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D
Dimensioning and tolerancing per ASME Y14.5M-2009
C

B
A

A


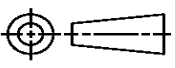
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4		3		2		1							
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									B1	ECR-12-015681	14SEP2012	XZ	SX

REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2151096-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1852668
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
1852668

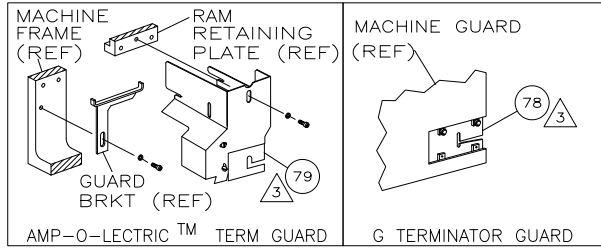
THIS DRAWING IS A CONTROLLED DOCUMENT.				DWN X. ZHAO		 TE Connectivity				
DIMENSIONS:				CHK S. XI						
				APVD S. XI		NAME SIDE FEED HDM APPLICATOR				
				PRODUCT SPEC						
				APPLICATION SPEC						
				MATERIAL		FINISH		WEIGHT		SIZE A3
								SCALE	SHEET 1 OF 2	REV B1

Dimensioning and tolerancing per ASME Y14.5M-2009

THIS DRAWING IS A CONTROLLED DOCUMENT.

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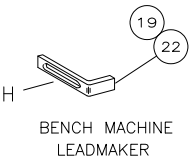
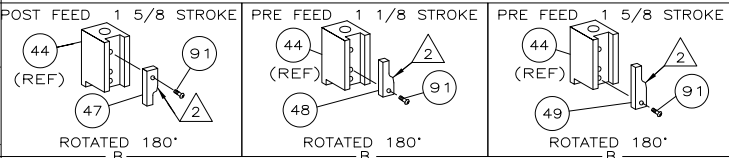
PART NUMBER	REV	FIRST USED
1852668-1	B	122500-1
1852668-2	B	565435-5
1852668-3	B	354500-1
7-1852668-7	A	354500-1



TERMINAL NAME: 4.2MM PE SERIES PIN & SOCKET 6			
SOCKET 794956	PAD LTR	TE CRIMP SPECS	
		CRIMP HEIGHT	WIRE SIZE
PIN 794955	A	.040 ±.002 [1.02 ±.05mm]	18
	B	.039 ±.002 [0.99 ±.05mm]	20
	C	.035 ±.002 [0.83 ±.05mm]	22
	D	.032 ±.002 [0.81 ±.05mm]	24
		CRIMP	SIZE
		TYPE	RANGE
	WIRE	.062 [1.57mm]	F
	INSUL	.125 [3.18mm]	F
WIRE STRIP LENGTH .118-.138		FEED .435	APPL INSTRUCTION 408-8040
TERM APPL SPEC 114-13172		SET UP GAGE 458637-1	LAYOUT L2015

-	2	2	2	-	5-354779-2	PIN, WIRE DISC (.3250)D	129
-	2	2	2	-	4-354779-6	PIN, WIRE DISC (.3220)C	128
-	2	2	2	-	3-354779-8	PIN, WIRE DISC (.3180)B	127
-	2	2	2	-	3-354779-6	PIN, WIRE DISC (.3170)A	126
-	1	1	1	-	986950-1	WASHER, FLAT PRECISION	125
-	1	1	1	-	217238-1	GENERAL INSTRUCTION PACKAGE	124
-	1	1	1	-	4088040	SF APPL INST 408-8040	123
-	1	1	1	-	4-21028-0	PIN,SLT SPR(Ø.093x.75)ST GDE PL	121
-	REF	REF	REF	-	1-21030-1	PIN,DOWEL(Ø.187x.50)LEVER	120
-	REF	REF	REF	-	1-21030-6	PIN,DOWEL(Ø.187x1.25)HOUSING	119
-	REF	REF	REF	-	21045-3	RING,RET "C"(Ø.187)FD FING PIN	118
-	1	2	1	-	21024-5	WASHER, LOCK(#10)ADJ BLOCK	117
-	REF	REF	REF	-	21024-5	WASHER,LOCK(#10)ADJ PLATE	116
-	REF	REF	REF	-	21024-5	WASHER,LOCK(#10)FEED GDE ROD	115
-	2	2	2	-	21024-2	WASHER,LOCK(#4)FRONT STP GUIDE	114
-	REF	REF	REF	-	5-21028-1	PIN,SLT SPR(Ø.125x.50)ADJ ROD	113
-	4	4	4	-	21024-4	WASHER,LOCK(#8)STRIPPER	111
-	REF	REF	REF	-	21899-4	WASHER,FLAT(Ø.6/16)SCREW ADJ	110
-	-	1	-	-	21899-2	WASHER, FLAT(Ø.10) LUB ASS'Y	109
-	1	1	1	-	21018-5	NUT,HEX(NO.6)HOLDDOWN	108
-	REF	REF	REF	-	21068-5	NUT,HEX(6-32)FEED ADJ	107
-	1	1	1	-	21009-2	SCR,SKT SET(1/4-20x.25 LW)RAM	103
-	2	2	2	-	21017-2	SCR,DRIVE(#2x.19)ID PLATE	102
-	REF	REF	REF	-	6-23715-5	SCR,PAN HD(6-32x1.50)FEED ADJ	101
-	1	1	1	-	461264-1	PLATE, IDENTIFICATION	100
-	2	2	2	-	5-21006-6	SCR,SET(10-32x.75)DRAG	99
-	1	1	1	-	22733-8	SCR,BHC(8-32x.38 LW)ANVIL	98
-	REF	REF	REF	-	2-21002-9	SCR,BHC(10-32x.75)CAP	97
-	REF	REF	REF	-	2-22733-8	SCR,BHC(1/4-20x.62)HOUSING	96
-	REF	REF	REF	-	2-21002-7	SCR,BHC(10-32x.50)SG ADJ BLOCK	95
-	6	6	6	-	2-21002-2	SCR,BHC(8-32x.50)TERM H DWN	94
-	1	1	1	-	1-21002-7	SCR,BHC(6-32x.38)CAM	91
-	1	1	1	-	2-22603-0	SCR,HEX HD(8-32x.31)FEED FINGER	86
-	2	2	2	-	1-21000-3	SCR,SHC(4-40x.25)FR ST GUIDE	85
-	3	3	3	-	2-21000-7	SCR,SHC(8-32x.50)STRIPPER	84
-	REF	REF	REF	-	3-21000-7	SCR,SHC(10-32x.75)FEED ROD GD	83
-	REF	REF	REF	-	3-21000-6	SCR,SHC(10-32x.62)FD ADJ BLK	82
-	1	2	1	-	3-21000-4	SCR,SHC(10-32x.38)SG ADJ BL	81
-	REF	REF	REF	-	3-21000-4	SCR,SHC(10-32x.38)PIVOT BLK	80
-	-	REF	-	-	455749-1	GUARD, WINDOW	79
-	REF	-	-	-	679532-1	INSERT, GUARD	78
-	-	1	-	-	1-465184-0	LUBRICATOR ASSY	77
-	1	1	1	-	690603-1	SPRING, ASSIST	74
-	1	1	1	-	23030-1	SCR,SHC(6-32x.25 SL)INS DISC	73
-	REF	REF	REF	-	458109-1	WASHER, SPECIAL	72
-	REF	REF	REF	-	690517-1	SPACER	71
-77	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY				PARTS LIST			

USED ON							
-	1	LEADMAKER	MECH POST FEED				
-	2	BENCH MODEL K	MECH PRE FEED				
-	3	BENCH MODEL G	MECH PRE FEED				
-	77	SPARE PARTS KIT	MECH PRE FEED				
-	REF	REF	REF	-	22594-8	NUT,HEX(1/2-20)	70
-	REF	REF	REF	-	240628-1	PLATE, ADJUSTMENT	69
-	REF	REF	REF	-	240626-1	SHAFT, PIVOT	68
-	REF	REF	REF	-	240633-1	BUSHING	67
-	REF	REF	REF	-	455680-1	LEVER, INTERMEDIATE	66
-	REF	REF	REF	-	240629-1	BLOCK, PIVOT	65
-	REF	REF	REF	-	240632-2	SCREW, ADJ FEED ROD	64
-	REF	REF	REF	-	240659-3	PIN, CAM ROLLER	63
-	REF	REF	REF	-	240658-1	ROLLER, CAM	62
-	REF	REF	REF	-	454398-2	ROD, FEED	61
-	REF	REF	REF	-	454178-1	GUIDE, FEED ROD	60
-	REF	REF	REF	-	454220-1	CAP, RAM	59
-	REF	REF	REF	-	454485-1	HOUSING	58
-	1	1	1	-	458537-2	PAWL, FEED	57
-	REF	REF	REF	-	240624-1	PIN, FEED FINGER	55
-	REF	REF	REF	-	691499-1	SPRING, FEED FINGER	54
-	REF	REF	REF	-	690541-1	HOLDER, FEED FINGER	53
-	REF	REF	REF	-	455679-1	LEVER, TERMINAL FEED ARM	52
-	1	1	1	-	811242-2	BUMPER, HOLDDOWN	51
-	1	1	1	-	690753-1	SPACER, TONKER	50
-	1	-	-	-	690602-6	CAM, PRE-FEED 1 5/8 ST	49
-	-	-	-	-	690602-5	CAM, PRE-FEED 1 1/8 ST	48
-	-	-	-	-	690501-4	CAM, POST-FEED 1 5/8 ST	47
-	1	1	1	-	459456-1	APPLICATOR, BASIC (SUBASSY)	46
-	1	1	1	-	690191-1	PLUG, NYLON	45
-	1	1	1	-	455673-1	RAM	44
-	1	1	1	-	690125-1	WASHER, LAMINATED	43
-	1	1	1	-	690124-1	WASHER, RAM	42
-	1	1	1	-	7-21002-9	BOLT, CRIMPER(5/16x1.00)	41
-	1	1	1	-	23241-6	BALL, STEEL	40
-	1	1	1	-	690170-1	SPRING, COMPRESSION	39
-	1	1	1	-	690142-1	DISC, INSULATION	38
-	1	1	1	-	354777-1	DISC, WIRE	37
-	1	1	1	-	22480-5	WASHER, SPRING	36
-	1	1	1	-	690212-1	POST, RAM	35
-	1	1	1	-	690786-3	SUPPORT, TERMINAL	34
-	REF	REF	REF	-	455675-1	PLATE, BASE	33
-	1	1	1	-	690432-3	SCREW, ADJUSTMENT	32
-	REF	REF	REF	-	455689-1	BLOCK, STRIP GUIDE ADJ	30
-	1	1	1	-	455671-1	PLATE, STRIP GUIDE	29
-	1	1	1	-	455888-7	SPACER, FRONT SHEAR DEP	28
-	2	2	2	-	1-22284-0	SPRING, DRAG	27
-	1	1	1	-	690546-1	LEVER, DRAG RELEASE	26
-	1	1	1	-	240792-1	DRAG, TERMINAL	25
-	1	1	1	-	6-690504-0	GUIDE, STRIP (REAR)	24
-	1	1	1	-	690438-1	GUIDE, STRIP (FRONT)	23
-	-	-	-	-	1-690472-4	STRIPPER	22
-	REF	REF	REF	-	4-22284-9	SPRING, FEED RETURN	21
-	1	1	-	-	690472-9	STRIPPER	19
-	1	1	-	-			18
-	1	1	-	-			17
-	1	1	1	-	318563-1	GUARD, CHIP, FRONT	16
-	1	1	-	-			15
-	1	1	-	-			14
-	1	1	1	-			13
-	1	1	1	-	3-22280-3	SPRING, SHEAR	12
-	1	1	1	-	690461-1	STOP, SHEAR	11
-	1	1	1	-	690459-1	HOLDER, SHEAR (FRONT)	10
-	1	1	1	-	462006-1	SHEAR, FLOAT (FRONT)	9
-	1	1	1	1	3-1633107-9	ANVIL	8
-	1	1	1	-			7
-	1	1	1	-			6
-	1	1	1	-	1-455889-4	DEPRESSOR, SHEAR (FRONT)	5
-	1	1	1	-	1-238011-0	SPACER, BLOCK CRIMPER	4
-	1	1	1	-	679440-6	CRIMPER, INSULATION	3
-	1	1	1	1			2
-	1	1	1	1	9-657555-1	CRIMPER, WIRE	1
-77	-3	-2	-1	U/M	PART NO	DESCRIPTION	ITEM NO
QTY REQD PER ASSY				PARTS LIST			



- 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 TERMINAL LUBRICANT IS REQUIRED

B	ECR-09-016988	7-2009	MY	GB	ANGLES	-
P	LTR	REVISION RECORD	DATE	DWN	APVD	SURFACE TEXTURE

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
INCHES:			
0 PL	±		
1 PL	±		
2 PL	±		
3 PL	±		
4 PL	±		

DWN	B.HIGMAN	25AUG04	MATERIAL	-	HEAT TREAT	-
CHK	-	-	-	-	-	-
APVD	T.ELBIN	25AUG04	Tyco Electronics Corporation			
NAME	-	-	Harrisburg, PA 17105-3608			
SIDE FEED HDM APPLICATOR						
SCALE	SIZE	DRAWING NO	SHEET	OF	REV	
-	A1	1852668	1	1	B	

GUSTOMER ACCESSIBLE PRODUCTION DRAWING