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LOC DIST

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A2	ECR-13-003195	20FEB2013	XZ	SX

# REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2151191-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1855034  
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  
1855034

Dimensioning and tolerancing per ASME Y14.5M-2009


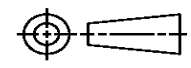
B

A

Dimensioning and tolerancing per ASME Y14.5M-2009

B

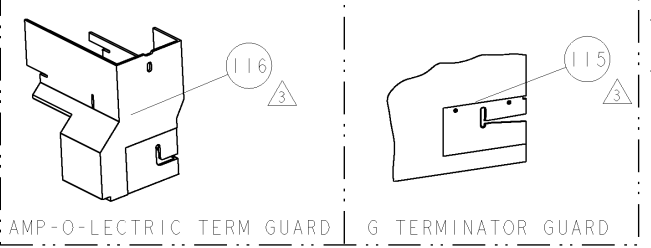
A

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN X. ZHAO	 TE Connectivity	
DIMENSIONS:		CHK S. XI		
		APVD S. XI	NAME SIDE FEED HDM APPLICATOR W/FINE ADJUST	
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		
MATERIAL		PRODUCT SPEC	SIZE A3	
FINISH		APPLICATION SPEC		
		WEIGHT	CAGE CODE	DRAWING NO C-1855034
			RESTRICTED TO	
			SCALE	SHEET 1 OF 2 REV A2

Dimensioning and tolerancing per ASME Y14.5M-2009

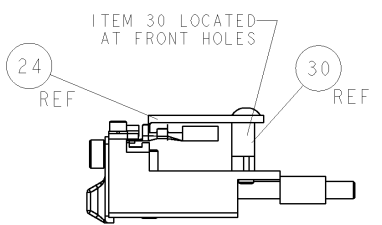
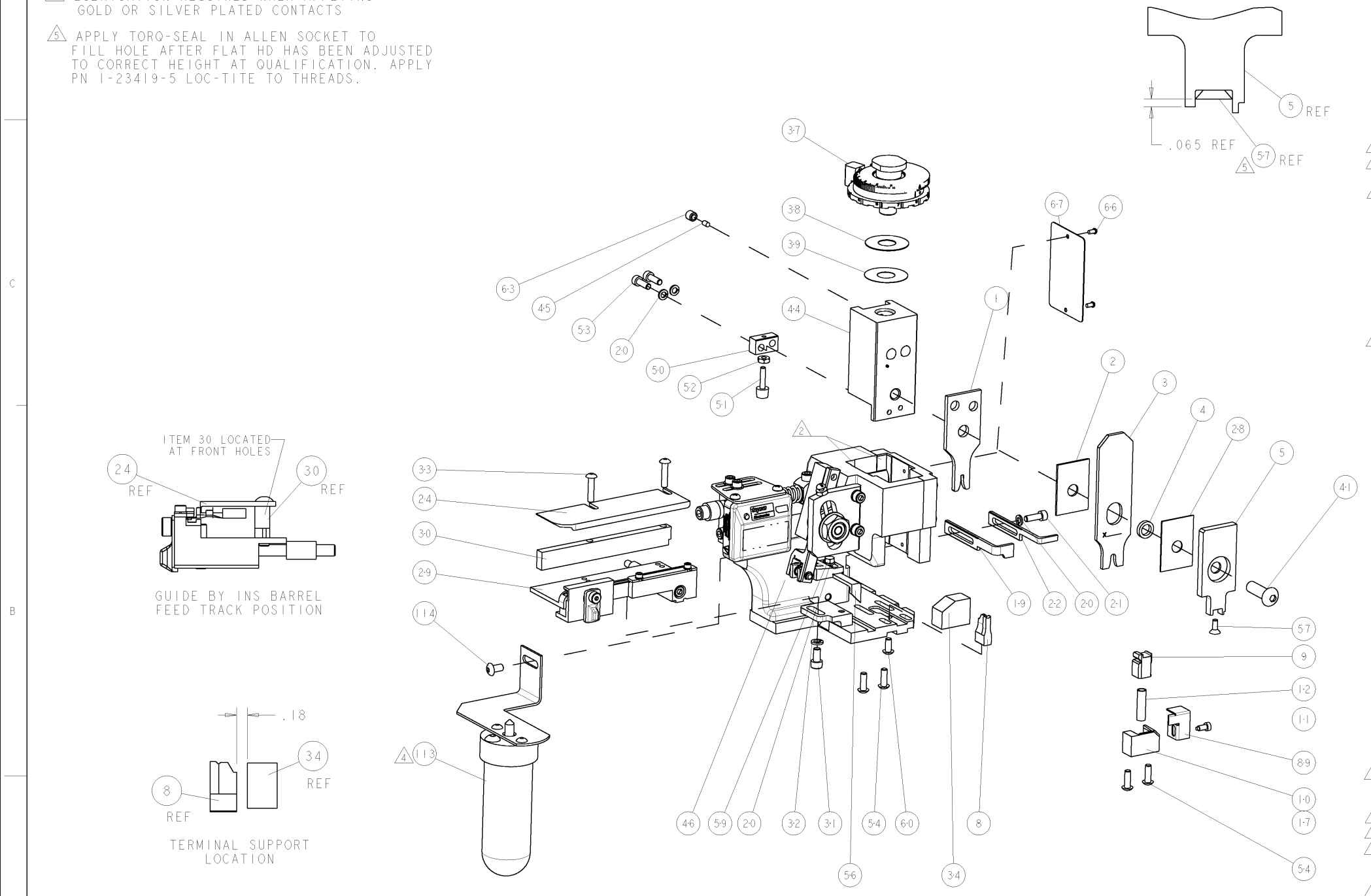
PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE	DESCRIPTION
1855034-1	A	122500-1	LEADMAKER	POST FEED	CUTS CARRIER
1855034-2	A	565435-5	BENCH MODEL K	PRE FEED	CUTS CARRIER
1855034-3	A	354500-1	BENCH MODEL G	PRE FEED	CUTS CARRIER
1855034-6	A	122500-1	LEADMAKER	POST FEED	CONTINUOUS CARRIER
7-1855034-7	A	-	-	-	SPARE PARTS

- ① RECOMMENDED SPARE PARTS
- ② GREASE LIGHTLY
- ③ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE
- ④ LUBRICATION REQUIRED WHEN APPLYING GOLD OR SILVER PLATED CONTACTS
- ⑤ APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY PN 1-23419-5 LOC-TITE TO THREADS.

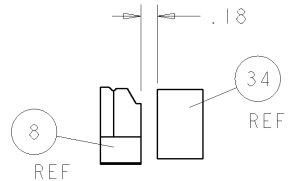


TERMINAL NAME: JUNIOR POWER TIMER CONTACT					
929939	-	-	AMP TERMINAL - AMP CRIMP SPECS		
963978	-	-			
927770	-	REF	CRIMP HEIGHT	WIRE SIZE	
-	-	B9	.054±.002[1.37±0.05mm]	1.0 mm <sup>2</sup>	
-	-	C6	.050±.002[1.27±0.05mm]	0.75 mm <sup>2</sup>	
-	-	D4	.046±.002[1.17±0.05mm]	0.5 mm <sup>2</sup>	
SEAL PN.			CRIMP	SIZE	TYPE RANGE
828904	-	-	WIRE	.080 [2.03mm]	F 0.5-1.0 mm <sup>2</sup>
828905	-	-	INSUL	.160 [4.06mm]	O ∅.134 MAX
WIRE STRIP LENGTH	TERM APPL SPEC	FEED	APPL INSTRUCTIONS	SET UP GAGE	
.165 - .180	114-18050	.551	408-8040	458637-1	

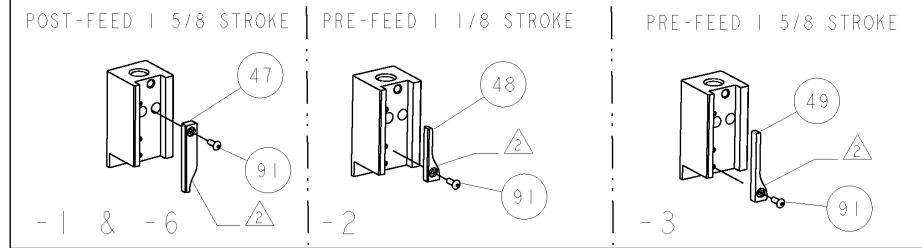
REVISIONS					
REV	DATE	BY	CHKD	APPD	DESCRIPTION
A	04APR2006	MEH	GB		RELEASED
A1	02MAR2008	MY	TE		ECR-08-007567



GUIDE BY INS BARREL FEED TRACK POSITION



TERMINAL SUPPORT LOCATION



③	-	-	REF	-	455749-1	GUARD WINDOW	116
③	-	-	REF	-	679532-1	INSERT, GUARD	115
-	-	-	-	-	2-21002-6	SCR, BTN SKT HD CAP 10-32 X .375	114
④	-	-	-	-	1-465184-0	LUBRICATOR ASSY	113
-	-	-	-	-	1-21002-7	SCR, BTN SKT HD CAP 6-32 X .375	91
-	-	-	-	-	318563-1	GUARD, FRONT CHIP	89
-	-	-	-	-	4088040	SF APPL INST 408-8040	72
-	-	-	-	-	217238-1	GENERAL INSTRUCTION PKG	71
-	-	-	-	-	461264-5	PLATE, IDENTIFICATION	67
-	2	2	2	2	21017-2	SCREW, DRIVE	66
-	-	-	-	-	21009-2	SCR, SET, SELF LOCKING 1/4-20 X .250	63
-	-	-	-	-	22733-8	SCR, BHSC, SELF-LOCKING, 8-32 X .375	60
-	-	-	-	-	2-22603-0	SCR, HEX HD CAP 8-32 X .312	59
⑤	-	-	-	-	1-21003-9	SCR, FLT SKT HD CAP 6-32 X .375	57
-	-	-	-	-	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
-	-	-	-	-	21018-5	NUT, HEX, 21018-5	52
-	-	-	-	-	811242-2	BUMPER, HOLD DOWN	51
-	-	-	-	-	690753-1	SPACER, TONKER	50
-	-	-	-	-	690602-6	CAM, PRE FEED, 1 5/8	49
-	-	-	-	-	690602-5	CAM, PRE FEED, 1 1/8	48
-	-	-	-	-	690501-4	CAM, POST FEED, 1 5/8	47
-	-	-	-	-	459456-1	APPL, BASIC SUB ASSY (SIDE WISE MOCA)	46
-	-	-	-	-	690191-1	PLUG, NYLON	45
-	-	-	-	-	455673-1	RAM, SIDE FEED	44
-	-	-	-	-	7-21002-9	SCR, BTN SKT HD CAP 5/16-24 X 1.00	41
-	-	-	-	-	690125-1	SHIM SUB-ASSY	39
-	-	-	-	-	469367-9	SHIM	38
-	-	-	-	-	879103-3	FINE ADJUST HEAD SUBASSY	37
-	-	-	-	-	690786-3	TERMINAL SUPPORT	34
-	2	2	2	2	2-21002-4	SCR, BTN SKT HD CAP 8-32 X .750	33
-	-	-	-	-	21024-5	WASHER, SPRG LOCK, REG NO 10	32
-	-	-	-	-	3-21000-4	SCR, SKT HD CAP 10-32 X .375	31
-	-	-	-	-	1320908-2	SPACER, STRIP GUIDE	30
-	-	-	-	-	1633091-3	ASSEMBLY, STRIP GUIDE	29
-	-	-	-	-	455888-6	SPACER, CRIMPER	28
-	-	-	-	-	1320928-1	PLATE, STRIP GUIDE	24
-	-	-	-	-	690472-2	STRIPPER	22
-	-	-	-	-	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	-	-	-	-	679625-3	SHEAR HOLDER, FRONT (NO CUT)	17
-	-	-	-	-	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	690461-2	STOP, SHEAR	11
①	-	-	-	-	1-690459-3	SHEAR HOLDER, FRONT	10
①	-	-	-	-	1-454276-1	FLOATING SHEAR, FRONT	9
①	-	-	-	-	9-854014-0	ANVIL, COMBINATION	8
-	-	-	-	-	318701-1	DEPRESSOR, SHEAR	5
-	-	-	-	-	3-238011-3	BLOCK, CRIMPER SPACER	4
①	-	-	-	-	8-683454-9	CRIMPER, INSULATION O	3
-	-	-	-	-	1-455888-1	SPACER, CRIMPER	2
①	-	-	-	-	1-456405-5	CRIMPER, WIRE PREMIUM	1

DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWN: R.O. WILSON		DATE: 16MAR2006		DESIGNED: R.O. WILSON		DATE: 17MAR2006		CHECKED: J. ELRIN		DATE: 17MAR2006	
0 PLC	±	1 PLC	±0.1	TITACO				Tyco Electronics				Harrisburg, PA 17105-3608			
2 PLC	±0.01	3 PLC	±0.001	PRODUCT SPEC				SIDE FEED HDM APPLICATOR				W/FINE ADJUST			
4 PLC	±0.0001	MATERIAL:				WEIGHT:				RESTRICTED TO:					
FINISH:				CUSTOMER DRAWING				SCALE: 3:5				SHEET 1 OF 1			