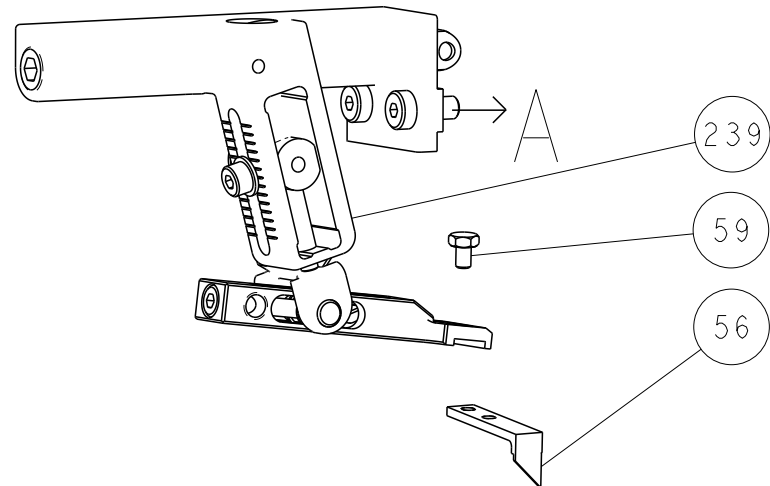
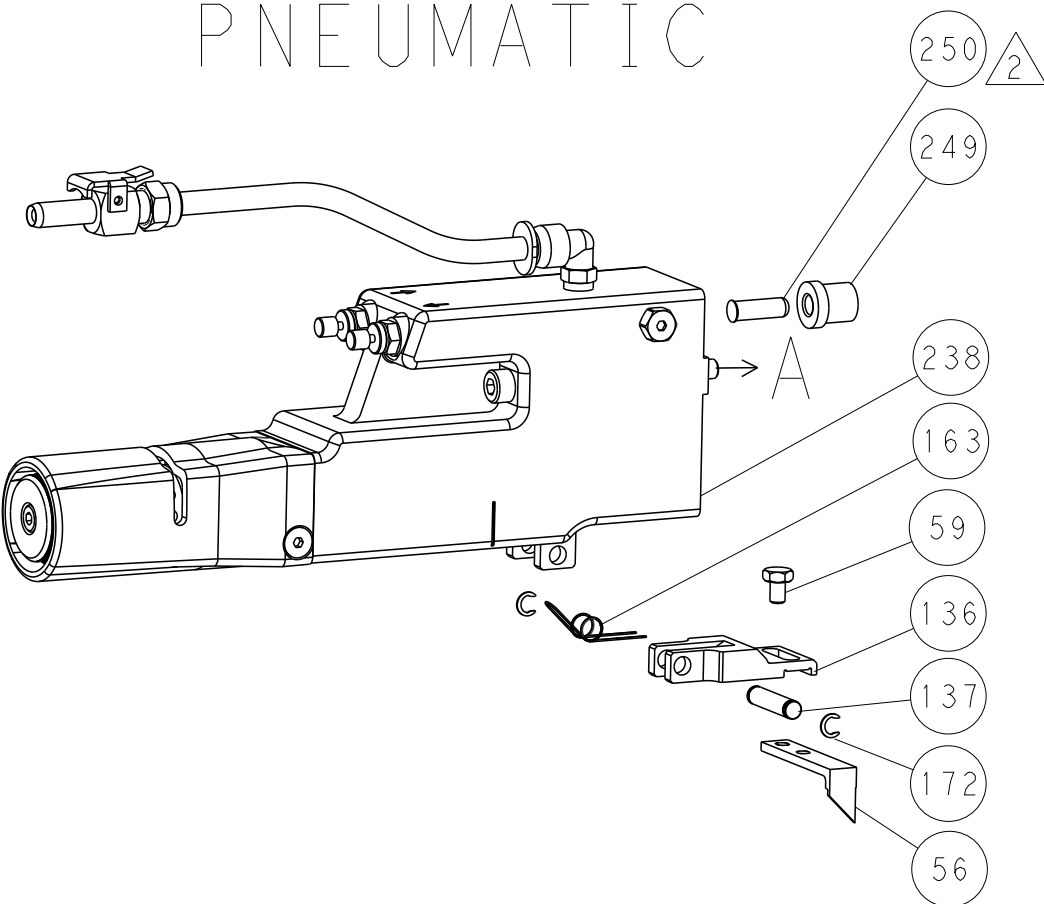


LOC	DIST	REVISIONS				
		P	LTR	DESCRIPTION	DATE	DWN APVD
				rev_sym_1666_8466E111	rev_delete_v_dwn_happr_1	
				rev_sym_2rev_desc_2	rev_delete_v_dwn_happr_2	
				rev_sym_3rev_desc_3	rev_delete_v_dwn_happr_3	
				rev_sym_4rev_desc_4	rev_delete_v_dwn_happr_4	

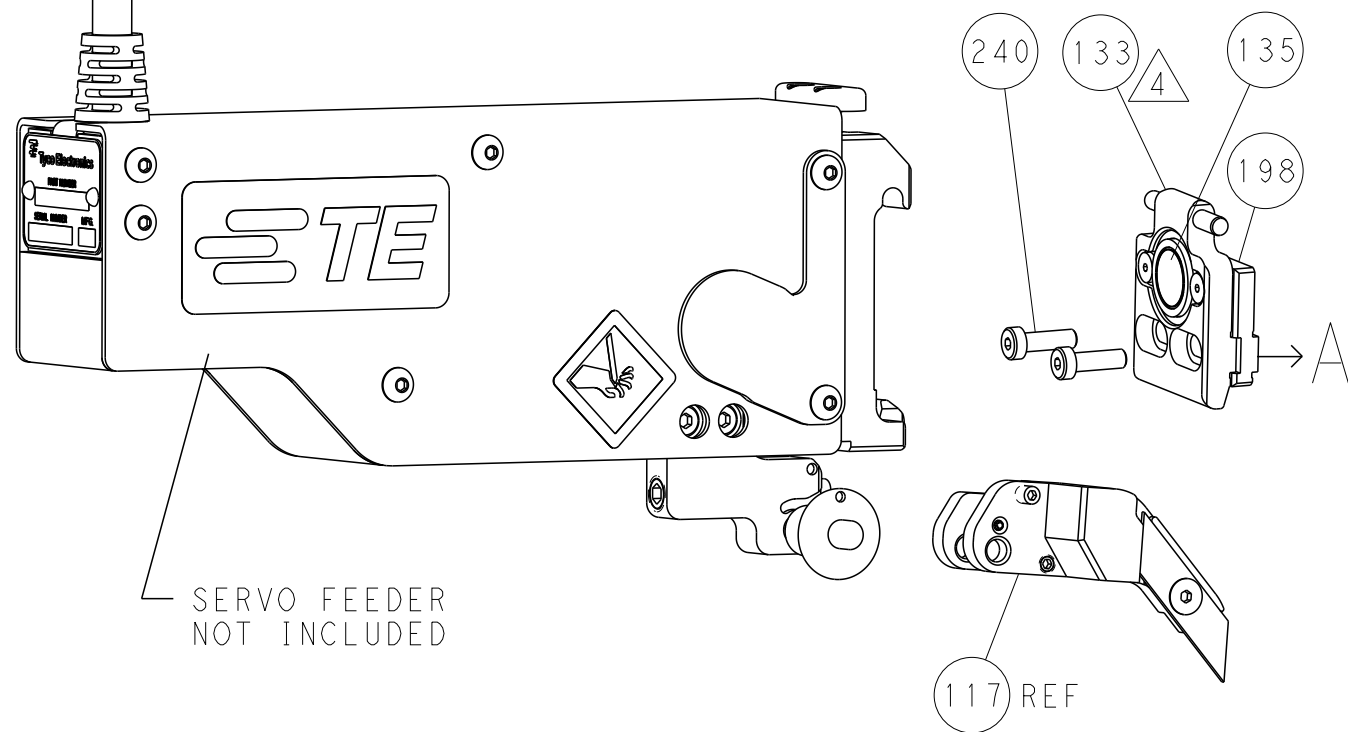
FEED TYPE MECHANICAL



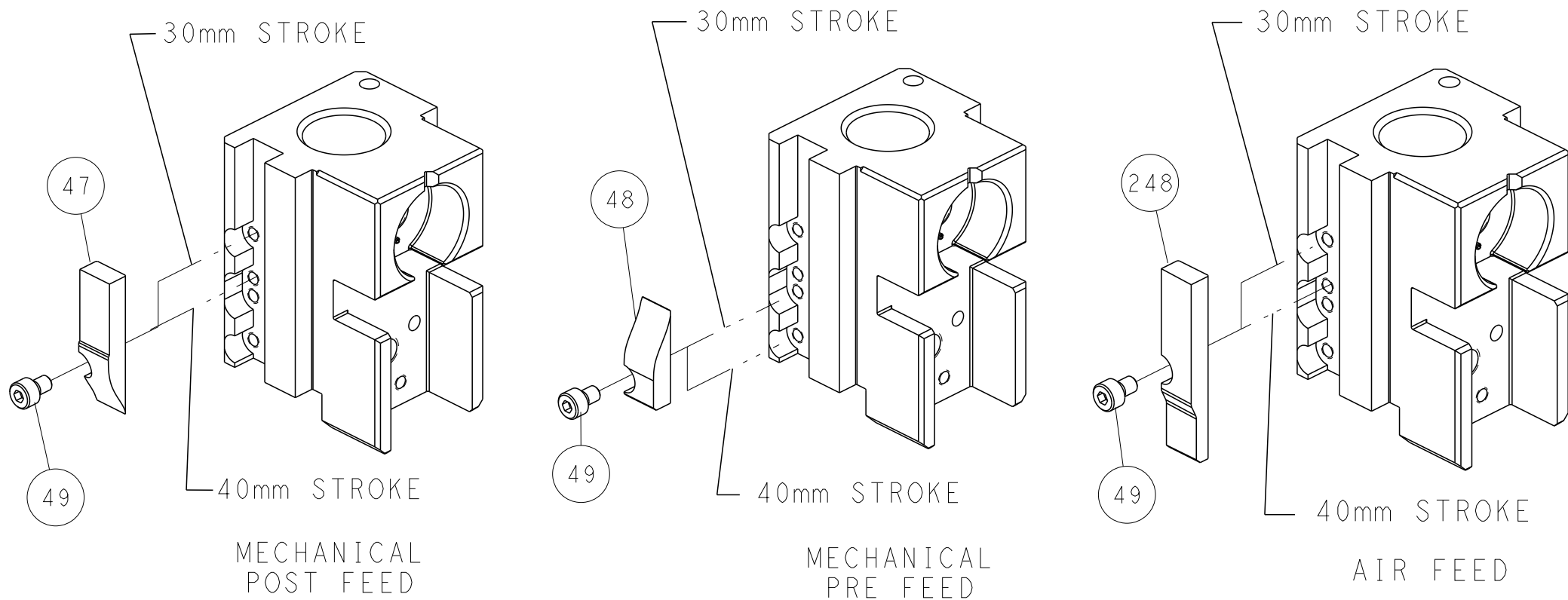
PNEUMATIC



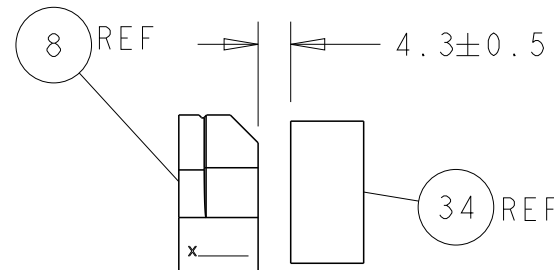
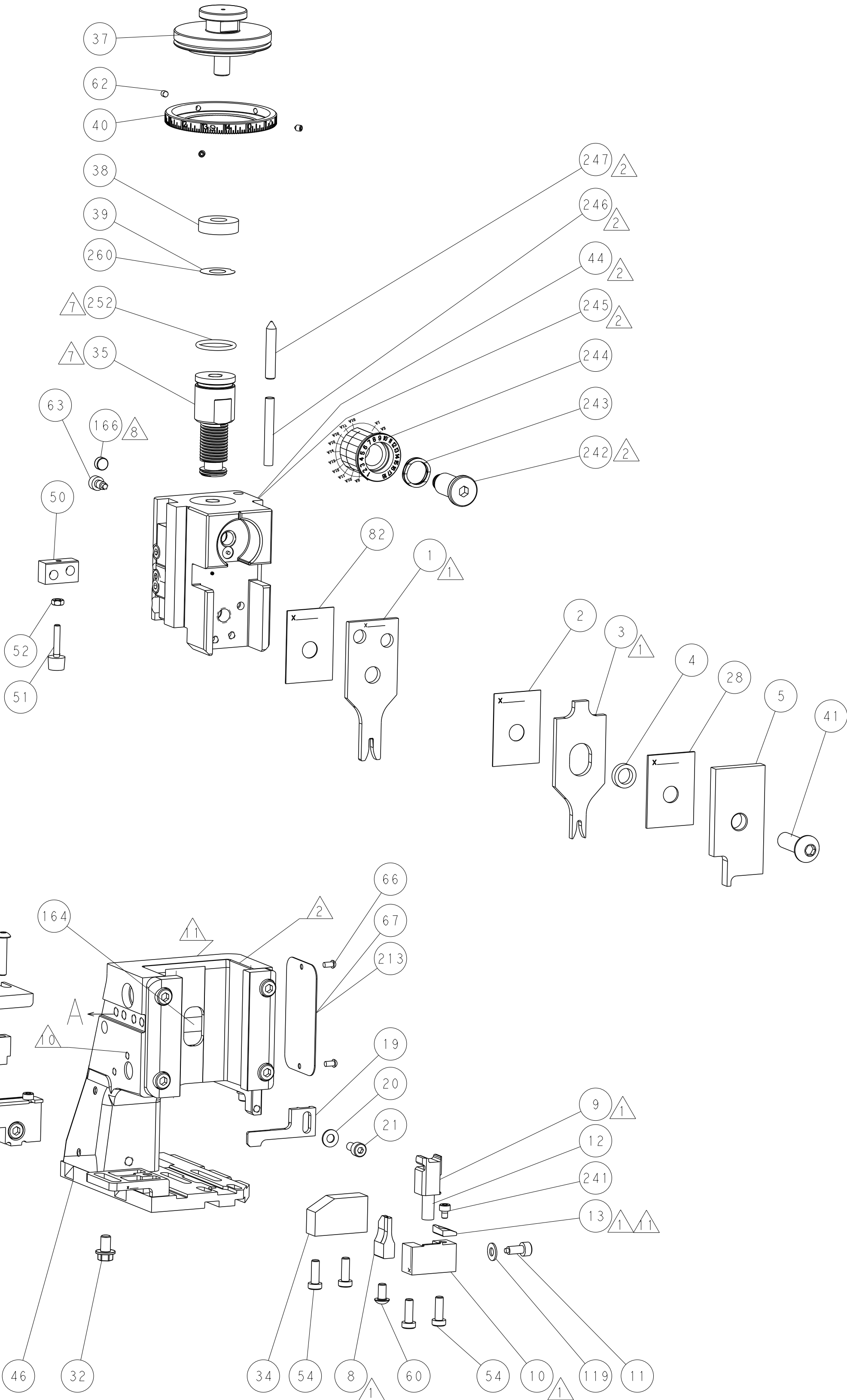
SERVO LATCH PLATE



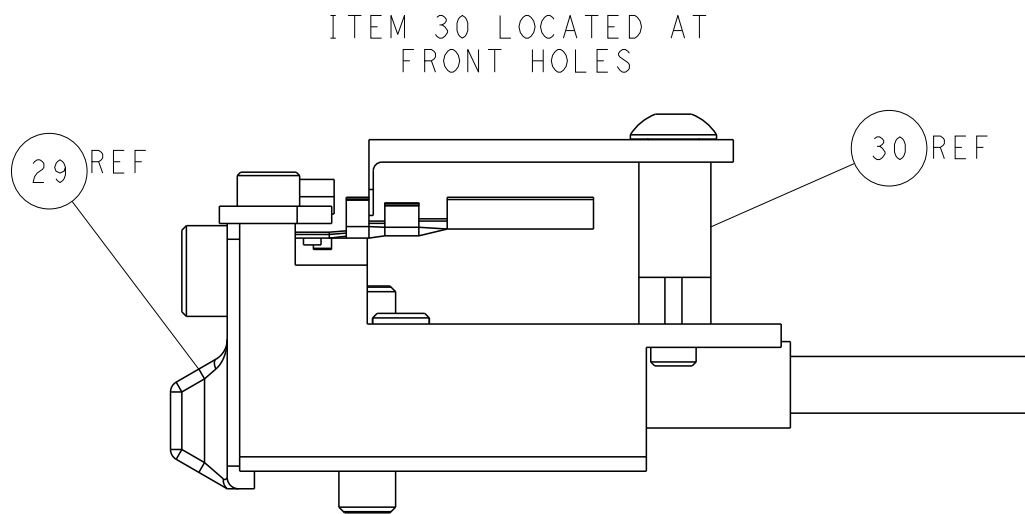
CAM POSITIONS



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

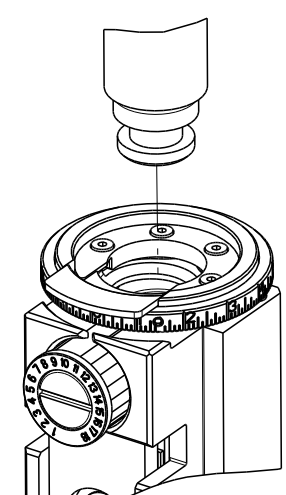


TERMINAL SUPPORT LOCATION

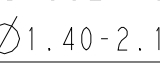


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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				CHK	G. BAILEY	15SEP2011				
				APVD	S. XI	15SEP2011				
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator				
mm				PRODUCT SPEC						

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2151058-1	G	FINE CRIMP HEIGHT ADJUST
	2-2151058-2	G	FINE CRIMP HEIGHT ADJUST
	2-2151058-5	G	FINE CRIMP HEIGHT ADJUST
	2-2151058-7	G	FINE CRIMP HEIGHT ADJUST
	7-2151058-7	F	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.54 mm [.100]	O
APPLICATOR INSTRUCTIONS 408-10389 		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: MICRO TIMER 2 CONTACT			
WIRE STRIP LENGTH  3.80-4.40 mm [.150-.173 IN]		INSULATION DIAMETER RANGE  Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION 	(A) 114-18081	-	-
	(B) 114-18082	-	-
TERMINALS APPLIED ¹			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 964263-2	(A) 964263-3	(B) 964267-2	(B) 964267-1
(B) 964267-3	(B) 964267-4	(A) 1241860-2	(A) 1241860-7

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING 
1.00mm2	1.20+/-0.05 [.047+/-0.002]	7.3
0.75mm2	1.18+/-0.05 [.046+/-0.002]	7.5
0.50mm2	1.15+/-0.05 [.045+/-0.002]	7.7



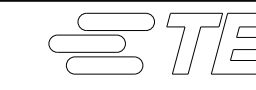
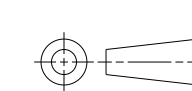
- ¹ RECOMMENDED SPARE PARTS
- ² GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- ⁴ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151058-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151058-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151058-5
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 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.
- ¹⁰ 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.
- ¹² TERMINAL LUBRICATOR IS RECOMMENDED WHEN RUNNING GOLD AND SILVER PLATED TERMINALS.

*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.

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	DIST	REVISIONS			
P	LTR	DESCRIPTION		DATE	DWN	APVD	
rev_sym_1	1666	886EII1		rev_delete	v_dwn	lapp	1
rev_sym_2	2	rev_desc_2		rev_delete	v_dwn	2app	2
rev_sym_3	3	rev_desc_3		rev_delete	v_dwn	3app	3
rev_sym_4	4	rev_desc_4		rev_delete	v_dwn	4app	4

6	-	1	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	1-22279-3	SPRING, COMPRESSION	246
	-	1	1	1	1	2119082-8	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
	-	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	2119580-1	MECHANICAL FEED ASSEMBLY	239
8	-	-	-	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	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	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	2119798-2	DETENT PIN	145
7	-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
	-	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
	-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
	-	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
	-	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
6	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	-	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
1	-	-	-	1	1	1338685-1	PAWL, FEED	56
	-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	1	690753-2	SPACER, TONKER	50
	-	-	-	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	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	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	1-1752356-8	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
	-	1	1	1	1	1320908-3	SPACER, STRIP GUIDE	30
	-	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
	-	1	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	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	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
	1	1	1	1	1	1333204-3	ANVIL, COMBINATION	8
	-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	1	1	1	1	1633965-3	CRIMPER, INSULATION O PREMIUM	3
1	-	1	1	1	1	455888-3	SPACER, CRIMPER	2
	1	1	1	1	1	1803125-9	CRIMPER, WIRE	1

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				CHK G.BAILEY	15SEP2011				
DIMENSIONS:				APVD S.XI	15SEP2011				
mm				PRODUCT SPEC					
				APPLICATION SPEC		NAME Ocean Side Feed Applicator			
MATERIAL				WEIGHT					
-				-		SIZE			
-				-		CASE CODE			
-				-		DRAWING NO			
				Customer Accessible Production Drawing		SCALE		SHEET	
						1:2		3 OF 4	
								REV G	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

