DRAG, TERMINAL	25
1	1	1	1	D	6-690504-6	GUIDE, STRIP (REAR)	24
1	1	1	1	A	690438-1	GUIDE, STRIP (FRONT)	23
1	1	1	1	A	1-458230-0	STRIPPER	22
1	1	1	1	A	4-22284-9	SPRING, FEED RETURN	21
							20
							19
1	1	1	1	C	455888-1	SPACER, FRONT SHEAR DEP	18
1	1	1	1	C	1-455889-4	DEPRESSOR, SHEAR (FRONT)	17
1	1	1	1	B	318563-1	GUARD, CHIP, FRONT	16
2	2	2	2	A	994991-5	SCR, OVL. HD, M4X12	15
1	1	1	1	A	1804303-1	BRACKET, MOUNTING	14
1	1	1	1	A	1424352-1	BLOCK, SHEAR	13
1	1	1	1	A	6-22279-4	SPRING, SHEAR	12
1	1	1	1	B	690461-1	STOP, SHEAR	11
1	1	1	1	C	468798-1	HOLDER, SHEAR (FRONT)	10
1	1	1	1	C	462006-3	SHEAR, FLOAT (FRONT)	9
1	1	1	1	C	1424351-1	ANVIL	8
1	1	1	1	A	1-853714-3	PLATE, REAR SHEAR	7
1	1	1	1	B	1-853720-0	BLADE, SLUG	6
1	1	1	1	B	455888-1	SPACER	5
1	1	1	1	B	1-238011-0	SPACER, BLOCK CRIMPER	4
1	1	1	1	C	6-683454-4	CRIMPER, INSULATION	3
1	1	1	1	C	455888-3	SPACER, CRIMPER	2
1	1	1	1	C	1424354-1	CRIMPER, WIRE	1

THIS DRAWING IS A CONTROLLED DOCUMENT.

QTY	REQD PER ASSY	PARTS LIST	ITEM NO				
			129				
			128				
			127				
			126				
1	1	1	1	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	1	1	-	4088040	SF APPL INST 408-8040	123
							122
1	1	1	1	A	3-21028-7	PIN,SLT SPR(Ø.093x.75)ST GDE PL	121
1	1	1	1	A	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	120
1	1	1	1	A	1-21030-6	PIN,DOWEL(Ø.187x1.25)HOUSING	119
2	2	2	2	A	21045-3	RING,RET "C"(Ø.187)FD FING PIN	118
1	1	1	1	A	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
2	2	2	2	A	21024-5	WASHER,LOCK(#10)ADJ PLATE	116
2	2	2	2	A	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115
2	2	2	2	A	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
2	2	2	2	A	1-21046-6	RING, RETAIN, 5/16 E-RING	113
							112
2	2	2	2	A	21024-4	WASHER,LOCK(#8)STRIPPER	111
							110
							109
							108
1	1	1	1	A	21068-5	NUT,HEX(6-32)FEED ADJ	107
							106
							105
							104
1	1	1	1	A	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
2	2	2	2	A	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
1	1	1	1	A	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
1	1	1	1	B	461264-5	PLATE, IDENTIFICATION	100
2	2	2	2	A	5-21006-6	SCR, SET (10-32x.75)DRAG	99
1	1	1	1	A	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
4	4	4	4	A	2-21002-9	SCR,BHC(10-32x.75)CAP	97
3	3	3	3	A	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
1	1	1	1	A	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
2	2	2	2	A	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
2	2	2	2	A	2-21002-1	SCR,BHC(8-32x.38)TERM H DWN	93
							92
1	1	1	1	A	1-21002-7	SCR,BHC(6-32x.38)CAM	91
							90
							89
							88
2	2	2	2	A	1-21000-3	SCR, SHC 4-40x .25	87
1	1	1	1	A	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
1	1	1	1	A	2-21000-8	SCR,SHC(8-32x.62)SHEAR	85
1	1	1	1	A	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
2	2	2	2	A	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
2	2	2	2	A	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	82
1	1	1	1	A	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
1	1	1	1	A	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	80
-	-	1	-	B	455749-1	GUARD, WINDOW	79
-	REF	-	-	B	679532-1	INSERT, GUARD	78
2	2	2	2	A	22593-1	NUT, HEX, JAM SS	77
1	1	1	1	A	1804310-1	MAGNET RING	76
							75
1	1	1	1	A	1804299-1	SPACER, MAGNET	74
2	2	2	2	A	3-21081-3	SHCS, 1/4-20 X 1.25	73
1	1	1	1	A	458109-1	WASHER, SPECIAL	72
1	1	1	1	A	690517-1	SPACER	71

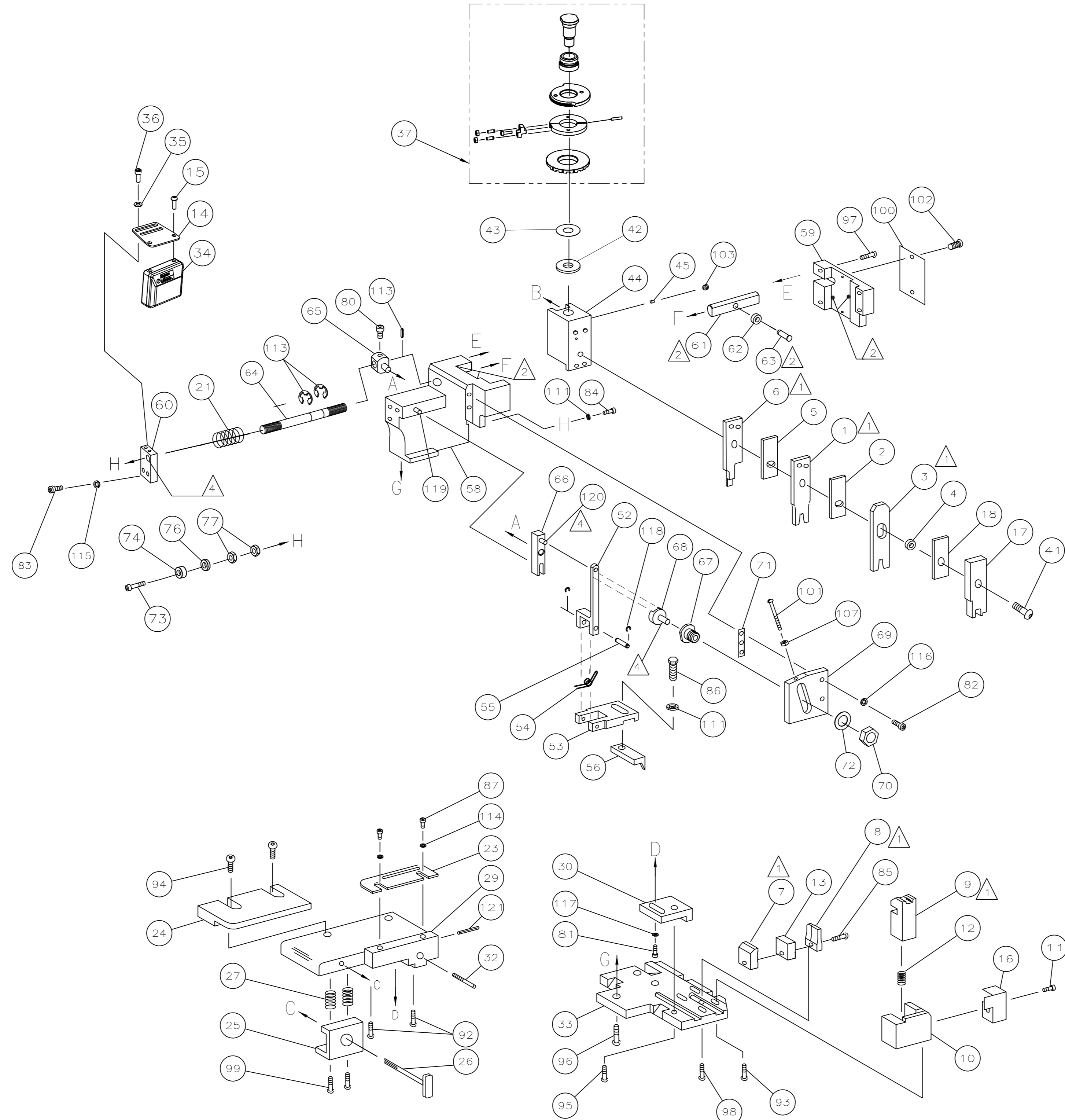
- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 4 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
- 6 CUT TO LENGTH AT ASSY

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



LOC	A
DIST	66

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATL	HT TR	FIN
2 PLC DEC ±				
3 PLC DEC ±				
4 PLC DEC ±				
ANGLES ±				
SURF TEXTURE:	✓			
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX				
DR 29AUG06	APP 29AUG06	AMP Incorporated Harrisburg, PA 17105-3608		
C.REICHELDERFER	T.ELBIN	MACHINE REF MINI APPL		
CHK 29AUG06	REL	SCALE		
C.REICHELDERFER		DWG NO 1855122		
NAME SIDE FEED HDM FINE ADJUST		SHEET 1 OF 2		
REVISION RECORD		REV A		
CAGE CODE 00779		CUSTOMER AND ASSEMBLY DRAWING		



LOC  
 A  
 DIST  
 66

P	LTR	REVISION RECORD	DATE	DWN	APVD
		SEE SHEET 1			

FINISH	-	DWN	C.REICHELDERFER	27SEP06	MATERIAL	-	HEAT TREAT	-
DIMENSIONS:	IN	TOLERANCES UNLESS OTHERWISE SPECIFIED:						
		0 PLC	±					
		1 PLC	±.02					
		2 PLC	±.005					
		3 PLC	±.0005					
		4 PLC	±.0005					
ANGLS	± 0° 30'							
SURFACE TEXTURE	125							
CAGE CODE	00779	CUSTOMER AND ASSEMBLY DRAWING					RESTRICTED TO	

AMP Tyco Electronics  
 Harrisburg, PA 17105-3608

NAME: T.ELBIN  
 SIDE FEED HDM FINE ADJUST

SCALE: 1:1 SIZE: A1 DRAWING NO: 1855122 SHEET 2 OF 2 REV A

# Mouser Electronics

Authorized Distributor

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[TE Connectivity:](#)

[1855122-3](#)