

PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1855334-1	A	122500-1	LEADMAKER	POST FEED	CUTS CARRIER
1855334-2	A	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER
1855334-3	A	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER
1855334-6	A	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER
7-1855334-7	A	-	-	-	SPARE PARTS

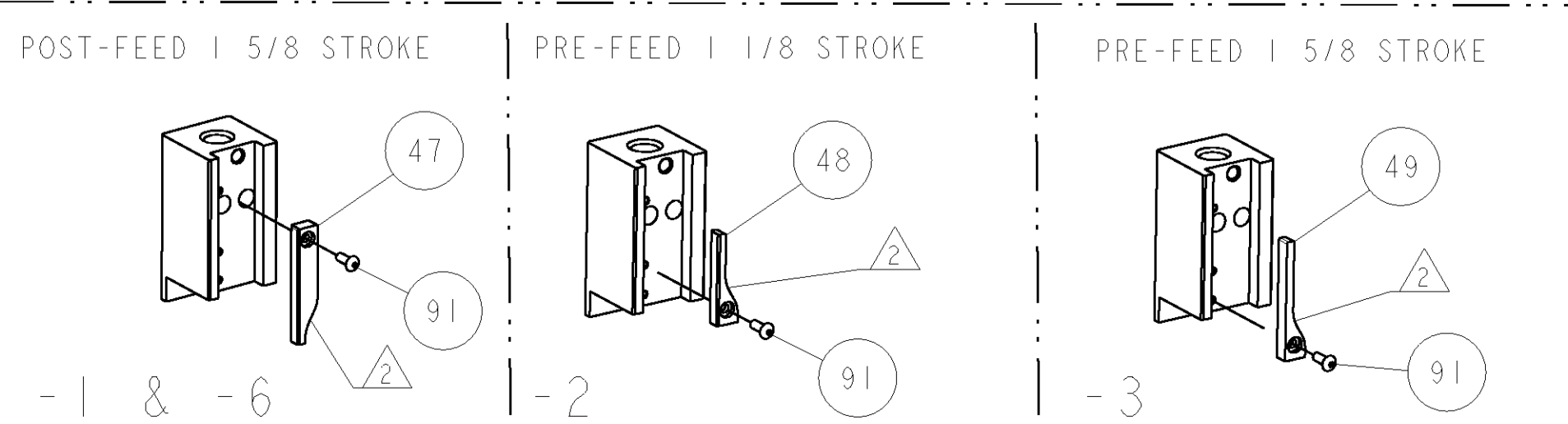
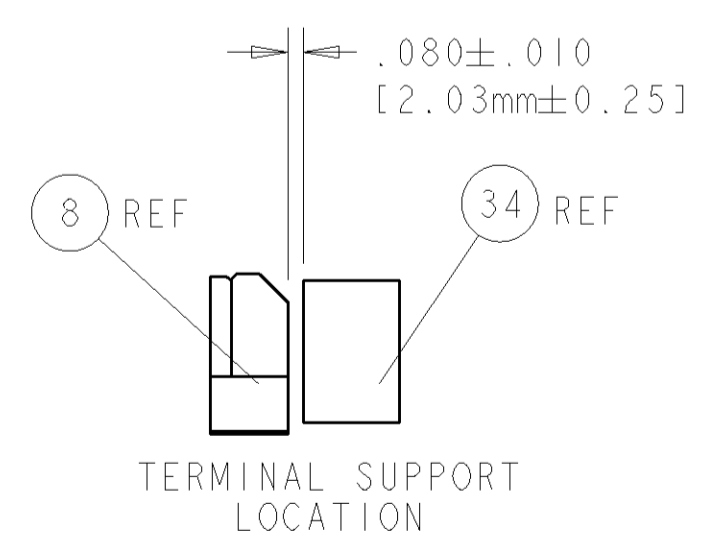
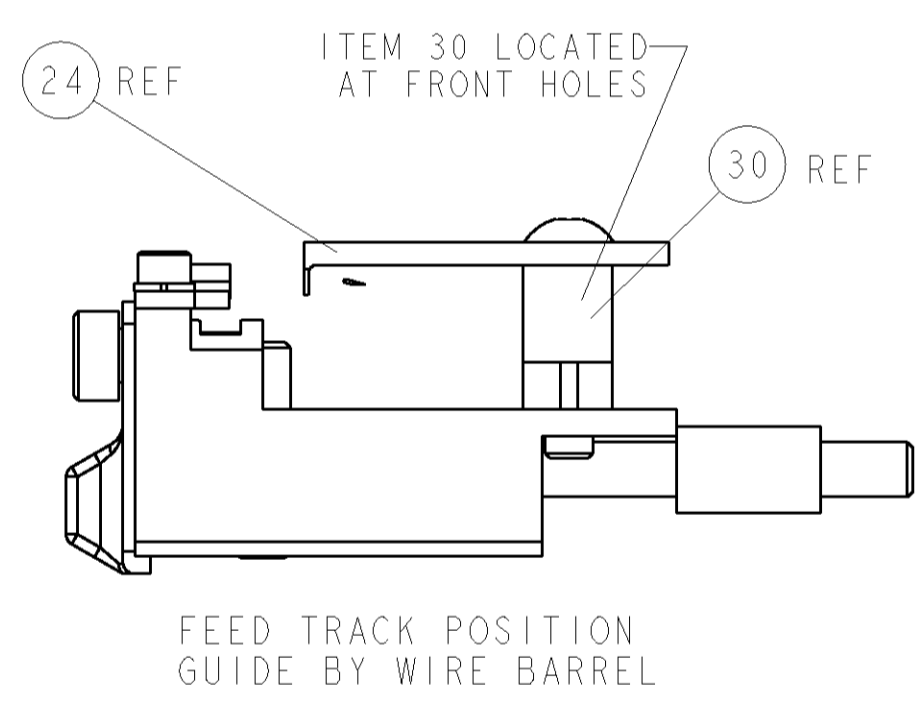
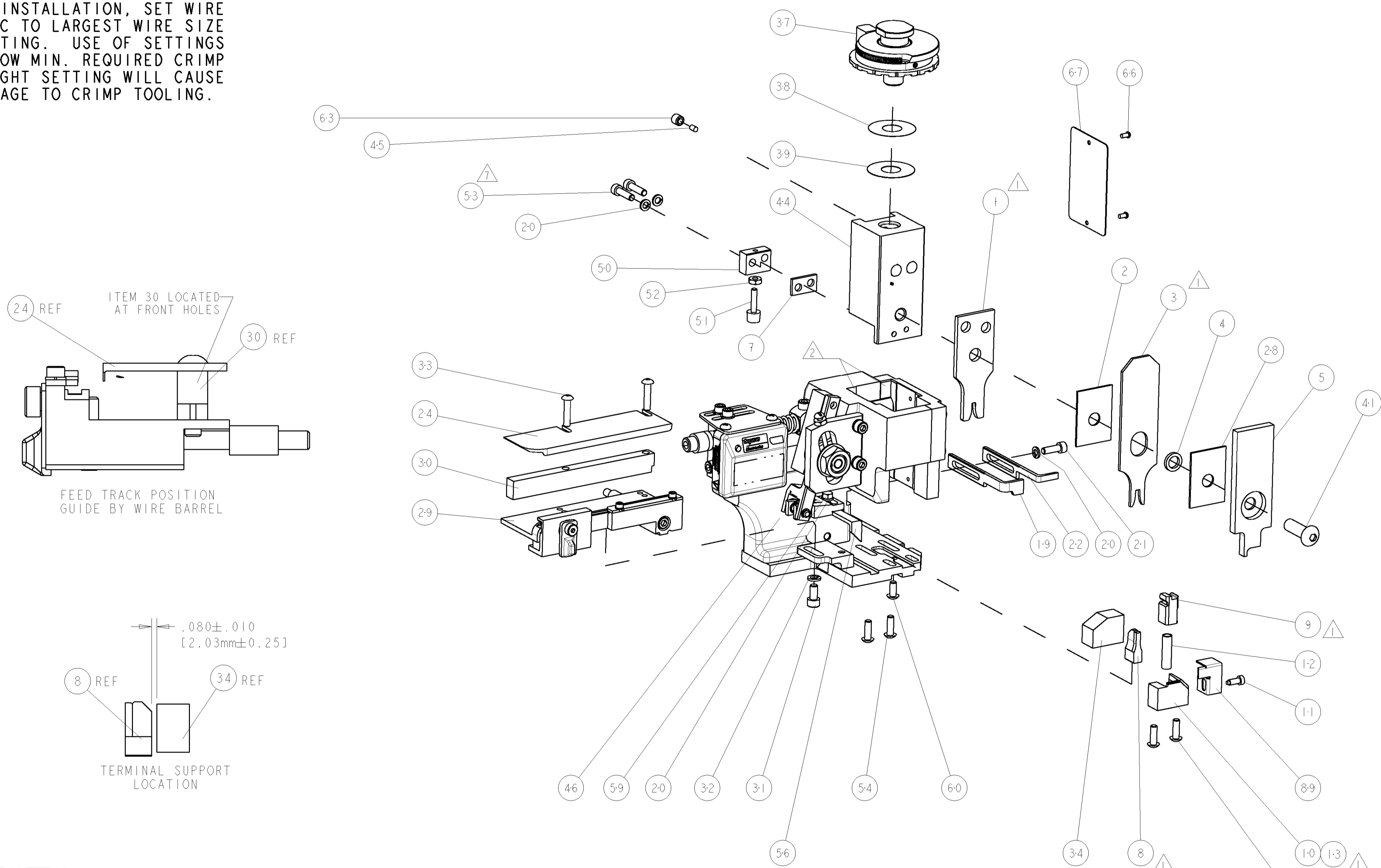


TE TERM PN		MANUF PN		FCI TERMINAL - TE CRIMP SPECS		REF SETTING
1949503-1	-	60010541	-	CRIMP HEIGHT	WIRE SIZE	B 5
-	-	-	-	1.91±0.05mm [.075±.002]	2.5mm <sup>2</sup>	-
-	-	-	-	1.57±0.05mm [.062±.002]	1.5mm <sup>2</sup>	E 0
CRIMP	SIZE	TYPE	RANGE			
-	2.54mm [.100]	F	>1.00-2.50			
-	3.30mm [.130]	F	3.00 MAX			
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPLICATOR INSTRUCTIONS	SET UP GAGE		
3.80-4.20	-	12.5	408-8040	458637-1		

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A	66	-	SEE ECO-07-022859	28SEP2007	LJL	MC

- △ RECOMMENDED SPARE PARTS
- △ GREASE LIGHTLY
- △ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
- △ CRIMP DATA CALCULATED BY TYCO ELECTRONICS.
- △ WIRE AND INSULATION RANGE ARE THAT OF THE TERMINAL. APPLICATOR DESIGNED TO APPLY FLRY TYPE INSULATION.
- △ CUT TO LENGTH AT ASSEMBLY.

**\* 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.



3	-	-	-	REF	-	..	455749-1	GUARD WINDOW	116
3	-	-	-	REF	-	..	679532-1	INSERT, GUARD	115
-	1	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
7	2	2	2	2	2	-	2-21000-8	SCR, SKT HD CAP 8-32 X .625	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
-	-	-	-	-	-	..	690602-6	CAM, PRE FEED, 1 5/8	49
-	-	-	-	-	-	..	690602-5	CAM, PRE FEED, 1 1/8	48
-	1	-	-	-	-	-	690501-4	CAM, POST FEED, 1 5/8	47
-	1	1	1	1	1	-	459456-1	APPL. BASIC SUB ASSY (SIDE WISE MOCA)	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	-	469367-2	SHIM	38
-	1	1	1	1	1	-	879103-2	FINE ADJUST HEAD ASSEMBLY	37
-	1	1	1	1	1	-	2-690786-3	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	-	1320908-1	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	-	1633091-3	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	-	-	-	-	-	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
-	-	-	-	-	-	-	691353-1	STRIPPER	19
△	1	1	1	1	1	-	679625-1	SHEAR HOLDER, FRONT (NO CUT)	13
△	1	1	1	1	1	-	3-22280-3	SPRING, COMPRESSION	12
△	1	1	1	1	1	-	690461-1	STOP, SHEAR	11
△	-	-	-	-	-	-	690459-1	SHEAR HOLDER, FRONT	10
△	1	1	1	1	1	-	454276-1	FLOATING SHEAR, FRONT	9
△	1	1	1	1	1	-	2-1633111-2	ANVIL, COMBINATION .100	8
-	1	1	1	1	1	-	1-240641-3	SPACER	7
-	-	-	-	-	-	..	-	-	6
-	1	1	1	1	1	-	2-455889-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	-	238011-7	BLOCK, CRIMPER SPACER	4
△	1	1	1	1	1	-	6-456134-9	CRIMPER, INSULATION F PREMIUM	3
△	1	1	1	1	1	-	455888-9	SPACER, CRIMPER	2
△	1	1	1	1	1	-	1-456407-3	CRIMPER, WIRE PREMIUM	1

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DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN L LOFTHOUSE		Tyco Electronics Harrisburg, PA 17105-3608	
0 PLC	±	1 PLC	±0.1	2 PLC	±0.01	3 PLC	±0.001
4 PLC	±0.001	ANGLES	±0.0001	NAME: FINE ADJUST SIDE FEED HDM APPLICATOR			
MATERIAL		FINISH		WEIGHT		RESTRICTED TO	
-		-		-		-	
CUSTOMER DRAWING				SCALE 3:5		SHEET 1 OF 1 REV A	

CUSTOMER VIEWABLE ASSEMBLY