



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:

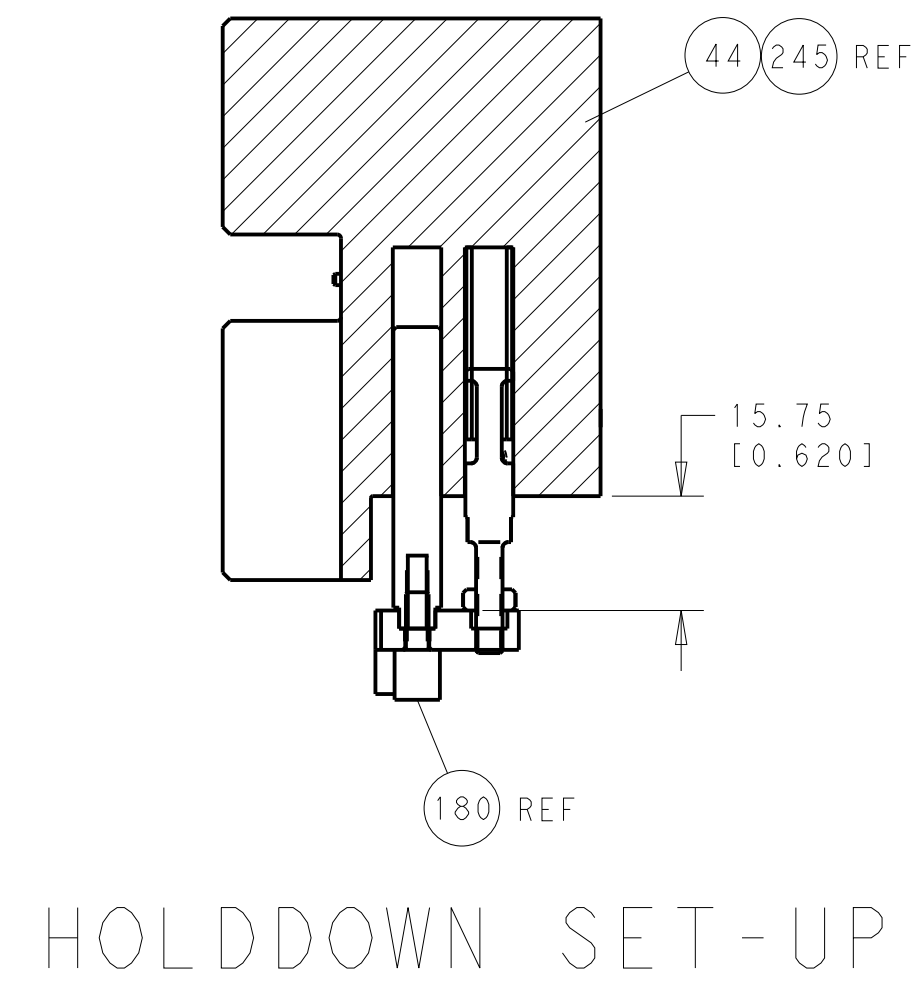
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION:	8-2150439-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION:	8-2150439-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST":	8-2150439-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST":	8-2150439-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
6. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62, 180 & 7. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 7.
7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
8. MAGNET, ITEM 166 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. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
11. THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
12. WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119759-1	RAM, AMP STYLE, END FEED, NON-ADJUST	245
-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

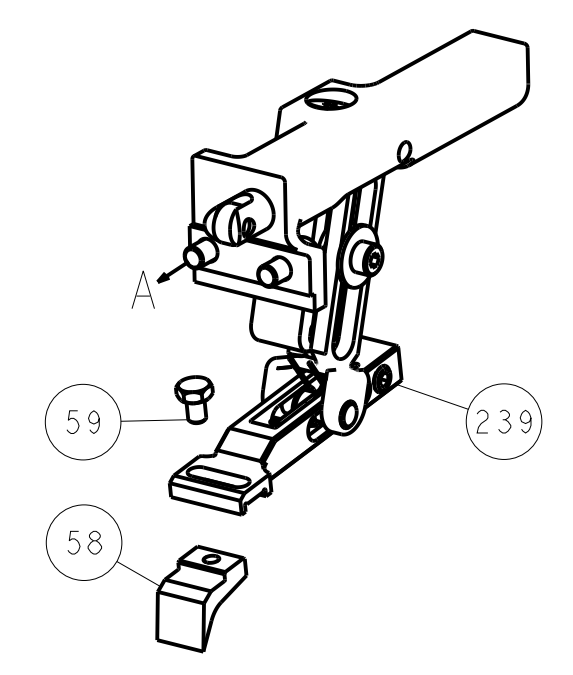
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

					2							1	
SET UP GAUGE 2119599-2					LOC A	DIST 66	REVISIONS						
		F		LTR		DESCRIPTION				DATE	DWN	APVD	
		1				DEVELOPMENT				07MAY2014	YY	UG	
		A				RELEASED				06JUN2014	YY	UG	

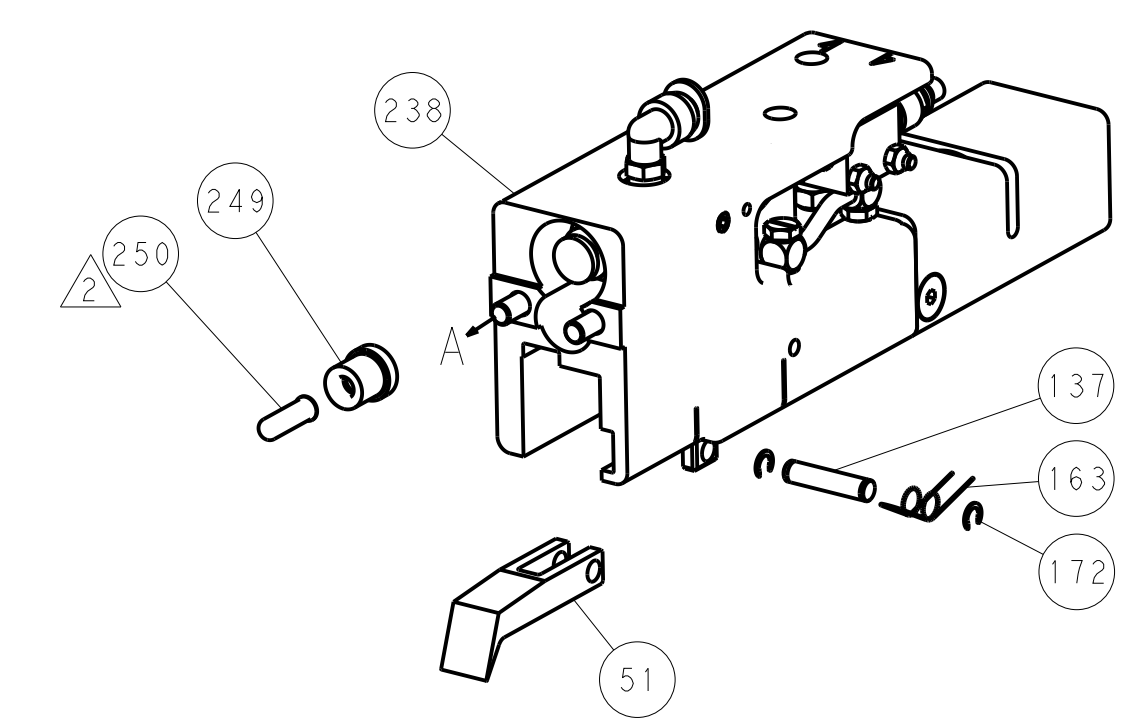
LOC		DIST		REVISONS			
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-



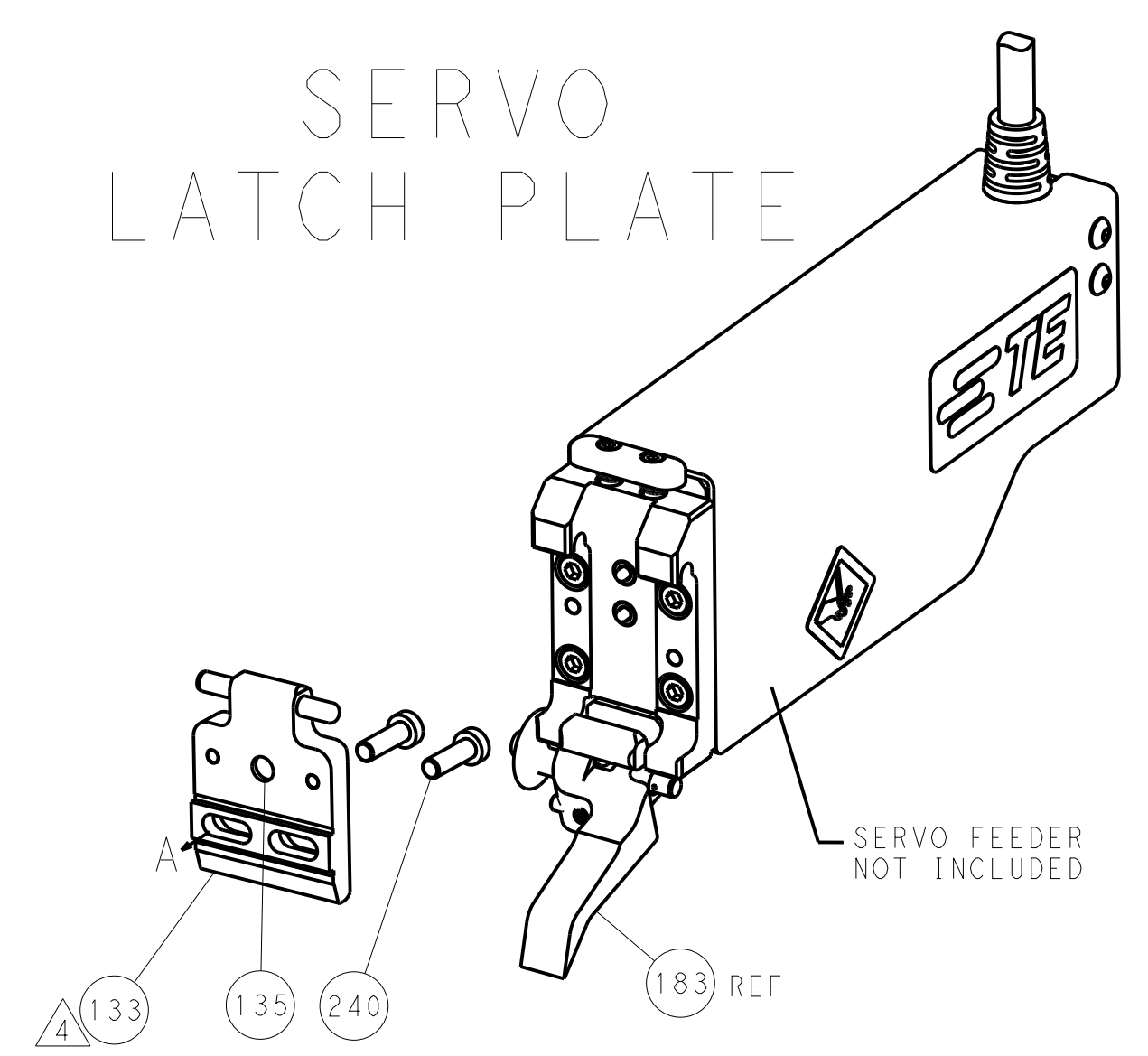
FEED TYPE
MECHANICAL



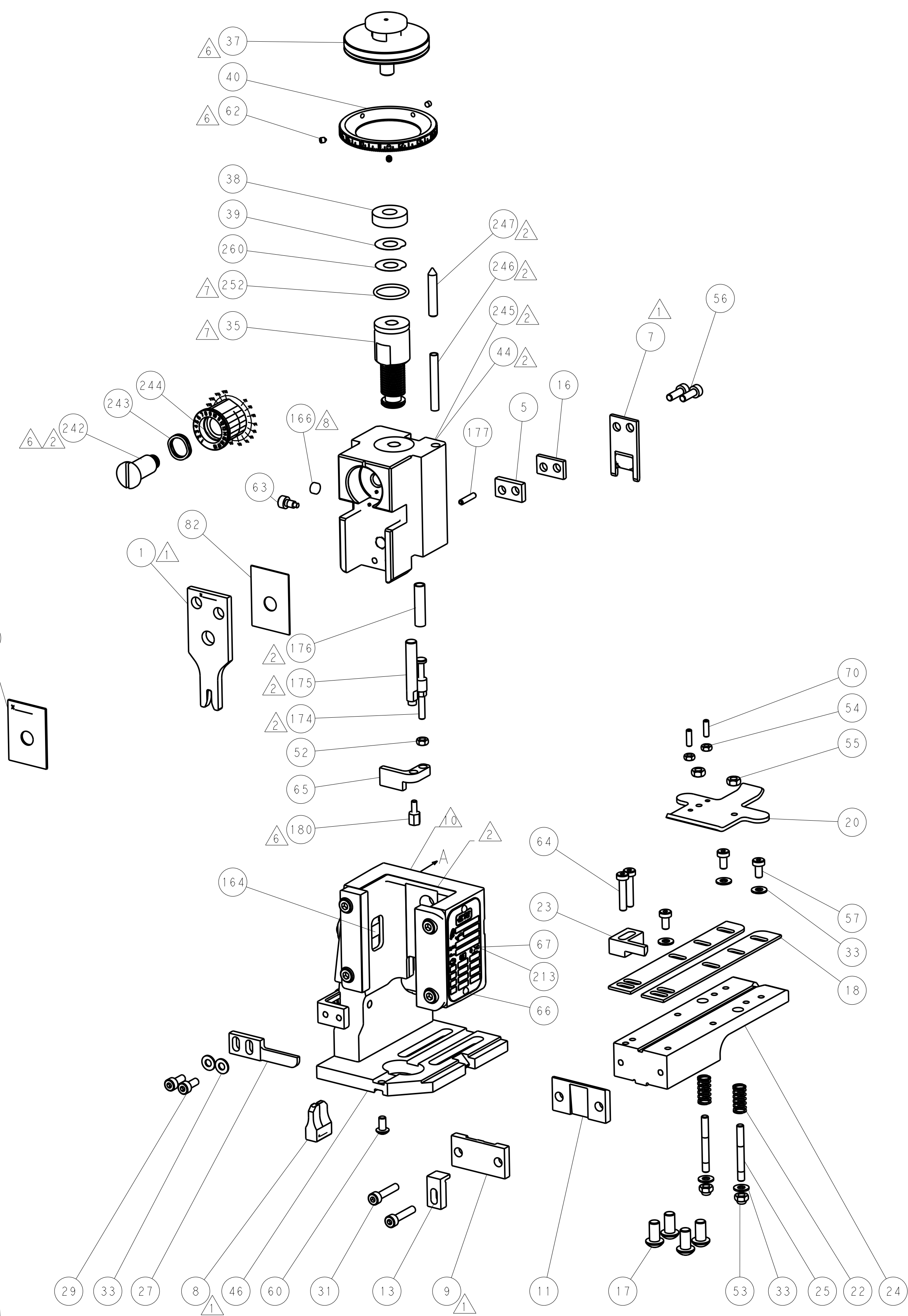
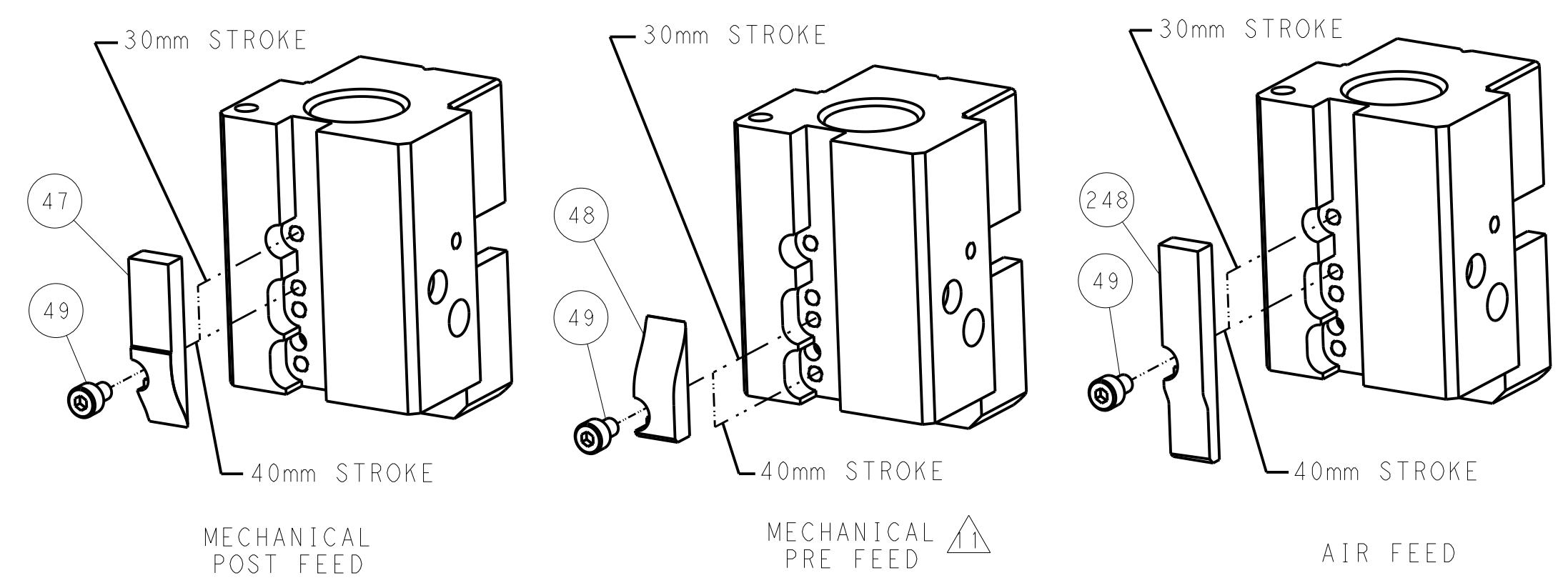
PNEUMATIC



SERVO
LATCH PLATE

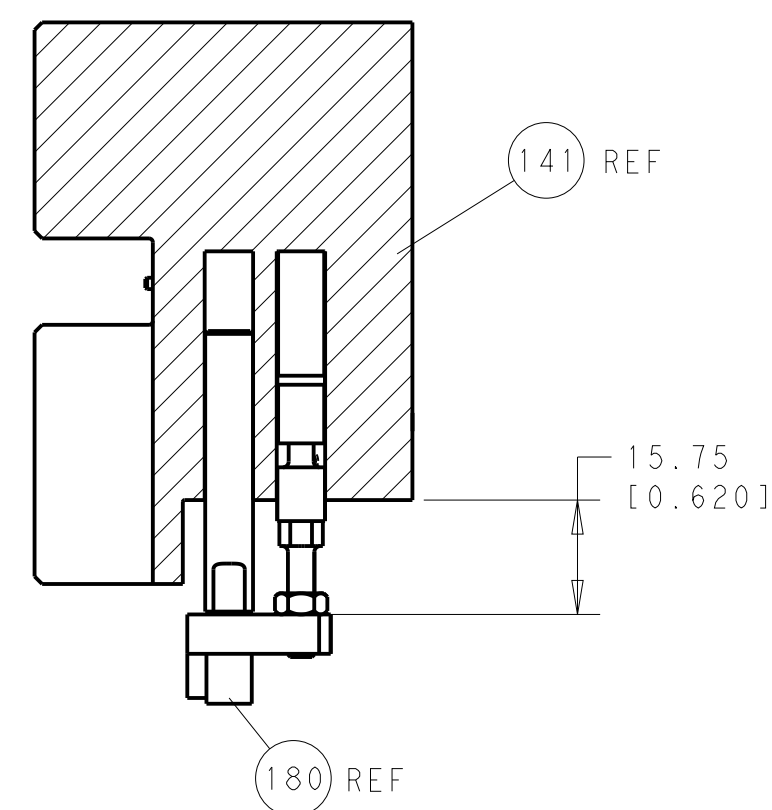


CAM POSITIONS

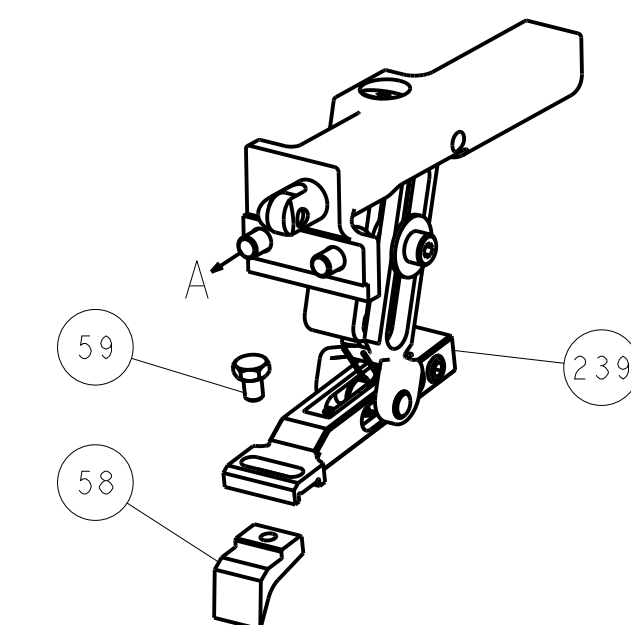
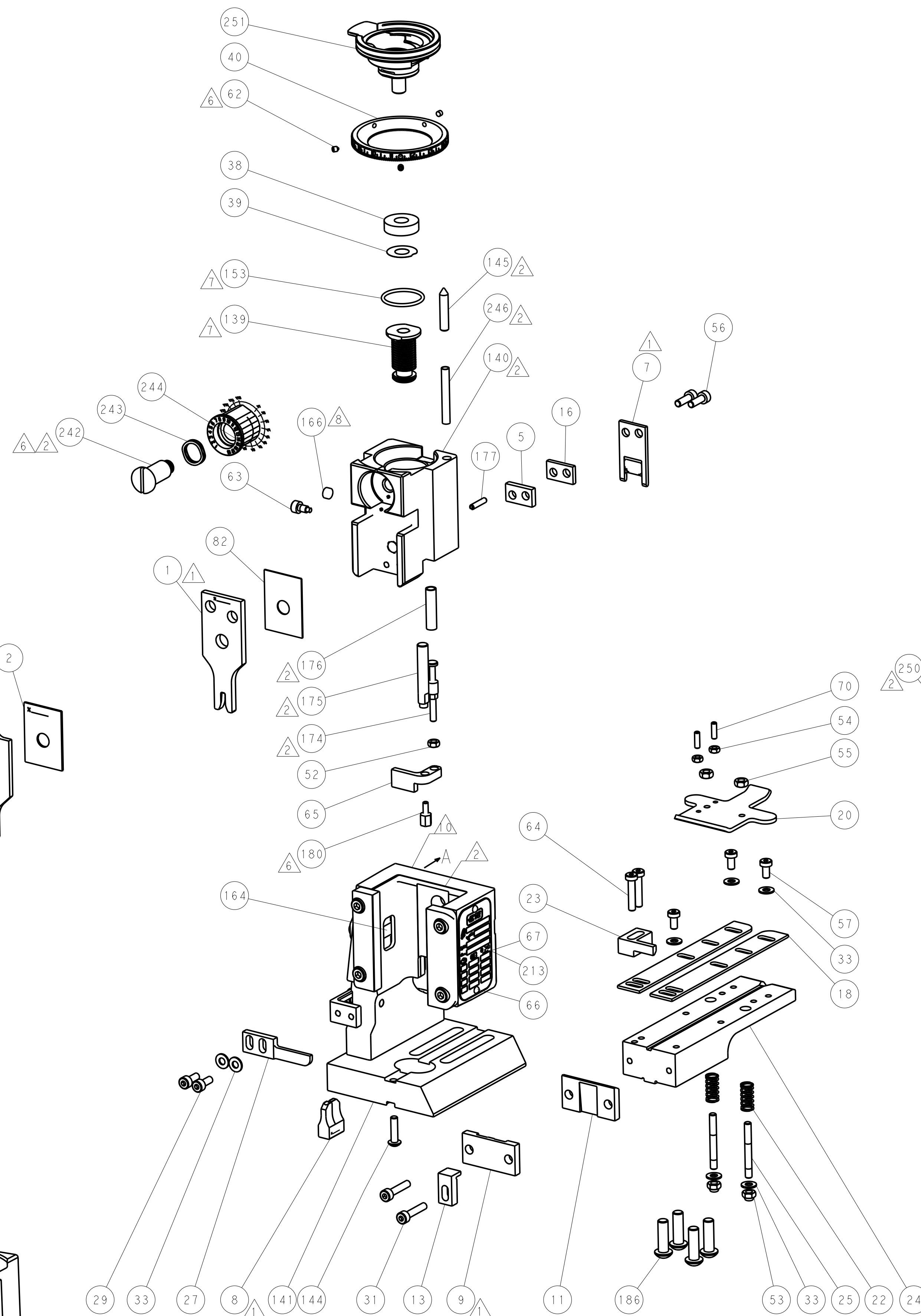


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(Pacific version shown on sheets 3 of 4 & 4 of 4)

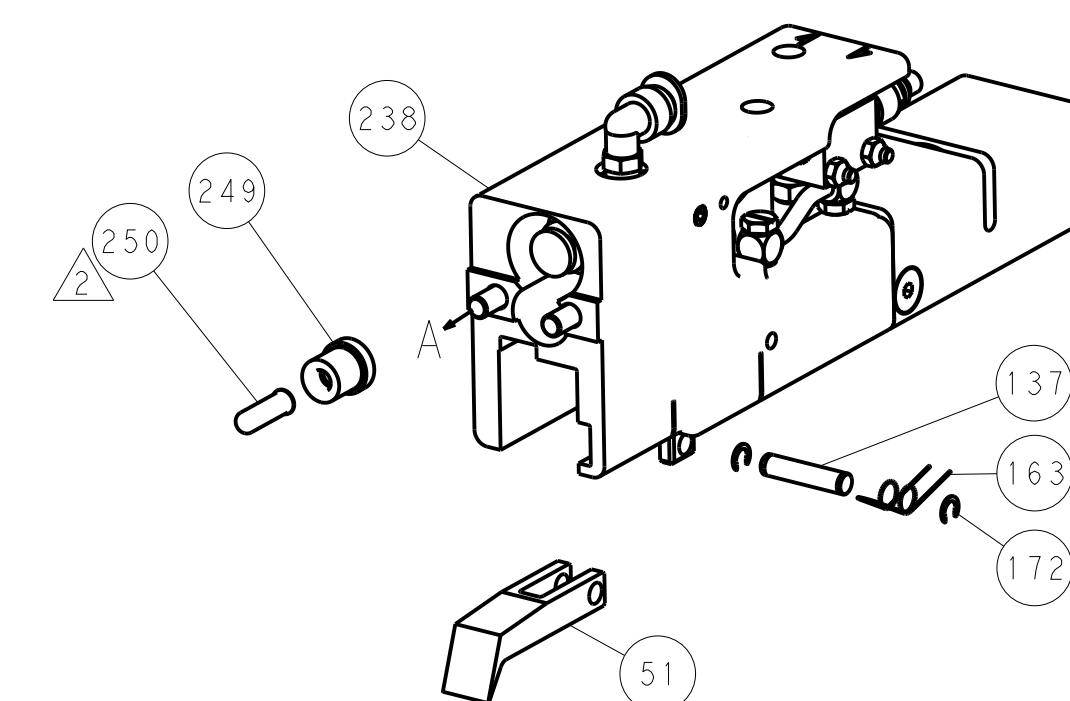
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DIMENSIONS:				CHK G. BAILEY 07MAY2014																					
mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME																			
				APVD U. GUO 07MAY2014		Ocean End Feed Applicator -																			
				PRODUCT SPEC																					
				-																					
				APPLICATION SPEC																					
				-																					
MATERIAL		FINISH		WEIGHT		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO													
						A		00779		C=2150439		-													
Customer Accessible Production Drawing										SCALE		1:1		SHEET		2		OF		4		REV		A	



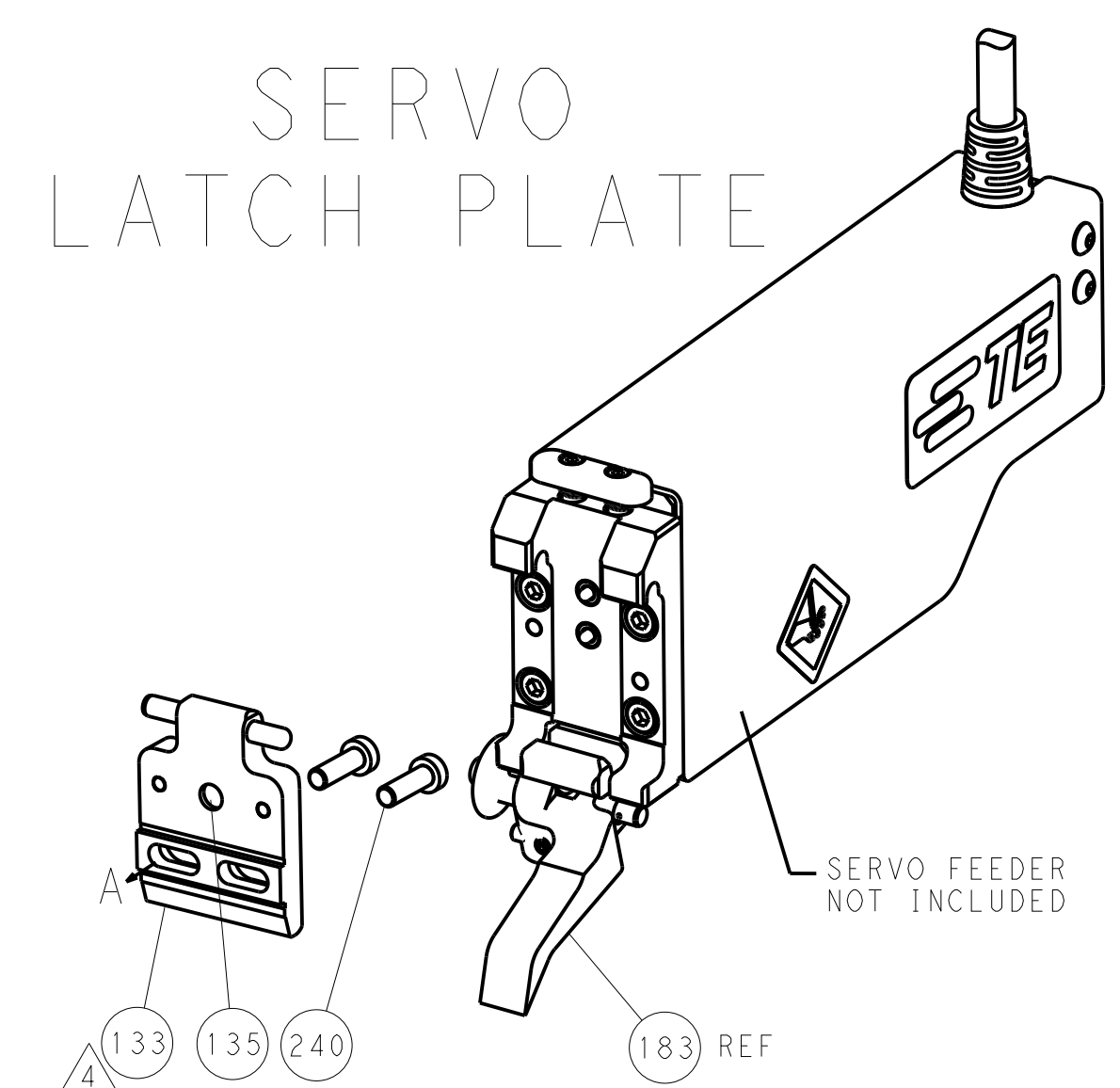
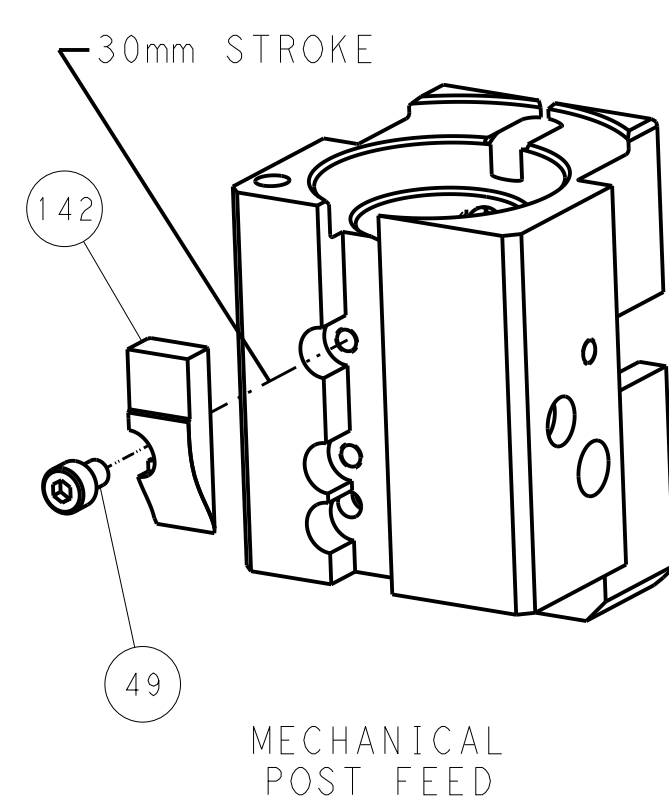
HOLDDOWN SET-UP



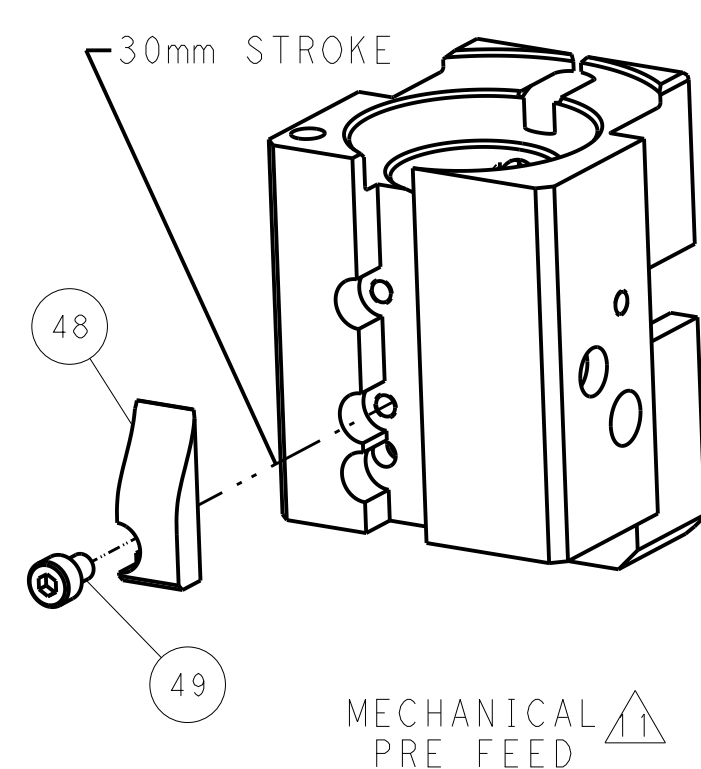
FEED TYPE
MECHANICAL



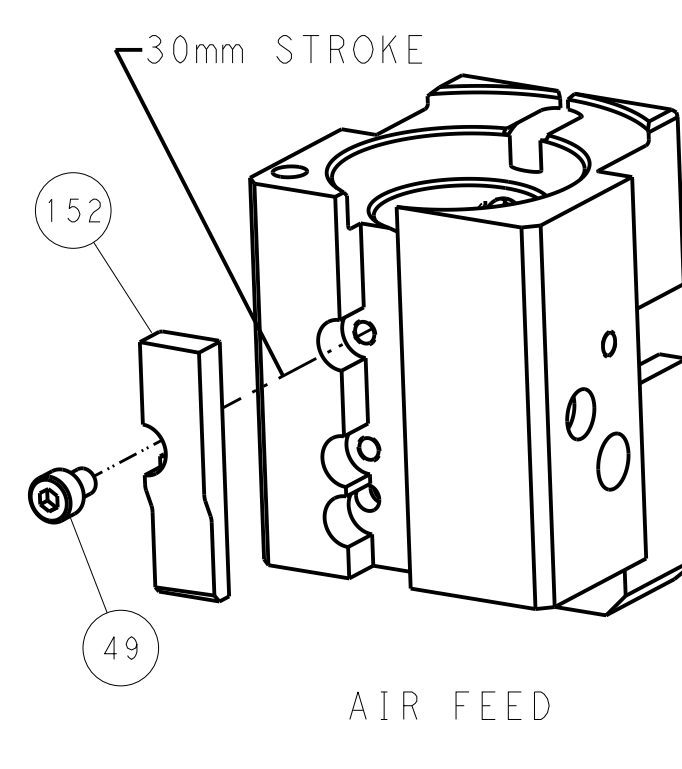
PNEUMATIC

SERVO
LATCH PLATE

MECHANICAL
POST FEED



MECHANICAL PRE FEED



AIR FEED

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

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES		NAME Ocean End Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A 1	
MATERIAL -		FINISH -		DRAWING NO C=2150439	
WEIGHT -		RESTRICTED TO -		SCALE 1:1 SHEET A OF A REV A	
Customer Accessible Production Drawing					