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LOC

DIST

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A1	ECR-15-004848	27MAR2015	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2150121-2

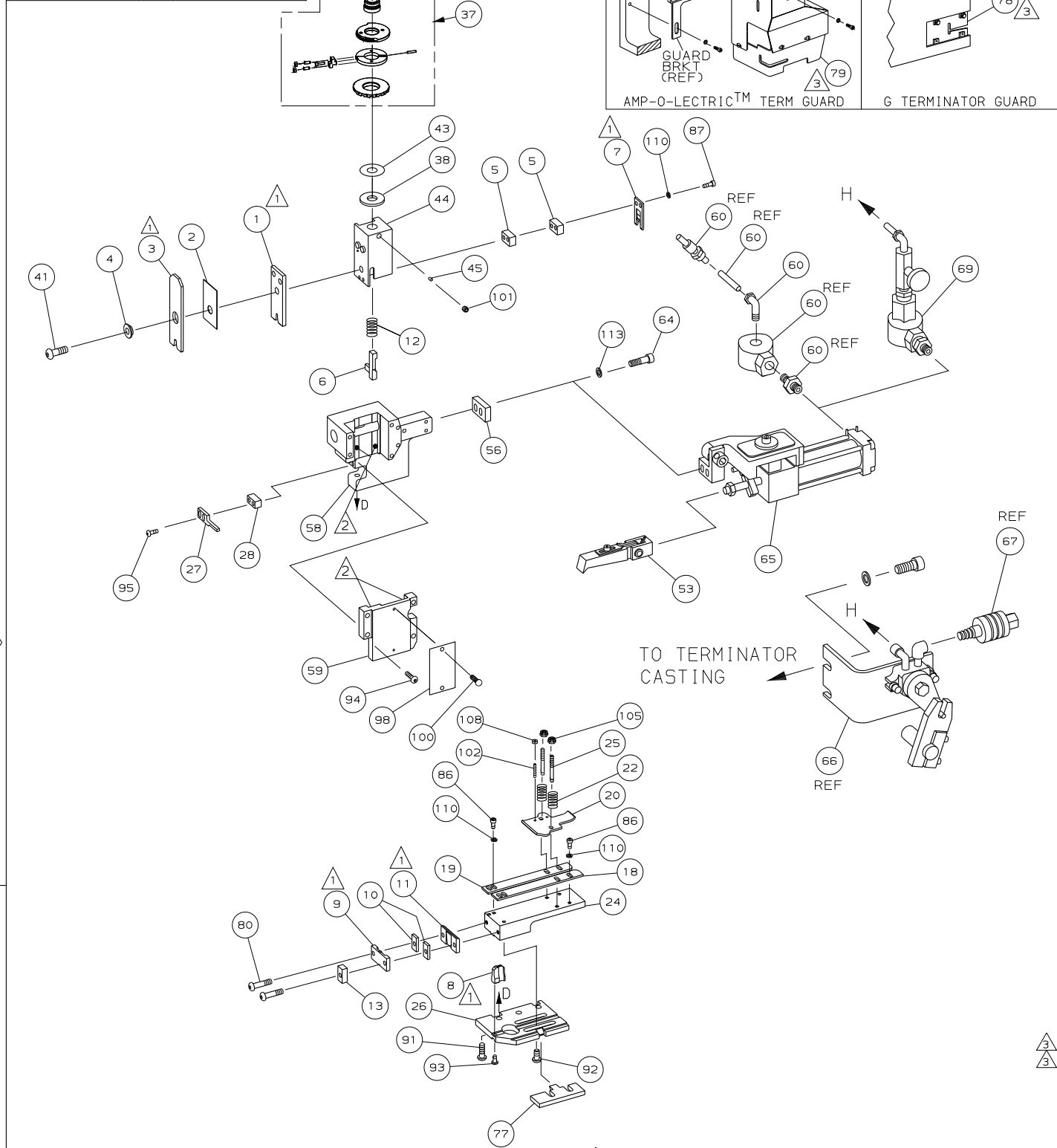
FOR REPLACEMENT PARTS FOR APPLICATOR 1855053
REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED)
WILL REMAIN AVAILABLE.

THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE
SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR
1855053

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN GOPALAKRISHNA HV		 TE Connectivity	
CHK RAGHAVENDRA		APVD RAGHAVENDRA			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME FINE ADJUST END FD HDM APPL	
		0 PLC ±		SIZE	
		1 PLC ±		CAGE CODE	
		2 PLC ±		DRAWING NO	
		3 PLC ±		RESTRICTED TO	
4 PLC ±		4 PLC ±		C- 1855053	
MATERIAL		FINISH		WEIGHT	
				CUSTOMER DRAWING	
				SCALE	
				SHEET 1 OF 2	
				REV A1	

DRAWING MADE IN THIRD ANGLE PROJECTION

PART NUMBER	REV	FIRST USED
1855053-1	A	122500-1
1855053-2	A	565435-5
7-1855053-7	A	SPARE PARTS KIT



- 1 RECOMMENDED SPARE PARTS.
2 GREASE LIGHTLY.
3 GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
4 SEE DRAWING FOR COMPONENTS

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

1855053 1855053

TERMINAL NAME: RING					
61336	61337	640143	REF SETTING	CRIMPING DATA	
			B1	CRIMP HEIGHT *	WIRE SIZE
			C2	.106 ±.002 [2.69 ±0.05mm]	14
			-	.100 ±.002 [2.54 ±0.05mm]	16
			-	NOT	USED
			-	NOT	USED
			CRIMP	SIZE	TYPE
			WIRE	.160 [4.06mm]	F
			INSUL	.210 [5.33mm]	0
					.120-.180
			WIRE STRIP LENGTH	TERM APPL SPEC	FEED
			.172-.203	114-2084	1.370
				APPL INSTRUCTION	SET UP GAGE
				408-8039	458638-1
					LAYOUT
					918

-	1	1	-	A	217238-1	GENERAL INSTRUCTION PACKAGE	124
-	1	1	-	-	4088039	EF APPL INST 408-8039	123
-	2	2	-	A	21024-5	WASHER, LOCK (#10) AIR ASSY	113
-	4	4	-	A	21024-4	WASHER, LOCK (NO. 8) SHEAR BL	110
-	2	2	-	A	21018-4	NUT, HEX (4-40) DRAG	108
-	2	2	-	A	21022-2	NUT, HEX SL (8-32) DRAG STUD	105
-	2	2	-	A	2-21006-6	SCR, SKT SET (4-40x.62) DRAG	102
-	1	1	-	A	21009-2	SCR, SKT SET (1/4-20x.25) RAM	101
-	2	2	-	A	21017-2	SCR, DRIVE (#2x.19) ID PLATE	100
-	1	1	-	B	461264-5	PLATE, IDENTIFICATION	98
-	2	2	-	A	2-21002-2	SCR, BHC (8-32x.50) STRIPPER	95
-	4	4	-	A	3-21002-0	SCR, BHC (10-32x.88) CAP	94
-	1	1	-	A	22733-8	SCR, BHC (8-32x.38) LW ANVIL	93
-	4	4	-	A	3-21002-3	SCR, BHC (1/4-20x.50) ST GD PL	92
-	3	3	-	A	2-22733-8	SCR, BHC (1/4-20x.62) HSG	91
-	2	2	-	A	3-21000-1	SCR, SHC (8-32x1.00) SLUG BLADE	87
-	4	4	-	A	2-21000-6	SCR, SHC (8-32x.38) STRIP GUIDE	86
-	2	2	-	A	3-21002-1	SCR, BHC (10-32x1.00) SHEAR PL	80
-	1	-	-	A	455750-7	GUARD ASSY	79
-	-	REF	-	A	679532-1	INSERT, GUARD	78
-	1	-	-	A	694427-1	BRACKET, HOLD DOWN	77

QTY REQD PER ASSY	PARTS LIST
1	61336
1	61337
1	640143
1	REF SETTING
1	B1
1	C2
1	NOT
1	NOT
1	CRIMP
1	SIZE
1	TYPE
1	WIRE
1	INSUL
1	WIRE STRIP LENGTH
1	TERM APPL SPEC
1	FEED
1	APPL INSTRUCTION
1	SET UP GAGE
1	LAYOUT

-1	LEADMAKER & BENCH MODEL G				AIR FEED		
-2	BENCH MODEL K				AIR FEED		
-77	SPARE PARTS KIT						
-							70
-	1	-	-	C	692655-5	AIR FEED VALVE ASSY	69
							68
-	REF	-	-	A	24042-2	VALVE, SHUT OFF	67
-	REF	-	-	C	692655-6	AIR FEED VALVE ASSY	66
-	1	1	-	B	460277-4	AIR FEED ASSY (1 INCH)	65
-	2	2	-	A	4-21000-2	SCR,SHC(10-32x1.75)AIR ASSY	64
							63
							62
							61
-	-	1	-	C	692655-7	AIR FEED VALVE ASSY	60
-	1	1	-	C	458268-1	CAP, RAM	59
-	1	1	-	D	458267-1	HOUSING	58
							57
-	1	1	-	A	461690-3	SPACER, AIR FEED	56
							55
							54
-	1	1	-	B	460680-1	FEED FINGER ASSY	53
							52
							51
							50
							49
							48
							47
							46
-	1	1	-	A	690191-1	PLUG, NYLON	45
-	1	1	-	C	458266-1	RAM	44
-	1	1	-	A	690125-1	WASHER, LAMINATED	43
							42
-	1	1	-	A	690686-1	BOLT, CRIMPER(5/16-24x1.00)	41
							40
							39
-	1	1	-	-	469367-8	SPACER, FINE ADJUST	38
-	1	1	-	-	879103-2	FINE ADJUST HEAD ASSY	37
							36
							35
							34
							33
							32
							31
							30
							29
-	1	1	-	B	3-690451-2	SPACER, STRIPPER	28
-	1	1	-	A	240639-1	STRIPPER	27
-	1	1	-	D	463915-2	PLATE, BASE	26
-	2	2	-	A	22354-8	DRAG, STUD	25
-	1	1	-	B	463903-1	PLATE, STRIP GUIDE	24
							23
-	2	2	-	A	4-22281-1	SPRING, DRAG	22
							21
-	1	1	-	A	454177-2	DRAG, STOCK	20
-	1	1	-	B	458030-4	GUIDE, STRIP (REAR)	19
-	1	1	-	C	458031-4	GUIDE, STRIP (FRONT)	18
							17
							16
							15
							14
-	1	1	-	C	1-690481-0	SPACER, HOLD DOWN	13
-	1	1	-	A	23846-1	SPRING, HOLD DOWN	12
1	1	1	-	B	458255-1	PLATE, REAR SHEAR	11
-	2	2	-	C	1-240645-2	SPACER, SHEAR PLATE	10
1	1	1	-	B	461449-1	PLATE, FRONT SHEAR	9
1	1	1	-	D	7-238005-7	ANVIL	8
1	1	1	-	B	238074-9	BLADE, SLUG	7
-	1	1	-	D	8455892-0	HOLD DOWN, TERMINAL	6
-	2	2	-	C	5-238075-6	SPACER, SLUG BLADE	5
-	1	1	-	B	1-238009-8	SPACER, BLOCK CRIMPER	4
1	1	1	-	C	464463-3	CRIMPER, INSULATION	3
-	1	1	-	B	455888-8	SPACER, CRIMPER	2
1	1	1	-	C	1-464112-8	CRIMPER, WIRE	1
-77	-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			
DIMENSIONS IN INCHES. DO NOT SCALE PRINT. TOLERANCES UNLESS OTHERWISE SPECIFIED: 2 PLC DEC ±.25 3 PLC DEC ±. 4 PLC DEC ±. ANGLES ±. SURF TEXTURE, ✓ REMOVE BURRS, BREAK SHARP EDGES R.015 MAX				MATL		HT TR	FIN
				OR C.ERISMAN 21MAR06 APP 21MAR06 T.ELBIN		AMP	
				CHK 21MAR06 C.ERISMAN REL -		AMP Incorporated Harrisburg, PA 17105-3608	
				NAME		MACHINE REF	
				SCALE		SHEET	
				FINE ADJUST END FD HDM APPL		MINI APPL	
				1855053		REV A	
CASE CODE 00779				CUSTOMER AND ASSEMBLY DRAWING			
				RESTRICTED TO -			

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JUN 26, 1999

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