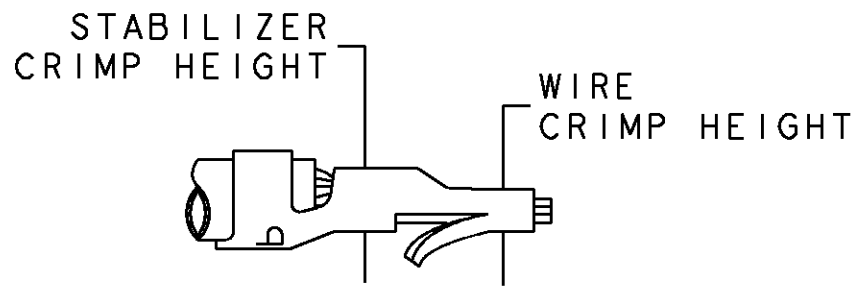


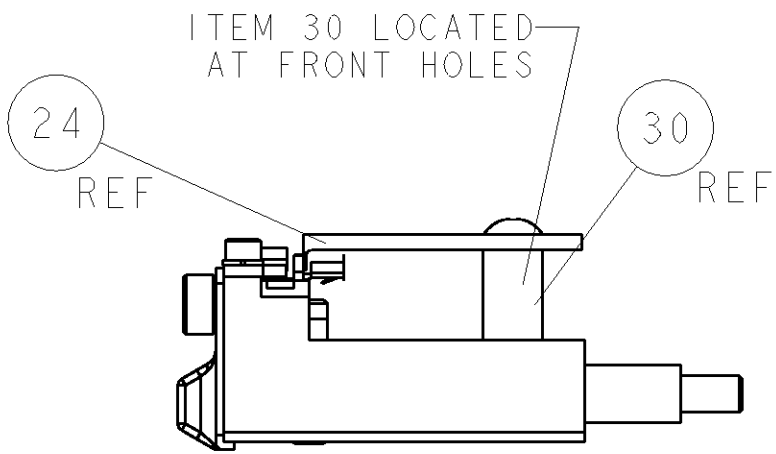
8				7			
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20				20			
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PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION		
1855059-1	A	122500-1	LEADMAKER	POST FEED	CUTS CARRIER		
1855059-2	A	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER		
1855059-3	A	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER		
1855059-6	A	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER		
1855059-8	A	122500-1	LEADMAKER	PRE FEED	CONTINUOUS CARRIER		
7-1855059-7	A	-	-	-	SPARE PARTS		

- △ RECOMMENDED SPARE PARTS
- △ GREASE LIGHTLY
- △ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
- △ LOCATE ITEM 19 BETWEEN ITEMS 75 AND 1.
- △ USED WITH BENCH TERMINATING UNITS ONLY.
- △ UNLESS OTHERWISE SPECIFIED, SET UP APPLICATOR FOR 20 & 22 GAGE WIRE. ITEM 75. ADDITIONAL WIRE CRIMPER, ITEM 76, SHOULD ALSO ACCOMPANY APPLICATOR.
- △ STABILIZER CRIMP HEIGHT TO BE MEASURED OVER CENTER BARREL. STABILIZER CRIMP HEIGHT LISTED BELOW.

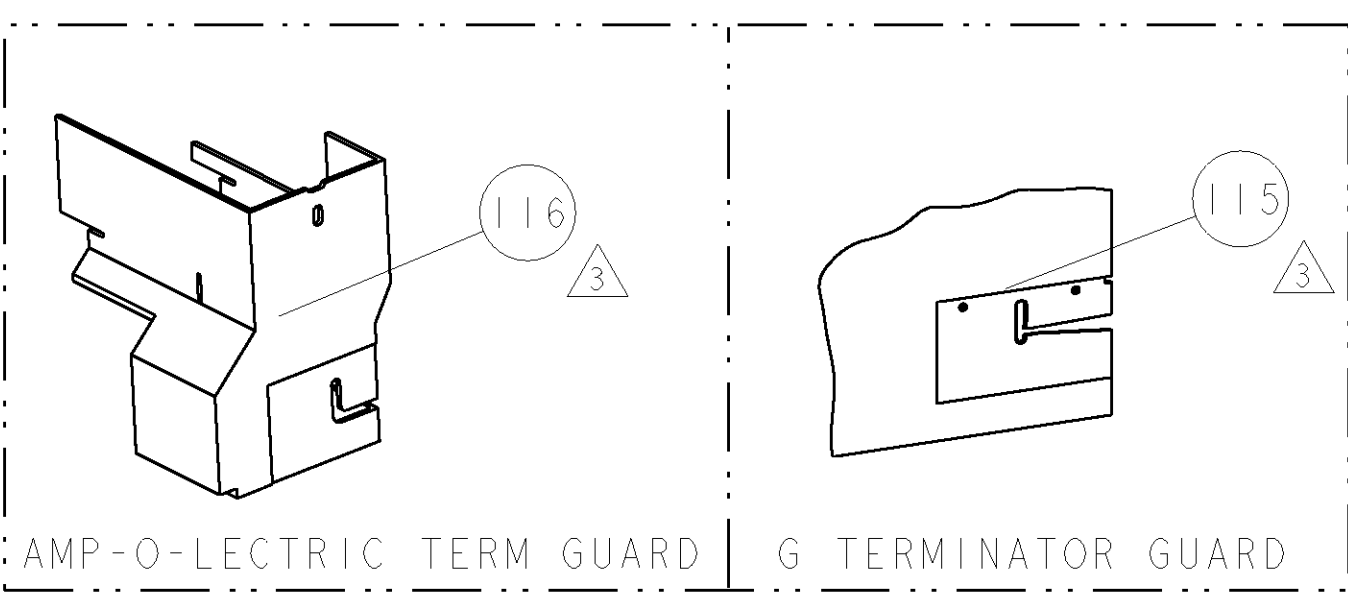
STABILIZER CRIMP HEIGHT	WIRE SIZE
.055 ± .005 [1.40 ± 0.13mm]	22, 20 & 18 AWG



- △ USE ITEM NO 76 WHEN RUNNING 20 & 22 GAGE WIRE.
- △ USE ITEM NO 75 WHEN RUNNING 18 GAGE WIRE.

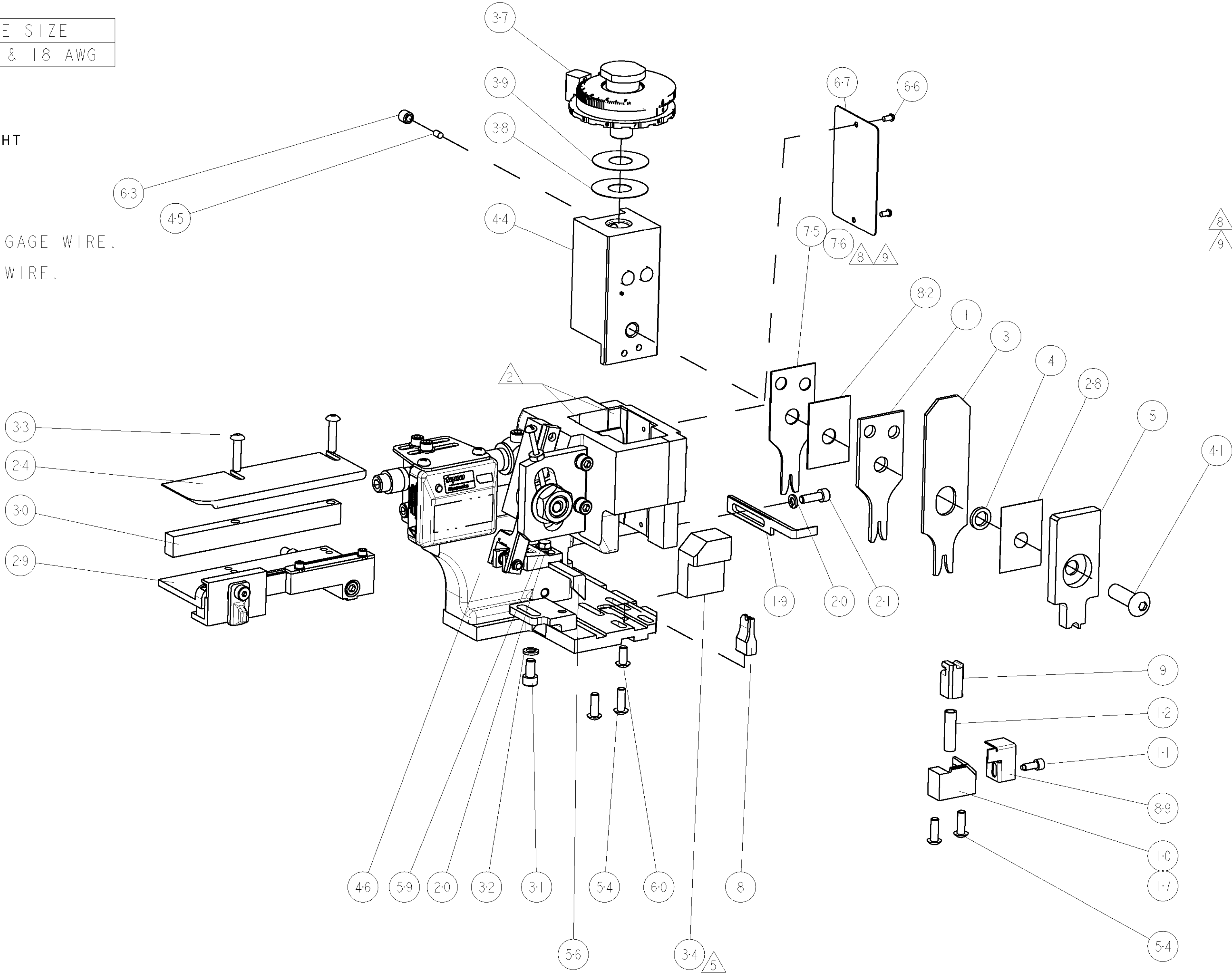


FEED TRACK POSITION



TERMINAL NAME: MINI AMP-IN					
TERMINAL	-	AMP TERMINAL - AMP CRIMP SPECS			
640311	-				
-	-	REF SETTING	CRIMP HEIGHT	WIRE SIZE	
-	-	B7	.037±.002[.94±0.05mm]	18 AWG	
-	-	B3	.030±.002[.76±0.05mm]	20 OR 22 AWG	
-	-	-	-		
-	-	-	-		
-	-	CRIMP	SIZE	TYPE	RANGE
-	-	WIRE	.062 [1.57mm]	F	18-22 AWG
-	-	STABILIZER	.062 [1.57mm]	F	18-22 AWG
-	-	INSUL	.110 [2.79mm]	F	∅.060-.110
WIRE STRIP LENGTH .175-.205	TERM APPL SPEC 114-1016	FEED .330	APPL INSTRUCTIONS 408-8040	SET UP GAGE 458637-1	

LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		A		RELEASED	07APR2006	LG	GB
		A1		ADD -8	11MAY2006	ROW	TE



△ 3	-	-	-	-	REF	-	...	455749-1	GUARD WINDOW	116
△ 3	-	-	-	-	REF	-	...	679532-1	INSERT, GUARD	115
	-	1	1	1	1	1	-	1-21002-7	SCR, BTN SKT HD CAP 6-32 X .375	91
	-	1	1	1	1	1	-	318563-1	GUARD, FRONT CHIP	89
	-	1	1	1	1	1	-	455888-7	SPACER, CRIMPER	82
	-	1	1	1	1	1	-	1-458141-4	CRIMPER, WIRE PREMIUM	76
	-	1	1	1	1	1	-	1-458141-5	CRIMPER, WIRE PREMIUM	75
	-	1	1	1	1	1	-	4088040	SF APPL INST 408-8040	72
	-	1	1	1	1	1	-	217238-1	GENERAL INSTRUCTION PKG	71
	-	1	1	1	1	1	-	461264-5	PLATE, IDENTIFICATION	67
	-	2	2	2	2	2	-	21017-2	SCREW, DRIVE	66
	-	1	1	1	1	1	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	63
	-	1	1	1	1	1	-	22733-8	SCR, BHSC, SELF-LOCKING, 8-32 X .375	60
	-	1	1	1	1	1	-	2-22603-0	SCR, HEX HD CAP 8-32 X .312	59
	-	1	1	1	1	1	-	458537-2	PAWL, FEED	56
	-	4	4	4	4	4	-	2-21002-2	SCR, BTN SKT HD CAP 8-32 X .500	54
	-	1	-	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	1	-	459456-1	APPL. BASIC SUB ASSY (SIDE WISE MQCA)	46
	-	1	1	1	1	1	-	690191-1	PLUG,NYLON	45
	-	1	1	1	1	1	-	455673-6	RAM, SIDE FEED	44
	-	1	1	1	1	1	-	7-21002-9	SCR, BTN SKT HD CAP 5/16-24 X 1.00	41
	-	1	1	1	1	1	-	690125-1	SHIM SUB-ASSY	39
	-	1	1	1	1	1	-	469367-1	SHIM	38
	-	1	1	1	1	1	-	879103-2	FINE ADJUST HEAD SUBASSY	37
△ 5	-	1	1	1	1	1	-	469465-1	STOP, WIRE	34
	-	2	2	2	2	2	-	2-21002-4	SCR, BTN SKT HD CAP 8-32 X .750	33
	-	1	1	1	1	1	-	21024-5	WASHER, SPRG LOCK, REG NO 10	32
	-	1	1	1	1	1	-	3-21000-4	SCR, SKT HD CAP 10-32 X .375	31
	-	1	1	1	1	1	-	1320908-4	SPACER, STRIP GUIDE	30
	-	1	1	1	1	1	-	1633091-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	1	-	455888-1	SPACER, CRIMPER	28
	-	1	1	1	1	1	-	1320928-5	PLATE, STRIP GUIDE	24
	-	1	1	1	1	1	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	21
	-	2	2	2	2	2	-	21024-4	WASHER, SPRG LOCK, REG NO 8	20
	-	1	1	1	1	1	-	1-690472-3	STRIPPER	19
△ 4	-	1	1	-	-	-	-	679625-1	SHEAR HOLDER, FRONT (NO CUT)	17
△ 1	-	1	1	1	1	1	-	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1	-	690461-1	STOP, SHEAR	11
	-	-	-	1	1	1	-	690459-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	1	-	454276-1	FLOATING SHEAR, FRONT	9
	1	1	1	1	1	1	-	464962-3	ANVIL, COMBINATION	8
	-	1	1	1	1	1	-	455889-9	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1	-	238011-7	BLOCK, CRIMPER SPACER	4
	1	1	1	1	1	1	-	2-456134-2	CRIMPER, INSULATION F PREMIUM	3
	1	1	1	1	1	1	-	1-456403-3	CRIMPER, WIRE PREMIUM	1
△ 1	-77	-8	-6	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO

*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.

POST-FEED 1 5/8 STROKE	PRE-FEED 1 1/8 STROKE	PRE-FEED 1 5/8 STROKE
-1 & -6	-2	-3 & -8

DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN L. GROSS 22MAR2006		Tyco Electronics Harrisburg, PA 17105-3608	
9 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.001 4 PLC ±.0001		FINISH		CHKD R. KNEPPER 22MAR2006		NAME	
MATERIAL		APPL SPEC		PRODUCT SPEC		SIZE	
		WEIGHT		CUSTOMER DRAWING		SCALE	
						3:5	

CUSTOMER VIEWABLE ASSEMBLY