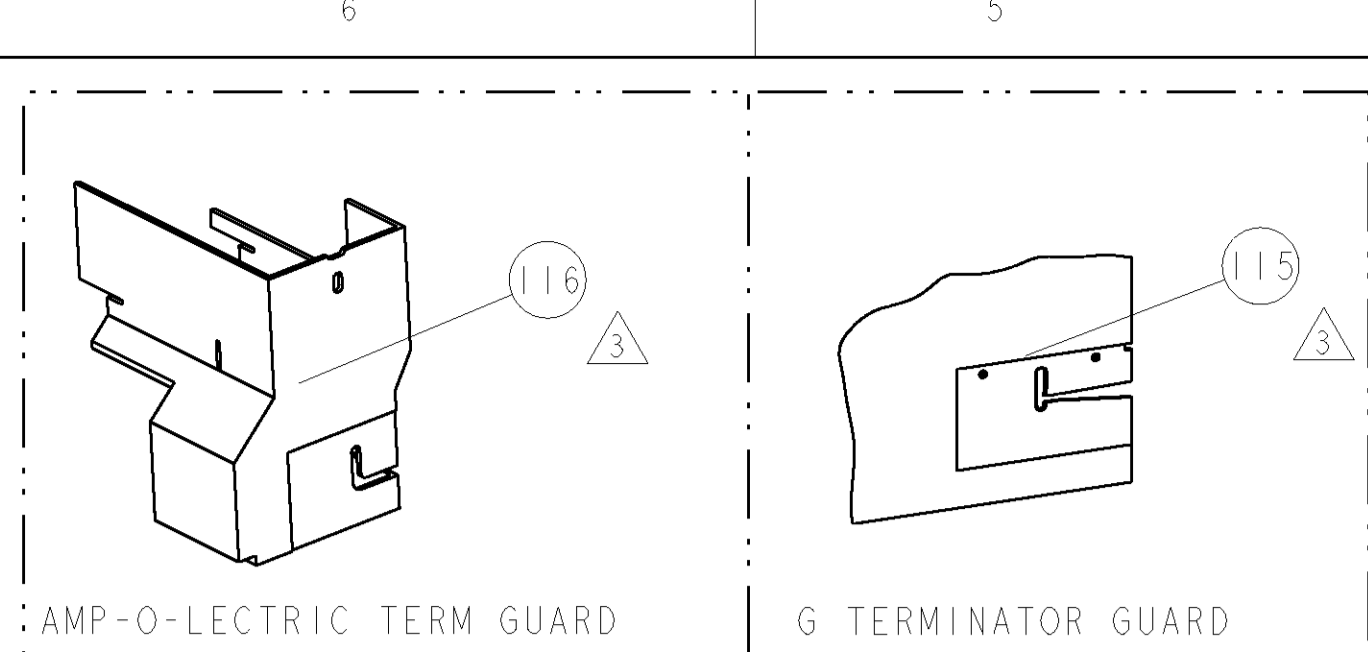
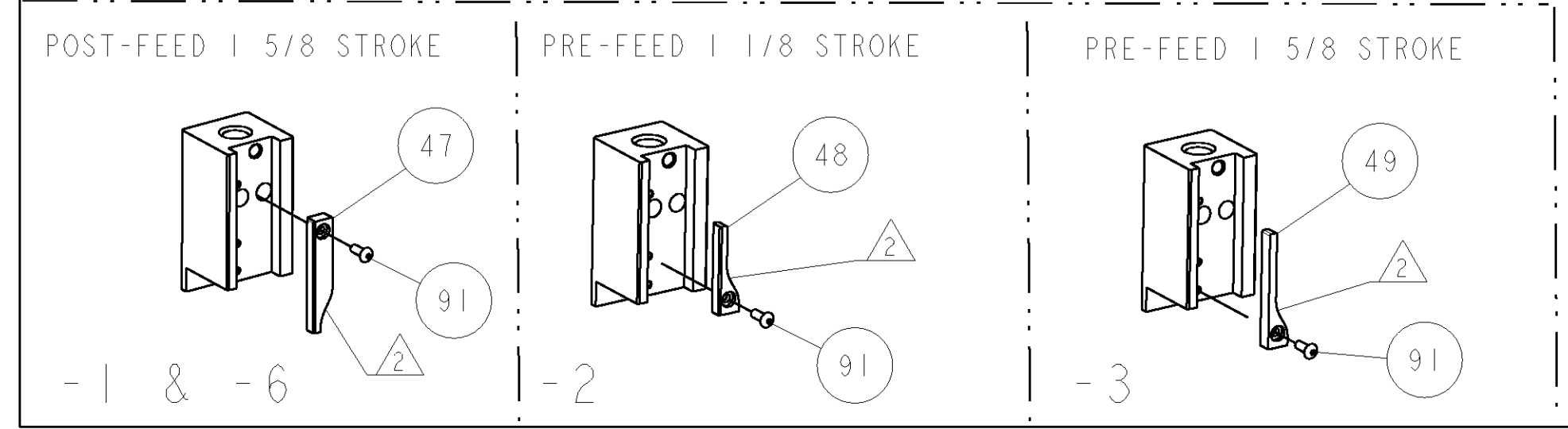
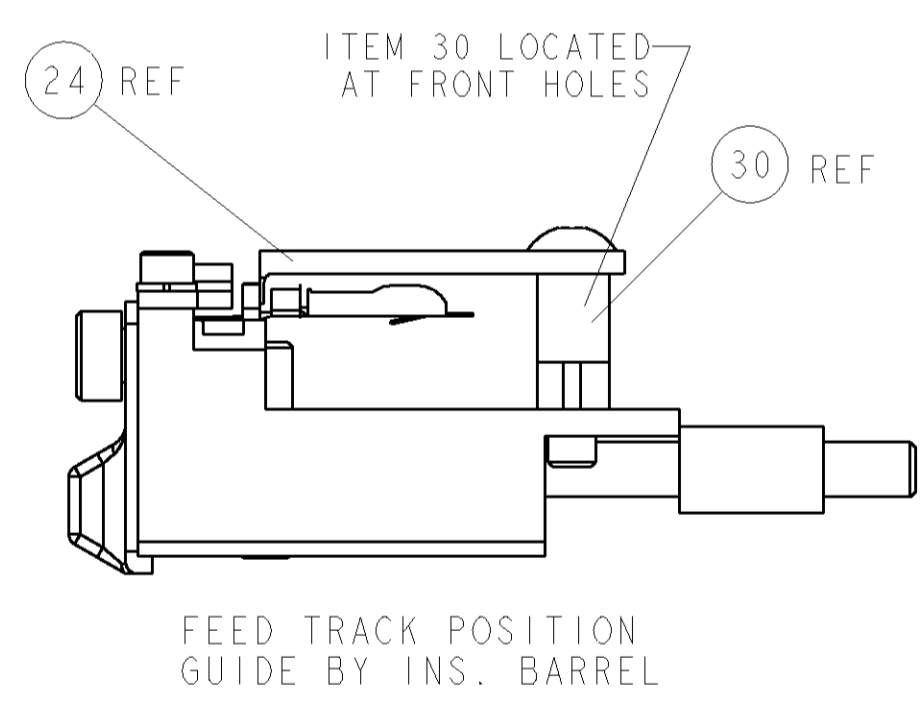
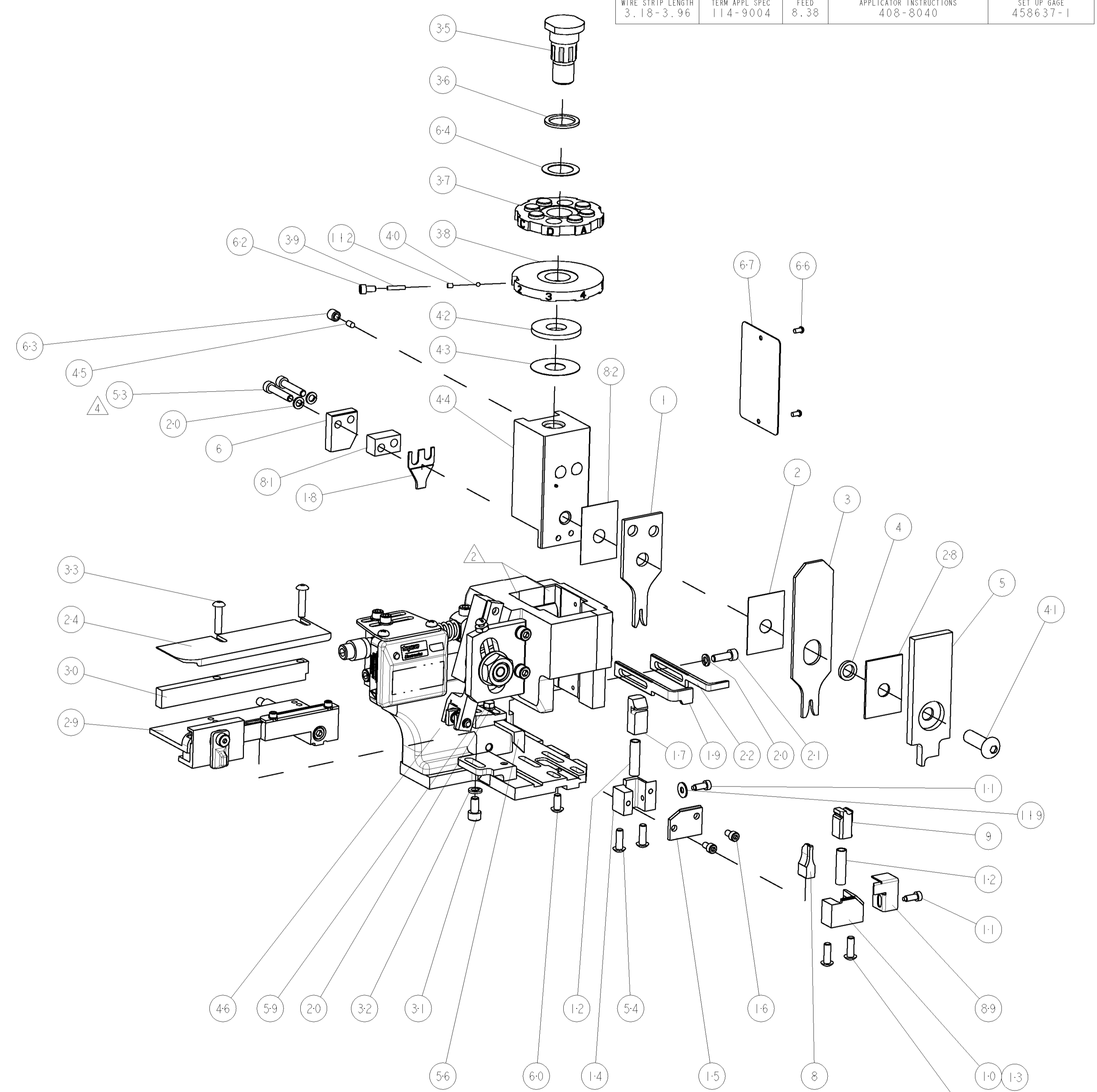
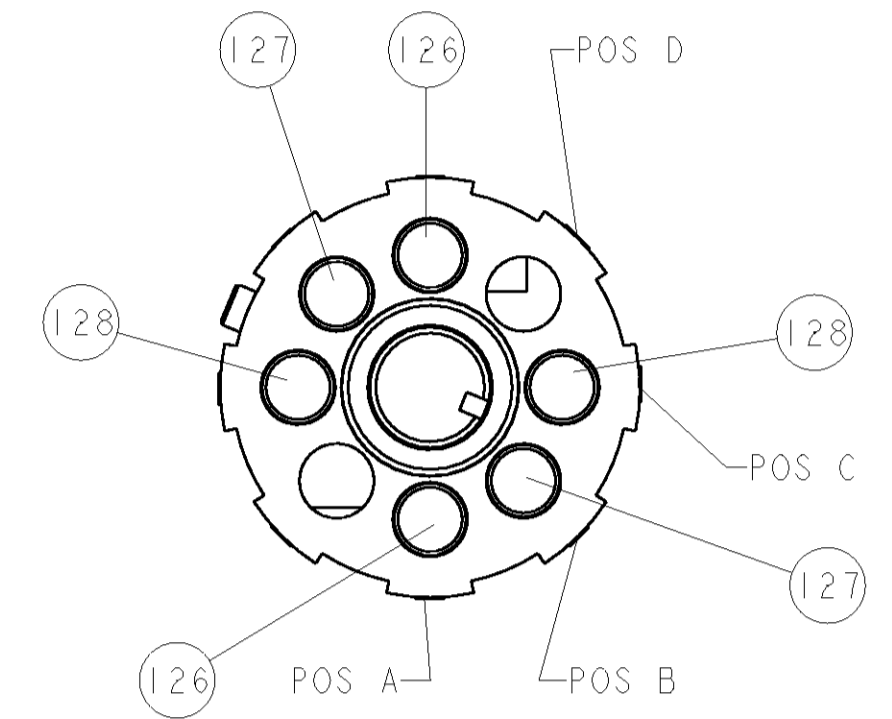


| PART NUMBER | REV | FIRST USED | POWER UNIT | FEED TYPE | DESCRIPTION |
|-------------|-----|------------|---------------|-----------|--------------------|
| 1852684-1 | A | 122500-1 | LEADMAKER | POST FEED | CUTS CARRIER |
| 1852684-2 | A | 565435-5 | BENCH MODEL K | PRE FEED | CUTS CARRIER |
| 1852684-3 | A | 354500-1 | BENCH MODEL G | PRE FEED | CUTS CARRIER |
| 1852684-6 | A | 122500-1 | LEADMAKER | POST FEED | CONTINUOUS CARRIER |
| 7-1852684-7 | A | - | - | - | SPARE PARTS |



| TERMINAL NAME: CONTACT - TWIN LEAF | | | |
|------------------------------------|----------------|------------------------------|---|
| SOCKET | PIN | TE TERMINAL - TE CRIMP SPECS | |
| 583649 | - | | |
| - | - | PAD LTR | CRIMP HEIGHT |
| - | - | A | 1.17mm+ .05/- .05 [.046+ .002/- .002] |
| - | - | B | 1.02mm+ .05/- .05 [.040+ .002/- .002] |
| - | - | C | .94mm+ .05/- .05 [.037+ .002/- .002] |
| - | - | D | - |
| - | - | CRIMP | SIZE |
| - | - | WIRE | 1.57mm [.062] |
| - | - | INSUL | 2.29mm [.090] |
| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPLICATOR INSTRUCTIONS |
| 3.18-3.96 | 114-9004 | 8.38 | 408-8040 |
| | | | SET UP GAGE |
| | | | 458637-1 |

- △ RECOMMENDED SPARE PARTS
- △ GREASE LIGHTLY
- △ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
- △ CUT TO LENGTH AT ASSEMBLY.



| LOC | QTY | REV | DESCRIPTION | DATE | OWN | APPROV | | |
|-----|-----|-----|-------------|-----------|-----|-------------|---------------------------------------|-----|
| A | 66 | | RELEASED | 30APR2008 | LG | TE | | |
| - | 2 | 2 | 2 | 2 | - | 4-354779-2 | PIN, WIRE DISC. .3200 | 128 |
| - | 2 | 2 | 2 | 2 | - | 3-354779-5 | PIN, WIRE DISC. .3165 | 127 |
| - | 2 | 2 | 2 | 2 | - | 2-354779-2 | PIN, WIRE DISC. .3100 | 126 |
| - | 1 | 1 | 1 | 1 | - | 21055-5 | WASHER, FLAT, REG NO 6 | 119 |
| △ | - | - | REF | - | .. | 455749-1 | GUARD WINDOW | 116 |
| △ | - | - | REF | - | .. | 679532-1 | INSERT, GUARD | 115 |
| - | 1 | 1 | 1 | 1 | - | 690603-1 | SPRING ASSIST AMP-O-MATOR APPLICATOR | 112 |
| - | 1 | 1 | 1 | 1 | - | 1-21002-7 | SCR, BTN SKT HD CAP 6-32 X .375 | 91 |
| - | 1 | 1 | 1 | 1 | - | 318563-1 | GUARD, FRONT CHIP | 89 |
| - | 1 | 1 | 1 | 1 | - | 455888-1 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | - | 5-240641-6 | SPACER | 81 |
| - | 1 | 1 | 1 | 1 | - | 4088040 | SF APPL INST 408-8040 | 72 |
| - | 1 | 1 | 1 | 1 | - | 217238-1 | GENERAL INSTRUCTION PKG | 71 |
| - | 1 | 1 | 1 | 1 | - | 461264-1 | PLATE, IDENTIFICATION | 67 |
| - | 2 | 2 | 2 | 2 | - | 21017-2 | SCREW, DRIVE | 66 |
| - | 1 | 1 | 1 | 1 | - | 986950-1 | WASHER, FLAT PRECISION | 64 |
| - | 1 | 1 | 1 | 1 | - | 21009-2 | SCR, SET, SELF LOCKING 1/4-20 X .250 | 63 |
| - | 1 | 1 | 1 | 1 | - | 23030-1 | SCR, SKT HD CAP 6-32 X .25 | 62 |
| - | 1 | 1 | 1 | 1 | - | 22733-8 | SCR, BHSC, SELF-LOCKING, 8-32 X .375 | 60 |
| - | 1 | 1 | 1 | 1 | - | 2-22603-0 | SCR, HEX HD CAP 8-32 X .312 | 59 |
| - | 1 | 1 | 1 | 1 | - | 458537-2 | PAWL, FEED | 56 |
| - | 4 | 4 | 4 | 4 | - | 2-21002-2 | SCR, BTN SKT HD CAP 8-32 X .500 | 54 |
| △ | 2 | 2 | 2 | 2 | - | 3-21000-0 | SCR, SKT HD CAP 8-32 X .875 | 53 |
| - | - | - | - | - | .. | 690602-6 | CAM, PRE FEED, 1 5/8 | 49 |
| - | - | - | - | - | .. | 690602-5 | CAM, PRE FEED, 1 1/8 | 48 |
| - | 1 | - | - | 1 | - | 690501-4 | CAM, POST FEED, 1 5/8 | 47 |
| - | 1 | 1 | 1 | 1 | - | 459456-1 | APPL. BASIC SUB ASSY (SIDE WISE MQCA) | 46 |
| - | 1 | 1 | 1 | 1 | - | 690191-1 | PLUG, NYLON | 45 |
| - | 1 | 1 | 1 | 1 | - | 455673-1 | RAM, SIDE FEED | 44 |
| - | 1 | 1 | 1 | 1 | - | 690125-1 | SHIM SUB-ASSY | 43 |
| - | 1 | 1 | 1 | 1 | - | 1-690124-4 | WASHER, RAM (.120) | 42 |
| - | 1 | 1 | 1 | 1 | - | 7-21002-9 | SCR, BTN SKT HD CAP 5/16-24 X 1.00 | 41 |
| - | 1 | 1 | 1 | 1 | - | 23241-6 | BALL, STEEL | 40 |
| - | 1 | 1 | 1 | 1 | - | 690170-1 | SPRING, COMPRESSION | 39 |
| - | 1 | 1 | 1 | 1 | - | 690142-1 | DISC, INSULATION | 38 |
| - | 1 | 1 | 1 | 1 | - | 354777-1 | WIRE DISC, ASSEMBLY | 37 |
| - | 1 | 1 | 1 | 1 | - | 22480-5 | SPRING, COMPRESSION | 36 |
| - | 1 | 1 | 1 | 1 | - | 690212-1 | POST, RAM | 35 |
| - | 2 | 2 | 2 | 2 | - | 2-21002-4 | SCR, BTN SKT HD CAP 8-32 X .750 | 33 |
| - | 1 | 1 | 1 | 1 | - | 21024-5 | WASHER, SPRG LOCK, REG NO 10 | 32 |
| - | 1 | 1 | 1 | 1 | - | 3-21000-4 | SCR, SKT HD CAP 10-32 X .375 | 31 |
| - | 1 | 1 | 1 | 1 | - | 1320908-4 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | - | 1633091-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | - | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | 1 | 1 | 1 | 1 | - | 1320928-1 | PLATE, STRIP GUIDE | 24 |
| - | 1 | - | - | 1 | - | 690472-2 | STRIPPER | 22 |
| - | 1 | 1 | 1 | 1 | - | 2-21000-7 | SCR, SKT HD CAP 8-32 X .500 | 21 |
| - | 4 | 4 | 4 | 4 | - | 21024-4 | WASHER, SPRG LOCK, REG NO 8 | 20 |
| - | - | 1 | 1 | - | - | 691353-1 | STRIPPER | 19 |
| - | 1 | 1 | 1 | 1 | - | 1-690518-1 | HOLD DOWN, TERMINAL | 18 |
| - | 1 | 1 | 1 | 1 | - | 690463-1 | FLOATING SHEAR, REAR | 17 |
| - | 2 | 2 | 2 | 2 | - | 1-21000-8 | SCR, SKT HD CAP 6-32 X .250 | 16 |
| - | 1 | 1 | 1 | 1 | - | 690691-9 | PLATE, REAR SHEAR | 15 |
| - | - | 1 | 1 | - | - | 690462-1 | SHEAR HOLDER, REAR | 14 |
| - | 1 | - | - | - | - | 679625-1 | SHEAR HOLDER, FRONT (NO CUT) | 13 |
| - | 2 | 2 | 2 | 2 | - | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 2 | 2 | 2 | 2 | - | 690461-1 | STOP, SHEAR | 11 |
| - | - | 1 | 1 | - | - | 690459-1 | SHEAR HOLDER, FRONT | 10 |
| △ | 1 | 1 | 1 | 1 | - | 462006-1 | FLOATING SHEAR, FRONT | 9 |
| △ | 1 | 1 | 1 | 1 | - | 4-1633107-0 | ANVIL, COMBINATION .062 | 8 |
| - | - | - | - | - | .. | - | - | 7 |
| - | 1 | 1 | 1 | 1 | - | 690468-1 | DEPRESSOR SHEAR, REAR | 6 |
| - | 1 | 1 | 1 | 1 | - | 455889-9 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | - | 2-238011-2 | BLOCK, CRIMPER SPACER | 4 |
| △ | 1 | 1 | 1 | 1 | - | 4-456135-4 | CRIMPER, INSULATION O PREMIUM | 3 |
| △ | 1 | 1 | 1 | 1 | - | 455888-3 | SPACER, CRIMPER | 2 |
| △ | 1 | 1 | 1 | 1 | - | 2-456403-6 | CRIMPER, WIRE PREMIUM | 1 |

| | | | | | | | |
|---|--|---|--|---|--|---|--|
| DIMENSIONS: INCHES 9 PLC ±.01 1 PLC ±.01 3 PLC ±.001 4 PLC ±.0001 ANGLES ±.001 | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 9 PLC ±.01 1 PLC ±.01 3 PLC ±.001 4 PLC ±.0001 ANGLES ±.001 | | DWN: 15APR2008 G. G. BAILEY: 15APR2008 W. DEMING: 15APR2008 | | Tyco Electronics Harrisburg, PA 17105-3608 | |
| MATERIAL: - FINISH: - | | | | WEIGHT: - | | SIZE: A1 00779 C=1852684 | |
| CUSTOMER DRAWING | | | | SCALE: 3:5 SHEET: 1 OF 1 REV: A | | RESTRICTED TO: - | |

CUSTOMER VIEWABLE ASSEMBLY