

4

3

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LOC

DIST

REVISIONS

| P | LTR | DESCRIPTION   | DATE      | DWN | APVD |
|---|-----|---------------|-----------|-----|------|
|   | A2  | ECR-14-010821 | 18JUL2014 | GK  | HMR  |
|   |     |               |           |     |      |
|   |     |               |           |     |      |
|   |     |               |           |     |      |

REPLACED BY OCEAN STYLE APPLICATOR PART  
NUMBER 2266266-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1855369  
REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED)  
WILL REMAIN AVAILABLE.

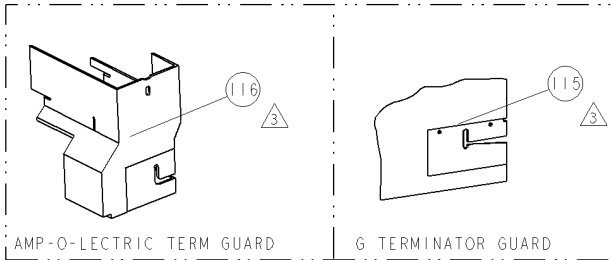
THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE  
SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR  
1855369

|                                                                                       |  |                      |  |                                                                                                       |           |                          |               |
|---------------------------------------------------------------------------------------|--|----------------------|--|-------------------------------------------------------------------------------------------------------|-----------|--------------------------|---------------|
| THIS DRAWING IS A CONTROLLED DOCUMENT.                                                |  | DWN Gopalakrishna HV |  |  TE Connectivity |           |                          |               |
| DIMENSIONS:                                                                           |  | CHK RAGHAVENDRA      |  |                                                                                                       |           |                          |               |
|  |  | APVD RAGHAVENDRA     |  | NAME<br>FINE ADJUST SIDE FEED HDM<br>APPLICATOR                                                       |           |                          |               |
|                                                                                       |  | PRODUCT SPEC         |  |                                                                                                       |           |                          |               |
|                                                                                       |  | APPLICATION SPEC     |  |                                                                                                       |           |                          |               |
| MATERIAL                                                                              |  | WEIGHT               |  | SIZE<br>A3                                                                                            | CAGE CODE | DRAWING NO<br>C- 1855369 | RESTRICTED TO |
| FINISH                                                                                |  | CUSTOMER DRAWING     |  | SCALE                                                                                                 |           | SHEET 1 OF 2             | REV A2        |

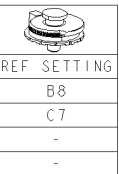
|                              |     |               |               |                                                      |                    |  |  |
|------------------------------|-----|---------------|---------------|------------------------------------------------------|--------------------|--|--|
| 8                            |     |               |               | 7                                                    |                    |  |  |
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| PART<br>NUMBER               | REV | FIRST<br>USED | POWER UNIT    | FEED TYPE                                            | DESCRIPTION        |  |  |
| 1855369-1                    | A   | 122500-1      | LEADMAKER     | POST FEED                                            | CUTS CARRIER       |  |  |
| 1855369-2                    | A   | 565435-5      | BENCH MODEL K | PRE FEED                                             | CUTS CARRIER       |  |  |
| 1855369-3                    | A   | 354500-1      | BENCH MODEL G | PRE FEED                                             | CUTS CARRIER       |  |  |
| 1855369-6                    | A   | 122500-1      | LEADMAKER     | POST FEED                                            | CONTINUOUS CARRIER |  |  |
| 7-1855369-7                  | A   | -             | -             | -                                                    | SPARE PARTS        |  |  |

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

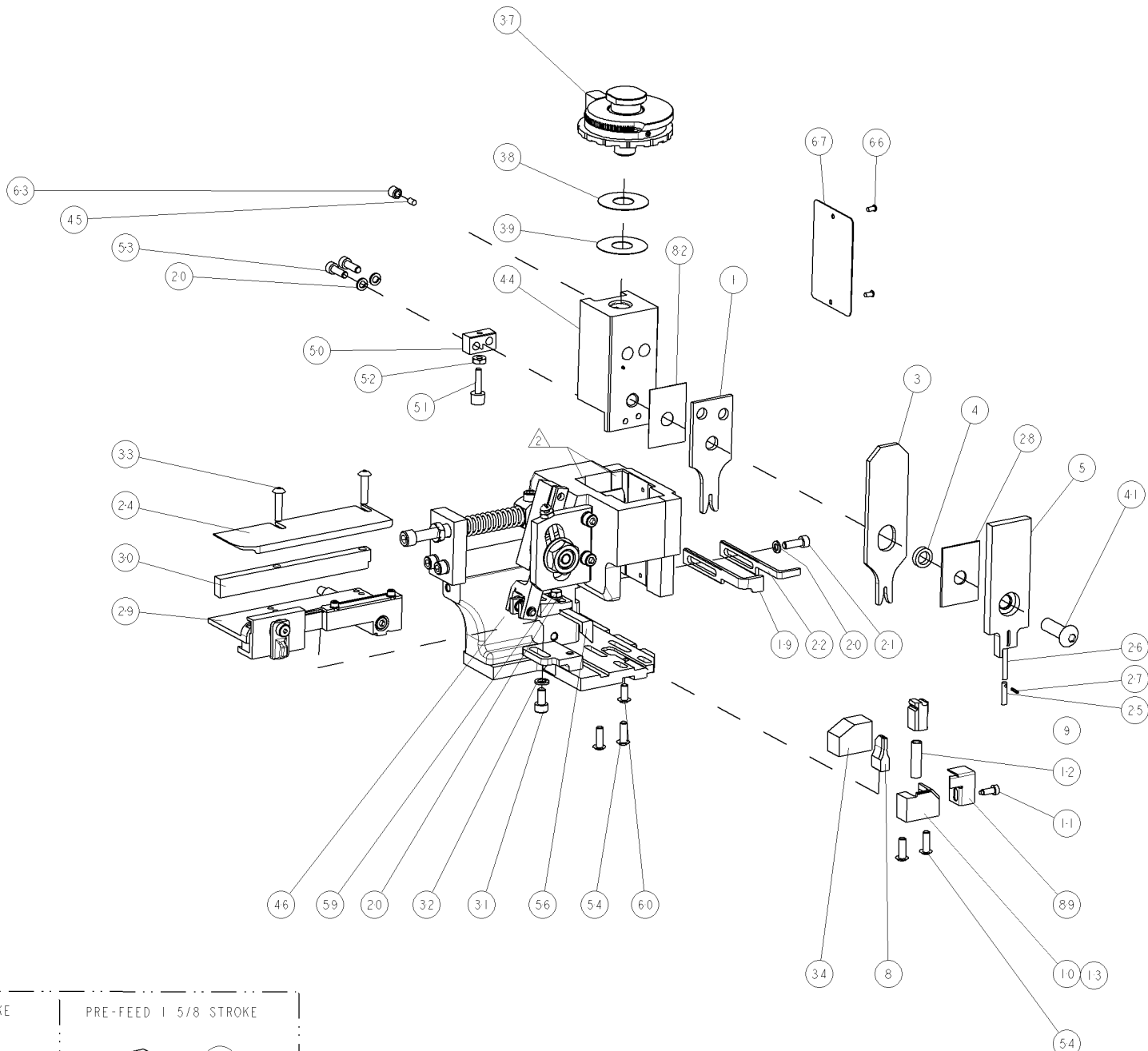
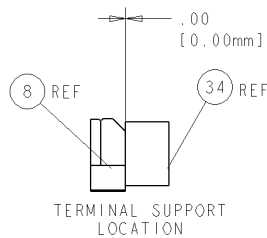
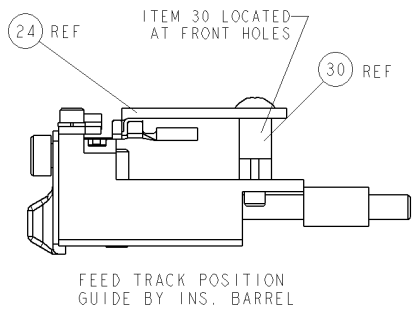
**\* WARNING**  
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN. REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



| TERMINAL NAME: 1.2mm GET FEMALE TERMINAL |   |                                    |  |                         |      |
|------------------------------------------|---|------------------------------------|--|-------------------------|------|
| 1924880                                  | - | TE TERMINAL - TE CRIMP SPECS       |  |                         |      |
| -                                        | - | CRIMP HEIGHT                       |  | WIRE SIZE               |      |
| -                                        | - | 1.42mm ± .05 [-.056, .002] [-.002] |  | 1.5mm2                  |      |
| -                                        | - | 1.31mm ± .05 [-.052, .002] [-.002] |  | 16 AWG                  |      |
| -                                        | - | CRIMP                              |  | SIZE                    | TYPE |
| -                                        | - | WIRE                               |  | 1.96mm [ .077 ]         | F    |
| -                                        | - | INSUL                              |  | 2.16mm [ .085 ]         | O    |
| -                                        | - | WIRE STRIP LENGTH                  |  | SET UP GAGE             |      |
| -                                        | - | 3.700-4.100                        |  | 458637-1                |      |
| -                                        | - | TERM APPL SPEC                     |  | APPLICATOR INSTRUCTIONS |      |
| -                                        | - | 114-13236                          |  | 408-8040                |      |
| -                                        | - | FEED                               |  | 8.000                   |      |



| LOC |  | DIST |  | REVISIONS |                 |           |        |
|-----|--|------|--|-----------|-----------------|-----------|--------|
| A   |  | 66   |  | REV       | DESCRIPTION     | DATE      | APPD   |
|     |  |      |  | A         | PRODUCT RELEASE | 14JUL2008 | CMR TE |
|     |  |      |  | A1        | ECR-10-010049   | 11MAY2010 | KH TE  |



|   |   |   |     |   |    |             |                                       |     |
|---|---|---|-----|---|----|-------------|---------------------------------------|-----|
| 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 | -  | 2-21000-7   | SCR, SKT HD CAP 8-32 X .500           | 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  |
| - | - | 1 | -   | - | .. | 690602-6    | CAM, PRE FEED, 1 5/8                  | 49  |
| - | - | - | 1   | - | .. | 690602-5    | CAM, PRE FEED, 1 1/8                  | 48  |
| - | 1 | - | -   | 1 | -  | 690501-4    | CAM, POST-FEED 1 5/8                  | 47  |
| - | 1 | 1 | 1   | 1 | -  | 459456-1    | APPL. BASIC SUB ASSY (SIDE WISE MQCA) | 46  |
| - | 1 | 1 | 1   | 1 | -  | 690191-1    | PLUG, NYLON                           | 45  |
| - | 1 | 1 | 1   | 1 | -  | 455673-1    | 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 | -  | 1-469367-0  | SHIM                                  | 38  |
| - | 1 | 1 | 1   | 1 | -  | 879103-3    | 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 | -  | 1320908-4   | SPACER, STRIP GUIDE                   | 30  |
| - | 1 | 1 | 1   | 1 | -  | 1633091-3   | ASSEMBLY, STRIP GUIDE                 | 29  |
| - | 1 | 1 | 1   | 1 | -  | 1-455888-0  | SPACER, CRIMPER                       | 28  |
| - | 1 | 1 | 1   | 1 | -  | 21028-2     | PIN, SLOTTED SPRING .062 X .250       | 27  |
| - | 1 | 1 | 1   | 1 | -  | 5-547505-2  | SPRING, COMPRESSION                   | 26  |
| - | 1 | 1 | 1   | 1 | -  | 854769-1    | HOLDER, INS                           | 25  |
| - | 1 | 1 | 1   | 1 | -  | 1320928-1   | PLATE, STRIP GUIDE                    | 24  |
| - | 1 | - | -   | 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  |
| - | - | 1 | -   | - | .. | 691353-1    | STRIPPER                              | 19  |
| - | 1 | - | -   | - | .. | 679625-1    | SHEAR HOLDER, FRONT (NO CUT)          | 13  |
| - | 1 | 1 | 1   | 1 | -  | 3-22280-3   | SPRING, COMPRESSION                   | 12  |
| - | 1 | 1 | 1   | 1 | -  | 690461-1    | STOP, SHEAR                           | 11  |
| - | - | 1 | -   | - | .. | 690459-1    | SHEAR HOLDER, FRONT                   | 10  |
| - | 1 | 1 | 1   | 1 | -  | 462006-1    | FLOATING SHEAR, FRONT                 | 9   |
| 1 | 1 | 1 | 1   | 1 | -  | 7-1633535-5 | ANVIL, COMBINATION                    | 8   |
| - | - | - | -   | - | .. | -           | -                                     | 7   |
| - | - | - | -   | - | .. | -           | -                                     | 6   |
| - | 1 | 1 | 1   | 1 | -  | 854772-1    | DEPRESSOR, SHEAR                      | 5   |
| - | 1 | 1 | 1   | 1 | -  | 238011-2    | BLOCK, CRIMPER SPACER                 | 4   |
| 1 | 1 | 1 | 1   | 1 | -  | 5-1583690-9 | CRIMPER, INSUL O                      | 3   |
| - | - | - | -   | - | .. | -           | -                                     | 2   |
| 1 | 1 | 1 | 1   | 1 | -  | 2-1633588-5 | CRIMPER, WIRE                         | 1   |

|                                                                                                                                                                                                                                                   |  |                                              |  |                                                        |  |              |  |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------------|--|--------------------------------------------------------|--|--------------|--|
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| DIMENSIONS<br>INCHES                                                                                                                                                                                                                              |  | TOLERANCES UNLESS OTHERWISE SPECIFIED        |  | TYCO ELECTRONICS<br>Harrisburg, PA 17105-3608          |  | NAME         |  |
| 0.0005                                                                                                                                                                                                                                            |  | 0.0005                                       |  | DRAWN BY<br>N. DEMING<br>DATE<br>09MAY2008             |  | PRODUCT SPEC |  |
| 0.0005                                                                                                                                                                                                                                            |  | 0.0005                                       |  | APPLICATOR SPEC                                        |  | SIZE         |  |
| 0.0005                                                                                                                                                                                                                                            |  | 0.0005                                       |  | WEIGHT                                                 |  | CAGE CODE    |  |
| 0.0005                                                                                                                                                                                                                                            |  | 0.0005                                       |  | CUSTOMER DRAWING                                       |  | DRAWING NO.  |  |
| 0.0005                                                                                                                                                                                                                                            |  | 0.0005                                       |  | SCALE                                                  |  | SHEET        |  |
| 0.0005                                                                                                                                                                                                                                            |  | 0.0005                                       |  | 3:5                                                    |  | OF           |  |
| 0.0005                                                                                                                                                                                                                                            |  | 0.0005                                       |  | REV                                                    |  | A1           |  |
| 0.0005                                                                                                                                                                                                                                            |  | 0.0005                                       |  | CUSTOMER VIEWABLE ASSEMBLY                             |  |              |  |

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