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LOC

DIST


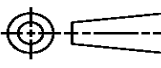
REVISIONS

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.

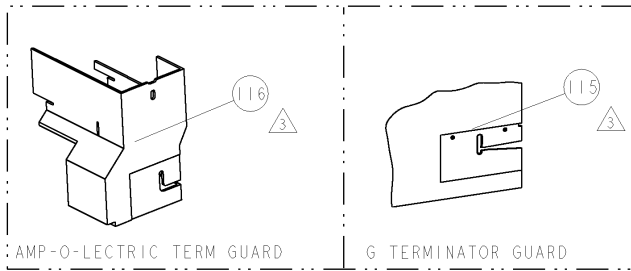
THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE  
SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR  
1855224

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

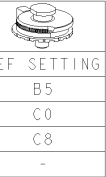
PART NUMBER		REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1855224-1	B	122500-1	LEADMAKER	POST FEED	CUTS CARRIER	
1855224-2	B	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER	
1855224-3	B	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER	
1855224-6	B	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER	
7-1855224-7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

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

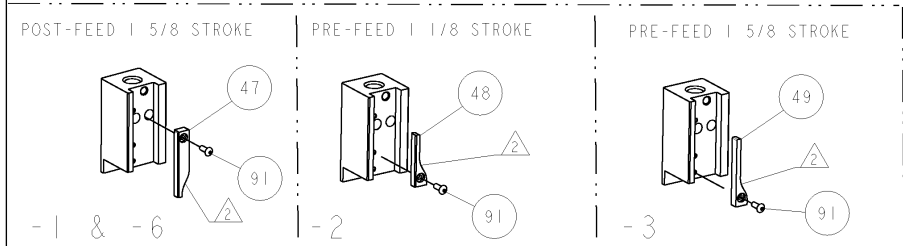
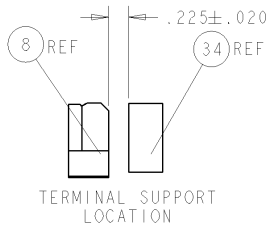
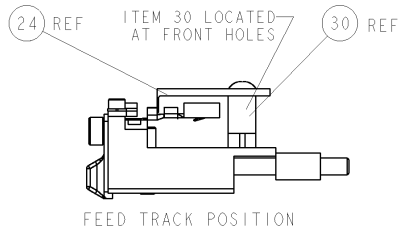
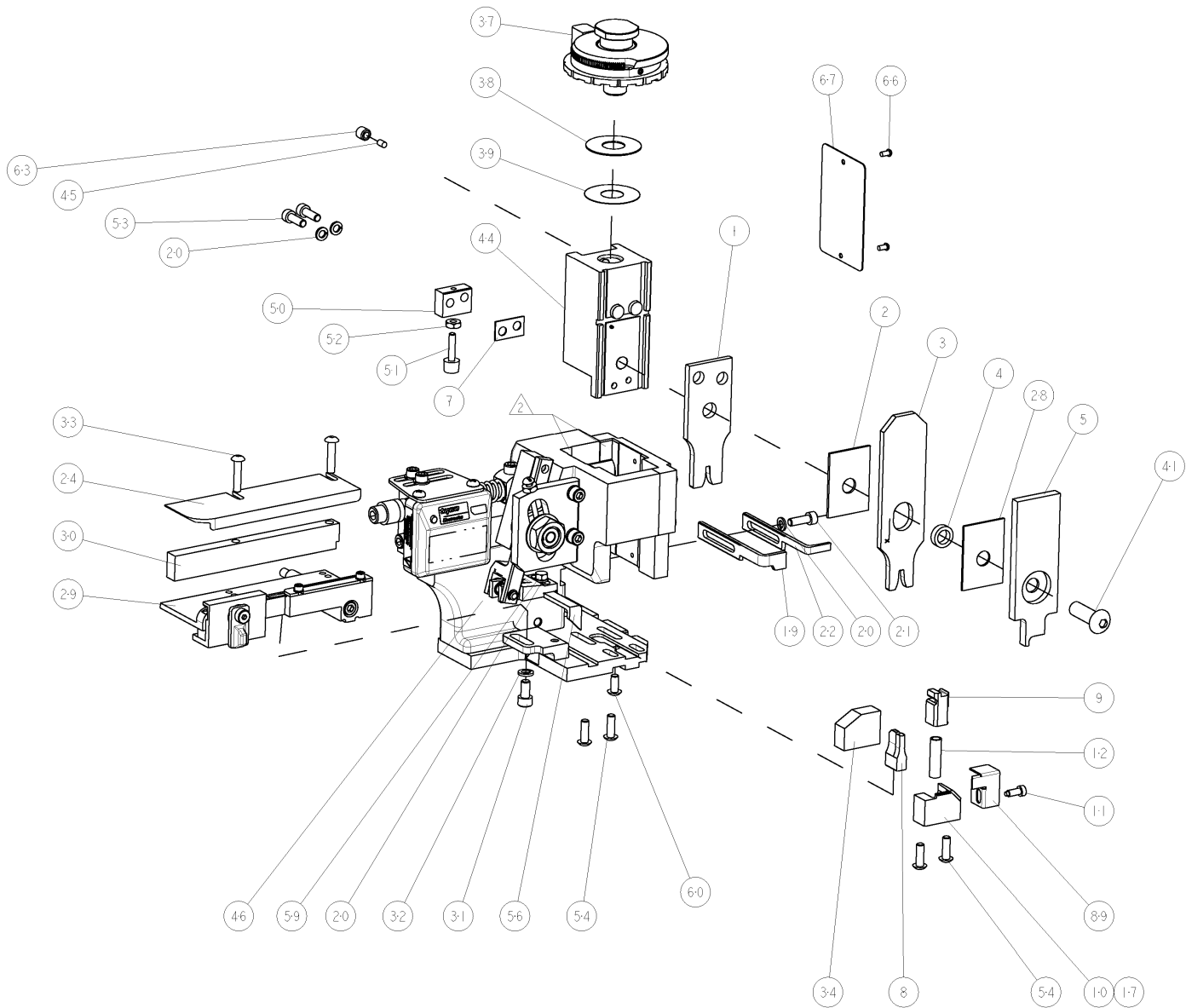
**\* WARNING**  
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN. REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



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

PART NO		DESCRIPTION		ITEM NO
-77	-6	-3	-2	-1
U/M				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		
INCHES		0 PLC ±.01		
		1 PLC ±.01		
		2 PLC ±.01		
		3 PLC ±.01		
		4 PLC ±.01		
		ANGLES		
MATERIAL		FINISH		
CUSTOMER DRAWING		SCALE 3:5		
		SHEET 1 OF 1		
		REV B		

CUSTOMER VIEWABLE ASSEMBLY

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