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LOC

DIST

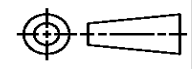
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	B1	ECR-14-001601	04FEB2014	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2151749-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1855224
REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED)
WILL REMAIN AVAILABLE.

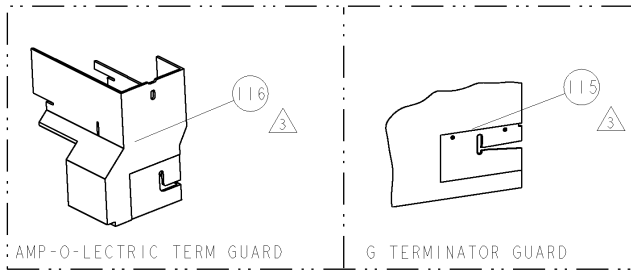
THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE
SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR
1855224

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV		 TE Connectivity					
		CHK	RAGHAVENDRA							
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	NAME					
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		RAGHAVENDRA		FINE ADJUST SIDE FEED HDM APPLICATOR				
				PRODUCT SPEC						
				APPLICATION SPEC						
MATERIAL		FINISH		WEIGHT	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
					A3		©- 1855224			
CUSTOMER DRAWING				SCALE	SHEET	1	OF	2	REV	B1

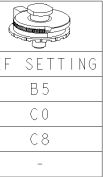
PART NUMBER		REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1855224-1	B	122500-1	LEADMAKER	POST FEED	CUTS CARRIER	
1855224-2	B	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER	
1855224-3	B	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER	
1855224-6	B	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER	
7-1855224-7	A	-	-	-	-	SPARE PARTS

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

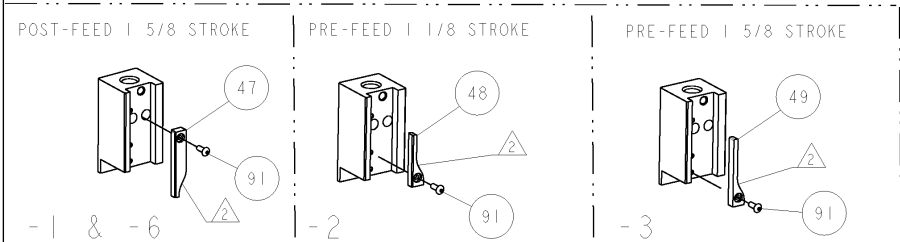
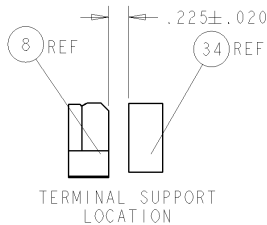
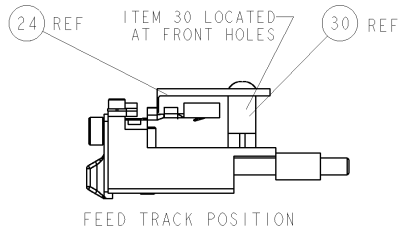
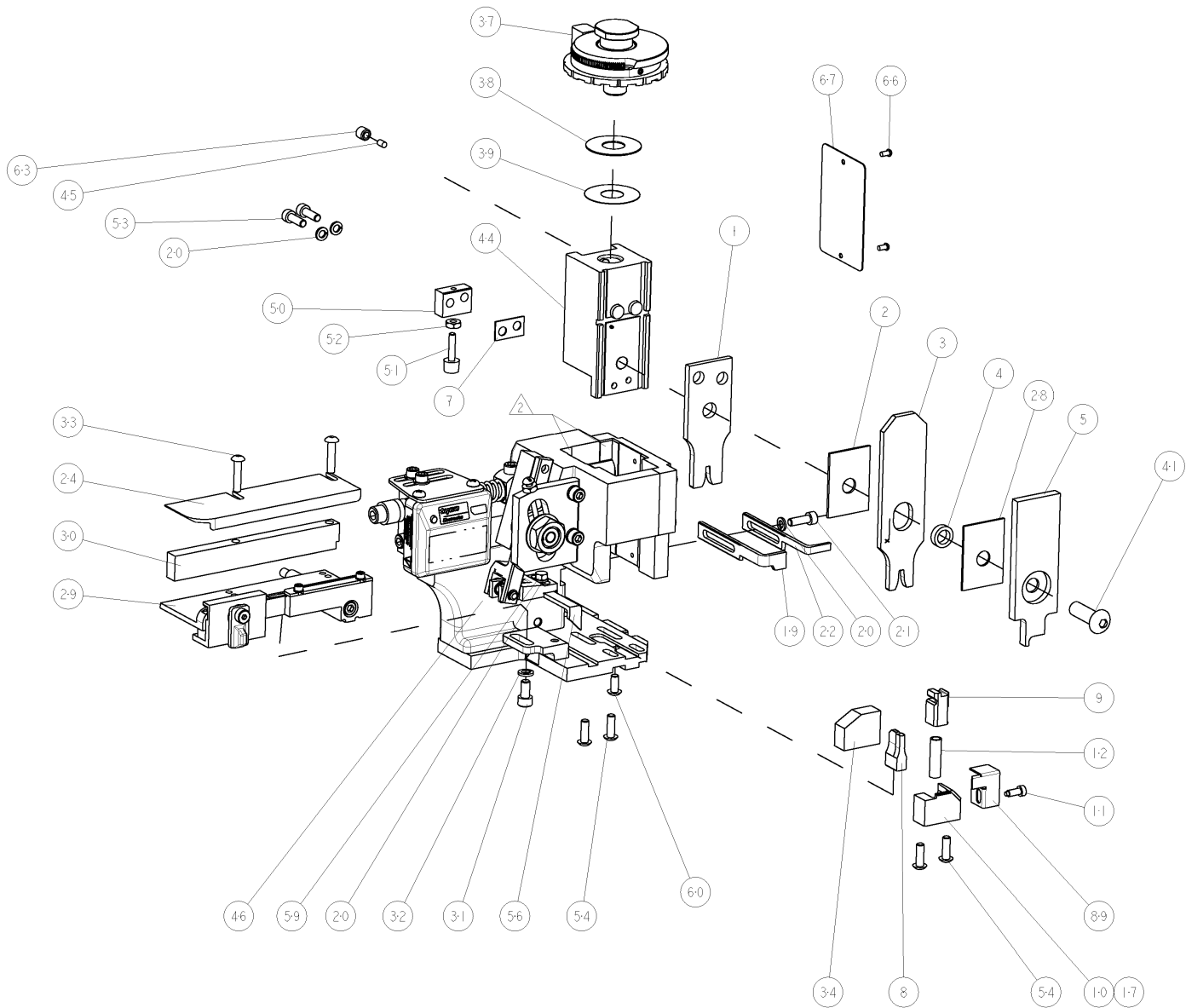
*** WARNING**
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN. REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



TERMINAL NAME: 480 FEMALE TERMINAL			
TERM PN	MFR PN	PACKARD TERMINAL-PACKARD CRIMP SPECS	
1572145	12015860		
2-1393884-2	-	CRIMP HEIGHT	WIRE SIZE
-	-	1.40±0.05mm [.055±.002]	1mm2
-	-	1.35±0.05mm [.053±.002]	18AWG or 0.8mm2
-	-	1.25±0.05mm [.049±.002]	0.5mm2
-	-	-	-
-	-	CRIMP	SIZE TYPE RANGE
-	-	WIRE	2.39mm [.094] F 0.5-0.8mm2 OR 18
-	-	INSUL	3.43mm [.135] O .080-.123
WIRE STRIP LENGTH 5.16-5.94mm	TERM APPL SPEC NONE	FEED 15.24mm	APPLICATOR INSTRUCTIONS 408-8040 SET UP GAGE 458637-1



LOC		DIST		REV		REVISIONS		DATE		BY		REV	
A	66	P	LTR			DESCRIPTION							
						RELEASED		29MAR2007		J.K.			
						RELEASED		18APR2007		BH			
						ECR-07-012228		23MAY2007		MY			



△	-	-	-	REF	-	..	455749-1	GUARD WINDOW	116
△	-	-	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	-	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
	-	-	-	-	-	..	690602-6	CAM, PRE FEED, 1 5/8	49
	-	-	-	-	-	..	690602-5	CAM, PRE FEED, 1 1/8	48
	-	1	-	-	-	-	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	-	819307-1	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	-	1-469367-2	SHIM	38
	-	1	1	1	1	-	879103-3	FINE ADJUST HEAD ASSEMBLY	37
	-	1	1	1	1	-	690786-1	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	-	455888-9	SPACER, CRIMPER	28
	-	1	1	1	1	-	1320928-2	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	-	-	-	-	679625-1	SHEAR HOLDER, FRONT (NO CUT)	17
	-	1	1	1	1	-	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	-	690461-1	STOP, SHEAR	11
△	-	-	-	-	-	-	690459-1	SHEAR HOLDER, FRONT	10
△	-	1	1	1	1	-	454276-1	FLOATING SHEAR, FRONT	9
△	1	1	1	1	1	-	1-1424534-8	ANVIL, COMBINATION	8
	-	1	1	1	1	-	1-240641-7	SPACER	7
	-	1	1	1	1	-	1-455889-8	DEPRESSOR, SHEAR	5
	-	1	1	1	1	-	3-238011-1	BLOCK, CRIMPER SPACER	4
△	1	1	1	1	1	-	7-683453-6	CRIMPER, INSULATION PREMIUM	3
	-	1	1	1	1	-	1-455888-1	SPACER, CRIMPER	2
△	1	1	1	1	1	-	2-1490019-6	CRIMPER, WIRE PREMIUM	1

DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		APPLICATION SPEC		WEIGHT		CUSTOMER DRAWING	
0 PLC	±.01	1 PLC	±.01	2 PLC	±.01	3 PLC	±.01	4 PLC	±.01	5 PLC	±.01
6 PLC	±.01	7 PLC	±.01	8 PLC	±.01	9 PLC	±.01	10 PLC	±.01	11 PLC	±.01
12 PLC	±.01	13 PLC	±.01	14 PLC	±.01	15 PLC	±.01	16 PLC	±.01	17 PLC	±.01
18 PLC	±.01	19 PLC	±.01	20 PLC	±.01	21 PLC	±.01	22 PLC	±.01	23 PLC	±.01
24 PLC	±.01	25 PLC	±.01	26 PLC	±.01	27 PLC	±.01	28 PLC	±.01	29 PLC	±.01
30 PLC	±.01	31 PLC	±.01	32 PLC	±.01	33 PLC	±.01	34 PLC	±.01	35 PLC	±.01
36 PLC	±.01	37 PLC	±.01	38 PLC	±.01	39 PLC	±.01	40 PLC	±.01	41 PLC	±.01
42 PLC	±.01	43 PLC	±.01	44 PLC	±.01	45 PLC	±.01	46 PLC	±.01	47 PLC	±.01
48 PLC	±.01	49 PLC	±.01	50 PLC	±.01	51 PLC	±.01	52 PLC	±.01	53 PLC	±.01
54 PLC	±.01	55 PLC	±.01	56 PLC	±.01	57 PLC	±.01	58 PLC	±.01	59 PLC	±.01
60 PLC	±.01	61 PLC	±.01	62 PLC	±.01	63 PLC	±.01	64 PLC	±.01	65 PLC	±.01
66 PLC	±.01	67 PLC	±.01	68 PLC	±.01	69 PLC	±.01	70 PLC	±.01	71 PLC	±.01
72 PLC	±.01	73 PLC	±.01	74 PLC	±.01	75 PLC	±.01	76 PLC	±.01	77 PLC	±.01
78 PLC	±.01	79 PLC	±.01	80 PLC	±.01	81 PLC	±.01	82 PLC	±.01	83 PLC	±.01
84 PLC	±.01	85 PLC	±.01	86 PLC	±.01	87 PLC	±.01	88 PLC	±.01	89 PLC	±.01
90 PLC	±.01	91 PLC	±.01	92 PLC	±.01	93 PLC	±.01	94 PLC	±.01	95 PLC	±.01
96 PLC	±.01	97 PLC	±.01	98 PLC	±.01	99 PLC	±.01	100 PLC	±.01	101 PLC	±.01
102 PLC	±.01	103 PLC	±.01	104 PLC	±.01	105 PLC	±.01	106 PLC	±.01	107 PLC	±.01
108 PLC	±.01	109 PLC	±.01	110 PLC	±.01	111 PLC	±.01	112 PLC	±.01	113 PLC	±.01
114 PLC	±.01	115 PLC	±.01	116 PLC	±.01	117 PLC	±.01	118 PLC	±.01	119 PLC	±.01
120 PLC	±.01	121 PLC	±.01	122 PLC	±.01	123 PLC	±.01	124 PLC	±.01	125 PLC	±.01
126 PLC	±.01	127 PLC	±.01	128 PLC	±.01	129 PLC	±.01	130 PLC	±.01	131 PLC	±.01
132 PLC	±.01	133 PLC	±.01	134 PLC	±.01	135 PLC	±.01	136 PLC	±.01	137 PLC	±.01
138 PLC	±.01	139 PLC	±.01	140 PLC	±.01	141 PLC	±.01	142 PLC	±.01	143 PLC	±.01
144 PLC	±.01	145 PLC	±.01	146 PLC	±.01	147 PLC	±.01	148 PLC	±.01	149 PLC	±.01
150 PLC	±.01	151 PLC	±.01	152 PLC	±.01	153 PLC	±.01	154 PLC	±.01	155 PLC	±.01
156 PLC	±.01	157 PLC	±.01	158 PLC	±.01	159 PLC	±.01	160 PLC	±.01	161 PLC	±.01
162 PLC	±.01	163 PLC	±.01	164 PLC	±.01	165 PLC	±.01	166 PLC	±.01	167 PLC	±.01
168 PLC	±.01	169 PLC	±.01	170 PLC	±.01	171 PLC	±.01	172 PLC	±.01	173 PLC	±.01
174 PLC	±.01	175 PLC	±.01	176 PLC	±.01	177 PLC	±.01	178 PLC	±.01	179 PLC	±.01
180 PLC	±.01	181 PLC	±.01	182 PLC	±.01	183 PLC	±.01	184 PLC	±.01	185 PLC	±.01
186 PLC	±.01	187 PLC	±.01	188 PLC	±.01	189 PLC	±.01	190 PLC	±.01	191 PLC	±.01
192 PLC	±.01	193 PLC	±.01	194 PLC	±.01	195 PLC	±.01	196 PLC	±.01	197 PLC	±.01
198 PLC	±.01	199 PLC	±.01	200 PLC	±.01	201 PLC	±.01	202 PLC	±.01	203 PLC	±.01
204 PLC	±.01	205 PLC	±.01	206 PLC	±.01	207 PLC	±.01	208 PLC	±.01	209 PLC	±.01
210 PLC	±.01	211 PLC	±.01	212 PLC	±.01	213 PLC	±.01	214 PLC	±.01	215 PLC	±.01
216 PLC	±.01	217 PLC	±.01	218 PLC	±.01	219 PLC	±.01	220 PLC	±.01	221 PLC	±.01
222 PLC	±.01	223 PLC	±.01	224 PLC	±.01	225 PLC	±.01	226 PLC	±.01	227 PLC	±.01
228 PLC	±.01	229 PLC	±.01	230 PLC	±.01	231 PLC	±.01	232 PLC	±.01	233 PLC	±.01
234 PLC	±.01	235 PLC	±.01	236 PLC	±.01	237 PLC	±.01	238 PLC	±.01	239 PLC	±.01
240 PLC	±.01	241 PLC	±.01	242 PLC	±.01	243 PLC	±.01	244 PLC	±.01	245 PLC	±.01
246 PLC	±.01	247 PLC	±.01	248 PLC	±.01	249 PLC	±.01	250 PLC	±.01	251 PLC	±.01
252 PLC	±.01	253 PLC	±.01	254 PLC	±.01	255 PLC	±.01	256 PLC	±.01	257 PLC	±.01
258 PLC	±.01	259 PLC	±.01	260 PLC	±.01	261 PLC	±.01	262 PLC	±.01	263 PLC	±.01
264 PLC	±.01	265 PLC	±.01	266 PLC	±.01	267 PLC	±.01	268 PLC	±.01	269 PLC	±.01
270 PLC	±.01	271 PLC	±.01	272 PLC	±.01	273 PLC	±.01	274 PLC	±.01	275 PLC	±.01
276 PLC	±.01	277 PLC	±.01	278 PLC	±.01	279 PLC	±.01	280 PLC	±.01	281 PLC	±.01
282 PLC	±.01	283 PLC	±.01	284 PLC	±.01	285 PLC	±.01	286 PLC	±.01	287 PLC	±.01
288 PLC	±.01	289 PLC	±.01	290 PLC	±.01	291 PLC	±.01	292 PLC	±.01	293 PLC	±.01
294 PLC	±.01	295 PLC	±.01	296 PLC	±.01	297 PLC	±.01	298 PLC	±.01	299 PLC	±.01
300 PLC	±.01	301 PLC	±.01	302 PLC	±.01	303 PLC	±.01	304 PLC	±.01	305 PLC	±.01
306 PLC	±.01	307 PLC	±.01	308 PLC	±.01	309 PLC	±.01	310 PLC	±.01	311 PLC	±.01
312 PLC	±.01	313 PLC	±.01	314 PLC	±.01	315 PLC	±.01	316 PLC	±.01	317 PLC	±.01
318 PLC	±.01	319 PLC	±.01	320 PLC	±.01	321 PLC	±.01	322 PLC	±.01	323 PLC	±.01
324 PLC	±.01	325 PLC	±.01	326 PLC	±.01	327 PLC	±.01	328 PLC	±.01	329 PLC	±.01
330 PLC	±.01	331 PLC	±.01	332 PLC	±.01	333 PLC	±.01	334 PLC	±.01	335 PLC	±.01
336 PLC	±.01	337 PLC	±.01	338 PLC	±.01	339 PLC	±.01	340 PLC	±.01	341 PLC	±.01

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