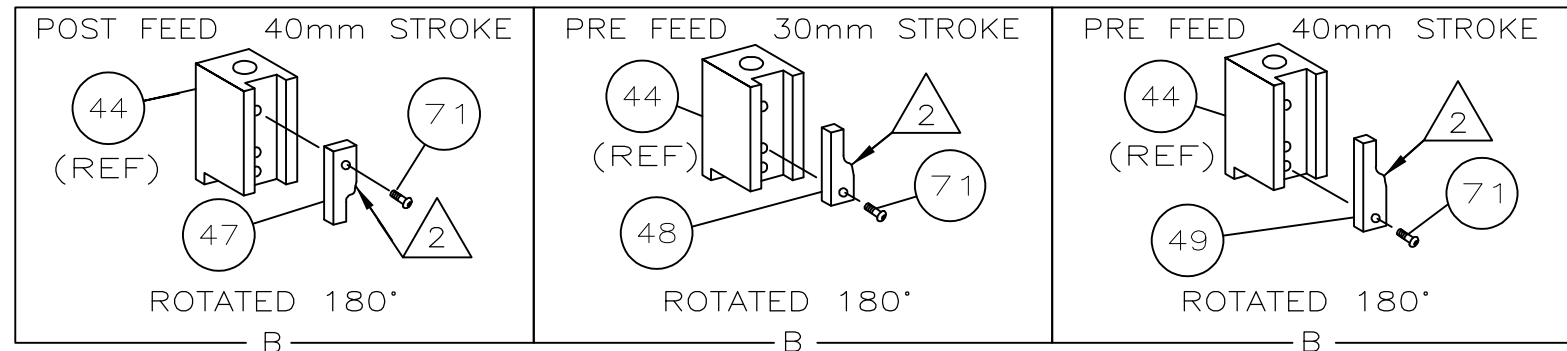


PART NUMBER	REV	FIRST USED	
1-1385346-1	E		-
1-1385346-2	E		-
1-1385346-3	E		-

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

- 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

- △ ** 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.

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

3	REF	REF	REF	—	455749-1	GUARD, WINDOW	59
	REF	REF	REF	—	679532-1	INSERT, GUARD	58
							57
	1	1	1	—	1490524-2	SPACER, DEPRESSOR	56
	1	1	1	—	1490525-1	DEPRESSOR, WIRE	55
							54
							53
							52
	1	1	1	—	811242-2	BUMPER, HOLD DOWN	51
X	-13	-12	-11	U/M	PART NO	DESCRIPTION	ITEM NO
					PARTS LIST		
	QTY	REQD	PER	ASSY			

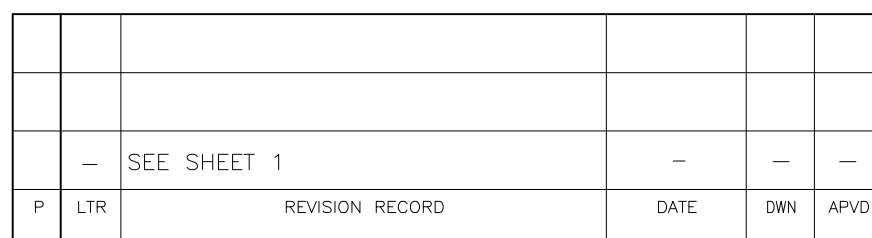
1	1	1	1	—	690753-1	SPACER, TONKER	50
1	1	1	1	—	690602-6	CAM, PRE-FEED 1 5/8 ST	49
1	1	1	1	—	690602-5	CAM, PRE-FEED 1 1/8 ST	48
1	1	1	1	—	690501-4	CAM, POST-FEED 1 5/8 ST	47
1	1	1	1	—	459456-1	APPLICATOR, BASIC (SUBASSY)	46
1	1	1	1	—	690191-1	PLUG, NYLON	45
1	1	1	1	—	455673-1	RAM	44
1	1	1	1	—	690125-1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

DWN	16JAN02	MATERIAL	—	HEAT TREAT	—
C.ERISMAN			—		—
CHK	—				
APVD	16JAN02	 Tyco Electronics Corporation Harrisburg, PA 17105-3608			
T.BENCHOFF					
NAME					
SIDE FEED HDM APPLICATOR					
SCALE	SIZE	DRAWING NO	SHEET	OF	REV
—	A 1	1385346	1	2	E

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

	E	ECR-10-017998		8-2010	MY	GB	
P	LTR	REVISION RECORD		DATE	DWN	APVD	

3308-8 (1/08)



CUSTOMER ACCESSIBLE PRODUCTION DRAWING