

PART NUMBER	REV	FIRST USED	POWER UNIT	FEED TYPE
1855129-1	J	854400-1	LEADMAKER	MECH POST FEED
1855129-2	H	565435-5	BENCH MODEL K	MECH PRE FEED
1855129-3	G	354500-1	BENCH MODEL G	MECH PRE FEED
7-1855129-7	E	-	SPARE PARTS	-

SUPERSEDED BY 1855129-1
SUPERSEDED BY 1855129-1

- RECOMMENDED SPARE PARTS.
- GREASE LIGHTLY.
- LUBRICATE DAILY USING NO. 20 MACHINE OIL.
- DO NOT EXCEED 80 C.P.M. WITH THIS APPLICATOR.
- AFTER ASSEMBLY OF APPLICATOR, PROPER SPRING PRESSURE (ITEM 34) CAN BE OBTAINED BY TIGHTENING SET SCREW (ITEM 105) UNTIL CONTACT IS MADE WITH SPACER (ITEM 32) THEN TIGHTEN AN ADITIONAL 5 1/2 - 6 REVOLUTIONS.

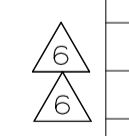


* WARNING: ON INSTALLATION, SET WIRE DISC TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MIN REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

- THIS APPLICATOR IS SETUP WITH A 1 5/8" OR 40 MM POST-FEED CAM. A 1 1/8" OR 30 MM PRE-FEED CAM AND 1 3/8" OR 40 MM PRE-FEED CAM ARE ALSO INCLUDED WITH THIS APPLICATOR. REFER TO THE CAM POSITIONS ON PAGE 2 FOR PROPER MOUNTING LOCATIONS.

TERMINAL NAME: .187 SERIES FLAG POS LOK-EX RECPT			
CRIMPING DATA			
REF SETTING	CRIMP HEIGHT	WIRE SIZE	
A6	.038 ±.002 [0.96 ±0.05mm]	16	
B0	.035 ±.002 [0.89 ±0.05mm]	18	
B2	.033 ±.002 [0.84 ±0.05mm]	20,22,OR 0.50mm ²	
B4	.035 ±.002 [0.89 ±0.05mm]	(2) 0.50mm ²	
CRIMP WIRE	SIZE	TYPE	RANGE
	.140 [3.56mm]		
INSUL	.140 [3.56mm]	0	φ.059 -.122
WIRE STRIP LENGTH	.165-.205	TERM APPL SPEC	114-5118
FEED	.567	APPL INSTRUCTION	408-8031
SET UP GAGE	-	LAYOUT	L1412 L1886

QTY REQD PER ASSY	REV	DESCRIPTION	ITEM NO					
1	1	129						
1	1	128						
1	1	127						
1	1	126						
1	1	125						
1	1	1-21030-2 PIN, DOWEL (φ1.87X.62)	124					
1	1	1-21030-6 PIN, DOWEL (φ1.87X1.25)	123					
1	1	122						
2	2	3-21028-2 PIN, SLOTTED SPRING (φ0.94X.25)	121					
2	2	4-21028-9 PIN, SLOTTED SPRING (φ1.25X.38)	120					
2	2	5-21028-1 PIN, SLOTTED SPRING (φ1.25X.50)	119					
1	1	21029-5 PIN, SLOTTED SPRING (φ1.88X.75)	118					
1	1	117						
1	1	21899-4 WASHER, FLAT	116					
4	4	21024-4 WASHER, LOCK (#8)	115					
1	1	114						
2	2	21899-2 WASHER, FLAT (#10)	113					
2	2	21024-5 WASHER, LOCK (#10)	112					
1	1	111						
1	1	110						
1	1	1-22202-7 NUT, HEX (5/16-24)	109					
1	1	21022-3 NUT, HEX (LOCKING)(10-32)	108					
1	1	21018-5 NUT, HEX (6-32)	107					
2	2	21045-3 RING, RET "C" (φ1.87) FD PIN	106					
1	1	8-21007-5 SCREW, SKT SET (5/16-24X.75)	105					
7	7	2-22733-8 SCREW, BHC (1/4-20X.63)	104					
1	1	103						
1	1	21009-2 SCREW, SKT SET (1/4-20X.25)	102					
1	1	1-21002-7 SCR, BHC (6-32X.38)	101					
1	1	3-21000-9 SCREW, SHC (10-32X1.00)	100					
4	4	3-21000-8 SCREW, SHC (10-32X.88)	99					
2	2	3-21000-6 SCREW, SHC (10-32X.62)	98					
1	1	3-21000-4 SCREW, SHC (10-32X.38)	97					
2	2	7-21000-6 SCREW, SHC (10-32X.38)	96					
1	1	95						
2	2	4-21006-0 SCREW, SKT SET (8-32X.25)	94					
1	1	21061-9 SCREW, SKT SET (8-32X.25)	93					
2	2	3-21000-0 SCREW, SHC (8-32X2.00)	92					
4	4	2-21000-9 SCREW, SHC (8-32X.75)	91					
2	2	1-23030-1 SCREW, SHC (NYLON)(8-32X.62)	90					
4	4	2-22603-3 SCREW, HEX HD (8-32X.62)	89					
2	2	2-21000-8 SCREW, SHC (8-32X.62)	88					
1	1	2-21002-1 SCREW, SBHC (8-32X.38)	87					
1	1	86						
1	1	6-23715-5 SCR, PAN HD(6-32X1.50) FEED ADJ	85					
1	1	84						
1	1	79						
1	1	REF - - - A 455745-1 GUARD, WINDOW	79					
1	1	REF - - - B 679532-1 INSERT, GUARD	78					
1	1	- - - B 694427-1 PLATE, MOUNTING	77					
2	2	2-21017-2 SCR, DRIVE (#2X.19) ID	76					
1	1	461264-5 PLATE, IDENTIFICATION	75					
1	1	74						
1	1	458109-1 WASHER, SPECIAL	72					
1	1	690517-1 SPACER	71					
-77	-3	-2	-1	U/M	DWG SIZE	PART NO	DESCRIPTION	ITEM NO



REVISIONS									
REV	DATE	DESCRIPTION	BY	CHK	APPV				
J	18OCT2023	REVISED PER ECR-23-189986	GK	TE					

QTY REQD PER ASSY	REV	DESCRIPTION	ITEM NO
1	1	22594-8 NUT, HEX	70
1	1	240628-1 PLATE, ADJ	69
1	1	240626-1 SHAFT, PIVOT	68
1	1	240633-1 BUSHING	67
1	1	240630-1 LEVER, INTERMEDIATE	66
1	1	1804317-1 BLOCK, PIVOT	65
1	1	1633286-1 SCR, ADJ	64
1	1	240659-3 PIN, CAM ROLLER	63
1	1	240658-1 ROLER, CAM	62
1	1	240631-1 ROD, FEED	61
1	1	2217626-1 CAP, RAM	59
1	1	2217625-1 HOUSING	58
1	1	57	
1	1	458361-1 GUIDE, FEED ROD	56
1	1	240624-1 PIN, FEED FINGER	55
1	1	691499-1 SPRING, FEED FINGER	54
1	1	454568-1 FINGER, FEED	53
1	1	240634-1 LEVER, TERMINAL	52
1	1	690696-1 CAM, PRE FEED 1 1/8 ST	51
1	1	2256119-1 SCREW, SHOULDER	50
1	1	3-21002-5 BOLT, CRIMPER	49
1	1	453991-1 CAM, PRE-FEED 1 5/8 ST	48
1	1	238015-1 CAM, POST-FEED 1 5/8 ST	47
1	1	690578-5 BLOCK, INSULATION ADJUST	46
1	1	690191-1 PLUG, NYLON	45
1	1	2217624-1 RAM	44
1	1	43	
1	1	42	
1	1	41	
1	1	40	
1	1	690125-1 SHIM SUBASSY	39
1	1	469367-6 SPACER, FINE ADJUST	38
1	1	879103-3 FINE ADJUST HEAD ASSY	37
1	1	36	
1	1	35	
1	1	3-23846-5 SPRING, HINGE BAR	34
1	1	33	
1	1	690573-1 SPACER, SPRING	32
1	1	454569-1 MOUNT, DRAG	31
1	1	1-22354-8 STUD, DRAG	30
1	1	21030-2 PIN, MOUNT, DRAG	29
1	1	690582-1 PIN, HINGE	28
1	1	27	
1	1	684905-1 PLATE, BASE	26
1	1	454579-2 HINGE BAR	25
1	1	690571-1 BLOCK, STABILIZER	24
1	1	690585-1 BLOCK, PRESSURE	23
1	1	22282-5 SPRING, DRAG	22
1	1	21030-6 LEVER, DRAG	21
1	1	454570-1 DRAG, STOCK	20
1	1	454573-1 GUIDE, STRIP (REAR)	19
1	1	318739-3 GUIDE, STRIP (FRONT)	18
1	1	17	
1	1	4-22284-6 SPRING, FEED RETURN	16
1	1	15	
1	1	14	
1	1	1-692134-7 POSITIONER, TERMINAL	13
1	1	5-22280-5 SPRING, TERM. POSITIONER	12
1	1	454712-6 PLATE, REAR SHEAR	11
1	1	454578-1 ANVIL INSERT	10
1	1	690569-3 PLATE, FRONT SHEAR	9
1	1	690718-1 ANVIL	8
1	1	454575-8 BLADE, SLUG	7
1	1	6	
1	1	684906-1 PLATE, ANVIL RETAINING	5
1	1	690574-1 SPACER, TUBULAR INSUL CRIMPER	4
1	1	918254-1 CRIMPER, INSULATION	3
1	1	2	
1	1	690716-3 CRIMPER, WIRE	1

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIN R.O.WILSON 10-23-06
CHK R.O.WILSON 10-23-06
APVD T.ELBIN 10-23-06

TE Connectivity Ltd.

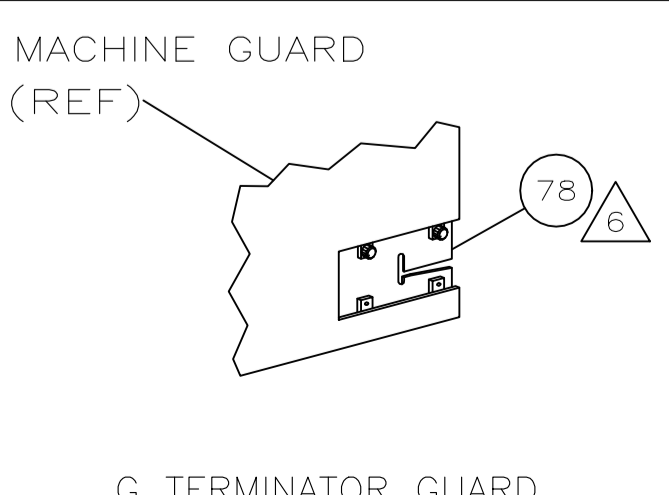
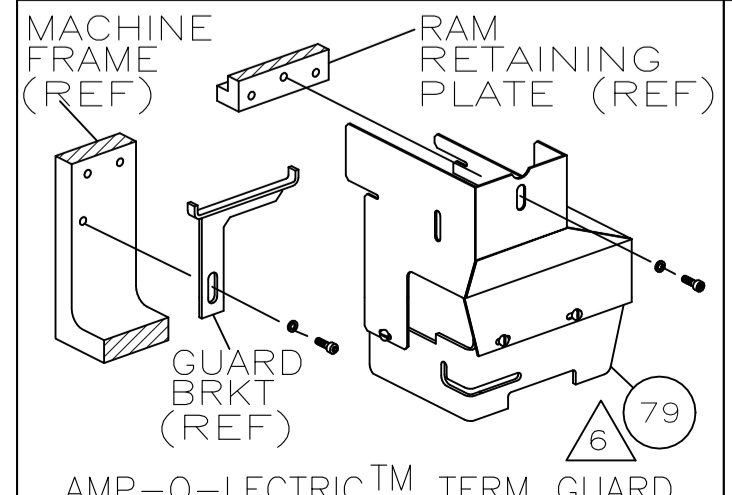
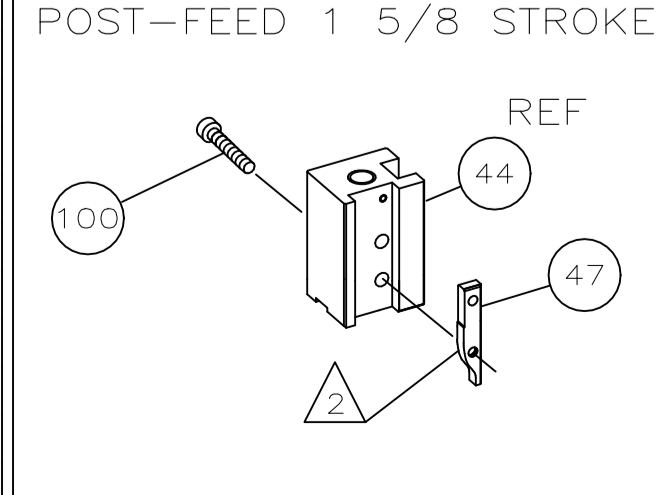
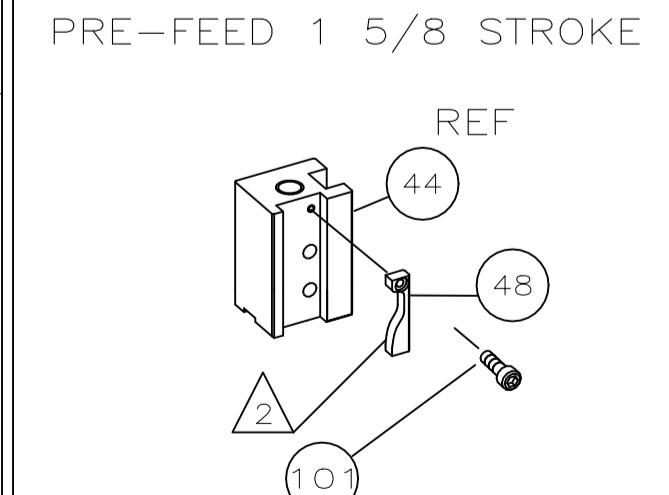
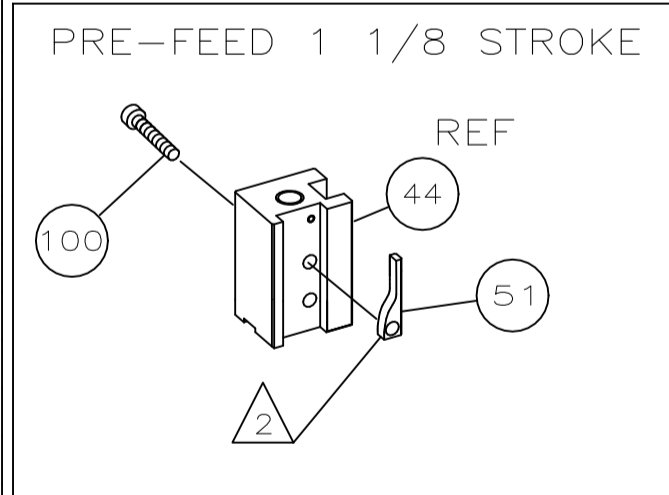
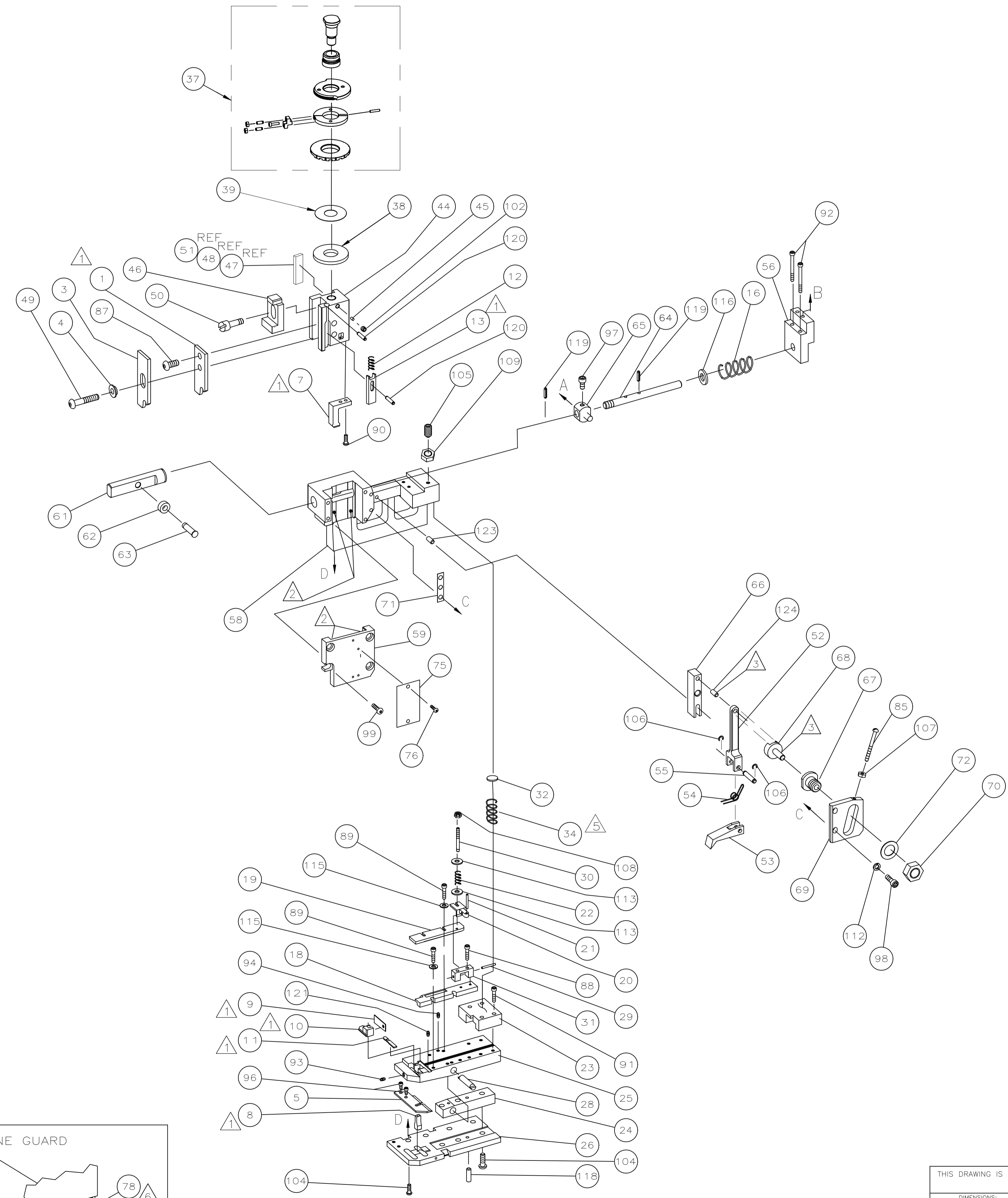
END FEED HINGE BAR APPLICATOR

SIZE: A1 CAGE CODE: 00779 DRAWING NO: 1855129

WEIGHT: -

CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: - SHEET 1 OF 2 REV: J

REVISIONS				
P	LTR	DESCRIPTION	DATE	APVD
-	-	SEE SHEET 1	-	-



THIS DRAWING IS A CONTROLLED DOCUMENT.		DIN R.O.WILSON 10-23-06	
DIMENSIONS: INCHES		CHK R.O.WILSON 10-23-06	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD T.ELBIN 10-23-06	NAME
0. PLC ± .005		END FEED HINGE BAR APPLICATOR	
1. PLC ± .002		PRODUCT SPEC	
2. PLC ± .001		APPLICATION SPEC	
3. PLC ± .0005		SIZE CAGE CODE DRAWING NO	
4. PLC ± .0002		RESTRICTED TO	
ANGLES ± .001		A1 00779 C=1855129	
MATERIAL	FINISH	WEIGHT	CUSTOMER ACCESSIBLE PRODUCTION DRAWING
		SCALE	SHEET 2 OF 2 REV J