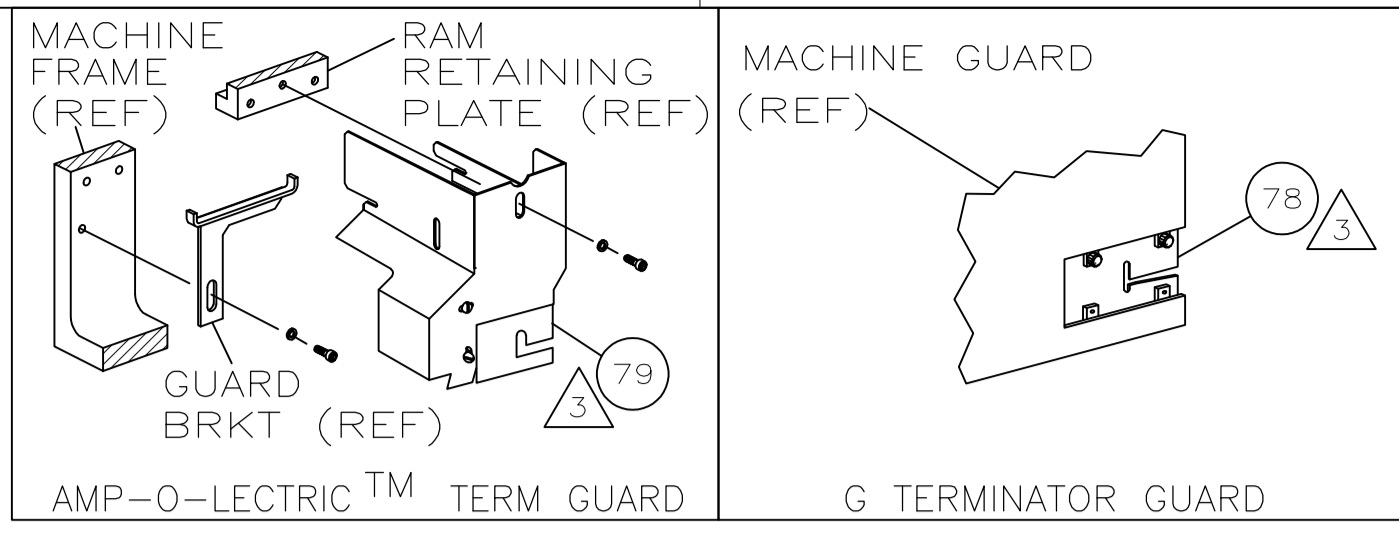


PART NUMBER	REV	FIRST USED
466707-1	B	
466707-2	B	565435-5
466707-3	R	854400-1
466707-4	R	565435-5
466707-5	R	354500-1

SUP BY -3
SUP BY -4



TERMINAL NAME: .250 BLADE

640416	PAD LTR	CRIMP HEIGHT	WIRE SIZE
	A	.098 ±.002	14
	B	.091 ±.002	16
	C	.087 ±.002	18
	D	NOT USED	

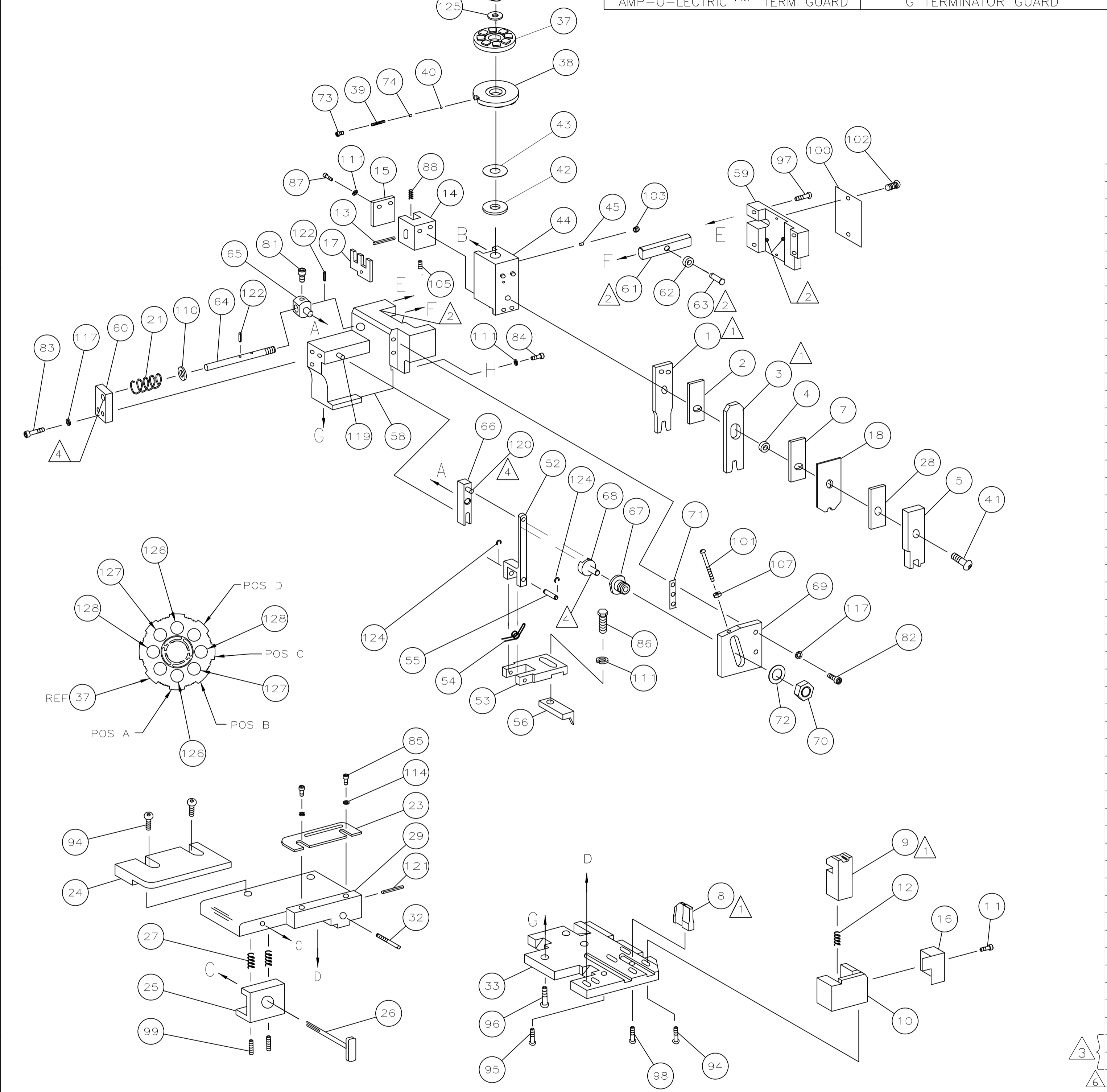
CRIMPING DATA

CRIMP	SIZE	TYPE	RANGE
WIRE	.140	F	18-14
INSUL	.210	F	.100-.142
FEED	.600	APPL INST 408-8040	SET UP GAGE 458637-1 LAYOUT 982

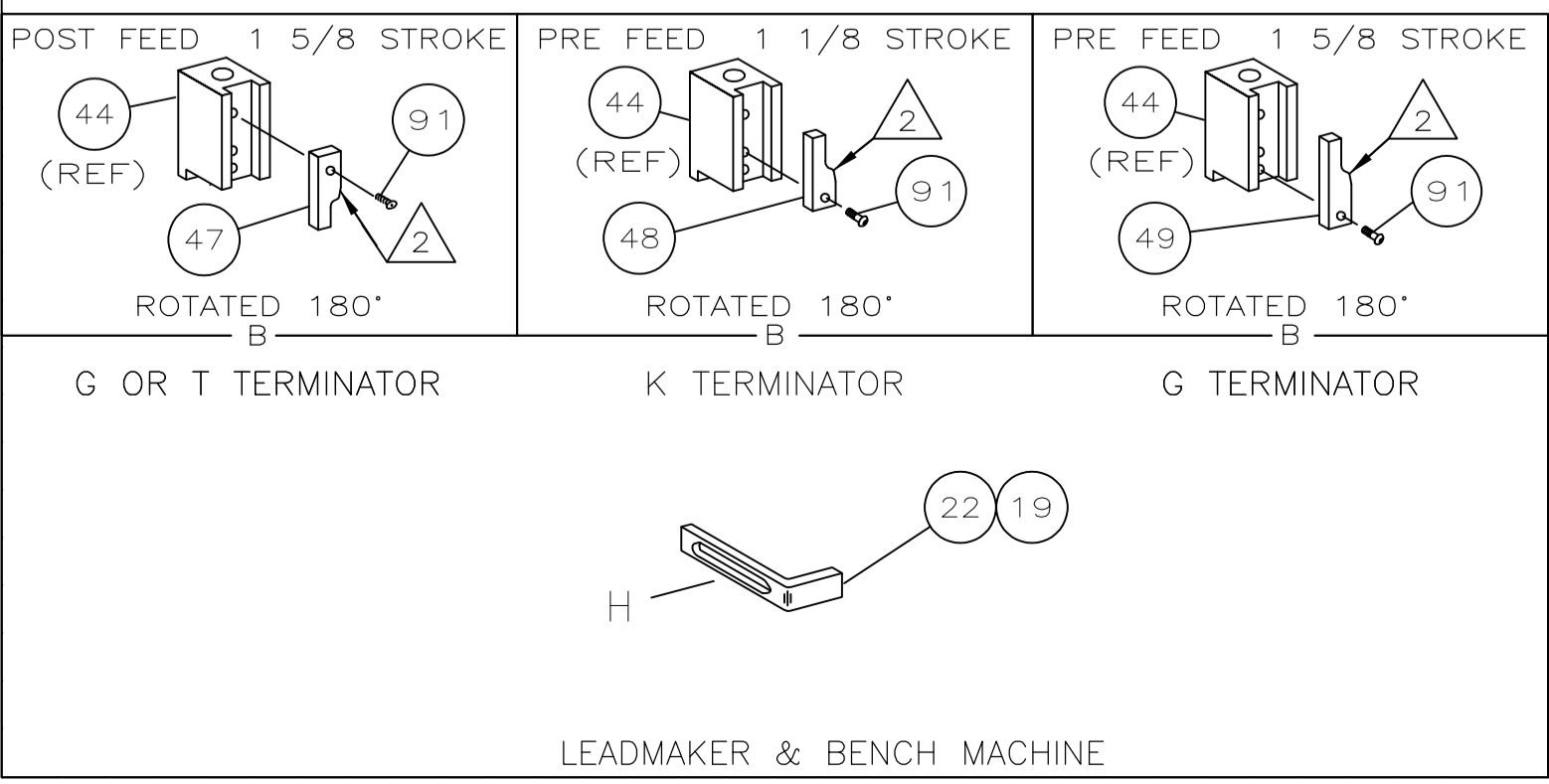
TERM APPL SPEC 114-01025 WIRE STRIP LENGTH .187-.219

LOC	DIST	REV	DESCRIPTION	DATE	BY	APPRO
A	66	R	ECR-08-01180	5-2008	MY	GB

-3	LEADMAKER	MECH POST FEED
-4	BENCH MODEL K	MECH PRE FEED
-5	BENCH MODEL G	MECH PRE FEED



QTY	REQD	PER	ASSY	PART NO	DESCRIPTION	ITEM NO
129				7-354778-0	PIN, WIRE DISC (.2845)C	129
128				6-354778-1	PIN, WIRE DISC (.2800)B	128
127				4-354778-7	PIN, WIRE DISC (.2730)A	127
126				986950-1	WASHER, FLAT PRECISION	126
125				21045-3	RING, RET "C"(Ø.187)FD FING PIN	125
124						124
123						123
122				5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	122
121				4-21028-0	PIN,SLT SPR(Ø.093x.75)ST GDE PL	121
120				1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	120
119				1-21030-6	PIN,DOWEL(Ø.187x1.25)HOUSING	119
118						118
117				21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
116						116
115						115
114				21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
113						113
112						112
111				21024-4	WASHER,LOCK(#8)STRIPPER	111
110				21899-4	WASHER,FLAT(Ø5/16)SCREW ADJ	110
109						109
108						108
107				21018-5	NUT,HEX(6-32)FEED ADJ	107
106						106
105				2-21008-1	SCR,SOC SET(4-40x.25)HOLD DOWN	105
104						104
103				21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
102				21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
101				6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
100				461264-1	PLATE, IDENTIFICATION	100
99				5-21006-6	SCR,SET(10-32x.75)DRAG	99
98				22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
97				2-21002-9	SCR,BHC(10-32x.75)CAP	97
96				2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
95				2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
94				2-21002-2	SCR,BHC(8-32x.50)SHEAR	94
93						93
92						92
91				1-21002-7	SCR,BHC(6-32x.38)CAM	91
90						90
89						89
88				3-22278-0	SPRING, HOLD DOWN	88
87				3-21000-0	SCR,SHC(8-32x.88)DEP-HOLD	87
86				2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
85				1-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	85
84				2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
83				3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
82				3-21000-6	SCR,SHC(10-32x.62)FEED ADJ BLK	82
81				3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
80						80
79				455749-1	GUARD, WINDOW	79
78				679532-1	INSERT, GUARD	78
77				464519-2	LUBRICATOR ASSY	77
76						76
75						75
74				690603-1	SPRING, ASSIST	74
73				23030-1	SCR,SHC(6-32x.25 SL)INS DISC	73
72				458109-1	WASHER, SPECIAL	72
71				690517-1	SPACER	71
70						70
69						69
68						68
67						67
66						66
65						65
64						64
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56						56
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54						54
53						53
52						52
51						51
50						50
49				690602-6	CAM, PRE-FEED 1 5/8 ST	49
48				690602-5	CAM, PRE-FEED 1 1/8 ST	48
47				690501-4	CAM, POST-FEED 1 5/8 ST	47
46						46
45				690191-1	PLUG, NYLON	45
44				455673-1	RAM	44
43				690125-1	WASHER, LAMINATED	43
42				690124-9	WASHER, RAM	42
41				690686-2	BOLT, CRIMPER(5/16x1.00)	41
40				23241-6	BALL, STEEL	40
39				690170-1	SPRING, COMPRESSION	39
38				690142-4	DISC, INSULATION	38
37				354777-1	WIRE DISC, PLASTIC	37
36				22480-5	WASHER, SPRING	36
35				690212-1	POST, RAM	35
34						34
33				458832-1	PLATE, BASE	33
32				690432-3	SCREW, ADJUSTMENT	32
31						31
30						30
29				461532-1	PLATE, STRIP GUIDE	29
28				455888-5	SPACER, FRONT SHEAR DEP	28
27				1-22284-0	SPRING, DRAG	27
26				690546-1	LEVER, DRAG RELEASE	26
25				240792-1	DRAG, TERMINAL	25
24				458876-1	GUIDE, STRIP (REAR)	24
23				458875-1	GUIDE, STRIP (FRONT)	23
22				690472-2	STRIPPER	22
21				4-22284-9	SPRING, FEED RETURN	21
20						20
19				691353-1	STRIPPER	19
18				461519-4	HOLDER,TERMINAL (FRONT)	18
17				455054-1	HOLD DOWN,TERM,REAR	17
16				691667-2	GUARD, CHIP (FRONT)	16
15				455053-1	PLATE,RETAINING	15
14				455052-1	HOLDER,HOLD DOWN	14
13				4-21028-0	PIN,HOLD DOWN(.094X.75)	13
12				3-22280-3	SPRING, SHEAR	12
11				690461-7	STOP, SHEAR	11
10				1-690459-3	HOLDER, SHEAR (FRONT)	10
9				1-454276-1	SHEAR, FLOAT (FRONT)	9
8				690493-5	ANVIL	8
7				455888-4	SPACER,HOLDER	7
6						6
5				2-455889-4	DEPRESSOR, SHEAR (FRONT)	5
4				1-238011-0	SPACER, BLOCK CRIMPER	4
3				3-456134-1	CRIMPER, INSULATION	3
2				455888-8	SPACER, CRIMPER	2
1				456411-4	CRIMPER, WIRE	1



- 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 MAX INSULATION CRIMP HEIGHT .190
- 6 LUBRICATOR ASSY NOT SHOWN, ATTACH TO THE TERMINAL GUIDE (SHROUD).
- 7 WIRE STRIP LENGTH .187-.250 FOR #14 AWG ONLY.

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIN D. SALTZER 8/22/94
C. FERISMAN 8-22-94
I. BEDDICK 8-22-94

Tyco Electronics Corporation
Harrisburg, PA 17105-3608

NAME: SIDE FEED HDM APPLICATOR

PRODUCT SPEC: -

APPLICATION SPEC: -

WEIGHT: -

SIZE: A1
CASE CODE: 00779
DRAWING NO: 466707

CUSTOMER DRAWING: -

SCALE: - SHEET: 1 OF 1 REV: R