4	3	2	I

LOC **DIST**

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	AD4	ECR-14-002796	26FEB2014	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2151032-2

FOR REPLACEMENT PARTS FOR APPLICATOR 466778
REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED)
WILL REMAIN AVAILABLE.

THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE
SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR
466778

THIS DRAWING IS A CONTROLLED DOCUMENT.

DWN	GOPALAKRISHNA HV
CHK	RAGHAVENDRA
APVD	RAGHAVENDRA

DIMENSIONS:

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC	±
I PLC	±
2 PLC	±
3 PLC	±
4 PLC	±
ANGLES	±

MATERIAL   **FINISH**

PRODUCT SPEC

APPLICATION SPEC

WEIGHT

NAME

≣TE   TE Connectivity

SIDE FEED HDM APPLICATOR

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A3		© 466778	

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

SCALE	SHEET 1 OF 3	REV AD4

1470-19 (3/11)

Pro/ENGINEER DRAWING
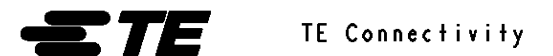
PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE
466778-3	AD	854400-1	LEADMAKER	AIRFEED
466778-4	AD	565435-5	BENCH MODEL K	AIRFEED
~~466778-5~~	~~AD~~	~~843083-1~~	~~LEADMAKER~~	~~DOUBLE-ACTING AIRFEED~~
466778-6	AD	354500-1	BENCH MODEL G	AIRFEED
7-466778-7	Y	-	SPARE PARTS	

TERMINAL NAME: FULLY INSULATED FASTON

AMP TERMINAL - AMP CRIMP SPECS

GROUP I	GROUP II	PAD LTR	CRIMP HEIGHT	WIRE SIZE	Ø SOLDER
350815	520140				
350819	520150				
520106	520276	A	.075±.002	14	Ø.19/5
520116	521142	B	.070±.002	16 OR (2)18 OR (3)20	Ø.19/5
520124	-	C	-	-	-
-	-	D	-	-	-

CRIMP	SIZE	TYPE	RANGE
WIRE	.205	D	16-14
INSUL	-	-	-

WIRE STRIP LENGTH .265-.297	TERM APPL SPEC 114-2123	FEED .785-.940	APPL INSTRUCTIONS 408-8051	SET UP GAGE 458637-1	LAYOUT L1038

Notes

1. RECOMMENDED SPARE PARTS.
2. GREASE LIGHTLY.
3. GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
4. SEE DRAWING FOR COMPONENTS.
5. TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.19 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.

(Diagram: CALIPERS, CRIMP HEIGHT, SOLDER)
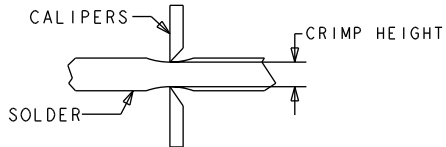
6. CUT TO LENGTH AT ASSEMBLY.
7. ITEM 16 MUST BE REMOVED IF APPLICATOR IS REMOVED FROM LEADMAKER AND PLACED IN AMP-O-LECTRIC* TERMINATING UNIT.
8. ITEM 76 REQUIRED WHEN APPLICATOR IS REMOVED FROM LEADMAKER AND PLACED IN AMP-O-LECTRIC* TERMINATING UNIT.
9. ~~INSTALL ITEM 75 IN CHIP RELIEF HOLE OF T-TERMINATOR UNIT BEFORE INSTALLING APPLICATOR.~~
10. REMOVE WIRE FUNNEL WHEN USING THIS APPLICATOR ON AMPOMATOR* FEED SIDE T-TERMINATOR UNIT.
11. IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING UNIT'S BASE PLATE BEFORE INSTALLING THIS APPLICATOR BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.

(Diagram: .187, 1.75, BASE PLATE ASSEMBLY, 10-32 UNF-2B X .50 DP, RELOCATE THIS STOP TO NEXT OR ADDED HOLE.)
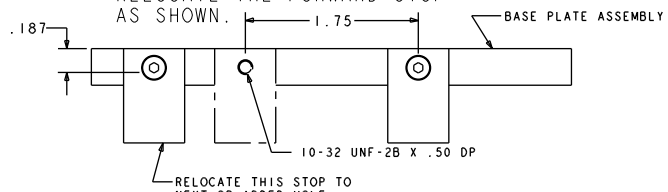
12. FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
13. GROUP I: Ø.160 MAX INSULATION. GROUP II: Ø.240 MAX INSULATION.
14. USE ITEMS 5 & 9 WITH GROUP I. USE ITEMS 10 & 20 WITH GROUP II.
15. AMPOMATOR* MODEL 48.
16. LEADMAKER LM40 OR CS55.
17. USE ITEM 46 WITH GROUP I. USE ITEM 47 WITH GROUP II.
18. ITEMS 75 AND 77 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR. LEADMAKERS W/A T TERMINATING UNIT ONLY REQUIRE ITEM 75.
19. ITEM NOT SHOWN.

TRADEMARK - *

-77	-6	-5	-4	-3	U/M	PART NO	DESCRIPTION	ITEM NO
-	1	1	1	1	-	4-21028-0	PIN, SLOTTED SPRING .094 X .750	121
-	3	3	3	3	-	21024-5	WASHER, SPRG LOCK, REG NO 10	117
-	4	4	4	4	-	21024-2	WASHER, SPRG LOCK, REG NO 4	114
-	1	1	1	1	-	21024-8	WASHER, SPRG LOCK, REG 3/8	112
-	4	4	4	4	-	21024-4	WASHER, SPRG LOCK, REG NO 8	111
-	1	1	1	1	-	22353-8	SCR, SHLD, SLOT HD, 3/16 DIA	105
-	1	1	1	1	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	103
-	2	2	2	2	-	21017-2	SCREW, DRIVE	102
-	1	1	1	1	-	461264-1	PLATE, IDENTIFICATION	100
-	2	2	2	2	-	5-21006-6	SCR, SET, CUP POINT 10-32 X .750	99
-	1	1	1	1	-	22733-8	SCR, BHSC, SELF-LOCKING, 8-32 X .375	98
-	REF	REF	REF	REF	-	2-21002-9	SCR, BTN SKT HD CAP 10-32 X .750	97
-	REF	REF	REF	REF	-	2-22733-8	SCR, BHSC, SELF-LOCKING, 1/4-20 X .625	96
-	1	1	1	1	-	2-21002-7	SCR, BTN SKT HD CAP 10-32 X .500	95
-	4	4	4	4	-	2-21002-2	SCR, BTN SKT HD CAP 8-32 X .500	94
-	2	4	2	4	-	1-21000-4	SCR, SKT HD CAP 4-40 X .375	93
-	-	2	-	2	-	1-21002-7	SCR, BTN SKT HD CAP 6-32 X .375	92
-	2	2	2	2	-	1-21002-3	SCR, BTN SKT HD CAP 4-40 X .250	91
-	2	2	2	2	-	3-21000-0	SCR, SKT HD CAP 8-32 X .875	87
-	1	1	1	1	-	2-22603-1	SCREW, MACH, HEX HD, 8-32 X .375	86
-	2	2	2	2	-	1-21000-3	SCR, SKT HD CAP 4-40 X .250	85
-	1	1	1	1	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	84
-	1	1	1	1	-	3-21000-4	SCR, SKT HD CAP 10-32 X .375	81
-	-	-	-	-	-	1-18023-1	SCR, SHC, M4x10	80
-	-	-	1	1	-	462992-5	GUARD ASSY	79
-	REF	-	-	-	..	679532-1	INSERT, GUARD	78
-	-	-	-	-	-	189728-1	BRACKET, SPACER	77
-	-	REF	1	1	..	803931-1	BRACKET, HOLD DOWN	76
-	1	1	1	1	-	568681-1	SPACER, BASE PLATE	75
-	1	1	1	1	-	690603-1	SPRING ASSIST AMP-O-MATOR APPLICATOR	74
-	1	1	1	1	-	23030-1	SCR, SKT HD CAP, S-LOCK, 6-32 X .25	73
-	1	1	1	1	-	3-21001-5	SCR, SKT HD CAP 3/8-16 X 1.000	72
-	1	1	1	1	-	459610-3	MOUNT, FEED BRACKET	71
-	-	-	1	1	-	692655-5	AIR FEED VALVE ASSEMBLY	69

						PART NO	DESCRIPTION	ITEM NO
-	-	-	-	-	-	461065-4	AIR FEED ASSY	68
-	-	REF	-	-	-	24042-2	VALVE, SHUT-OFF	67
-	-	-	REF	-	-	692655-6	AIR FEED VALVE ASSEMBY	66
-	1	1	1	1	-	461065-1	ASSEMBLY, AIR FEED	65
-	2	2	2	2	-	3-21000-9	SCR, SKT HD CAP 10-32 X 1.000	64
-	REF	REF	REF	REF	-	454220-1	CAP, RAM	59
-	REF	REF	REF	REF	-	454485-1	HOUSING, APPL CSTG	58
-	1	1	1	1	-	462427-1	FINGER, FEED	56
-	-	-	1	1	-	692655-7	AIR FEED VALVE ASSEMBLY	55
-	1	1	1	1	-	461062-2	FEED FINGER ASSEMBLY	53
-	1	1	1	1	-	816187-2	APPLICATOR, BASIC SUBASSEMBLY	51
-	1	1	1	1	-	816187-1	APPLICATOR, BASIC SUBASSEMBLY	50
-	1	1	1	1	-	469366-2	PLATE, REAR SHEAR	49
-	1	1	1	1	-	467590-1	HOLDER, SHEAR	48
-	1	1	1	1	-	462433-3	SUPPORT, INSULATION	47
-	1	1	1	1	-	462433-1	SUPPORT, INSULATION	46
-	1	1	1	1	-	690191-1	PLUG, NYLON	45
-	1	1	1	1	-	455673-1	RAM, SIDE FEED	44
-	1	1	1	1	-	690125-1	SHIM SUB-ASSY	43
-	1	1	1	1	-	690124-1	WASHER, RAM (.115)	42
-	1	1	1	1	-	690686-2	CRIMPER, BOLT SPECIAL	41
-	1	1	1	1	-	23241-6	BALL, STEEL	40
-	1	1	1	1	-	690170-1	SPRING, COMPRESSION	39
-	1	1	1	1	-	462426-1	DISC, SPRING	38
-	1	1	1	1	-	462425-1	WIRE DISC	37
-	8	8	8	8	-	2-22280-5	SPRING, COMPRESSION	36
-	1	1	1	1	-	690212-1	POST, RAM	35
-	-	REF	-	REF	-	808835-1	PLATE, BASE	34
-	REF	-	REF	-	-	455675-3	PLATE, BASE	33
-	1	1	1	1	-	690432-3	ADJUSTMENT SCREW	32
-	1	1	1	1	-	22480-5	WASHER, WAVE SPRING	31
-	1	1	1	1	-	455689-1	BLOCK, STRIP GUIDE ADJUST	30
-	1	1	1	1	-	684045-2	PLATE, STRIP GUIDE	29
-	2	2	2	2	-	22281-9	SPRING, COMPRESSION	27
-	1	1	1	1	-	240793-4	LEVER, DRAG RELEASE	26
-	1	1	1	1	-	240792-6	DRAG, TERMINAL	25
-	1	1	1	1	-	690438-1	FRONT STRIP GUIDE	24
-	1	1	1	1	-	684042-2	GUIDE, STRIP, FRONT	23
-	2	2	2	2	-	5-22278-1	SPRING, COMPRESSION	21
-	1	1	1	1	-	462431-5	FUNNEL, WIRE	20
-	1	1	1	1	-	690472-2	STRIPPER	19
-	1	1	1	1	-	463460-3	HOLD DOWN, TERMINAL	18
-	-	-	-	-	-	803925-1	GUIDE, CARRIER SCRAP	16
-	-	-	-	-	-	803926-1	PLATE, REAR SHEAR	15
-	1	1	1	1	-	467590-2	HOLDER, SHEAR, REAR	14
-	1	1	1	1	-	469542-3	REAR FLOATING SHEAR	13
-	1	1	1	1	-	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	-	1-690461-1	STOP, SHEAR	11
-	1	1	1	1	-	462843-3	TERMINAL SUPPORT	10
-	1	1	1	1	-	462843-1	TERMINAL SUPPORT	9
-	1	1	1	1	-	464282-1	ANVIL, SAND-BLASTED 16-14	8
-	1	1	1	1	-	240641-6	SPACER	7
-	1	1	1	1	-	690468-6	DEPRESSOR SHEAR, REAR	6
-	1	1	1	1	-	462431-4	WIRE FUNNEL	5
-	1	1	1	1	-	238009-3	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1	-	462432-4	STABILIZER	3
1	1	1	1	1	-	462842-1	SPACER	2
1	1	1	1	1	-	464281-1	CRIMPER, SEMI FLAT 16-14	1

DIMENSIONS: IN

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±

DWN	B WEAVER	22JAN2007
CHK	T ELBIN	22JAN2007
APVD	T ELBIN	22JAN2007

Tyco Electronics
Harrisburg, PA 17105-3608

NAME: SIDE FEED HDM APPLICATOR

SIZE A1 | CAGE CODE 00779 | DRAWING NO C-466778 | REV AD3
SCALE 1:5 | SHEET 2 OF 2

CUSTOMER DRAWING

CUSTOMER VIEWABLE ASSEMBLY

AMP 4605 REV 31MAR2000
Pro/ENGINEER DRAWING

RELEASED FOR PUBLICATION   2007

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
-	-	SEE SHEET 1	-	-	-

LOC A   DIST 66

REF
53

REF
53
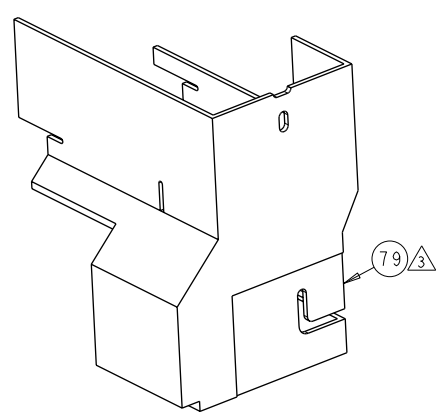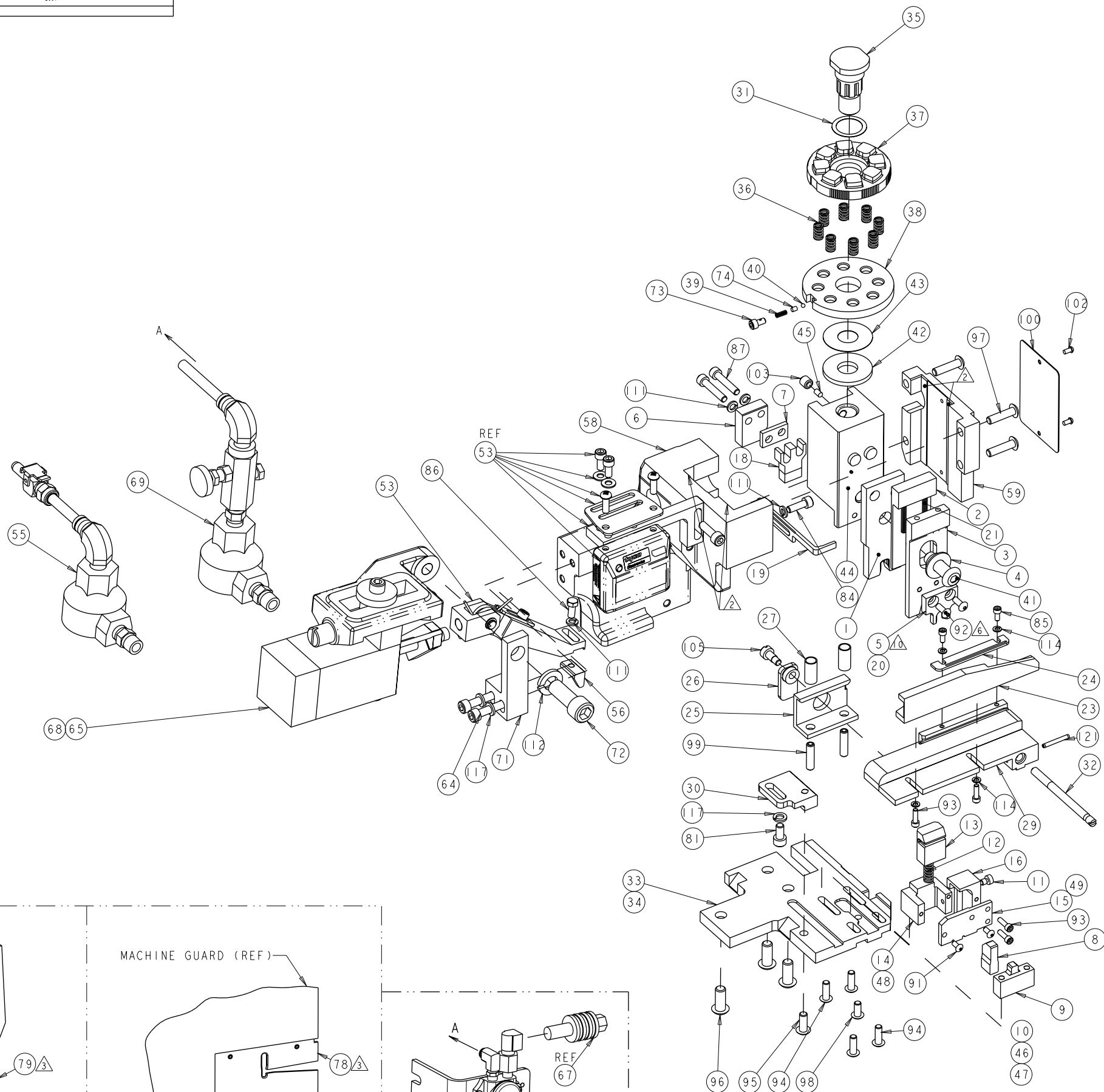
AMP-O-LECTRIC* TERMINATOR GUARD

MACHINE GUARD (REF)
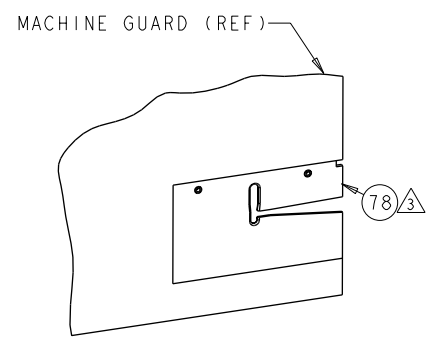
G TERMINATOR GUARD
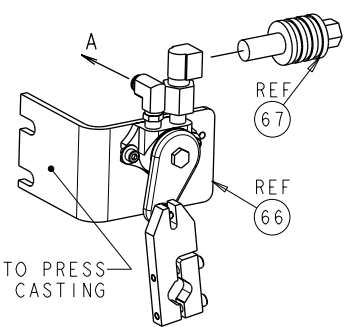
TO PRESS CASTING

DIMENSIONS: IN

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±

MATERIAL
:

FINISH
:

DWN B. WEAVER 22JAN2007
CHK T. ELBIN 22JAN2007
APVD T. ELBIN 22JAN2007

PRODUCT SPEC
-

APPLICATION SPEC
-

WEIGHT -

tyco Electronics

Tyco Electronics
Harrisburg, PA 17105-3608

NAME
SIDE FEED HDM APPLICATOR
-

SIZE A1   CAGE CODE 00779   DRAWING NO C=466778

RESTRICTED TO -

CUSTOMER DRAWING

SCALE 3:4   SHEET 2   OF 2   REV AD3

CUSTOMER VIEWABLE ASSEMBLY

AMP 4805 REV 31MAR2000