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LOC

DIST


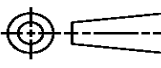
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	B1	ECR-15-012201	08SEP2015	GK	SD

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2150135-2

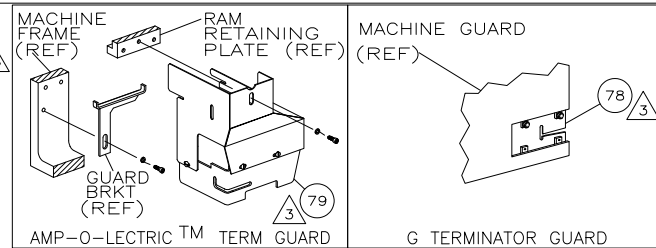
FOR REPLACEMENT PARTS FOR APPLICATOR 1855212
REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED)
WILL REMAIN AVAILABLE.

THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE
SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR
1855212

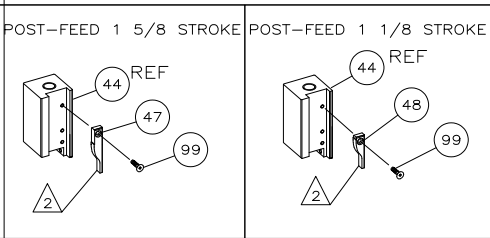
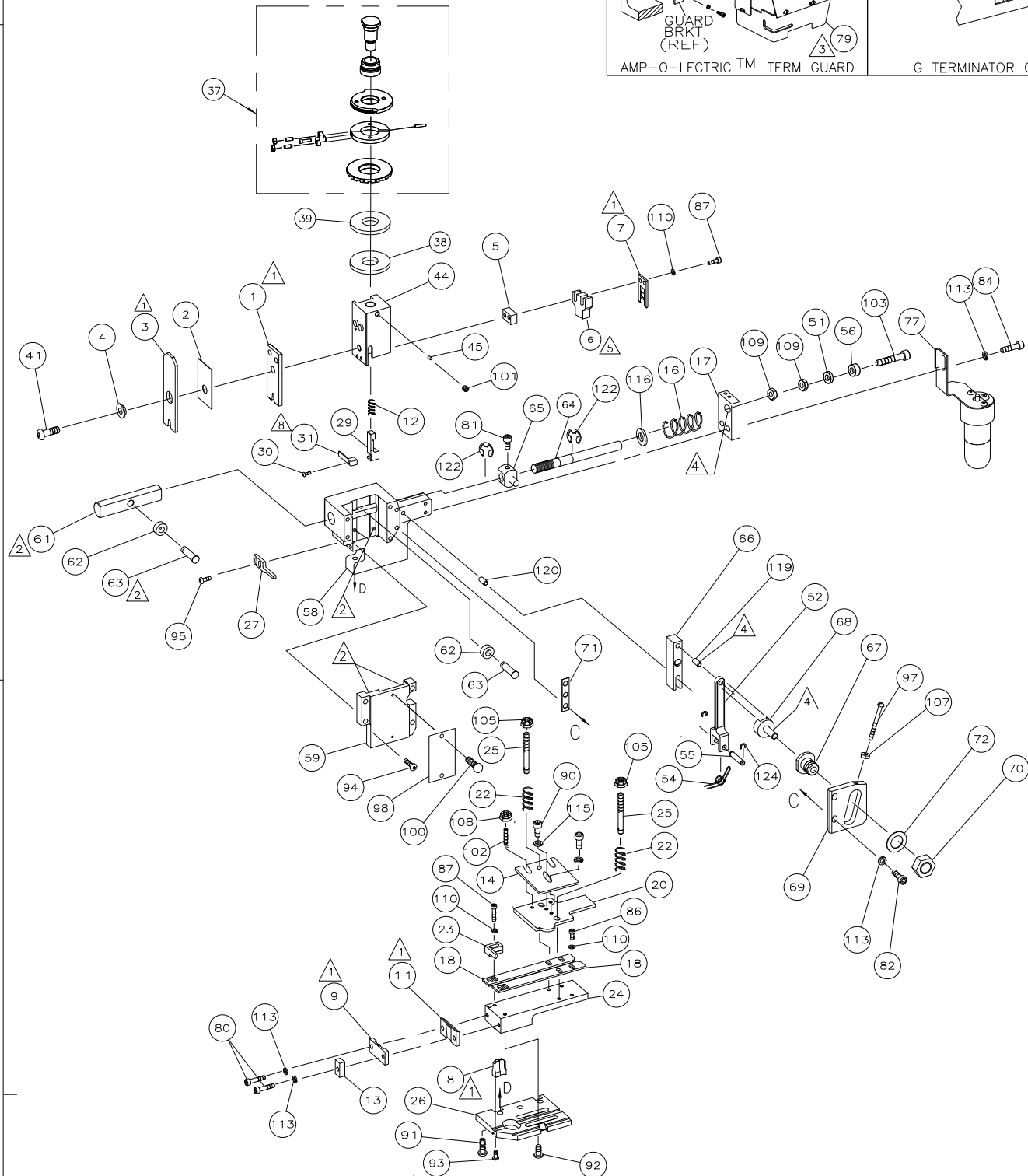
THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV		 TE Connectivity			
		CHK	GOPALAKRISHNA HV					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	NAME			
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		STOUGH DALE		END FEED HDM APPLICATOR FINE ADJUST		
				PRODUCT SPEC				
				APPLICATION SPEC				
				WEIGHT				
MATERIAL		FINISH		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
				A3		©- 1855212		
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE	SHEET 1 OF 2	REV	B1	

1855212
THIS DRAWING IS A CONTROLLED DOCUMENT.

PART NUMBER	REV	FIRST USED	POWER UNIT	FEED
1855212-1	B	854400-1	LEADMAKER& BENCH G	MECH POST FEED
1855212-2	B	565435-5	BENCH K	MECH-POST FEED
7-1855212-7	A	354500-1	SPARE TOOLING	



TERMINAL NAME: .250 POSI LOCK RECP							
63097		REF SETTING	AMP TERMINAL		AMP CRIMP SPECS		
63312			CRIMP HEIGHT		WIRE SIZE		
63442							
63515							
63809							
		A-9	.074 ±.002 [1.88 ±0.05mm]		14		
		C-7	.065 ±.002 [1.65 ±0.05mm]		16		
		E-2	.058 ±.002 [1.47 ±0.05mm]		18		
		-	NOT		USED		
		CRIMP	SIZE		TYPE		RANGE
		WIRE	.110 [2.79mm]		F		14-18
		INSUL	.180 [4.57mm]		F		Ø090-.155
WIRE STRIP LENGTH		TERM APPL SPEC		FEED		APPL INSTRUCTION	
.173-.203		114-2074		1.035		408-8039	
						SET UP GAGE	
						458638-1	
						LAYOUT	
						1165	



LOC	LEADMAKER	K TERMINATOR
A	&	BENCH MACHINE
DIST	G TERMINATOR	
66		

- RECOMMENDED SPARE PARTS.
- GREASE LIGHTLY.
- GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- ADJUST SO THAT BOTTOM OF NEOPRENE IS APPROX .125 ABOVE BOTTOM OF SLUG POCKET.
- ON LEADMAKER WITH T TERMINATING UNITS: IF TERMINAL LOCKING LANCE IS BEING BENT DOWN BEFORE ENTERING APPLICATOR, ORDER SHROUD KIT, PN 189781-1.
- ITEM 78 USED WITH G TERMINATING UNIT ONLY
- PUT ITEM 31 ON AFTER RAM HAS BEEN PUT INTO HOUSING.

***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

QTY	REQD	PER ASSY	PARTS LIST
-	1	1	WASHER, FLAT PRECISION
-	2	2	RING,RETAINING,EXT(5/16)FD ADJ ROD
-	1	1	PIN,DOWEL(Ø.187x1.50)HSG
-	1	1	PIN,DOWEL(Ø.187x.50)LEVER
-	1	1	PIN SPRING Ø.078 X .50
-	1	1	WASHER,FLAT(Ø5/16)SCR ADJ
-	2	2	WASHER,LOCK(NO.6)PL DRAG
-	6	6	WASHER,LOCK(NO.10)SHEAR PL
-	1	1	WASHER,FLAT(NO. 8) FEED FIN
-	7	7	WASHER,LOCK(NO.8)SHEAR BL
-	2	2	NUT,HEX(1/4-20)MAGNET
-	2	2	NUT,HEX(4-40)DRAG
-	1	1	NUT,HEX(6-32)FD ADJ PL
-	2	2	NUT,HEX SL(8-32)DRAG STUD
-	1	1	SCR,SHC(1/4-20X1.25)MAGNET
-	2	2	SCR,SKT SET(4-40 X.62)DRAG
-	1	1	SCR,SKT SET(1/4-20x.25)RAM
-	2	2	SCR,DRIVE(#2x.19)ID PLATE
-	1	1	SCR,BHC(6-32x.38)CAM
-	1	1	PLATE, IDENTIFICATION
-	1	1	SCR,PAN HD(6-32x1.50)FEED ADJ
-	2	2	SCR,BHC(8-32x.50)STRIPPER
-	4	4	SCR,BHC(10-32X.75)
-	1	1	SCR,BHC(8-32x.38 LW)ANVIL
-	4	4	SCR,BHC(1/4-20x.50)ST GD PL
-	3	3	SCR,BHC(1/4-20x.62)BASE PL
-	2	2	SCR,SHC(6-32 X .25)PL DRAG
-	1	1	SCR,SHC(8-32 X .25)FEED FIN
-	4	4	SCR,SHC(8-32x.75)SLUG BLADE
-	3	3	SCR,SHC(8-32x.38)STRIP GUIDE
-	2	2	SCR, SKT CAP(10-32x.75)FD GDE
-	2	2	SCR,SKT CAP(10-32x.62)FD ADJ P
-	1	1	SCR,SKT CAP(10-32x.38)PIVOT BL
-	2	2	SCR,SKT CAP(10-32x.88)SH PL
-	REF	REF	GUARD, WINDOW
-	REF	REF	INSERT, GUARD
-	1	1	LUBRICATOR ASSY
-	1	1	SPRING, ASSIST
-	1	1	SCR,SKT CAP(6-32x.25)CP DSC
-	1	1	WASHER, FLAT (SPECIAL)
-	1	1	SPACER
-77	-2	-1	U/M

QTY	REQD	PER ASSY	PARTS LIST
-	1	1	NUT, HEX
-	1	1	PLATE, ADJ
-	1	1	SHAFT, PIVOT
-	1	1	BUSHING
-	1	1	LEVER, INTERMEDIATE
-	1	1	BLOCK, PIVOT
-	1	1	SCR, ADJ
-	1	1	PIN, CAM ROLLER
-	1	1	CAM, ROLLER
-	1	1	ROD, FEED
-	1	1	CAP, RAM
-	1	1	HOUSING
-	1	1	SPACER, MAGNET
-	1	1	PIN, FEED FINGER
-	1	1	SPRING, FEED FINGER
-	1	1	FINGER, FEED
-	1	1	LEVER, TERMINAL
-	1	1	MAGNET, RING
-	1	1	CAM, POST FEED 1 1/8 ST
-	1	1	CAM, POST-FEED 1 5/8 ST
-	1	1	PLUG, NYLON
-	1	1	RAM
-	1	1	BOLT, CRIMPER(5/16-24x1.00)
-	1	1	SHIM ASSEMBLY
-	1	1	SPACER, FINE ADJUST
-	1	1	FINE ADJUST HEAD SUB
-	1	1	SPRING SWIVEL TIP
-	1	1	TIP, SWIVEL F.F
-	1	1	STRIPPER,TERMINAL
-	1	1	SCR,SHC (4-40 X.62)STR
-	1	1	SLIDE, STRIPPER
-	1	1	STRIPPER
-	1	1	PLATE, BASE
-	2	2	DRAG, STUD
-	1	1	PLATE, STRIP GUIDE
-	1	1	PLATE, STRIP HOLD DOWN
-	2	2	SPRING, DRAG
-	1	1	DRAG, STOCK
-	2	2	GUIDE STRIP,FRONT & REAR
-	1	1	GUIDE, FEED ROD
-	1	1	SPRING, FEED RETURN
-	1	1	PLATE, DRAG LOCATOR
-	1	1	SPACER, HOLD DOWN
-	1	1	SPRING, HOLD DOWN
-	1	1	PLATE, REAR SHEAR
-	1	1	PLATE, FRONT SHEAR
-	1	1	ANVIL
-	1	1	BLADE, SLUG
-	1	1	HOLD DOWN, TERMINAL
-	1	1	SPACER, SLUG BLADE
-	1	1	SPACER, BLOCK CRIMPER
-	1	1	CRIMPER, INSULATION
-	1	1	SPACER, CRIMPER
-	1	1	CRIMPER, WIRE
-77	-2	-1	U/M

3/9/2007	MATERIAL	HEAT TREAT
C.REICHELDERFER	-	-
CHK	3-9-07	
T.ELBIN		
APVD	3-9-07	
T.BENCHOFF		
NAME	END FEED HDW APPLICATOR	
	FINE ADJUST	
SCALE	SIZE	DRAWING NO
-	A1	1855212
SHEET	1	OF 1
REV	B	

GUSTOMER ACCESSIBLE PRODUCTION DRAWING

Mouser Electronics

Authorized Distributor

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[1855212-2](#)