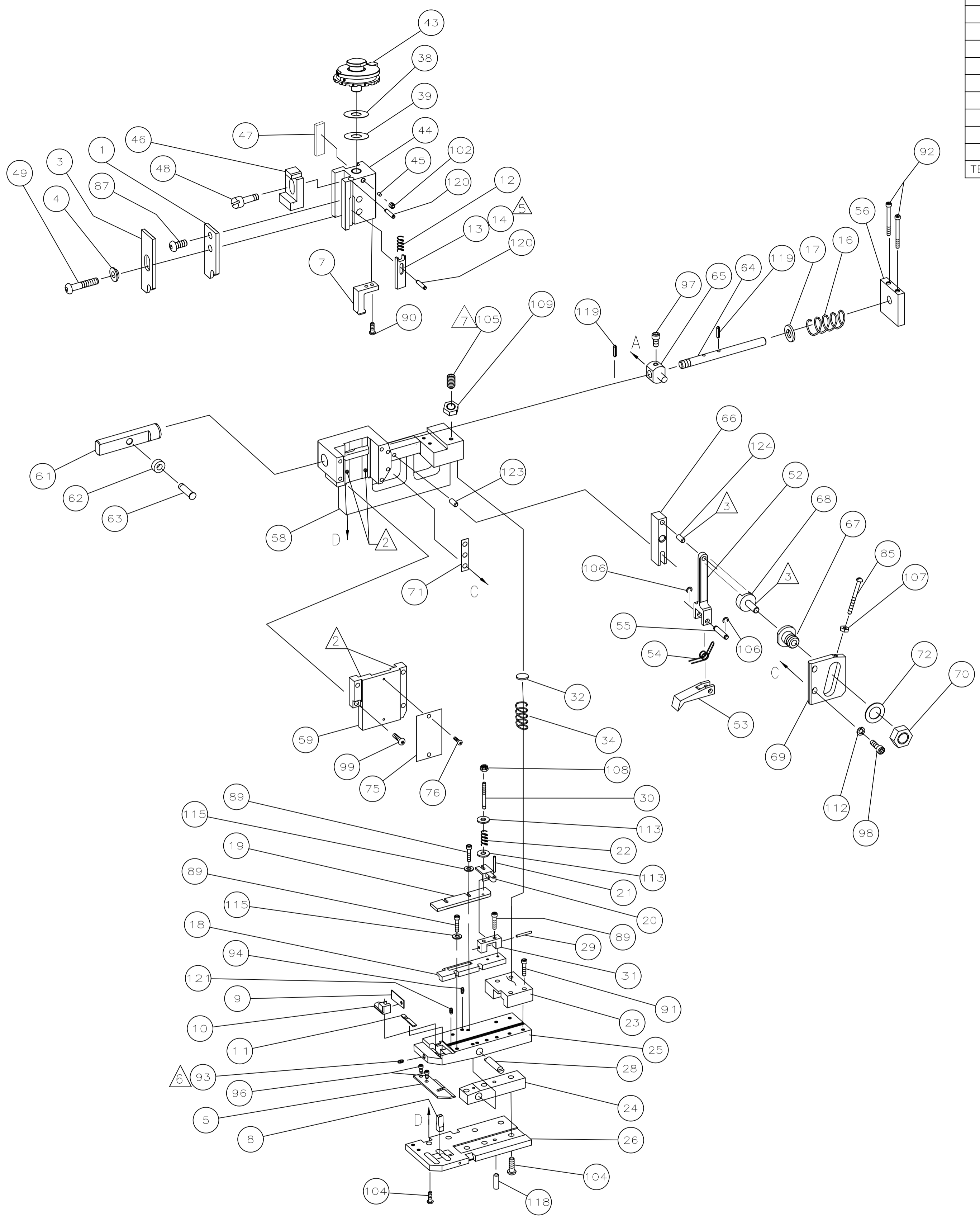


THIS DRAWING IS A CONTROLLED DOCUMENT.

THIS INFORMATION IS CONFIDENTIAL AND PROPRIETARY TO TYCO ELECTRONICS CORPORATION AND ITS WORLDWIDE SUBSIDIARIES AND AFFILIATES. IT MAY NOT BE DISCLOSED TO ANY OTHER PARTY WITHOUT THE WRITTEN AUTHORIZATION OF TYCO ELECTRONICS CORPORATION, HARRISBURG, PENNSYLVANIA, USA.

PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE
1855521-1	C	-	LEADMAKER	MECH POST FEED

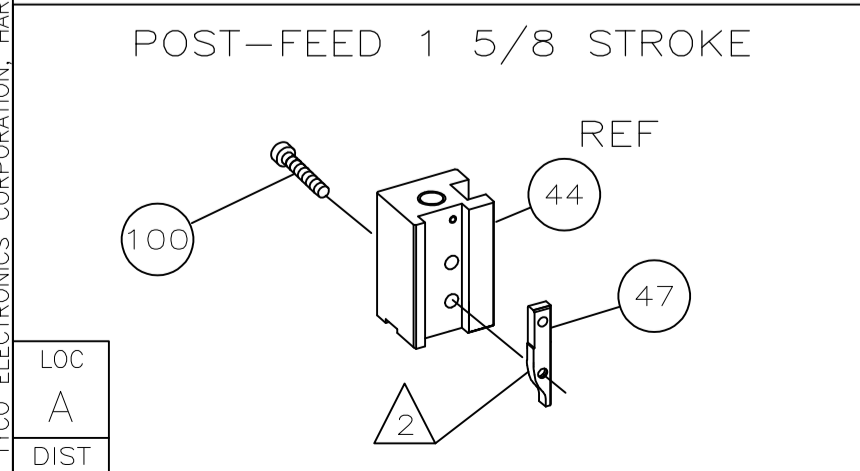
TERMINAL NAME:		CRIMPING DATA			
.250 FLAG FASTON RECEPTACLE		PAD LTR	CRIMP HEIGHT	WIRE SIZE	REF SETTING
	60851	A	.089±.002	10	B0
	42563-6	B	.075±.002	12	D4
	42563-8	C	NOT	USED	-
	42563-9	D	NOT	USED	-
		CRIMP	SIZE	TAB TYPE	RANGE
		WIRE	.200	LOCK	12-10
		INSUL	.220	0	.110-.210
		FEED	APPL INST	SET UP GAGE	LAYOUT
		.770	A18031	-	-
TERM APPL SPEC 114-2078		WIRE STRIP LENGTH .205-.235			



- ▲ 1 RECOMMENDED SPARE PARTS.
- ▲ 2 GREASE LIGHTLY.
- ▲ 3 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 4. DO NOT EXCEED 80 C.P.M. WITH THIS APPLICATOR.
- ▲ 5 TERMINAL POSITIONERS (ITEMS 13 & 14) CAN BE CHANGED TO CENTER TAB IN SLOT WHILE CRIMPING
- ▲ 6 APPLY LOCTITE P/N 1-23419-5 TO ITEM 93 AT ASSEMBLY.
- ▲ 7 AFTER ASSEMBLY OF APPLICATOR, PROPER SPRING PRESSURE (ITEM 34) CAN BE OBTAINED BY TIGHTENING SET SCREW (ITEM 105) UNTIL CONTACT IS MADE WITH SPACER (ITEM 32) THEN TIGHTEN AN ADDITIONAL 5 1/2 - 6 REVOLUTIONS.

					129
					128
					127
					126
					125
1	-	1-21030-2	PIN, DOWEL (Ø.187X.62)		124
1	-	1-21030-6	PIN, DOWEL (Ø.187X1.25)		123
					122
2	-	3-21028-2	PIN, SLOTTED SPRING (Ø.094X.25)		121
3	-	4-21028-9	PIN, SLOTTED SPRING (Ø.125X.38)		120
2	-	5-21028-1	PIN, SLOTTED SPRING (Ø.125X.50)		119
1	-	21029-5	PIN, SLOTTED SPRING (Ø.188X.75)		118
					117
					116
4	-	21024-4	WASHER, LOCK (#8)		115
2	-	21055-6	WASHER, FLAT (#8)		114
2	-	21899-2	WASHER, FLAT (#10)		113
2	-	21024-5	WASHER, LOCK (#10)		112
					111
					110
1	-	1-22202-7	NUT, HEX (5/16-24)		109
1	-	21022-3	NUT, HEX (LOCKING)(10-32)		108
1	-	21018-5	NUT, HEX (6-32)		107
2	-	21045-3	RING, RET "C" (Ø.187) FD PIN		106
1	-	8-21007-5	SCREW, SKT SET (5/16-24x.75)		105
7	-	2-22733-8	SCREW, BHC (1/4-20X.63)		104
					103
1	-	21009-2	SCREW, SKT SET (1/4-20x.25)		102
					101
2	-	3-21000-9	SCREW, SHC (10-32X1.00)		100
4	-	3-21000-8	SCREW, SHC (10-32X.88)		99
2	-	3-21000-6	SCREW, SHC (10-32X.62)		98
1	-	3-21000-4	SCREW, SHC (10-32X.38)		97
2	-	7-21000-6	SCREW, SHC (10-32X.31)		96
					95
1	-	4-21006-5	SCREW, SKT SET (8-32X.62)		94
1	-	21061-9	SCREW, SKT SET (8-32X.25)		93
2	-	3-21000-0	SCREW, SHC (8-32X.88)		92
4	-	2-21000-9	SCREW, SHC (8-32X.75)		91
2	-	1-23030-1	SCREW, SHC (NYLOK)(8-32X.62)		90
6	-	2-21000-8	SCREW, SHC (8-32X.62)		89
					88
1	-	2-21002-1	SCREW, SBHC (8-32X.38)		87
					86
1	-	6-23715-5	SCR, PAN HD (6-32x1.50) FEED ADJ		85
					84
					83
					82
					81
					80
					79
					78
					77
1	-	21017-2	SCR, DRIVE (2X .19)		76
1	-	461264-5	PLATE, IDENTIFICATION		75
					74
					73
1	-	458109-1	WASHER, SPECIAL		72
1	-	690517-1	SPACER		71
					70
					69
					68
					67
					66
					65
					64
					63
					62
					61
					60
1	-	2217626-1	CAP ASSEMBLY		59
1	-	2217625-1	HOUSING		58
					57
					56
1	-	458361-1	GUIDE, FEED ROD		55
1	-	240624-1	PIN, FEED FINGER		54
1	-	691499-1	SPRING, FEED FINGER		53
1	-	454568-1	FINGER, FEED		52
1	-	240634-1	LEVER, TERMINAL		51
					50
					49
1	-	3-21002-5	BOLT, CRIMPER		48
1	-	2256119-1	SCREW, SHOULDER		47
1	-	238015-1	CAM, POST-FEED 1 5/8 ST		46
1	-	690578-3	BLOCK, INSULATION ADJUST		45
1	-	690191-1	PLUG, NYLON		44
1	-	2217624-1	RAM		43
1	-	879103-2	FINE ADJUST HEAD ASSY		42
					41
					40
1	-	690125-1	SHIM, SUB-ASSY		39
1	-	1-469367-2	SHIM		38
					37
					36
					35
1	-	3-23846-5	SPRING, HINGE BAR		34
					33
1	-	690573-1	SPACER, SPRING		32
1	-	454569-1	MOUNT, DRAG		31
1	-	1-22354-8	STUD, DRAG		30
1	-	21030-2	PIN, MOUNT, DRAG		29
1	-	1633530-1	PIN, HINGE		28
					27
1	-	684905-1	PLATE, BASE		26
1	-	454579-2	HINGE BAR		25
1	-	690571-1	BLOCK, STABILIZER		24
1	-	690585-1	BLOCK, PRESSURE		23
1	-	22282-5	SPRING, DRAG		22
1	-	21030-6	LEVER, DRAG		21
1	-	454570-1	DRAG, STOCK		20
1	-	454573-1	GUIDE, STRIP (REAR)		19
1	-	454571-1	GUIDE, STRIP (FRONT)		18
1	-	21899-4	WASHER, ADJ. SCREW		17
1	-	4-22284-9	SPRING, FEED RETURN		16
					15
▲ 1	-	1-692134-6	POSITIONER, TERMINAL		14
1	-	692134-6	POSITIONER, TERMINAL		13
1	-	5-22280-5	SPRING, TERM. POSITIONER		12
1	-	454711-1	PLATE, REAR SHEAR		11
1	-	454710-1	ANVIL INSERT		10
1	-	1-690569-1	PLATE, FRONT SHEAR		9
1	-	690761-1	ANVIL		8
1	-	454575-4	BLADE, SLUG		7
					6
1	-	684906-1	PLATE, ANVIL RETAINING		5
1	-	690574-1	SPACER, TUBULAR INSUL CRIMPER		4
1	-	690764-1	CRIMPER, INSULATION		3
					2
▲ 1	-	690763-2	CRIMPER, WIRE		1

QTY	REQD	PER ASSY	PART NO	DESCRIPTION	ITEM NO
					70
					69
					68
					67
					66
					65
					64
					63
					62
					61
					60
					59
					58
					57
					56
					55
					54
					53
					52
					51
					50
					49
					48
					47
					46
					45
					44
					43
					42
					41
					40
					39
					38
					37
					36
					35
					34
					33
					32
					31
					30
					29
					28
					27
					26
					25
					24
					23
					22
					21
					20
					19
					18
					17
					16
					15
					14
					13
					12
					11
					10
					9
					8
					7
					6
					5
					4
					3
					2
					1



LOC A  
DIST 66

QTY	REQD	PER ASSY	PART NO	DESCRIPTION	ITEM NO
					75
					74
					73
					72
					71
					70
					69
					68
					67
					66
					65
					64
					63
					62
					61
					60
					59
					58
					57
					56
					55
					54
					53
					52
					51
					50
					49
					48
					47
					46
					45
					44
					43
					42
					41
					40
					39
					38
					37
					36
					35
					34
					33
					32
					31
					30
					29
					28
					27
					26
					25
					24
					23
					22
					21
					20
					19
					18
					17
					16
					15
					14
					13
					12
					11
					10
					9
					8
					7
					6
					5
					4
					3
					2
					1

QTY	REQD	PER ASSY
-----	------	----------

# Mouser Electronics

Authorized Distributor

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

[TE Connectivity:](#)

[1855521-1](#)