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LOC

DIST


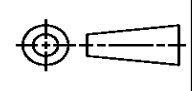
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	B1	ECR-13-019974	07JAN2014	RS	LZ

REPLACED BY OCEAN STYLE APPLICATOR PART  
NUMBER 2151363-1

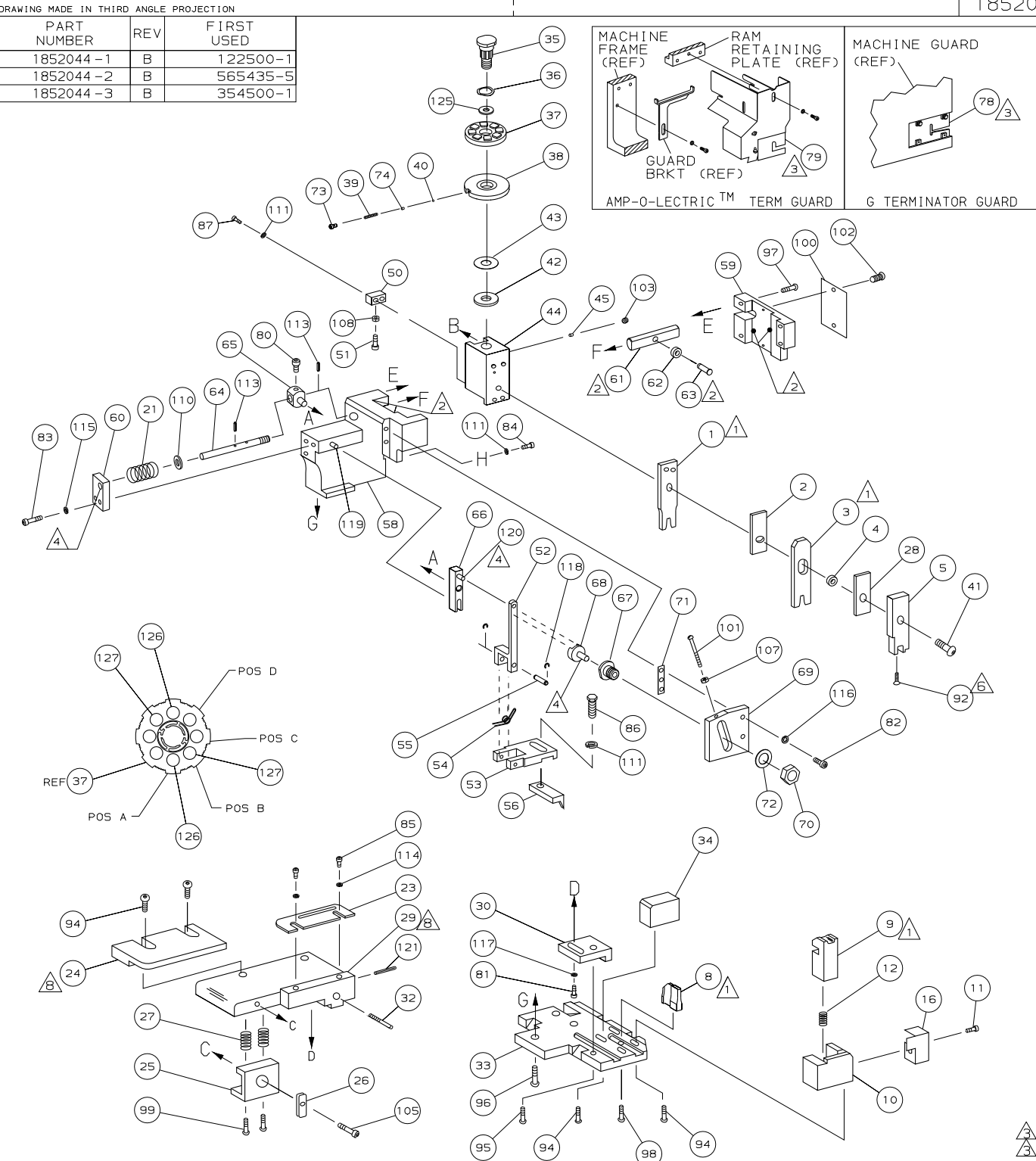
FOR REPLACEMENT PARTS FOR APPLICATOR 1852044  
REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED)  
WILL REMAIN AVAILABLE.

THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE  
SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR  
1852044

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN R.SHEN		 TE Connectivity			
DIMENSIONS:		CHK LJ.ZHANG					
		APVD U.GUO		NAME SIDE FEED HDM APPLICATOR			
		PRODUCT SPEC					
		APPLICATION SPEC					
MATERIAL		WEIGHT		SIZE A3	CAGE CODE	DRAWING NO C- 1852044	RESTRICTED TO
FINISH		CUSTOMER DRAWING		SCALE		SHEET 1 OF 2	REV B1

DRAWING MADE IN THIRD ANGLE PROJECTION

PART NUMBER	REV	FIRST USED
1852044-1	B	122500-1
1852044-2	B	565435-5
1852044-3	B	354500-1



POST FEED 1 5/8 STROKE	PRE FEED 1 1/8 STROKE	PRE FEED 1 5/8 STROKE
ROTATED 180° B	ROTATED 180° B	ROTATED 180° B
LEADMAKER	K TERMINATOR	G TERMINATOR

LOC A	22 19
DIST 66	
LEADMAKER & BENCH MACHINE	

- 1 RECOMMENDED SPARE PARTS.
- 2 GREASE LIGHTLY.
- 3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- 4 LUBRICATE DAILY USING NO. 20 MACHINE OIL.
5. ITEMS WITH QTY OF REF SPECIFIED (EXCEPT ITEMS 78 AND 79) ARE USED ON ITEM 46.
- 6 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- 7 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

1852044 1852044

TERMINAL NAME: MALE PIN, WEATHER PACK					CRIMP DATA PER CUSTOMER SPEC				
					CRIMPING DATA				
						CRIMP HEIGHT		WIRE SIZE	
AMP		MFG		PAD LTR					
286510		12124580		A		1.55 ±0.05 [0.061 ±.002IN]		2mm <sup>2</sup>	
286638		12124582		B		1.4 ±0.05 [0.055 ±.002IN]		1mm <sup>2</sup>	
				C		NOT		USED	
SEAL				D		NOT		USED	
286514		12010293		CRIMP		SIZE		TYPE	
				WIRE		2.89 [0.114IN]		F	
				INSUL		4.16 [0.164IN]		0	
								ø2.81-3.49	
WIRE STRIP LENGTH		TERM APPL SPEC		FEED		APPL INSTRUCTION		SET UP GAGE LAYOUT	
5.16-5.94		NONE		14.99		408-8040		458637-1 L2000	
									129
									128
2	2	2	-	C	1-354779-9	PIN, WIRE DISC (.3085)B			127
2	2	2	-	C	354779-9	PIN, WIRE DISC (.3035)A			126
1	1	1	-	A	986950-1	WASHER, FLAT PRECISION			125
1	1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE			124
1	1	1	-	-	4088040	SF APPL INST 408-8040			123
									122
1	1	1	-	A	4-21028-0	PIN,SLT SPR (ø.093x.75)ST GDE PL			121
REF	REF	REF	-	A	1-21030-1	PIN,DOWEL (ø.187x.50) LEVER			120
REF	REF	REF	-	A	1-21030-6	PIN,DOWEL (ø.187x1.25) HOUSING			119
REF	REF	REF	-	A	21045-3	RING,RET "C" (ø.187)FD FING PIN			118
1	1	1	-	A	21024-5	WASHER, LOCK (#10) ADJ BLOCK			117
REF	REF	REF	-	A	21024-5	WASHER,LOCK (#10)ADJ PLATE			116
REF	REF	REF	-	A	21024-5	WASHER,LOCK (#10)FEED GDE ROD			115
2	2	2	-	A	21024-2	WASHER,LOCK (#4)FRONT STP GUIDE			114
REF	REF	REF	-	A	5-21028-1	PIN,SLT SPR (ø.125x.50) ADJ ROD			113
									112
4	4	4	-	A	21024-4	WASHER,LOCK (#8) STRIPPER			111
REF	REF	REF	-	A	21899-4	WASHER,FLAT (ø5/16) SCREW ADJ			110
									109
1	1	1	-	A	21018-5	NUT, HEX (NO.6) HOLDDOWN			108
REF	REF	REF	-	A	21018-5	NUT, HEX (6-32) FEED ADJ			107
									106
1	1	1	-	A	22353-8	SCR,SHLD (ø.187x.25)DRAG LEVER			105
									104
1	1	1	-	A	21009-2	SCR,SKT SET (1/4-20x.25 LW)RAM			103
2	2	2	-	A	21017-2	SCR,DRIVE (#2x.19) ID PLATE			102
REF	REF	REF	-	A	6-23715-5	SCR, PAN HD (6-32x1.50) FEED ADJ			101
1	1	1	-	B	461264-1	PLATE, IDENTIFICATION			100
2	2	2	-	A	3-21002-0	SCR,BHC (10-32x.88) DRAG			99
1	1	1	-	A	22733-8	SCR, BHC (8-32x.38 LW) ANVIL			98
REF	REF	REF	-	A	2-21002-9	SCR, BHC (10-32x.75) CAP			97
REF	REF	REF	-	A	2-22733-8	SCR, BHC (1/4-20x.62) HOUSING			96
REF	REF	REF	-	A	2-21002-7	SCR, BHC (10-32x.50) SG ADJ BLOCK			95
6	6	6	-	A	2-21002-2	SCR, BHC (8-32x.50) TERM H DWN			94
									93
1	1	1	-	A	1-21003-9	SCR, FHC (6-32x.38) DEP			92
1	1	1	-	A	1-21002-7	SCR, BHC (6-32x.38) CAM			91
									90
									89
									88
2	2	2	-	A	2-21000-7	SCR,SHC (8-32x.48) DEP-HOLD			87
1	1	1	-	A	2-22603-0	SCR,HEX HD (8-32x.31) FEED FINGER			86
2	2	2	-	A	1-21000-3	SCR,SHC (4-40x.25) F ST GUIDE			85
1	1	1	-	A	2-21000-7	SCR,SHC (8-32x.50) STRIPPER			84
REF	REF	REF	-	A	3-21000-7	SCR,SHC (10-32x.75) FEED ROD GD			83
REF	REF	REF	-	A	3-21000-6	SCR,SHC (10-32x.62) FD ADJ BLK			82
1	1	1	-	A	3-21000-4	SCR,SHC (10-32x.38) SG ADJ BL			81
REF	REF	REF	-	A	3-21000-4	SCR,SHC (10-32x.38) PIVOT BLK			80
-	REF	-	-	B	455749-1	GUARD, WINDOW			79
REF	-	-	-	B	679532-1	INSERT, GUARD			78
									77
									76
									75
1	1	1	-	A	690603-1	SPRING, ASSIST			74
1	1	1	-	A	23030-1	SCR,SHC (6-32x.25 SL) INS DISC			73
REF	REF	REF	-	A	458109-1	WASHER, SPECIAL			72
REF	REF	REF	-	A	690517-1	SPACER			71
-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION			ITEM NO
QTY REQD PER ASSY				PARTS LIST					

ADJUSTMENT OF STRIP GUIDE PLATE ITEM 29 AND REAR STRIP GUIDE ITEM 24 WHEN CHANGING FROM TERMINAL 286510 TO 286638 AND VICE VERSA.

B	ECR-05-017302	GB	12-05
A	REVD	CE	JUN05
P	REV	APP	DATE
L	REVISION RECORD		

				LEADMAKER		MECH POST FEED			
				BENCH MODEL K		MECH PRE FEED			
				BENCH MODEL G		MECH PRE FEED			
REF	REF	REF	-	B	22594-8	NUT, HEX (1/2-20)		70	1852044
REF	REF	REF	-	B	240628-1	PLATE, ADJUSTMENT		69	
REF	REF	REF	-	B	240626-1	SHAFT, PIVOT		68	
REF	REF	REF	-	B	240633-1	BUSHING		67	
REF	REF	REF	-	A	455680-1	LEVER, INTERMEDIATE		66	
REF	REF	REF	-	B	240629-1	BLOCK, PIVOT		65	
REF	REF	REF	-	A	240632-2	SCREW, ADJ FEED ROD		64	
REF	REF	REF	-	B	240659-3	PIN, CAM ROLLER		63	
REF	REF	REF	-	B	240658-1	ROLLER, CAM		62	
REF	REF	REF	-	B	454398-2	ROD, FEED		61	
REF	REF	REF	-	A	454178-1	GUIDE, FEED ROD		60	
REF	REF	REF	-	C	454220-1	CAP, RAM		59	
REF	REF	REF	-	D	454485-1	HOUSING		58	
								57	
1	1	1	-	B	458537-2	PAWL, FEED		56	
REF	REF	REF	-	B	240624-1	PIN, FEED FINGER		55	
REF	REF	REF	-	B	691499-1	SPRING, FEED FINGER		54	
REF	REF	REF	-	B	690541-1	HOLDER, FEED FINGER		53	
REF	REF	REF	-	A	455679-1	LEVER, TERMINAL FEED ARM		52	
1	1	1	-	A	811242-2	BUMPER, HOLDDOWN		51	
1	1	1	-	A	690753-1	SPACER, TONKER		50	
1	-	-	-	B	690602-6	CAM, PRE-FEED 1 5/8 ST		49	
-	1	-	-	B	690602-5	CAM, PRE-FEED 1 1/8 ST		48	
-	-	1	-	B	690501-4	CAM, POST-FEED 1 5/8 ST		47	
1	1	1	-	B	459456-1	APPLICATOR, BASIC (SUBASSY)		46	
1	1	1	-	A	690191-1	PLUG, NYLON		45	
1	1	1	-	C	455673-1	RAM		44	
1	1	1	-	A	690125-1	WASHER, LAMINATED		43	
1	1	1	-	A	690124-1	WASHER, RAM		42	
1	1	1	-	A	7-21002-9	BOLT, CRIMPER (5/16x1.00)		41	
1	1	1	-	A	23241-6	BALL, STEEL		40	
1	1	1	-	A	690170-1	SPRING, COMPRESSION		39	
1	1	1	-	C	690142-1	DISC, INSULATION		38	
1	1	1	-	D	354777-1	WIRE DISC, PLASTIC		37	
1	1	1	-	A	22480-5	WASHER, SPRING		36	
1	1	1	-	B	690212-1	POST, RAM		35	
1	1	1	-	B	690786-5	SUPPORT, TERMINAL		34	
REF	REF	REF	-	D	455675-1	PLATE, BASE		33	
1	1	1	-	A	690432-3	SCREW, ADJUSTMENT		32	
								31	
REF	REF	REF	-	B	455689-1	BLOCK, STRIP GUIDE ADJ		30	
1	1	1	-	C	458144-1	PLATE, STRIP GUIDE		29	
1	1	1	-	C	455888-9	SPACER, FRONT SHEAR DEP		28	
2	2	2	-	A	1-22284-0	SPRING, DRAG		27	
1	1	1	-	B	356835-1	LEVER, DRAG RELEASE		26	
1	1	1	-	B	240792-1	DRAG, TERMINAL		25	
1	1	1	-	D	6-690504-2	GUIDE, STRIP (REAR)		24	
1	1	1	-	A	690438-1	GUIDE, STRIP (FRONT)		23	
-	-	1	-	B	690472-2	STRIPPER		22	
REF	REF	REF	-	A	4-22284-9	SPRING, FEED RETURN		21	
								20	
1	1	-	-	B	691353-1	STRIPPER		19	
								18	
								17	
1	1	1	-	B	318563-1	GUARD, CHIP, FRONT		16	
								15	
								14	
								13	
1	1	1	-	A	3-22280-3	SPRING, SHEAR		12	
1	1	1	-	B	690461-2	STOP, SHEAR		11	
1	1	1	-	C	1-690459-0	HOLDER, SHEAR (FRONT)		10	
1	1	1	-	C	318707-2	SHEAR, FLOAT (FRONT)		9	
1	1	1	-	C	3-1424534-5	ANVIL		8	
								7	
								6	
1	1	1	-	C	318701-1	DEPRESSOR, SHEAR (FRONT)		5	
1	1	1	-	B	3-238011-3	SPACER, BLOCK CRIMPER		4	
1	1	1	-	C	3-1583690-4	CRIMPER, INSULATION		3	
1	1	1	-	C	1-455888-1	SPACER, CRIMPER		2	
1	1	1	-	C	2-1673600-0	CRIMPER, WIRE		1	
-3	-2	-1	U/M	DWG SIZE	PART NO		DESCRIPTION		ITEM NO
				REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)					
QTY REQD PER ASSY				PARTS LIST					

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