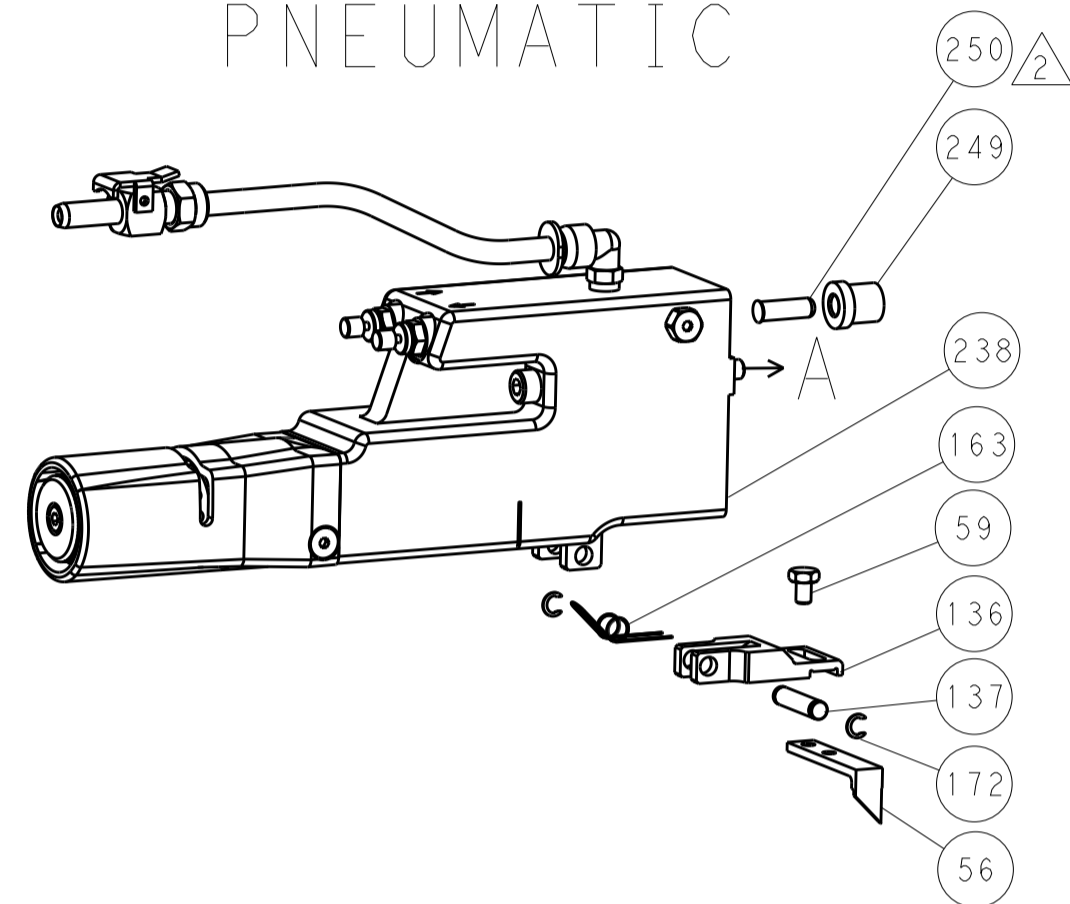
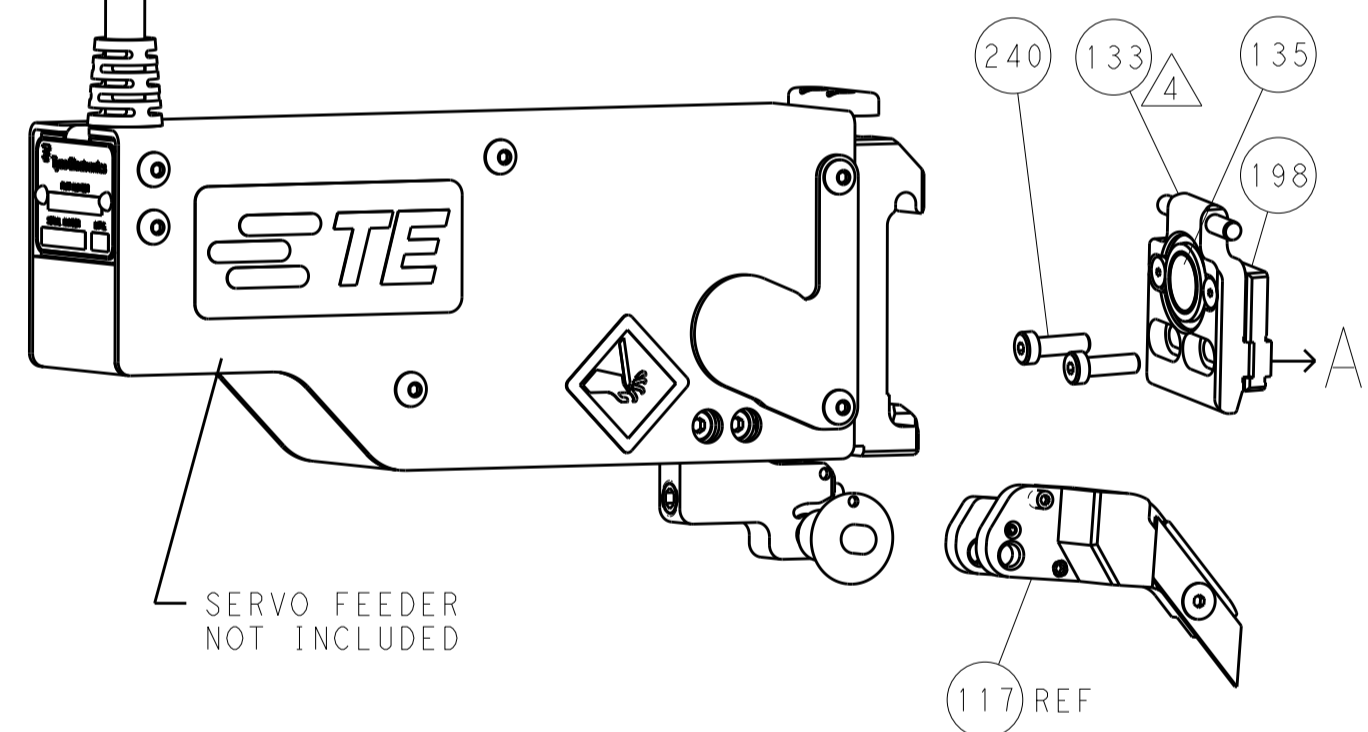


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

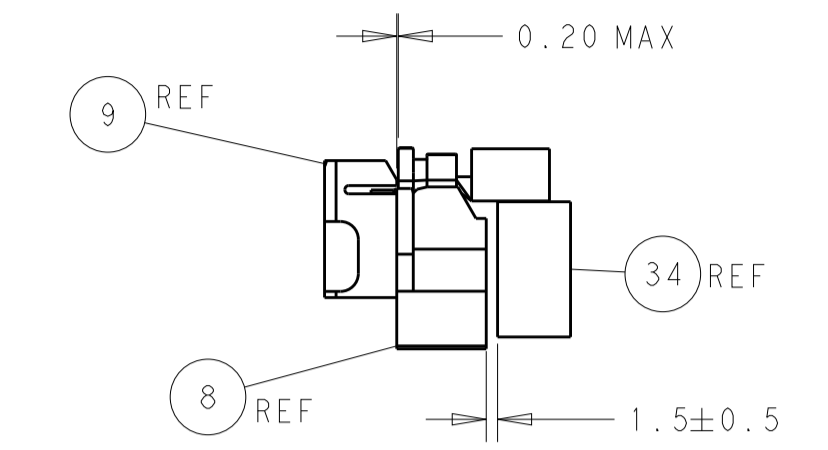
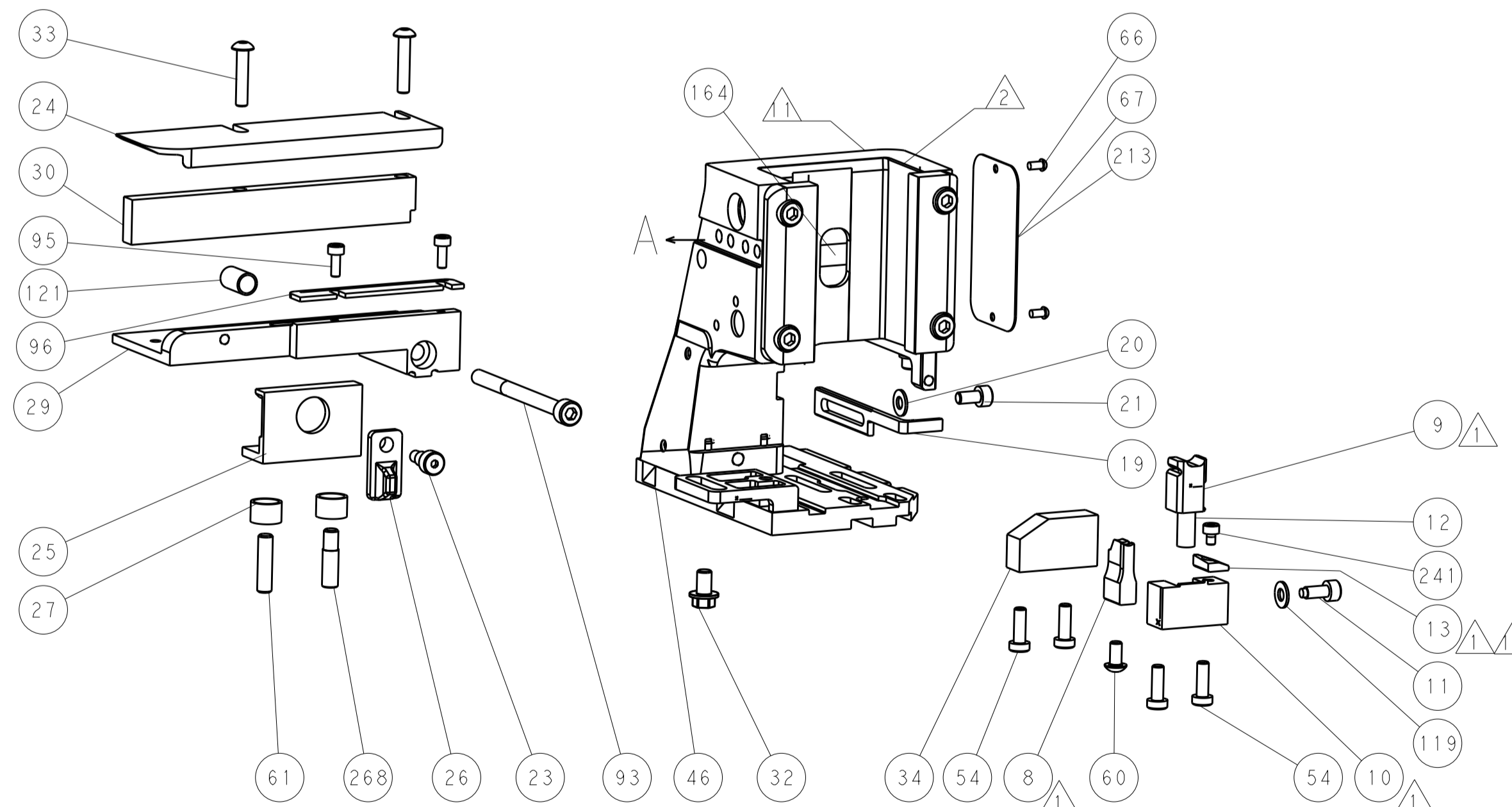
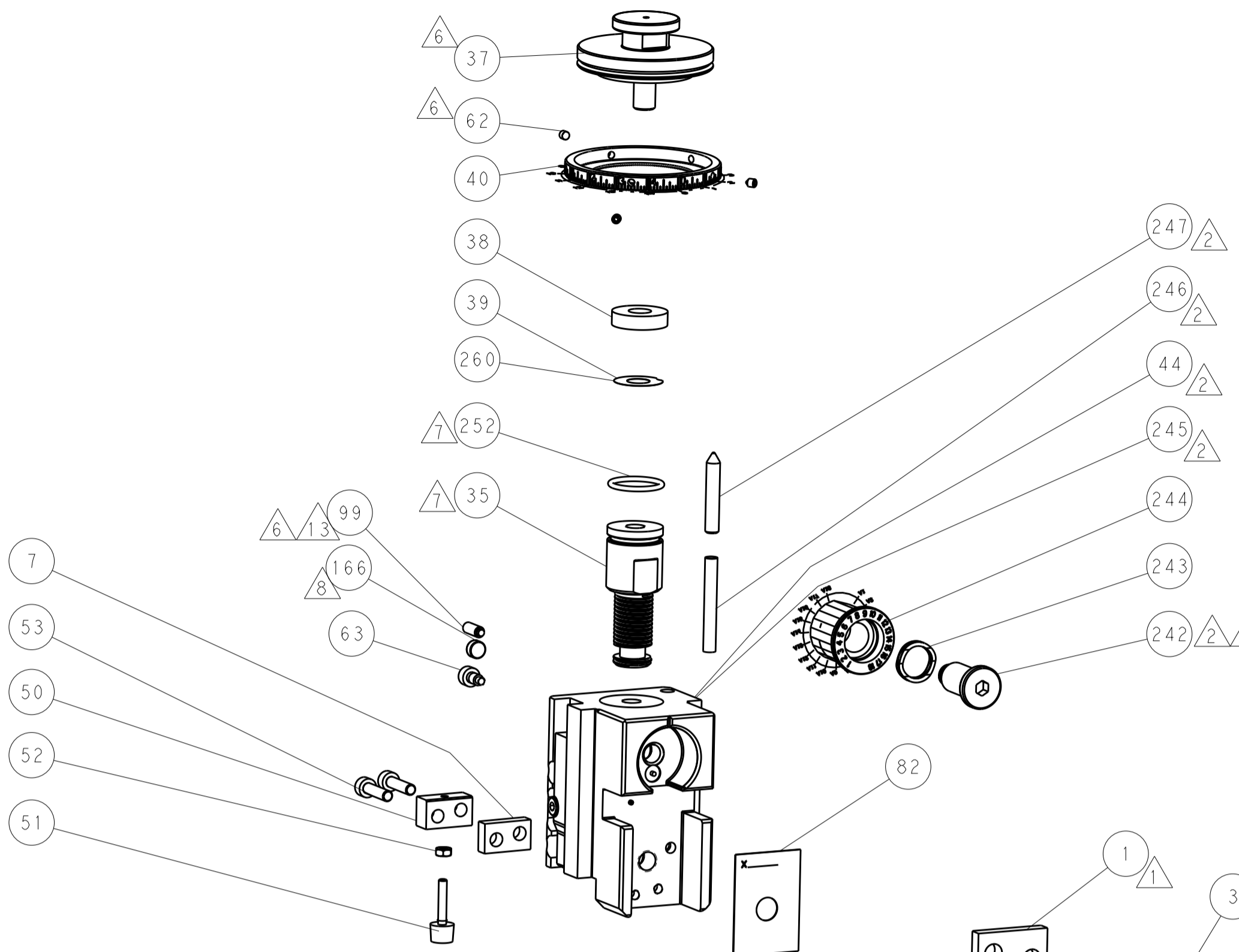
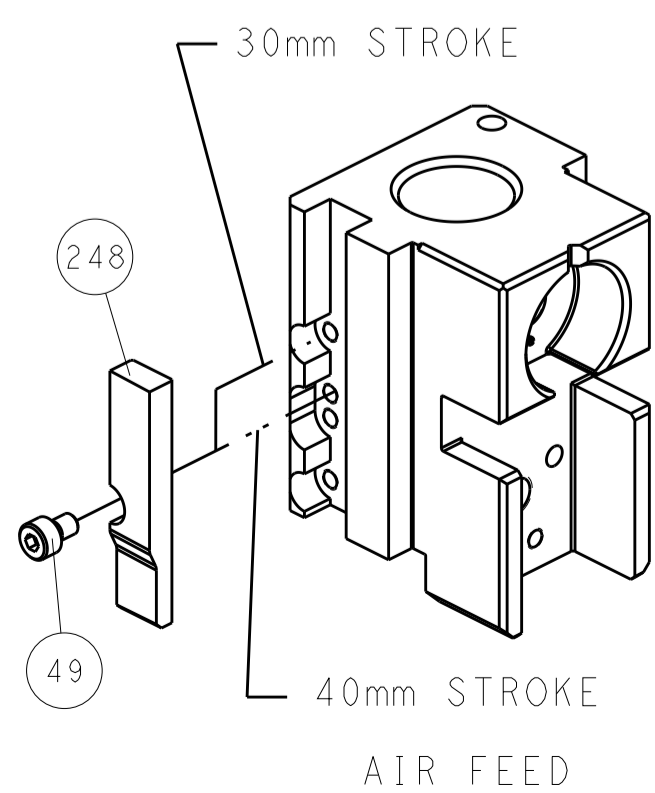
FEED TYPE PNEUMATIC



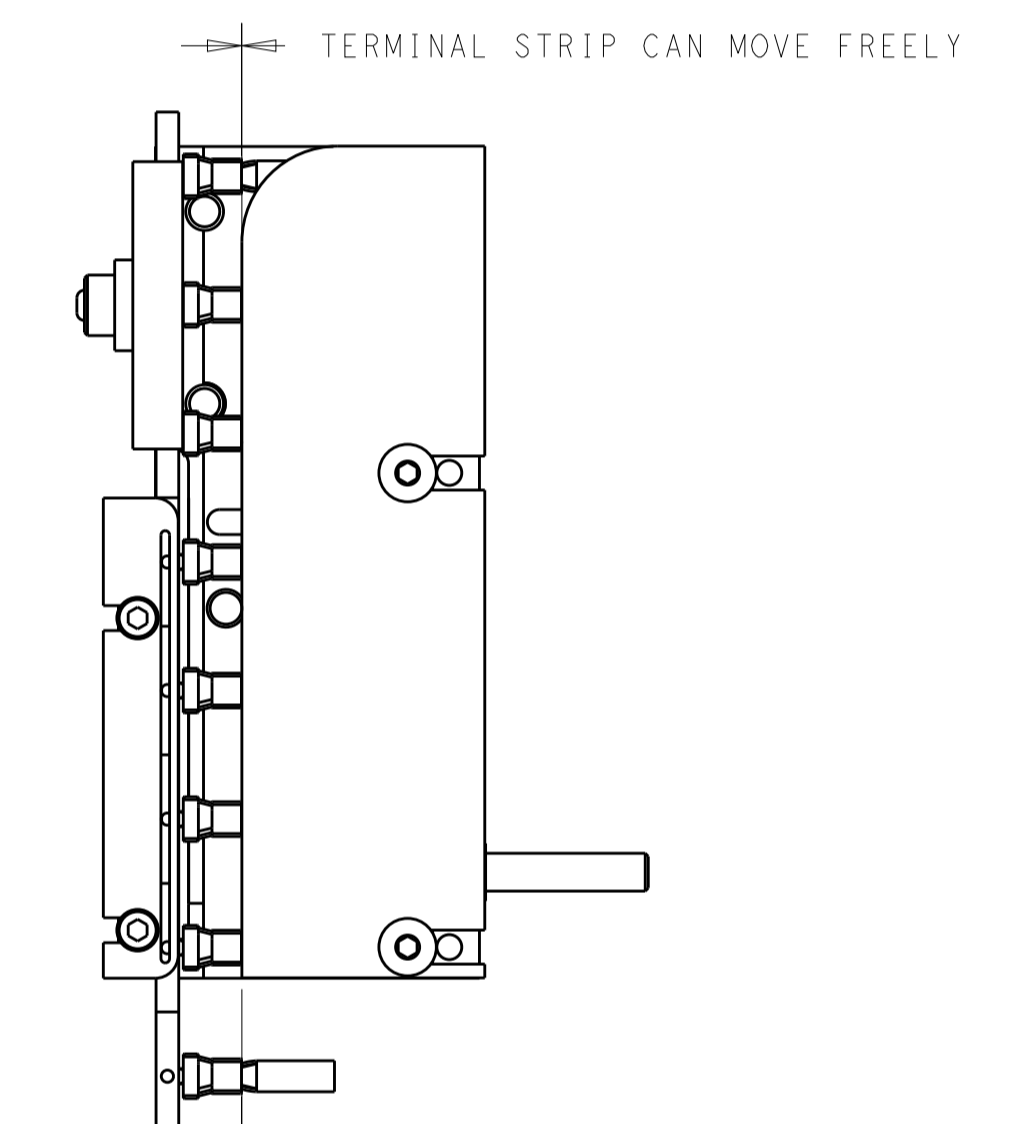
SERVO LATCH PLATE



CAM POSITIONS



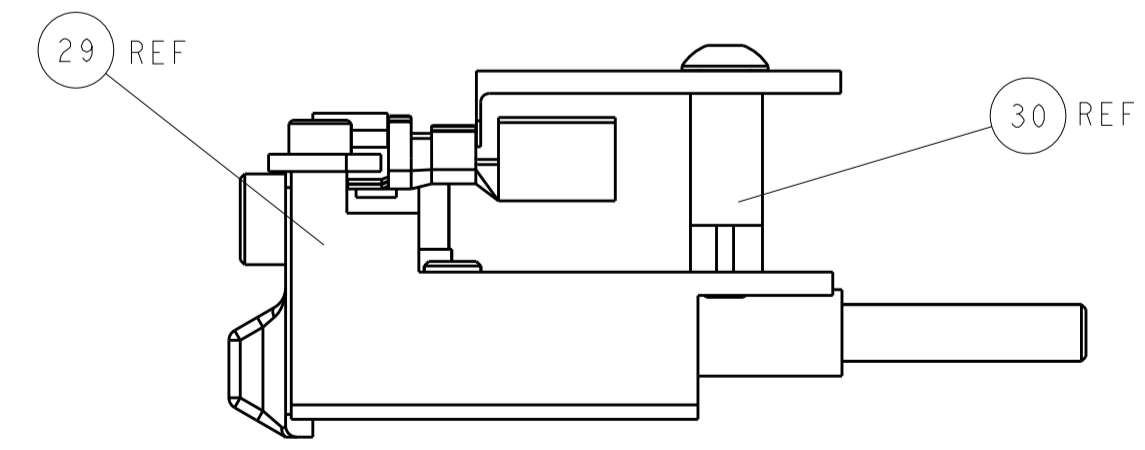
TERMINAL SUPPORT LOCATION



TERMINAL STRIP CAN MOVE FREELY WITH A MINIMUM OF SIDE CLEARANCE

FEED TRACK POSITION

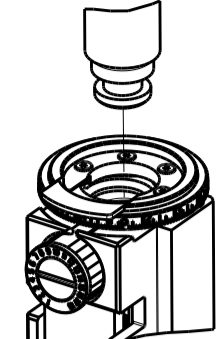
ITEM 30 LOCATED AT REAR HOLES



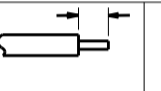
FEED TRACK POSITION GUIDE BY WIRE BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: R. KNEPPER 18JAN2012		TE Connectivity	
mm	0 PLC	±		CHK: T. ELBIN 18JAN2012	NAME: Ocean Side Feed Applicator		Harrisburg, PA 17105-3608
	1 PLC	±		APVD: M. CLIFFORD 18JAN2012	SIZE: A1		RESTRICTED TO
	2 PLC	±		PRODUCT SPEC	CAGE CODE: 00779		
	3 PLC	±		APPLICATION SPEC	DRAWING NO: C=2151551		
	4 PLC	±		ANGLES	SCALE: 1:2		
MATERIAL:	FINISH:	WEIGHT:		Customer Accessible Production Drawing		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					
	2-2151551-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151551-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151551-4	-	-	-
	2-2151551-5	G	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					-	-	-	-	-	-	-
2-2151551-7	G	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151551-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 6.3/4.8 K LITEALUM CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.40-4.00 mm [.134 -.157 IN]		∅ 3.56-3.74mm [.140-.147 IN]	
TERMINAL APPLICATION SPECIFICATION	114-94204	-	-
TERMINALS APPLIED ¹⁰			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-2177839-1	2-2177839-3		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm ²	1.90±0.04 [.0748±.0016]	8.5

- ¹ RECOMMENDED SPARE PARTS
- ² GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- ⁴ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151551-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151551-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- ⁶ 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.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- ⁸ MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- ⁹ 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.
- ¹⁰ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ¹¹ 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.
- ¹² 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.

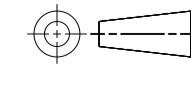
***WARNING**
 ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	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	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-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	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

-	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
⁸	-	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
⁷	-	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
⁷	-	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
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
¹² ⁶	-	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 6.5	93
-	1	1	1	455888-3	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
⁶	-	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	1320908-7	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
-	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	1-356885-5	STOP, SHEAR	11
¹	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
¹	-	1	1	462006-6	FLOATING SHEAR, FRONT	9
¹	1	1	1	2161316-2	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	5-238011-2	BLOCK, CRIMPER SPACER	4
¹	1	1	1	1722335-8	CRIMPER, INSULATION F	3
-	-	-	-	-	-	2
¹	1	1	1	2217302-2	CRIMPER, WIRE, CONICAL BLEND	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

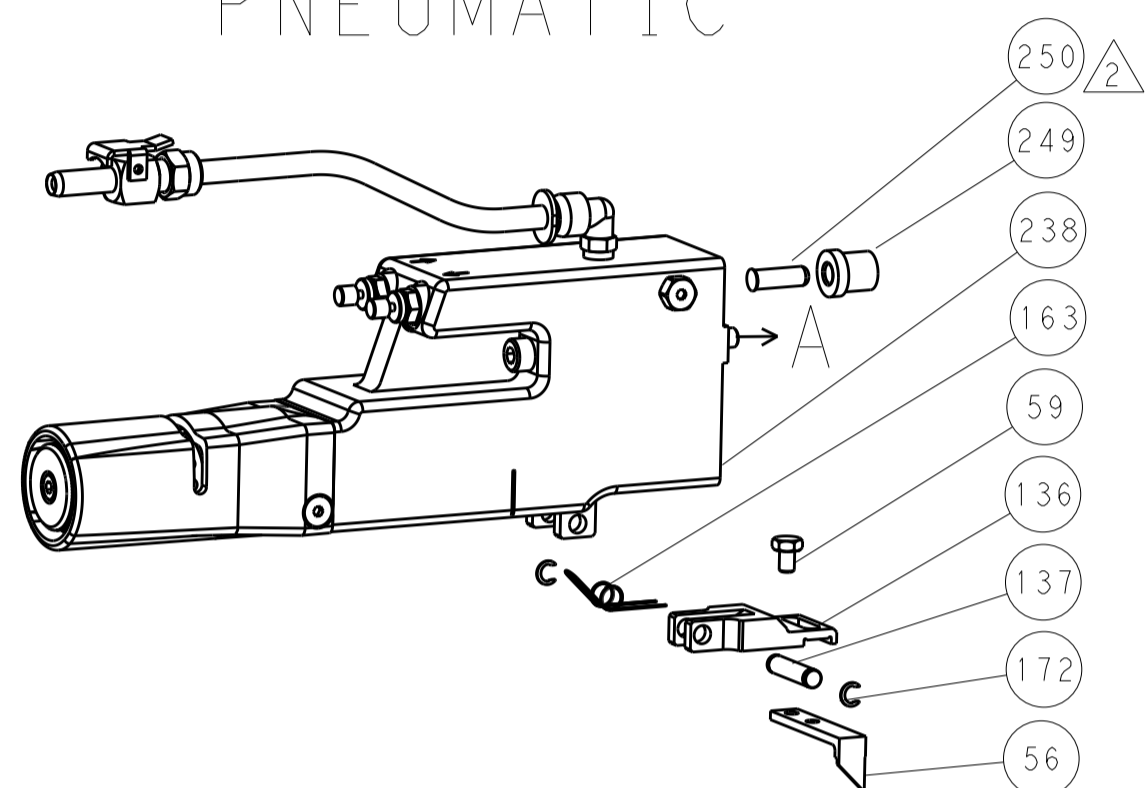
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG NO		REV	
mm	0 PLC ±	1 PLC ±	2 PLC ±	18JAN2012	R. KNEPPER	18JAN2012	T. ELBIN
	3 PLC ±	4 PLC ±	ANGLES ±	18JAN2012	M. CLIFFORD		
MATERIAL	FINISH	WEIGHT	SCALE	Customer Accessible Production Drawing			
			1:2	SHEET 3 OF 4			



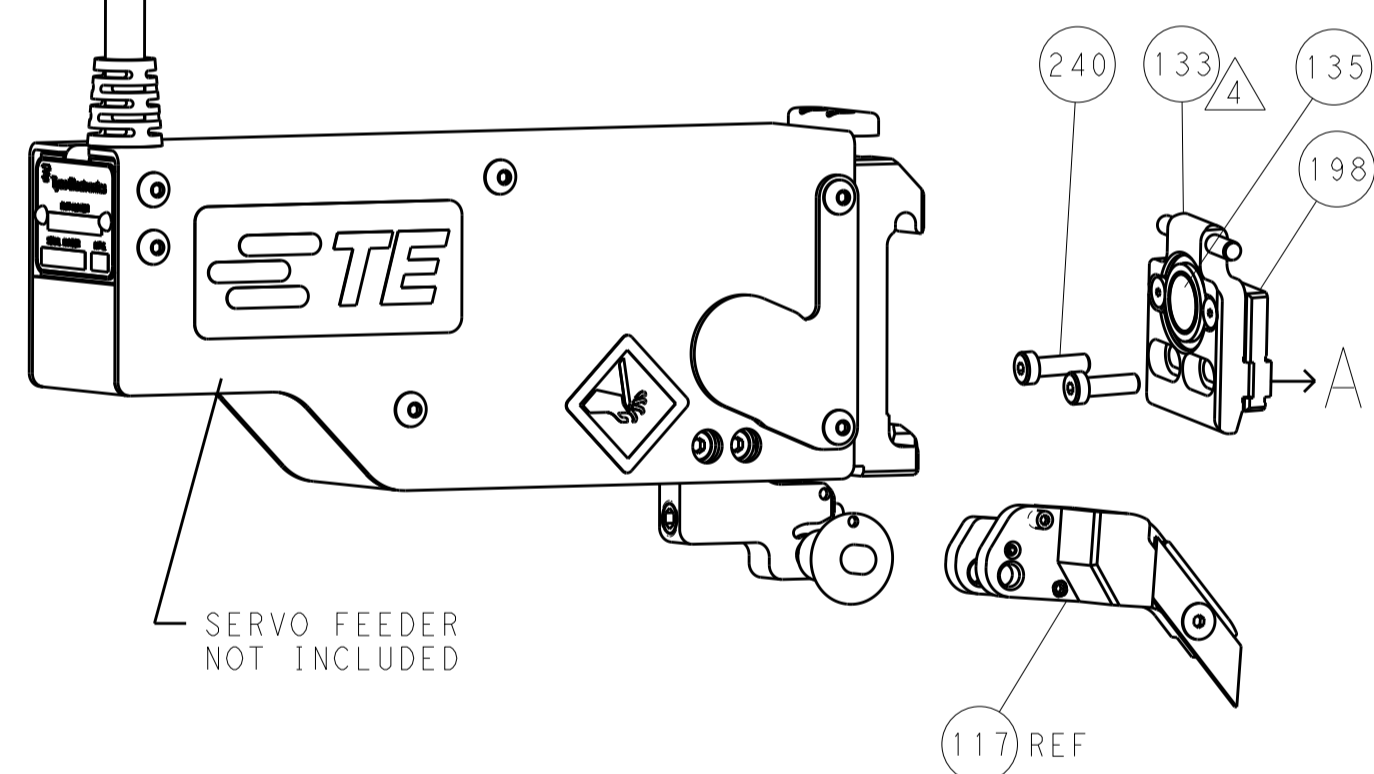
Ocean Side Feed Applicator

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

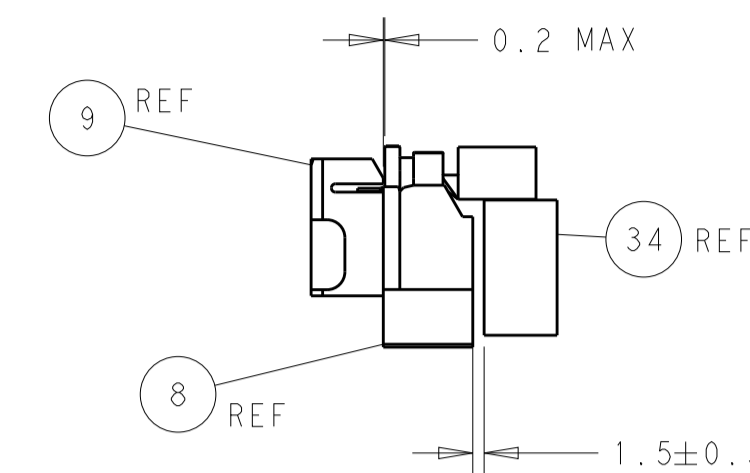
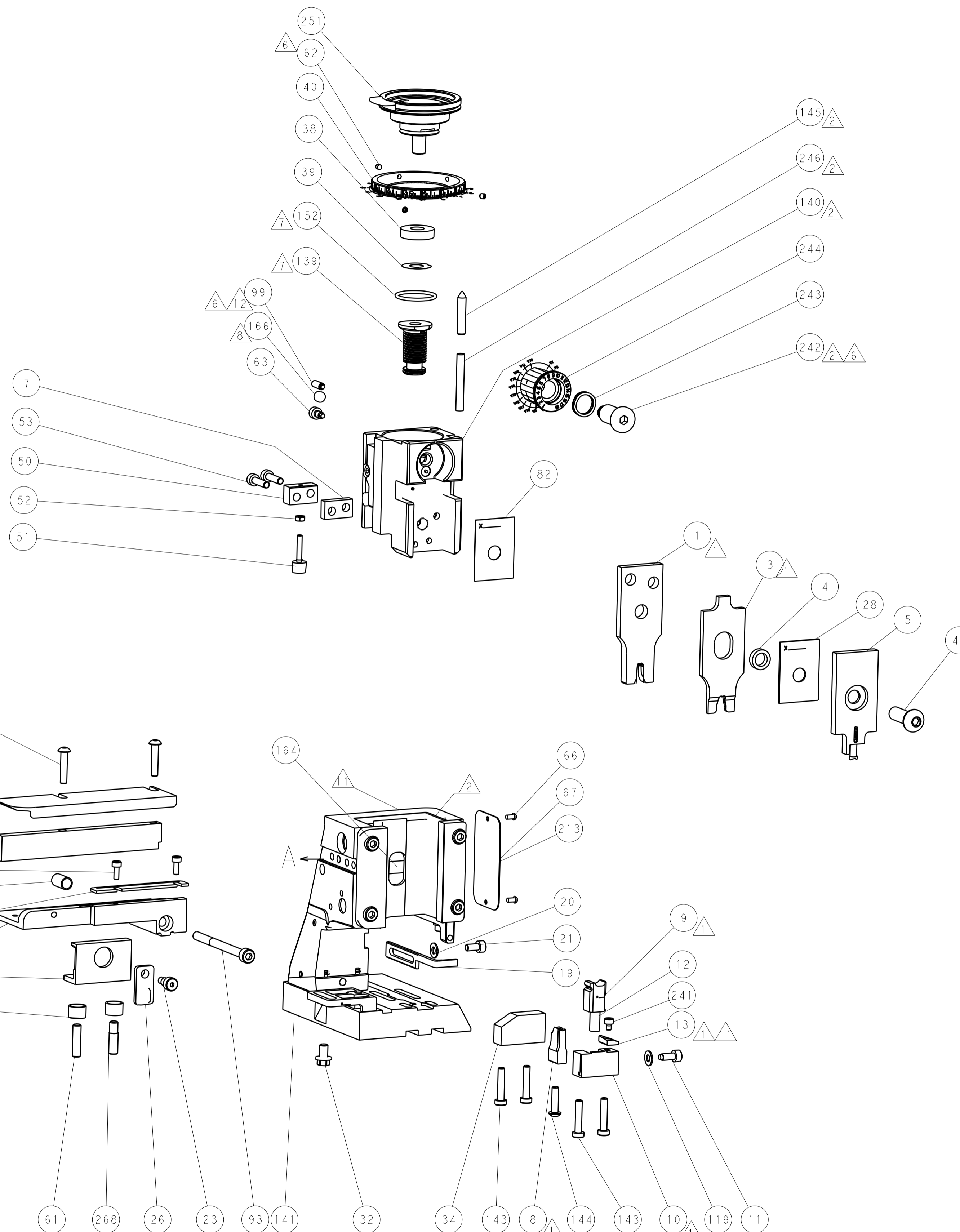
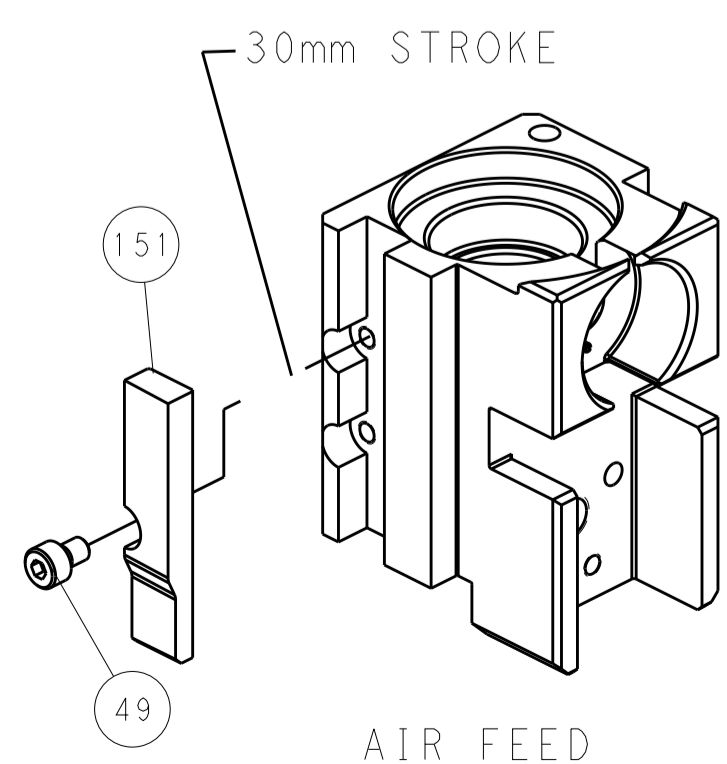
FEED TYPE PNEUMATIC



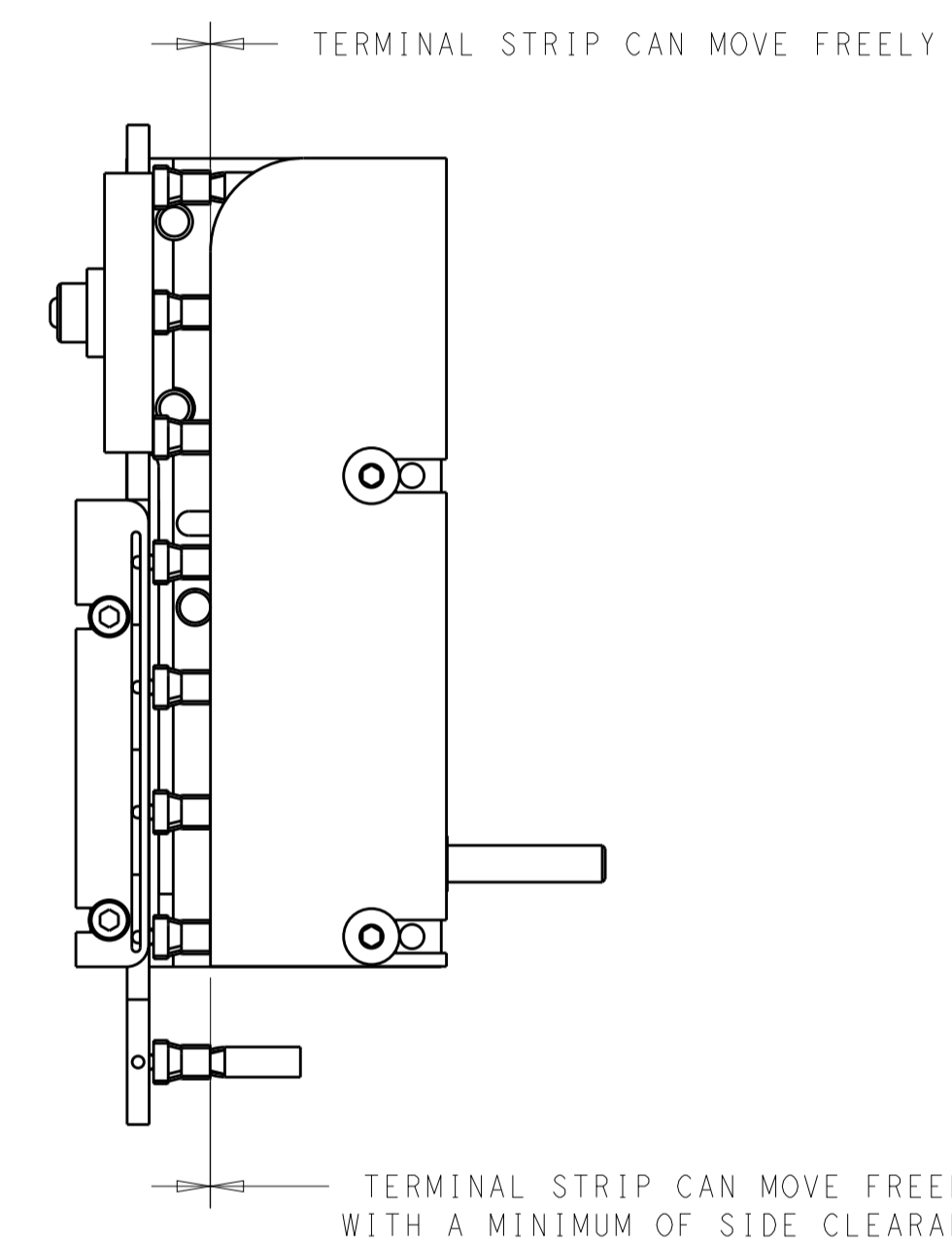
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION

ITEM 30 LOCATED AT REAR HOLES

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:	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151551 SCALE: 1:2 SHEET: 4 OF 4 REV: G