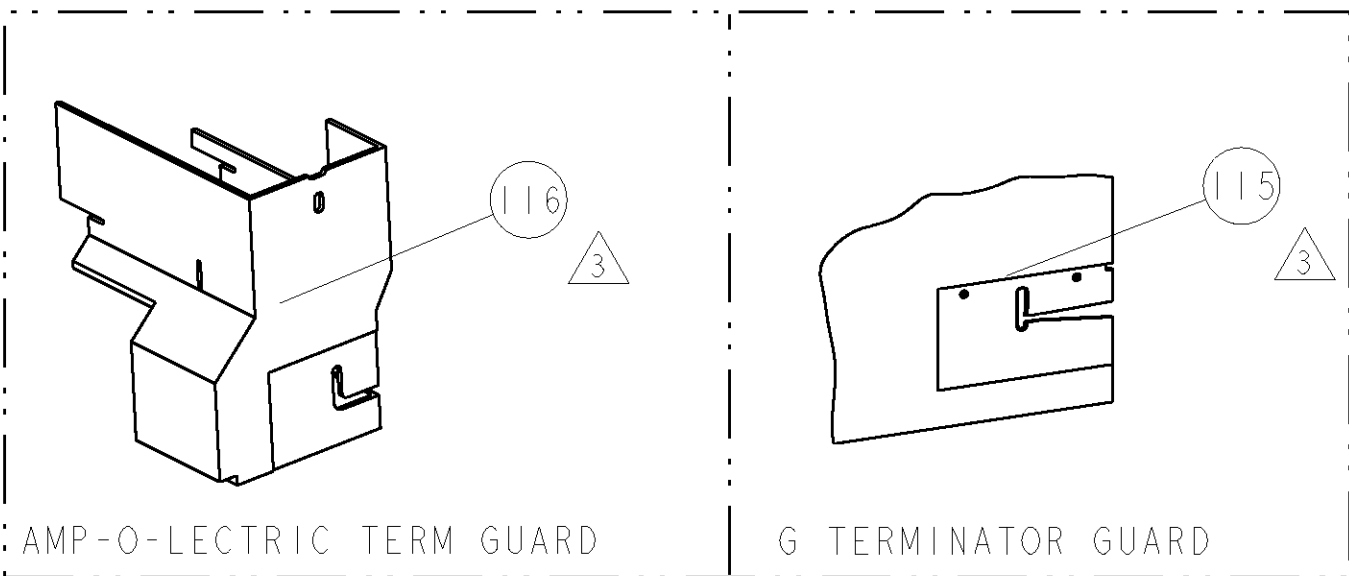


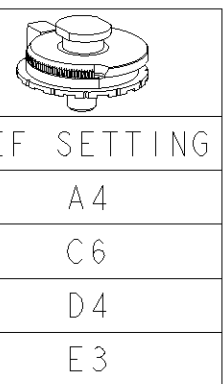
8				7			
THIS DRAWING IS UNPUBLISHED.				RELEASED FOR PUBLICATION			
COPYRIGHT 20				BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.			
PART NUMBER		REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION	
1855410-1		A	122500-1	LEADMAKER	POST FEED	CUTS CARRIER	
1855410-2		A	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER	
1855410-3		A	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER	
1855410-6		A	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER	
7-1855410-7		A	-	-	-	SPARE PARTS	

- RECOMMENDED SPARE PARTS
- GREASE LIGHTLY
- GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
- STRIPPER #22 MUST BE LOCATED BETWEEN WIRE CRIMPER #1 & SHEAR DEPRESSOR #5

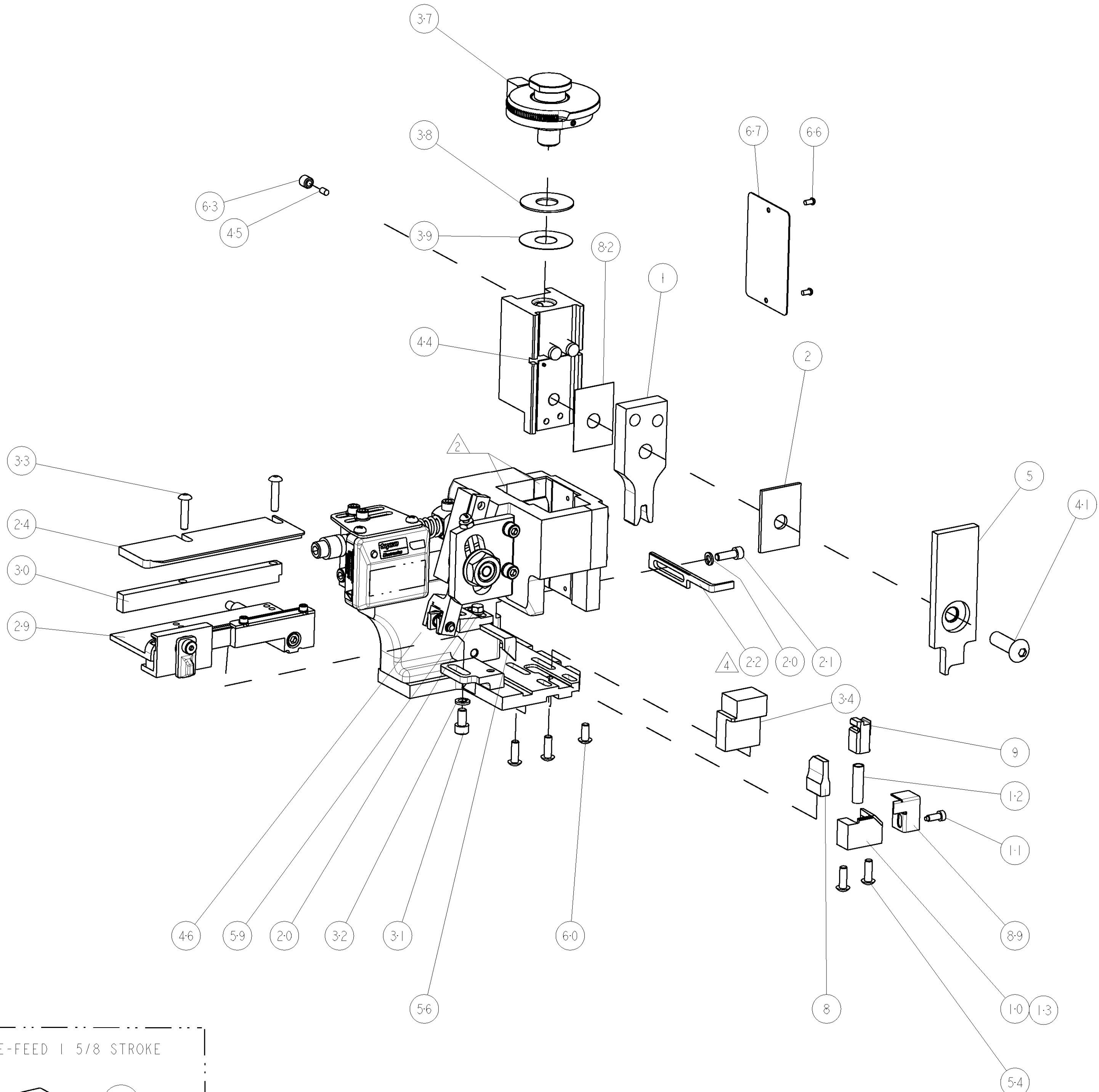
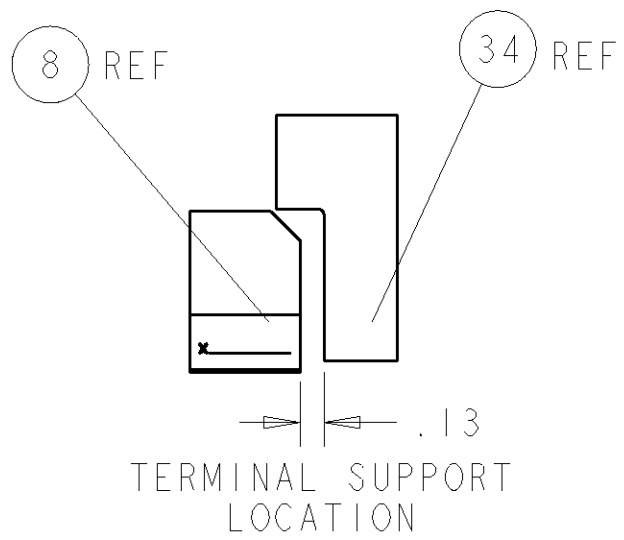
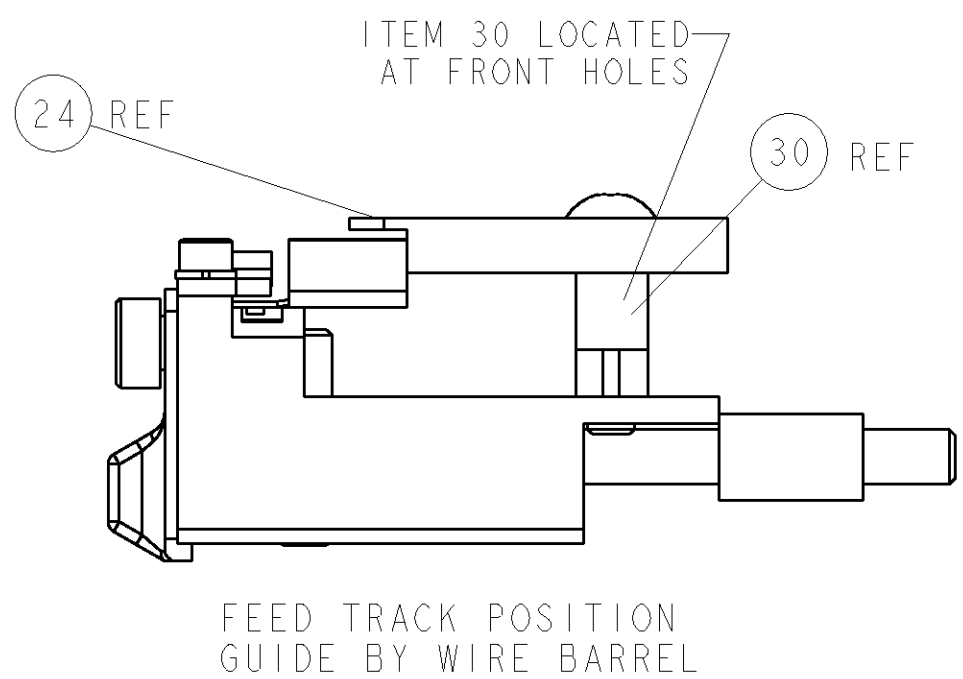
*** WARNING**
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN. REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



TERMINAL NAME: CLIP					
TE PN	MANF PN	GROTE & HARTMANN TERMINAL - TE CRIMP SPECS			
1949690	25775.123.178				
-	-	CRIMP HEIGHT		WIRE SIZE	
-	-	3.28mm+.05/- .05[.129+.002/- .002]		6mm2	
-	-	3.05mm+.05/- .05[.120+.002/- .002]		5mm2	
-	-	2.94mm+.05/- .05[.116+.002/- .002]		4.5mm2	
-	-	2.82mm+.05/- .05[.111+.002/- .002]		4mm2	
-	-	CRIMP	SIZE	TYPE	RANGE
-	-	WIRE	3.56mm [.140]	F	4.0-6.0mm
-	-	INSUL	-	-	Ø 4.19mm MAX
WIRE STRIP LENGTH 10.80-11.18mm	TERM APPL SPEC NONE	FEED 14.48	APPLICATOR INSTRUCTIONS 408-8040		SET UP GAGE 458637-1



REF SETTING
A4
C6
D4
E3



3-3	-	-	-	REF	-	..	455749-1	GUARD WINDOW	116
3-3	-	-	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
-	-	-	-	-	-	-	455888-1	SPACER, CRIMPER	82
-	-	-	-	-	-	-	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
-	-	-	-	-	-	..	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
-	-	-	-	-	-	-	2-819307-7	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
-	-	-	-	-	-	-	469367-7	SHIM	38
-	-	-	-	-	-	-	879103-4	FINE ADJUST HEAD ASSEMBLY	37
-	-	-	-	-	-	-	469465-3	STOP, WIRE	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
-	-	-	-	-	-	-	1320908-5	SPACER, STRIP GUIDE	30
-	-	-	-	-	-	-	1633091-3	ASSEMBLY, STRIP GUIDE	29
-	-	-	-	-	-	-	8-690440-1	GUIDE, REAR STRIP	24
4	-	-	-	-	-	-	1-690472-1	STRIPPER	22
-	-	-	-	-	-	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	21
-	-	-	-	-	-	-	21024-4	WASHER, SPRG LOCK, REG NO 8	20
1	-	-	-	-	-	-	679625-1	SHEAR HOLDER, FRONT (NO CUT)	13
-	-	-	-	-	-	-	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	-	-	690461-1	STOP, SHEAR	11
1	-	-	-	-	-	-	690459-1	SHEAR HOLDER, FRONT	10
1	-	-	-	-	-	-	454276-1	FLOATING SHEAR, FRONT	9
1	-	-	-	-	-	-	1633665-3	ANVIL, COMBINATION	8
-	-	-	-	-	-	..	-	-	7
-	-	-	-	-	-	..	-	-	6
-	-	-	-	-	-	..	2-455889-1	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	..	-	-	4
-	-	-	-	-	-	..	-	-	3
-	-	-	-	-	-	-	1-455888-8	SPACER, CRIMPER	2
1	-	-	-	-	-	-	1633664-5	CRIMPER, WIRE	1
-77	-6	-3	-2	-1	U/M	PART NO	DESCRIPTION		ITEM NO

THIS IS A CUSTOMER DRAWING. IT IS THE CUSTOMER'S RESPONSIBILITY TO ENSURE THE DRAWING IS USED FOR THE CORRECT PART AND ORGANIZATION. NO OTHER ORGANIZATION SHOULD BE CONTACTED FOR THE CORRECT PART.		DRAWN C. REICHELDERFER 03JUNE2008	Tyco Electronics Harrisburg, PA 17105-3608	
DIMENSIONS: INCHES		APPROVED N. DEMING 03JUNE2008	NAME FINE ADJUST SIDE FEED HDM APPLICATOR	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 9 PLC ±.01 1 PLC ±.01 3 PLC ±.001 4 PLC ±.0001 ANGLES ±.0001		PRODUCT SPEC APPLICATION SPEC	SIZE CAGE CODE DRAWING NO A1 00779 C=1855410	
MATERIAL -		FINISH -	WEIGHT -	RESTRICTED TO -
CUSTOMER DRAWING		SCALE 3:5	SHEET 1	REV A

CUSTOMER VIEWABLE ASSEMBLY

Mouser Electronics

Authorized Distributor

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

[TE Connectivity:](#)

[1855410-3](#)