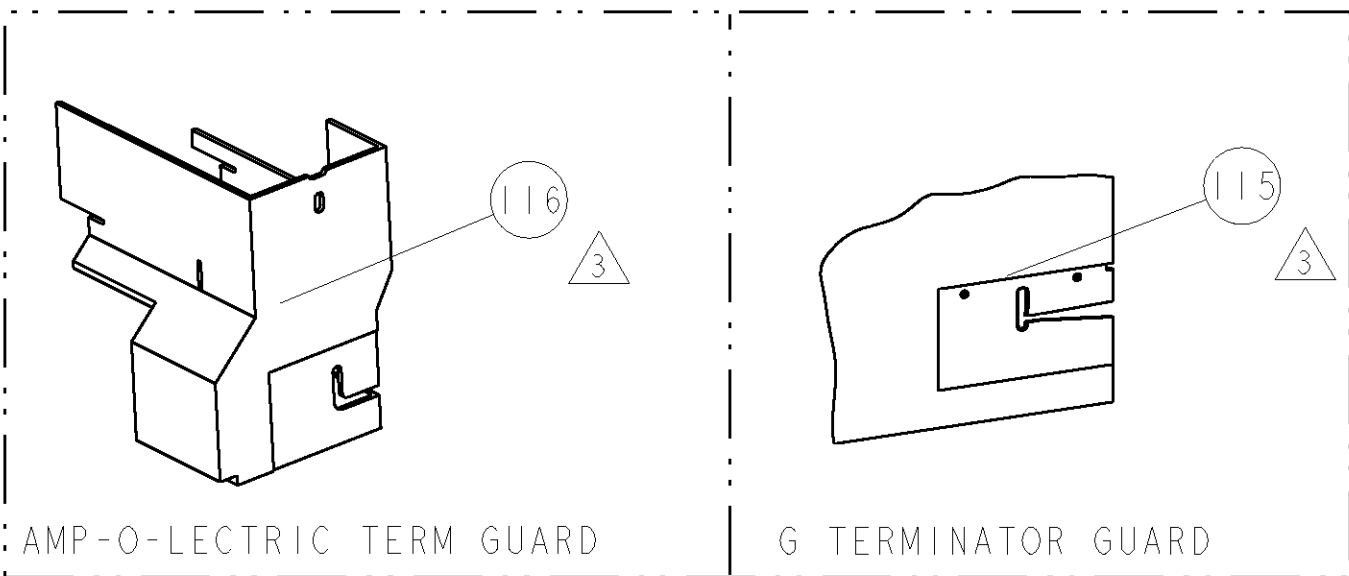
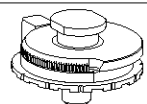


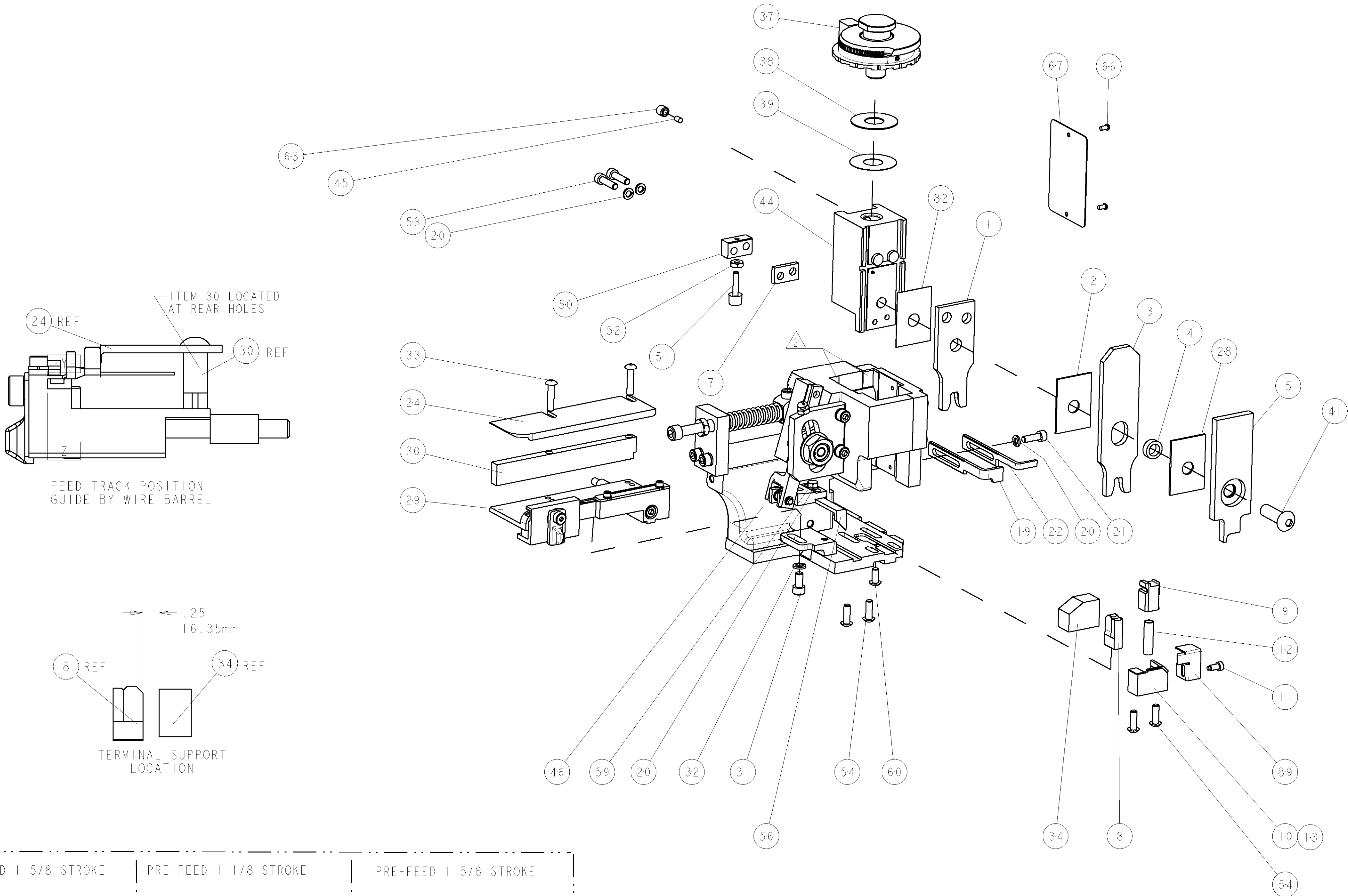
|                                                       |  |     |            |                          |           |                    |  |
|-------------------------------------------------------|--|-----|------------|--------------------------|-----------|--------------------|--|
| 8                                                     |  |     |            | 7                        |           |                    |  |
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| PART NUMBER                                           |  | REV | FIRST USED | POWER UNIT               | FEED TYPE | DESCRIPTION        |  |
| 1855472-1                                             |  | A   | 122500-1   | LEADMAKER                | POST FEED | CUTS CARRIER       |  |
| 1855472-2                                             |  | A   | 565435-5   | BENCH MODEL K            | PRE FEED  | CUTS CARRIER       |  |
| 1855472-3                                             |  | A   | 354500-1   | BENCH MODEL G            | PRE FEED  | CUTS CARRIER       |  |
| 1855472-6                                             |  | A   | 122500-1   | LEADMAKER                | POST FEED | CONTINUOUS CARRIER |  |
| 7-1855472-7                                           |  | A   | -          | -                        | -         | SPARE PARTS        |  |

- △ RECOMMENDED SPARE PARTS
- △ GREASE LIGHTLY
- △ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE

**\* WARNING**  
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN. REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



| TERMINAL NAME: TERMINAL, MALE BLADE TYPE |                                 |                                      |                                     |             |                         |  |
|------------------------------------------|---------------------------------|--------------------------------------|-------------------------------------|-------------|-------------------------|------------------------------------------------------------------------------------|
| TE PN                                    | YAZAKI                          | YAZAKI TERMINAL - YAZAKI CRIMP SPECS |                                     |             |                         |                                                                                    |
| 1949878                                  | 7114-2352-02                    |                                      |                                     |             |                         | REF SETTING                                                                        |
| -                                        | -                               | CRIMP HEIGHT                         |                                     | WIRE SIZE   |                         |                                                                                    |
| -                                        | -                               | 3.30mm+.05/- .05 [ .130+.002/- .002] |                                     | 10AWG       |                         |                                                                                    |
| -                                        | -                               | 3.10mm+.05/- .05 [ .122+.002/- .002] |                                     | 12AWG       |                         |                                                                                    |
| -                                        | -                               | 3.05mm+.05/- .05 [ .120+.002/- .002] |                                     | 14+14AWG    |                         |                                                                                    |
| -                                        | -                               | 2.85mm+.05/- .05 [ .112+.002/- .002] |                                     | 16+14AWG    |                         |                                                                                    |
| -                                        | -                               | CRIMP                                | SIZE                                | TYPE        | RANGE                   |                                                                                    |
| -                                        | -                               |                                      |                                     |             |                         |                                                                                    |
| -                                        | -                               | WIRE                                 | 5.33mm [ .210]                      | F           | 12-10 AWG               |                                                                                    |
| -                                        | -                               | INSUL                                | 5.99mm [ .236]                      | F           | Ø 5.000 MAX             |                                                                                    |
| WIRE STRIP LENGTH<br>5.25-5.63           | TERM APPL SPEC<br>XW4T-14421-DA | FEED<br>19.05                        | APPLICATOR INSTRUCTIONS<br>408-8040 |             | SET UP GAGE<br>458637-1 |                                                                                    |
| ADDITIONAL CRIMP HEIGHTS                 |                                 |                                      |                                     |             |                         |                                                                                    |
| CRIMP HEIGHT                             |                                 | WIRE SIZE                            |                                     | REF SETTING |                         |                                                                                    |
| 2.85±0.05mm [ .112±.002]                 |                                 | 16+16AWG                             |                                     | D4          |                         |                                                                                    |



|                     |   |   |     |     |   |    |             |                                       |         |
|---------------------|---|---|-----|-----|---|----|-------------|---------------------------------------|---------|
| △ 3                 | - | - | -   | REF | - | .. | 455749-1    | GUARD WINDOW                          | 116     |
| △ 3                 | - | - | REF | -   | - | .. | 679532-1    | INSERT, GUARD                         | 115     |
| -                   | - | 1 | 1   | 1   | 1 | -  | 1-21002-7   | SCR, BTN SKT HD CAP 6-32 X .375       | 91      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 318563-1    | GUARD, FRONT CHIP                     | 89      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 455888-1    | SPACER, CRIMPER                       | 82      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 4088040     | SF APPL INST 408-8040                 | 72      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 217238-1    | GENERAL INSTRUCTION PKG               | 71      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 461264-5    | PLATE, IDENTIFICATION                 | 67      |
| -                   | - | 2 | 2   | 2   | 2 | -  | 21017-2     | SCREW, DRIVE                          | 66      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 21009-2     | SCR, SET, SELF LOCKING 1/4-20 X .250  | 63      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 22733-8     | SCR, BHSC, SELF-LOCKING, 8-32 X .375  | 60      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 2-22603-0   | SCR, HEX HD CAP 8-32 X .312           | 59      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 458537-2    | PAWL, FEED                            | 56      |
| -                   | - | 4 | 4   | 4   | 4 | -  | 2-21002-2   | SCR, BTN SKT HD CAP 8-32 X .500       | 54      |
| -                   | - | 2 | 2   | 2   | 2 | -  | 2-21000-8   | SCR, SKT HD CAP 8-32 X .625           | 53      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 21018-5     | NUT, HEX, REG 6-32                    | 52      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 811242-2    | BUMPER, HOLD DOWN                     | 51      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 690753-1    | SPACER, TONKER                        | 50      |
| -                   | - | - | -   | -   | - | .. | 690602-6    | CAM, PRE FEED, 1 5/8                  | 49      |
| -                   | - | - | -   | -   | - | .. | 690602-5    | CAM, PRE FEED, 1 1/8                  | 48      |
| -                   | - | - | -   | -   | - | -  | 690501-4    | CAM, POST-FEED 1 5/8                  | 47      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 459456-1    | APPL. BASIC SUB ASSY (SIDE WISE MOCA) | 46      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 690191-1    | PLUG,NYLON                            | 45      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 3-819307-2  | RAM, SIDE FEED                        | 44      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 7-21002-9   | SCR, BTN SKT HD CAP 5/16-24 X 1.00    | 41      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 690125-1    | SHIM SUB-ASSY                         | 39      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 1-469367-2  | SHIM                                  | 38      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 879103-2    | FINE ADJUST HEAD ASSEMBLY             | 37      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 2-690786-3  | TERMINAL SUPPORT                      | 34      |
| -                   | - | 2 | 2   | 2   | 2 | -  | 2-21002-4   | SCR, BTN SKT HD CAP 8-32 X .750       | 33      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 21024-5     | WASHER, SPRG LOCK, REG NO 10          | 32      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 3-21000-4   | SCR, SKT HD CAP 10-32 X .375          | 31      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 1-1320908-0 | SPACER, STRIP GUIDE                   | 30      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 1633091-1   | ASSEMBLY, STRIP GUIDE                 | 29      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 1-455888-0  | SPACER, CRIMPER                       | 28      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 1320928-1   | PLATE, STRIP GUIDE                    | 24      |
| -                   | - | 1 | -   | -   | - | -  | 690472-2    | STRIPPER                              | 22      |
| -                   | - | 1 | 1   | 1   | 1 | -  | 2-21000-7   | SCR, SKT HD CAP 8-32 X .500           | 21      |
| -                   | - | 4 | 4   | 4   | 4 | -  | 21024-4     | WASHER, SPRG LOCK, REG NO 8           | 20      |
| -                   | - | - | -   | -   | - | -  | 691353-1    | STRIPPER                              | 19      |
| △ 1                 | - | 1 | -   | -   | - | -  | 679625-2    | SHEAR HOLDER, FRONT (NO CUT)          | 13      |
| △ 1                 | - | 1 | 1   | 1   | 1 | -  | 3-22280-3   | SPRING, COMPRESSION                   | 12      |
| △ 1                 | - | 1 | 1   | 1   | 1 | -  | 690461-2    | STOP, SHEAR                           | 11      |
| △ 1                 | - | - | -   | -   | - | -  | 1-690459-0  | SHEAR HOLDER, FRONT                   | 10      |
| △ 1                 | - | 1 | 1   | 1   | 1 | -  | 454276-5    | FLOATING SHEAR, FRONT                 | 9       |
| △ 1                 | 1 | 1 | 1   | 1   | 1 | -  | 3-1633381-1 | ANVIL, COMBINATION                    | 8       |
| -                   | 1 | 1 | 1   | 1   | 1 | -  | 240641-5    | SPACER                                | 7       |
| -                   | - | - | -   | -   | - | .. | -           | -                                     | 6       |
| -                   | 1 | 1 | 1   | 1   | 1 | -  | 1-455889-8  | DEPRESSOR, SHEAR                      | 5       |
| -                   | 1 | 1 | 1   | 1   | 1 | -  | 4-238011-2  | BLOCK, CRIMPER SPACER                 | 4       |
| △ 1                 | 1 | 1 | 1   | 1   | 1 | -  | 4-1633511-2 | CRIMPER, INSULATION F                 | 3       |
| △ 1                 | 1 | 1 | 1   | 1   | 1 | -  | 455888-9    | SPACER, CRIMPER                       | 2       |
| △ 1                 | 1 | 1 | 1   | 1   | 1 | -  | 1633738-9   | CRIMPER, WIRE                         | 1       |
| -77 -6 -3 -2 -1 U/M |   |   |     |     |   |    | PART NO     | DESCRIPTION                           | ITEM NO |

|                                                                                                              |  |                                                               |                                     |                                                 |  |
|--------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------|-------------------------------------|-------------------------------------------------|--|
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| DIMENSIONS:<br>INCHES                                                                                        |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                        |                                     | NAME<br>FINE ADJUST SIDE FEED<br>HDM APPLICATOR |  |
| 0 PLC ±.01<br>1 PLC ±.01<br>2 PLC ±.01<br>3 PLC ±.001<br>4 PLC ±.0001                                        |  | FINISH                                                        |                                     | SIZE CAGE CODE DRAWING NO<br>A1 00779 ©=1855472 |  |
| MATERIAL                                                                                                     |  | FINISH                                                        |                                     | RESTRICTED TO                                   |  |
| CUSTOMER DRAWING                                                                                             |  | SCALE 3:5                                                     |                                     | SHEET 1 OF 1                                    |  |
|                                                                                                              |  |                                                               |                                     | REV A                                           |  |

CUSTOMER VIEWABLE ASSEMBLY