

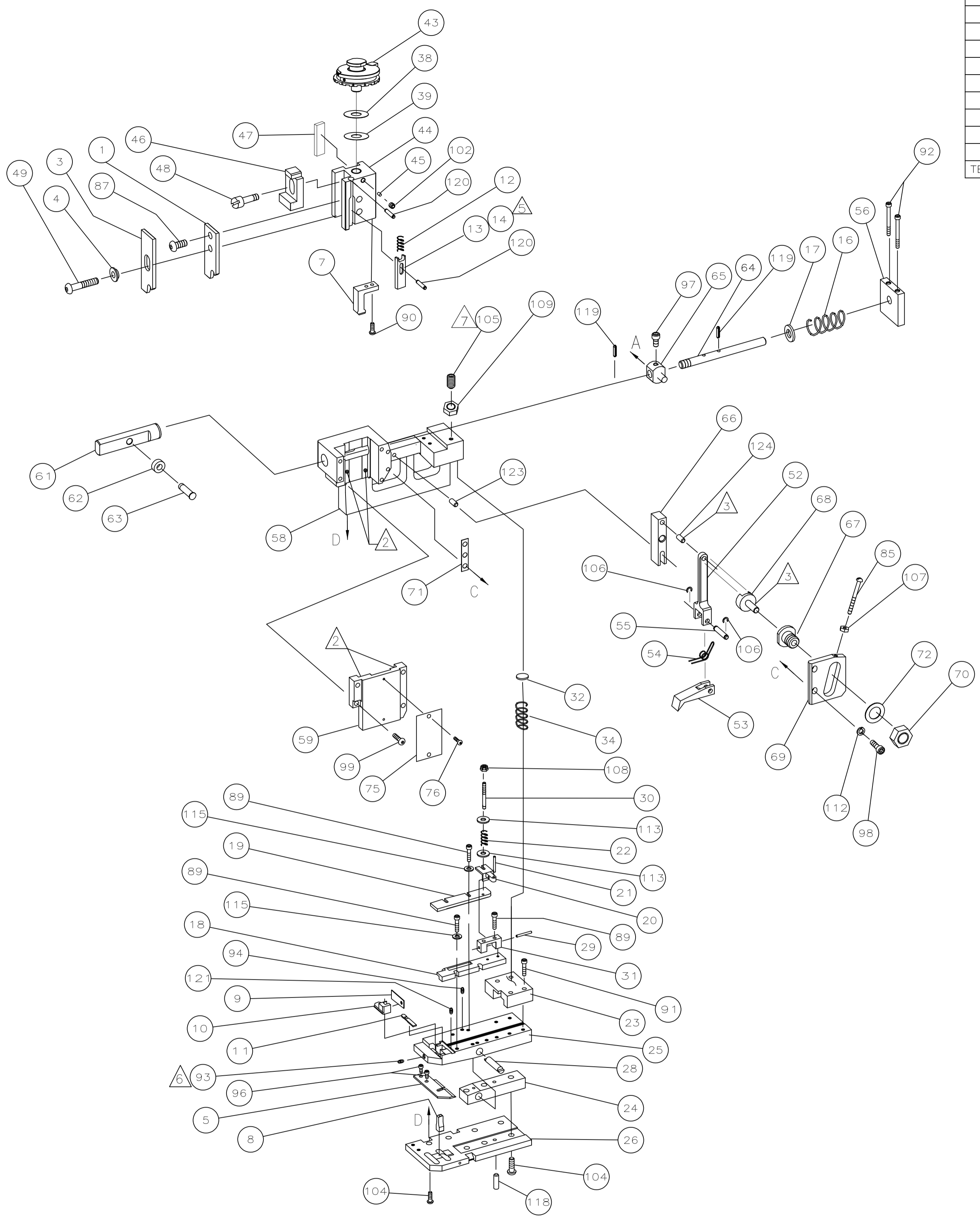
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PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE
1855521-1	C	-	LEADMAKER	MECH POST FEED

TERMINAL NAME:	
.250 FLAG FASTON RECEPTACLE	60851
	42563-6
	42563-8
	42563-9
TERM APPL SPEC 114-2078	

CRIMPING DATA			
PAD LTR	CRIMP HEIGHT	WIRE SIZE	REF SETTING
A	.089±.002	10	B0
B	.075±.002	12	D4
C	NOT	USED	-
D	NOT	USED	-
CRIMP	SIZE	TYPE	RANGE
WIRE	.200	TAB LOCK	12-10
INSUL	.220	0	.110-.210
FEED	APPL INST	SET UP GAGE	LAYOUT
.770	A18031	-	-
WIRE STRIP LENGTH .205-.235			



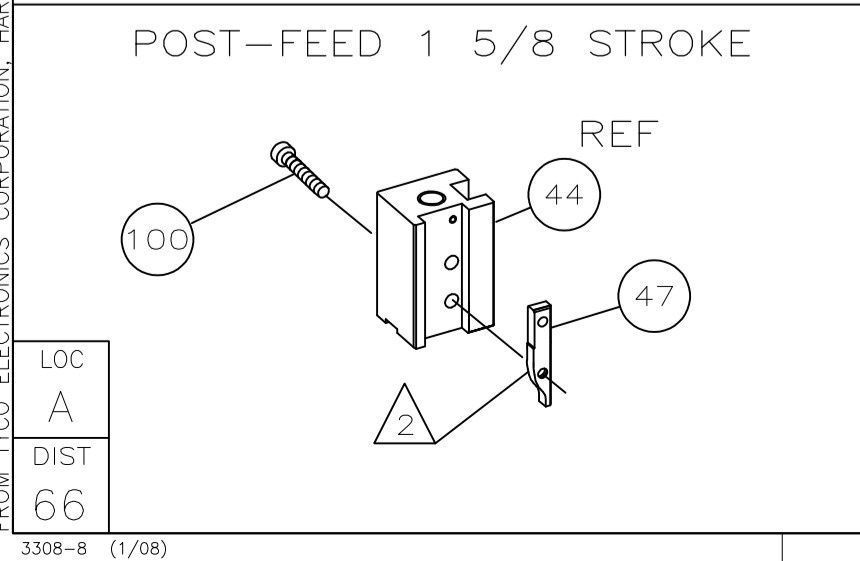
- ▲ 1 RECOMMENDED SPARE PARTS.
- ▲ 2 GREASE LIGHTLY.
- ▲ 3 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- 4. DO NOT EXCEED 80 C.P.M. WITH THIS APPLICATOR.
- ▲ 5 TERMINAL POSITIONERS (ITEMS 13 & 14) CAN BE CHANGED TO CENTER TAB IN SLOT WHILE CRIMPING
- ▲ 6 APPLY LOCTITE P/N 1-23419-5 TO ITEM 93 AT ASSEMBLY.
- ▲ 7 AFTER ASSEMBLY OF APPLICATOR, PROPER SPRING PRESSURE (ITEM 34) CAN BE OBTAINED BY TIGHTENING SET SCREW (ITEM 105) UNTIL CONTACT IS MADE WITH SPACER (ITEM 32) THEN TIGHTEN AN ADDITIONAL 5 1/2 - 6 REVOLUTIONS.

1	-	1-21030-2	PIN, DOWEL (Ø.187X.62)	124
1	-	1-21030-6	PIN, DOWEL (Ø.187X1.25)	123
2	-	3-21028-2	PIN, SLOTTED SPRING (Ø.094X.25)	121
3	-	4-21028-9	PIN, SLOTTED SPRING (Ø.125X.38)	120
2	-	5-21028-1	PIN, SLOTTED SPRING (Ø.125X.50)	119
1	-	21029-5	PIN, SLOTTED SPRING (Ø.188X.75)	118
4	-	21024-4	WASHER, LOCK (#8)	115
2	-	21055-6	WASHER, FLAT (#8)	114
2	-	21899-2	WASHER, FLAT (#10)	113
2	-	21024-5	WASHER, LOCK (#10)	112
1	-	1-22202-7	NUT, HEX (5/16-24)	109
1	-	21022-3	NUT, HEX (LOCKING)(10-32)	108
1	-	21018-5	NUT, HEX (6-32)	107
2	-	21045-3	RING, RET "C" (Ø.187) FD PIN	106
1	-	8-21007-5	SCREW, SKT SET (5/16-24x.75)	105
7	-	2-22733-8	SCREW, BHC (1/4-20X.63)	104
1	-	21009-2	SCREW, SKT SET (1/4-20x.25)	102
2	-	3-21000-9	SCREW, SHC (10-32X1.00)	100
4	-	3-21000-8	SCREW, SHC (10-32X.88)	99
2	-	3-21000-6	SCREW, SHC (10-32X.62)	98
1	-	3-21000-4	SCREW, SHC (10-32X.38)	97
2	-	7-21000-6	SCREW, SHC (10-32X.31)	96
1	-	4-21006-5	SCREW, SKT SET (8-32X.62)	94
1	-	21061-9	SCREW, SKT SET (8-32X.25)	93
2	-	3-21000-0	SCREW, SHC (8-32X.88)	92
4	-	2-21000-9	SCREW, SHC (8-32X.75)	91
2	-	1-23030-1	SCREW, SHC (NYLOK)(8-32X.62)	90
6	-	2-21000-8	SCREW, SHC (8-32X.62)	89
1	-	2-21002-1	SCREW, SBHC (8-32X.38)	87
1	-	6-23715-5	SCR, PAN HD (6-32x1.50) FEED ADJ	85
1	-	21017-2	SCR, DRIVE (2X .19)	76
1	-	461264-5	PLATE, IDENTIFICATION	75
1	-	458109-1	WASHER, SPECIAL	72
1	-	690517-1	SPACER	71

1	-	22594-8	NUT, HEX	70
1	-	240628-1	PLATE, ADJ	69
1	-	240626-1	SHAFT, PIVOT	68
1	-	240633-1	BUSHING	67
1	-	240630-1	LEVER, INTERMEDIATE	66
1	-	1804317-1	BLOCK, PIVOT	65
1	-	1633286-1	SCR, ADJ	64
1	-	240659-3	PIN, CAM ROLLER	63
1	-	240658-1	ROLLER, CAM	62
1	-	240631-1	ROD, FEED	61
1	-	2217626-1	CAP ASSEMBLY	59
1	-	2217625-1	HOUSING	58
1	-	458361-1	GUIDE, FEED ROD	56
1	-	240624-1	PIN, FEED FINGER	55
1	-	691499-1	SPRING, FEED FINGER	54
1	-	454568-1	FINGER, FEED	53
1	-	240634-1	LEVER, TERMINAL	52
1	-	3-21002-5	BOLT, CRIMPER	49
1	-	2256119-1	SCREW, SHOULDER	48
1	-	238015-1	CAM, POST-FEED 1 5/8 ST	47
1	-	690578-3	BLOCK, INSULATION ADJUST	46
1	-	690191-1	PLUG, NYLON	45
1	-	2217624-1	RAM	44
1	-	879103-2	FINE ADJUST HEAD ASSY	43
1	-	690125-1	SHIM, SUB-ASSY	39
1	-	1-469367-2	SHIM	38
1	-	3-23846-5	SPRING, HINGE BAR	34
1	-	690573-1	SPACER, SPRING	32
1	-	454569-1	MOUNT, DRAG	31
1	-	1-22354-8	STUD, DRAG	30
1	-	21030-2	PIN, MOUNT, DRAG	29
1	-	1633530-1	PIN, HINGE	28
1	-	684905-1	PLATE, BASE	26
1	-	454579-2	HINGE BAR	25
1	-	690571-1	BLOCK, STABILIZER	24
1	-	690585-1	BLOCK, PRESSURE	23
1	-	22282-5	SPRING, DRAG	22
1	-	21030-6	LEVER, DRAG	21
1	-	454570-1	DRAG, STOCK	20
1	-	454573-1	GUIDE, STRIP (REAR)	19
1	-	454571-1	GUIDE, STRIP (FRONT)	18
1	-	21899-4	WASHER, ADJ. SCREW	17
1	-	4-22284-9	SPRING, FEED RETURN	16
1	-	1-692134-6	POSITIONER, TERMINAL	14
1	-	692134-6	POSITIONER, TERMINAL	13
1	-	5-22280-5	SPRING, TERM. POSITIONER	12
1	-	454711-1	PLATE, REAR SHEAR	11
1	-	454710-1	ANVIL INSERT	10
1	-	1-690569-1	PLATE, FRONT SHEAR	9
1	-	690761-1	ANVIL	8
1	-	454575-4	BLADE, SLUG	7
1	-	684906-1	PLATE, ANVIL RETAINING	5
1	-	690574-1	SPACER, TUBULAR INSUL CRIMPER	4
1	-	690764-1	CRIMPER, INSULATION	3
1	-	690763-2	CRIMPER, WIRE	2

QTY REQD PER ASSY	U/M	PART NO	DESCRIPTION	ITEM NO
PARTS LIST				

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DIMENSIONS: INCHES
 TOLERANCES UNLESS OTHERWISE SPECIFIED:
 0 PLC ±.0005
 1 PLC ±.0010
 2 PLC ±.0015
 3 PLC ±.0020
 4 PLC ±.0025

SURFACE TEXTURE: ✓

SCALE: NTS A1
 SIZE: 1855521
 SHEET: 1 of 1
 REV: C

DATE: 25FEB2014
 DWN: KH
 APVD: TE

M.YOUNGER
 G.BAILEY
 T.ELBIN
 NAME: FINE ADJUST END FEED HINGE BAR APPLICATOR

MATERIAL: -
 HEAT TREAT: -
 16SEP2009
 16SEP2009

STE TE Connectivity
 Harrisburg, PA 17105-3608