DRAWING MADE IN THIRD ANGLE PROJECTION

1385507 ⇔ 1385507

/home/us012285/dmtecmod

PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1385507-1	B	122500-1	LEADMAKER	POST FEED	CUTS CARRIER
1385507-2	B	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER
1385507-3	B	354500-1	BENCH MODEL G	POST FEED	CUTS CARRIER
1385507-6	B	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER
7-1385507-7	B	-	-	-	SPARE PARTS

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 46.
6. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
7. 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.

TERMINAL NAME: TERMINAL (6)

AMP TERM PN	MFR TERM PN
1572192	1532-6269

AMP SEAL PN	MFR SEAL PN
1572194	12191153

PACKARD TERMINAL PACKARD CRIMP SPECS

PAD LTR	CRIMP HEIGHT	WIRE SIZE
A	.059 ±.002 [1.50 ±0.05mm]	1.3mm²
B	.055 ±.002 [1.40 ±0.05mm]	1mm²
C	.051 ±.002 [1.30 ±0.05mm]	.85mm²
D	.049 ±.002 [1.24 ±0.05mm]	.8mm²

CRIMP	SIZE	TYPE	RANGE
WIRE	.080 [2.03mm]	F	.8mm²-1.3mm²
INSUL	.140 [3.56mm]	O	-

WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
.205-.222	NONE	.432	408-8040	458637-1	L2738

-77	-6	-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-	2	2	2	2	-	C	2-354779-8	PIN, WIRE DISC (.3130)D	129
-	2	2	2	2	-	C	2-354779-4	PIN, WIRE DISC (.3110)C	128
-	2	2	2	2	-	C	1-354779-4	PIN, WIRE DISC (.3060)B	127
-	2	2	2	2	-	C	354779-6	PIN, WIRE DISC (.3020)A	126
-	1	1	1	1	-	A	986950-1	WASHER, FLAT PRECISION	125
-	1	1	1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
-	1	1	1	1	-	-	4088040	SF APPL INST 408-8040	123
									122
-	1	1	1	1	-	A	4-21028-0	PIN,SLT SPR(ø.093x.75)ST GDE PL	121
-	REF	REF	REF	REF	-	A	1-21030-1	PIN,DOWEL(ø.187x.50)LEVER	120
-	REF	REF	REF	REF	-	A	1-21030-6	PIN,DOWEL(ø.187x1.25)HOUSING	119
-	REF	REF	REF	REF	-	A	21045-3	RING,RET "C"(ø.187)FD FING PIN	118
-	1	1	1	1	-	A	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
-	REF	REF	REF	REF	-	A	21024-5	WASHER,LOCK(#10)ADJ PLATE	116
-	REF	REF	REF	REF	-	A	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115
-	2	2	2	2	-	A	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
-	REF	REF	REF	REF	-	A	5-21028-1	PIN,SLT SPR(ø.125x.50)ADJ ROD	113
									112
	4	4	4	4	-	A	21024-4	WASHER,LOCK(#8)STRIPPER	111
-	REF	REF	REF	REF	-	A	21899-4	WASHER,FLAT(ø5/16)SCREW ADJ	110
									109
-	1	1	1	1	-	A	21018-5	NUT,HEX(NO.6)HOLDDOWN	108
-	REF	REF	REF	REF	-	A	21068-5	NUT,HEX(6-32)FEED ADJ	107
									106
-	1	1	1	1	-	A	22353-8	SCR,SHLD(ø.187x.25)DRAG LEVER	105
									104
-	1	1	1	1	-	A	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
-	2	2	2	2	-	A	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
-	REF	REF	REF	REF	-	A	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
-	1	1	1	1	-	B	461264-1	PLATE, IDENTIFICATION	100
-	2	2	2	2	-	A	3-21002-0	SCR,BHC(10-32x.88)DRAG	99
-	1	1	1	1	-	A	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
-	REF	REF	REF	REF	-	A	2-21002-9	SCR,BHC(10-32x.75)CAP	97
-	REF	REF	REF	REF	-	A	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
-	REF	REF	REF	REF	-	A	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
-	6	6	6	6	-	A	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
									93
-	1	1	1	1	-	A	1-21003-9	SCR,FHC(6-32x.38)DEP	92
-	1	1	1	1	-	A	1-21002-7	SCR,BHC(6-32x.38)CAM	91
									90
									89
									88
-	2	2	2	2	-	A	2-21000-9	SCR,SHC(8-32x.75)DEP-HOLD	87
-	1	1	1	1	-	A	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
-	2	2	2	2	-	A	1-21000-3	SCR,SHC(4-40x.25)FR ST GUIDE	85
-	1	1	1	1	-	A	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
-	REF	REF	REF	REF	-	A	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
-	REF	REF	REF	REF	-	A	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	82
-	1	1	1	1	-	A	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
-	REF	REF	REF	REF	-	A	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	80
(3) -	-	-	REF	-	-	B	455749-1	GUARD, WINDOW	79
(3) -	-	REF	-	-	-	B	679532-1	INSERT, GUARD	78
									77
									76
									75
-	1	1	1	1	-	A	690603-1	SPRING, ASSIST	74
-	1	1	1	1	-	A	23030-1	SCR,SHC(6-32x.25 SL)INS DISC	73
-	REF	REF	REF	REF	-	A	458109-1	WASHER, SPECIAL	72
-	REF	REF	REF	REF	-	A	690517-1	SPACER	71

QTY REQD PER ASSY — PARTS LIST

-77	-6	-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
-	REF	REF	REF	REF	-	B	22594-8	NUT,HEX(1/2-20)	70
-	REF	REF	REF	REF	-	B	240628-1	PLATE, ADJUSTMENT	69
-	REF	REF	REF	REF	-	B	240626-1	SHAFT, PIVOT	68
-	REF	REF	REF	REF	-	B	240633-1	BUSHING	67
-	REF	REF	REF	REF	-	A	455680-1	LEVER, INTERMEDIATE	66
-	REF	REF	REF	REF	-	B	240629-1	BLOCK, PIVOT	65
-	REF	REF	REF	REF	-	A	240632-2	SCREW, ADJ FEED ROD	64
-	REF	REF	REF	REF	-	B	240659-3	PIN, CAM ROLLER	63
-	REF	REF	REF	REF	-	B	240658-1	ROLLER, CAM	62
-	REF	REF	REF	REF	-	B	454398-2	ROD, FEED	61
-	REF	REF	REF	REF	-	A	454178-1	GUIDE, FEED ROD	60
-	REF	REF	REF	REF	-	C	454220-1	CAP, RAM	59
-	REF	REF	REF	REF	-	D	454485-1	HOUSING	58
									57
-	1	1	1	1	-	B	690542-2	PAWL, FEED	56
-	REF	REF	REF	REF	-	B	240624-1	PIN, FEED FINGER	55
-	REF	REF	REF	REF	-	B	691499-1	SPRING, FEED FINGER	54
-	REF	REF	REF	REF	-	B	690541-1	HOLDER, FEED FINGER	53
-	REF	REF	REF	REF	-	A	455679-1	LEVER, TERMINAL FEED ARM	52
-	1	1	1	1	-	A	811242-2	BUMPER, HOLDDOWN	51
-	1	1	1	1	-	A	690753-1	SPACER, TONKER	50
-	-	1	-	-	-	B	690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	-	-	1	-	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST	48
-	1	-	-	1	-	B	690501-4	CAM, POST-FEED 1 5/8 ST	47
-	1	1	1	1	-	B	459456-1	APPLICATOR, BASIC (SUBASSY)	46
-	1	1	1	1	-	A	690191-1	PLUG, NYLON	45
-	1	1	1	1	-	C	455673-1	RAM	44
-	1	1	1	1	-	A	690125-1	WASHER, LAMINATED	43
-	1	1	1	1	-	A	690124-1	WASHER, RAM	42
-	1	1	1	1	-	A	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41
-	1	1	1	1	-	A	23241-6	BALL, STEEL	40
-	1	1	1	1	-	A	690170-1	SPRING, COMPRESSION	39
-	1	1	1	1	-	C	690142-1	DISC, INSULATION	38
-	1	1	1	1	-	D	354777-1	WIRE DISC, PLASTIC	37
-	1	1	1	1	-	A	22480-5	WASHER, SPRING	36
-	1	1	1	1	-	B	690212-1	POST, RAM	35
-	1	1	1	1	-	B	690786-1	SUPPORT, TERMINAL	34
-	REF	REF	REF	REF	-	D	455675-1	PLATE, BASE	33
-	1	1	1	1	-	A	690432-3	SCREW, ADJUSTMENT	32
									31
-	REF	REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ	30
-	1	1	1	1	-	C	458144-1	PLATE, STRIP GUIDE	29
-	1	1	1	1	-	C	1-455888-0	SPACER, FRONT SHEAR DEP	28
-	2	2	2	2	-	A	1-22284-0	SPRING, DRAG	27
-	1	1	1	1	-	B	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	-	B	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	-	D	6-690504-2	GUIDE, STRIP (REAR)	24
-	1	1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)	23
-	1	-	-	1	-	B	690472-2	STRIPPER	22
-	REF	REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN	21
									20
-	-	1	1	-	-	B	691353-1	STRIPPER	19
									18
	1	-	-	-	-	C	679625-2	HOLDER, SHEAR (NO CUT)	17
-	1	1	1	1	-	B	318563-1	GUARD, CHIP, FRONT	16
									15
									14
									13
-	1	1	1	1	-	A	3-22280-3	SPRING, SHEAR	12
-	1	1	1	1	-	B	690461-2	STOP, SHEAR	11
-	-	1	1	1	-	C	1-690459-0	HOLDER, SHEAR (FRONT)	10
(1) -	1	1	1	1	-	C	318707-3	SHEAR, FLOAT (FRONT)	9
(1) 1	1	1	1	1	-	C	7-662186-2	ANVIL	8
-	1	1	1	1	-	C	2-240641-3	SPACER, DEPRESSOR (REAR)	7
									6
-	1	1	1	1	-	C	318701-1	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	1	-	B	238011-2	SPACER, BLOCK CRIMPER	4
(1) 1	1	1	1	1	-	C	456135-6	CRIMPER, INSULATION	3
-	1	1	1	1	-	C	455888-7	SPACER, CRIMPER	2
(1) 1	1	1	1	1	-	C	1-456405-3	CRIMPER, WIRE	1

QTY REQD PER ASSY — PARTS LIST

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

P	F	LTR	REVISION RECORD	APP	DATE
		B1	ADD -6 & -77	TB	DEC06
		B	ECR-06-002810	TE	2-06
		A	REVISED	BH	NOV02

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 B.HIGMAN 07NOV02 APP T.ELBIN 07NOV02
CHK - - REL - -

AMP Tyco Electronics Harrisburg, PA 17105-3608

NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL

SCALE - D DWG NO 1385507 SHEET 1 OF 2 REV B1

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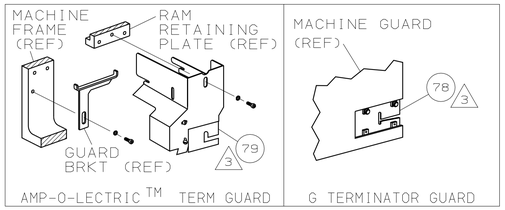
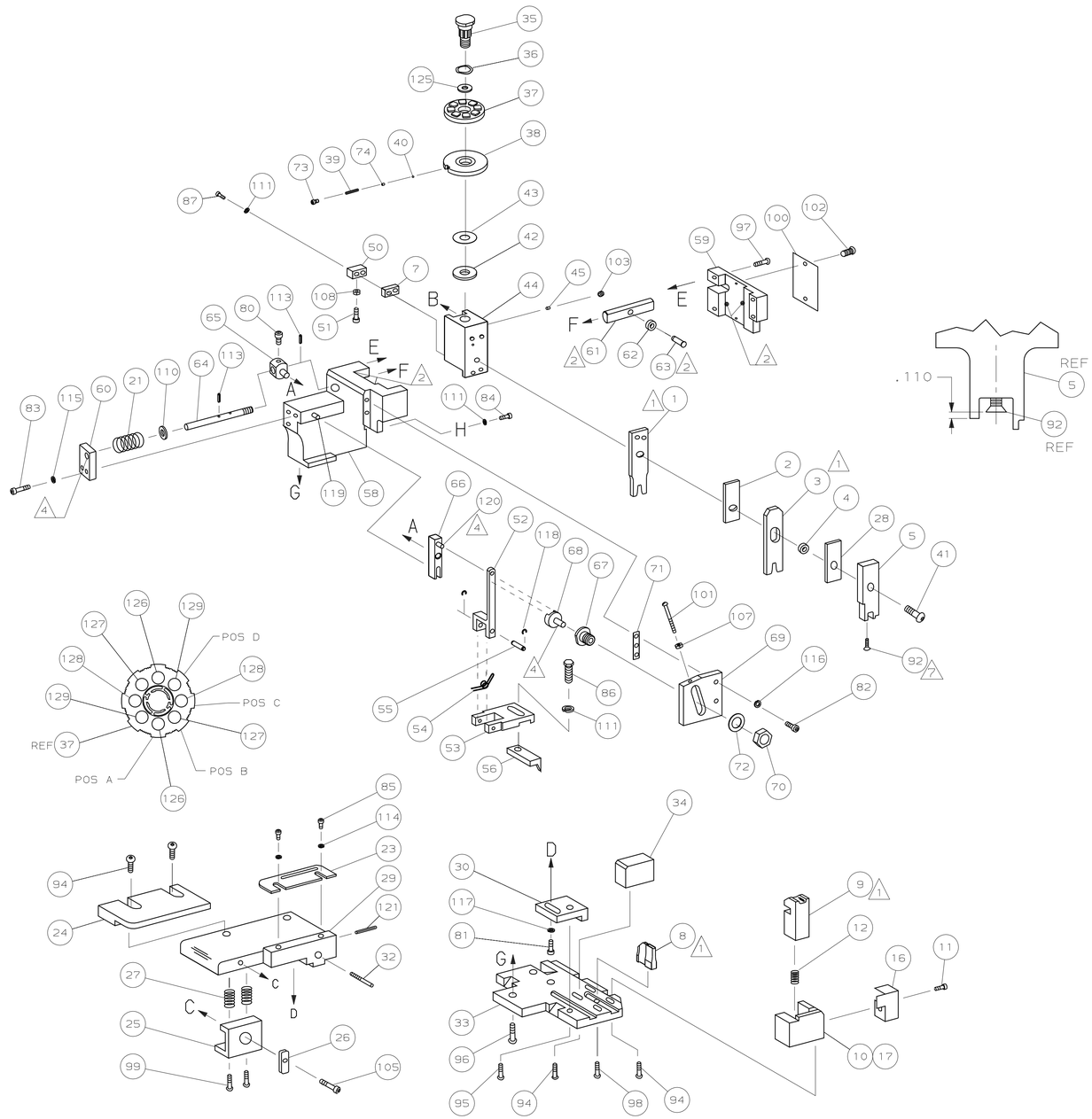
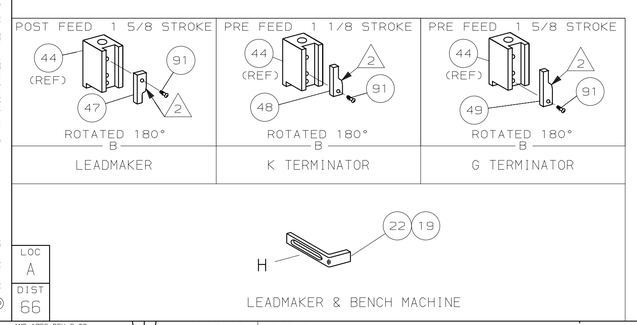
LOC A DIST 66







	DWG SIZE	PART NO	DESCRIPTION	ITEM NO
		← REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)		
QTY REQD PER ASSY		PARTS LIST		

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

SEE SHEET 1

P	F	LTR	REVISION RECORD	APP	DATE

MATL –	HT TR –	FIN –	
DR 20DEC06 R.O.WILSON	APP 21DEC06 T.BENCHOFF	AMP Tyco Electronics Harrisburg, PA 17105-3608	
CHK 21DEC06 T.ELBIN	REL – –		
NAME SIDE FEED HDM APPLICATOR		MACHINE REF MINI APPL	
SCALE –	D DWG NO 1385507	SHEET 2 OF 2	REV B1
CAGE CODE 00779	CUSTOMER AND ASSEMBLY DRAWING		RESTRICTED TO –

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LOC A
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