

| PART NUMBER |  | REV | FIRST USED | POWER UNIT    | FEED TYPE | DESCRIPTION        |
|-------------|--|-----|------------|---------------|-----------|--------------------|
| 1855373-1   |  | A   | 122500-1   | LEADMAKER     | POST FEED | CUTS CARRIER       |
| 1855373-2   |  | A   | 565435-5   | BENCH MODEL K | PRE FEED  | CUTS CARRIER       |
| 1855373-3   |  | A   | 354500-1   | BENCH MODEL G | PRE FEED  | CUTS CARRIER       |
| 1855373-6   |  | A   | 122500-1   | LEADMAKER     | POST FEED | CONTINUOUS CARRIER |
| 7-1855373-7 |  | A   | -          | -             | -         | SPARE PARTS        |

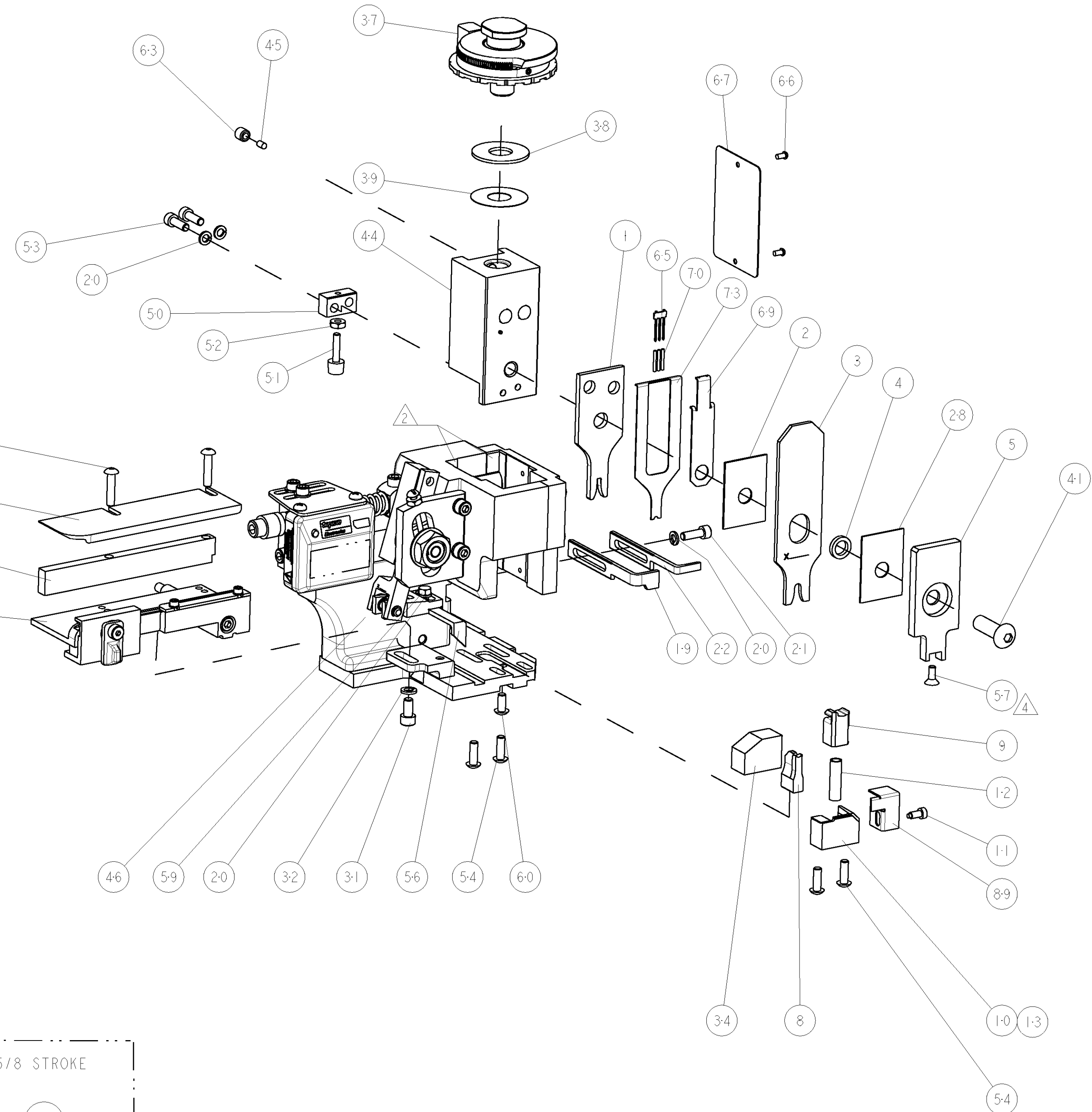
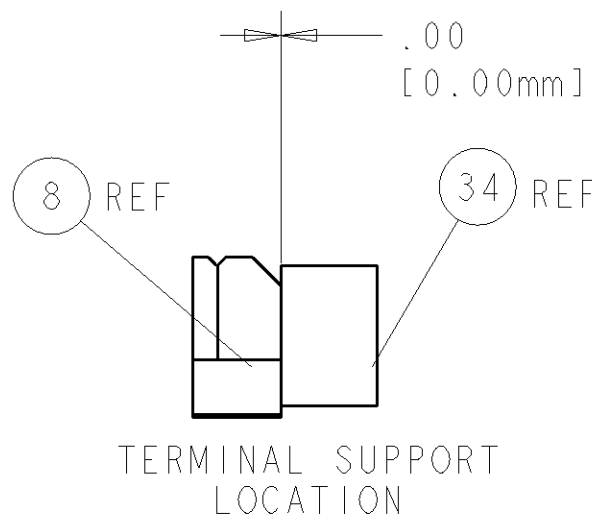
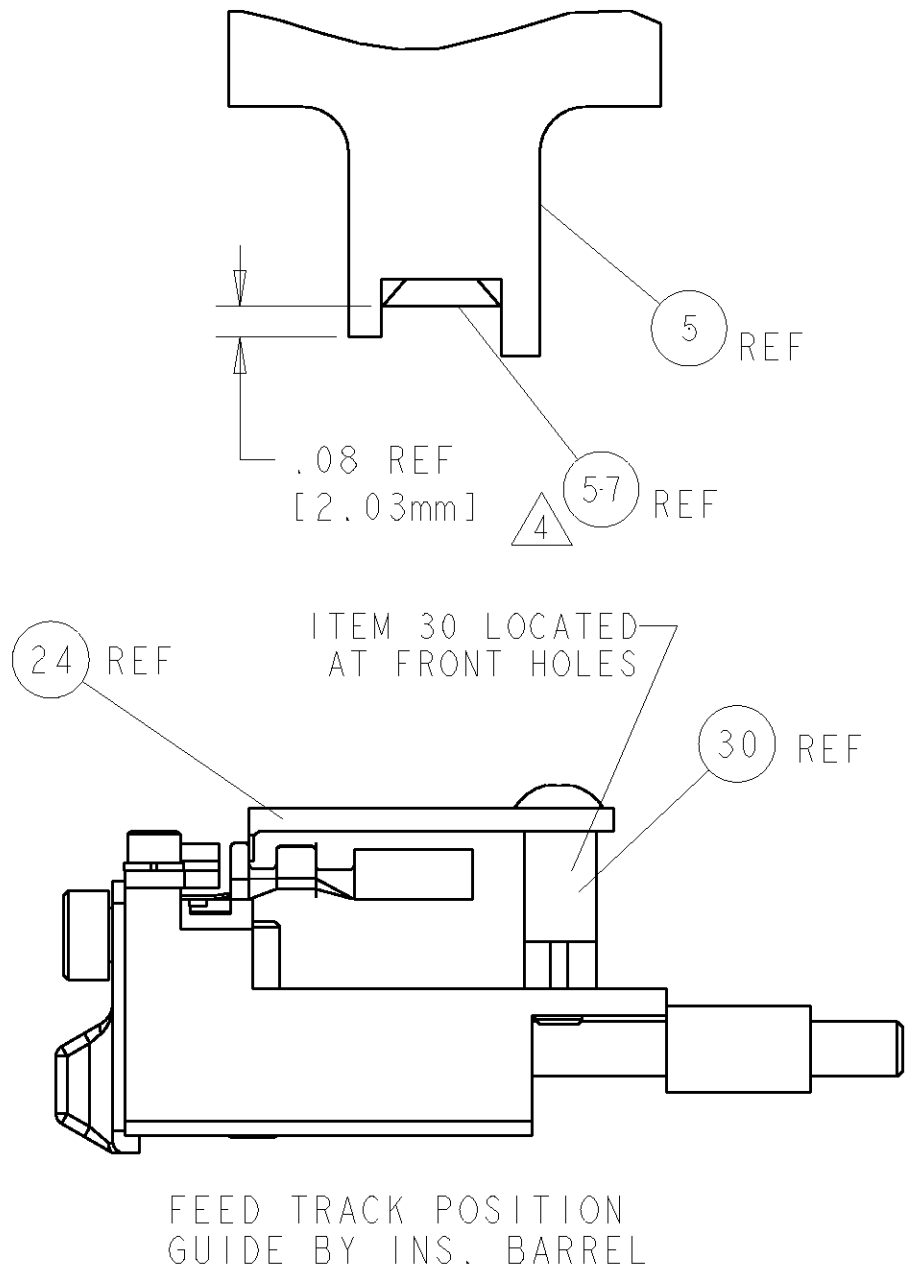
RECOMMENDED SPARE PARTS

GREASE LIGHTLY

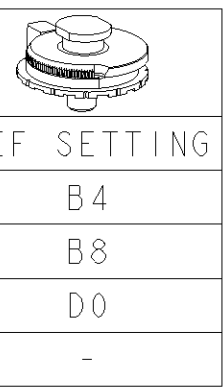
GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE

APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY PN 1-23419-5 LOC-TITE TO THREADS.

**\* 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: FEMALE DAMPING TERMINAL |             | BOSCH TERMINAL - TE CRIMP SPECS    |               | REF SETTING |
|----------------------------------------|-------------|------------------------------------|---------------|-------------|
| TE PN                                  | MANF PN     |                                    |               |             |
| 1572888-2                              | 1928498057  |                                    |               |             |
| -                                      | -           | CRIMP HEIGHT                       |               | WIRE SIZE   |
| -                                      | -           | 1.98mm+.05/- .05[.078+.002/- .002] |               | 2.50mm2     |
| -                                      | -           | 1.92mm+.05/- .05[.075+.002/- .002] |               | 2.0mm2      |
| -                                      | -           | 1.74mm+.05/- .05[.068+.002/- .002] |               | 1.5mm2      |
| -                                      | -           |                                    |               | -           |
| -                                      | -           | CRIMP                              | SIZE          | TYPE        |
| SEAL PN.                               | -           | 828905                             | 1928300600    | WIRE        |
| -                                      | -           | INSUL                              | 4.06mm [.160] | 0           |
| WIRE STRIP LENGTH                      | 4.700-5.081 | TERM APPL SPEC                     | NONE          | FEED        |
|                                        |             | APPLICATOR INSTRUCTIONS            |               | SET UP GAGE |
|                                        |             | 408-8040                           |               | 458637-1    |



REF SETTING

| LOC | DIST | P  | LTR | DESCRIPTION                            | DATE      | OWN | APPRO |
|-----|------|----|-----|----------------------------------------|-----------|-----|-------|
| A   | 66   | A1 |     | CHANGED TERMINAL INFO TO BOSCH ZONE D4 | 17MAR2008 | CMR | TE    |
|     |      | A1 |     | ECR-08-012808                          | 20MAY2008 | MY  | TE    |

|   |   |   |     |     |   |    |             |                                       |     |
|---|---|---|-----|-----|---|----|-------------|---------------------------------------|-----|
| 3 | - | - | -   | REF | - | .. | 455749-1    | GUARD WINDOW                          | 116 |
| 3 | - | - | REF | -   | - | .. | 679532-1    | INSERT, GUARD                         | 115 |
| - | 1 | 1 | 1   | 1   | 1 | -  | 1-21002-7   | SCR, BTN SKT HD CAP 6-32 X .375       | 91  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 318563-1    | GUARD, FRONT CHIP                     | 89  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 1490525-3   | DEPRESSOR, WIRE                       | 73  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 4088040     | SF APPL INST 408-8040                 | 72  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 217238-1    | GENERAL INSTRUCTION PKG               | 71  |
| - | 3 | 3 | 3   | 3   | - | -  | 2-23147-2   | SPRING, COMPRESSION                   | 70  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 1490524-1   | DEPRESSOR, SPACER                     | 69  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 461264-5    | PLATE, IDENTIFICATION                 | 67  |
| - | 2 | 2 | 2   | 2   | - | -  | 21017-2     | SCREW, DRIVE                          | 66  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 1424350-1   | HOLDER, PIN, WIRED                    | 65  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 21009-2     | SCR, SET, SELF LOCKING 1/4-20 X .250  | 63  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 22733-8     | SCR, BHSC, SELF-LOCKING, 8-32 X .375  | 60  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 2-22603-0   | SCR, HEX HD CAP 8-32 X .312           | 59  |
| 4 | - | 1 | 1   | 1   | 1 | -  | 1-21003-9   | SCR, FLT SKT HD CAP 6-32 X .375       | 57  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 458537-2    | PAWL, FEED                            | 56  |
| - | 4 | 4 | 4   | 4   | 4 | -  | 2-21002-2   | SCR, BTN SKT HD CAP 8-32 X .500       | 54  |
| - | 2 | 2 | 2   | 2   | 2 | -  | 2-21000-7   | SCR, SKT HD CAP 8-32 X .500           | 53  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 21018-5     | NUT, HEX, REG 6-32                    | 52  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 811242-2    | BUMPER, HOLD DOWN                     | 51  |
| - | 1 | 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   | 1 | -  | 459456-1    | APPL. BASIC SUB ASSY (SIDE WISE MOCA) | 46  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 690191-1    | PLUG,NYLON                            | 45  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 1-455673-4  | RAM, SIDE FEED                        | 44  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 7-21002-9   | SCR, BTN SKT HD CAP 5/16-24 X 1.00    | 41  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 690125-1    | SHIM SUB-ASSY                         | 39  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 690124-5    | WASHER, RAM (.062)                    | 38  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 879103-2    | FINE ADJUST HEAD ASSEMBLY             | 37  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 3-690786-5  | TERMINAL SUPPORT                      | 34  |
| - | 2 | 2 | 2   | 2   | 2 | -  | 2-21002-4   | SCR, BTN SKT HD CAP 8-32 X .750       | 33  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 21024-5     | WASHER, SPRG LOCK, REG NO 10          | 32  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 3-21000-4   | SCR, SKT HD CAP 10-32 X .375          | 31  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 1320908-6   | SPACER, STRIP GUIDE                   | 30  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 1633091-3   | ASSEMBLY, STRIP GUIDE                 | 29  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 455888-6    | SPACER, CRIMPER                       | 28  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 1320928-1   | PLATE, STRIP GUIDE                    | 24  |
| - | 1 | - | -   | -   | 1 | -  | 690472-2    | STRIPPER                              | 22  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 2-21000-7   | SCR, SKT HD CAP 8-32 X .500           | 21  |
| - | 4 | 4 | 4   | 4   | 4 | -  | 21024-4     | WASHER, SPRG LOCK, REG NO 8           | 20  |
| - | - | 1 | 1   | -   | - | -  | 691353-1    | STRIPPER                              | 19  |
| 1 | - | 1 | -   | -   | - | -  | 679625-2    | SHEAR HOLDER, FRONT (NO CUT)          | 13  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 3-22280-3   | SPRING, COMPRESSION                   | 12  |
| - | 1 | 1 | 1   | 1   | 1 | -  | 690461-2    | STOP, SHEAR                           | 11  |
| 1 | - | 1 | 1   | 1   | 1 | -  | 1-690459-0  | SHEAR HOLDER, FRONT                   | 10  |
| 1 | - | 1 | 1   | 1   | 1 | -  | 318707-2    | FLOATING SHEAR, FRONT                 | 9   |
| 1 | 1 | 1 | 1   | 1   | 1 | -  | 2-1633110-5 | ANVIL, COMBINATION .090               | 8   |
| - | - | - | -   | -   | - | .. | -           | -                                     | 7   |
| - | - | - | -   | -   | - | .. | -           | -                                     | 6   |
| - | 1 | 1 | 1   | 1   | 1 | -  | 318701-9    | DEPRESSOR, SHEAR                      | 5   |
| - | 1 | 1 | 1   | 1   | 1 | -  | 1-238011-0  | BLOCK, CRIMPER SPACER                 | 4   |
| 1 | 1 | 1 | 1   | 1   | 1 | -  | 9-683454-5  | CRIMPER, INSULATION 0                 | 3   |
| - | 1 | 1 | 1   | 1   | 1 | -  | 455888-8    | SPACER, CRIMPER                       | 2   |
| 1 | 1 | 1 | 1   | 1   | 1 | -  | 3-456406-3  | CRIMPER, WIRE PREMIUM                 | 1   |

|                                                                                                                                                                                                           |  |  |  |  |  |  |  |  |  |                                      |  |                                               |  |                 |  |         |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--|--|--|--|--|--|--------------------------------------|--|-----------------------------------------------|--|-----------------|--|---------|--|
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| DIMENSIONS:<br>INCHES                                                                                                                                                                                     |  |  |  |  |  |  |  |  |  | CHG 2/26/2008<br>E. LEBIN            |  | NAME                                          |  |                 |  |         |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:                                                                                                                                                                    |  |  |  |  |  |  |  |  |  | APVD 2/26/2008<br>N. DEMING          |  | FINE ADJUST SIZE FEED<br>HDM APPLICATOR       |  |                 |  |         |  |
| 0 PLC ±.01<br>1 PLC ±.01<br>2 PLC ±.01<br>3 PLC ±.01<br>4 PLC ±.0001                                                                                                                                      |  |  |  |  |  |  |  |  |  | PRODUCT SPEC -<br>APPLICATION SPEC - |  | SIZE CAGE CODE DRAWING NO                     |  | RESTRICTED TO - |  |         |  |
| ANGLES<br>FINISH                                                                                                                                                                                          |  |  |  |  |  |  |  |  |  | WEIGHT                               |  | A 1 00779 C 1855373                           |  | -               |  |         |  |
| MATERIAL -                                                                                                                                                                                                |  |  |  |  |  |  |  |  |  | CUSTOMER DRAWING                     |  | SCALE 3:5                                     |  | SHEET 1 OF 1    |  | REV A 1 |  |

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