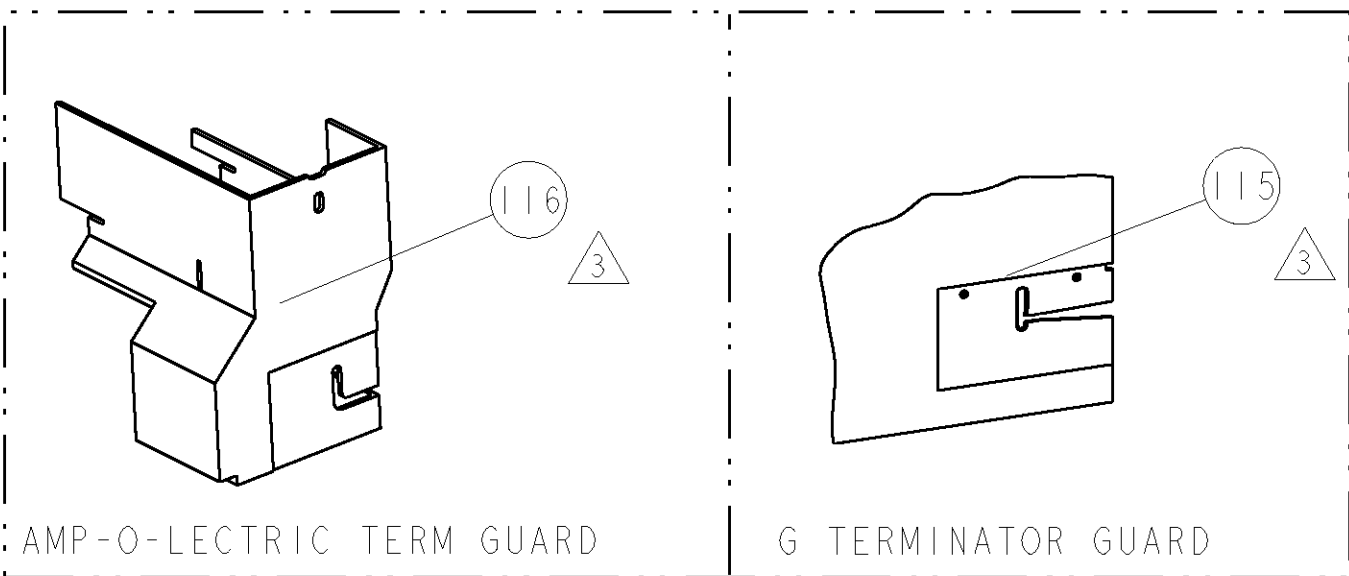


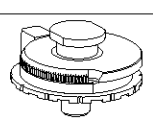
8				7			
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PART NUMBER		REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION	
1855370-1		A	122500-1	LEADMAKER	POST FEED	CUTS CARRIER	
1855370-2		A	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER	
1855370-3		A	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER	
1855370-6		A	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER	
7-1855370-7		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: RECEPTACLE, MOLEX					
TE PN	1949602-1	MOLEX TERMINAL - FORD CRIMP SPECS			
MOLEX PN	33044-0003				
FORD PN	XL3T-14474-HA	CRIMP HEIGHT		WIRE SIZE	REF SETTING
-	-	1.90mm+.05/- .05[.075+ .002/- .002]		14AWG	C0
-	-	1.80mm+.05/- .05[.071+ .002/- .002]		16AWG	C4
-	-			-	-
-	-			-	-
-	-	CRIMP	SIZE	TYPE	RANGE
-	-	WIRE	2.79mm [.110]	F	16-14 AWG
-	-	INSUL	3.05mm [.120]	F	Ø2.794 MAX
WIRE STRIP LENGTH 4.661-5.042	TERM APPL SPEC FORD	FEED 18.593	APPLICATOR INSTRUCTIONS 408-8040		SET UP GAGE 458637-1



REF SETTING

LOC		DIST		REVISONS			
A		66		P	LTR	DESCRIPTION	DATE
				A		RELEASED	20FEB2008
							MEH
							TE

3	-	-	-	REF	-	..	455749-1	GUARD WINDOW	116
	-	-	REF	-	-	..	679532-1	INSERT, GUARD	115
	-	1	1	1	1	-	1-21002-7	SCR, BTN SKT HD CAP 6-32 X .375	91
-	1	1	1	1	1	-	318563-1	GUARD, FRONT CHIP	89
-	1	1	1	1	1	-	4088040	SF APPL INST 408-8040	72
-	1	1	1	1	1	-	217238-1	GENERAL INSTRUCTION PKG	71
-	1	1	1	1	1	-	461264-5	PLATE, IDENTIFICATION	67
-	2	2	2	2	2	-	21017-2	SCREW, DRIVE	66
-	1	1	1	1	1	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	63
-	1	1	1	1	1	-	22733-8	SCR, BHSC, SELF-LOCKING, 8-32 X .375	60
-	1	1	1	1	1	-	2-22603-0	SCR, HEX HD CAP 8-32 X .312	59
-	1	1	1	1	1	-	458537-2	PAWL, FEED	56
-	4	4	4	4	4	-	2-21002-2	SCR, BTN SKT HD CAP 8-32 X .500	54
-	2	2	2	2	2	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	53
-	1	1	1	1	1	-	21018-5	NUT, HEX, REG 6-32	52
-	1	1	1	1	1	-	811242-2	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	-	690753-1	SPACER, TONKER	50
-	-	-	1	-	-	..	690602-6	CAM, PRE FEED, 1 5/8	49
-	-	-	-	1	-	..	690602-5	CAM, PRE FEED, 1 1/8	48
-	1	-	-	-	1	-	690501-4	CAM, POST FEED, 1 5/8	47
-	1	1	1	1	1	-	459456-1	APPL. BASIC SUB ASSY (SIDE WISE MQCA)	46
-	1	1	1	1	1	-	690191-1	PLUG,NYLON	45
-	1	1	1	1	1	-	455673-1	RAM, SIDE FEED	44
-	1	1	1	1	1	-	7-21002-9	SCR, BTN SKT HD CAP 5/16-24 X 1.00	41
-	1	1	1	1	1	-	690125-1	SHIM SUB-ASSY	39
-	1	1	1	1	1	-	879103-3	FINE ADJUST HEAD ASSEMBLY	37
-	1	1	1	1	1	-	690786-6	TERMINAL SUPPORT	34
-	2	2	2	2	2	-	2-21002-4	SCR, BTN SKT HD CAP 8-32 X .750	33
-	1	1	1	1	1	-	21024-5	WASHER, SPRG LOCK, REG NO 10	32
-	1	1	1	1	1	-	3-21000-4	SCR, SKT HD CAP 10-32 X .375	31
-	1	1	1	1	1	-	1320908-8	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	-	1633091-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	-	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1	-	1320928-1	PLATE, STRIP GUIDE	24
-	1	-	-	-	1	-	690472-2	STRIPPER	22
-	1	1	1	1	1	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	21
-	4	4	4	4	4	-	21024-4	WASHER, SPRG LOCK, REG NO 8	20
-	-	-	1	1	-	-	691353-1	STRIPPER	19
△	-	1	-	-	-	-	679625-1	SHEAR HOLDER, FRONT (NO CUT)	13
△	-	1	1	1	1	-	3-22280-3	SPRING, COMPRESSION	12
△	-	1	1	1	1	-	690461-1	STOP, SHEAR	11
△	-	-	1	1	1	-	690459-1	SHEAR HOLDER, FRONT	10
△	-	1	1	1	1	-	454276-1	FLOATING SHEAR, FRONT	9
△	1	1	1	1	1	-	1-1633112-7	ANVIL, COMBINATION .110	8
-	-	-	-	-	-	..	-	-	7
-	-	-	-	-	-	..	-	-	6
-	1	1	1	1	1	-	3-455889-6	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	-	238011-2	BLOCK, CRIMPER SPACER	4
△	1	1	1	1	1	-	2-456134-6	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	-	455888-5	SPACER, CRIMPER	2
△	1	1	1	1	1	-	2-456408-8	CRIMPER, WIRE PREMIUM	1
-77	-6	-3	-2	-1	U/M	PART NO	DESCRIPTION		ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS THE CUSTOMER'S RESPONSIBILITY TO OBTAIN THE NECESSARY PERMISSIONS FROM THE APPLICATOR'S ORGANIZATION BEFORE ANY CHANGES ARE MADE TO THE DRAWING. ANY CHANGES TO THE DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.		OWN: CHKD: APVD:	M. HERR G. BAILEY N. DEMING	11FEB2008 11FEB2008 11FEB2008	Tyco Electronics Harrisburg, PA 17105-3608	
DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	FINE ADJUST SIDE FEED HDM APPLICATOR -	

Mouser Electronics

Authorized Distributor

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[1855370-6](#)