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LOC

DIST

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A1	ECR-14-003326	11MAR2014	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2266160-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1855094
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
1855094

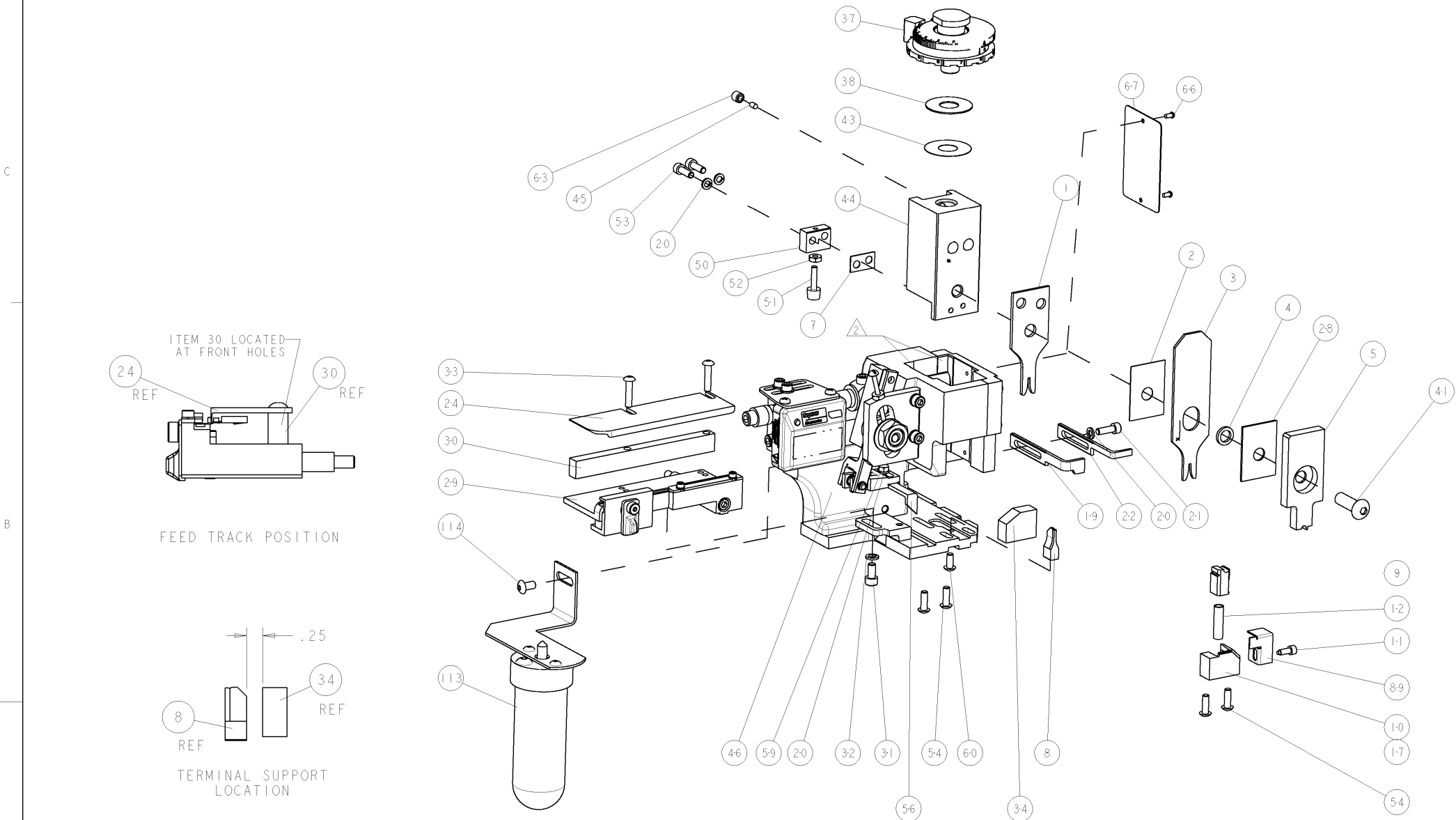
THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN GOPALAKRISHNA HV		 TE Connectivity			
DIMENSIONS:		CHK RAGHAVENDRA					
		APVD RAGHAVENDRA		NAME SIDE FEED HDM APPLICATOR FINE ADJUST			
		PRODUCT SPEC					
		APPLICATION SPEC					
MATERIAL		WEIGHT		SIZE A3	CAGE CODE	DRAWING NO C- 1855094	RESTRICTED TO
FINISH		CUSTOMER DRAWING		SCALE		SHEET 1 OF 2	REV A1

6	5
AMP-O-ELECTRIC TERM GUARD	G TERMINATOR GUARD

TERMINAL NAME: TERMINAL, IPDB CONTACT						
TYCO PN	MFG PN	SAMTEC TERMINAL - SAMTEC CRIMP SPECS				
1572571	CC69R-2024-01-X-XX					
-	-	REF SETTING	CRIMP HEIGHT			WIRE SIZE
-	-	B8	.041±.002 [1.04±0.05mm]			20 AWG
-	-	C2	.039±.002 [1.99±0.05mm]			22 AWG
-	-	C6	.037±.002 [1.94±0.05mm]			24 AWG
-	-	-				-
-	-	CRIMP	SIZE	TYPE	RANGE	
-	-					
-	-	WIRE	.055 [1.40mm]	F	24-20 AWG	
-	-	INSUL	.070 [1.78mm]	F	Ø.035-.070	
WIRE STRIP LENGTH 1.105-.135	TERM APPL SPEC NONE	FEED 4.25	APPL INSTRUCTIONS 408-8040		SET UP GAGE 458637-	

[illegible]

- ① RECOMMENDED SPARE PARTS
- ② GREASE LIGHTLY
- ③ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE



3	-	-	-	REF	-	-	455749-1	GUARD WINDOW	116
3	-	-	REF	-	-	...	679532-1	INSERT, GUARD	115
-	-	-	-	-	-	-	2-21002-6	SCR, BTN SKT HD CAP 10-32 X .375	114
-	-	-	-	-	-	...	1-465184-0	LUBRICATOR ASSY	113
-	-	-	-	-	-	-	1-21002-7	SCR, BTN SKT HD CAP 6-32 X .375	91
-	-	-	-	-	-	-	318563-1	GUARD, FRONT CHIP	89
-	-	-	-	-	-	-	4088040	SF APPL INST 408-8040	72
-	-	-	-	-	-	-	217238-1	GENERAL INSTRUCTION PKG	71
-	-	-	-	-	-	-	461264-5	PLATE, IDENTIFICATION	67
-	-	-	-	-	-	-	21017-2	SCREW, DRIVE	66
-	-	-	-	-	-	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	63
-	-	-	-	-	-	-	22733-8	SCR, BHSC, SELF-LOCKING, 8-32 X .375	60
-	-	-	-	-	-	-	2-22603-0	SCR, HEX HD CAP 8-32 X .312	59
-	-	-	-	-	-	-	458537-2	PAWL, FEED	56
-	-	-	-	-	-	-	2-21002-2	SCR, BTN SKT HD CAP 8-32 X .500	54
-	-	-	-	-	-	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	53
-	-	-	-	-	-	-	21018-5	NUT, HEX, REG 6-32	52
-	-	-	-	-	-	-	811242-2	BUMPER, HOLD DOWN	51
-	-	-	-	-	-	-	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
-	-	-	-	-	-	-	459456-1	APPL. BASIC SUB ASSY (SIDE WISE MOCA)	46
-	-	-	-	-	-	-	690191-1	PLUG, NYLON	45
-	-	-	-	-	-	-	455673-1	RAM, SIDE FEED	44
-	-	-	-	-	-	-	690125-1	SHIM SUB-ASSY	43
-	-	-	-	-	-	-	7-21002-9	SCR, BTN SKT HD CAP 5/16-24 X 1.00	41
-	-	-	-	-	-	-	469367-8	SHIM	38
-	-	-	-	-	-	-	879103-3	FINE ADJUST HEAD SUBASSY	37
-	-	-	-	-	-	-	690786-1	TERMINAL SUPPORT	34
-	-	-	-	-	-	-	2-21002-4	SCR, BTN SKT HD CAP 8-32 X .750	33
-	-	-	-	-	-	-	21024-5	WASHER, SPRG LOCK, REG NO 10	32
-	-	-	-	-	-	-	3-21000-4	SCR, SKT HD CAP 10-32 X .375	31
-	-	-	-	-	-	-	1-1320908-5	SPACER, STRIP GUIDE	30
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-	-	-	-	-	-	-	1320928-1	PLATE, STRIP GUIDE	24
-	-	-	-	-	-	-	690472-2	STRIPPER	22
-	-	-	-	-	-	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	21
-	-	-	-	-	-	-	21024-4	WASHER, SPRG LOCK, REG NO 8	20
-	-	-	-	-	-	-	691353-1	STRIPPER	19
-	-	-	-	-	-	-	679625-1	SHEAR HOLDER, FRONT (NO CUT)	17
-	-	-	-	-	-	-	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	-	-	690461-1	STOP, SHEAR	11
-	-	-	-	-	-	-	690459-1	SHEAR HOLDER, FRONT	10
-	-	-	-	-	-	-	462006-2	FLOATING SHEAR, FRONT	9
-	-	-	-	-	-	-	1583502-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	2-240641-1	SPACER	7
-	-	-	-	-	-	-	2-455889-0	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	238011-6	BLOCK, CRIMPER SPACER	4
-	-	-	-	-	-	-	3-683453-3	CRIMPER, INSULATION PREMIUM	3
-	-	-	-	-	-	-	455888-3	SPACER, CRIMPER	2
-	-	-	-	-	-	-	2-456402-4	CRIMPER, WIRE PREMIUM	1
-77	-6	-3	-2	-1	U/M	PART NO	DESCRIPTION		ITEM NO

Diagram A illustrates the assembly of the front cover in three steps:

- POST-FEED | 5/8 STROKE:** The cover (47) is positioned, and screw 91 is inserted into the frame (2).
- PRE-FEED | 1/8 STROKE:** The cover (48) is slightly moved, and screw 91 is tightened.
- PRE-FEED | 5/8 STROKE:** The cover (49) is fully in place, and screw 91 is tightened further.

* 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.

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DIMENSIONS: INCHES 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.001 4 PLC ±.0001 ANGLES ±.1		NAME: SIDE FEED HDM APPLICATOR FINE ADJUST PRODUCT SPEC: - APPLICATION SPEC: -	
MATERIAL: -		FINISH: -		SIZE: A CASE CODE: 00779 DRAWING NO: C-1855094 RESTRICTED TO: - WEIGHT: - CUSTOMER DRAWING: -	
				SCALE: 3:5 SHEET: 1 OF 1 REV: A	
CUSTOMER VIEWABLE ASSEMBLY					

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