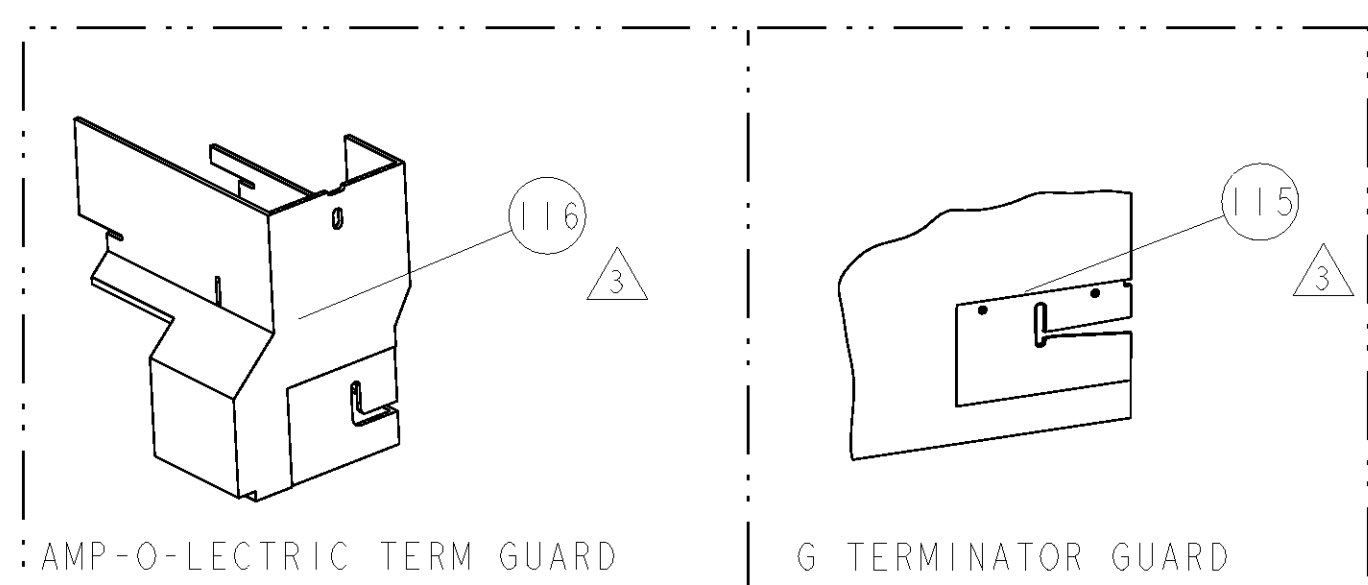


| PART NUMBER | REV | FIRST USED | POWER UNIT | FEED TYPE | DESCRIPTION |
|-------------|-----|------------|---------------|-----------|--------------------|
| 1855343-1 | B | 122500-1 | LEADMAKER | POST FEED | CUTS CARRIER |
| 1855343-2 | B | 565435-5 | BENCH MODEL K | PRE FEED | CUTS CARRIER |
| 1855343-3 | B | 354500-1 | BENCH MODEL G | PRE FEED | CUTS CARRIER |
| 1855343-6 | B | 122500-1 | LEADMAKER | POST FEED | CONTINUOUS CARRIER |
| 7-1855343-7 | A | - | - | - | SPARE PARTS |

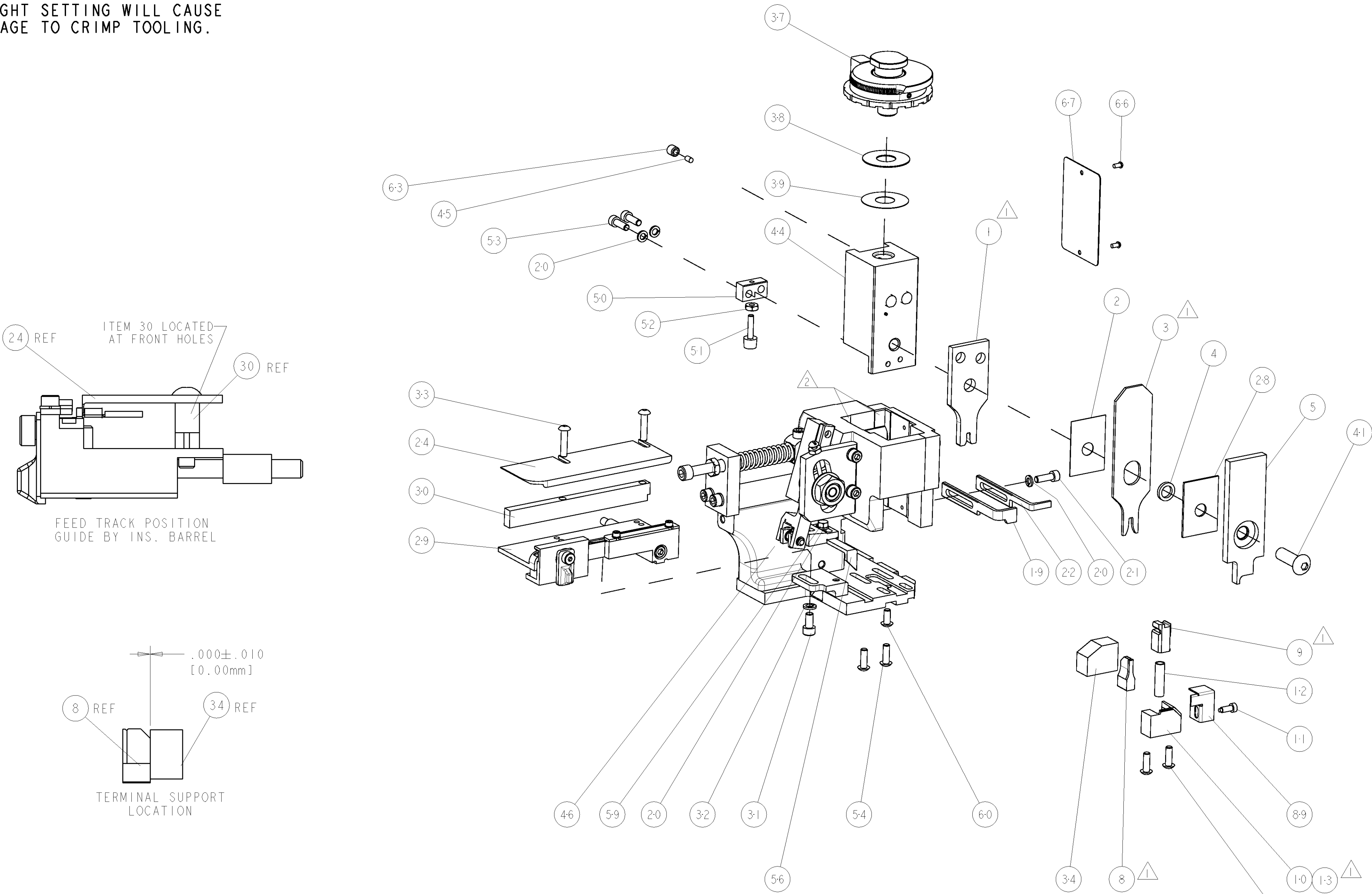


| TE TERM PN | | MANUF PN | ITT TERMINAL - TE CRIMP SPECS | | |
|-------------------|----------------|----------------|-------------------------------|-----------|-------------|
| 1572605-1 | 110238-1016 | | CRIMP HEIGHT | WIRE SIZE | REF SETTING |
| 1572605-2 | 030-2480-007 | | 1.35±0.05mm [0.053±.002] | 16AWG | C 0 |
| - | - | | 1.17±0.05mm [0.046±.002] | 18AWG | D 6 |
| - | - | | 1.04±0.05mm [0.041±.002] | 20AWG | E 7 |
| CRIMP | | SIZE | TYPE | RANGE | |
| - | - | 2.29mm [0.090] | F | 20-16 AWG | |
| - | - | 3.05mm [0.120] | F | 2-72 MAX | |
| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPLICATOR INSTRUCTIONS | | SET UP GAGE |
| 5.46-5.87 | NONE | 10.16 | 408-8040 | | 458637-1 |

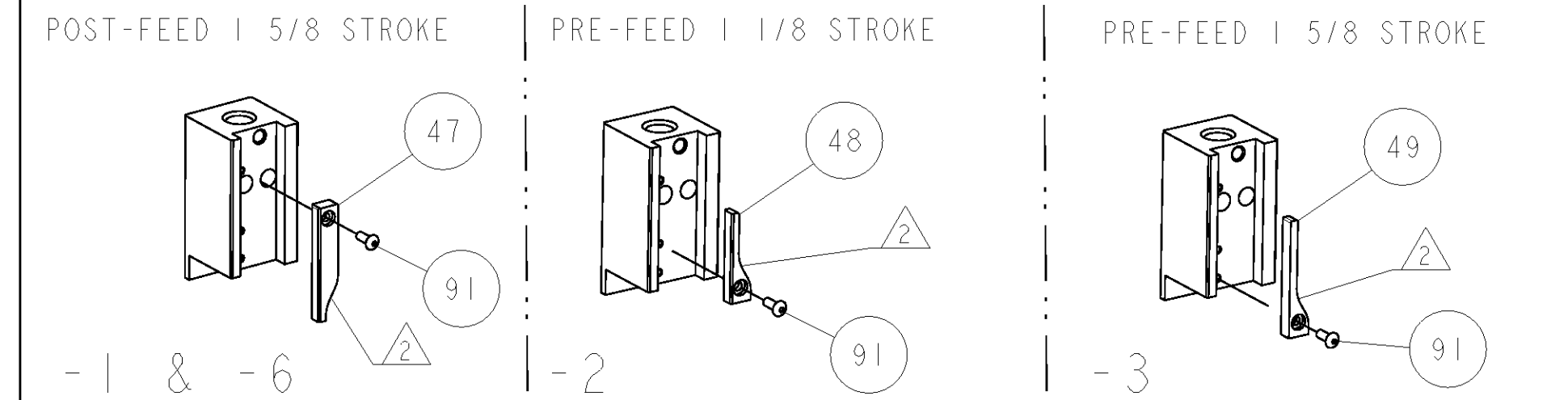
| LOC | DIST | REV | DESCRIPTION | DATE | DWN | APVD |
|-----|------|-----|-------------------|-----------|-----|------|
| A | 66 | | | | | |
| | | A | SEE ECO-07-024348 | 16OCT2007 | LJL | TE |
| | | B | ECR-10-015306 | 21JUL2010 | MY | GB |

- △ RECOMMENDED SPARE PARTS
- △ GREASE LIGHTLY
- △ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
- △ CRIMP DATA CALCULATED BY TYCO ELECTRONICS LTD.

*** 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.



| | | | | | | | | | |
|---|---|---|---|-----|---|----|------------|---------------------------------------|-----|
| △ | - | - | - | REF | - | .. | 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 |
| - | - | - | - | - | - | - | 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 |
| - | - | - | - | - | - | - | 458537-2 | PAWL, FEED | 56 |
| - | - | - | - | - | - | - | 2-21002-2 | SCR, BTN SKT HD CAP 8-32 X .500 | 54 |
| - | - | - | - | - | - | - | 2-21000-7 | SCR, SKT HD CAP 8-32 X .500 | 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 1/8 | 49 |
| - | - | - | - | - | - | - | 690602-5 | CAM, PRE FEED, 1 1/8 | 48 |
| - | - | - | - | - | - | - | 690501-4 | CAM, POST-FEED 1 1/8 | 47 |
| - | - | - | - | - | - | - | 459456-1 | APPL. BASIC SUB ASSY (SIDE WISE MQCA) | 46 |
| - | - | - | - | - | - | - | 690191-1 | PLUG, NYLON | 45 |
| - | - | - | - | - | - | - | 455673-6 | 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 |
| - | - | - | - | - | - | - | 1-469367-2 | SHIM | 38 |
| - | - | - | - | - | - | - | 879103-3 | FINE ADJUST HEAD ASSEMBLY | 37 |
| - | - | - | - | - | - | - | 690786-3 | TERMINAL SUPPORT | 34 |
| - | - | - | - | - | - | - | 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 |
| - | - | - | - | - | - | - | 1320908-4 | SPACER, STRIP GUIDE | 30 |
| - | - | - | - | - | - | - | 1633091-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | - | - | - | - | - | - | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | - | - | - | - | - | - | 1320928-5 | PLATE, STRIP GUIDE | 24 |
| - | - | - | - | - | - | - | 690472-2 | STRIPPER | 22 |
| - | - | - | - | - | - | - | 2-21000-7 | SCR, SKT HD CAP 8-32 X .500 | 21 |
| - | - | - | - | - | - | - | 21024-4 | WASHER, SPRG LOCK, REG NO 8 | 20 |
| - | - | - | - | - | - | - | 691353-1 | STRIPPER | 19 |
| △ | - | - | - | - | - | - | 679625-1 | SHEAR HOLDER, FRONT (NO CUT) | 13 |
| △ | - | - | - | - | - | - | 3-22280-3 | SPRING, COMPRESSION | 12 |
| △ | - | - | - | - | - | - | 690461-1 | STOP, SHEAR | 11 |
| △ | - | - | - | - | - | - | 690459-1 | SHEAR HOLDER, FRONT | 10 |
| △ | - | - | - | - | - | - | 454276-1 | FLOATING SHEAR, FRONT | 9 |
| △ | - | - | - | - | - | - | 5-662187-7 | ANVIL, COMBINATION .090 | 8 |
| - | - | - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | - | - | 6 |
| - | - | - | - | - | - | - | 1-455889-4 | DEPRESSOR, SHEAR | 5 |
| - | - | - | - | - | - | - | 238011-7 | BLOCK, CRIMPER SPACER | 4 |
| △ | - | - | - | - | - | - | 1213077-2 | CRIMPER, INSULATION PREMIUM | 3 |
| △ | - | - | - | - | - | - | 455888-3 | SPACER, CRIMPER | 2 |
| △ | - | - | - | - | - | - | 6-456406-2 | CRIMPER, WIRE PREMIUM | 1 |



| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | MATERIAL: | | FINISH: | | WEIGHT: | | CUSTOMER ACCESSIBLE PRODUCTION DRAWING | |
|-------------|-------------|--|-------------|-------------|-------------|---------------|--|---------|--|--|--|
| INCHES | 9 PLC ±.001 | 1 PLC ±.001 | 2 PLC ±.001 | 3 PLC ±.001 | 4 PLC ±.001 | ANGLES ±.0001 | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |