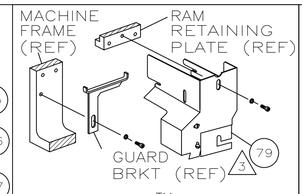
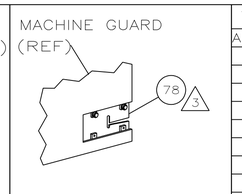
PART NUMBER	REV	FIRST USED
1385576-1	B	122500-1
1385576-2	B	565435-5
1385576-3	B	354500-1



AMP-O-LECTRIC TM TERM GUARD



G TERMINATOR GUARD

TERMINAL NAME: 0.64 MALE INLINE

AMP TERM PN	MFG TERM PN
1642306-1	2LIT-14421-CA

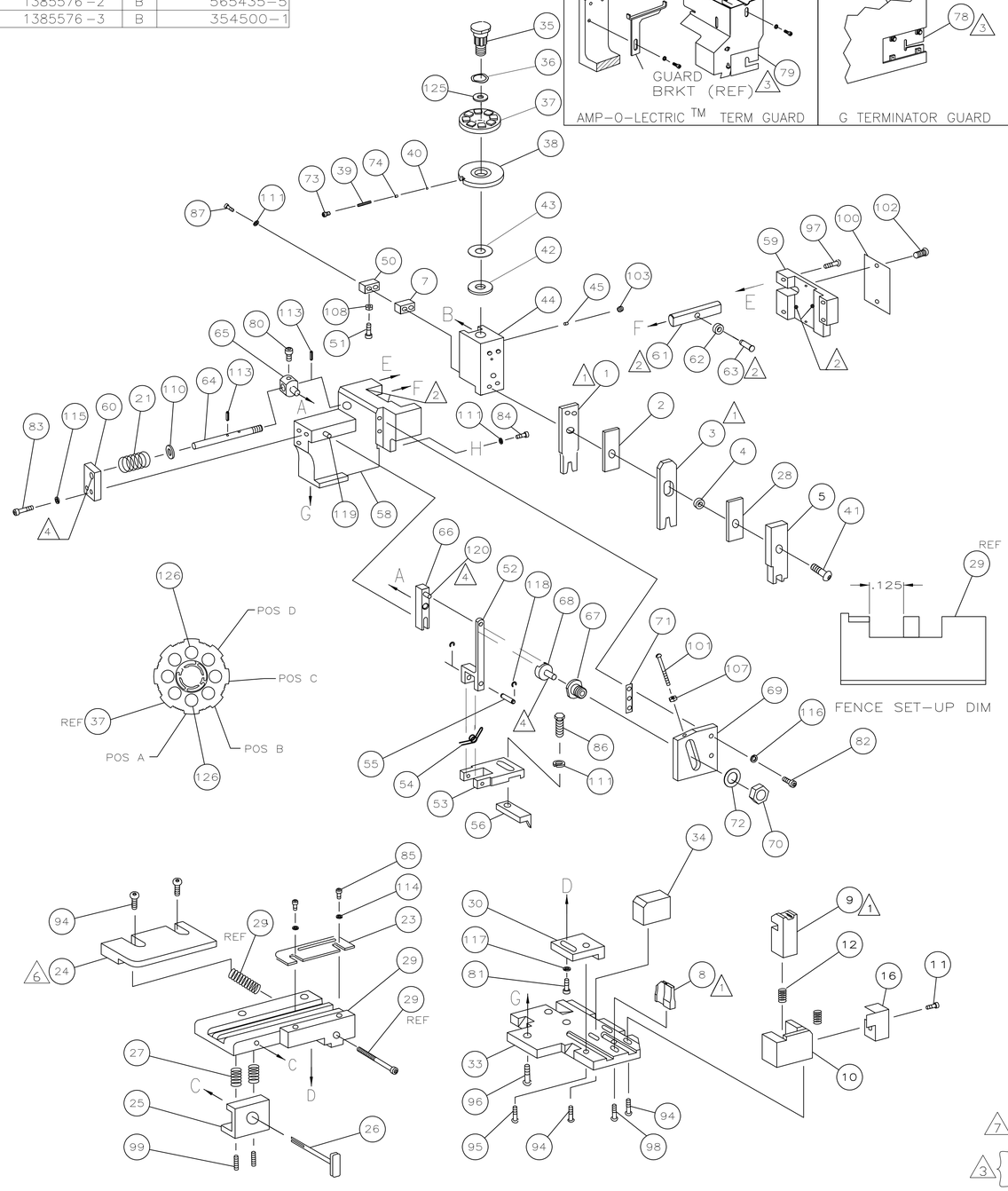
MOLEX TERMINAL		MOLEX CRIMP SPECS
PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.049 ±.002 [1.24±0.05mm]	18 AWG △8
B	NOT	USED
C	NOT	USED
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.082 [2.08mm]	F	18 △8
INSUL	.089 [2.26mm]	O	.055 MAX

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.197-.228	NONE	.380	408-8040	458637-1	L2813

USED ON _

-1	LEADMAKER	MECH POST FEED
-2	BENCH MODEL K	MECH PRE FEED
-3	BENCH MODEL G	MECH PRE FEED

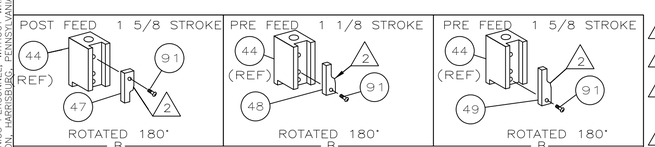


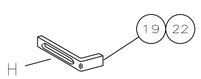
-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
						129
						128
						127
2	2	2	–	4-354779-2	PIN, WIRE DISC (.3200)A	126
1	1	1	–	986950-1	WASHER, FLAT PRECISION	125
1	1	1	–	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	1	–	4088040	SF APPL INST 408-8040	123
						122
						121
REF	REF	REF	–	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	120
REF	REF	REF	–	1-21030-6	PIN,DOWEL(Ø.187x1.25)HOUSING	119
REF	REF	REF	–	21045-3	RING,RET "C"(Ø.187)FD FING PIN	118
1	1	1	–	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
REF	REF	REF	–	21024-5	WASHER,LOCK(#10)ADJ PLATE	116
REF	REF	REF	–	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115
2	2	2	–	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
REF	REF	REF	–	5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	113
						112
4	4	4	–	21024-4	WASHER,LOCK(#8)STRIPPER	111
REF	REF	REF	–	21899-4	WASHER,FLAT(Ø5/16)SCREW ADJ	110
						109
1	1	1	–	21018-5	NUT,HEX(NO.6)HOLDDOWN	108
REF	REF	REF	–	21068-5	NUT,HEX(6-32)FEED ADJ	107
						106
						105
						104
1	1	1	–	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
2	2	2	–	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
REF	REF	REF	–	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
1	1	1	–	461264-1	PLATE, IDENTIFICATION	100
2	2	2	–	5-21006-6	SCR,SET(10-32x.75)DRAG	99
1	1	1	–	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
REF	REF	REF	–	2-21002-9	SCR,BHC(10-32x.75)CAP	97
REF	REF	REF	–	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
REF	REF	REF	–	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
4	4	4	–	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
2	2	2	–	2-21002-2	SCR,BHC(8-32x.50)R STP GDE	93
						92
1	1	1	–	1-21002-7	SCR,BHC(6-32x.38)CAM	91
						90
						89
						88
2	2	2	–	2-21000-9	SCR,SHC(8-32x.75)DEP-HOLD	87
1	1	1	–	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
2	2	2	–	1-21000-3	SCR,SHC(4-40x.25)FR ST GUIDE	85
1	1	1	–	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
REF	REF	REF	–	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
REF	REF	REF	–	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	82
△7 1	1	1	–	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
REF	REF	REF	–	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	80
–	REF	–	–	455749-1	GUARD, WINDOW	79
△3 REF	–	–	–	679532-1	INSERT, GUARD	78
						77
						76
						75
1	1	1	–	690603-1	SPRING, ASSIST	74
1	1	1	–	23030-1	SCR,SHC(6-32x.25 SL)INS DISC	73
REF	REF	REF	–	458109-1	WASHER, SPECIAL	72
REF	REF	REF	–	690517-1	SPACER	71

QTY REQD PER ASSY — PARTS LIST

-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
REF	REF	REF	–	22594-8	NUT,HEX(1/2-20)	70
REF	REF	REF	–	240628-1	PLATE, ADJUSTMENT	69
REF	REF	REF	–	240626-1	SHAFT, PIVOT	68
REF	REF	REF	–	240633-1	BUSHING	67
REF	REF	REF	–	455680-1	LEVER, INTERMEDIATE	66
REF	REF	REF	–	240629-1	BLOCK, PIVOT	65
REF	REF	REF	–	240632-2	SCREW, ADJ FEED ROD	64
REF	REF	REF	–	240659-3	PIN, CAM ROLLER	63
REF	REF	REF	–	240658-1	ROLLER, CAM	62
REF	REF	REF	–	454398-2	ROD, FEED	61
REF	REF	REF	–	454178-1	GUIDE, FEED ROD	60
REF	REF	REF	–	454220-1	CAP, RAM	59
REF	REF	REF	–	454485-1	HOUSING	58
						57
1	1	1	–	458537-2	PAWL, FEED	56
REF	REF	REF	–	240624-1	PIN, FEED FINGER	55
REF	REF	REF	–	691499-1	SPRING, FEED FINGER	54
REF	REF	REF	–	690541-1	HOLDER, FEED FINGER	53
REF	REF	REF	–	455679-2	LEVER, TERMINAL FEED ARM	52
1	1	1	–	811242-2	BUMPER, HOLDDOWN	51
1	1	1	–	690753-1	SPACER, TONKER	50
1	–	–	–	690602-6	CAM, PRE-FEED 1 5/8 ST	49
–	1	–	–	690602-5	CAM, PRE-FEED 1 1/8 ST	48
–	–	1	–	690501-4	CAM, POST-FEED 1 5/8 ST	47
1	1	1	–	459456-2	APPLICATOR, BASIC (SUBASSY)	46
1	1	1	–	690191-1	PLUG, NYLON	45
1	1	1	–	455673-6	RAM	44
1	1	1	–	690125-1	WASHER, LAMINATED	43
1	1	1	–	690124-1	WASHER, RAM	42
1	1	1	–	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41
1	1	1	–	23241-6	BALL, STEEL	40
1	1	1	–	690170-1	SPRING, COMPRESSION	39
1	1	1	–	690142-4	DISC, INSULATION	38
1	1	1	–	354777-1	WIRE DISC, PLASTIC	37
1	1	1	–	22480-5	WASHER, SPRING	36
1	1	1	–	690212-1	POST, RAM	35
1	1	1	–	690786-2	SUPPORT, TERMINAL	34
REF	REF	REF	–	455675-1	PLATE, BASE	33
						32
						31
REF	REF	REF	–	455689-1	BLOCK, STRIP GUIDE ADJ	30
1	1	1	–	318756-3	STRIP GUIDE PLATE ASSY	29
1	1	1	–	2-455888-2	SPACER, FRONT SHEAR DEP	28
2	2	2	–	1-22284-0	SPRING, DRAG	27
1	1	1	–	690546-1	LEVER, DRAG RELEASE	26
1	1	1	–	240792-1	DRAG, TERMINAL	25
△6 1	1	1	–	1-90765-8	GUIDE, STRIP (REAR)	24
1	1	1	–	690438-1	GUIDE, STRIP (FRONT)	23
–	–	1	–	690472-2	STRIPPER	22
REF	REF	REF	–	4-22284-9	SPRING, FEED RETURN	21
						20
1	1	–	–	691353-1	STRIPPER	19
						18
						17
1	1	1	–	318563-1	GUARD, CHIP, FRONT	16
						15
						14
						13
1	1	1	–	3-22280-3	SPRING, SHEAR	12
1	1	1	–	690461-1	STOP, SHEAR	11
1	1	1	–	690459-1	HOLDER, SHEAR (FRONT)	10
△1 1	1	1	–	454276-1	SHEAR, FLOAT (FRONT)	9
1	1	1	–	7-662520-3	ANVIL	8
1	1	1	–	2-240641-3	SPACER,DEPRESSOR (REAR)	7
						6
1	1	1	–	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
1	1	1	–	238011-4	SPACER, BLOCK CRIMPER	4
△1 1	1	1	–	7-904741-7	CRIMPER, INSULATION	3
1	1	1	–	1-455888-0	SPACER, CRIMPER	2
△1 1	1	1	–	3-1460019-5	CRIMPER, WIRE	1

QTY REQD PER ASSY — PARTS LIST





LEADMAKER AND BENCH MACHINE

△1 RECOMMENDED SPARE PARTS.

△2 GREASE LIGHTLY.

△3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.

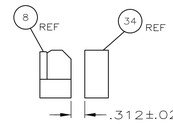
△4 LUBRICATE DAILY USING NO. 20 MACHINE OIL.

5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.

△6 REAR STRIP GUIDE TO GUIDE ON INSULATION BARREL.

△7 CUT TO LENGTH AT ASSY

△8 APPLICATOR ONLY RUNS 18 AWG WIRE. 16 & 20 AWG REQUIRES DIFFERENT TOOLING.



ITEM 34 LOCATION

P	LTR	REVISION RECORD	DATE	DWN	APVD
	B	ECR-09-019120	8-2009	MY	GB

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ± –
1 PLC ± –
2 PLC ± .02
3 PLC ± –
4 PLC ± –
ANGLES ± –
SURFACE TEXTURE

DWN M.YOUNGER	26AUG2009	MATERIAL – –
CHK G.BAILEY	27AUG2009	HEAT TREAT – –
APVD T.ELBIN	27AUG2009	Tyco Electronics Corporation Harrisburg, PA 17105-3608

NAME: SIDE FEED HDM APPLICATOR

SCALE	SIZE	DRAWING NO	SHEET	REV
–	A1	1385576	1 OF 1	B

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

LOC A
DIST 66

3308-8 (1/08)

Translated 070809:101623 (YYMMDD.HHMMSS) from CompuServision, Inc., Medusa Revision 14.2.51

27AUG2009 1:02pm

DWG NO 1385576

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