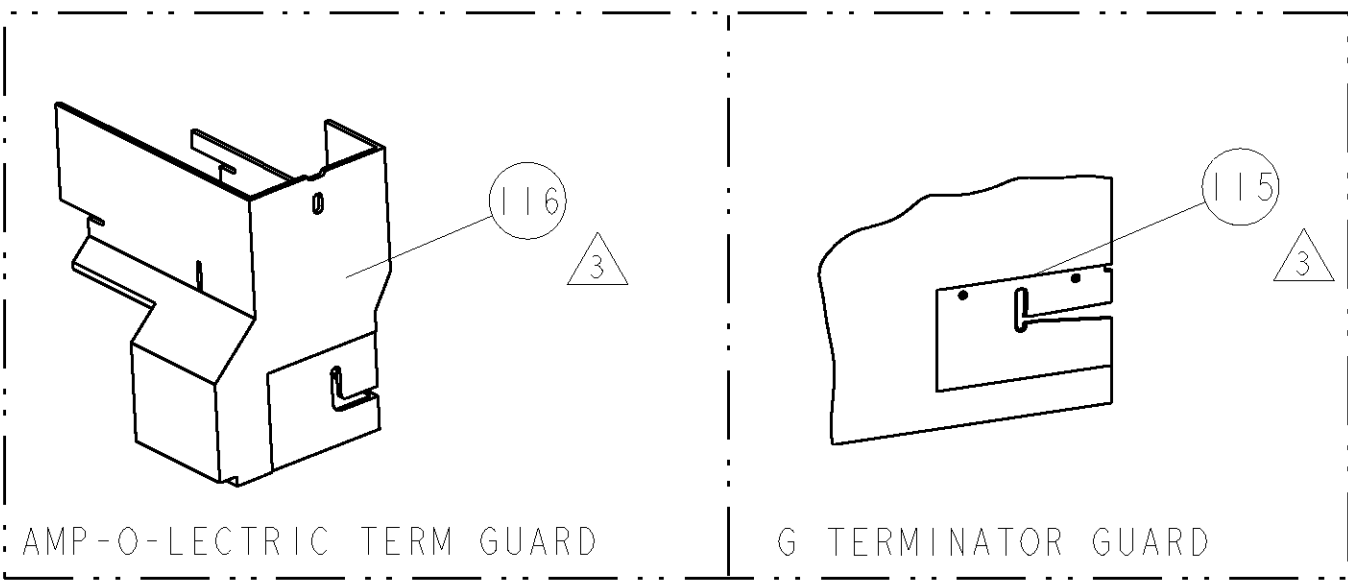
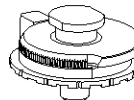


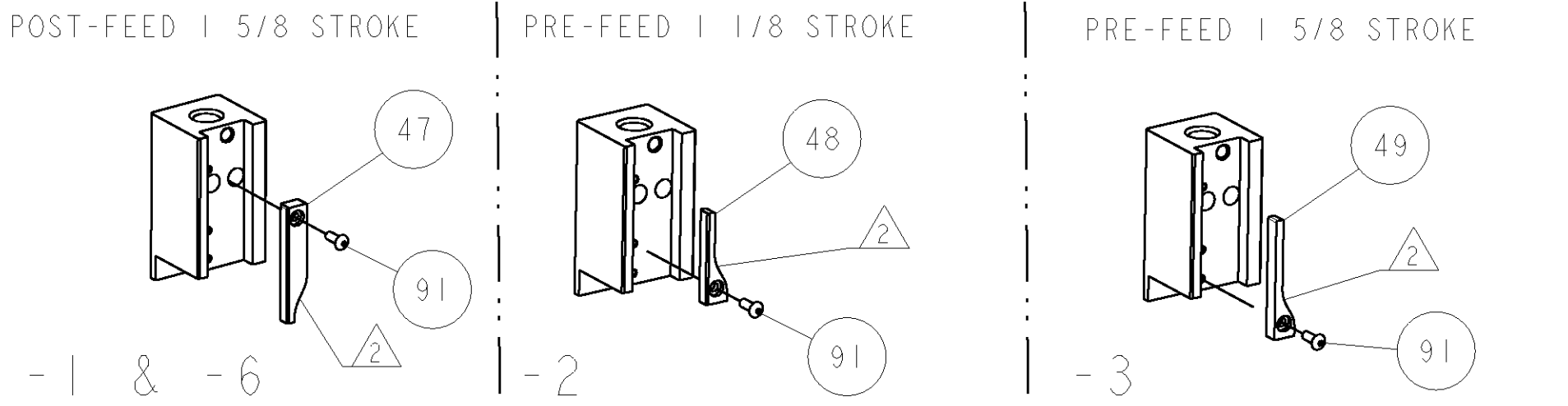
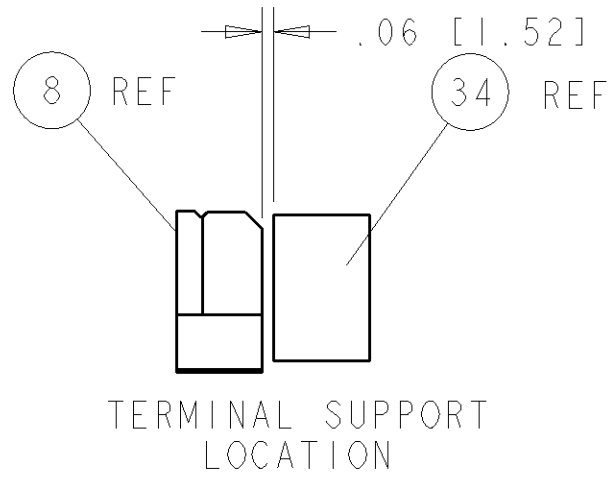
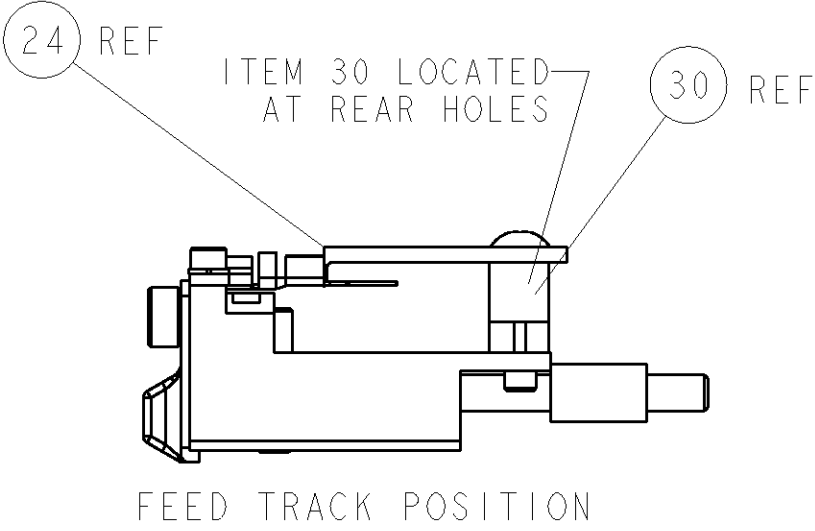
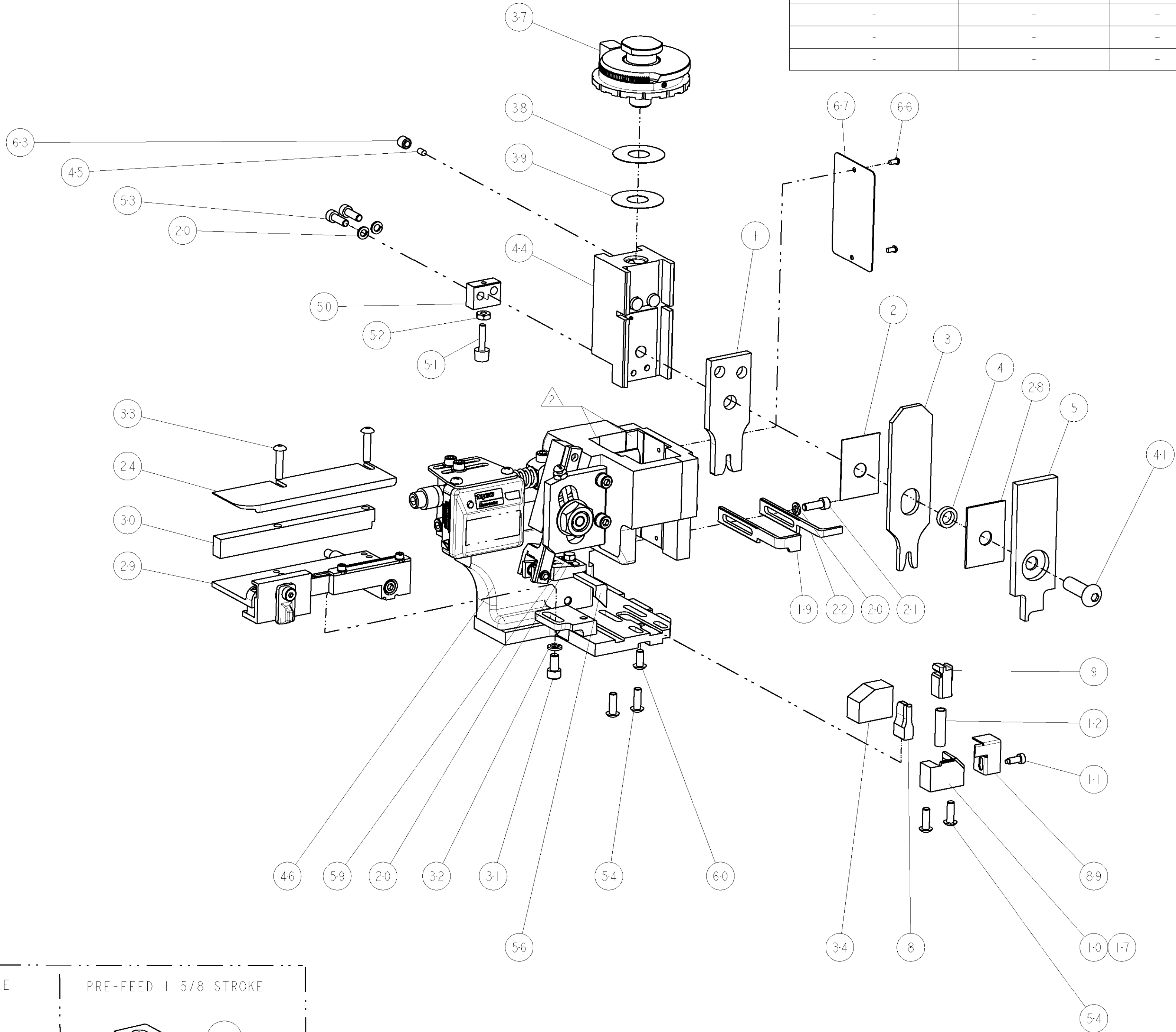
8				7			
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PART NUMBER		REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION	
1852412-1		A	122500-1	LEADMAKER	POST FEED	CUTS CARRIER	
1852412-2		A	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER	
1852412-3		A	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER	
1852412-6		A	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER	
7-1852412-7		A	-	-	-	SPARE PARTS	

- △ RECOMMENDED SPARE PARTS
- △ GREASE LIGHTLY
- △ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE

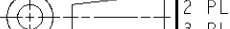
*** WARNING**
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN. REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



TERMINAL NAME: AMPLIVAR, (M3.5) RING TONGUE					
TYCO PN		AMP TERMINAL - AMP CRIMP SPECS			
1930001	-				REF SETTING
-	-	CRIMP HEIGHT		WIRE SIZE	
-	-	1.95±0.05mm [1.077±.002]		1.65mm Mag Wire	B-2
-	-	1.88±0.05mm [1.074±.002]		1.54mm Mag Wire	B-8
-	-	1.82±0.05mm [1.072±.002]		1.45mm Mag Wire	C-2
-	-	1.77±0.05mm [1.070±.002]		1.37mm Mag Wire	C-7
-	-	CRIMP	SIZE	TYPE	RANGE
-	-	WIRE	2.69mm [1.106]	F	1.0-1.65mm
-	-	INSUL	3.56mm [1.140]	O	Ø2.7 MAX
WIRE STRIP LENGTH 5.66-6.04	TERM APPL SPEC 114-58505	FEED 12.5	APPLICATOR INSTRUCTIONS 408-8040		SET UP GAGE 458637-1
ADDITIONAL CRIMP HEIGHTS					
CRIMP HEIGHT		WIRE SIZE		REF SETTING	
1.73±0.05mm [1.068±.002]		1.29mm Mag Wire		D-0	
1.69±0.05mm [1.067±.002]		1.22mm Mag Wire		D-3	
1.66±0.05mm [1.065±.002]		1.15mm Mag Wire		D-5	
1.63±0.05mm [1.064±.002]		1.09mm Mag Wire		D-7	
1.60±0.05mm [1.063±.002]		1.02mm Mag Wire		E-0	
-		-		-	
-		-		-	
-		-		-	



△	-	-	-	REF	-	..	455749-1	GUARD WINDOW	116
△	-	-	REF	-	-	..	679532-1	INSERT, GUARD	115
	-	1	1	1	1	-	1-21002-7	SCR, BTN SKT HD CAP 6-32 X .375	91
	-	1	1	1	1	-	318563-1	GUARD, FRONT CHIP	89
	-	1	1	1	1	-	4088040	SF APPL INST 408-8040	72
	-	1	1	1	1	-	217238-1	GENERAL INSTRUCTION PKG	71
	-	1	1	1	1	-	461264-5	PLATE, IDENTIFICATION	67
	-	2	2	2	2	-	21017-2	SCREW, DRIVE	66
	-	1	1	1	1	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	63
	-	1	1	1	1	-	22733-8	SCR, BHSC, SELF-LOCKING, 8-32 X .375	60
	-	1	1	1	1	-	2-22603-0	SCR, HEX HD CAP 8-32 X .312	59
	-	1	1	1	1	-	458537-2	PAWL, FEED	56
	-	4	4	4	4	-	2-21002-2	SCR, BTN SKT HD CAP 8-32 X .500	54
	-	2	2	2	2	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	53
	-	1	1	1	1	-	21018-5	NUT, HEX, REG 6-32	52
	-	1	1	1	1	-	811242-2	BUMPER, HOLD DOWN	51
	-	1	1	1	1	-	690753-1	SPACER, TONKER	50
	-	-	1	-	-	..	690602-6	CAM, PRE FEED, 1 5/8	49
	-	-	-	1	-	..	690602-5	CAM, PRE FEED, 1 1/8	48
	-	1	-	-	1	-	690501-4	CAM, POST FEED, 1 5/8	47
	-	1	1	1	1	-	459456-1	APPL. BASIC SUB ASSY (SIDE WISE MOCA)	46
	-	1	1	1	1	-	690191-1	PLUG, NYLON	45
	-	1	1	1	1	-	819307-1	RAM, SIDE FEED	44
	-	1	1	1	1	-	7-21002-9	SCR, BTN SKT HD CAP 5/16-24 X 1.00	41
	-	1	1	1	1	-	690125-1	SHIM SUB-ASSY	39
	-	1	1	1	1	-	469367-1	SHIM	38
	-	1	1	1	1	-	879103-3	FINE ADJUST HEAD ASSEMBLY	37
	-	1	1	1	1	-	690786-3	TERMINAL SUPPORT	34
	-	2	2	2	2	-	2-21002-4	SCR, BTN SKT HD CAP 8-32 X .750	33
	-	1	1	1	1	-	21024-5	WASHER, SPRG LOCK, REG NO 10	32
	-	1	1	1	1	-	3-21000-4	SCR, SKT HD CAP 10-32 X .375	31
	-	1	1	1	1	-	1320908-4	SPACER, STRIP GUIDE	30
	-	1	1	1	1	-	1633091-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	-	1-455888-0	SPACER, CRIMPER	28
	-	1	1	1	1	-	1320928-1	PLATE, STRIP GUIDE	24
	-	1	-	-	1	-	690472-2	STRIPPER	22
	-	1	1	1	1	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	21
	-	4	4	4	4	-	21024-4	WASHER, SPRG LOCK, REG NO 8	20
	-	-	1	1	-	-	691353-1	STRIPPER	19
	-	1	-	-	-	-	679625-1	SHEAR HOLDER, FRONT (NO CUT)	17
	-	1	1	1	1	-	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	-	690461-1	STOP, SHEAR	11
	-	-	1	1	1	-	690459-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	-	1-454276-9	FLOATING SHEAR, FRONT	9
	1	1	1	1	1	-	1633535-1	ANVIL, COMBINATION	8
	-	1	1	1	1	-	2-455889-0	DEPRESSOR, SHEAR	5
	-	1	1	1	1	-	238011-2	BLOCK, CRIMPER SPACER	4
	1	1	1	1	1	-	456135-6	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	-	455888-4	SPACER, CRIMPER	2
	1	1	1	1	1	-	5-1673600-4	CRIMPER, WIRE	1

THIS IS THE ONLY DRAWING TO BE USED FOR THE MANUFACTURE OF THIS PRODUCT. ANY OTHER DRAWING OR MODIFICATION SHOULD BE CONTACTED FOR THE LATEST REVISION.				DAN M. HERR 09FEB2007		tyco Electronics Tyco Electronics Harrisburg, PA 17105-3608			
DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHKD T. ELBIN 09FEB2007		NAME T. BENCHOFF			
		9 PLC ±.01		PRODUCT SPEC		FINE ADJUST SIDE FEED HDM APPLICATOR - - - -			
		1 PLC ±0.1		APPLICATION SPEC					
		2 PLC ±0.01							
		3 PLC ±0.001							
4 PLC ±0.0001									
ANGLES		FINISH		WEIGHT		SIZE CAGE CODE DRAWING NO			
MATERIAL						RESTRICTED TO			
-		-		-		A1 00779 C=1852412			
CUSTOMER DRAWING						SCALE 3:5 SHEET 1 OF 1 REV A			

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