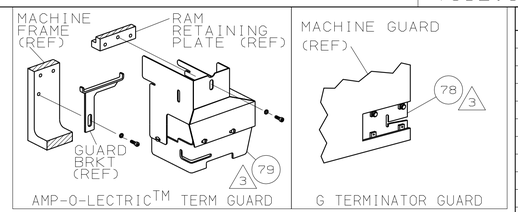
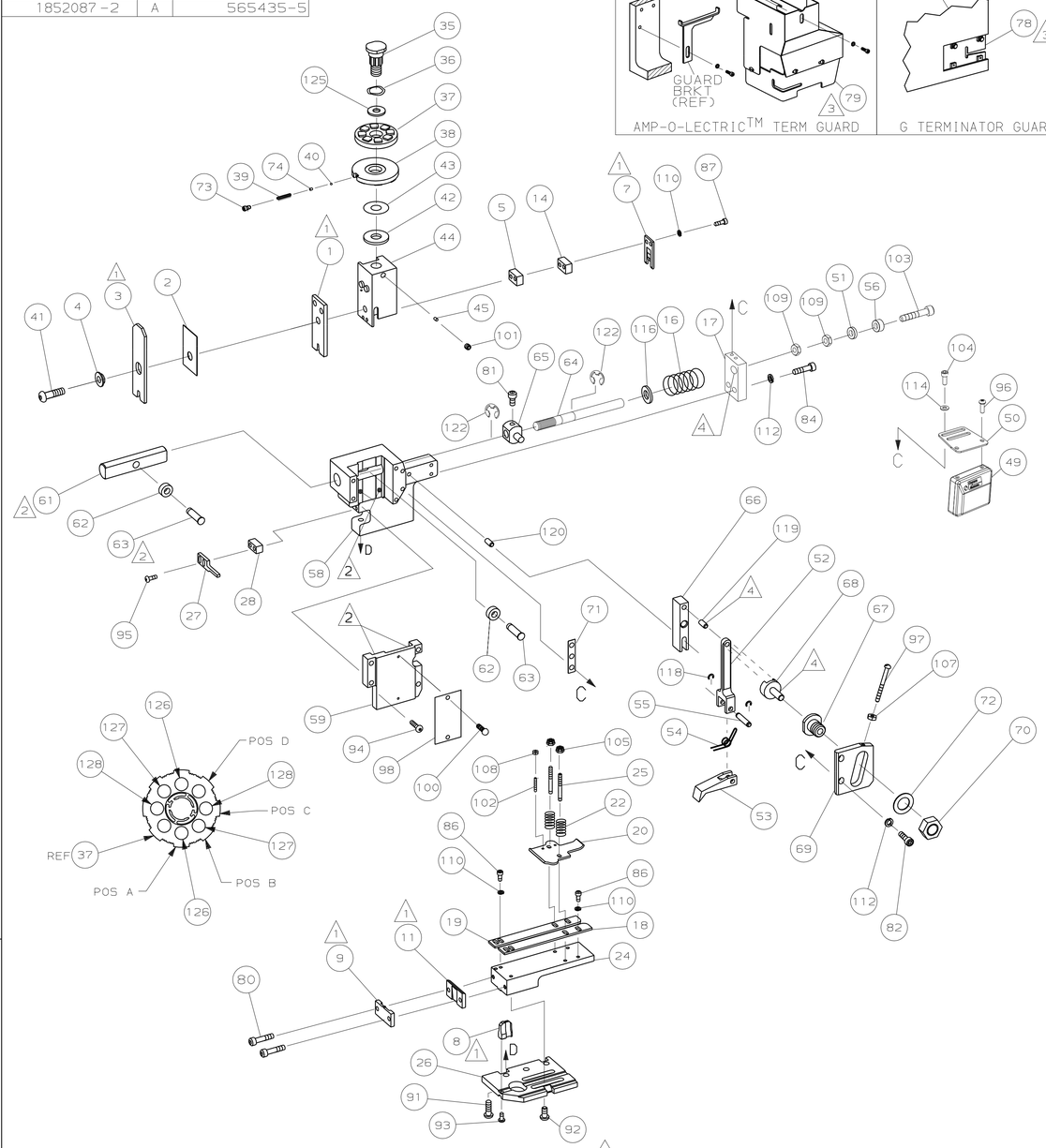
DRAWING MADE IN THIRD ANGLE PROJECTION

1852087 ⇔ 1852087

/home/us024474/tecmod

PART NUMBER	REV	FIRST USED
1852087-1	A	122500-1
1852087-2	A	565435-5





TERMINAL NAME: RING	
AMP TERM PN	MFR TERM PN
1572747	3375.00

ESCUBEDO TERMINAL AMP CRIMP SPECS

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.081 ±.002 [2.06 ±0.05mm]	14
B	.073 ±.002 [1.85 ±0.05mm]	16
C	.068 ±.002 [1.73 ±0.05mm]	18
D	NOT	USED

CRIMP	SIZE	TYPE	RANGE
WIRE	.120 [3.05mm]	F	18-14
INSUL	.160 [4.06mm]	F	.098-.138

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.195-.212	NONE	.866	408-8039	458638-1	L1852087

-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
						129
2	2	-	C	1-354779-1	PIN, WIRE DISC (.3045)C	128
2	2	-	C	9-354778-9	PIN, WIRE DISC (.2990)B	127
2	2	-	C	8-354778-3	PIN, WIRE DISC (.2910)A	126
1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
1	1	-	-	4088039	EF APPL INST 408-8039	123
REF	REF	-	A	1-21046-6	RING,RETAINING,EXT(5/16)FD ADJ ROD	122
						121
REF	REF	-	A	1-21030-6	PIN,DOWEL(ø.187x1.25)HSG	120
REF	REF	-	A	1-21030-1	PIN,DOWEL(ø.187x.50)LEVER	119
REF	REF	-	A	21045-3	RING,RET"C"(ø.187)FD PIN	118
						117
REF	REF	-	A	21899-4	WASHER,FLAT(ø5/16)SCR ADJ	116
						115
REF	REF	-	A	18028-2	WASHER,FLAT(M4)COUNTER	114
						113
REF	REF	-	A	21024-5	WASHER,LOCK(NO.10)FD ROD GDE	112
						111
6	6	-	A	21024-4	WASHER,LOCK(NO.8)SHEAR BL	110
REF	REF	-	A	22593-1	NUT,HEX(1/4-20)MAGNET	109
2	2	-	A	21018-4	NUT,HEX(4-40)DRAG	108
REF	REF	-	A	21018-5	NUT,HEX(6-32)FD ADJ PL	107
						106
2	2	-	A	21022-2	NUT,HEX SL(8-32)DRAG STUD	105
REF	REF	-	A	9-21000-9	SCR,SHC(8-32X.44)COUNTER	104
REF	REF	-	A	3-21081-3	SCR,SHC(1/4-20X1.25)MAGNET	103
2	2	-	A	2-21006-6	SCR,SKT SET(4-40x.62)DRAG	102
1	1	-	A	21009-2	SCR,SKT SET(1/4-20x.25)RAM	101
2	2	-	A	21017-2	SCR,DRIVE(#2x.19)ID PLATE	100
1	1	-	A	1-21002-7	SCR,BHC(6-32x.38)CAM	99
1	1	-	B	461264-1	PLATE, IDENTIFICATION	98
REF	REF	-	A	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	97
REF	REF	-	A	994991-5	SCR,OVAL HD(M4X14)COUNTER	96
2	2	-	A	2-21002-2	SCR,BHC(8-32x.50)STRIPPER	95
REF	REF	-	A	2-21002-9	SCR,BHC(10-32x.75)HSG CAP	94
1	1	-	A	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	93
4	4	-	A	3-21002-3	SCR,BHC(1/4-20x.50)ST GD PL	92
REF	REF	-	A	2-22733-8	SCR,BHC(1/4-20x.62)BASE PL	91
						90
						89
						88
2	2	-	A	2-21000-7	SCR,SHC(8-32x.50)SLUG BLADE	87
4	4	-	A	2-21000-6	SCR,SHC(8-32x.38)STRIP GUIDE	86
						85
REF	REF	-	A	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GDE	84
						83
REF	REF	-	A	3-21000-6	SCR,SHC(10-32x.62)FEED ADJ PL	82
REF	REF	-	A	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLOCK	81
2	2	-	A	2-21002-9	SCR,BHC(10-32x.88)SHEAR PL	80
REF	-	-	A	455745-1	GUARD, WINDOW	79
-	REF	-	A	679532-1	INSERT, GUARD	78
						77
						76
						75
1	1	-	A	690603-1	SPRING, ASSIST	74
1	1	-	A	23030-1	SCR,SKT CAP(6-32x.25)CP DSC	73
REF	REF	-	A	458109-1	WASHER, FLAT (SPECIAL)	72
REF	REF	-	A	690517-1	SPACER	71
-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY — PARTS LIST

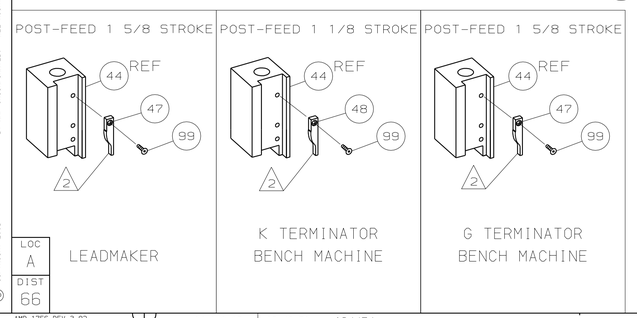
-1	LEADMAKER & BENCH MODEL G	MECH POST FEED
-2	BENCH MODEL K	MECH POST FEED

-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
REF	REF	-	A	22594-8	NUT, HEX	70
REF	REF	-	B	240628-1	PLATE, ADJ	69
REF	REF	-	B	240626-1	SHAFT, PIVOT	68
REF	REF	-	B	240633-1	BUSHING	67
REF	REF	-	A	455680-1	LEVER, INTERMEDIATE	66
REF	REF	-	B	240629-1	BLOCK, PIVOT	65
REF	REF	-	A	1804311-1	SCR, ADJ	64
REF	REF	-	B	240659-3	PIN, CAM ROLLER	63
REF	REF	-	B	240658-1	CAM, ROLLER	62
REF	REF	-	B	454398-1	ROD, FEED	61
						60
REF	REF	-	C	454220-1	CAP, RAM	59
REF	REF	-	D	453736-1	HOUSING	58
						57
REF	REF	-	A3	1804299-1	SPACER, MAGNET	56
REF	REF	-	B	240624-1	PIN, FEED FINGER	55
REF	REF	-	B	691499-1	SPRING, FEED FINGER	54
REF	REF	-	B	240635-1	FINGER, FEED	53
REF	REF	-	B	240634-1	LEVER, TERMINAL	52
REF	REF	-	A	1804310-1	MAGNET, RING	51
REF	REF	-	A	1804303-1	BRACKET, COUNTER MOUNTING	50
REF	REF	-	A	1804300-1	APPLICATOR COUNTER ASSEMBLY	49
1	-	-	B	690501-3	CAM, POST FEED 1 1/8 ST	48
-	1	-	B	690501-4	CAM, POST-FEED 1 5/8 ST	47
						46
1	1	-	A	690191-1	PLUG, NYLON	45
1	1	-	C	455674-1	RAM	44
1	1	-	A	690125-1	WASHER, LAMINATED	43
1	1	-	A	690124-1	WASHER, RAM	42
1	1	-	A	7-21002-9	BOLT, CRIMPER(5/16-24x1.00)	41
1	1	-	A	23241-6	BALL, STEEL	40
1	1	-	A	690170-1	SPRING, COMPRESSION	39
1	1	-	C	690142-1	DISC, INSULATION	38
1	1	-	D	354777-1	DISC, WIRE	37
1	1	-	A	22480-5	WASHER, SPRING	36
1	1	-	B	690212-1	POST, RAM	35
						34
						33
1	1	-	D	458980-1	APPLICATOR, BASIC (SUB ASSY)	32
						31
						30
						29
1	1	-	B	3-690451-2	SPACER, STRIPPER	28
1	1	-	A	240639-1	STRIPPER	27
REF	REF	-	C	455676-1	PLATE, BASE	26
2	2	-	A	22354-8	DRAG, STUD	25
1	1	-	B	455678-1	PLATE, STRIP GUIDE	24
						23
2	2	-	A	4-22281-1	SPRING, DRAG	22
						21
1	1	-	A	454177-1	DRAG, STOCK	20
1	1	-	B	1-458030-4	GUIDE, STRIP (REAR)	19
1	1	-	C	1-458031-4	GUIDE, STRIP (FRONT)	18
REF	REF	-	A	1804305-2	GUIDE, FEED ROD	17
REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	16
						15
1	1	-	C	240641-4	SPACER, SLUG BLADE	14
						13
						12
1	1	-	B	240644-1	PLATE, REAR SHEAR	11
						10
1	1	-	B	690482-4	PLATE, FRONT SHEAR	9
1	1	-	D	1-1633098-8	ANVIL	8
1	1	-	B	690474-4	BLADE, SLUG	7
						6
1	1	-	C	1-240641-9	SPACER, SLUG BLADE	5
1	1	-	B	238009-1	SPACER, BLOCK CRIMPER	4
1	1	-	C	9-1213077-4	CRIMPER, INSULATION	3
1	1	-	B	455888-8	SPACER, CRIMPER	2
1	1	-	C	2-456409-7	CRIMPER, WIRE	1
-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

QTY REQD PER ASSY — PARTS LIST

1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
4. LUBRICATE DAILY USING NO. 20 MACHINE OIL.
5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 32.
6. ITEM 78 USED WITH G TERMINATOR ONLY.



P	F	LTR	REVISION RECORD	APP	DATE
		A	RELEASED	RK	AUG05

DIMENSIONS IN INCHES. DO NOT SCALE PRINT.
TOLERANCES UNLESS OTHERWISE SPECIFIED:
2 PLC DEC ±-
3 PLC DEC ±-
4 PLC DEC ±-
ANGLES ± -
SURF TEXTURE: √
REMOVE BURRS, BREAK SHARP EDGES R.015 MAX

MATL - -	HT TR - -	FIN - -	
DR 18JUL05 R. KNEPPER	APP 18JUL05 T.ELBIN	AMP Tyco Electronics Harrisburg, PA 17105-3608	
CHK - -	REL - -		
NAME END FEED HDM APPLICATOR		MACHINE REF MINI APPL	
SCALE -	D DWG NO 1852087	SHEET 1 OF 1	REV A
CAGE CODE 00779	CUSTOMER AND ASSEMBLY DRAWING	RESTRICTED TO -	

THIS DRAWING IS A CONTROLLED DOCUMENT.
THIS DRAWING IS UNPUBLISHED. © COPYRIGHT 2005 BY AMP INCORPORATED. ALL RIGHTS RESERVED. RELEASED FOR PUBLICATION: AUGUST 04,2005.

LOC A DIST 66

AMP 1756 REV 3-92 04-AUG-05 12:48:50 us024474