

PART NUMBER	REV	FIRST USED	
1855530-1	E	122500-1	T-UNIT
1855530-2	D	680017-4	K-UNIT
1855530-3	E	354500-1	G-UNIT
1855530-4	D	122500-1	T-UNIT

SUPERSEDED BY 1855530-1  
 SUPERSEDED BY 1855530-1  
 OBSOLETE

REVISIONS					
P	LTR	DESCRIPTION	DATE	DN	APVO
E2	REVISED PER	ECR-23-189986	18OCT2023	GK	TE

- 1 RECOMMENDED SPARE PARTS
- 2 ITEMS NOT SHOWN
- 3 TOL ±.25
- 5 USE SEALANT PN 1-23419-5 AS SHOWN
- 7 AFTER QUALIFICATION, DRILL AND PIN ITEM 2 TO ITEM 1 USING ITEM 172, 2 PLACES. (-4 ONLY)
- 8 ITEM 69 TO BE ATTACHED TO ITEM 65 USING HOLES AS SHOWN IN VIEW B-B.
- 9 CANNOT RUN 2 WIRES ON LEADMAKER.
- 10. SPRING LOADED TONKER (P/N 354853-1) MUST BE USED WHEN RUNNING THE APPLICATOR ON A LEADMAKER.
- 11 PNEUMATIC ASSEMBLY AIR PRESSURE SHOULD BE SET TO 40-60 PSI

CRIMPING DATA				THIS APPLICATOR WILL APPLY
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	STRIP LENGTH	TERMINAL P/N
C3	1.42	#18		520988-1
C7	1.37	(2)#22/9		520988-2
D3	1.29	#20		520986-1
D7	1.24	#22		521368-1
CRIMP	SIZE TYPE	FEED		521368-2
WIRE	.090 F	.760		521084-2
INS.	.140 F			521753-1
INSULATION RANGE	WIRE RANGE			521753-2
.090-.130	22-18	AI 8095 & 8098		1969161-1
TERM APPL SPEC 114-2124				

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
			181
			180
			179
			178
1	1	217238-1	DOCUMENTATION PKG
			177
			176
2	2	21026-4	WASHER, STAR
		90647-1	COVER, MODIFIED
			175
			174
			173
2		21029-5	PIN, SLOTTED SPRING
2	2	21017-2	SCR., DRIVE 2 X .19
1	1	461264-5	TAG, IDENTIFICATION
		22307-1	BUSHING, PIPE FITTING
		28582-1	LUBRICATOR
		22311-2	NIPPLE
		28580-1	FILTER, MINATURE
		23791-2	TEE, FEMALE BRANCH
			165
			164
			163
			162
		26108-1	BODY,QUICK CONNECT
1	1	19832-1	TIE,WIRE
			160
			159
			158
2	2	4-21000-3	SHCS, 10-32 X 2.00
2	2	21024-5	WASHER, LOCK, #10
			157
			156
			155
68	68	27319-4	TUBING,NYLON .250 DIA
2	2	23238-1	INSERT,COUPLING
			154
			153
			152
		455755-8	GUARD ASS'Y
	REF	679532-1	INSERT, GUARD
1	1	1-21018-6	NUT, HEX, 5/16-24
			150
			149
			148
			147
			146
1	1	21007-8	SCR,SOC,SET (1/4-20X.63)
1	1	459610-3	MOUNT,FEED BRACKET
			145
			144
			143
			142
			141
QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
			140
			139
			138
1	1	879103-2	FINE ADJUST HEAD ASSY
			137
			136
1	1	469367-8	WASHER, RAM
		690125-1	WASHER,LAMINATED
1	1	21009-2	SCR,SOC SET 1/4-20 X .25 LG
1	1	690191-1	PLUG,NYLON
1	1	461690-1	SPACER
			131
			130
		692655-1	VALVE ASSY
4	4	2-21002-9	SCR. BUT HD 10-32 X .75
2	2	3-21000-6	SCR. SOC HD 10-32 X .62
1	1	852224-1	FINGER,FEED
1	1	461062-6	FEED FINGER ASSY
1	1	3-21001-4	SCREW, SOC HD CP 3/8-16 X .88 LG
1	1	852289-1	AIR FEED ASSY
1	1	21024-8	WASHER, LOCK, .38
2	2	1-23030-2	SCR., SOC.HD. 8-32X.75 LOK-WEL
			122
			121
2	2	852253-1	BLADE,SLUG
1	1		118
			117
			116
			115
			114
			113
			112
			111
			110
			109
			108
			107
			106
			105
			104
			103
1	1	1-455888-5	SPACER, CRIMPER
2	2	3-21000-5	SCR. SOC HD 10-32 X .50
		454220-1	CAP, RAM
1	1	6-456406-6	CRIMPER, WIRE
1	1	4-683453-4	CRIMPER,INS "F"
1	1	238009-8	BLOCK, CRIMPER SPACER
1	1	1-455888-4	SPACER,CRIMPER
1	1	7-21002-7	SCR.,BUT. HD.5/16 UNF-24 X .75
			95
			94
1	1	1-22183-7	PIN, GROOVE TYP 67 .125 DIA X .63
1	1	2-22286-2	SPRING, EXT. LE-031B-2
1	1	1-21919-1	PIN,DOWEL .094 DIA X .375
1	1	852281-2	ROLLER
1	1	354385-2	PNEUMATIC ASSY
1	1	852287-1	PLATE, RETAINER
1	1	852286-1	LATCH, INSERT
2	2	852521-1	PIN, DOWEL MOD. .094 DIA X .49
1	1	852284-1	ARM, LATCH
1	1	1-21030-7	PIN, DOWEL .188 DIA X 1.50
			84
			83
			82
			81
2	2	980282-3	CONNECTOR,MALE 1/8NPTX.25
			80
			79
3	3	980285-2	ELBOW,MALE,SWIVEL 1/8 X .25T
			78
			77
			76
			75
1	1	852247-1	SLIDE,STRIPPER
1	1	4-22279-9	SPRING, COMP. LC-026B-9
			74
			73
			72
5	5	1-21002-6	SCR,BUT HD CP 6-32 X .25
			71
QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO

QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO
			70
			69
			68
			67
			66
			65
			64
			63
			62
		1-23619-6	PIN,GROOVED .188 DIA
		852298-1	LINK
4	4	21045-3	CRESCENT RING
1	1	4-23619-0	PIN,GROOVED, .188 DIA
1	1	852296-1	CLEVIS
			56
5	5	6-21002-1	SCR.,BUT.HD. 10-24X.25
			55
			54
		852323-2	MOUNT,AIR CYL.
		852297-1	ARM,PIVOT
1	1	856544-2	ANVIL
1	1	985314-1	AIR CYL., 3/4 BORE X 7/16 ST.
1	1	852295-1	ROD,BACKUP
			48
			47
1	1	21021-4	NUT,FLEXLOC 10-32
1	1	852294-5	BACKUP,TERMINAL
1	1	852294-2	BACKUP,TERMINAL
3	3	21899-2	WASHER, FLAT
1	1	852294-3	BACKUP,TERMINAL
			42
			41
1	1	852250-3	GUIDE,FRONT STRIP
2	2	22354-7	STUD,8-32
1	1	852251-2	DRAG
2	2	2-22280-9	SPRING, COMP. LC-032C-6
2	2	21021-3	NUT,FLEXLOC 8-32
1	1	90594-1	GUIDE, REAR STRIP
4	4	1-21899-3	WASHER, FLAT #8
			33
1	1	90591-1	SHEAR, LEFT
			32
1	1	853981-1	SHEAR, RIGHT
			31
			29
2	2	2-21002-2	SCR., BUT.HD. 8-32X.50
1	1	856231-1	PLATE, STRIP GUIDE
			27
			26
			25
			24
			23
			22
4	4	23030-2	SCR. SOC.HD. 6-32X.38 LOK-WEL
			21
			20
			19
2	2	21026-3	WASHER, EXT LOCK #8
15	15	2-21002-1	SCR, BUT HD, 8-32 X .38
			18
			17
			16
			15
			14
1	1	354993-1	AIR CYL 1 1/8 BORE X 5/8 ST
			13
			12
1	1	5-21028-1	PIN, SPRING .125 DIA x .50
1	1	1-23470-7	SPRING, COMP. LC-035C-19
1	1	90777-1	GIB, HOUSING
1	1	318198-1	INSERTOR, POD
1	1	22733-8	SCR.,BUT.HD.8-32X.38
1	1	90775-1	HOUSING, INSERT SLIDE
			7
			6
			5
1	1	1338955-1	HOLDDOWN, SPRING
3	3	2-22733-8	SCR. BUT HD 1/4-20 X .62
1	1	314866-2	PLATE, BASE
			4
			3
1	1	852221-1	HOUSING, APPLICATOR
			1
QTY REQD PER ASSY	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DIN K. STAKEM 31JULY2009	CHK T. ELBIN 31JULY2009	APVD G. BAILEY 31JULY2009	NAME
0 PLC ± .010	1 PLC ± .005	TE Connectivity Ltd.			
2 PLC ± .005	3 PLC ± .003	ULTRA-POD APPLICATOR .250 STRAIGHT			
4 PLC ± .002	ANGLES ± .005	APPLICATION SPEC			
MATERIAL	FINISH	WEIGHT	SIZE	CAGE CODE	DRAWING NO
			A1	00779	1855530
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	SHEET	REV	E2
		1:1	1 of 2		

