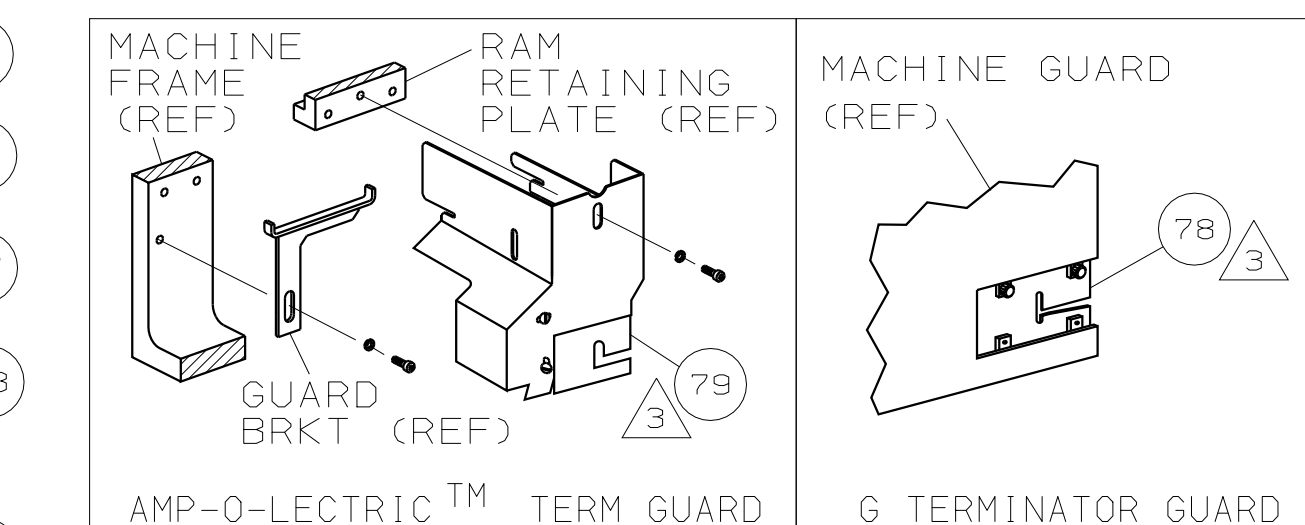
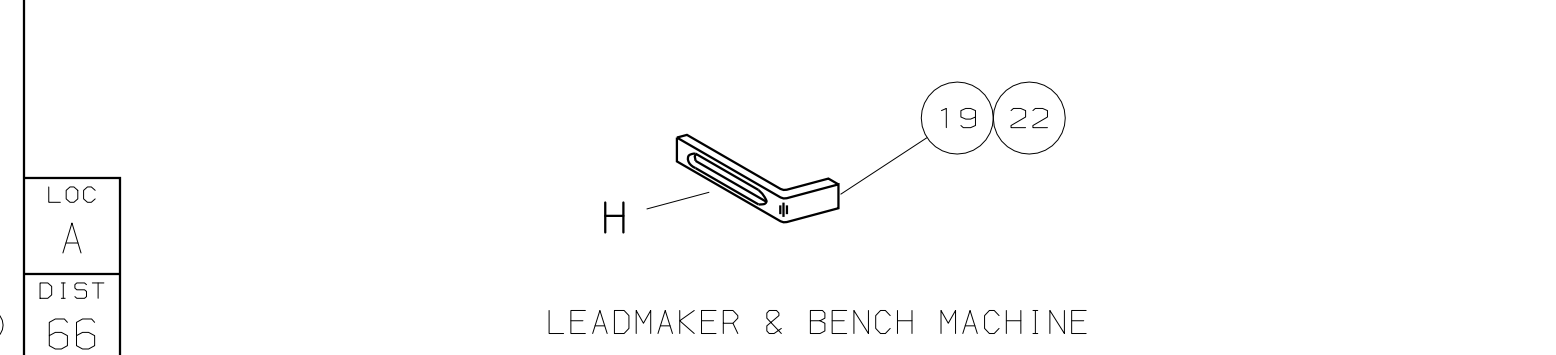
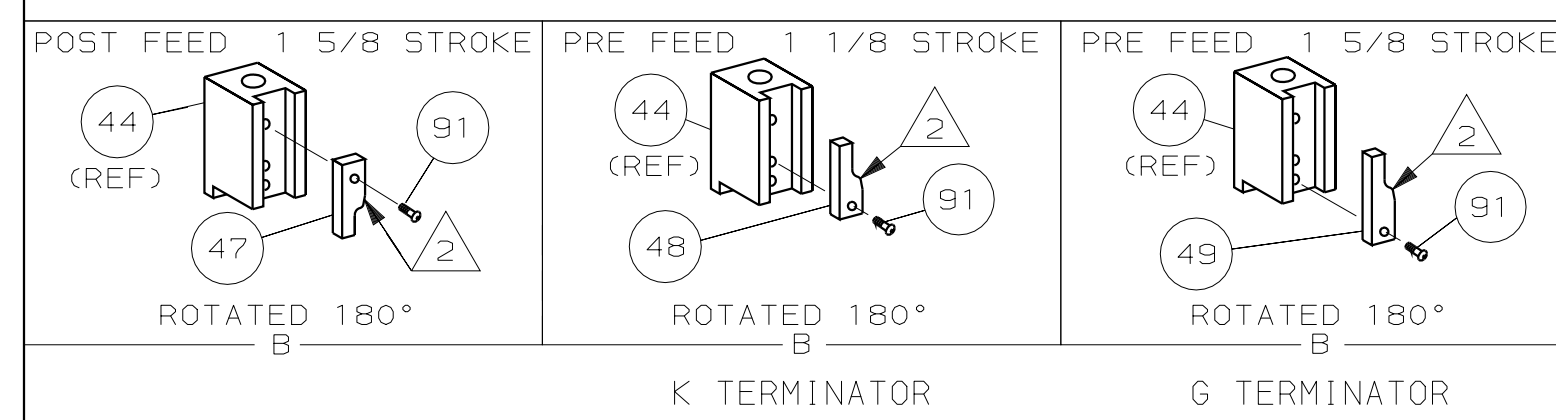
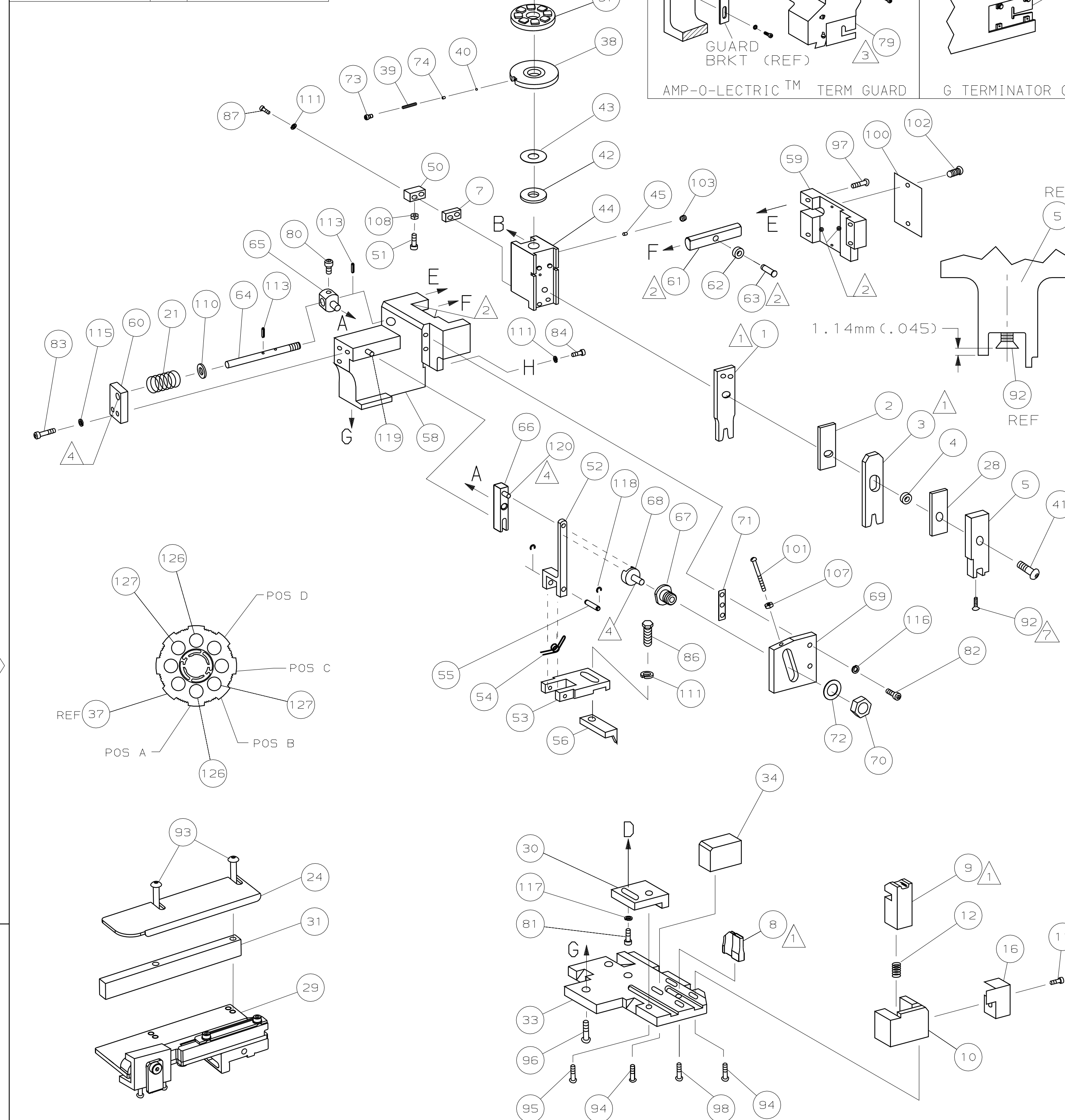


PART NUMBER	REV	FIRST USED
1852072-1	A	122500-1
1852072-2	A	565435-5
1852072-3	A	354500-1
7-1852072-7	A	-



TERMINAL NAME: ELO POWER 2.8 SEALED TERMINAL						
AMP TERMINAL PN	SIEMENS TERMINAL	AMP CRIMP SPECS				
2-1411593-1	PAD LTR	CRIMP HEIGHT	WIRE SIZE			
SIEMENS TERMINAL PN	A	1.38 ±0.05mm [.054 ±.002]	1.0mm ²			
V23540-X6000-Y63	B	1.28 ±0.05mm [.050 ±.002]	0.75mm ²			
	C	NOT	USED			
	D	NOT	USED			
AMP SEAL PN	CRIMP	SIZE	TYPE			
0-1393458-1			RANGE			
SIEMENS SEAL PN	WIRE	1.83mm [.072]	F			
V23540-M1000-Z111	INSUL	3.99mm [.157]	0			
			0.75-1.0 mm ²			
			Ø3.5mm MAX			
WIRE STRIP LENGTH	TERM APPL	SPEC	FEED	APPL INSTRUCTION	SET UP GAGE	LAYOUT
5.1-5.9mm	NONE		10mm	408-8040	458637-1	L1852072

QTY	REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO					
-				129					
-	2	2	- C 3-354779-1	PIN, WIRE DISC (.3145)B	127				
-	2	2	- C 2-354779-2	PIN, WIRE DISC (.3100)A	126				
-	1	1	- A 986950-1	WASHER, FLAT PRECISION	125				
-	1	1	- A 217238-1	GENERAL INSTRUCTION PACKAGE	124				
-	1	1	- - 4088040	SF APPL INST 408-8040	123				
-				122					
-				121					
-	REF	REF	- A 1-21030-1	PIN, DOWEL (Ø.187x.50) LEVER	120				
-	REF	REF	- A 1-21030-6	PIN, DOWEL (Ø.187x1.25) HOUSING	119				
-	REF	REF	- A 21045-3	RING, RET "C" (Ø.187) FD FING PIN	118				
-	1	1	- A 21024-5	WASHER, LOCK (#10) ADJ BLOCK	117				
-	REF	REF	- A 21024-5	WASHER, LOCK (#10) ADJ PLATE	116				
-	REF	REF	- A 21024-5	WASHER, LOCK (#10) FEED GDE ROD	115				
-				114					
-	REF	REF	- A 5-21028-1	PIN, SLT SPR (Ø.125x.50) ADJ ROD	113				
-				112					
-	4	4	- A 21024-4	WASHER, LOCK (#8) STRIPPER	111				
-	REF	REF	- A 21899-4	WASHER, FLAT (Ø5/16) SCREW ADJ	110				
-				109					
-	1	1	- A 21018-5	NUT, HEX (NO. 6) HOLDDOWN	108				
-	REF	REF	- A 21068-5	NUT, HEX (6-32) FEED ADJ	107				
-				106					
-				105					
-	1	1	- A 21009-2	SCR, SKT SET (1/4-20x.25 LW) RAM	103				
-	2	2	- A 21017-2	SCR, DRIVE (#2x.19) ID PLATE	102				
-	REF	REF	- A 6-23715-5	SCR, PAN HD (6-32x1.50) FEED ADJ	101				
-	1	1	- B 461264-1	PLATE, IDENTIFICATION	100				
-				99					
-	1	1	- A 22733-8	SCR, BHC (8-32x.38 LW) ANVIL	98				
-	REF	REF	- A 2-21002-9	SCR, BHC (10-32x.75) CAP	97				
-	REF	REF	- A 2-22733-8	SCR, BHC (1/4-20x.62) HOUSING	96				
-	REF	REF	- A 2-21002-7	SCR, BHC (10-32x.50) SG ADJ BLOCK	95				
-	4	4	- A 2-21002-2	SCR, BHC (8-32x.50) TERM H DWN	94				
-	2	2	- A 2-21002-4	SCR, BHC (8-32x.75) R STP GDE	93				
-	1	1	- A 1-21003-9	SCR, FHC (6-32x.38) DEP	92				
-	1	1	- A 1-21002-7	SCR, BHC (6-32x.38) CAM	91				
-				90					
-				89					
-				88					
-	2	2	- A 2-21000-8	SCR, SHC (8-32x.62) DEP-HOLD	87				
-	1	1	- A 2-22603-0	SCR, HEX HD (8-32x.31) FEED FINGER	86				
-				85					
-	1	1	- A 2-21000-7	SCR, SHC (8-32x.50) STRIPPER	84				
-	REF	REF	- A 3-21000-7	SCR, SHC (10-32x.75) FEED ROD GD	83				
-	REF	REF	- A 3-21000-6	SCR, SHC (10-32x.62) FD ADJ BLK	82				
-	1	1	- A 3-21000-4	SCR, SHC (10-32x.38) SG ADJ BL	81				
-	REF	REF	- A 3-21000-4	SCR, SHC (10-32x.38) PIVOT BLK	80				
-	-	REF	- B 455749-1	GUARD, WINDOW	79				
-	REF	-	- B 679532-1	INSERT, GUARD	78				
-				77					
-				76					
-				75					
-	1	1	- A 690603-1	SPRING, ASSIST	74				
-	1	1	- A 23030-1	SCR, SHC (6-32x.25 SL) INS DISC	73				
-	REF	REF	- A 458109-1	WASHER, SPECIAL	72				
-	REF	REF	- A 690517-1	SPACER	71				
-	-77	-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO

- 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 46.
- 6 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 7 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY PN 1-23419-5 LOC-TITE TO THREADS.

QTY	REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO	
-				70	
-	REF	REF	- B 22594-8	NUT, HEX (1/2-20)	69
-	REF	REF	- B 240628-1	PLATE, ADJUSTMENT	68
-	REF	REF	- B 240626-1	SHAFT, PIVOT	67
-	REF	REF	- B 240633-1	BUSHING	66
-	REF	REF	- A 455680-1	LEVER, INTERMEDIATE	65
-	REF	REF	- B 240629-1	BLOCK, PIVOT	64
-	REF	REF	- A 240632-2	SCREW, ADJ FEED ROD	63
-	REF	REF	- B 240659-3	PIN, CAM ROLLER	62
-	REF	REF	- B 240658-1	ROLLER, CAM	61
-	REF	REF	- B 454398-2	ROD, FEED	60
-	REF	REF	- A 454178-1	GUIDE, FEED ROD	59
-	REF	REF	- C 454220-1	CAP, RAM	58
-	REF	REF	- D 454485-1	HOUSING	57
-				56	
-	1	1	- B 458537-2	PAWL, FEED	55
-	REF	REF	- B 240624-1	PIN, FEED FINGER	54
-	REF	REF	- B 691499-1	SPRING, FEED FINGER	53
-	REF	REF	- B 690541-1	HOLDER, FEED FINGER	52
-	REF	REF	- A 455679-1	LEVER, TERMINAL FEED ARM	51
-	1	1	- A 811242-2	BUMPER, HOLDDOWN	50
-	1	1	- A 690753-1	SPACER, TONKER	49
-	1	-	- B 690602-6	CAM, PRE-FEED 1 5/8 ST	48
-	-	-	- B 690602-5	CAM, PRE-FEED 1 1/8 ST	47
-	-	-	- B 690501-4	CAM, POST-FEED 1 5/8 ST	46
-	1	1	- B 459456-1	APPLICATOR, BASIC (SUBASSY)	45
-	1	1	- A 690191-1	PLUG, NYLON	44
-	1	1	- C 819307-4	RAM	43
-	1	1	- A 690125-1	WASHER, LAMINATED	42
-	1	1	- A 690124-1	WASHER, RAM	41
-	1	1	- A 7-21002-9	BOLT, CRIMPER (5/16x1.00)	40
-	1	1	- A 23241-6	BALL, STEEL	39
-	1	1	- A 690170-1	SPRING, COMPRESSION	38
-	1	1	- C 1-690142-1	DISC, INSULATION	37
-	1	1	- D 354777-1	DISC, WIRE	36
-	1	1	- A 22480-5	WASHER, SPRING	35
-	1	1	- B 690212-1	POST, RAM	34
-	1	1	- B 1-690786-2	SUPPORT, TERMINAL	33
-	REF	REF	- D 455675-1	PLATE, BASE	32
-				31	
-	1	1	- B 1320908-8	SPACER, STRIP GUIDE	30
-	REF	REF	- B 455689-1	BLOCK, STRIP GUIDE ADJ	29
-	1	1	- C 1633091-1	PLATE, STRIP GUIDE	28
-	1	1	- C 1-455888-0	SPACER, FRONT SHEAR DEP	27
-				26	
-				25	
-	1	1	- D 1320928-1	GUIDE, STRIP (REAR)	24
-				23	
-	-	-	- B 690472-2	STRIPPER	22
-	REF	REF	- A 4-22284-9	SPRING, FEED RETURN	21
-				20	
-	1	1	- B 690472-9	STRIPPER	19
-				18	
-				17	
-	1	1	- B 318563-1	GUARD, CHIP, FRONT	16
-				15	
-				14	
-	1	1	- A 5-22280-0	SPRING, SHEAR	13
-	1	1	- B 690461-2	STOP, SHEAR	12
-	1	1	- C 1-690459-0	HOLDER, SHEAR (FRONT)	11
-	1	1	- C 318707-3	SHEAR, FLOAT (FRONT)	10
1	1	1	- C 1633330-1	ANVIL	9
-	1	1	- C 2-240641-4	SPACER, DEPRESSOR (REAR)	8
-				7	
-				6	
-	1	1	- C 318701-1	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	- B 1-238011-9	SPACER, BLOCK CRIMPER	4
1	1	1	- C 3-1583690-9	CRIMPER, INSULATION	3
-	1	1	- C 1-455888-9	SPACER, CRIMPER	2
1	1	1	- C 1633305-6	CRIMPER, WIRE	1

DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATL	HT TR	FIN
2 PLC DEC ± -		DR R. KNEPPER	30JUN05	APP T.ELBIN
3 PLC DEC ± -		CHK 04AUG05	REL 04AUG05	T.ELBIN
4 PLC DEC ± -		AMP Tyco Electronics Harrisburg, PA 17105-3808		
ANGLES ± -		NAME SIDE FEED HDM APPLICATOR MACHINE REF MINI APPL		
SURF TEXTURE: REMOVE BURRS, BREAK SHARP EDGES R.015 MAX		SCALE	DWG NO	1852072
REVISION RECORD		DATE	REV	1 OF 1
A	RELEASED	APP	DATE	A
P/F	LTR	REVISION RECORD	APP	DATE

CAGE CODE 00779 CUSTOMER AND ASSEMBLY DRAWING

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