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LOC

DIST

REVISIONS

| P | LTR | DESCRIPTION   | DATE      | DWN | APVD |
|---|-----|---------------|-----------|-----|------|
|   | A1  | ECR-14-001794 | 01APR2014 | GK  | HMR  |
|   |     |               |           |     |      |
|   |     |               |           |     |      |
|   |     |               |           |     |      |

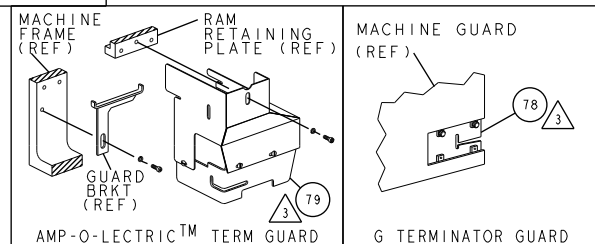
REPLACED BY OCEAN STYLE APPLICATOR PART  
NUMBER 2150273-2

FOR REPLACEMENT PARTS FOR APPLICATOR 1852605  
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  
1852605

|                                                                                       |  |                      |  |                                                                                                       |           |                          |               |
|---------------------------------------------------------------------------------------|--|----------------------|--|-------------------------------------------------------------------------------------------------------|-----------|--------------------------|---------------|
| THIS DRAWING IS A CONTROLLED DOCUMENT.                                                |  | DWN GOPALAKRISHNA HV |  |  TE Connectivity |           |                          |               |
| DIMENSIONS:                                                                           |  | CHK RAGHAVENDRA      |  |                                                                                                       |           |                          |               |
|  |  | APVD RAGHAVENDRA     |  | NAME<br>END FEED HDM APPLICATOR                                                                       |           |                          |               |
|                                                                                       |  | PRODUCT SPEC         |  |                                                                                                       |           |                          |               |
|                                                                                       |  | APPLICATION SPEC     |  |                                                                                                       |           |                          |               |
| MATERIAL                                                                              |  | WEIGHT               |  | SIZE<br>A3                                                                                            | CAGE CODE | DRAWING NO<br>C- 1852605 | RESTRICTED TO |
| FINISH                                                                                |  | CUSTOMER DRAWING     |  | SCALE                                                                                                 |           | SHEET 1 OF 2             | REV A1        |

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



|                                   |   |                        |                                      |                                  |                           |                               |
|-----------------------------------|---|------------------------|--------------------------------------|----------------------------------|---------------------------|-------------------------------|
| TERMINAL NAME: RING TONGUE        |   |                        |                                      |                                  |                           |                               |
| TE PN                             |   | COMP PN                |                                      | LEAR TERMINAL - LEAR CRIMP SPECS |                           |                               |
| 19495080-1                        |   | 25237.123.011          |                                      |                                  |                           |                               |
| -                                 | - | PAD LTR                | CRIMP HEIGHT                         |                                  | WIRE SIZE                 |                               |
| -                                 | - | A                      | 3.15±0.10/-0.05mm [.124±.004/- .002] |                                  | 6mm <sup>2</sup>          |                               |
| -                                 | - | B                      | 3.10±0.10/-0.05mm [.122±.004/- .002] |                                  | 5mm <sup>2</sup> or 10AWG |                               |
| -                                 | - | C                      | 2.95±0.10/-0.05mm [.116±.004/- .002] |                                  | 4mm <sup>2</sup>          |                               |
| -                                 | - | D                      | 2.80±0.05mm [.110±.002]              |                                  | (2) 1.5mm <sup>2</sup>    |                               |
| -                                 | - | CRIMP                  |                                      | SIZE                             | TYPE                      | RANGE                         |
| -                                 | - | WIRE                   |                                      | 4.57mm [.180]                    | F                         | 4mm-6mm                       |
| -                                 | - | INSUL                  |                                      | 6.35mm [.250]                    | F                         | Ø5.1 MAX                      |
| WIRE STRIP LENGTH<br>6.1mm-6.47mm |   | TERM APPL SPEC<br>NONE |                                      | FEED<br>37.85mm                  |                           | APPL INSTRUCTIONS<br>408-8039 |
|                                   |   |                        |                                      |                                  |                           | SET UP GAGE<br>458638-1       |

[illegible]

|   |   |     |     |    |             |                                      |     |
|---|---|-----|-----|----|-------------|--------------------------------------|-----|
|   | - | 1   | 1   | -  | 460680-1    | FEED FINGER ASSEMBLY                 | 175 |
|   | - | 2   | 2   | -  | 3-21000-9   | SCR, SKT HD CAP 10-32 X 1.000        | 174 |
|   | - | -   | 1   | -  | 692655-7    | AIR FEED VALVE ASSEMBLY              | 173 |
|   | - | 1   | -   | -  | 692655-5    | AIR FEED VALVE ASSEMBLY              | 170 |
|   | - | 1   | 1   | -  | 2-460277-7  | AIR FEED ASSY                        | 169 |
|   | - | 2   | 2   | -  | 6-354778-9  | PIN, WIRE DISC, .2840                | 129 |
|   | - | 2   | 2   | -  | 5-354778-5  | PIN, WIRE DISC, .2770                | 128 |
|   | - | 2   | 2   | -  | 4-354778-5  | PIN, WIRE DISC, .2720                | 127 |
|   | - | 2   | 2   | -  | 4-354778-0  | PIN, WIRE DISC, .2695                | 126 |
| 3 | - | REF | -   | .. | 455745-1    | GUARD WINDOW                         | 79  |
| 3 | - | -   | REF | .. | 679532-1    | INSERT, GUARD                        | 78  |
|   | - | 1   | 1   | -  | 690603-1    | SPRING ASSIST AMP-O-MATOR APPLICATOR | 74  |
|   | - | 1   | 1   | -  | 1490525-2   | DEPRESSOR, WIRE                      | 73  |
|   | - | 1   | 1   | -  | 217238-1    | GENERAL INSTRUCTION PKG              | 72  |
|   | - | 1   | 1   | -  | 4088039     | EF APPL INST 408-8039                | 71  |
|   | - | 3   | 3   | -  | 2-23147-2   | SPRING, COMPRESSION                  | 70  |
|   | - | 1   | 1   | -  | 1490524-2   | DEPRESSOR, SPACER                    | 69  |
|   | - | 1   | 1   | -  | 461264-1    | PLATE, IDENTIFICATION                | 67  |
|   | - | 2   | 2   | -  | 21017-2     | SCREW, DRIVE                         | 66  |
|   | - | 1   | 1   | -  | 1424350-1   | HOLDER, PIN, WIRED                   | 65  |
|   | - | 1   | 1   | -  | 986950-1    | WASHER, FLAT PRECISION               | 64  |
|   | - | 1   | 1   | -  | 21009-2     | SCR, SET, SELF LOCKING 1/4-20 X .250 | 63  |
|   | - | 1   | 1   | -  | 23030-1     | SCR, SKT HD CAP 6-32 X .25           | 62  |
|   | - | 1   | 1   | -  | 22733-8     | SCR, BHSC, SELF-LOCKING, 8-32 X .375 | 60  |
|   | - | 4   | 4   | -  | 2-21000-6   | SCR, SKT HD CAP 8-32 X .375          | 57  |
|   | - | 2   | 2   | -  | 3-21000-1   | SCR, SKT HD CAP 8-32 X 1.000         | 56  |
|   | - | 2   | 2   | -  | 21018-4     | NUT, HEX, REG 4-40                   | 54  |
|   | - | 2   | 2   | -  | 21022-2     | NUT, LOCK, HEX, TORQUE, 8-32         | 53  |
|   | - | 2   | 2   | -  | 2-21006-6   | SCR, SET, CUP POINT 4-40 X .625      | 52  |
|   | - | 1   | 1   | -  | 1633570-2   | SUB ASSY, APPLICATOR FRAME           | 46  |
|   | - | 1   | 1   | -  | 690191-1    | PLUG, NYLON                          | 45  |
|   | - | 1   | 1   | -  | 455674-1    | RAM                                  | 44  |
|   | - | 1   | 1   | -  | 690125-1    | SHIM SUB-ASSY                        | 43  |
|   | - | 1   | 1   | -  | 690124-1    | WASHER, RAM (.115)                   | 42  |
|   | - | 1   | 1   | -  | 690686-2    | CRIMPER, BOLT SPECIAL                | 41  |
|   | - | 1   | 1   | -  | 23241-6     | BALL, STEEL                          | 40  |
|   | - | 1   | 1   | -  | 690170-1    | SPRING, COMPRESSION                  | 39  |
|   | - | 1   | 1   | -  | 690142-1    | DISC, INSULATION                     | 38  |
|   | - | 1   | 1   | -  | 354777-1    | WIRE DISC, ASSEMBLY                  | 37  |
|   | - | 1   | 1   | -  | 22480-5     | SPRING, COMPRESSION                  | 36  |
|   | - | 1   | 1   | -  | 690212-1    | POST, RAM                            | 35  |
|   | - | 1   | 1   | -  | 3-21002-1   | SCR, BTN SKT HD CAP 10-32 X 1.00     | 33  |
|   | - | 6   | 6   | -  | 21024-4     | WASHER, SPRG LOCK, REG NO 8          | 32  |
|   | - | 1   | 1   | -  | 2-21002-9   | SCR, BTN SKT HD CAP 10-32 X .750     | 31  |
|   | - | 2   | 2   | -  | 2-21002-2   | SCR, BTN SKT HD CAP 8-32 X .500      | 29  |
|   | - | 2   | 2   | -  | 21024-5     | WASHER, SPRG LOCK, REG NO 10         | 28  |
|   | - | 1   | 1   | -  | 690455-3    | STRIPPER, FRONT CASTING              | 27  |
|   | - | 2   | 2   | -  | 22354-8     | STUD, THREADED                       | 25  |
|   | - | 1   | 1   | -  | 455678-1    | PLATE, STRIP GUIDE                   | 24  |
|   | - | 2   | 2   | -  | 2-22281-6   | SPRING, COMPRESSION                  | 22  |
|   | - | 1   | 1   | -  | 454177-1    | DRAG                                 | 20  |
|   | - | 1   | 1   | -  | 4-458030-6  | STRIP GUIDE, REAR                    | 19  |
|   | - | 1   | 1   | -  | 4-458031-6  | STRIP GUIDE, FRONT                   | 18  |
|   | - | 4   | 4   | -  | 3-21002-3   | SCR, BTN SKT HD CAP 1/4-20 X .500    | 17  |
|   | - | 1   | 1   | -  | 2-240641-9  | SPACER                               | 14  |
|   | - | 1   | 1   | -  | 1-690481-0  | SPACER, HOLD DOWN                    | 13  |
|   | - | 1   | 1   | -  | 23846-1     | SPRING, DIE                          | 12  |
|   | - | 1   | 1   | -  | 240644-1    | PLATE, REAR SHEAR                    | 11  |
|   | - | -   | -   | .. | -           | -                                    | 10  |
|   | - | 1   | 1   | -  | 690482-3    | PLATE, FRONT SHEAR                   | 9   |
|   | - | 1   | 1   | -  | 1-1633248-9 | ANVIL, COMBINATION                   | 8   |
|   | - | 1   | 1   | -  | 690474-9    | BLADE, SLUG                          | 7   |
|   | - | 1   | 1   | -  | 7-455892-3  | HOLD DOWN, TERMINAL                  | 6</ |

|                                                                                       |                                                                             |                        |           |                                                                                                       |                         |
|---------------------------------------------------------------------------------------|-----------------------------------------------------------------------------|------------------------|-----------|-------------------------------------------------------------------------------------------------------|-------------------------|
| THIS DRAWING IS A CONTROLLED DOCUMENT.                                                |                                                                             | DOWN<br>B HIGHMAN      | 28NOV2007 |                                                                                                       |                         |
| DIMENSIONS:<br>INCHES                                                                 |                                                                             | UP<br>B HIGHMAN        | 28NOV2007 |  TE Connectivity |                         |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:                                                |                                                                             | APPROVED BY<br>J ELFIN | 28NOV2007 | NAME                                                                                                  | END FEED HDM APPLICATOR |
|  | Ø PLC ±<br>PLC +0/-1<br>PLC +0/-0.01<br>P PLC +0/-0.001<br>F PLC +0/-0.0001 | PRODUCT SPEC           |           | -                                                                                                     |                         |
|                                                                                       | ANGLES ±                                                                    | APPLICATION SPEC       |           | -                                                                                                     |                         |
| MATERIAL                                                                              | FINISH                                                                      | REWORK                 |           | SIZE CAGE CODE DRAWING NO                                                                             | RESTRICTED TO           |
| -                                                                                     | -                                                                           | -                      | A1        | 100779 ©=1852605                                                                                      |                         |
| Customer Accessible Production Drawing                                                |                                                                             |                        |           | SCALE                                                                                                 | 3:5 SHEET 1 OF 1 REV A  |

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