

4

3

2

1


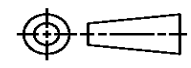
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| LOC | DIST | REVISIONS | | | |
|-----|------|---------------|-----------|-----|------|
| P | LTR | DESCRIPTION | DATE | DWN | APVD |
| | A1 | ECR-15-004848 | 27MAR2015 | GK | HMR |
| | | | | | |
| | | | | | |

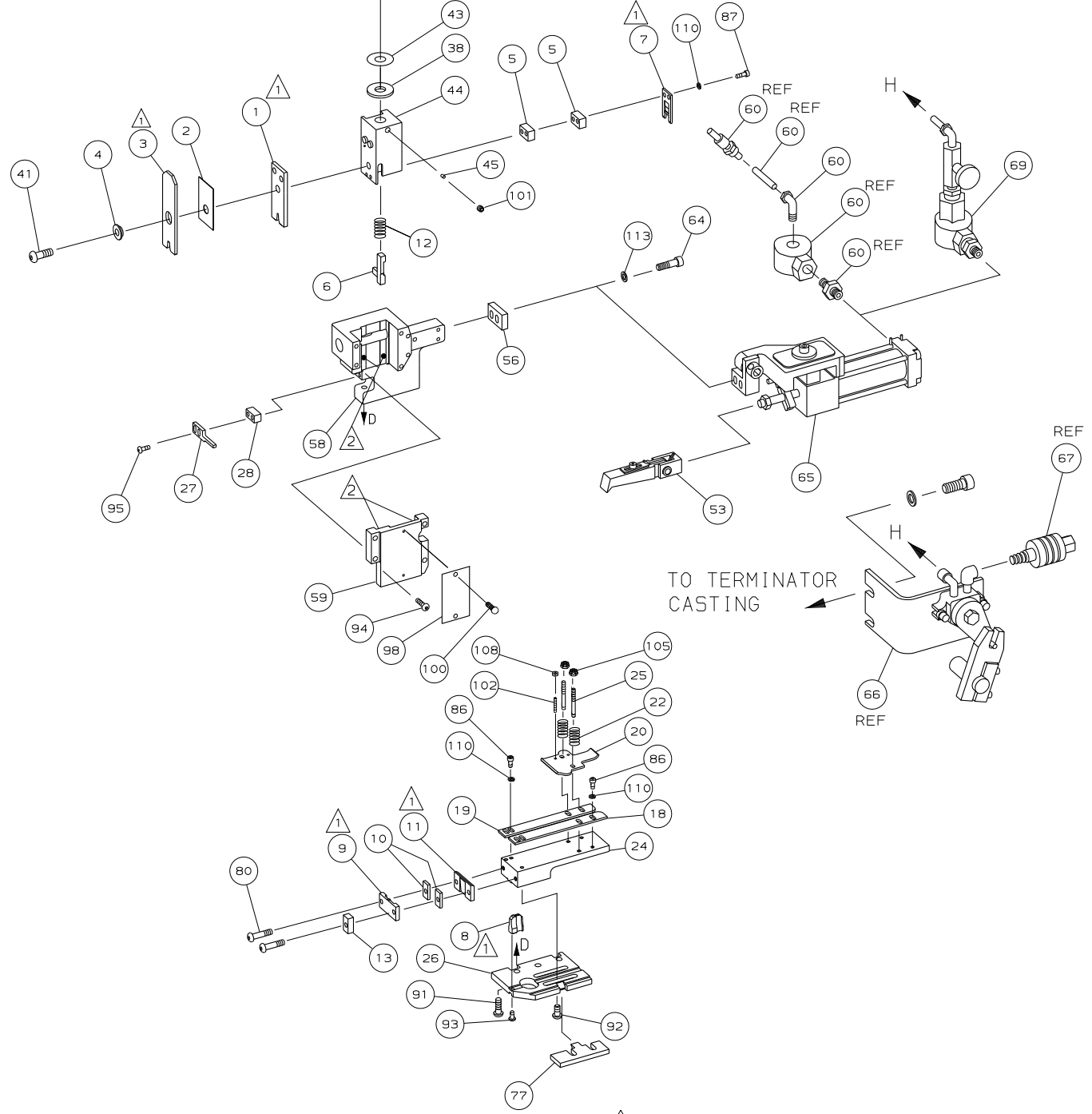
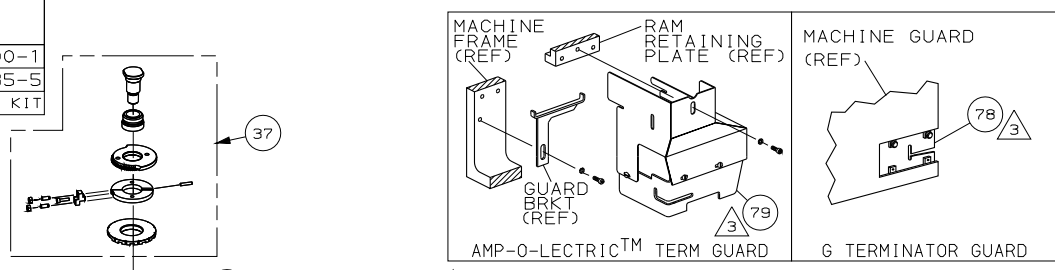
REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2150121-2

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 | | | |
| DIMENSIONS: | | CHK | RAGHAVENDRA | | | NAME | | | |
|  | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | APVD | FINE ADJUST END FD HDM APPL | | | | |
| | | 0 PLC ± | 1 PLC ± | RAGHAVENDRA | | PRODUCT SPEC | | | |
| MATERIAL | | 2 PLC ± | 3 PLC ± | APPLICATION SPEC | | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| FINISH | | 4 PLC ± | ANGLES ± | WEIGHT | | A3 | | ©- 1855053 | |
| | | | | CUSTOMER DRAWING | | SCALE | SHEET 1 OF 2 | REV A1 | |

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



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

TERMINAL NAME: RING

| CRIMP SETTING | CRIMP HEIGHT * | WIRE SIZE | |
|---------------|---------------------------|-----------|-----------|
| B1 | .106 ±.002 [2.69 ±0.05mm] | 14 | |
| C2 | .100 ±.002 [2.54 ±0.05mm] | 16 | |
| - | NOT | USED | |
| - | NOT | USED | |
| CRIMP WIRE | SIZE | TYPE | RANGE |
| INSUL | .210 [5.33mm] | 0 | .120-.180 |
| WIRE | .160 [4.06mm] | F | 16-14 |

| WIRE STRIP LENGTH | TERM APPL SPEC | FEED | APPL INSTRUCTION | SET UP GAGE | LAYOUT |
|-------------------|----------------|-------|------------------|-------------|--------|
| .172-.203 | 114-2084 | 1.370 | 408-8039 | 458638-1 | 918 |

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO | |
|-----|------|----------|-----|----------|-------------------|---|---------------|----|
| - | - | - | - | - | 61336 | REF SETTING | | |
| - | - | - | - | - | 61337 | REF SETTING | | |
| - | - | - | - | - | 640143 | REF SETTING | | |
| - | - | - | - | - | B1 | .106 ±.002 [2.69 ±0.05mm] | | |
| - | - | - | - | - | C2 | .100 ±.002 [2.54 ±0.05mm] | | |
| - | - | - | - | - | - | NOT | | |
| - | - | - | - | - | - | NOT | | |
| - | - | - | - | - | - | USED | | |
| - | - | - | - | - | - | USED | | |
| - | - | - | - | - | CRIMP WIRE | SIZE TYPE RANGE | | |
| - | - | - | - | - | INSUL | .210 [5.33mm] 0 .120-.180 | | |
| - | - | - | - | - | WIRE | .160 [4.06mm] F 16-14 | | |
| - | - | - | - | - | WIRE STRIP LENGTH | TERM APPL SPEC FEED APPL INSTRUCTION SET UP GAGE LAYOUT | | |
| - | - | - | - | - | .172-.203 | 114-2084 1.370 408-8039 458638-1 | 918 | |
| - | - | - | - | - | | | 129 | |
| - | - | - | - | - | | | 128 | |
| - | - | - | - | - | | | 127 | |
| - | - | - | - | - | | | 126 | |
| - | - | - | - | - | | | 125 | |
| - | - | - | - | - | | | 124 | |
| - | - | - | - | - | 217238-1 | GENERAL INSTRUCTION PACKAGE | 124 | |
| - | - | - | - | - | 4088039 | EF APPL INST 408-8039 | 123 | |
| - | - | - | - | - | | | 122 | |
| - | - | - | - | - | | | 121 | |
| - | - | - | - | - | | | 120 | |
| - | - | - | - | - | | | 119 | |
| - | - | - | - | - | | | 118 | |
| - | - | - | - | - | | | 117 | |
| - | - | - | - | - | | | 116 | |
| - | - | - | - | - | | | 115 | |
| - | - | - | - | - | | | 114 | |
| - | - | - | - | - | 21024-5 | WASHER, LOCK (#10) AIR ASSY | 113 | |
| - | - | - | - | - | | | 112 | |
| - | - | - | - | - | | | 111 | |
| - | - | - | - | - | 21024-4 | WASHER, LOCK (NO. 8) SHEAR BL | 110 | |
| - | - | - | - | - | | | 109 | |
| - | - | - | - | - | 21018-4 | NUT, HEX (4-40) DRAG | 108 | |
| - | - | - | - | - | | | 107 | |
| - | - | - | - | - | | | 106 | |
| - | - | - | - | - | 21022-2 | NUT, HEX SL (8-32) DRAG STUD | 105 | |
| - | - | - | - | - | | | 104 | |
| - | - | - | - | - | | | 103 | |
| - | - | - | - | - | | | 102 | |
| - | - | - | - | - | 2-21006-6 | SCR, SKT SET (4-40x.62) DRAG | 102 | |
| - | - | - | - | - | 21009-2 | SCR, SKT SET (1/4-20x.25) RAM | 101 | |
| - | - | - | - | - | 21017-2 | SCR, DRIVE (#2x.19) ID PLATE | 100 | |
| - | - | - | - | - | | | 99 | |
| - | - | - | - | - | 461264-5 | PLATE, IDENTIFICATION | 98 | |
| - | - | - | - | - | | | 97 | |
| - | - | - | - | - | | | 96 | |
| - | - | - | - | - | 2-21002-2 | SCR, BHC (8-32x.50) STRIPPER | 95 | |
| - | - | - | - | - | 3-21002-0 | SCR, BHC (10-32x.88) CAP | 94 | |
| - | - | - | - | - | 22733-8 | SCR, BHC (8-32x.38 LW) ANVIL | 93 | |
| - | - | - | - | - | 3-21002-3 | SCR, BHC (1/4-20x.50) ST GD PL | 92 | |
| - | - | - | - | - | 2-22733-8 | SCR, BHC (1/4-20x.62) HSG | 91 | |
| - | - | - | - | - | | | 90 | |
| - | - | - | - | - | | | 89 | |
| - | - | - | - | - | | | 88 | |
| - | - | - | - | - | | | 87 | |
| - | - | - | - | - | 3-21000-1 | SCR, SHC (8-32x1.00) SLUG BLADE | 87 | |
| - | - | - | - | - | 2-21000-6 | SCR, SHC (8-32x.38) STRIP GUIDE | 86 | |
| - | - | - | - | - | | | 85 | |
| - | - | - | - | - | | | 84 | |
| - | - | - | - | - | | | 83 | |
| - | - | - | - | - | | | 82 | |
| - | - | - | - | - | | | 81 | |
| - | - | - | - | - | 3-21002-1 | SCR, BHC (10-32x1.00) SHEAR PL | 80 | |
| - | - | - | - | - | 455750-7 | GUARD ASSY | 79 | |
| - | - | - | - | - | REF | 679532-1 | INSERT, GUARD | 78 |
| - | - | - | - | - | 694427-1 | BRACKET, HOLD DOWN | 77 | |
| - | - | - | - | - | | | 76 | |
| - | - | - | - | - | | | 75 | |
| - | - | - | - | - | | | 74 | |
| - | - | - | - | - | | | 73 | |
| - | - | - | - | - | | | 72 | |
| - | - | - | - | - | | | 71 | |
| - | - | - | - | - | -77 | -2 -1 U/M | | |

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO | | | |
|-----|------|----------|-----|----------|--------------|---------------------------|--------------|--------------------------------|-----------------------|----|
| - | - | - | - | - | 1 | LEADMAKER & BENCH MODEL G | AIR FEED | | | |
| - | - | - | - | - | 2 | BENCH MODEL K | AIR FEED | | | |
| - | - | - | - | - | -77 | SPARE PARTS KIT | | | | |
| - | - | - | - | - | 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 | 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 | | | | |

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LOC A
DIST 66

AMP 1756 REV 3-92 8 20-APR-06 15:09:48 us014442 7

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |

REVISION OF EACH ASSY NO (WHEN BLANK, USE DWG REVISION)

| QTY | REQD | PER ASSY | U/M | DWG SIZE | PART NO | DESCRIPTION | ITEM NO |
|-----|------|----------|-----|----------|---------|-------------|---------|
| - | - | - | - | - | | | |