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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.

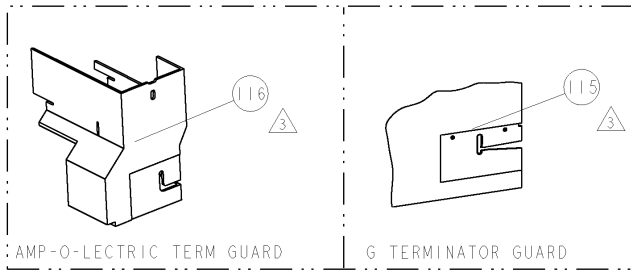
THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE  
SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR  
1855224

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN GOPALAKRISHNA HV		 TE Connectivity	
CHK RAGHAVENDRA		APVD RAGHAVENDRA			
APVD RAGHAVENDRA		NAME		FINE ADJUST SIDE FEED HDM APPLICATOR	
PRODUCT SPEC		APPLICATION SPEC		RESTRICTED TO	
SIZE		CAGE CODE		DRAWING NO	
A 3				©- 1855224	
CUSTOMER DRAWING		SCALE		SHEET 1 OF 2 REV B1	

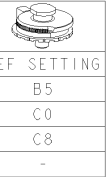
PART NUMBER		REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1855224-1	B	122500-1	LEADMAKER	POST FEED	CUTS CARRIER	
1855224-2	B	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER	
1855224-3	B	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER	
1855224-6	B	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER	
7-1855224-7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

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

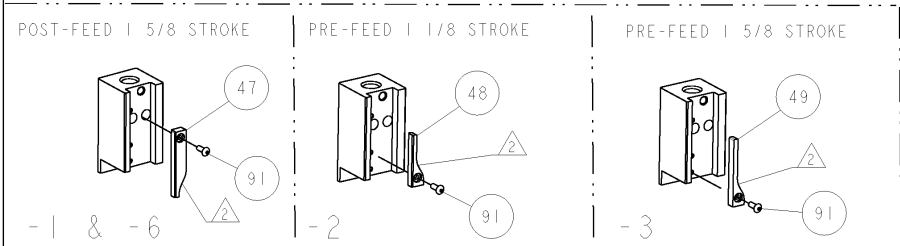
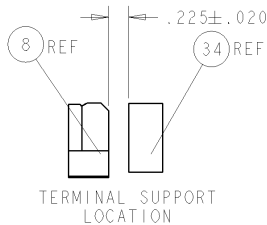
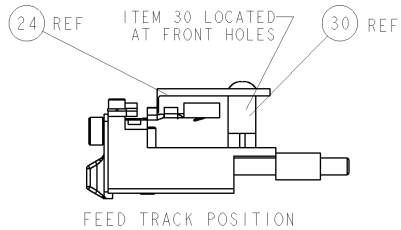
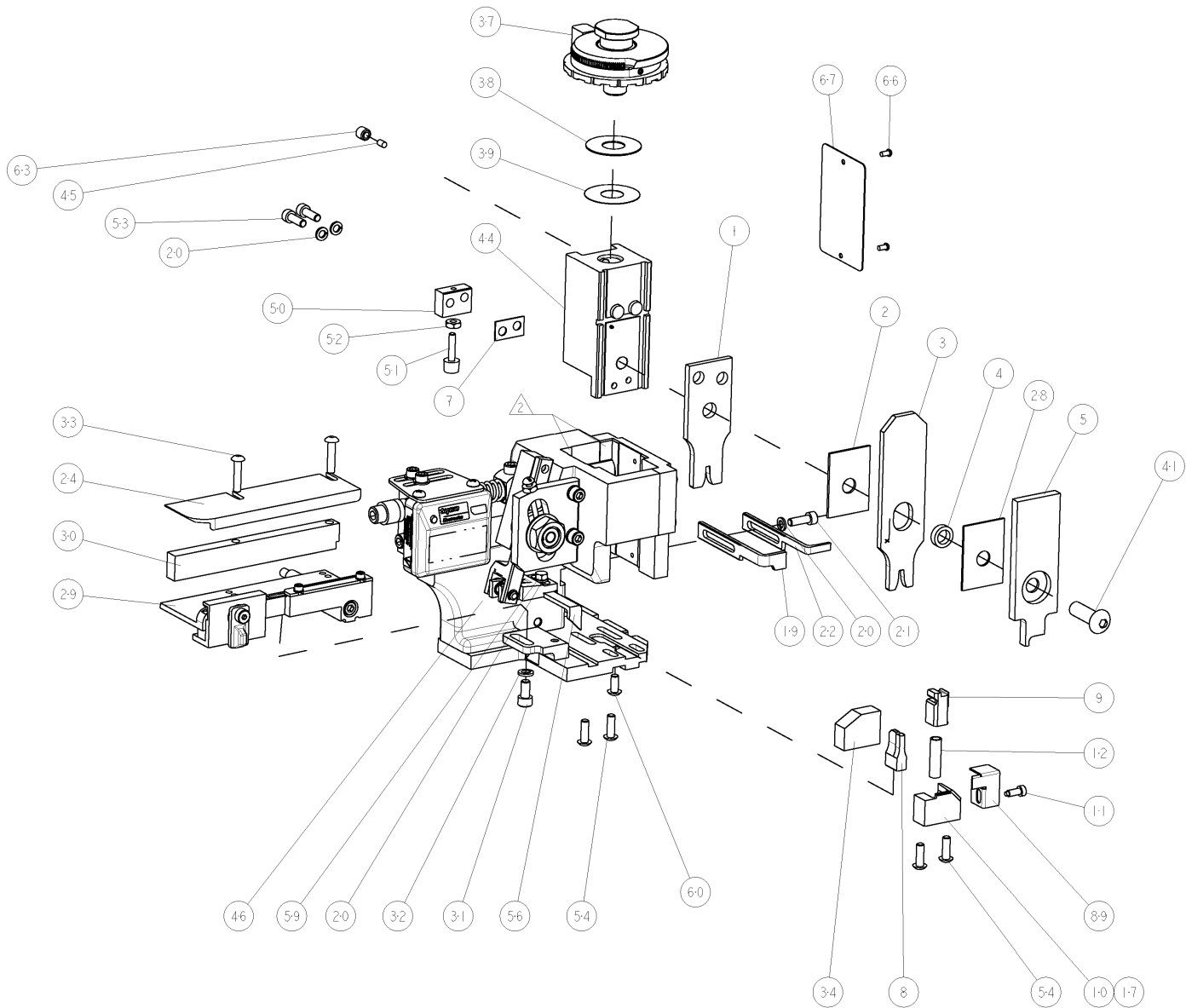
**\* WARNING**  
ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN. REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.



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

DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		APPLICATION SPEC		WEIGHT		CUSTOMER DRAWING	
0 PLC	±.01	1 PLC	±.01	2 PLC	±.01	3 PLC	±.01	4 PLC	±.01	5 PLC	±.01
6 PLC	±.01	7 PLC	±.01	8 PLC	±.01	9 PLC	±.01	10 PLC	±.01	11 PLC	±.01
12 PLC	±.01	13 PLC	±.01	14 PLC	±.01	15 PLC	±.01	16 PLC	±.01	17 PLC	±.01
18 PLC	±.01	19 PLC	±.01	20 PLC	±.01	21 PLC	±.01	22 PLC	±.01	23 PLC	±.01
24 PLC	±.01	25 PLC	±.01	26 PLC	±.01	27 PLC	±.01	28 PLC	±.01	29 PLC	±.01
30 PLC	±.01	31 PLC	±.01	32 PLC	±.01	33 PLC	±.01	34 PLC	±.01	35 PLC	±.01
36 PLC	±.01	37 PLC	±.01	38 PLC	±.01	39 PLC	±.01	40 PLC	±.01	41 PLC	±.01
42 PLC	±.01	43 PLC	±.01	44 PLC	±.01	45 PLC	±.01	46 PLC	±.01	47 PLC	±.01
48 PLC	±.01	49 PLC	±.01	50 PLC	±.01	51 PLC	±.01	52 PLC	±.01	53 PLC	±.01
54 PLC	±.01	55 PLC	±.01	56 PLC	±.01	57 PLC	±.01	58 PLC	±.01	59 PLC	±.01
60 PLC	±.01	61 PLC	±.01	62 PLC	±.01	63 PLC	±.01	64 PLC	±.01	65 PLC	±.01
66 PLC	±.01	67 PLC	±.01	68 PLC	±.01	69 PLC	±.01	70 PLC	±.01	71 PLC	±.01
72 PLC	±.01	73 PLC	±.01	74 PLC	±.01	75 PLC	±.01	76 PLC	±.01	77 PLC	±.01
78 PLC	±.01	79 PLC	±.01	80 PLC	±.01	81 PLC	±.01	82 PLC	±.01	83 PLC	±.01
84 PLC	±.01	85 PLC	±.01	86 PLC	±.01	87 PLC	±.01	88 PLC	±.01	89 PLC	±.01
90 PLC	±.01	91 PLC	±.01	92 PLC	±.01	93 PLC	±.01	94 PLC	±.01	95 PLC	±.01
96 PLC	±.01	97 PLC	±.01	98 PLC	±.01	99 PLC	±.01	100 PLC	±.01	101 PLC	±.01
102 PLC	±.01	103 PLC	±.01	104 PLC	±.01	105 PLC	±.01	106 PLC	±.01	107 PLC	±.01
108 PLC	±.01	109 PLC	±.01	110 PLC	±.01	111 PLC	±.01	112 PLC	±.01	113 PLC	±.01
114 PLC	±.01	115 PLC	±.01	116 PLC	±.01	117 PLC	±.01	118 PLC	±.01	119 PLC	±.01
120 PLC	±.01	121 PLC	±.01	122 PLC	±.01	123 PLC	±.01	124 PLC	±.01	125 PLC	±.01
126 PLC	±.01	127 PLC	±.01	128 PLC	±.01	129 PLC	±.01	130 PLC	±.01	131 PLC	±.01
132 PLC	±.01	133 PLC	±.01	134 PLC	±.01	135 PLC	±.01	136 PLC	±.01	137 PLC	±.01
138 PLC	±.01	139 PLC	±.01	140 PLC	±.01	141 PLC	±.01	142 PLC	±.01	143 PLC	±.01
144 PLC	±.01	145 PLC	±.01	146 PLC	±.01	147 PLC	±.01	148 PLC	±.01	149 PLC	±.01
150 PLC	±.01	151 PLC	±.01	152 PLC	±.01	153 PLC	±.01	154 PLC	±.01	155 PLC	±.01
156 PLC	±.01	157 PLC	±.01	158 PLC	±.01	159 PLC	±.01	160 PLC	±.01	161 PLC	±.01
162 PLC	±.01	163 PLC	±.01	164 PLC	±.01	165 PLC	±.01	166 PLC	±.01	167 PLC	±.01
168 PLC	±.01	169 PLC	±.01	170 PLC	±.01	171 PLC	±.01	172 PLC	±.01	173 PLC	±.01
174 PLC	±.01	175 PLC	±.01	176 PLC	±.01	177 PLC	±.01	178 PLC	±.01	179 PLC	±.01
180 PLC	±.01	181 PLC	±.01	182 PLC	±.01	183 PLC	±.01	184 PLC	±.01	185 PLC	±.01
186 PLC	±.01	187 PLC	±.01	188 PLC	±.01	189 PLC	±.01	190 PLC	±.01	191 PLC	±.01
192 PLC	±.01	193 PLC	±.01	194 PLC	±.01	195 PLC	±.01	196 PLC	±.01	197 PLC	±.01
198 PLC	±.01	199 PLC	±.01	200 PLC	±.01	201 PLC	±.01	202 PLC	±.01	203 PLC	±.01
204 PLC	±.01	205 PLC	±.01	206 PLC	±.01	207 PLC	±.01	208 PLC	±.01	209 PLC	±.01
210 PLC	±.01	211 PLC	±.01	212 PLC	±.01	213 PLC	±.01	214 PLC	±.01	215 PLC	±.01
216 PLC	±.01	217 PLC	±.01	218 PLC	±.01	219 PLC	±.01	220 PLC	±.01	221 PLC	±.01
222 PLC	±.01	223 PLC	±.01	224 PLC	±.01	225 PLC	±.01	226 PLC	±.01	227 PLC	±.01
228 PLC	±.01	229 PLC	±.01	230 PLC	±.01	231 PLC	±.01	232 PLC	±.01	233 PLC	±.01
234 PLC	±.01	235 PLC	±.01	236 PLC	±.01	237 PLC	±.01	238 PLC	±.01	239 PLC	±.01
240 PLC	±.01	241 PLC	±.01	242 PLC	±.01	243 PLC	±.01	244 PLC	±.01	245 PLC	±.01
246 PLC	±.01	247 PLC	±.01	248 PLC	±.01	249 PLC	±.01	250 PLC	±.01	251 PLC	±.01
252 PLC	±.01	253 PLC	±.01	254 PLC	±.01	255 PLC	±.01	256 PLC	±.01	257 PLC	±.01
258 PLC	±.01	259 PLC	±.01	260 PLC	±.01	261 PLC	±.01	262 PLC	±.01	263 PLC	±.01
264 PLC	±.01	265 PLC	±.01	266 PLC	±.01	267 PLC	±.01	268 PLC	±.01	269 PLC	±.01
270 PLC	±.01	271 PLC	±.01	272 PLC	±.01	273 PLC	±.01	274 PLC	±.01	275 PLC	±.01
276 PLC	±.01	277 PLC	±.01	278 PLC	±.01	279 PLC	±.01	280 PLC	±.01	281 PLC	±.01
282 PLC	±.01	283 PLC	±.01	284 PLC	±.01	285 PLC	±.01	286 PLC	±.01	287 PLC	±.01
288 PLC	±.01	289 PLC	±.01	290 PLC	±.01	291 PLC	±.01	292 PLC	±.01	293 PLC	±.01
294 PLC	±.01	295 PLC	±.01	296 PLC	±.01	297 PLC	±.01	298 PLC	±.01	299 PLC	±.01
300 PLC	±.01	301 PLC	±.01	302 PLC	±.01	303 PLC	±.01	304 PLC	±.01	305 PLC	±.01
306 PLC	±.01	307 PLC	±.01	308 PLC	±.01	309 PLC	±.01	310 PLC	±.01	311 PLC	±.01
312 PLC	±.01	313 PLC	±.01	314 PLC	±.01	315 PLC	±.01	316 PLC	±.01	317 PLC	±.01
318 PLC	±.01	319 PLC	±.01	320 PLC	±.01	321 PLC	±.01	322 PLC	±.01	323 PLC	±.01
324 PLC	±.01	325 PLC	±.01	326 PLC	±.01	327 PLC	±.01	328 PLC	±.01	329 PLC	±.01
330 PLC	±.01	331 PLC	±.01	332 PLC	±.01	333 PLC	±.01	334 PLC	±.01	335 PLC	±.01
336 PLC	±.01	337 PLC	±.01	338 PLC	±.01	339 PLC	±.01	340 PLC	±.01	341 PLC	±.01