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LOC

DIST


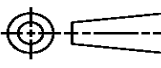
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	A1	ECR-14-003326	11MAR2014	GK	HMR

REPLACED BY OCEAN STYLE APPLICATOR PART
NUMBER 2266160-1

FOR REPLACEMENT PARTS FOR APPLICATOR 1855094
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
1855094

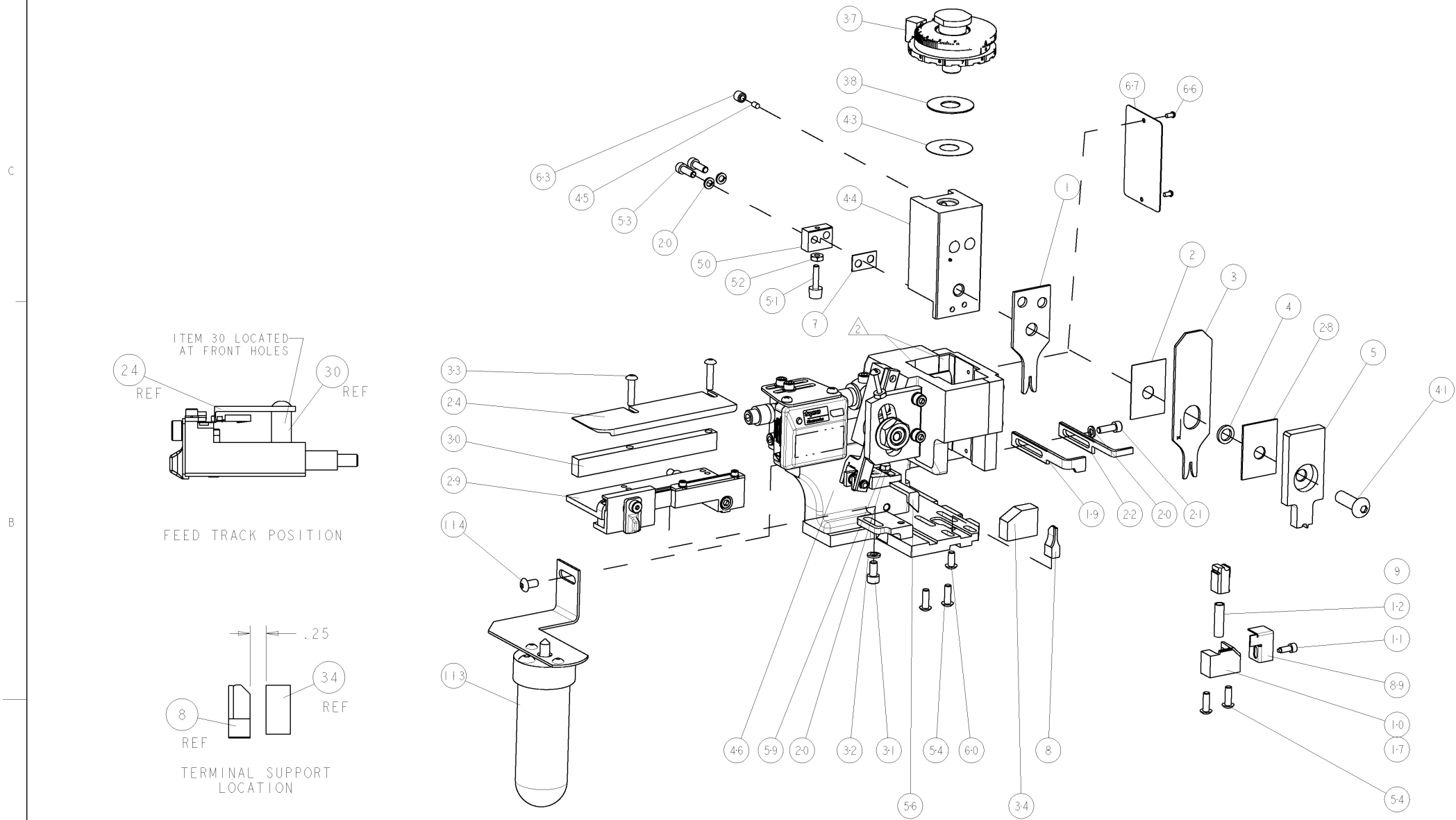
THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	GOPALAKRISHNA HV		 TE Connectivity	
		CHK	RAGHAVENDRA			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	RAGHAVENDRA	
		0 PLC ±		NAME SIDE FEED HDM APPLICATOR FINE ADJUST		
		1 PLC ±				
		2 PLC ±				
		3 PLC ±				
4 PLC ±		4 PLC ±		SIZE A 3		
ANGLES ±		FINISH				
MATERIAL				RESTRICTED TO		
				CUSTOMER DRAWING		
				SHEET 1 OF 2		

6	5
<p>AMP-O-ELECTRIC TERM GUARD</p>	<p>G TERMINATOR GUARD</p>

TERMINAL NAME: TERMINAL, IPDB CONTACT						
TYCO PN	MFG PN	SAMTEC TERMINAL - SAMTEC CRIMP SPECS				
1572571	CC69R-2024-01-X-XX					
-	-	REF SETTING	CRIMP HEIGHT			WIRE SIZE
-	-	B8	.041±.002 [1.04±0.05mm]			20 AWG
-	-	C2	.039±.002 [1.99±0.05mm]			22 AWG
-	-	C6	.037±.002 [1.94±0.05mm]			24 AWG
-	-	-				-
-	-	CRIMP	SIZE	TYPE	RANGE	
-	-					
-	-	WIRE	.055 [1.40mm]	F	24-20 AWG	
-	-	INSUL	.070 [1.78mm]	F	Ø.035-.070	
WIRE STRIP LENGTH 1.105-.135	TERM APPL SPEC NONE	FEED 4.25	APPL INSTRUCTIONS 408-8040		SET UP GAGE 458637-	

[illegible]


- ① RECOMMENDED SPARE PARTS
- ② GREASE LIGHTLY
- ③ GUARD MUST BE IN PLACE WHEN OPERATING APPLICATOR IN A BENCH MACHINE



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
-	-	-	-	-	-	...	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
-	-	-	-	-	-	-	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
-	-	-	-	-	-	-	458537-2	PAWL, FEED	56
-	-	-	-	-	-	-	2-21002-2	SCR, BTN SKT HD CAP 8-32 X .500	54
-	-	-	-	-	-	-	2-21000-7	SCR, SKT HD CAP 8-32 X .500	53
-	-	-	-	-	-	-	21018-5	NUT, HEX, REG 6-32	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
-	-	-	-	-	-	-	690125-1	SHIM SUB-ASSY	43
-	-	-	-	-	-	-	7-21002-9	SCR, BTN SKT HD CAP 5/16-24 X 1.00	41
-	-	-	-	-	-	-	469367-8	SHIM	38
-	-	-	-	-	-	-	879103-3	FINE ADJUST HEAD SUBASSY	37
-	-	-	-	-	-	-	690786-1	TERMINAL SUPPORT	34
-	-	-	-	-	-	-	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
-	-	-	-	-	-	-	1-1320908-5	SPACER, STRIP GUIDE	30
-	-	-	-	-	-	-	1633091-1	ASSEMBLY, STRIP GUIDE	29
-	-	-	-	-	-	-	1-455888-0	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
-	-	-	-	-	-	-	21024-4	WASHER, SPRG LOCK, REG NO 8	20
-	-	-	-	-	-	-	691353-1	STRIPPER	19
-	-	-	-	-	-	-	679625-1	SHEAR HOLDER, FRONT (NO CUT)	17
-	-	-	-	-	-	-	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	-	-	690461-1	STOP, SHEAR	11
-	-	-	-	-	-	-	690459-1	SHEAR HOLDER, FRONT	10
-	-	-	-	-	-	-	462006-2	FLOATING SHEAR, FRONT	9
-	-	-	-	-	-	-	1583502-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	2-240641-1	SPACER	7
-	-	-	-	-	-	-	2-455889-0	DEPRESSOR, SHEAR	5
-	-	-	-	-	-	-	238011-6	BLOCK, CRIMPER SPACER	4
-	-	-	-	-	-	-	3-683453-3	CRIMPER, INSULATION PREMIUM	3
-	-	-	-	-	-	-	455888-3	SPACER, CRIMPER	2
-	-	-	-	-	-	-	2-456402-4	CRIMPER, WIRE PREMIUM	1
-77	-6	-3	-2	-1	U/M	PART NO	DESCRIPTION		ITEM NO

	POST-FEED 5/8 STROKE	PRE-FEED 1/8 STROKE	PRE-FEED 5/8 STROKE
A	<p>- 1 & - 6</p>	<p>- 2</p>	<p>- 3</p>

* 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.

(THIS SPECIFICATION IS SUBJECT TO THE FOLLOWING CONDITIONS: DRAWINGS AND SPECIFICATIONS SHALL BE CONSIDERED TO TAKE PRECEDENCE OVER ANY OTHER DOCUMENTS OR INFORMATION.)		DWG. NO. ZOAPR2006 R. O. WILSON		tyco <i>Electronics</i> Tyco Electronics Harrisburg, PA 17105-3608	
DIMENSIONS TO: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED: 8 PLC $\pm .01$ 12 PLC $\pm .01$ 15 PLC $\pm .01$ 20 PLC $\pm .001$ 24 PLC $\pm .001$ ANGLE $\pm .01$		NAME TYCO THERM ZOAPR2006 PRODUCT SPEC APPLICATION SPEC	
		SIZE CASE CODE DRAWING NO A 00779 C=1855094		RESTRICTED TO -	
MATERIAL -		WEIGHT -		SCALE 3:5 SHEET 1 OF 1 REV A	
CUSTOMER DRAWING					

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[1855094-3](#)