

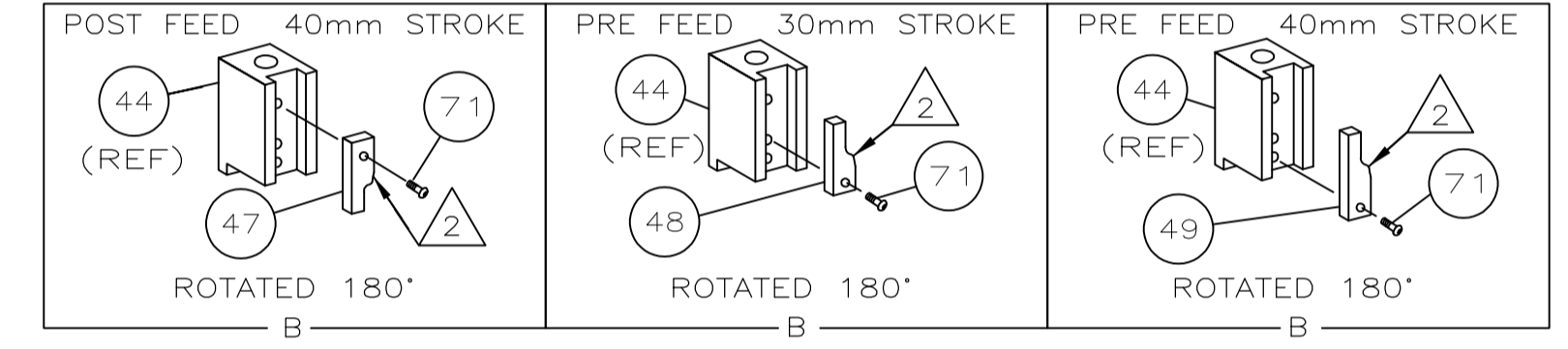
PART NUMBER	REV	FIRST USED	5
1-1385346-1	E		-
1-1385346-2	E		-
1-1385346-3	E		-

MISC CRIMP DATA	
DEUTSCH TERMINAL DEUTSCH SPEC	
WIRE CRIMP SIZE TYPE	.140 [3.56mm] F
WIRE STRIP LENGTH	.225-.275
FEED	SET UP GAGE
.651	458637-1
LAYOUT	APPL INSTR
L2537	408-8040

TERMINAL APPLICATION CHART

TERMINAL DEUTSCH AMP EQUIV	TERMINAL INSUL RANGE	APPLICATOR PART NUMBER	TOOLING INSUL RANGE	ANVIL	INSUL CRIMPER	INSUL CRIMP WIDTH	WIRE CRIMP WIDTH	WIRE SIZE	CRIMP HEIGHT ±.002 [±0.05]	REF * SETTING
1060-12-02**	286988	1-1385346-1	.185-.204	1-1424534-5	6-904741-2	.190 O	.140 F	6mm ²	.107 [2.72mm]	A6
1062-12-02**	286989	1-1385346-2	.155-.190	1-1424534-9	6-904741-3	.180 O		10 OR 5mm ²	.099 [2.51mm]	B6
		1-1385346-3	.125-.160	1-1424534-6	6-904741-4	.140 O		4mm ²	.085 [2.16mm]	D6

- 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 APPLICATOR SET UP FOR 40 mm BENCH TERMINATOR FROM THE FACTORY. THIS APPLICATOR MUST BE RECONFIGURED TO RUN IN A DIFFERENT TERMINATOR. PLEASE REFER TO THE CAM CONFIGURATION AND APPLICATOR INSTRUCTION SHEET FOR PROPER FEED ADJUSTMENT.



CAM CONFIGURATION

- 6 ** IN TERMINAL NUMBER REFERS TO THE PLATING. CONSULT THE DEUTSCH COMPANY FOR PLATING OPTIONS.
- 7 SHIM MAY NEED TO CHANGE TO OBTAIN ALL CRIMP HEIGHTS FOR ALL TERMINALS.

*** WARNING:**

ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN REQ'D CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
			113
			112
			111
			110
1	1-1424534-6	ANVIL	109
1	6-904741-4	CRIMPER, INSULATION	108
			107
			106
			105
			104
1	1-1424534-9	ANVIL	103
1	6-904741-3	CRIMPER, INSULATION	102
1	4-21028-0	PIN,SLT SPR(Ø.093x.75)ST GDE PL	101
-13	-12	-11 U/M	
PARTS LIST			

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
			100
			99
			98
1	21024-5	WASHER, LOCK(#10)ADJ BLOCK	97
			96
			95
2	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	94
			93
			92
4	21024-4	WASHER,LOCK(#8)STRIPPER	91
			90
			89
1	21018-5	NUT,HEX(NO.6)HOLDDOWN	88
			87
			86
1	22353-8	SCR,SHLD(Ø.187x.25)DRAG LEVER	85
			84
1	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	83
2	21017-2	SCR,DRIVE(#2x.19)ID PLATE	82
			81
			80
1	461264-5	PLATE, IDENTIFICATION	79
2	5-21006-6	SCR,SET(10-32x.75)DRAG	78
1	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	77
			76
			75
6	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	74
			73
			72
1	1424350-1	HOLDER, PIN, WIRED	71
1	1-21002-7	SCR,BHC(6-32x.38)CAM	70
3	23147-7	SPRING, DEPRESSOR	69
			68
2	2-21000-8	SCR,SHC(8-32x.62)DEP-HOLD	67
1	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	66
2	2-21000-3	SCR,SHC(4-40x.25)F ST GUIDE	65
1	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	64
			63
			62
1	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	61
			60
REF	REF	REF	59
REF	REF	REF	58
			57
1	1490524-2	SPACER, DEPRESSOR	56
1	1490525-1	DEPRESSOR, WIRE	55
			54
			53
			52
1	811242-2	BUMPER, HOLD DOWN	51
-13	-12	-11 U/M	
PARTS LIST			

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO	
1	690753-1	SPACER, TONKER	50	
1	690602-6	CAM, PRE-FEED 1 5/8 ST	49	
1	690602-5	CAM, PRE-FEED 1 1/8 ST	48	
1	690501-4	CAM, POST-FEED 1 5/8 ST	47	
1	459456-1	APPLICATOR, BASIC (SUBASSY)	46	
1	690191-1	PLUG, NYLON	45	
1	455673-1	RAM	44	
1	690125-1	LAMINATED WASHER	43	
			42	
1	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41	
1	458537-2	PAWL, FEED	40	
			39	
1	469367-9	SPACER, FINE ADJUST	38	
1	879103-3	FINE ADJUST HEAD SUBASSY	37	
			36	
			35	
1	690786-6	SUPPORT, TERMINAL	34	
			33	
1	690432-3	SCREW, ADJUSTMENT	32	
			31	
			30	
1	458144-1	PLATE, STRIP GUIDE	29	
1	455888-6	SPACER, FRONT SHEAR DEP	28	
2	1-22284-0	SPRING, DRAG	27	
1	240793-1	LEVER, DRAG RELEASE	26	
1	240792-1	DRAG, TERMINAL	25	
1	1-90765-2	GUIDE, STRIP (REAR)	24	
1	690438-1	GUIDE, STRIP (FRONT)	23	
			22	
			21	
			20	
1	2-1338987-9	STRIPPER	19	
			18	
			17	
1	318563-1	GUARD, CHIP, FRONT	16	
			15	
			14	
			13	
1	4-22280-8	SPRING, SHEAR	12	
1	690461-2	STOP, SHEAR	11	
1	1-690459-3	HOLDER, SHEAR (FRONT)	10	
1	2-454276-6	SHEAR, FLOAT (FRONT)	9	
-	-	1-1424534-5	ANVIL	8
1	1-240641-2	SPACER, DEPRESSOR (REAR)	7	
			6	
1	1-455889-8	DEPRESSOR, SHEAR (FRONT)	5	
1	238011-2	SPACER, BLOCK CRIMPER	4	
-	-	6-904741-2	CRIMPER, INSULATION	3
			2	
1	8-568176-1	CRIMPER, WIRE	1	
-13	-12	-11 U/M		
PARTS LIST				

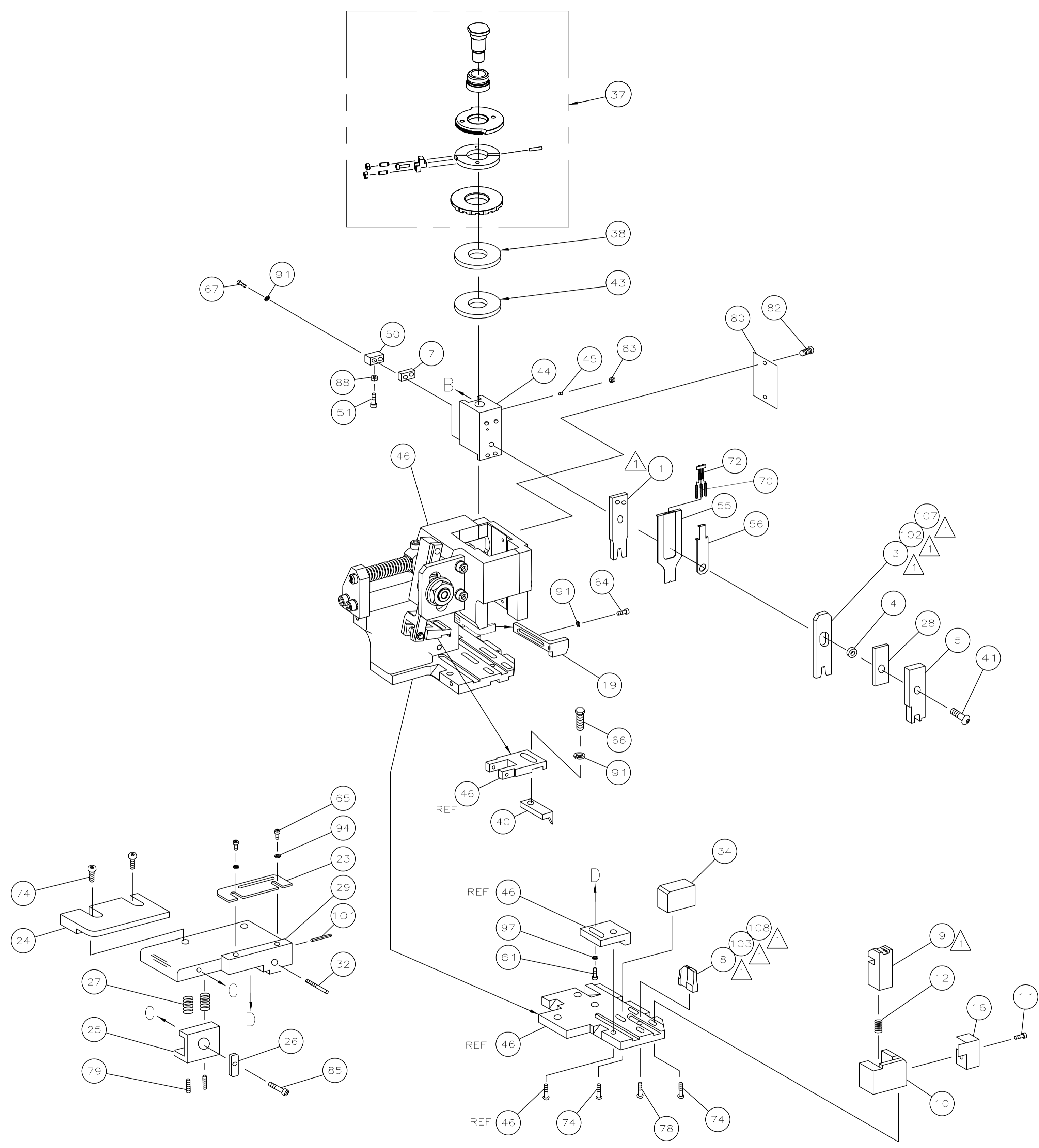
LOC A
DIST 66

REVISION RECORD	DATE	BY	APPROVED
E	8-2010	MY	GB

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:
INCHES	0 PLC ±.010
	1 PLC ±.005
	2 PLC ±.003
	3 PLC ±.002
	4 PLC ±.001

DWN: C.ERISMAN	16JAN02	MATERIAL: -	HEAT TREAT: -
CHK: -			
APVD: T.BENCHOFF	16JAN02	Tyco Electronics Corporation Harrisburg, PA 17105-3608	
SIDE FEED HDM APPLICATOR			
SCALE: -	SIZE: A1	DRAWING NO: 1385346	SHEET 1 OF 2
REVISION RECORD		DATE	BY

THIS DRAWING IS A CONTROLLED DOCUMENT. 1385346



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LOC A
DIST 66

P	LTR	REVISION RECORD	DATE	DWN	APVD

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
INCHES		0 PLC	± .-
		1 PLC	± .-
		2 PLC	± .-
		3 PLC	± .-
		4 PLC	± .-
ANGLES: #		-	
SURFACE TEXTURE		√	

DWN	16JAN02	MATERIAL	-	HEAT TREAT	-
CHK	-				
APVD	16JAN02	Tyco Electronics Corporation Harrisburg, PA 17105-3608			
NAME	T.BENCHOFF				
SIDE FEED HDM APPLICATOR					
SCALE	SIZE	DRAWING NO	SHEET	OF	REV
-	A1	1385346	2	2	E

CUSTOMER ACCESSIBLE PRODUCTION DRAWING