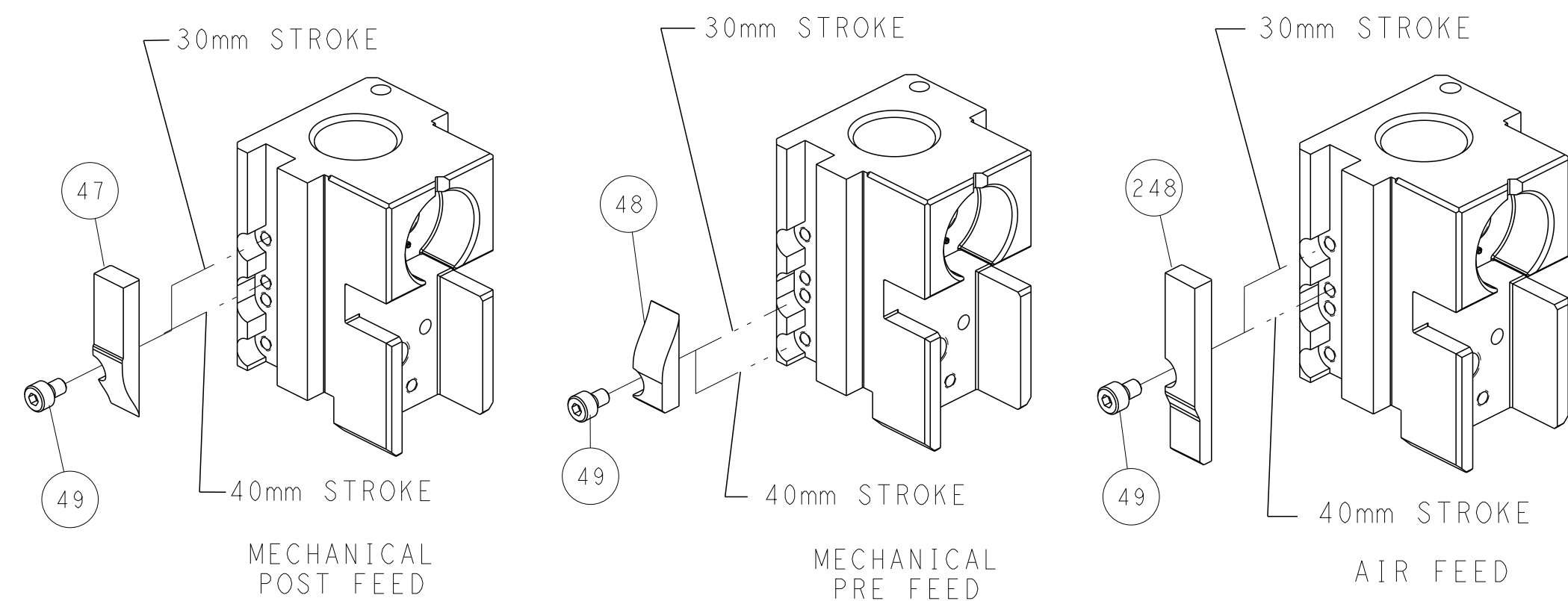
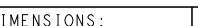




ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN C. MOYER 25AUG2011 CHK T. ELFIN 25AUG2011		 TE Connectivity	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.5°		NAME Ocean Side Feed Applicator	
		APVD T. ELFIN 25AUG2011 PRODUCT SPEC - APPLICATION SPEC -		SIZE - CAGE CODE - DRAWING NO C-2151488	
MATERIAL - FINISH -		WEIGHT -		RESTRICTED TO -	
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING			
		SCALE 1:2 SHEET 2 OF 4 REV B			

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION
		2-2151488-1	B
		2-2151488-2	B
		2-2151488-5	B
		2-2151488-7	B
		7-2151488-7	A
		DESCRIPTION	
		FINE CRIMP HEIGHT ADJUST	
		FINE CRIMP HEIGHT ADJUST	
		FINE CRIMP HEIGHT ADJUST	
		FINE CRIMP HEIGHT ADJUST	
		CRIMP TOOLING KIT	
APPLICATOR DATA			
CRIMP	SIZE	TYPE	
WIRE	1.07 mm [.042]	F	
INSUL	1.58 mm [.062]	O	
APPLICATOR INSTRUCTIONS 408-10389			
TERMINAL DATA: TE TERMINAL			
TE CRIMP SPECIFICATION			
TERMINAL NAME: AMPMODU CRIMP SNAP-IN 22-26 AWG			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.18-3.96 mm [.125-.156 IN]		Ø0.00-1.52 mm [.000-.060 IN]	
TERMINAL		-	
		-	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMPMODU CRIMP SNAP-IN 22-26 AWG			
WIRE STRIP LENGTH 3.18-3.96 mm [1.25-.156 IN]		INSULATION DIAMETER RANGE Ø0.00-1.52 mm [0.00-.060 IN]	
TERMINAL APPLICATION SPECIFICATION		114-25038	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
104480-2	104480-3	104480-4	1-104480-2
1-104480-3	1-104480-7		

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
22 AWG			0.91+/-0.05 [0.036+/-0.002]		8.0
24 AWG			0.81+/-0.05 [0.032+/-0.002]		9.0
26 AWG			0.76+/-0.05 [0.030+/-0.002]		9.7



 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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151488-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151488-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151488-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151488-6

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 ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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.

SET UP GAUGE 2119599-1	REVISIONS					
	P	LYR	DESCRIPTION	DATE	DWN	APVD
	-		SEE SHEET 1	-	-	-

	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	237
-	-	-	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	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	1	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	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	14
-	-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	1	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	1	1-22281-8	SPRING, COMPRESSION	121
-	2	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	119
-	-	-	1	-	-	1901694-1	FEED FINGER ASSEMBLY,SF	118
-	1	1	1	1	1	690438-1	FRONT STRIP GUIDE	96
-	4	4	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	240641-2	SPACER	81
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1	1338683-1	FEED PAWL	56
-	2	2	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	53
-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	31
-	1	1	1	1	1	1901091-1	PLATE, REAR STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1	189124-7	GUIDE, FRONT STRIP	24
-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	690518-1	HOLD DOWN, TERMINAL	18
-	1	1	1	1	1	690463-1	FLOATING SHEAR, REAR	17
-	2	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1	1	1	1-690691-3	PLATE,REAR SHEAR	15
-	1	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	2	2	2	2	2	2119806-1	INSERT, SHEAR	13
-	2	2	2	2	2	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	4-1633139-8	ANVIL, COMBINATION	8
-	1	1	1	1	1	690468-2	DEPRESSOR SHEAR, REAR	6
-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	2119784-5	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	1	1	2-1633730-7	CRIMPER, WIRE	1
-77	-27	-25	-22	-21		PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWG C. MOYER 25AUG2011 CHK T. ELBIN 25AUG2011 APVD T. ELBIN 25AUG2011		 TE Connectivity	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator SIZE A1	
MATERIAL -		FINISH -		PRODUCT SPEC - APPLICATION SPEC - WEIGHT -	
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2 SHEET 3 OF 4 REV B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

4805 (3/13)

*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	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	1803259-1	BUSHING, FLANGED	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	2	2	2	2	18023-1	SCR, SKT HD CAP M3 X 5.0	241
-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

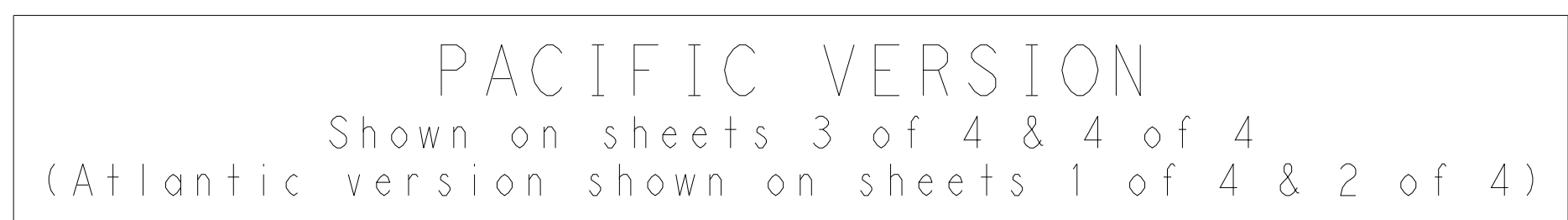
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

PNEUMATIC

Diagram illustrating the assembly of a pneumatic cylinder. The main components are shown in an exploded view, with callouts indicating the following parts:

- 250: End cap/rod end fitting
- 249: End cap/rod end fitting
- 238: End cap/rod end fitting
- 163: Piston rod
- 59: Piston rod seal
- 136: Piston rod seal
- 137: Piston rod seal
- 172: Piston rod seal
- 56: Piston rod seal
- C: Piston rod seal
- 40: Piston rod seal
- 137: Piston rod seal
- 163: Piston rod
- 238: End cap/rod end fitting
- 249: End cap/rod end fitting
- 250: End cap/rod end fitting

SERVO FEEDER NOT INCLUDED



THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN C. MOYER 25AUG2011 CHK T. ELBRIN 25AUG2011		 TE Connectivity	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
		APVD T. ELBRIN 25AUG2011 PRODUCT SPEC APPLICATION SPEC		SIZE -	
MATERIAL -		FINISH -		CAGE CODE -	
		WEIGHT -		DRAWING NO C-2151488	
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2 SHEET 4 OF 4 REV B	