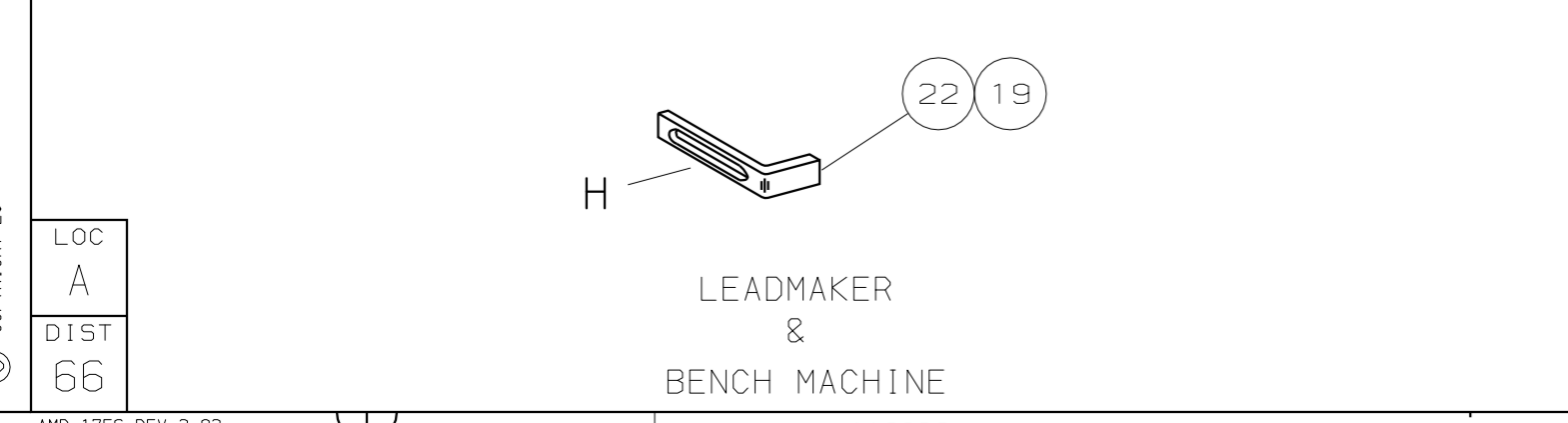
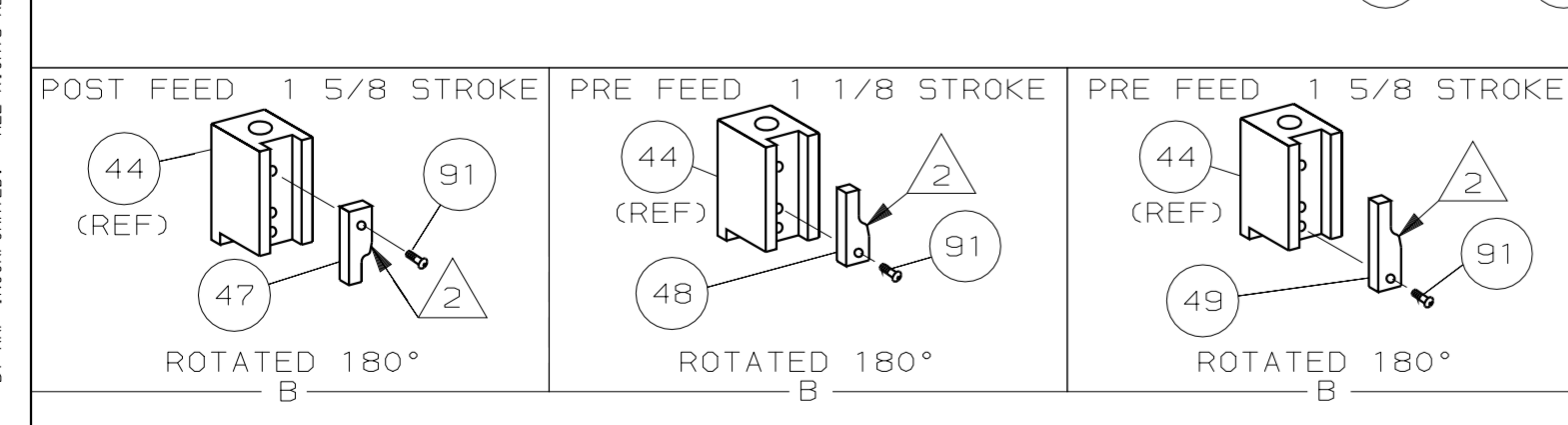
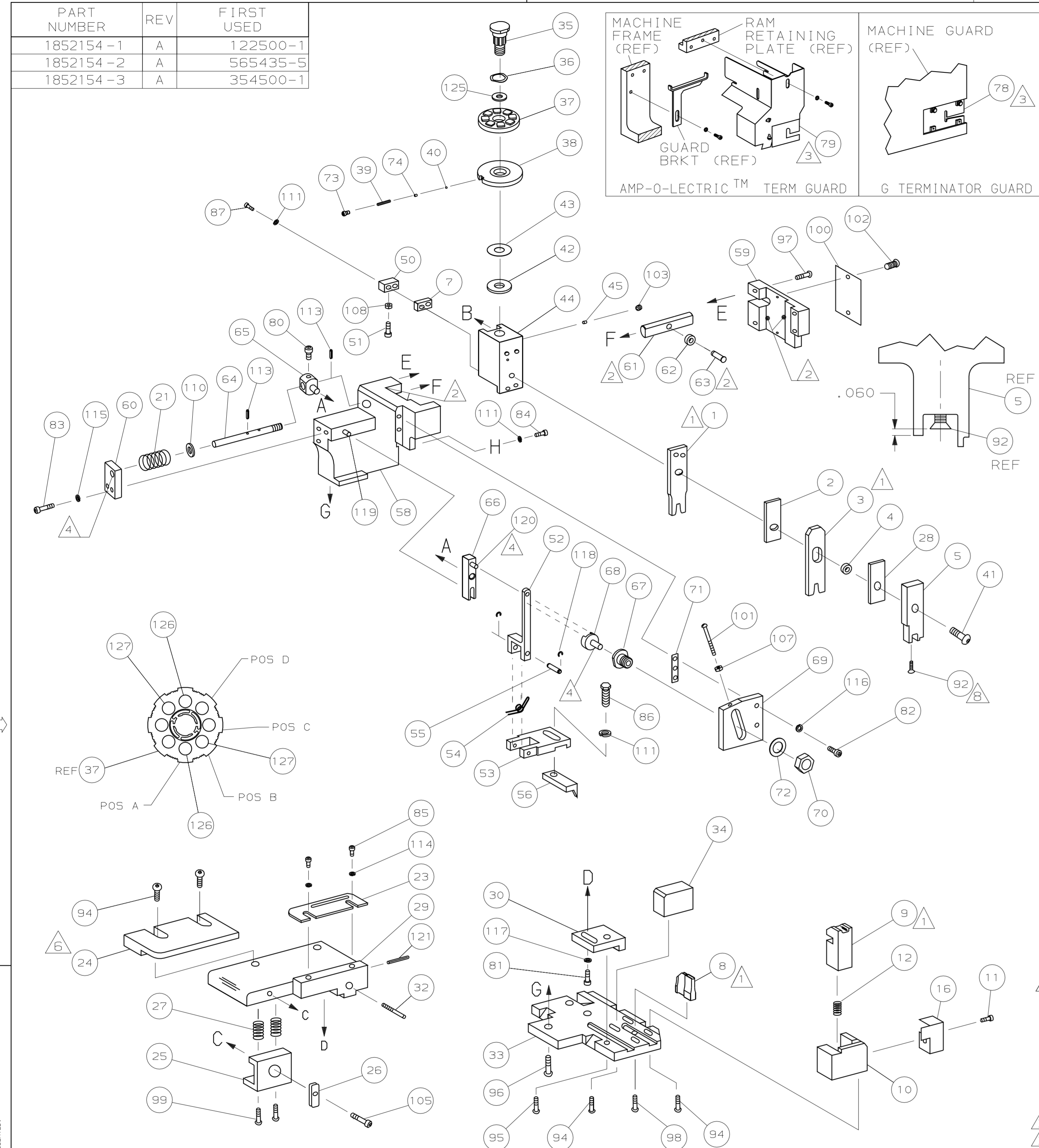


PART NUMBER	REV	FIRST USED
1852154-1	A	122500-1
1852154-2	A	565435-5
1852154-3	A	354500-1



- 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 MAY NEED TO ADJUST FOR DIFFERENT TERMINAL.
- 7 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 8 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY PN 1-23419-5 LOC-TITE TO THREADS.
- 9 CUT TO LENGTH AT ASSY

AMP SEAL PN			MFR SEAL PN		
286968			15366065		

WIRE STRIP LENGTH	TERM APPL	SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.210-.230	NONE		.548	408-8040	458637-1	L1852154

QTY	REF	REF	REF	REF	REF	REF	DESCRIPTION	ITEM NO
129								129
2	2	2	-	C	2-354779-5		PIN, WIRE DISC (.3115)B	127
2	2	2	-	C	1-354779-0		PIN, WIRE DISC (.3040)A	126
1	1	1	-	A	986950-1		WASHER, FLAT PRECISION	125
1	1	1	-	A	217238-1		GENERAL INSTRUCTION PACKAGE	124
1	1	1	-	-	4088040		SF APPL INST 408-8040	123
1	1	1	-	A	4-21028-0		PIN,SLT SPR(φ.093x.75)ST 6DE PL	121
REF	REF	REF	-	A	1-21030-1		PIN,DOWEL(φ.187x.50)LEVER	120
REF	REF	REF	-	A	1-21030-6		PIN,DOWEL(φ.187x1.25)HOUSING	119
REF	REF	REF	-	A	21045-3		RING,RET "C"(φ.187)FD FING PIN	118
1	1	1	-	A	21024-5		WASHER, LOCK(#10)ADJ BLOCK	117
REF	REF	REF	-	A	21024-5		WASHER,LOCK(#10)ADJ PLATE	116
REF	REF	REF	-	A	21024-5		WASHER,LOCK(#10)FEED GDE ROD	115
2	2	2	-	A	21024-2		WASHER,LOCK(#4)FRONT ST GUIDE	114
REF	REF	REF	-	A	5-21028-1		PIN,SLT SPR(φ.125x.50)ADJ ROD	113
								112
4	4	4	-	A	21024-4		WASHER, LOCK(#8)STRIPPER	111
REF	REF	REF	-	A	21899-4		WASHER, FLAT(φ5/16)SCREW ADJ	110
								109
1	1	1	-	A	21018-5		NUT, HEX(NO.6)HOLDDOWN	108
REF	REF	REF	-	A	21068-5		NUT, HEX(6-32)FEED ADJ	107
								106
1	1	1	-	A	22353-8		SCR,SHLD(φ.187x.25)DRAG LEVER	105
								104
1	1	1	-	A	21009-2		SCR,SKT SET(1/4-20x.25 LW)RAM	103
2	2	2	-	A	21017-2		SCR,DRIVE(#2x.19)ID PLATE	102
REF	REF	REF	-	A	6-23715-5		SCR,PAN HD(6-32x1.50)FEED ADJ	101
1	1	1	-	B	461264-1		PLATE, IDENTIFICATION	100
2	2	2	-	A	3-21002-0		SCR,BHC(10-32x.88)DRAG	99
1	1	1	-	A	22733-8		SCR,BHC(8-32x.38 LW)ANVIL	98
REF	REF	REF	-	1	2-21002-9		SCR,BHC(10-32x.75)CAP	97
REF	REF	REF	-	A	2-22733-8		SCR,BHC(1/4-20x.62)HOUSING	96
REF	REF	REF	-	A	2-21002-7		SCR,BHC(10-32x.50)SG ADJ BLOCK	95
6	6	6	-	A	2-21002-2		SCR,BHC(8-32x.50)TERM H DWN	94
								93
1	1	1	-	A	1-21003-9		SCR,FHC(6-32x.38)DEP	92
1	1	1	-	A	1-21002-7		SCR,BHC(6-32x.38)CAM	91
								90
								89
								88
2	2	2	-	A	2-21000-9		SCR,SHC(8-32x.75)HOLDDOWN	87
1	1	1	-	A	2-22603-0		SCR,HEX HD(8-32x.31)FEED FINGER	86
2	2	2	-	A	1-21000-3		SCR,SHC(4-40x.25)FR ST GUIDE	85
1	1	1	-	A	2-21000-7		SCR,SHC(8-32x.50)STRIPPER	84
REF	REF	REF	-	A	3-21000-7		SCR,SHC(10-32x.75)FEED ROD 6D	83
REF	REF	REF	-	A	3-21000-6		SCR,SHC(10-32x.62)FD ADJ BLK	82
1	1	1	-	A	3-21000-4		SCR,SHC(10-32x.38)SG ADJ BL	81
REF	REF	REF	-	A	3-21000-4		SCR,SHC(10-32x.38)PIVOT BLK	80
-	REF	-	-	B	455749-1		GUARD, WINDOW	79
REF	-	-	-	B	679532-1		INSERT, GUARD	78
								77
								76
								75
1	1	1	-	A	690603-1		SPRING, ASSIST	74
1	1	1	-	A	23030-1		SCR,SHC(6-32x.25 SL)INS DISC	73
REF	REF	REF	-	A	458109-1		WASHER, SPECIAL	72
REF	REF	REF	-	A	690517-1		SPACER	71
								70
								69
								68
								67
								66
								65
								64
								63
								62
								61
								60
								59
								58
								57

QTY	REF	REF	REF	REF	REF	REF	DESCRIPTION	ITEM NO
								20
								19
								18
								17
								16
								15
								14
								13
1	1	1	-	A	5-22280-0		SPRING, SHEAR	12
								11
1	1	1	-	B	690461-2		STOP, SHEAR	11
1	1	1	-	C	1-690459-0		HOLDER, SHEAR (FRONT)	10
1	1	1	-	C	318707-3		SHEAR, FLOAT (FRONT)	9
1	1	1	-	C	7-318711-9		ANVIL	8
1	1	1	-	C	2-240641-9		SPACER, DEPRESSOR (REAR)	7
								6
1	1	1	-	C	318701-1		DEPRESSOR, SHEAR (FRONT)	5
1	1	1	-	B	238011-2		SPACER, BLOCK CRIMPER	4
1	1	1	-	C	9-904741-5		CRIMPER, INSULATION	3
1	1	1	-	C	1-455888-0		SPACER, CRIMPER	2
1	1	1	-	C	6-1490019-2		CRIMPER, WIRE	1
								0

DR B.HIGMAN	03NOV05	APP T.ELBIN	03NOV05
CHK -	REL -	DATE	
NAME SIDE FEED HDM APPLICATOR		MACHINE REF MINI APPL	
SCALE		DWG NO 1852154	
SHEET 1 OF 1		REV A1	