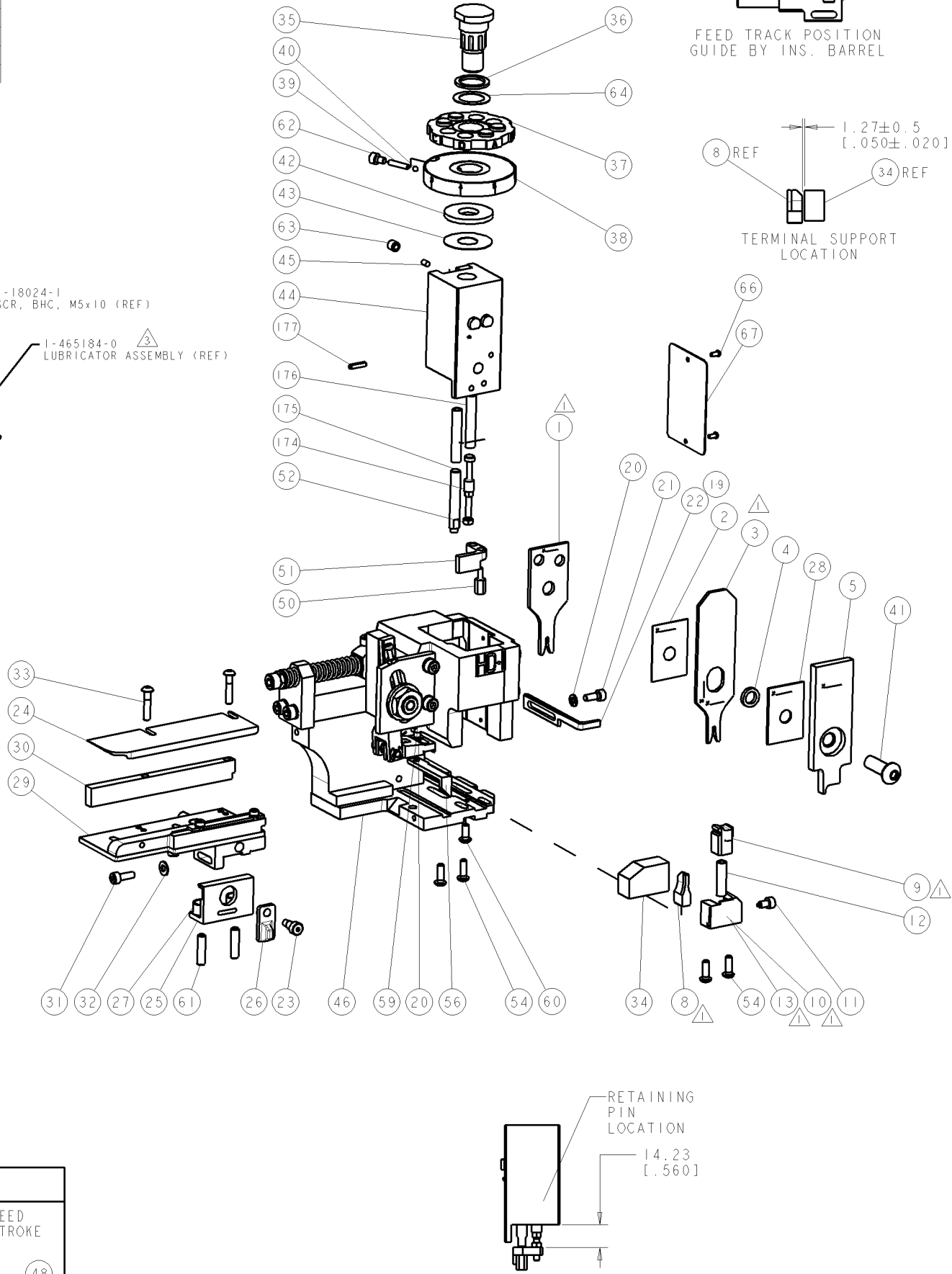
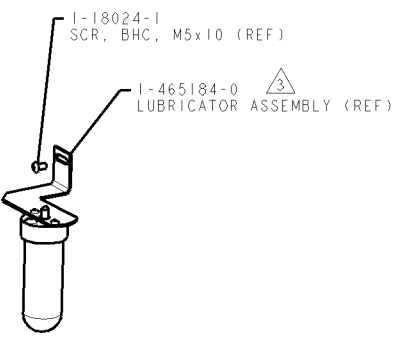


PART NUMBER		REV	TERMINATOR	FEED TYPE	DESCRIPTION
2114020-1		A	LEADMAKER	MECH POST FEED	CUTS CARRIER
2114020-2		A	BENCH	MECH PRE FEED	CUTS CARRIER
2114020-6		A	LEADMAKER	MECH POST FEED	CONTINUOUS CARRIER
7-2114020-1		A	LEADMAKER	MECH POST FEED	-1 AND SPARE PARTS
7-2114020-2		A	BENCH	MECH PRE FEED	-2 AND SPARE PARTS
7-2114020-6		A	LEADMAKER	MECH POST FEED	-6 AND SPARE PARTS
7-2114020-7		A	-	-	SPARE PARTS KIT

CRIMP DATA DELPHI TERMINAL TE CRIMP SPECS			
TERMINAL NAME: TERMINAL			
CRIMP	SIZE	TYPE	RANGE
WIRE	1.58 [.062 IN]	F	0.35-0.50mm ²
INSUL	1.93 [.076 IN]	F	Ø1.40-1.60 mm
WIRE STRIP LENGTH 2.00-3.00 [.078-.118 IN]		APPL INSTRUCTIONS 408-8322	
TERMINAL APPL SPEC		NONE	FEED 9.00 [.354 IN]
TERMINALS APPLIED			
TE PN	M.F.R.		
2082136	14000957	-	-
-	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-
WIRE SIZE	CRIMP HEIGHT	PIN PN & LENGTH [IN]	
0.50mm ²	.97 ±0.05 [.038 ±.002 IN]	3-354779-9 [.3185]	
0.35mm ²	.89 ±0.05 [.035 ±.002 IN]	4-354779-5 [.3215]	
-	-		
-	-		
-	-		
-	-		
-	-		
-	-		
-	-		
-	-		

- △ RECOMMENDED SPARE PARTS.
2. GREASE RAM, CAM, CAM FOLLOWER AND FEED ROD LIGHTLY.
- △ CERTAIN TERMINALS REQUIRE LUBRICATION. REFER TO THE APPLICATOR INSTRUCTION SHEET FOR MORE INFORMATION.
4. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

VIEW B ROTATED 180°			
POST-FEED 40mm STROKE	POST-FEED 30mm STROKE	PRE-FEED 30mm STROKE	PRE-FEED 40mm STROKE



HOLDDOWN SET-UP

SET UP GAGE
458637-3

REVISONS			
LYK	DESCRIPTION	DATE	OWN
A	RELEASED	11JUN2009	T.Y.

-	1	1	1	1	1	1	993111-8	PIN, SLOTTED SPRING 3.0 X 12.0	177
-	2	2	2	2	2	2	3-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1	1752353-1	GUIDE PIN,HOLDDOWN	175
-	1	1	1	1	1	1	1901680-1	GUIDE PIN,HOLDDOWN	174
-	1	1	1	1	1	1	1338705-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	461264-1	PLATE, IDENTIFICATION	67
-	2	2	2	2	2	2	21017-2	SCREW, DRIVE	66
-	1	1	1	1	1	1	986950-1	WASHER, FLAT PRECISION	64
-	1	1	1	1	1	1	3-18031-0	SCR, SET, CUP POINT M6 X 6.0	63
-	1	1	1	1	1	1	18023-9	SCR, SKT HD CAP M4 X 6.0	62
-	2	2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	1	1	1	1	1	1	18024-7	SCR, BTN SKT HD CAP (M4 X 10.0)	60
-	1	1	1	1	1	1	5-18022-2	SCR, HEX HD CAP M4 X 8.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	18024-8	SCR, BTN SKT HD CAP (M4 X 12.0)	54
-	1	1	1	1	1	1	1-18030-0	NUT, HEX, REG M3.5	52
-	1	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1	1	2-1752354-2	STANDOFF,HOLD-DOWN	50
-	1	1	1	1	1	1	18024-3	SCR, BTN SKT HD CAP (M3 X 10.0)	49
-	-	-	-	-	-	-	1338675-1	CAM, UNIVERSAL PRE FEED	48
-	1	-	1	1	-	1	1338676-1	CAM, UNIVERSAL POST-FEED	47
-	1	1	1	1	1	1	1320999-3	APPLICATOR SUBASSEMBLY, HDI	46
-	1	1	1	1	1	1	690191-1	PLUG,NYLON	45
-	1	1	1	1	1	1	1633724-1	RAM, (SIDE FEED)	44
-	1	1	1	1	1	1	690125-1	SHIM SUB-ASSY	43
-	1	1	1	1	1	1	690124-1	WASHER, RAM (.115)	42
-	1	1	1	1	1	1	2-18024-6	SCR, BTN SKT HD CAP (M8 X 25.0)	41
-	1	1	1	1	1	1	23241-1	BALL, STEEL	40
-	1	1	1	1	1	1	2-22278-7	SPRING, COMPRESSION	39
-	1	1	1	1	1	1	1-1320922-3	DISC, ADJUST, INSULATION CRIMP	38
-	1	1	1	1	1	1	354777-1	WIRE DISC, ASSEMBLY	37
-	1	1	1	1	1	1	22480-5	SPRING, COMPRESSION	36
-	1	1	1	1	1	1	690212-1	POST, RAM	35
-	1	1	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	1-18024-0	SCR, BTN SKT HD CAP (M4 X 20.0)	33
-	1	1	1	1	1	1	18027-2	WASHER, FLAT, REG M4	32
-	1	1	1	1	1	1	1-18023-2	SCR, SKT HD CAP M4 X 12.0	31
-	1	1	1	1	1	1	1320908-1	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1	1633073-1	STRIP GUIDE ASSEMBLY	29
-	1	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	2	2	1-22284-0	SPRING, COMPRESSION	27
-	1	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1	1	1320928-1	PLATE, STRIP GUIDE	24
-	1	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	-	1	1	-	1	690472-2	STRIPPER	22
-	1	1	1	1	1	1	1-18023-1	SCR, SKT HD CAP M4 X 10.0	21
-	2	2	2	2	2	2	18025-2	WASHER, SPRG LOCK, REG M4	20
-	-	-	-	-	-	-	690472-1	STRIPPER	19
-	1	-	-	-	-	-	1338684-2	SHEAR HOLDER, FRONT	13
-	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1	356885-5	STOP, SHEAR	11
-	-	1	1	-	1	1	1-1320921-0	SHEAR HOLDER, FRONT, CUT	10
-	1	1	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
1	2	2	2	1	1	1	4-1633129-6	ANVIL, COMBINATION .062	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2-455889-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
1	2	2	2	1	1	1	1-683453-2	CRIMPER, INSULATION PREMIUM	3
-	1	1	1	1	1	1	455888-2	SPACER, CRIMPER	2
1	2	2	2	1	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1

PART NO		DESCRIPTION		ITEM NO
77-76-72-71-6-2-1		SIDE FEED HDI APPLICATOR		-
07MAY2009		Tyco Electronics		-
S. ZOU		Harrisburg, PA 17105-3608		-
07MAY2009		APPROVED		-
S. X		APPLICATION SPEC		-
See Table		WEIGHT		-
CUSTOMER DRAWING		SCALE		-
3:5		SHEET		-
1		OF		-
A		REV		-

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