

4

3

2

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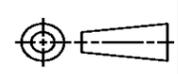
| LOC | DIST | REVISIONS     |           |     |      |
|-----|------|---------------|-----------|-----|------|
| P   | LTR  | DESCRIPTION   | DATE      | DWN | APVD |
|     | A1   | ECR-15-004848 | 27MAR2015 | GK  | HMR  |
|     |      |               |           |     |      |
|     |      |      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

# REPLACED BY OCEAN STYLE APPLICATOR PART NUMBER 2150524-2

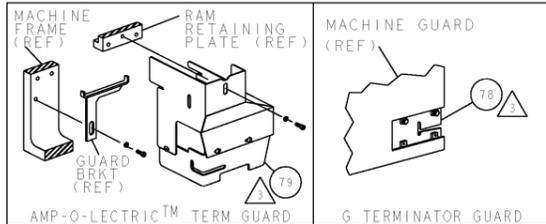
FOR REPLACEMENT PARTS FOR APPLICATOR 1855180  
REFER TO ADDITIONAL PAGE(S). SPARE PARTS KIT (IF LISTED)  
WILL REMAIN AVAILABLE.

THE REPLACEMENT OCEAN STYLE APPLICATOR HAS THE  
SAME TERMINATOR/PRESS INTERFACE AS APPLICATOR  
1855180

|  |   |                  |                         |              |            |       |   |       |   |       |   |        |   |              |      |  |  |
|--|---|------------------|-------------------------|--------------|------------|-------|---|-------|---|-------|---|--------|---|--------------|------|--|--|
| THIS DRAWING IS A CONTROLLED DOCUMENT.   |   | DWN              | GOPALAKRISHNA HV        |              |            |       |   |       |   |       |   |        |   |              |      |  |  |
| DIMENSIONS:  |   | CHK              | RAGHAVENDRA             |              |            |       |   |       |   |       |   |        |   |              |      |  |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:   |   | APVD             | RAGHAVENDRA             |              |            |       |   |       |   |       |   |        |   |              |      |  |  |
| <table border="0"> <tr><td>0 PLC</td><td>±</td></tr> <tr><td>1 PLC</td><td>±</td></tr> <tr><td>2 PLC</td><td>±</td></tr> <tr><td>3 PLC</td><td>±</td></tr> <tr><td>4 PLC</td><td>±</td></tr> <tr><td>ANGLES</td><td>±</td></tr> </table> |   | 0 PLC            | ±                       | 1 PLC        | ±          | 2 PLC | ± | 3 PLC | ± | 4 PLC | ± | ANGLES | ± | PRODUCT SPEC | NAME |  |  |
| 0 PLC  | ± |                  |                         |              |            |       |   |       |   |       |   |        |   |              |      |  |  |
| 1 PLC  | ± |                  |                         |              |            |       |   |       |   |       |   |        |   |              |      |  |  |
| 2 PLC  | ± |                  |                         |              |            |       |   |       |   |       |   |        |   |              |      |  |  |
| 3 PLC  | ± |                  |                         |              |            |       |   |       |   |       |   |        |   |              |      |  |  |
| 4 PLC  | ± |                  |                         |              |            |       |   |       |   |       |   |        |   |              |      |  |  |
| ANGLES   | ± |                  |                         |              |            |       |   |       |   |       |   |        |   |              |      |  |  |
| MATERIAL   |   | APPLICATION SPEC | END FEED HDM APPLICATOR |              |            |       |   |       |   |       |   |        |   |              |      |  |  |
| FINISH   |   | WEIGHT           | SIZE                    | CAGE CODE    | DRAWING NO |       |   |       |   |       |   |        |   |              |      |  |  |
|  |   |                  | A3                      |              | ©- 1855180 |       |   |       |   |       |   |        |   |              |      |  |  |
|  |   | CUSTOMER DRAWING | SCALE                   | SHEET 1 OF 2 | REV A1     |       |   |       |   |       |   |        |   |              |      |  |  |



| 8   |     | 7          |                           | 6         |  | 5 |  | 4 |  | 3 |  | 2 |  | 1 |  |
|---|-----|------------|---------------------------|-----------|--|---|--|---|--|---|--|---|--|---|--|
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| PART NUMBER   | REV | FIRST USED | POWER UNIT                | FEED TYPE |  |   |  |   |  |   |  |   |  |   |  |
| 1855180-1   | A   | 122500-1   | LEADMAKER & BENCH MODEL G | AIR FEED  |  |   |  |   |  |   |  |   |  |   |  |
| 1855180-2   | A   | 565435-5   | BENCH MODEL K             | AIR FEED  |  |   |  |   |  |   |  |   |  |   |  |
| 7-1855180-7   | A   | -          | SPARE PARTS               | -         |  |   |  |   |  |   |  |   |  |   |  |

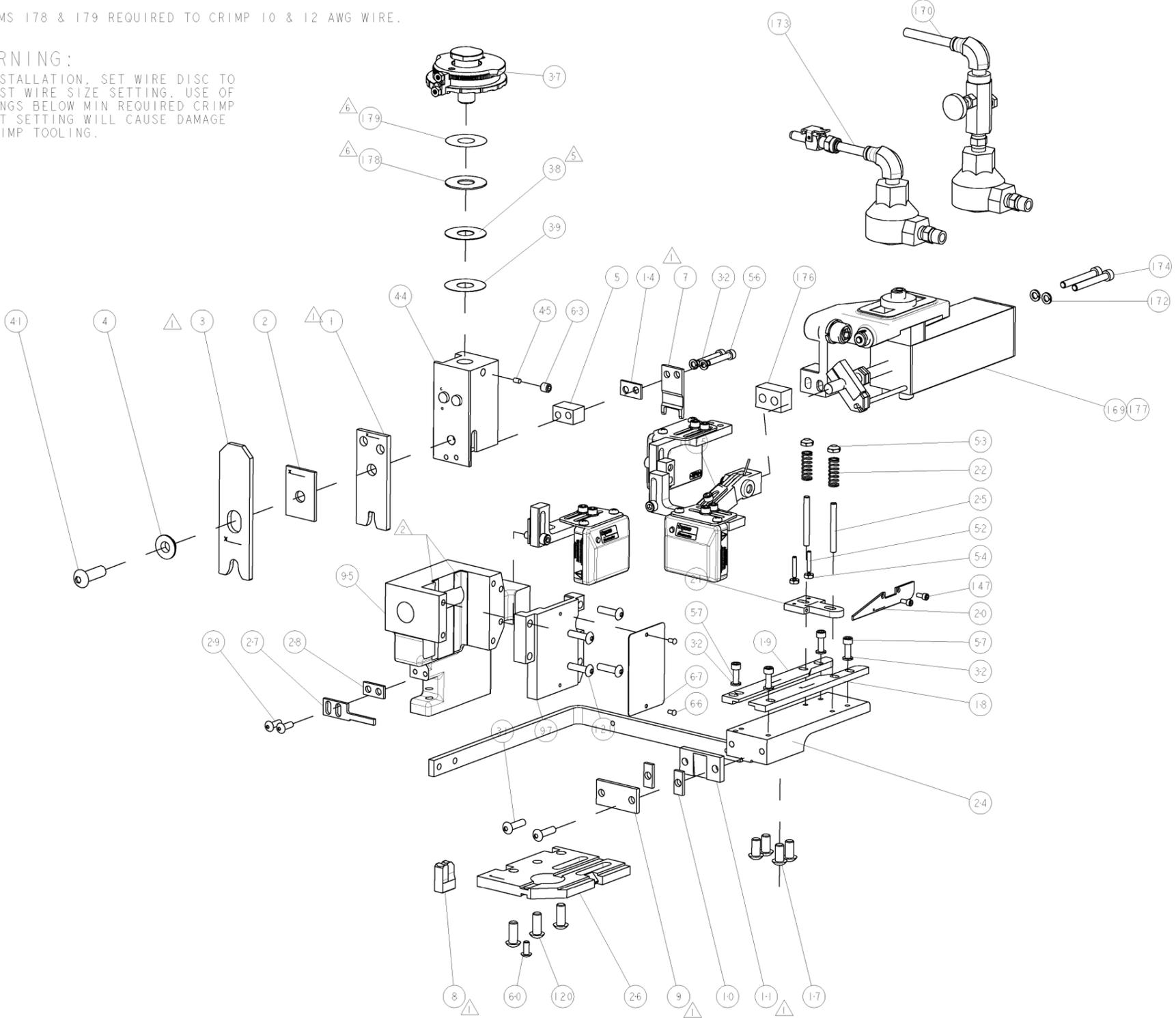


| TERMINAL NAME: RING TONGUE      |                         |                        |                                |                             |
|---------------------------------|-------------------------|------------------------|--------------------------------|-----------------------------|
| 42946                           | -                       | -                      | AMP TERMINAL - AMP CRIMP SPECS |                             |
| 42947                           | -                       | -                      | AMP TERMINAL - AMP CRIMP SPECS |                             |
| 61288                           | -                       | -                      | CRIMP HEIGHT                   | WIRE SIZE REF SETTING*      |
| 61289                           | -                       | .159±.002[4.04±0.05mm] | 8 AWG                          | B 5                         |
| 61290                           | -                       | .139±.002[3.53±0.05mm] | 10 AWG                         | B 3                         |
| 640012                          | -                       | .127±.002[3.23±0.05mm] | 12 AWG                         | D 8                         |
| 640014                          | -                       | -                      | -                              | -                           |
| -                               | -                       | -                      | CRIMP                          | SIZE TYPE RANGE             |
| -                               | -                       | -                      | WIRE                           | .210 [5.33mm] F 12-8 AWG    |
| -                               | -                       | -                      | INSUL                          | .300 [7.62mm] O .191 - .220 |
| WIRE STRIP LENGTH SEE APPL SPEC | TERM APPL SPEC 114-2084 | FEED 1.370             | APPL INSTRUCTIONS 408-8039     | SET UP GAUGE 458638-1       |

| LOC | REV | DESCRIPTION       | DATE      | BY  | APPV |
|-----|-----|-------------------|-----------|-----|------|
| A   | 66  | SEE ECO-07-005361 | 07MAR2007 | LJL | MC   |

- △ RECOMMENDED SPARE PARTS
- △ GREASE LIGHTLY
- △ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE.
- △ 8 AWG WIRE SUBJECT TO ENGINEERING APPROVAL.
- △ ITEMS 38 & 39 REQUIRED TO CRIMP 8 AWG WIRE.
- △ ITEMS 178 & 179 REQUIRED TO CRIMP 10 & 12 AWG WIRE.

**\*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.



| QTY | DESCRIPTION                            | ITEM NO |
|-----|--|---------|
| 1   | SHIM                                   | 179     |
| 1   | SHIM                                   | 178     |
| 1   | AIR FEED ASSY                          | 177     |
| 1   | SPACER, AIR FEED                       | 176     |
| 1   | FEED FINGER ASSEMBLY                   | 175     |
| 2   | SCR, SKT HD CAP 10-32 X 1.500          | 174     |
| 1   | AIR FEED VALVE ASSEMBLY                | 173     |
| 2   | WASHER, SPRG LOCK, REG NO 10           | 172     |
| 1   | AIR FEED VALVE ASSEMBLY                | 170     |
| 1   | AIR FEED ASSY                          | 169     |
| 2   | SCR, SKT HD CAP 4-40 X .250            | 147     |
| 4   | SCR, BTN SKT HD CAP 10-32 X .750       | 121     |
| 3   | SCR, BHSC, SELF-LOCKING, 1/4-20 X .625 | 120     |
| 1   | CAP, RAM                               | 97      |
| 1   | HOUSING, APPLICATOR                    | 95      |
| REF | GUARD WINDOW                           | 79      |
| REF | INSERT, GUARD                          | 78      |
| 1   | GENERAL INSTRUCTION PKG                | 72      |
| 1   | EF APPL INST 408-8039                  | 71      |
| 1   | PLATE, IDENTIFICATION                  | 67      |
| 2   | SCREW, DRIVE                           | 66      |
| 1   | SCR, SET, SELF LOCKING 1/4-20 X .250   | 63      |
| 1   | SCR, BHSC, SELF-LOCKING, 8-32 X .375   | 60      |
| 4   | SCR, SKT HD CAP 8-32 X .500            | 57      |
| 2   | SCR, SKT HD CAP 8-32 X 1.000           | 56      |
| 2   | NUT, HEX, REG 4-40                     | 54      |
| 2   | NUT, LOCK, HEX, TORQUE, 8-32           | 53      |
| 2   | SCR, SET, CUP POINT 4-40 X .625        | 52      |
| 1   | PLUG, NYLON                            | 45      |
| 1   | RAM                                    | 44      |
| 1   | SCR, BTN SKT HD CAP 5/16-24 X 1.00     | 41      |
| 1   | SHIM SUB-ASSY                          | 39      |
| 1   | SHIM                                   | 38      |
| 1   | FINE ADJUST HEAD SUBASSY               | 37      |
| 6   | WASHER, SPRG LOCK, REG NO 8            | 32      |
| 2   | SCR, BTN SKT HD CAP 10-32 X .750       | 31      |
| 2   | SCR, BTN SKT HD CAP 8-32 X .500        | 29      |
| 1   | SPACER, STRIPPER                       | 28      |
| 1   | STRIPPER, FRONT CASTING                | 27      |
| 1   | PLATE, BASE                            | 26      |
| 2   | STUD, THREADED                         | 25      |
| 1   | PLATE, STRIP GUIDE                     | 24      |
| 2   | SPRING, COMPRESSION                    | 22      |
| 1   | ARM, STOCK DRAG                        | 21      |
| 1   | DRAG, STOCK                            | 20      |
| 1   | STRIP GUIDE, REAR                      | 19      |
| 1   | STRIP GUIDE, FRONT                     | 18      |
| 4   | SCR, BTN SKT HD CAP 1/4-20 X .500      | 17      |
| 1   | SPACER                                 | 14      |
| 1   | PLATE, REAR SHEAR                      | 11      |
| 2   | SPACER, SHEAR PLATE                    | 10      |
| 1   | PLATE, FRONT SHEAR                     | 9       |
| 1   | ANVIL, COMBINATION                     | 8       |
| 1   | BLADE, SLUG                            | 7       |
| 1   | SPACER                                 | 5       |
| 1   | BLOCK, FL CRIMPER SPACER               | 4       |
| 1   | CRIMPER, INSULATION O                  | 3       |
| 1   | SPACER, CRIMPER                        | 2       |
| 1   | CRIMPER, WIRE                          | 1       |

|                    |            |  |            |                 |             |                  |       |   |                  |
|--------------------|------------|--|------------|-----------------|-------------|------------------|-------|---|------------------|
| DIMENSIONS: INCHES |            | TOLERANCES UNLESS OTHERWISE SPECIFIED: |            | DWG: J2FEB2007  |             | APV: M. CLEFFORD |       | NAME: END FEED HDM APPLICATOR               |                  |
| Ø                  | 8 PLC ±.01 | 1 PLC ±.01                             | 2 PLC ±.01 | 3 PLC ±.001     | 4 PLC ±.001 | ANGLES           | ±.001 | SIZE: A                                     | CASE CODE: 00779 |
| MATERIAL: -        |            | FINISH: -                              |            | WEIGHT: -       |             | SCALE: 3:5       |       | SHEET 1 OF 1                                |                  |
| CUSTOMER DRAWING   |            | CUSTOMER VIEWABLE ASSEMBLY             |            | DATE: 12FEB2007 |             | BY: J. LOFTHOUSE |       | Tyco Electronics, Harrisburg, PA 17105-3688 |                  |