

4

3

2

1


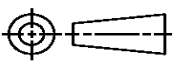
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LOC		DIST		REVISIONS			
P	LTR	DESCRIPTION		DATE	DWN	APVD	
	B1	ECR-16-009822		14JUL2016	GK	SD	

# REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2836250-1

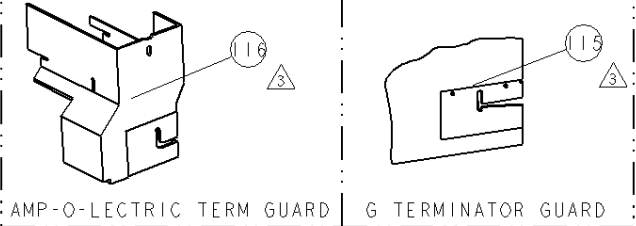
FOR REPLACEMENT PARTS FOR APPLICATOR 1852168  
REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED)  
WILL REMAIN AVAILABLE.

THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE  
SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR  
1852168

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV			TE Connectivity			
DIMENSIONS:		CHK	GOPALAKRISHNA HV			NAME			
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIDE FEED HDM APPLICATOR					
		0 PLC	±	APVD	STOUGH DALE		PRODUCT SPEC		
MATERIAL		1 PLC	±	APPLICATION SPEC		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
FINISH		2 PLC	±	WEIGHT		A3		©- 1852168	
		3 PLC	±	CUSTOMER DRAWING		SCALE	SHEET 1 OF 2	REV B1	
		4 PLC	±						
		ANGLES	±						

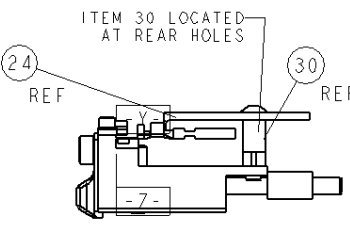
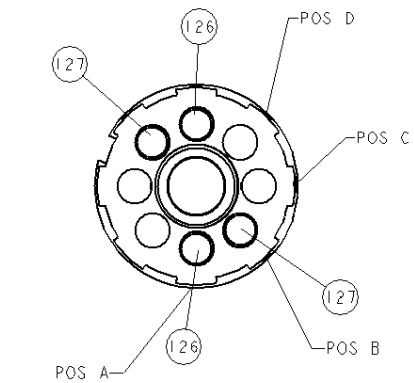
PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1852168-1	B	122500-1	LEADMAKER	POST FEED	CUTS CARRIER
1852168-2	B	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER
1852168-3	B	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER
1852168-6	B	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER
7-1852168-7	B	-	-	-	SPARE PARTS

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

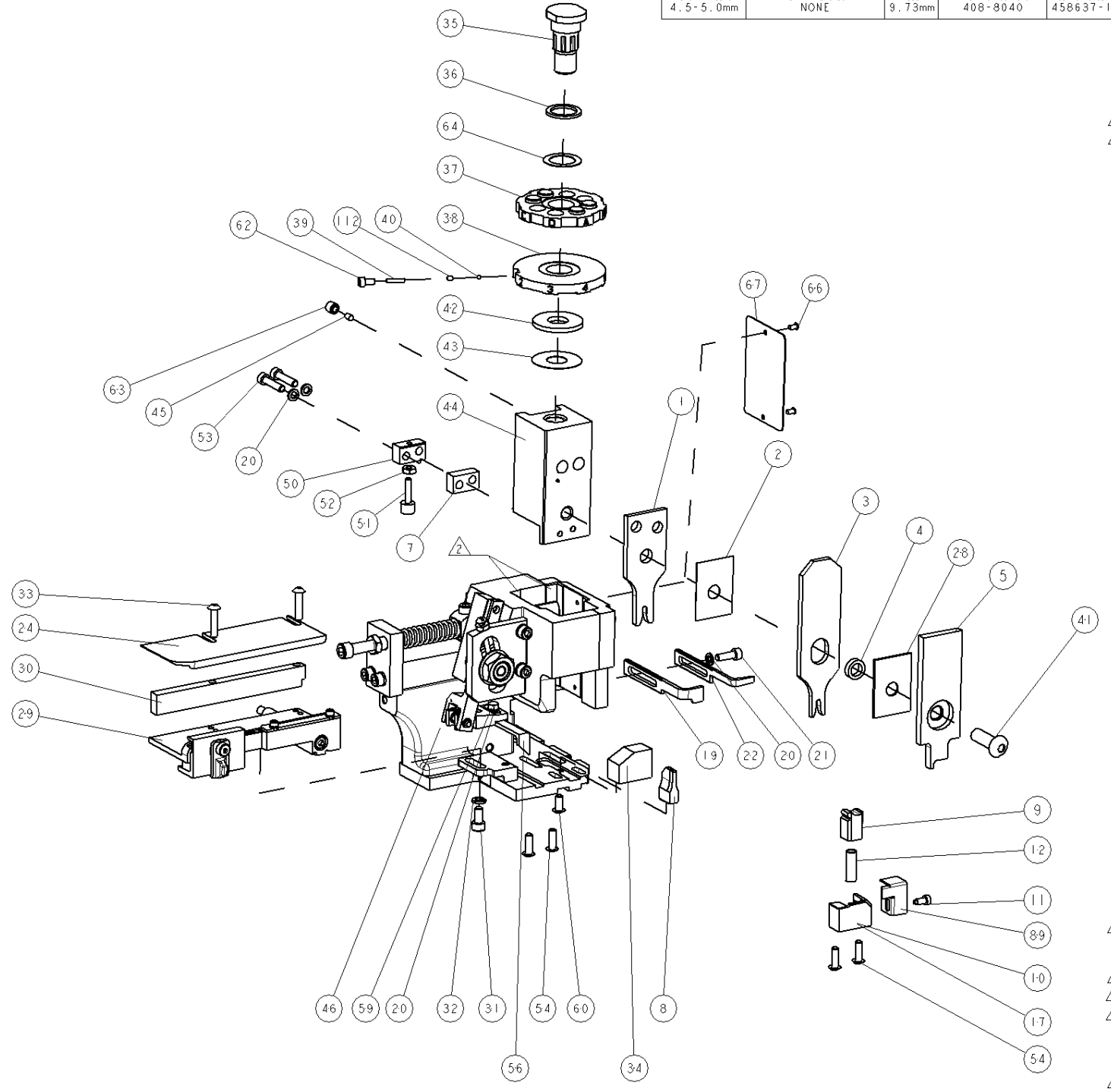
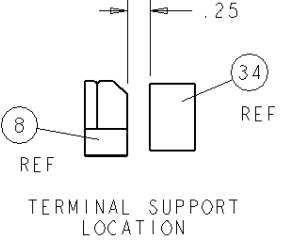


TERMINAL NAME: TERMINAL					
TE PN	MANF PN	FORD TERMINAL - FORD CRIMP SPECS			
1572875-1	F2UB-14487-AA	CRIMP HEIGHT		WIRE SIZE	
-	33230-0002	A	1.50±0.05mm [ .059±.002]	14 AWG	
-	-	B	1.35±0.05mm [ .053±.002]	16 AWG	
-	-	C	-	-	
-	-	D	-	-	
		CRIMP	SIZE	TYPE	RANGE
-	-	WIRE	2.40mm [ .094]	F	14-16 AWG
-	-	INSUL	2.80mm [ .110]	OV	∅1.9-2.6mm
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTIONS	SET UP GAGE	
4.5-5.0mm	NONE	9.73mm	408-8040	458637-1	

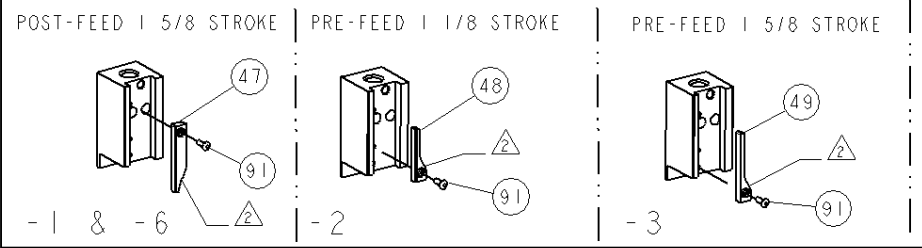
REV		REVISIONS			
REV	DATE	DESCRIPTION	BY	CHK	APP
A	RELEASED				
A1	ECR-08-08601				
A2	ECR-09-007687				
B	ECR-10-020086				



FEED TRACK POSITION



-	2	2	2	2	-	4-354779-1	PIN, WIRE DISC, .3195	127
-	2	2	2	2	-	2-354779-8	PIN, WIRE DISC, .3130	126
-	-	-	REF	-	-	455749-1	GUARD WINDOW	116
-	-	-	REF	-	-	679532-1	INSERT, GUARD	115
-	1	1	1	1	-	690603-1	SPRING ASSIST AMP-O-MATOR APPLICATOR	112
-	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	-	461264-1	PLATE, IDENTIFICATION	67
-	2	2	2	2	-	21017-2	SCREW, DRIVE	66
-	1	1	1	1	-	986950-1	WASHER, FLAT PRECISION	64
-	1	1	1	1	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	63
-	1	1	1	1	-	23030-1	SCR, SKT HD CAP 6-32 x .25	62
-	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	-	2-21000-9	SCR, SKT HD CAP 8-32 X .750	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	-	-	-	-	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	-	455673-1	RAM, SIDE FEED	44
-	1	1	1	1	-	690125-1	SHIM SUB-ASSY	43
-	1	1	1	1	-	1-690124-3	WASHER, RAM (1.105)	42
-	1	1	1	1	-	7-21002-9	SCR, BTN SKT HD CAP 5/16-24 X 1.00	41
-	1	1	1	1	-	23241-6	BALL, STEEL	40
-	1	1	1	1	-	690170-1	SPRING, COMPRESSION	39
-	1	1	1	1	-	690142-3	DISC, INSULATION	38
-	1	1	1	1	-	354777-1	WIRE DISC, ASSEMBLY	37
-	1	1	1	1	-	22480-5	SPRING, COMPRESSION	36
-	1	1	1	1	-	690212-1	POST, RAM	35
-	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	-	1320908-8	SPACER, STRIP GUIDE	30
-	1	1	1	1	-	1633091-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	-	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	-	1320928-3	PLATE, STRIP GUIDE	24
-	1	1	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	-	-	-	-	679625-2	SHEAR HOLDER, FRONT (NO CUT)	17
-	1	1	1	1	-	5-22280-0	SPRING, COMPRESSION	12
-	1	1	1	1	-	690461-2	STOP, SHEAR	11
-	-	1	-	-	-	1-690459-0	SHEAR HOLDER, FRONT	10
-	1	1	1	1	-	462006-6	FLOATING SHEAR, FRONT	9
-	1	1	1	1	-	3-1633116-9	ANVIL, COMBINATION	8
-	1	1	1	1	-	1-240641-5	SPACER	7
-	1	1	1	1	-	2-455889-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	-	3-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	-	3-1633569-5	CRIMPER, INSULATION OVERLAP	3
-	1	1	1	1	-	455888-3	SPACER, CRIMPER	2
-	1	1	1	1	-	6-1673600-3	CRIMPER, WIRE	1



DIMENSIONS	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DWG	DATE
INCHES	0 PLC ±.010 1 PLC ±.015 2 PLC ±.020 3 PLC ±.030 4 PLC ±.050	GROSS	17NOV2005
MATERIAL	FINISH	BY	DATE
		KNEPPER	17NOV2005
		B. BAILEY	17NOV2005
CUSTOMER DRAWING		Tyco Electronics Harrisburg, PA 17105-3608	
SCALE 3:5		SHEET 1 OF 2	

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