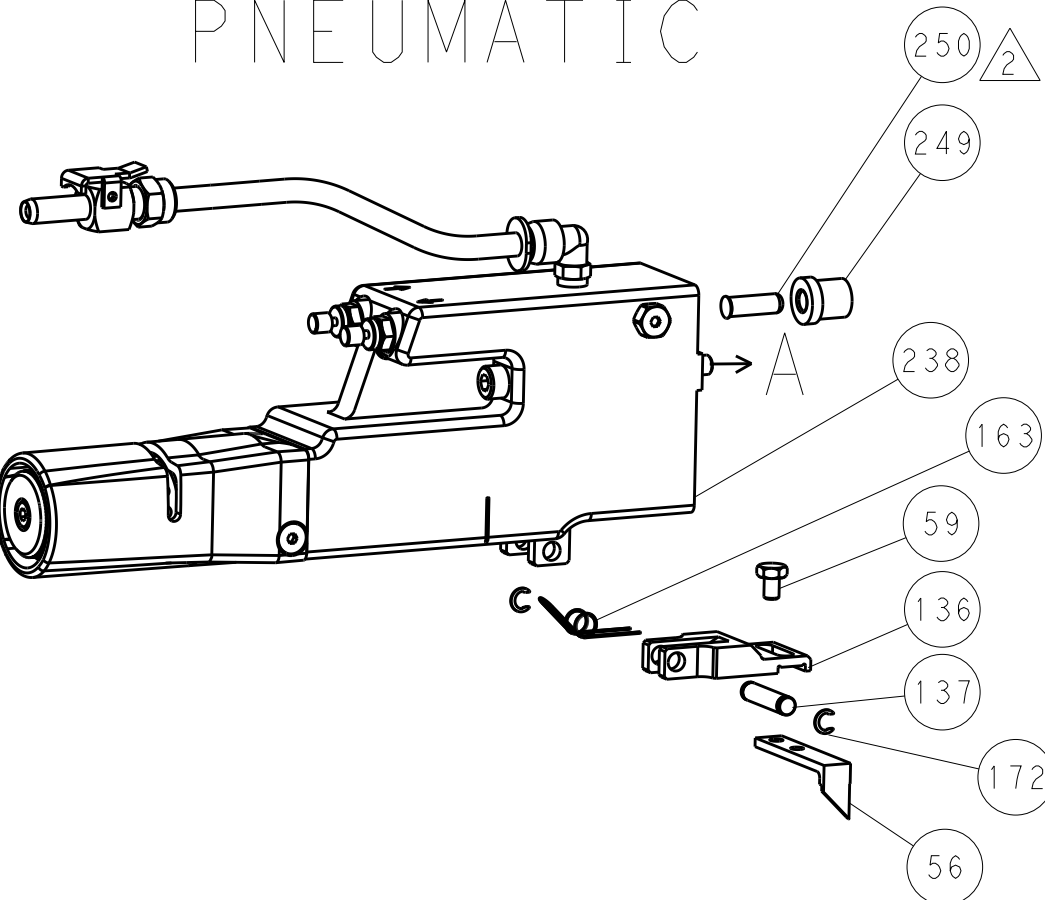


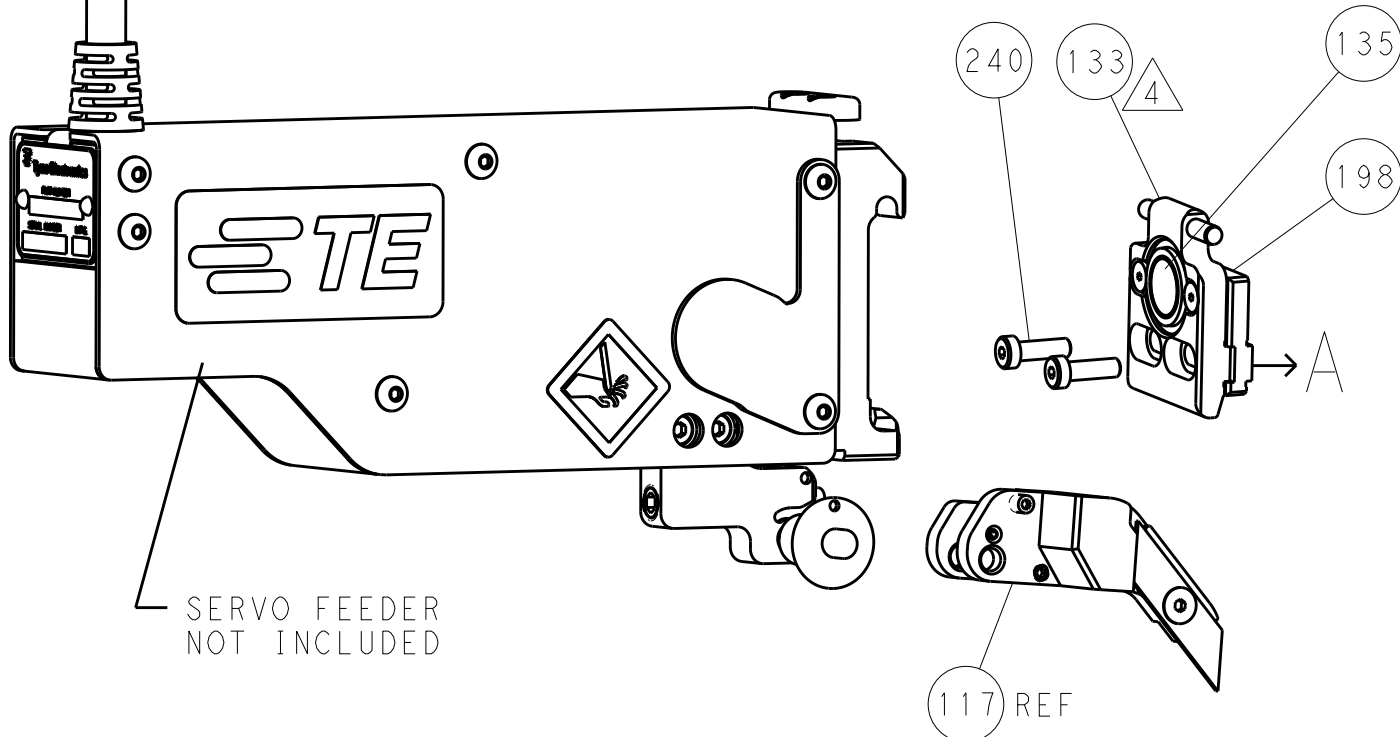
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE

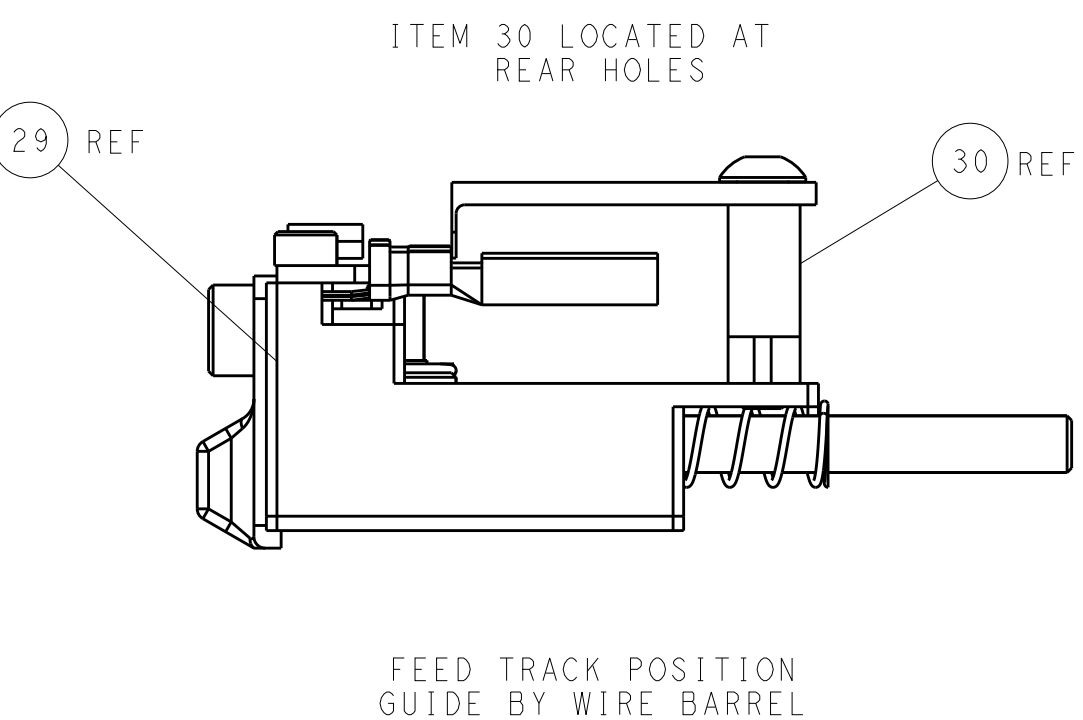
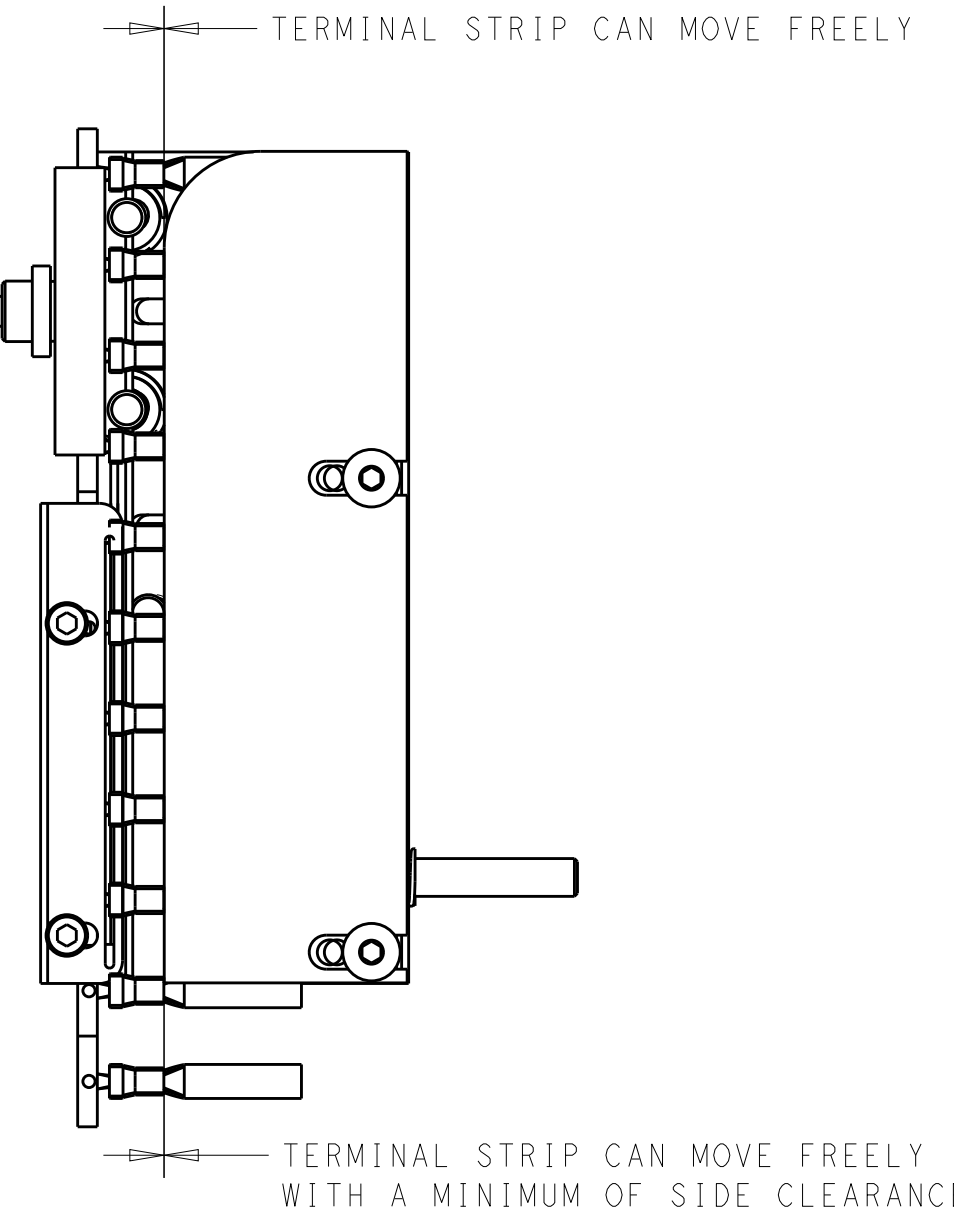
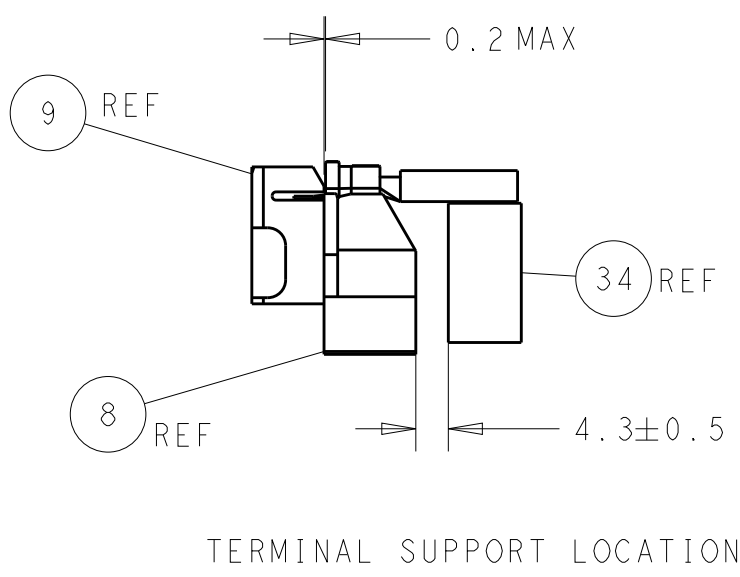
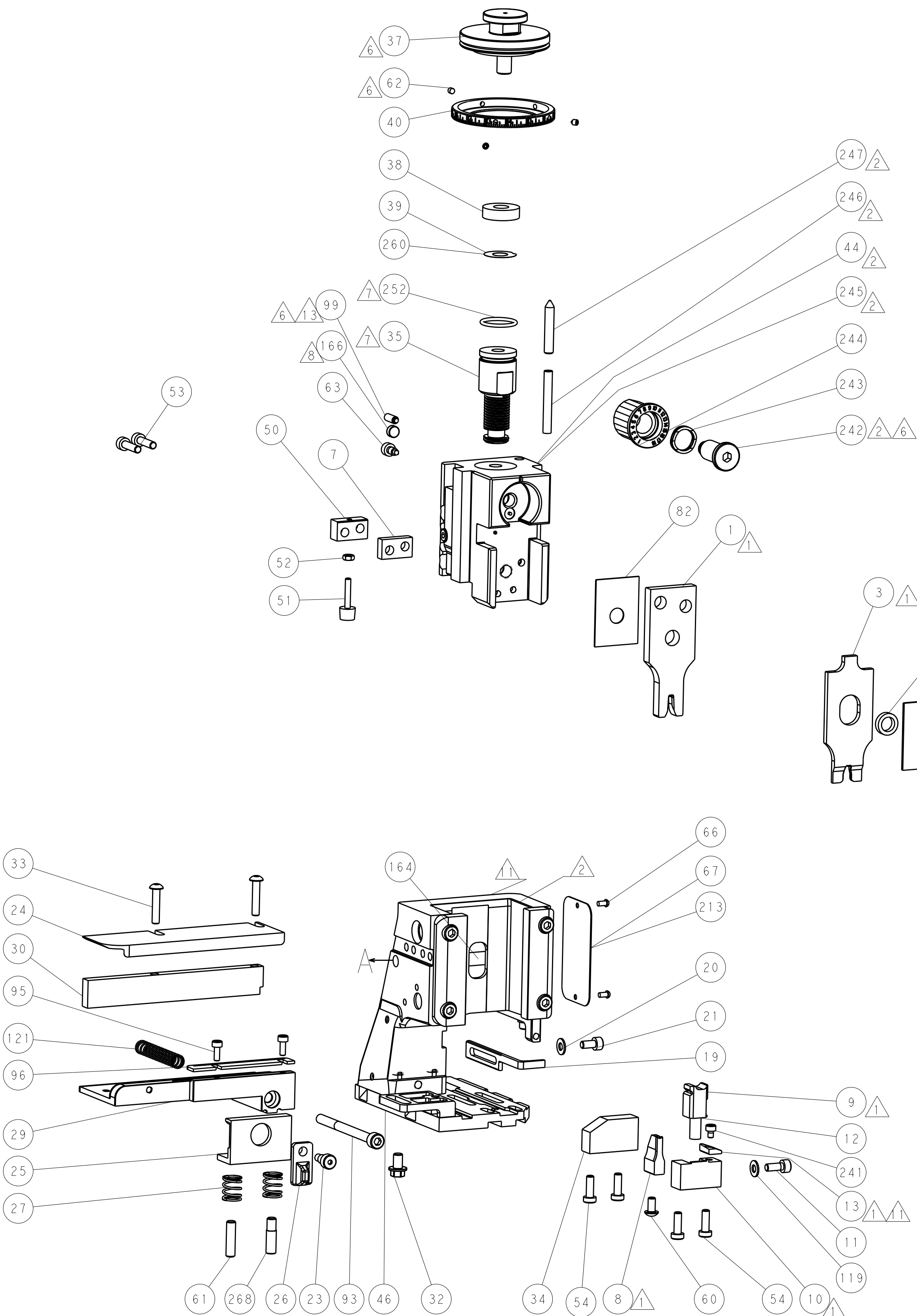
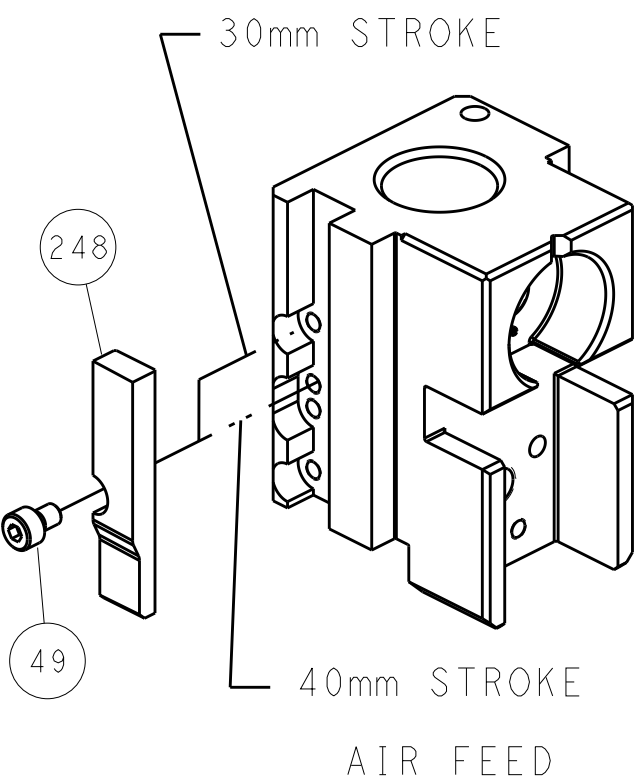
PNEUMATIC



SERVO LATCH PLATE

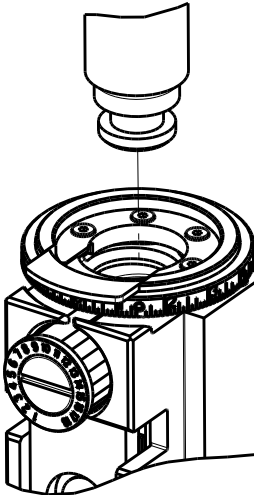


CAM POSITION

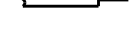


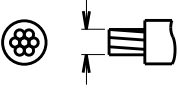
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN: C.CHEN 07FEB2013 CHK: S.XI 07FEB2013 APVD: J.CRUZ 07FEB2013				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±				NAME: Ocean Side Feed Applicator			
MATERIAL: -				FINISH: -				SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151812			
				WEIGHT: -				Customer Accessible Production Drawing			
				SCALE: 1:2				SHEET 2 OF 4 REV F			

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2151812-2	F	FINE CRIMP HEIGHT ADJUST
	2-2151812-5	F	FINE CRIMP HEIGHT ADJUST
	2-2151812-7	F	FINE CRIMP HEIGHT ADJUST
	7-2151812-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-10389 		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K LITEALUM CONTACT			
WIRE STRIP LENGTH 3.20-3.80 mm [.126-.150 IN]			INSULATION DIAMETER RANGE Ø 2.88-3.04 mm [.113-.120 IN]
TERMINAL APPLICATION SPECIFICATION 	114-94204	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-2177928-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
2.50mm2		1.56+/-0.04 [.0614+/- .0016]		3.5



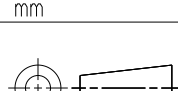
-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151812-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151812-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
-  APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 99 & 242.
-  GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
-  MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
-  CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
-  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
-  TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
-  SET THE FINE CRIMP HEIGHT ADJUSTMENT HEAD TO PROPER CRIMP HEIGHT PRIOR TO TIGHTENING/LOCKING THE BRASS TIP SET SCREW, ITEM 99, AGAINST THE ADJUSTMENT BOLT THREADS.
13. APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

-	1	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	268
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

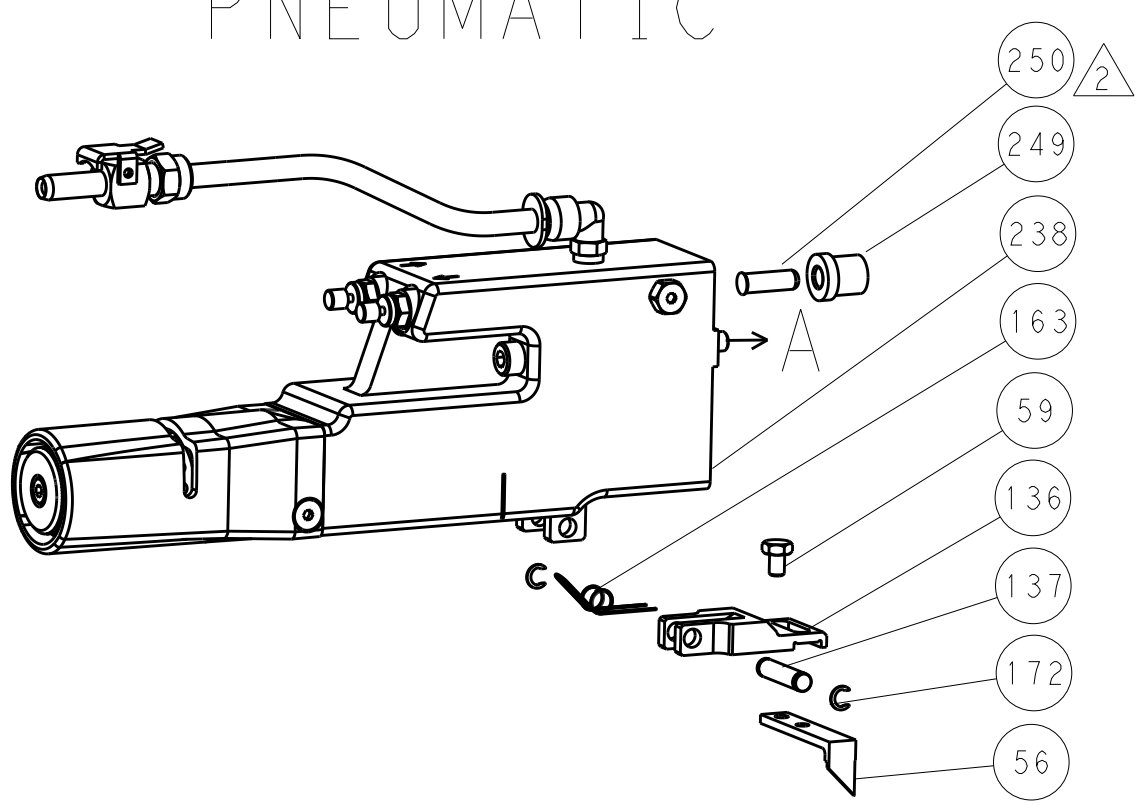
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS				
			P	LTR	DESCRIPTION	DATE	DWN
			-	-	SEE SHEET 1	-	-

	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
	-	-	-	1	2063440-1	AIR FEED MODULE	238
	-	-	1	-	2119740-2	TAG,IDENTIFICATION	213
	-	-	1	-	1901094-3	SPACER, FEEDER	198
	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	-	1	240638-1	SPRING, FEED FINGER	163
	-	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152
	-	-	-	1	2119641-2	FEED CAM, AIR FEED	151
	-	1	1	1	2119798-2	DETENT PIN	145
	-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
	-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
	-	1	1	1	2-2119656-4	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
	-	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
	-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	-	-	1	2119799-1	HOLDER,FEED FINGER, AF	136
	-	-	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
	-	-	1	-	1633743-1	SERVO FEED LATCH ASM	133
	-	1	1	1	1-22281-8	SPRING, COMPRESSION	121
	-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	1	1	1	2256587-1	SCR, SET, SOFT TIP, M4	99
	-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	-	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	1	1	1	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	-	1	1338685-1	PAWL, FEED	56
	-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	690753-2	SPACER, TONKER	50
	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1	2119644-1	RAM WASHER, PRECISION	38
	-	1	1	1	1-1752356-7	SUPPORT, TERMINAL	34
	-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
	-	1	1	1	1320908-7	SPACER, STRIP GUIDE	30
	-	2	2	2	1901086-1	PLATE, STRIP GUIDE	29
	-	1	1	1	1-455888-0	SPACER, CRIMPER	28
	-	2	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1	1803142-1	DRAG, TERMINAL	25
	-	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	690472-2	STRIPPER	19
	-	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1-18023-1	SCR, SKT HD CAP M4 X 10.0	11
	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
	1	1	1	1	2161316-5	ANVIL, COMBINATION	8
	-	1	1	1	2-240641-9	SPACER	7
	-	-	-	-	-	-	6
	-	1	1	1	1-1722335-0	SHEAR DEPRESSOR ASSEMBLY	5
	-	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
	1	1	1	1	1-1722335-2	CRIMPER, INSULATION F	3
	-	-	-	-	-	-	2
	1	1	1	1	2217303-2	CRIMPER, WIRE, CONICAL BLEND	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO	

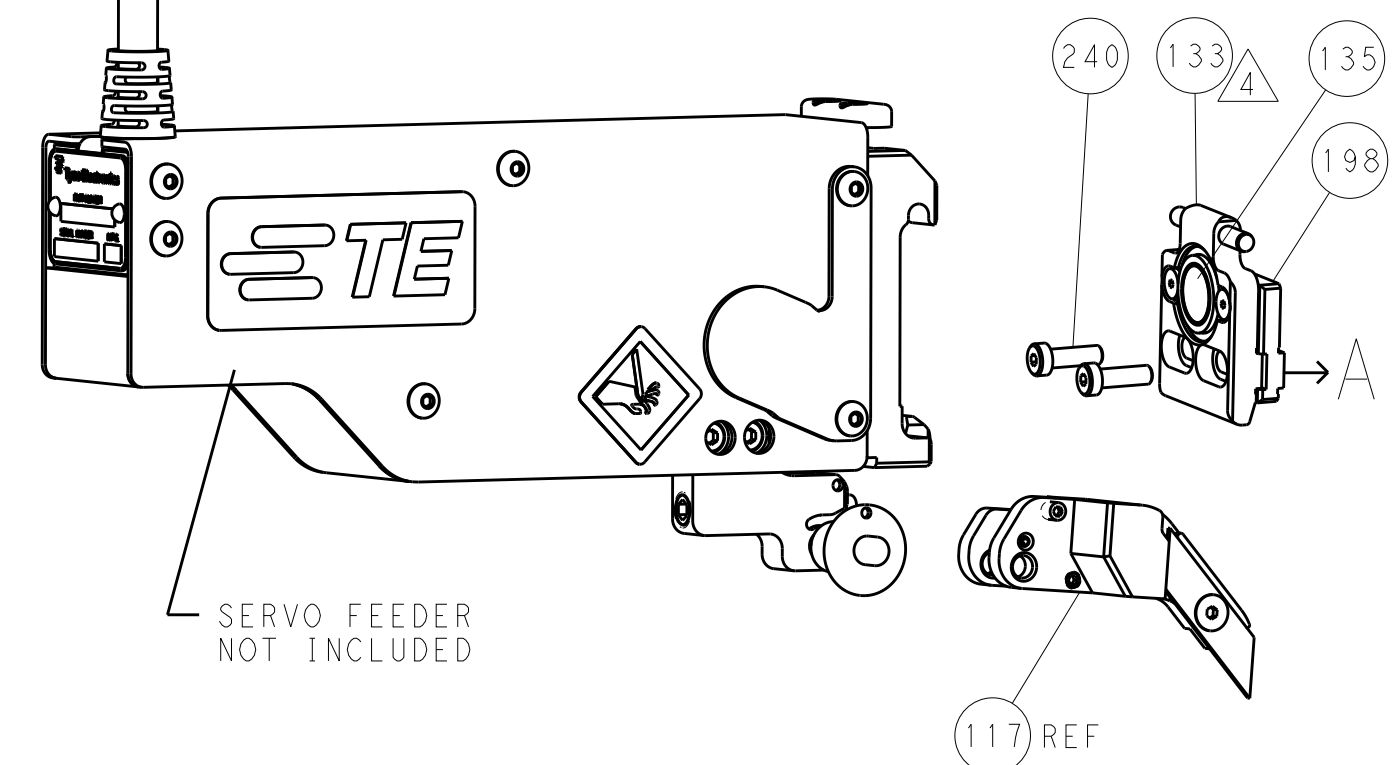
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DIMENSIONS: mm		CHK S.XI 07FEB2013	NAME Ocean Side Feed Applicator	
		APVD J. CRUZ 07FEB2013	PRODUCT SPEC	
			APPLICATION SPEC	
			FINISH	
MATERIAL -			SIZE A1	CAGE CODE 00779
			DRAWING NO C=2151812	RESTRICTED TO -
Customer Accessible Production Drawing		SCALE 1:2	SHEET 3	REV F

LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

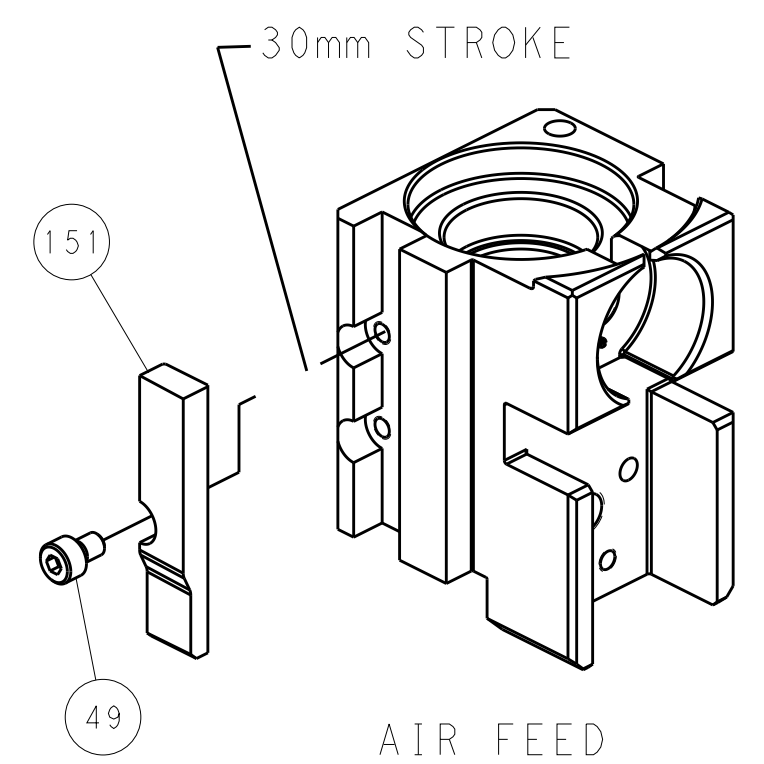
FEED TYPE
PNEUMATIC



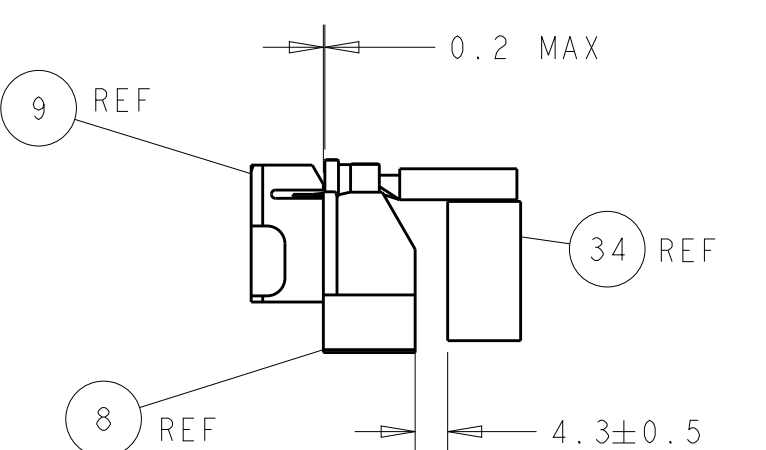
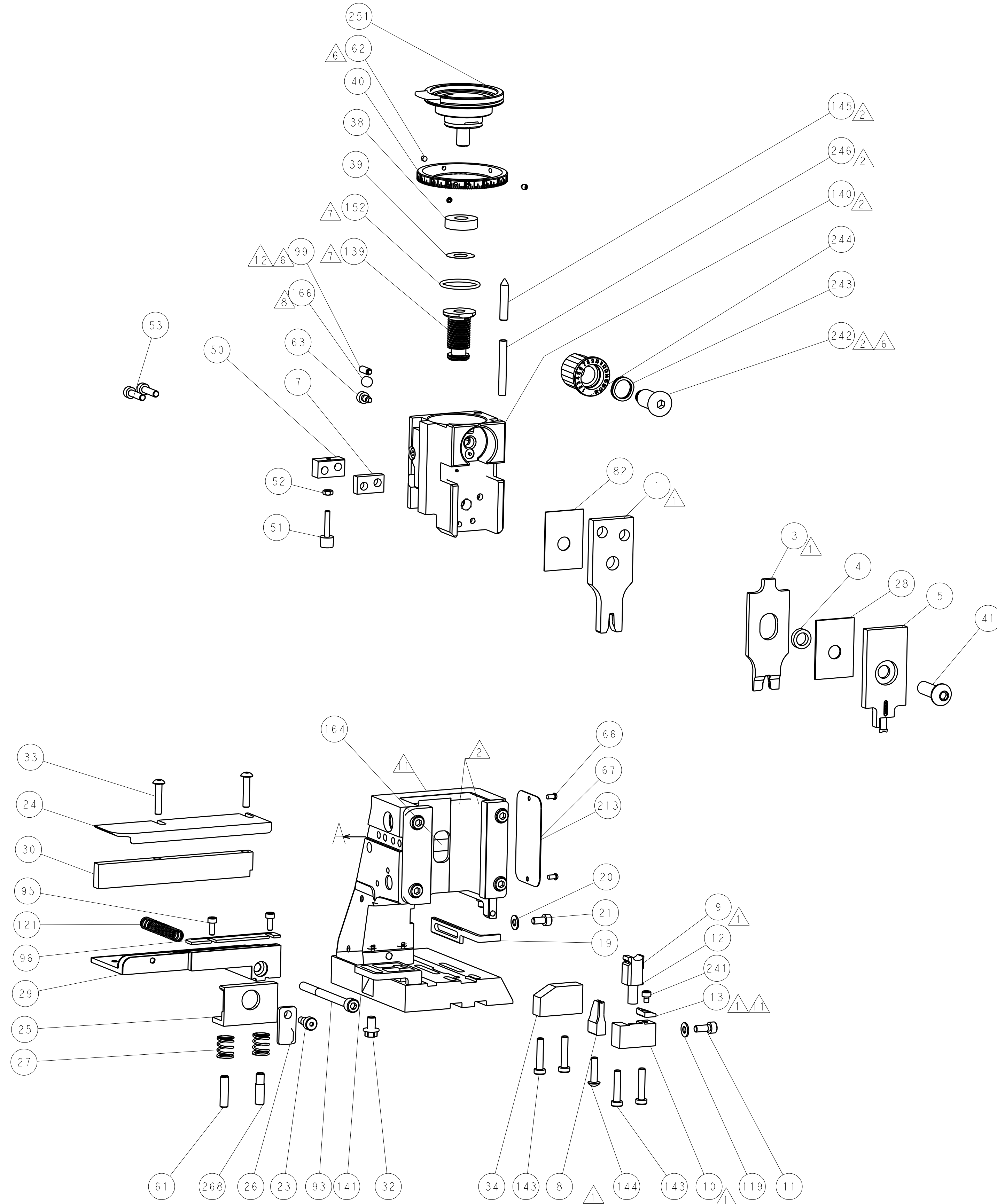
SERVO
LATCH PLATE



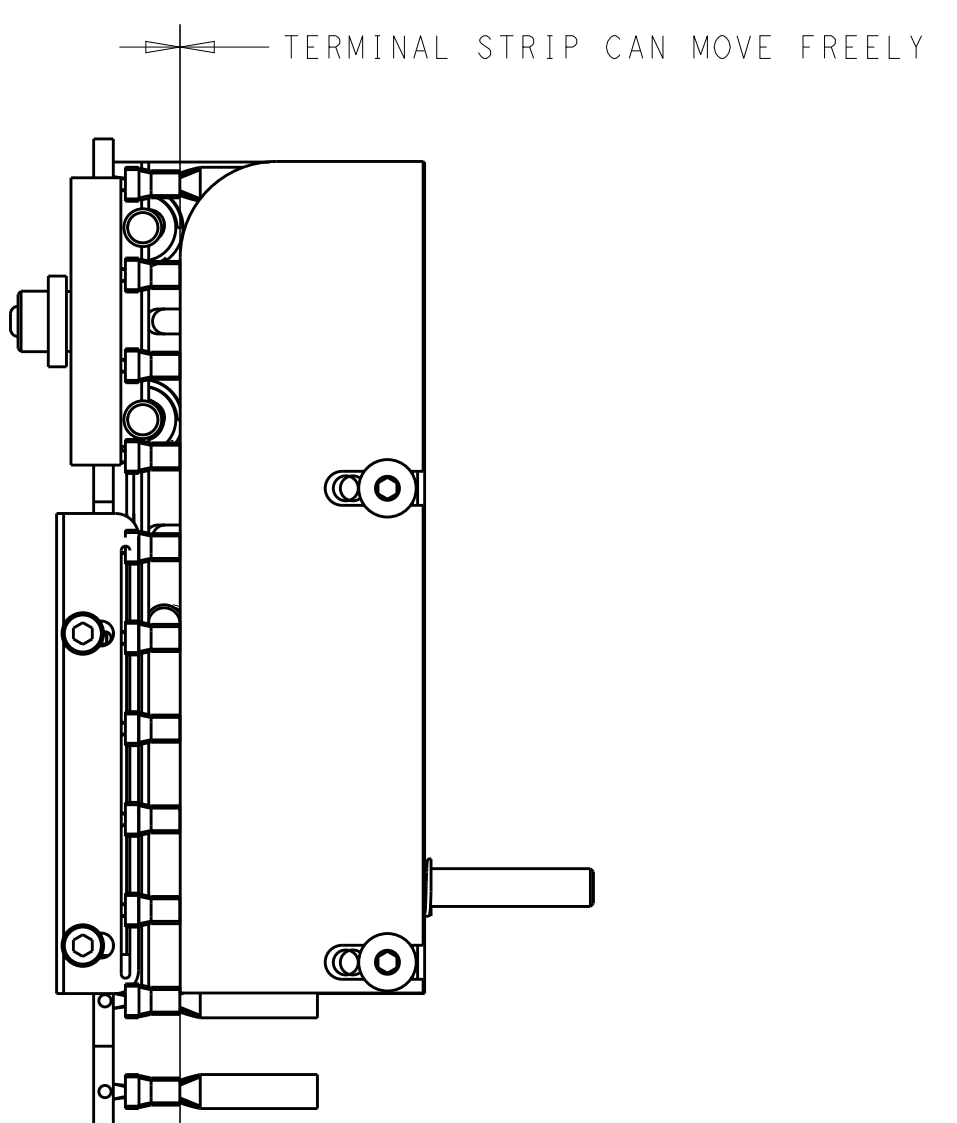
CAM POSITION



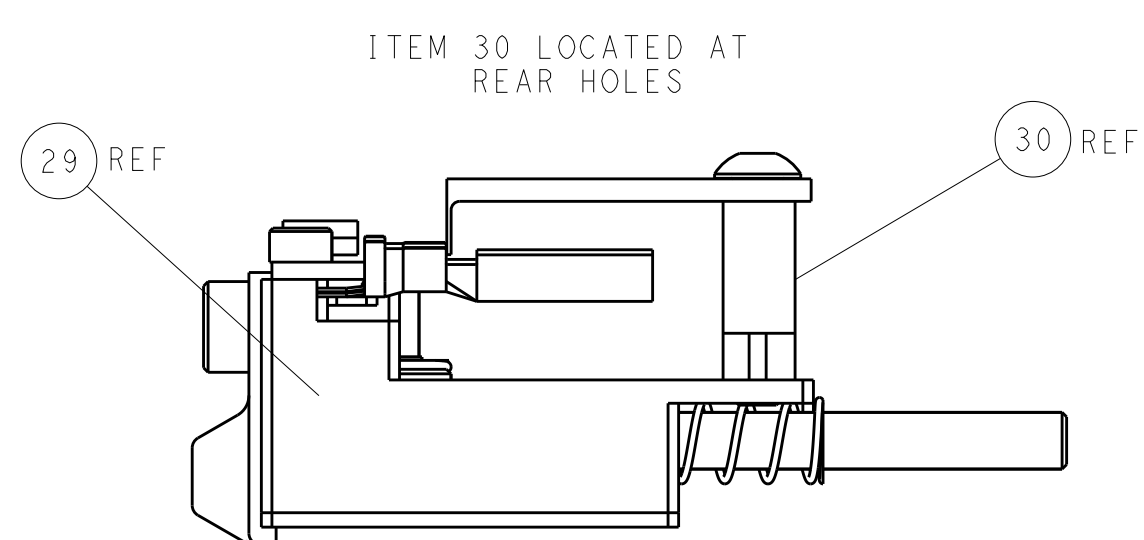
AIR FEED



TERMINAL SUPPORT LOCATION



TERMINAL STRIP CAN MOVE FREELY
WITH A MINIMUM OF SIDE CLEARANCE



FEED TRACK POSITION
GUIDE BY WIRE BARREL

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH				NAME: Ocean Side Feed Applicator			
MATERIAL: -				PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: -				SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151812			
				Customer Accessible Production Drawing				SCALE: 1:2 SHEET: 4 OF 4 REV: F			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION