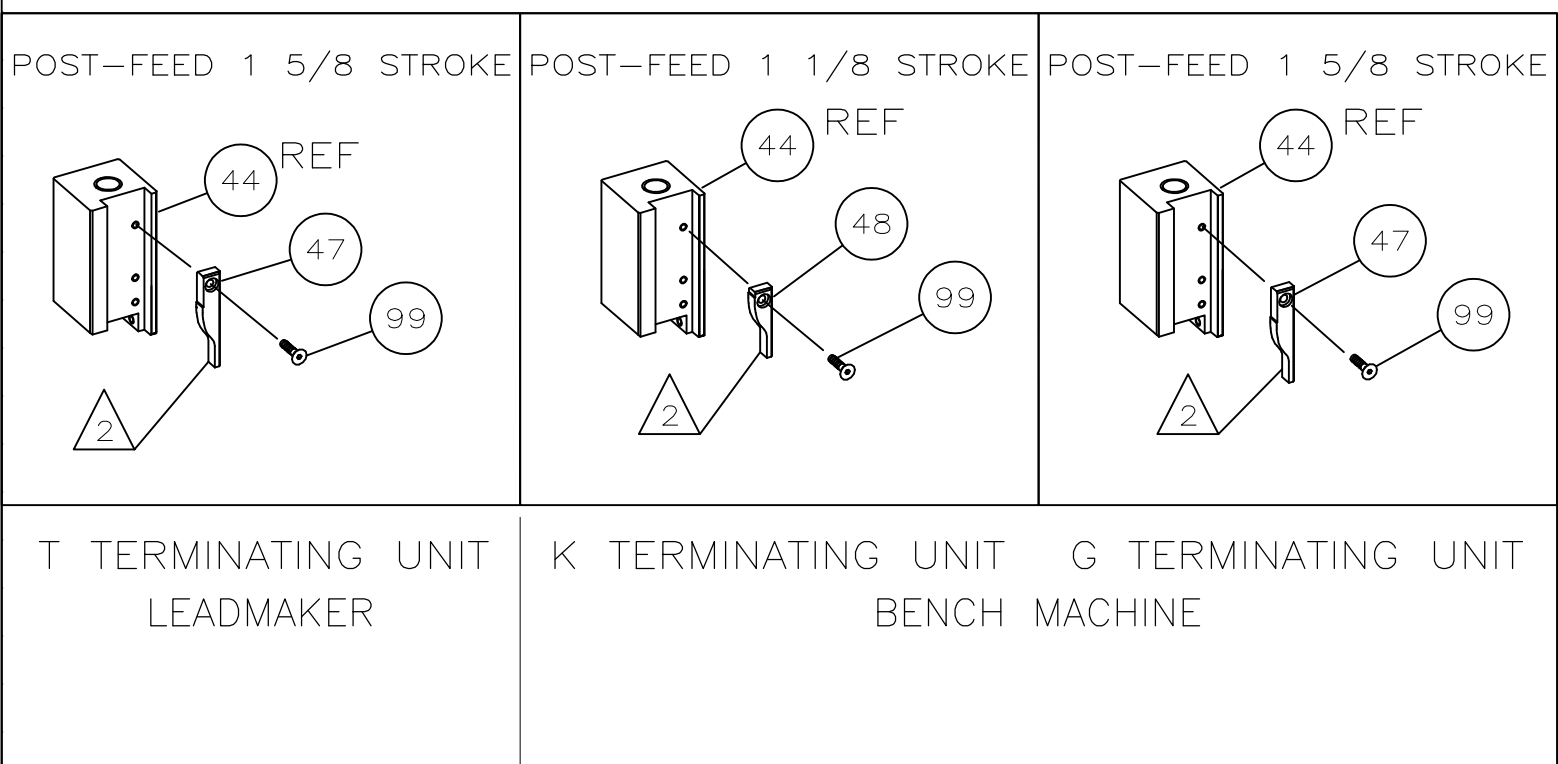
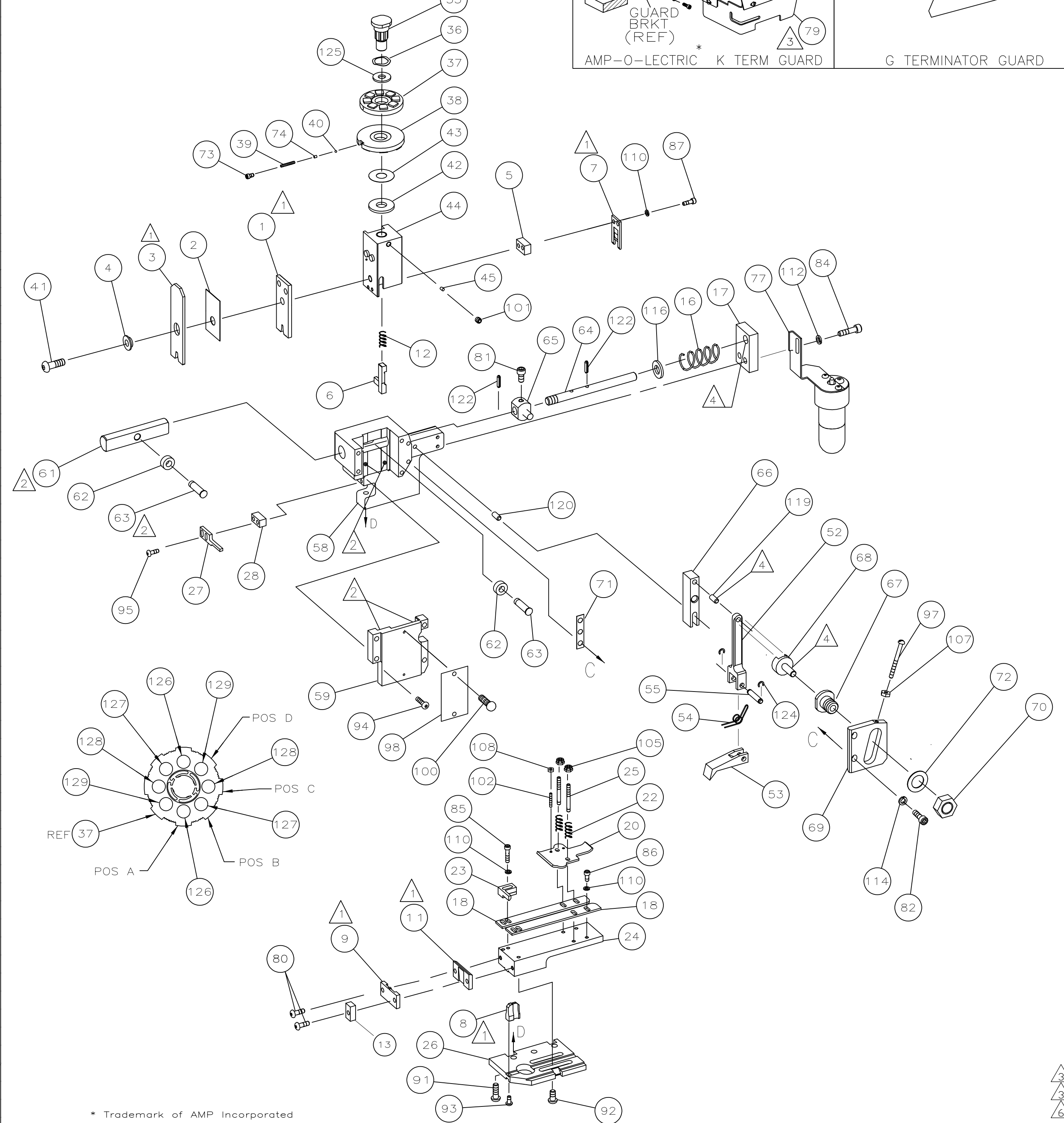
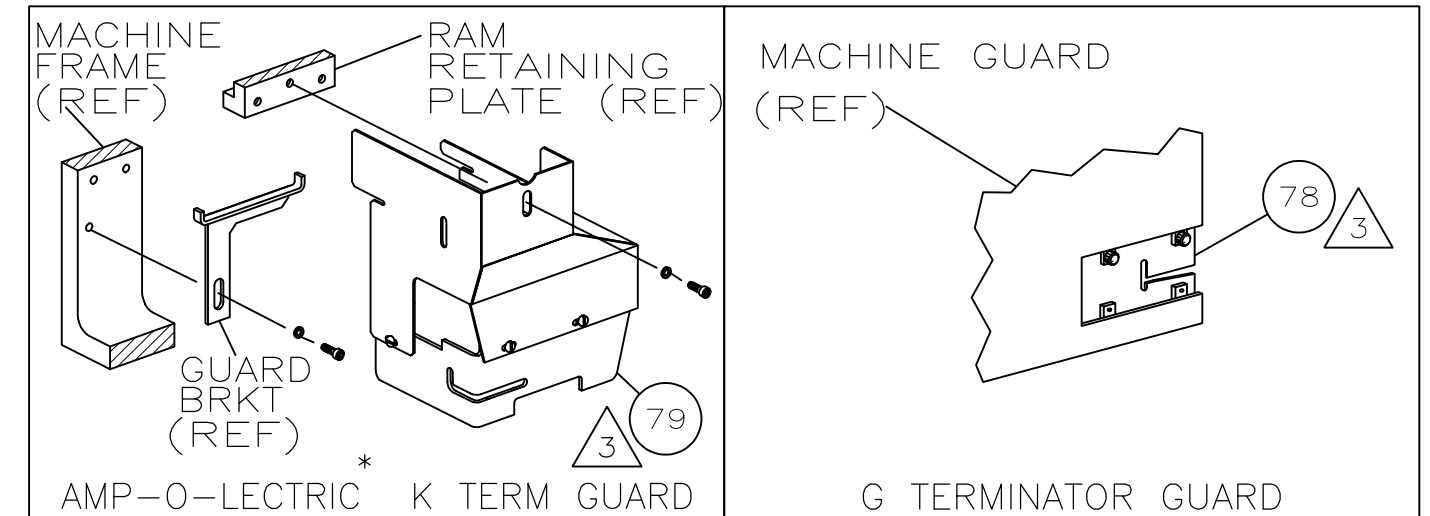


| PART NUMBER | REV | FIRST USED |
|-------------|-----|------------------|
| 466649-1 | U | 854400-1 |
| 466649-2 | U | 565435-5 |
| 466649-3 | - | SEE DWG 466649-3 |
| 466649-4 | - | SEE DWG 466649-4 |
| 466649-5 | M | SUPSD BY -1 |
| 7-466649-7 | S | - |



- 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 LUBRICATION REQUIRED TO APPLY NICKEL, GOLD OR SILVER PLATED TERMINALS
- 7 ITEM 78 REQD FOR BENCH G ONLY

| TERMINAL NAME: | |
|----------------|----------|
| RING | FASTON |
| 350981 | 42219 |
| | 42400 |
| SPADE | 42660 |
| 350983 | 60650 |
| | 60713 |
| | 63306 |
| | 1217393 |
| FASTON | 1217272 |
| 1742198 | 63674 |
| | 63985 |
| | 151919-1 |
| | 154692-1 |
| TERM APPL SPEC | 114-2036 |

| CRIMPING DATA | | | |
|-------------------|--------------|------------------------|-----------|
| PAD LTR | CRIMP HEIGHT | WIRE SIZE | |
| A | .073 ±.002 | (1)14 OR (1)18 & (1)16 | |
| B | .068 ±.002 | (2)18 | |
| C | .064 ±.002 | (1)16 OR (1)20 + (1)18 | |
| D | .058 ±.002 | (1)18 | |
| CRIMP | SIZE | TYPE | RANGE |
| WIRE | .110 | F | 18-14 |
| INSUL | .180 | F | .120-.170 |
| FEED | APPL INST | SET UP GAGE | LAYOUT |
| .843 | 408-8039 | 458638-1 | 20 HD |
| WIRE STRIP LENGTH | .205-.235 | | |

| LOC | DIST | REVISIONS | | | |
|-----|---------------|-------------|--------|----|------|
| F | LTR | DESCRIPTION | DATE | BY | APPV |
| A | 66 | | | | |
| U2 | ECR-09-015387 | | 7-2009 | MY | TE |

| | | |
|-----|---------------------------|----------------|
| -1 | LEADMAKER & BENCH MODEL G | MECH POST FEED |
| -2 | BENCH MODEL K | MECH-POST FEED |
| -77 | SPARE TOOLING KIT | |

| | | | | | |
|-------------------|-----|------------|------------|-----------------------------------|---------|
| - 2 | 2 | - | 354779-2 | PIN, WIRE DISC (.3000)D | 129 |
| - 2 | 2 | - | 8-354778-9 | PIN, WIRE DISC (.2940)C | 128 |
| - 2 | 2 | - | 8-354778-1 | PIN, WIRE DISC (.2900)B | 127 |
| - 2 | 2 | - | 7-354778-1 | PIN, WIRE DISC (.2850)A | 126 |
| - 1 | 1 | - | 986950-1 | WASHER, FLAT PRECISION | 125 |
| - REF | REF | - | 21045-3 | RING, RET "C" (Ø.187) FD PIN | 124 |
| - REF | REF | - | | | 123 |
| - REF | REF | - | 5-21028-1 | PIN, STD SPRING (Ø.12) FD ADJ ROD | 122 |
| - REF | REF | - | | | 121 |
| - REF | REF | - | 1-21030-7 | PIN, DOWEL (Ø.187x1.50) HSG | 120 |
| - REF | REF | - | 1-21030-1 | PIN, DOWEL (Ø.187x.50) LEVER | 119 |
| - REF | REF | - | | | 118 |
| - REF | REF | - | | | 117 |
| - REF | REF | - | 21899-4 | WASHER, FLAT (Ø5/16) SCR ADJ | 116 |
| - REF | REF | - | | | 115 |
| - REF | REF | - | 21024-5 | WASHER, LOCK (NO.10) FD ADJ PL | 114 |
| - REF | REF | - | | | 113 |
| - REF | REF | - | 21024-5 | WASHER, LOCK (NO.10) FD ROD GDE | 112 |
| - REF | REF | - | | | 111 |
| - 7 | 7 | - | 21024-4 | WASHER, LOCK (NO.8) SHEAR BL | 110 |
| - REF | REF | - | | | 109 |
| - 2 | 2 | - | 21018-4 | NUT, HEX (4-40) DRAG | 108 |
| - REF | REF | - | 21018-5 | NUT, HEX (6-32) FD ADJ PL | 107 |
| - REF | REF | - | | | 106 |
| - 2 | 2 | - | 21022-2 | NUT, HEX SL (8-32) DRAG STUD | 105 |
| - REF | REF | - | | | 104 |
| - REF | REF | - | | | 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 |
| - REF | REF | - | | | 100 |
| - 1 | 1 | - | 1-21002-7 | SCR, BHC (6-32x.38) CAM | 99 |
| - 1 | 1 | - | 461264-1 | PLATE, IDENTIFICATION | 98 |
| - REF | REF | - | 6-23715-5 | SCR, PAN HD (6-32x1.50) FEED ADJ | 97 |
| - REF | REF | - | | | 96 |
| - 2 | 2 | - | 2-21002-2 | SCR, BHC (8-32x.50) STRIPPER | 95 |
| - REF | REF | - | 2-21002-9 | SCR, BHC (10-32x.75) HSG 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 |
| - REF | REF | - | 2-22733-8 | SCR, BHC (1/4-20x.62) BASE PL | 91 |
| - REF | REF | - | | | 90 |
| - REF | REF | - | | | 89 |
| - 2 | 2 | - | 2-21000-7 | SCR, SHC (8-32x.50) SLUG BLADE | 87 |
| - 3 | 3 | - | 7-21000-4 | SCR, SHC (8-32x.31) STRIP GUIDE | 86 |
| - 2 | 2 | - | 2-21000-9 | SCR, SHC (8-32x.75) R STRIP GUIDE | 85 |
| - REF | REF | - | 3-21000-7 | SCR, SKT CAP (10-32x.75) FD GDE | 84 |
| - REF | REF | - | | | 83 |
| - REF | REF | - | 3-21000-6 | SCR, SKT CAP (10-32x.62) FD ADJ P | 82 |
| - REF | REF | - | 3-21000-4 | SCR, SKT CAP (10-32x.38) PIVOT BL | 81 |
| - 2 | 2 | - | 3-21002-0 | SCR, BHC (10-32x.88) SH PL | 80 |
| - REF | REF | - | 455745-1 | GUARD, WINDOW | 79 |
| - REF | REF | - | 679532-1 | INSERT, GUARD | 78 |
| - 1 | - | - | 465184-9 | LUBRICATOR ASSY | 77 |
| - REF | REF | - | | | 76 |
| - 1 | 1 | - | 690603-1 | SPRING, ASSIST | 74 |
| - 1 | 1 | - | 23030-1 | SCR, SKT CAP (6-32x.25) CP DSC | 73 |
| - REF | REF | - | 458109-1 | WASHER, FLAT (SPECIAL) | 72 |
| - REF | REF | - | 690517-1 | SPACER | 71 |
| -77 | -2 | -1 | U/M | PART NO | ITEM NO |
| QTY REQD PER ASSY | | PARTS LIST | | | ITEM NO |

| | | | | | |
|-------------------|-----|------------|------------|------------------------------|---------|
| - REF | REF | - | 22594-8 | NUT, HEX | 70 |
| - REF | REF | - | 240628-1 | PLATE, ADJ | 69 |
| - REF | REF | - | 240626-1 | SHAFT, PIVOT | 68 |
| - REF | REF | - | 240633-1 | BUSHING | 67 |
| - REF | REF | - | 455680-1 | LEVER, INTERMEDIATE | 66 |
| - REF | REF | - | 240629-1 | BLOCK, PIVOT | 65 |
| - REF | REF | - | 240632-2 | SCR, ADJ | 64 |
| - REF | REF | - | 240659-3 | PIN, CAM ROLLER | 63 |
| - REF | REF | - | 240658-1 | CAM, ROLLER | 62 |
| - REF | REF | - | 454398-1 | ROD, FEED | 61 |
| - REF | REF | - | | | 60 |
| - REF | REF | - | 454220-1 | CAP, RAM | 59 |
| - REF | REF | - | 453736-1 | HOUSING | 58 |
| - REF | REF | - | | | 57 |
| - REF | REF | - | | | 56 |
| - REF | REF | - | 240624-1 | PIN, FEED FINGER | 55 |
| - REF | REF | - | 691499-1 | SPRING, FEED FINGER | 54 |
| - REF | REF | - | 240635-1 | FINGER, FEED | 53 |
| - REF | REF | - | 240634-3 | LEVER, TERMINAL | 52 |
| - REF | REF | - | | | 51 |
| - REF | REF | - | | | 50 |
| - 1 | - | - | 690501-3 | CAM, POST FEED 1 1/8 ST | 48 |
| - - | - | - | 690501-4 | CAM, POST-FEED 1 5/8 ST | 47 |
| - REF | REF | - | | | 46 |
| - 1 | 1 | - | 690191-1 | PLUG, NYLON | 45 |
| - 1 | 1 | - | 455674-1 | RAM | 44 |
| - 1 | 1 | - | 690125-1 | WASHER, LAMINATED | 43 |
| - 1 | 1 | - | 690124-9 | 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 | - | 690142-1 | 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 |
| - REF | REF | - | | | 34 |
| - REF | REF | - | | | 33 |
| - 1 | 1 | - | 458980-2 | APPLICATOR, BASIC (SUB ASSY) | 32 |
| - REF | REF | - | | | 31 |
| - REF | REF | - | | | 30 |
| - REF | REF | - | | | 29 |
| - 1 | 1 | - | 3-690451-2 | SPACER, STRIPPER | 28 |
| - 1 | 1 | - | 240639-1 | STRIPPER | 27 |
| - REF | REF | - | 455676-1 | PLATE, BASE | 26 |
| - 2 | 2 | - | 22354-8 | DRAG, STUD | 25 |
| - 1 | 1 | - | 455678-1 | PLATE, STRIP GUIDE | 24 |
| - 1 | 1 | - | 240825-2 | PLATE, STRIP HOLD DOWN | 23 |
| - 2 | 2 | - | 4-22281-1 | SPRING, DRAG | 22 |
| - REF | REF | - | | | 21 |
| - 1 | 1 | - | 454177-1 | DRAG, STOCK | 20 |
| - REF | REF | - | | | 19 |
| - 2 | 2 | - | 454204-3 | GUIDE, STRIP (FRONT) | 18 |
| - REF | REF | - | 454178-1 | GUIDE, FEED ROD | 17 |
| - REF | REF | - | 4-22284-9 | SPRING, FEED RETURN | 16 |
| - REF | REF | - | | | 15 |
| - REF | REF | - | | | 14 |
| - 1 | 1 | - | 690481-2 | SPACER, HOLD DOWN | 13 |
| - 1 | 1 | - | 23846-1 | SPRING, HOLD DOWN | 12 |
| - 1 | 1 | - | 240644-1 | PLATE, REAR SHEAR | 11 |
| - REF | REF | - | | | 10 |
| - 1 | 1 | - | 690482-3 | PLATE, FRONT SHEAR | 9 |
| 1 | 1 | 1 | 238005-1 | ANVIL | 8 |
| - 1 | 1 | - | 690474-3 | BLADE, SLUG | 7 |
| - 1 | 1 | - | 4-455892-4 | HOLD DOWN, TERMINAL | 6 |
| - 1 | 1 | - | 1-240641-0 | SPACER, SLUG BLADE | 5 |
| - 1 | 1 | - | 238009-1 | SPACER, BLOCK CRIMPER | 4 |
| 1 | 1 | 1 | 6-456134-1 | CRIMPER, INSULATION | 3 |
| - 1 | 1 | - | 455888-7 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 456422-2 | CRIMPER, WIRE | 1 |
| -77 | -2 | -1 | U/M | PART NO | ITEM NO |
| QTY REQD PER ASSY | | PARTS LIST | | | ITEM NO |

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES
 TOLERANCES UNLESS OTHERWISE SPECIFIED:
 0 PL ± .005
 1 PL ± .005
 2 PL ± .005
 3 PL ± .005
 4 PL ± .005
 ANGLES ± .005

MATERIAL: - FINISH: -
 WEIGHT: -
 CUSTOMER DRAWING: -

BDN: P. MATHIAS 4/12/94
 CHK: C. ERISMAN 4-12-94
 APPR: B. WOLFE 4-12-94
 NAME: B. WOLFE
 PRODUCT SPEC: -
 APPLICATION SPEC: -
 SIZE: A1
 CASE CODE: 00779
 DRAWING NO: 466649
 RESTRICTED TO: -
 SCALE: - SHEET 1 of 1 REV: U2

Tyco Electronics Corporation
 Harrisburg, PA 17105-3608
 END FEED HDM APPLICATOR