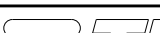
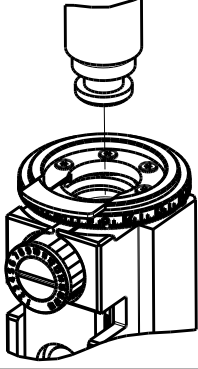
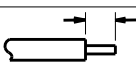


THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE CUSTOMER'S INFORMATION IT IS SUBJECT TO THE CUSTOMER'S OWNERSHIP AND THE CUSTOMER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN: 07FEB2013 X_ZHAO CHK: 07FEB2013 T_CLB1N		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 9 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL -		FINISH -		CAGE CODE 00779	
WEIGHT -		DRAWING NO C=2151818		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 OF 4 REV G	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						-	1338685-1	5-18022-5	-	-	-
	2-2151818-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151818-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2151818-5	G	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SMART APPLICATOR	2161326-1	-	8-2151818-4	-	-	-
	2-2151818-7	G	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151818-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	4.83 mm [.190]	F
APPLICATOR INSTRUCTIONS 408-10389 		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: SPT LITEALUM CONTACT			
WIRE STRIP LENGTH 3.90-4.50 mm [.154-.177 IN]			INSULATION DIAMETER RANGE Ø 4.13-4.38 mm[.163-.172 IN]
TERMINAL APPLICATION SPECIFICATION 	114-94204	-	-
TERMINALS APPLIED ⁹			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-1862004-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁸
6.00mm2		2.10±0.04 [.0827±.0016]		7.8



-  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: 8-2151818-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151818-5
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.
-  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.
-  GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
-  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.

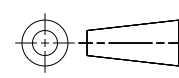
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	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	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-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	LYR	DESCRIPTION	DATE	OWN
					SEE SHEET 1	-	-

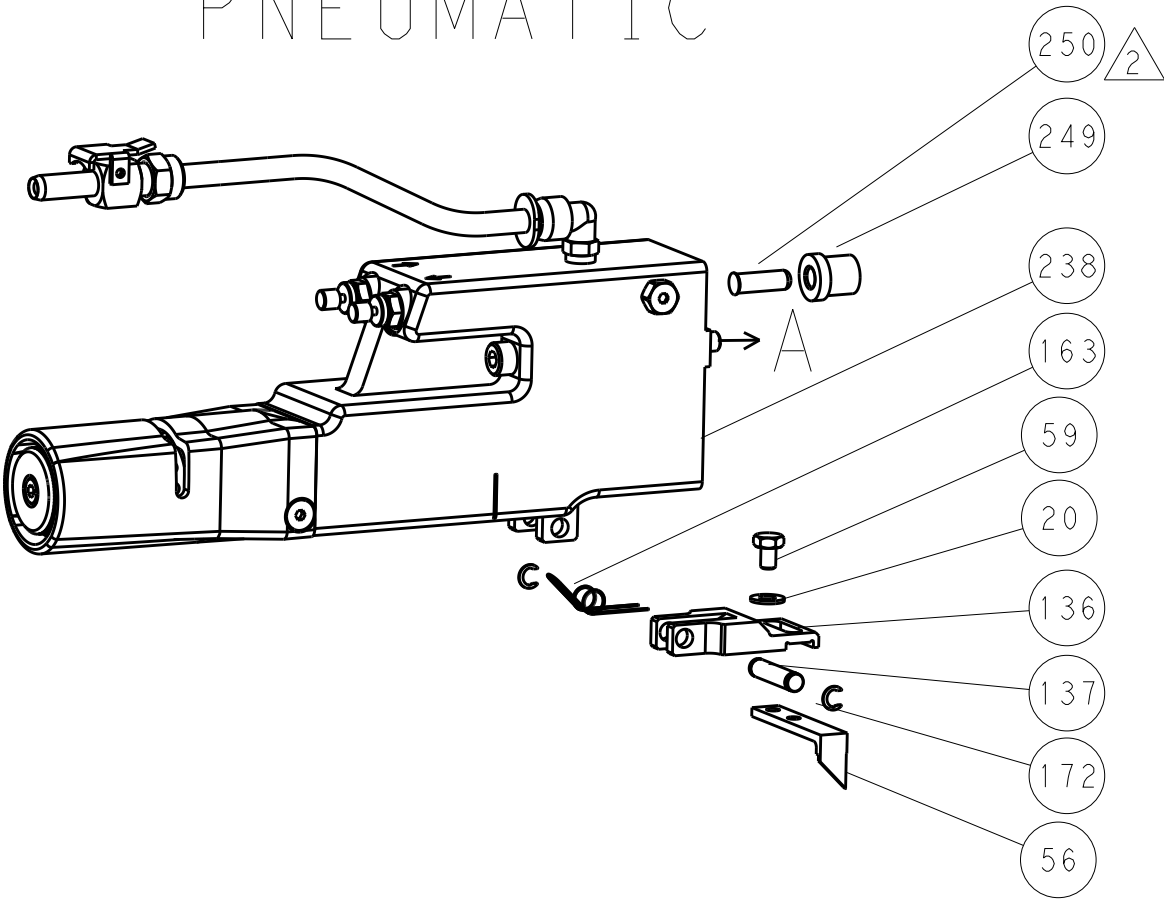
 6	-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
	-	-	-	1	2063440-1	AIR FEED MODULE	238
	-	-	1	-	2119740-2	TAG, IDENTIFICATION	213
	-	-	1	-	1901094-3	SPACER, FEEDER	198
	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
 7	-	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
 11	-	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
 11	-	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
 12 6	-	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	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
 6	-	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	2119644-2	RAM WASHER, PRECISION	38
	-	1	1	1	1-1752356-2	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	2-1320908-2	SPACER, STRIP GUIDE	30
	-	1	1	1	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
	-	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	690472-2	STRIPPER	19
 10 1	-	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1-356885-4	STOP, SHEAR	11
 1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
 1	-	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
 1	1	1	1	1	2161316-4	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	4-238011-5	BLOCK, CRIMPER SPACER	4
 1	1	1	1	1	1722335-9	CRIMPER, INSULATION F	3
	-	-	-	-	-	-	2
 1	1	1	1	1	2217303-1	CRIMPER, WIRE, CONICAL BLEND	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO	

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				CHK T, ELBIN	07FEB2013						
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S, XI	07FEB2013	NAME		Ocean Side Feed Applicator			
mm		0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		PRODUCT SPEC							
				APPLICATION SPEC							
MATERIAL		FINISH		WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
-		-		-		A1	00779	C=2151818	-		
Customer Accessible Production Drawing				SCALE		SHEET		OF	REV		
				1:2		3		4	G		

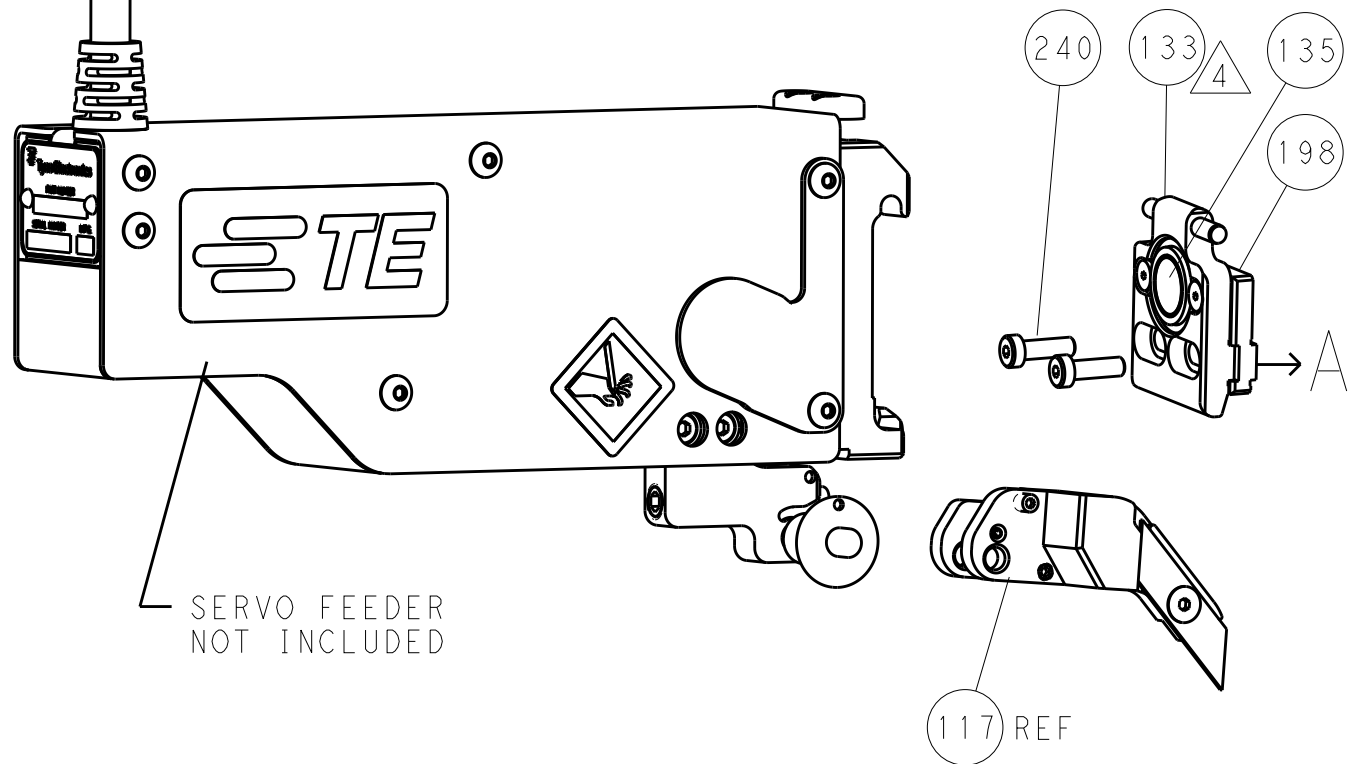
LOC	DIST	REVISIONS				
		P	LTR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

FEED TYPE

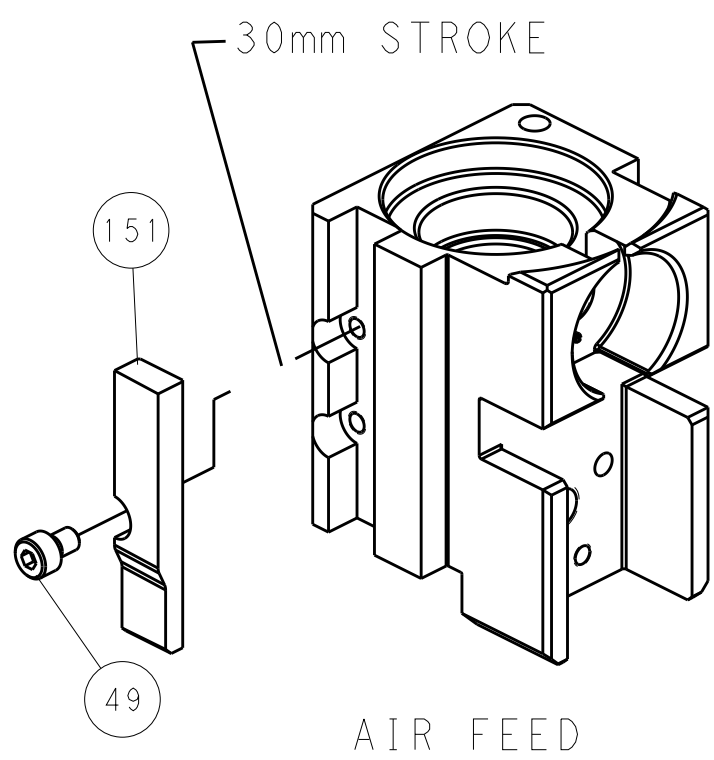
PNEUMATIC



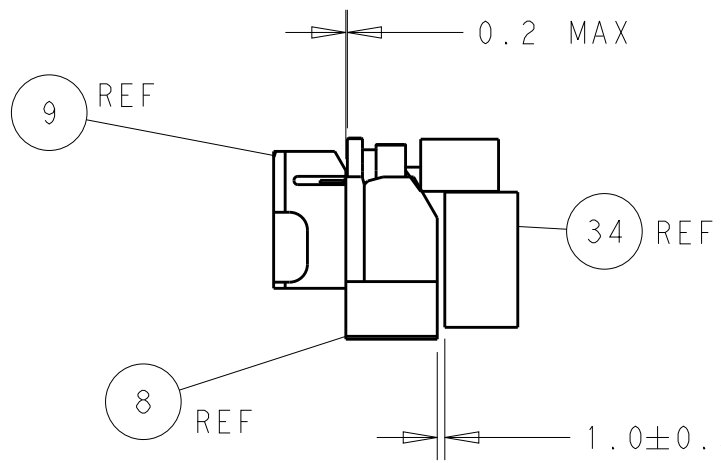
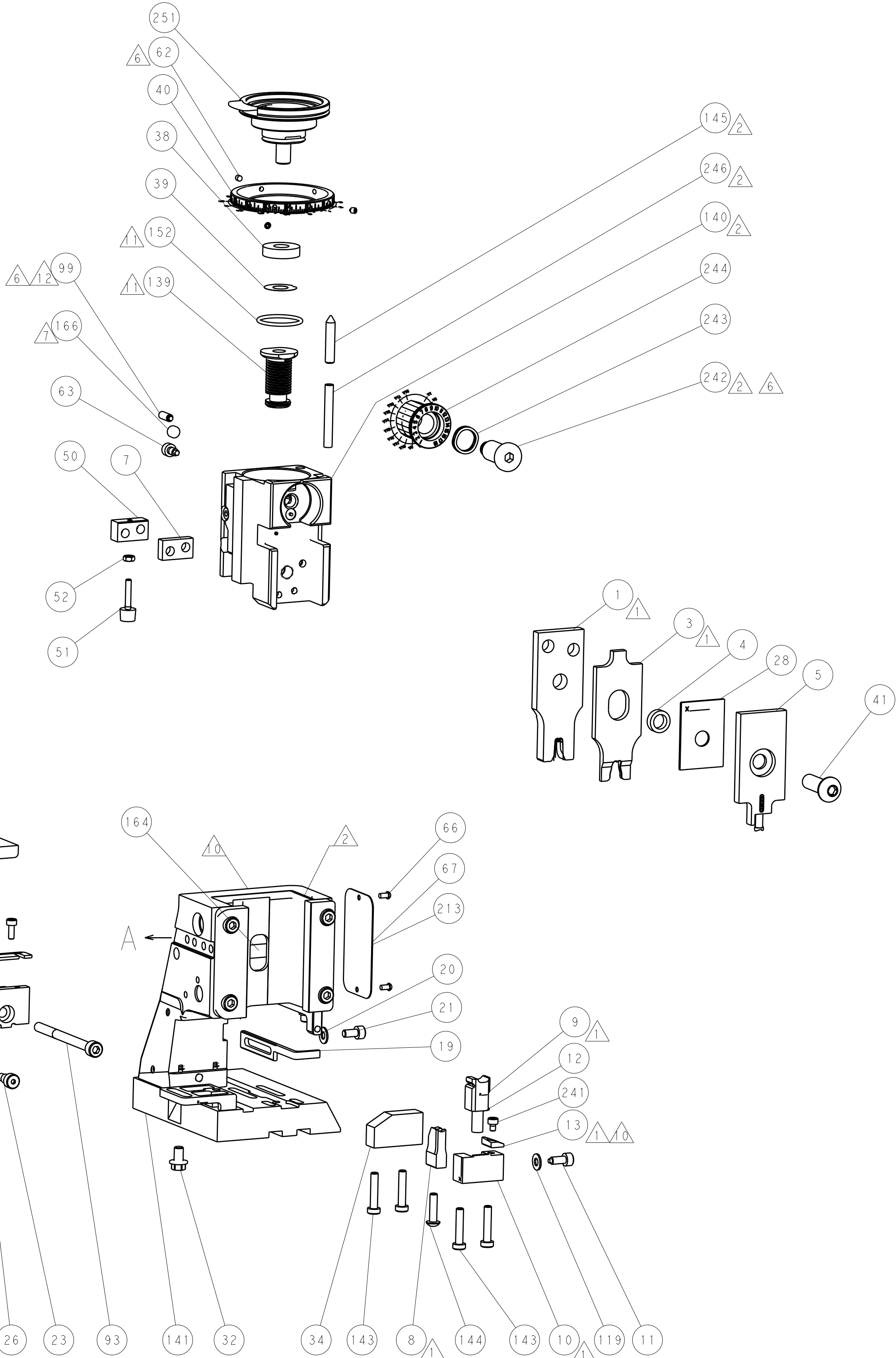
SERVO LATCH PLATE



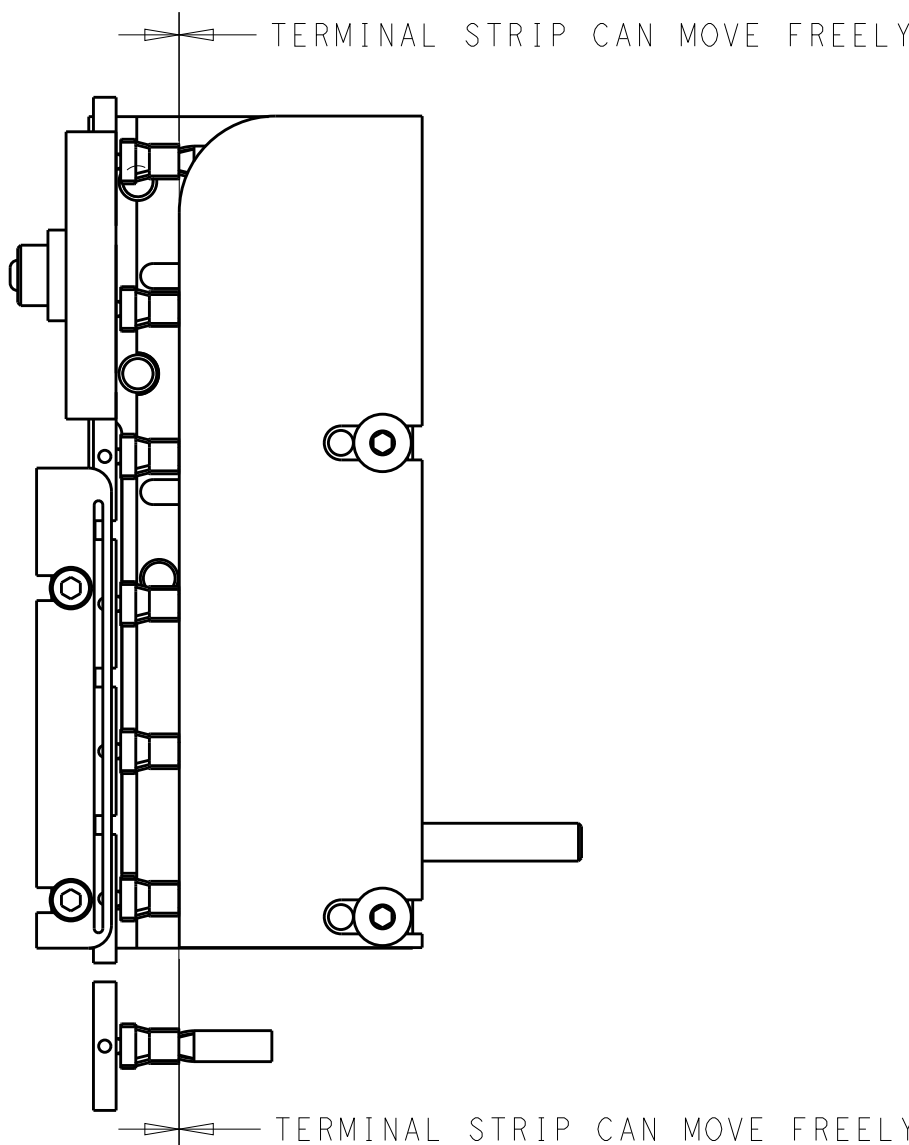
CAM POSITION



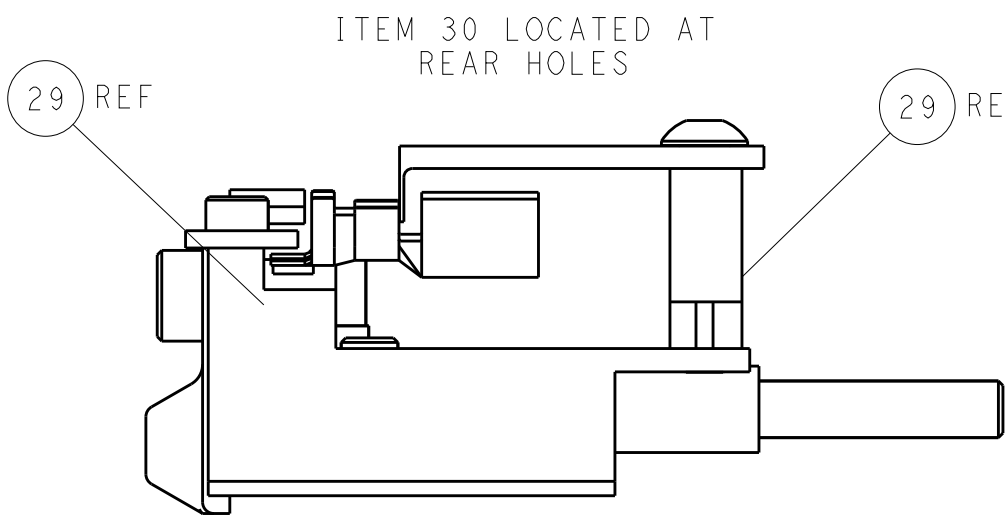
AIR FEED



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.		OWN X. ZHAO CHK T. ELBIN APVD S. XI	07FEB2013 07FEB2013 07FEB2013	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		FINISH -		WEIGHT -	
				Customer Accessible Production Drawing	
				SCALE 1:2 SHEET 4 OF 4 REV G	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION