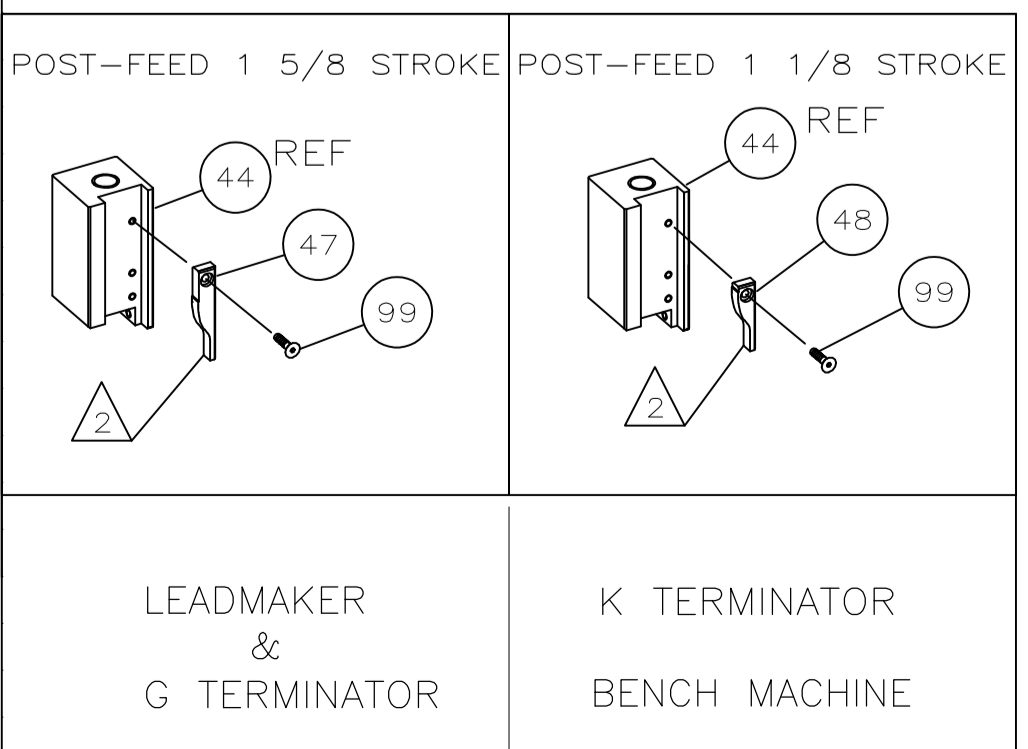
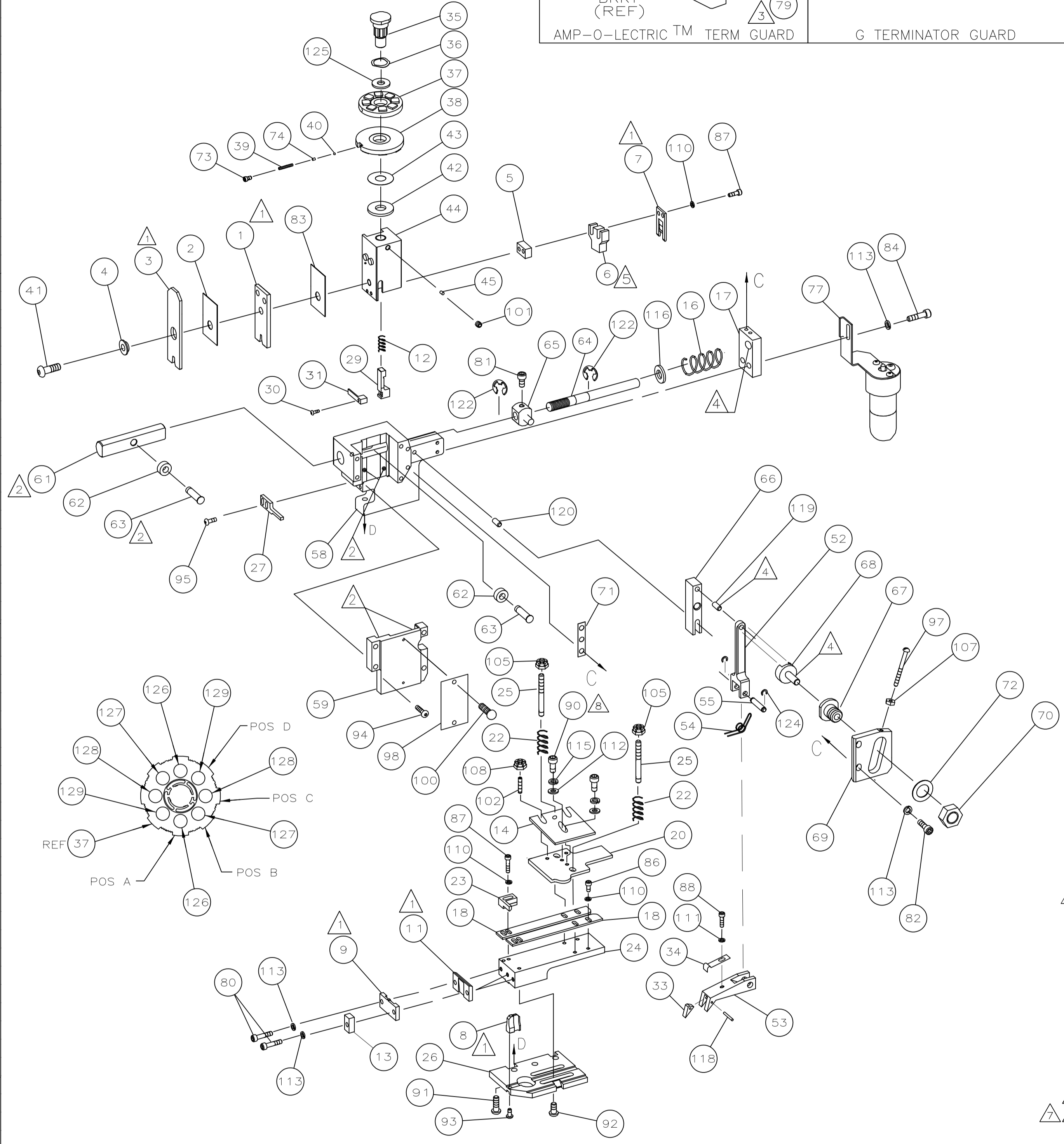


PART NUMBER	REV	FIRST USED
1852190-1	B	854400-1
1852190-2	B	565435-5
7-1852190-7	A	1852190-2



- 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 ADJUST SO THAT BOTTOM OF NEOPRENE IS APPROX .125 ABOVE BOTTOM OF SLUG BLADE POCKET.
- 6 ON LEADMAKER WITH T TERMINATING UNITS: IF TERMINAL LOCKING LANCE IS BEING BENT DOWN BEFORE ENTERING APPLICATOR, ORDER SHROUD KIT, PN 189781-1.
- 7 ITEM 78 USED WITH G TERMINATING UNIT ONLY

TERMINAL NAME: RECEPTACLE, .250 POSI LOCK	
AMP TERMINAL	AMP CRIMP SPECS
PAD LTR	CRIMP HEIGHT WIRE SIZE
A	.070 ±.002 [1.78 ±0.05mm] (2)18
B	.067 ±.002 [1.70 ±0.05mm] 16
C	.063 ±.002 [1.60 ±0.05mm] (2)20
D	.061 ±.002 [1.55 ±0.05mm]
CRIMP	SIZE TYPE RANGE
WIRE	.110 [6.35mm]
INSUL	.210 [7.87mm] F
WIRE STRIP LENGTH	TERM APPL SPEC FEED APPL INSTRUCTION SET UP GAGE LAYOUT
.188-.219	114-2074 408-8039 458638-1 L1165

-	2	2	-	C	2-354779-2	PIN, WIRE DISC (.3100)D	129	
-	2	2	-	C	1-354779-8	PIN, WIRE DISC (.3080)C	128	
-	2	2	-	C	1-354779-0	PIN, WIRE DISC (.3040)B	127	
-	2	2	-	C	354779-4	PIN, WIRE DISC (.3010)A	126	
-	1	1	-	A	986950-1	WASHER, FLAT PRECISION	125	
-	2	2	-	A	21045-3	RING, RET "C" (Ø.187)FD PIN	124	
-	2	2	-	A	1-21046-6	RING, RETAINING, EXT(5/16)FD ADJ ROD	122	
-	1	1	-	A	1-21030-7	PIN, DOWEL (Ø.187x1.50)HSG	120	
-	1	1	-	A	1-21030-1	PIN, DOWEL (Ø.187x.50)LEVER	119	
-	1	1	-	A	1-21028-9	PIN, SPRING (Ø.078x.50)TIP	118	
-	1	1	-	A	21899-4	WASHER, FLAT (Ø5/16)SCR ADJ	116	
-	2	2	-	A	21024-3	WASHER, LOCK (NO.6)PL DRAG	114	
-	6	6	-	A	21024-5	WASHER, LOCK (NO.10)SHEAR PL	113	
-	2	2	-	A	21055-5	WASHER, FLAT (NO.10)SHEAR PL	112	
-	1	1	-	A	21055-6	WASHER, FLAT (NO.8)	111	
-	7	7	-	A	21024-4	WASHER, LOCK (NO.8)SHEAR BL	110	
-	2	2	-	A	21018-4	NUT, HEX (4-40)DRAG	109	
-	1	1	-	A	21018-5	NUT, HEX (6-32)FD ADJ PL	108	
-	2	2	-	A	21022-2	NUT, HEX SL (8-32)DRAG STUD	106	
-	2	2	-	A	2-21006-6	SCR, SKT SET (4-40 X.62)DRAG	102	
-	1	1	-	A	21009-2	SCR, SKT SET (1/4-20x.25)RAM	101	
-	2	2	-	A	21017-2	SCR, DRIVE (#2x.19)ID PLATE	100	
-	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38)CAM	99	
-	1	1	-	B	461264-1	PLATE, IDENTIFICATION	98	
-	1	1	-	A	6-23715-5	SCR, PAN HD (6-32x1.50)FEED ADJ	97	
-	2	2	-	A	2-21002-2	SCR, BHC (8-32x.50)STRIPPER	96	
-	4	4	-	A	2-21002-9	SCR, BHC (10-32x.75)	94	
-	1	1	-	A	22733-8	SCR, BHC (8-32x.38 LW)ANVIL	93	
-	4	4	-	A	3-21002-3	SCR, BHC (1/4-20x.50)ST GD PL	92	
-	3	3	-	A	2-22733-8	SCR, BHC (1/4-20x.62)BASE PL	91	
-	2	2	-	A	1-21000-8	SCR, SHC (6-32 X .25)PL DRAG	90	
-	1	1	-	A	2-21000-5	SCR, SHC (8-32x.25)SWIVEL SPRING	89	
-	4	4	-	A	2-21000-9	SCR, SHC (8-32x.75)SLUG BLADE	88	
-	3	3	-	A	2-21000-6	SCR, SHC (8-32x.38)STRIP GUIDE	86	
-	2	2	-	A	3-21000-7	SCR, SKT CAP (10-32x.75)FD GDE	85	
-	1	1	-	B	455888-3	SPACER, CRIMPER	84	
-	2	2	-	A	3-21000-6	SCR, SKT CAP (10-32x.62)FD ADJ P	82	
-	1	1	-	A	3-21000-4	SCR, SKT CAP (10-32x.38)PIVOT BL	81	
-	2	2	-	A	3-21000-8	SCR, SKT CAP (10-32x.88)SH PL	80	
-	REF	-	-	A	455745-1	GUARD, WINDOW	79	
-	-	REF	-	A	679532-1	INSERT, GUARD	78	
-	1	-	-	C	465184-9	LUBRICATOR ASSY	77	
-	1	1	-	A	690603-1	SPRING, ASSIST	76	
-	1	1	-	A	23030-1	SCR, SKT CAP (6-32x.25)CP DSC	74	
-	1	1	-	A	458109-1	WASHER, FLAT (SPECIAL)	72	
-	1	1	-	A	690517-1	SPACER	71	
-77	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO	
QTY REQD PER ASSY		REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)						ITEM NO
PARTS LIST								

8 GRIND ITEM 90 FLUSH TO ITM 20 ON UNDERSIDE.

REV	DATE	BY	APPV
B	ECR-17-002010	MAR17	RS LZ

REV	DATE	BY	APPV	DESCRIPTION				
-1				LEADMAKER & BENCH MODEL G MECH POST FEED				
-2				BENCH MODEL K MECH-POST FEED				
-77				SPARE PARTS KIT				
-	1	1	-	A 22594-8 NUT, HEX 70				
-	1	1	-	B 240628-1 PLATE, ADJ 69				
-	1	1	-	B 240626-1 SHAFT, PIVOT 68				
-	1	1	-	B 240633-1 BUSHING 67				
-	1	1	-	A 455680-1 LEVER, INTERMEDIATE 66				
-	1	1	-	B 240629-1 BLOCK, PIVOT 65				
-	1	1	-	A 240632-2 SCR, ADJ 64				
-	1	1	-	B 240659-3 PIN, CAM ROLLER 63				
-	1	1	-	B 240658-1 CAM, ROLLER 62				
-	1	1	-	B 454398-1 ROD, FEED 61				
-	1	1	-	C 189467-1 CAP, RAM 60				
-	1	1	-	D 453736-1 HOUSING 59				
-	1	1	-	B 240624-1 PIN, FEED FINGER 58				
-	1	1	-	B 691499-1 SPRING, FEED FINGER 57				
-	1	1	-	B 1752620-2 FINGER, FEED 56				
-	1	1	-	B 240634-1 LEVER, TERMINAL 55				
-	1	-	-	B 690501-3 CAM, POST FEED 1 1/8 ST 54				
-	-	1	-	B 690501-4 CAM, POST-FEED 1 5/8 ST 49				
-	1	1	-	A 690191-1 PLUG, NYLON 48				
-	1	1	-	C 455674-1 RAM 47				
-	1	1	-	A 690125-1 WASHER, LAMINATED 46				
-	1	1	-	A 690124-1 WASHER, RAM 45				
-	1	1	-	A 7-21002-9 BOLT, CRIMPER (5/16-24x1.00) 44				
-	1	1	-	A 23241-6 BALL, STEEL 43				
-	1	1	-	A 690170-1 SPRING, COMPRESSION 42				
-	1	1	-	C 690142-5 DISC, INSULATION 41				
-	1	1	-	D 354777-1 WIRE DISC, PLASTIC 40				
-	1	1	-	A 22480-5 WASHER, SPRING 39				
-	1	1	-	B 690212-1 POST, RAM 38				
-	1	1	-	A3 1752621-1 SPRING, SWIVEL TIP 37				
-	1	1	-	A3 1752622-1 TIP, SWIVEL FEED FINGER 36				
-	1	1	-	A 189181-1 STRIPPER, TERMINAL 35				
-	1	1	-	A 1-21000-6 SCR, SHC (4-40 X.62)STR 34				
-	1	1	-	B 189453-1 SLIDE, STRIPPER 33				
-	1	1	-	A 189257-1 STRIPPER 32				
-	1	1	-	C 455676-1 PLATE, BASE 31				
-	2	2	-	A 22354-8 DRAG, STUD 30				
-	1	1	-	B 804823-2 PLATE, STRIP GUIDE 29				
-	1	1	-	C 568663-1 PLATE, STRIP HOLD DOWN 28				
-	2	2	-	A 1-22280-8 SPRING, DRAG 27				
-	1	1	-	A 814130-1 DRAG, STOCK 26				
-	2	2	-	C 454204-3 GUIDE STRIP, FRONT & REAR 25				
-	1	1	-	A 1804305-2 GUIDE, FEED ROD 24				
-	1	1	-	A 4-22284-9 SPRING, FEED RETURN 23				
-	1	1	-	C 683875-1 PLATE, DRAG LOCATOR 22				
-	1	1	-	C 690481-2 SPACER, HOLD DOWN 21				
-	1	1	-	A 23846-2 SPRING, HOLD DOWN 20				
-	1	1	-	B 240833-1 PLATE, REAR SHEAR 19				
-	1	1	-	B 690482-7 PLATE, FRONT SHEAR 18				
1	1	1	-	D 8-356038-9 ANVIL 17				
-	1	1	-	B 3-690474-9 BLADE, SLUG 16				
-	1	1	-	D 463460-1 HOLD DOWN, TERMINAL 15				
-	1	1	-	C 240641-7 SPACER, SLUG BLADE 14				
-	1	1	-	B 1-238009-4 SPACER, BLOCK CRIMPER 13				
1	1	1	-	C 9-1213077-9 CRIMPER, INSULATION 12				
-	1	1	-	B 455888-8 SPACER, CRIMPER 11				
1	1	1	-	C 6-456408-4 CRIMPER, WIRE 10				
-77	-2	-1	U/M	DWG SIZE PART NO DESCRIPTION ITEM NO				
QTY REQD PER ASSY		REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)						ITEM NO
PARTS LIST								

THIS DRAWING IS A CONTROLLED DOCUMENT.

DTN: R.O. WILSON 24JAN06  
 CHK: R.O. WILSON 24JAN06  
 APV: J. ELBIN 25JAN06

TE Connectivity  
 END FEED HDM APPLICATOR

SIZE: A1  
 CAGE CODE: 00779  
 DRAWING NO: 1852190

CUSTOMER DRAWING SCALE: 1 OF 1 REV: B