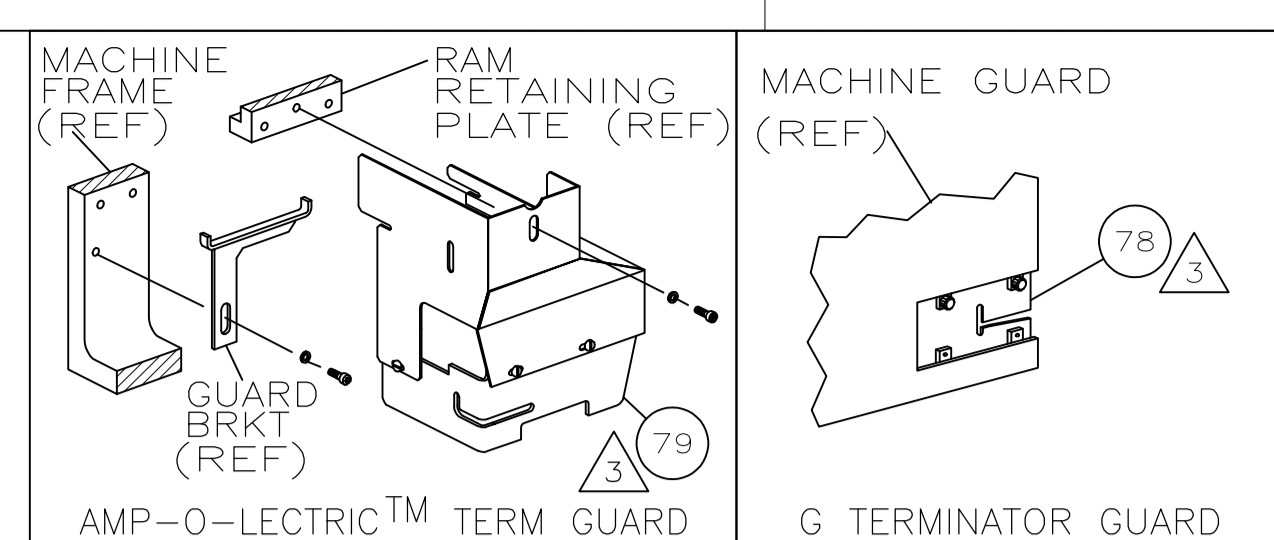


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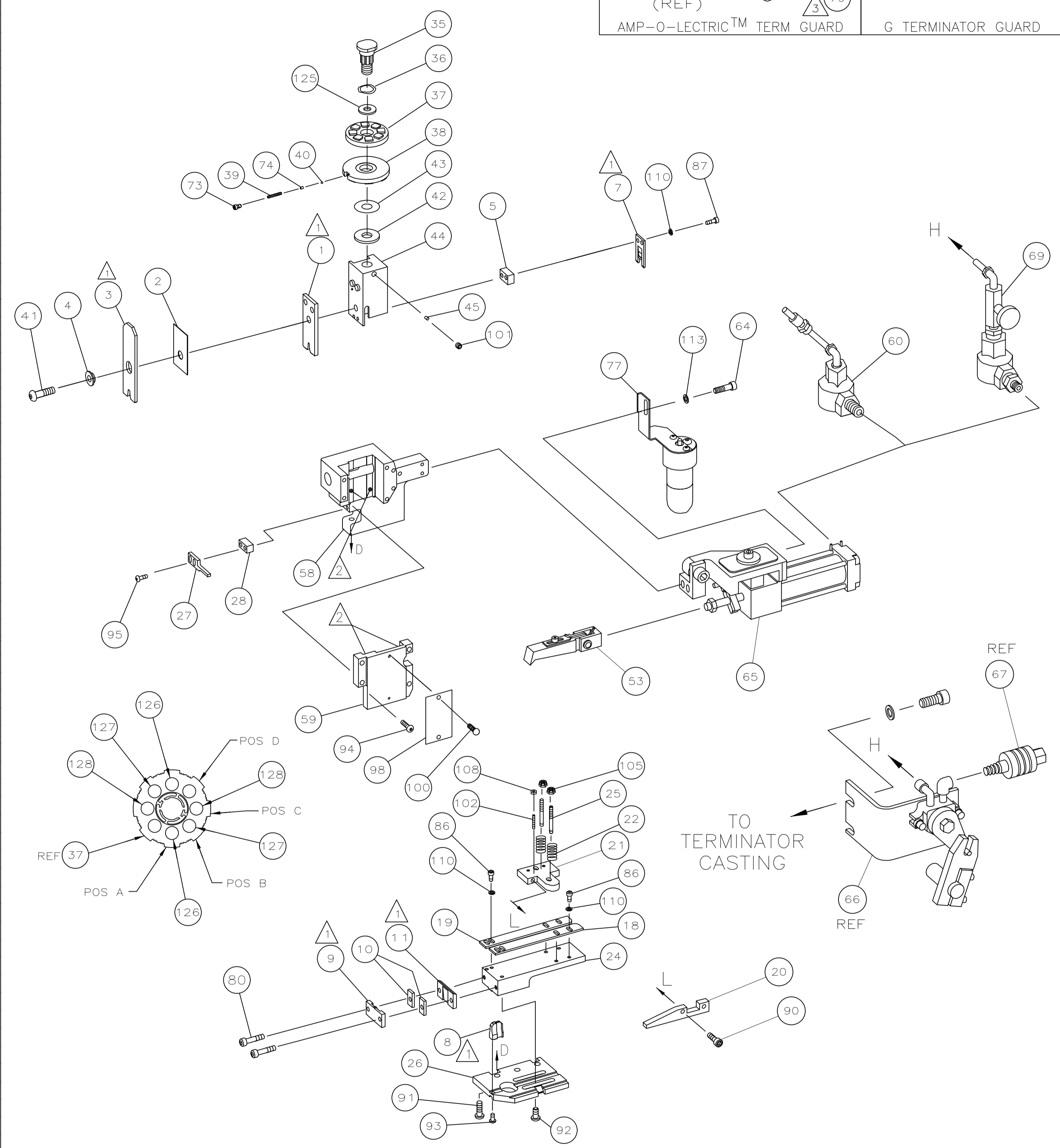
PART NUMBER	REV	FIRST USED
1852598-1	A	122500-1
1852598-2	A	565435-5



TERMINAL NAME: FLAG		AMP TERMINAL		AMP CRIMP SPECS	
1544114		PAD LTR	CRIMP HEIGHT	WIRE SIZE	
		A	.087 ±.002 [2.21 ±0.05mm]	12 AWG	
		B	.076 ±.002 [1.93 ±0.05mm]	14 AWG	
		C	.067 ±.002 [1.70 ±0.05mm]	16 AWG	
		D	NOT	USED	
CRIMP		SIZE	TYPE		RANGE
		WIRE .125 [3.18mm]	F		12-16
		INSUL .180 [4.57mm]	F		2.4-3.5mm
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.236-.252	NONE	.728	408-8039	458638-1	L2689

LOC		DIST		REVISIONS			
A		66		REV	DESCRIPTION	DATE	BY
				A	ORIGINAL	-	-

-1	LEADMAKER & BENCH MODEL G	AIR FEED
-2	BENCH MODEL K	AIR FEED



					129
2	2	-	354779-8	PIN, WIRE DISC (.3030)C	128
2	2	-	8-354778-7	PIN, WIRE DISC (.2930)B	127
2	2	-	6-354778-7	PIN, WIRE DISC (.2830)A	126
1	1	-	986950-1	WASHER, FLAT PRECISION	125
1	1	-	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	-	4088039	EF APPL INST 408-8039	123
					122
					121
					120
					119
					118
					117
					116
					115
					114
2	2	-	21024-5	WASHER, LOCK(#10)AIR ASSY	113
					112
4	4	-	21024-4	WASHER, LOCK(NO.8)SHEAR BL	111
					109
2	2	-	21018-4	NUT, HEX(4-40)DRAG	108
					107
					106
2	2	-	21022-2	NUT, HEX SL(8-32)DRAG STUD	105
					104
					103
2	2	-	2-21006-6	SCR, SKT SET(4-40x.62)DRAG	102
1	1	-	21009-2	SCR, SKT SET(1/4-20x.25)RAM	101
2	2	-	21017-2	SCR, DRIVE(#2x.19)ID PLATE	100
					99
1	1	-	461264-1	PLATE, IDENTIFICATION	98
					97
					96
2	2	-	2-21002-2	SCR, BHC(8-32x.50)STRIPPER	95
4	4	-	2-21002-9	SCR, BHC(10-32x.75)CAP	94
1	1	-	22733-8	SCR, BHC(8-32x.38 LW)ANVIL	93
4	4	-	3-21002-3	SCR, BHC(1/4-20x.50)ST GD PL	92
3	3	-	2-22733-8	SCR, BHC(1/4-20x.62)HSG	91
2	2	-	1-21000-3	SCR, SHC(4-40x.25)DRAG	90
					89
					88
2	2	-	2-21000-6	SCR, SHC(8-32x.38)SLUG BLADE	87
4	4	-	2-21000-6	SCR, SHC(8-32x.38)STRIP GUIDE	86
					85
					84
					83
					82
					81
2	2	-	3-21002-0	SCR, BHC(10-32x.88)SHEAR PL	80
1	-	-	455750-8	GUARD ASSY	79
-	REF	-	679532-1	INSERT, GUARD	78
1	-	-	465184-9	LUBRICATOR ASSY	77
					76
					75
1	1	-	690603-1	SPRING, ASSIST	74
1	1	-	23030-1	SCR, SKT CAP(6-32x.25)CP DSC	73
					72
					71
					70

					70
4	1	-	692655-5	AIR FEED VALVE ASSY	69
					68
					67
4	REF	-	24042-2	VALVE, SHUT OFF	66
REF	-	-	692655-6	AIR FEED VALVE ASSY	66
1	1	-	460277-1	AIR FEED ASSY (1 INCH)	65
2	2	-	3-21000-9	SCR, SHC(10-32x1.00)AIR ASSY	64
					63
					62
					61
4	-	1	692655-7	AIR FEED VALVE ASSY	60
1	1	-	454220-1	CAP, RAM	59
1	1	-	453736-1	HOUSING	58
					57
					56
					55
					54
4	1	1	2-460680-3	FEED FINGER ASSY	53
					52
					51
					50
					49
					48
					47
					46
1	1	-	690191-1	PLUG, NYLON	45
1	1	-	455674-2	RAM	44
1	1	-	690125-1	WASHER, LAMINATED	43
1	1	-	690124-1	WASHER, RAM	42
1	1	-	7-21002-9	BOLT, CRIMPER(5/16-24x1.00)	41
1	1	-	23241-6	BALL, STEEL	40
1	1	-	690170-1	SPRING, COMPRESSION	39
1	1	-	690142-3	DISC, INSULATION	38
1	1	-	354777-1	WIRE DISC, PLASTIC	37
1	1	-	22480-5	WASHER, SPRING	36
1	1	-	690212-1	POST, RAM	35
					34
					33
					32
					31
					30
					29
1	1	-	3-690451-7	SPACER, STRIPPER	28
1	1	-	240639-4	STRIPPER	27
1	1	-	455676-1	PLATE, BASE	26
2	2	-	22354-8	DRAG, STUD	25
1	1	-	856076-1	PLATE, STRIP GUIDE	24
					23
2	2	-	3-22281-5	SPRING, DRAG	22
1	1	-	464451-5	ARM, STOCK DRAG	21
1	1	-	464452-4	DRAG, STOCK	20
1	1	-	1338002-1	GUIDE, STRIP (REAR)	19
1	1	-	1338003-4	GUIDE, STRIP (FRONT)	18
					17
					16
					15
					14
					13
					12
1	1	1	240644-1	PLATE, REAR SHEAR	11
2	2	-	6-240645-0	SPACER, SHEAR PLATE	10
1	1	-	1-240642-1	PLATE, FRONT SHEAR	9
1	1	-	9-461295-1	ANVIL	8
1	1	-	1633043-1	BLADE, SLUG	7
					6
1	1	-	2-240641-1	SPACER, SLUG BLADE	5
1	1	-	238009-4	SPACER, BLOCK CRIMPER	4
1	1	-	6-1213077-6	CRIMPER, INSULATION	3
1	1	-	2-455888-7	SPACER, CRIMPER	2
1	1	-	9-568176-5	CRIMPER, WIRE	1

- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 4 SEE DRAWING FOR COMPONENTS
- 5 ITEM 78 USED WITH G TERMINATOR ONLY.
- 6. FEED OFF INSULATION BARREL.
- 7 INSULATION CRIMP HEIGHT MUST BE HELD; SEE SPEC.

QTY REQD PER ASSY	U/M	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY	U/M	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.

DM: M. YOUNGER 18DEC2007
 CWK: -

Tyco Electronics Corporation
 Harrisburg, PA 17105-3608

APPROVED: T. ELBIN 11JUL02
 PRODUCT SPEC

NAME: END FEED HDM APPLICATOR

APPLICATION SPEC

SIZE: A1
 CAGE CODE: 00779
 DRAWING NO: 1852598

RESTRICTED TO: -

CUSTOMER DRAWING SCALE: - SHEET: 1 OF 1 REV: A