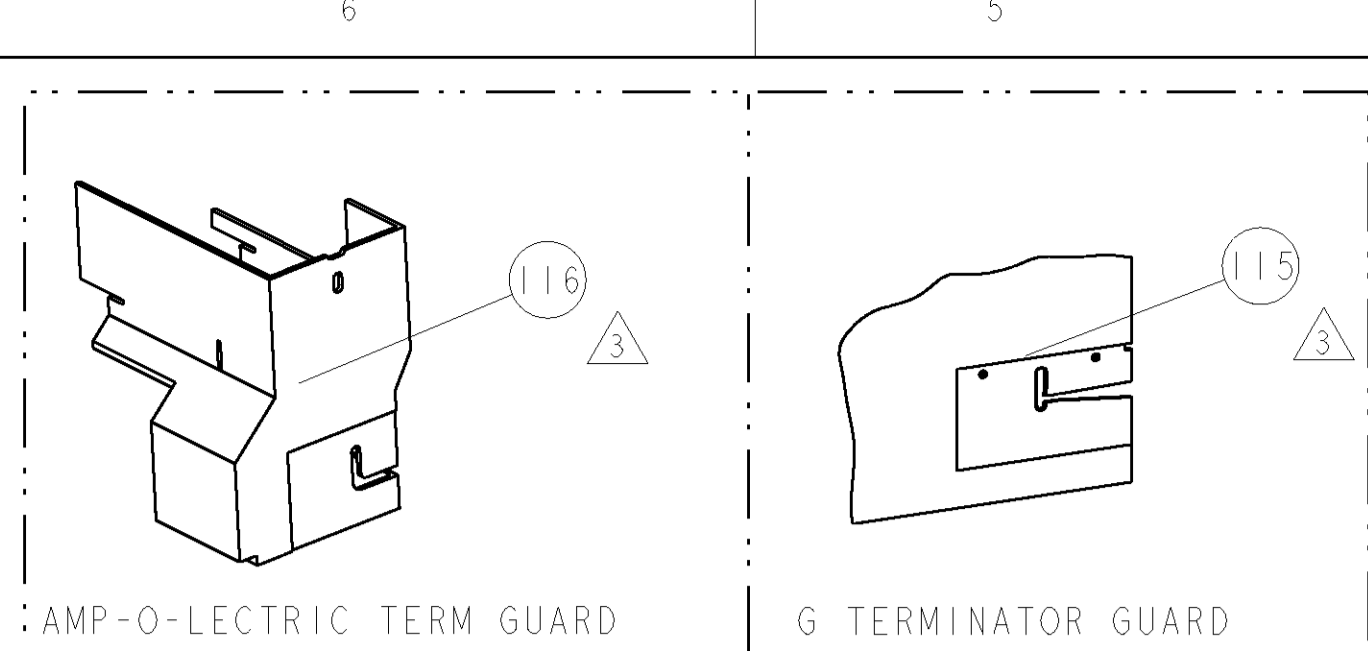


PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1855117-1	A	122500-1	LEADMAKER	POST FEED	CUTS CARRIER
1855117-2	A	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER
1855117-3	A	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER
1855117-6	A	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER
7-1855117-7	A	-	-	-	SPARE PARTS

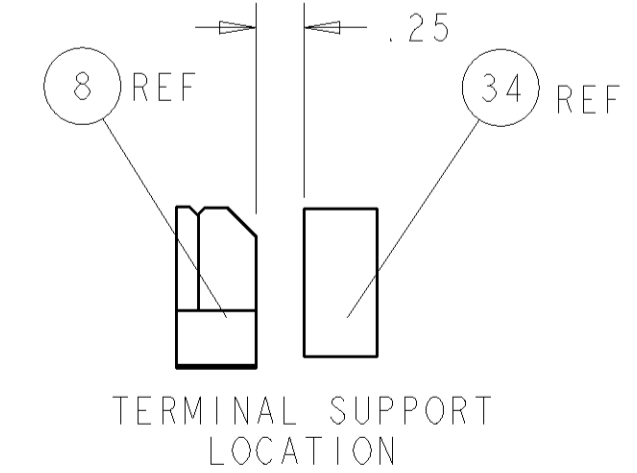
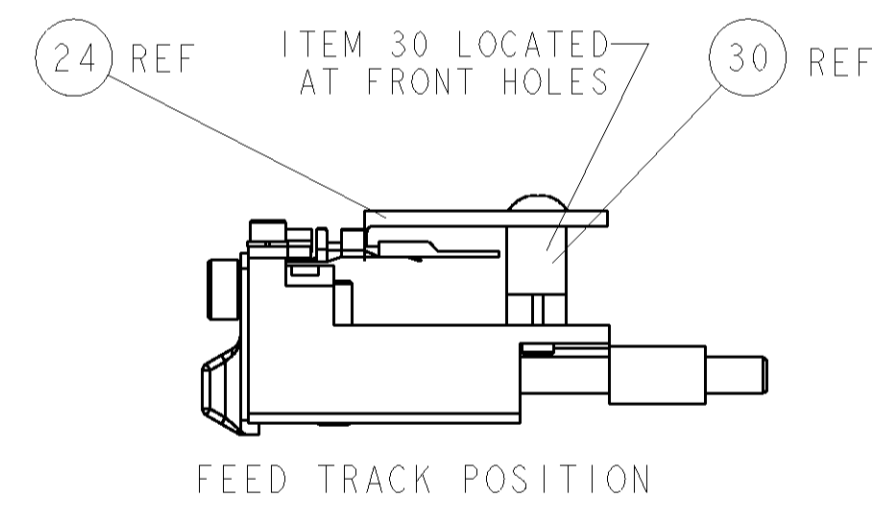
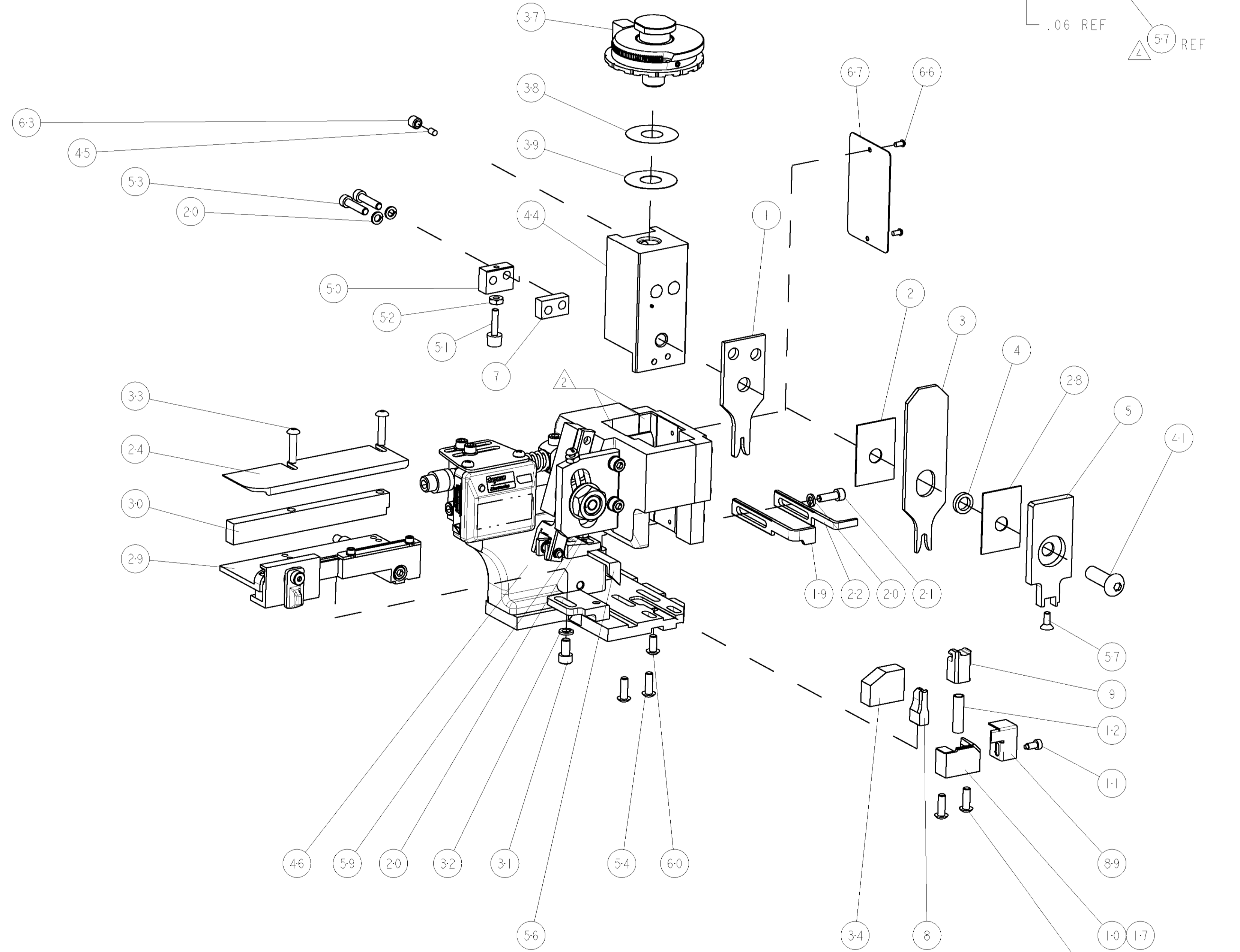
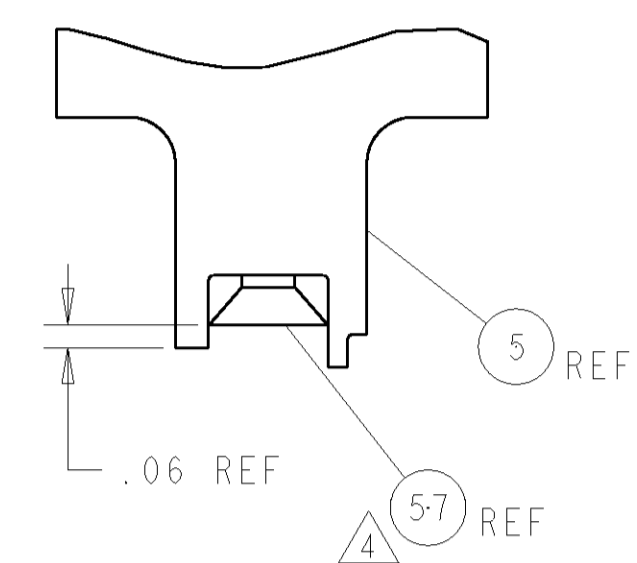


TERMINAL NAME: TERMINAL		FURUKAWA TERMINAL - AMP CRIMP SPECS			
TYCO PN	MFG PN	CRIMP HEIGHT	WIRE SIZE	REF SETTING	
1572252	FW-M-200	1.85±0.05mm [.073±.002]	2mm2	A4	
-	-	1.45±0.05mm [.057±.002]	1.25mm2	D3	
-	-	-	-	-	
-	-	-	-	-	
SEAL PN.	-	CRIMP	SIZE	TYPE	RANGE
1572251	FW-W-201	WIRE	1.93mm [.076]	F	1.25-2.00mm2
-	-	INSUL	3.71mm [.146]	O	∅3.80mm MAX
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPLICATOR INSTRUCTIONS	SET UP GAGE	
3.99-4.37mm	NONE	11.1mm	408-8040	458637-1	

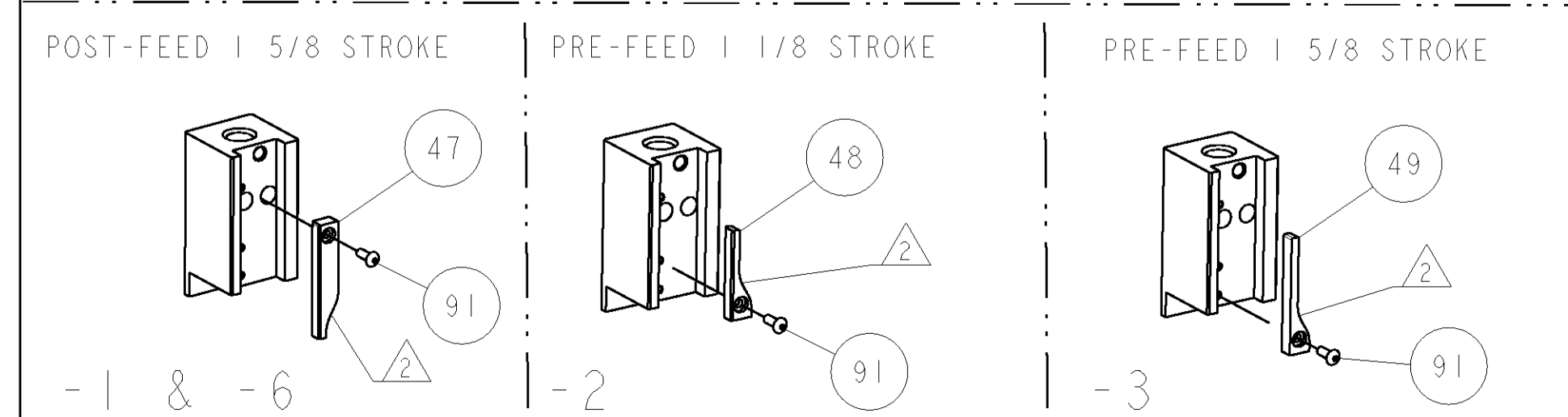
LOC	DIST	REV	DESCRIPTION	DATE	DWN	APVD
A	66		RELEASED	20SEP2006	LG	GB

- RECOMMENDED SPARE PARTS
- GREASE LIGHTLY
- GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
- 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.
- IF THE INSULATION DIAMETER IS LESS THAN 2.6mm THE INSULATION HEIGHT SHOULD BE 3.9±0.1mm. IF THE INSULATION DIAMETER IS BETWEEN 2.6-2.9mm THE INSULATION HEIGHT SHOULD BE 4.0±0.1mm

*** 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.



QTY	REF	DESCRIPTION	ITEM NO
-	-	455749-1 GUARD WINDOW	116
-	REF	679532-1 INSERT, GUARD	115
-	-	1-21002-7 SCR, BTN SKT HD CAP 6-32 X .375	91
-	-	318563-1 GUARD, FRONT CHIP	89
-	-	4088040 SF APPL INST 408-8040	72
-	-	217238-1 GENERAL INSTRUCTION PKG	71
-	-	461264-5 PLATE, IDENTIFICATION	67
-	2	21017-2 SCREW, DRIVE	66
-	-	21009-2 SCR, SET, SELF LOCKING 1/4-20 X .250	63
-	-	22733-8 SCR, BHSC, SELF-LOCKING, 8-32 X .375	60
-	-	2-22603-0 SCR, HEX HD CAP 8-32 X .312	59
-	-	1-21003-9 SCR, FLT SKT HD CAP 6-32 X .375	57
-	-	458537-2 PAWL, FEED	56
-	4	2-21002-2 SCR, BTN SKT HD CAP 8-32 X .500	54
-	2	2-21000-9 SCR, SKT HD CAP 8-32 X .750	53
-	-	21018-5 NUT, HEX, REG 6-32	52
-	-	811242-2 BUMPER, HOLD DOWN	51
-	-	690753-1 SPACER, TONKER	50
-	-	690602-6 CAM, PRE FEED, 1 5/8	49
-	-	690602-5 CAM, PRE FEED, 1 1/8	48
-	-	690501-4 CAM, POST FEED, 1 5/8	47
-	-	459456-2 APPL. BASIC SUB ASSY (SIDE WISE MOCA)	46
-	-	690191-1 PLUG, NYLON	45
-	-	455673-1 RAM, SIDE FEED	44
-	-	7-21002-9 SCR, BTN SKT HD CAP 5/16-24 X 1.00	41
-	-	690125-1 SHIM SUB-ASSY	39
-	-	469367-2 SHIM	38
-	-	879103-2 FINE ADJUST HEAD ASSEMBLY	37
-	-	690786-1 TERMINAL SUPPORT	34
-	2	2-21002-4 SCR, BTN SKT HD CAP 8-32 X .750	33
-	-	21024-5 WASHER, SPRG LOCK, REG NO 10	32
-	-	3-21000-4 SCR, SKT HD CAP 10-32 X .375	31
-	-	1320908-8 SPACER, STRIP GUIDE	30
-	-	1633091-1 ASSEMBLY, STRIP GUIDE	29
-	-	455888-6 SPACER, CRIMPER	28
-	-	1320928-1 PLATE, STRIP GUIDE	24
-	-	690472-2 STRIPPER	22
-	-	2-21000-7 SCR, SKT HD CAP 8-32 X .500	21
-	4	21024-4 WASHER, SPRG LOCK, REG NO 8	20
-	-	691353-1 STRIPPER	19
-	-	679625-2 SHEAR HOLDER, FRONT (NO CUT)	17
-	-	3-22280-3 SPRING, COMPRESSION	12
-	-	690461-2 STOP, SHEAR	11
-	-	1-690459-0 SHEAR HOLDER, FRONT	10
-	-	318707-1 FLOATING SHEAR, FRONT	9
-	-	7-1633116-7 ANVIL, COMBINATION	8
-	-	2-240641-5 SPACER	7
-	-	318701-1 DEPRESSOR, SHEAR	5
-	-	238011-4 BLOCK, CRIMPER SPACER	4
-	-	7-1583690-7 CRIMPER, INSUL O	3
-	-	455888-6 SPACER, CRIMPER	2
-	-	5-1490019-4 CRIMPER, WIRE PREMIUM	1



DIMENSIONS: INCHES 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.001 4 PLC ±.0001 ANGLES ±.001	DWG NO: 05AUG2006 CHK: G. BALLEY APVD: I. BENCHOFF PRODUCT SPEC: APPLICATION SPEC: MATERIAL: FINISH:	Tyco Electronics Harrisburg, PA 17105-3608 NAME: FINE ADJUST SIDE FEED HDM APPLICATOR SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=1855117 SCALE: 3:5 SHEET: 1 OF 1 REV: A
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CUSTOMER VIEWABLE ASSEMBLY

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[1855117-6](#)