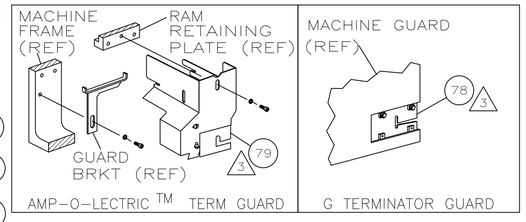
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION – ,– .
© COPYRIGHT – BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

PART NUMBER	REV	FIRST USED
1385661–1	A	122500–1
1385661–2	A	565435–5
1385661–3	A	354500–1



TERMINAL NAME: Ø.093 SOCKET

AMP TERM PN	MFR TERM PN
PIN	
1572331–1	02–09–2101
1572331–2	02–09–6100
1572331–3	02–09–6101
SOCKET	
1572332–1	02–09–1102
1572332–2	02–09–5100
1572332–3	02–09–5102
1572332–4	02–09–1205
1572332–5	02–09–5169

MOLEX TERMINAL		AMP CRIMP SPECS
PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.071 ±.002 [1.8 ±0.05mm]	14
B	.058 ±.002 [1.47 ±0.05mm]	16
C	.051 ±.002 [1.29 ±0.05mm]	18
D	.046 ±.002 [1.17 ±0.05mm]	20

CRIMP	SIZE	TYPE	RANGE
WIRE	.080 [2.03mm]	F	20–14
INSUL	.130 [3.3mm]	F	Ø.065–.161

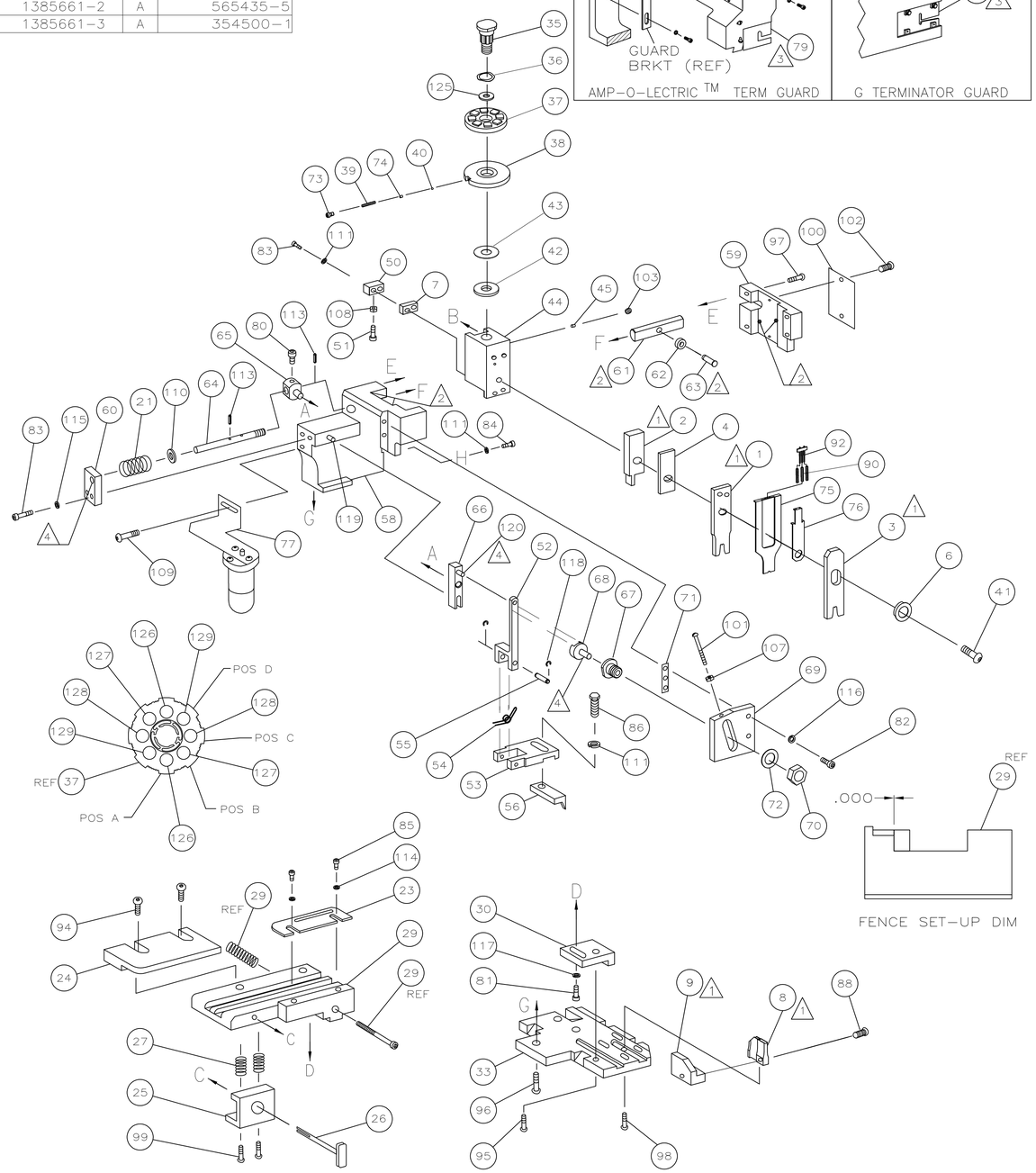
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.156–.188	NONE	.498	408–8040	458637–1	L2883

LOC	DIST
A	66

REVISIONS

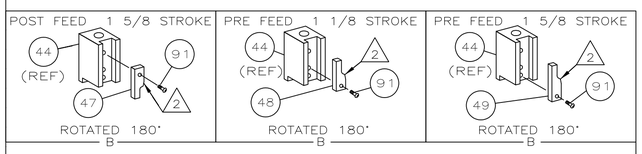
P	LTR	DESCRIPTION	DATE	DWN	APVD
	A2	ECR–07–029765	12–2007	MY	TE

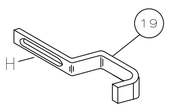
–1	LEADMAKER	MECH POST FEED
–2	BENCH MODEL K	MECH PRE FEED
–3	BENCH MODEL G	MECH PRE FEED



3	–3	–2	–1	U/M	PART NO	DESCRIPTION	ITEM NO
	2	2	2	–	3–354779–8	PIN, WIRE DISC (.3180)D	129
	2	2	2	–	2–354779–7	PIN, WIRE DISC (.3125)C	128
	2	2	2	–	1–354779–3	PIN, WIRE DISC (.3055)B	127
	2	2	2	–	8–354778–4	PIN, WIRE DISC (.2915)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
	3	3	3	–	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
	–	1	–	–	2–21002–6	SCR,BHC(10–32x.38)LUBE ASSY	109
	1	1	1	–	21018–5	NUT,HEX(6–32)	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	–	2–21002–9	SCR,BHC(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
	2	2	2	–	2–21002–2	SCR,BHC(8–32x.50)TERM H DWN	94
							93
	1	1	1	–	1424350–1	HOLDER, PIN, WIRED	92
	1	1	1	–	1–21002–7	SCR,BHC(6–32x.38)CAM	91
	3	3	3	–	2–23147–2	SPRING, DEPRESSOR	90
							89
	1	1	–	–	2–21000–7	SCR,SHC(8–32x.88)SHEAR	88
							87
	1	1	1	–	2–22603–1	SCR,HEX HD(8–32x.38)FEED FINGER	86
	2	2	2	–	1–21000–4	SCR,SHC(4–40x.50)FR ST GUIDE	85
	1	1	1	–	2–21000–7	SCR,SHC(8–32x.50)STRIPPER	84
	2	2	2	–	2–21000–8	SCR,SHC(8–32x.62)HOLDDOWN	83
	REF	REF	REF	–	3–21000–6	SCR,SHC(10–32x.62)FD ADJ BLK	82
	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
3	–	1	–	–	462992–7	GUARD ASSY	79
	REF	–	–	–	679532–1	INSERT, GUARD	78
	–	1	–	–	1–465184–0	LUBRICATOR ASSY	77
	1	1	1	–	1490524–1	SPACER, DEPRESSOR	76
	1	1	1	–	1490525–3	DEPRESSOR, WIRE	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
	–3	–2	–1	U/M	PART NO	DESCRIPTION	ITEM NO
	QTY REQD PER ASSY				PARTS LIST		

1	–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
	1	1	1	–	454220–1	CAP, RAM	59
	REF	REF	REF	–	454485–1	HOUSING	58
							57
	1	1	1	–	4–694433–4	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	–	455679–1	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	–	459456–1	APPLICATOR, BASIC (SUBASSY)	46
	1	1	1	–	690191–1	PLUG, NYLON	45
	1	1	1	–	455673–8	RAM	44
	1	1	1	–	690125–1	WASHER, LAMINATED	43
	1	1	1	–	690124–1	WASHER, RAM	42
	1	1	1	–	690686–2	BOLT, CRIMPER(5/16x1.10)	41
	1	1	1	–	23241–6	BALL, STEEL	40
	1	1	1	–	690170–1	SPRING, COMPRESSION	39
	1	1	1	–	1–690142–1	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
							34
	REF	REF	REF	–	455675–1	PLATE, BASE	33
							32
							31
	REF	REF	REF	–	455689–1	BLOCK, STRIP GUIDE ADJ	30
	1	1	1	–	1–318756–4	PLATE, STRIP GUIDE	29
							28
	2	2	2	–	8–22281–7	SPRING, DRAG	27
	1	1	1	–	690546–1	LEVER, DRAG RELEASE	26
	1	1	1	–	2–690754–1	DRAG, TERMINAL	25
	1	1	1	–	1320860–2	GUIDE, STRIP (REAR)	24
	1	1	1	–	1–690712–6	GUIDE, STRIP (FRONT)	23
							22
	REF	REF	REF	–	4–22284–9	SPRING, FEED RETURN	21
							20
	1	1	1	–	1–458230–5	STRIPPER	19
							18
							17
							16
							15
							14
							13
							12
							11
							10
1	1	1	1	–	2–853714–0	PLATE, REAR SHEAR	9
	1	1	1	–	1633054–2	ANVIL	8
	1	1	1	–	240641–7	SPACER, DEPRESSOR (REAR)	7
	1	1	1	–	238009–4	SPACER, BLOCK CRIMPER	6
							5
	1	1	1	–	455888–2	SPACER, CRIMPER	4
1	1	1	1	–	6–456134–6	CRIMPER, INSULATION	3
1	1	1	1	–	1–853720–4	BLADE, SLUG	2
	1	1	1	–	3–456405–9	CRIMPER, WIRE	1
	–3	–2	–1	U/M	PART NO	DESCRIPTION	ITEM NO
	QTY REQD PER ASSY				PARTS LIST		





BENCH MACHINE LEADMAKER

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.

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ± –
1 PLC ± –
2 PLC ± .25
3 PLC ± .020
4 PLC ± –
ANGLES ± –

MATERIAL –
FINISH –

DWN C.ERISMAN 23SEPT02
CHK C.ERISMAN 23SEPT02
APVD T.ELBIN 23SEPT02
PRODUCT SPEC –
APPLICATION SPEC –
WEIGHT –

Tyco Electronics
Tyco Electronics Corporation
Harrisburg, PA 17105–3608

NAME
SIDE FEED HDM APPLICATOR
–
–

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C–1385661	–

CUSTOMER DRAWING | SCALE – | SHEET 1 OF 1 | REV A2