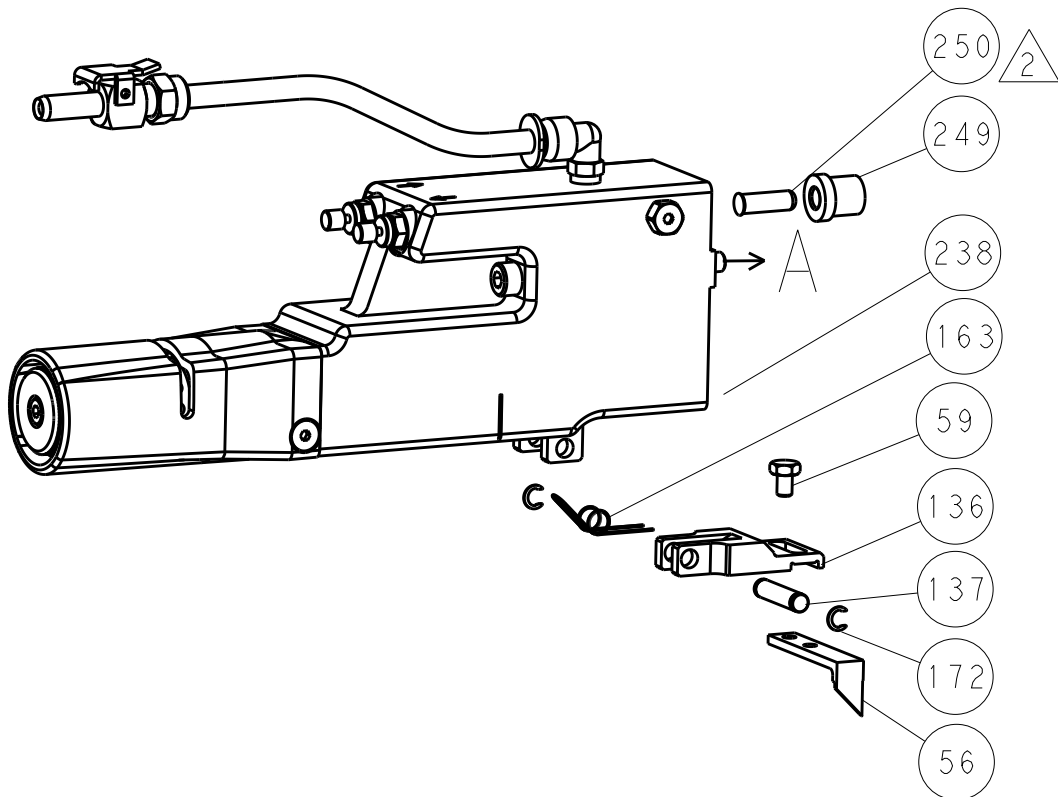
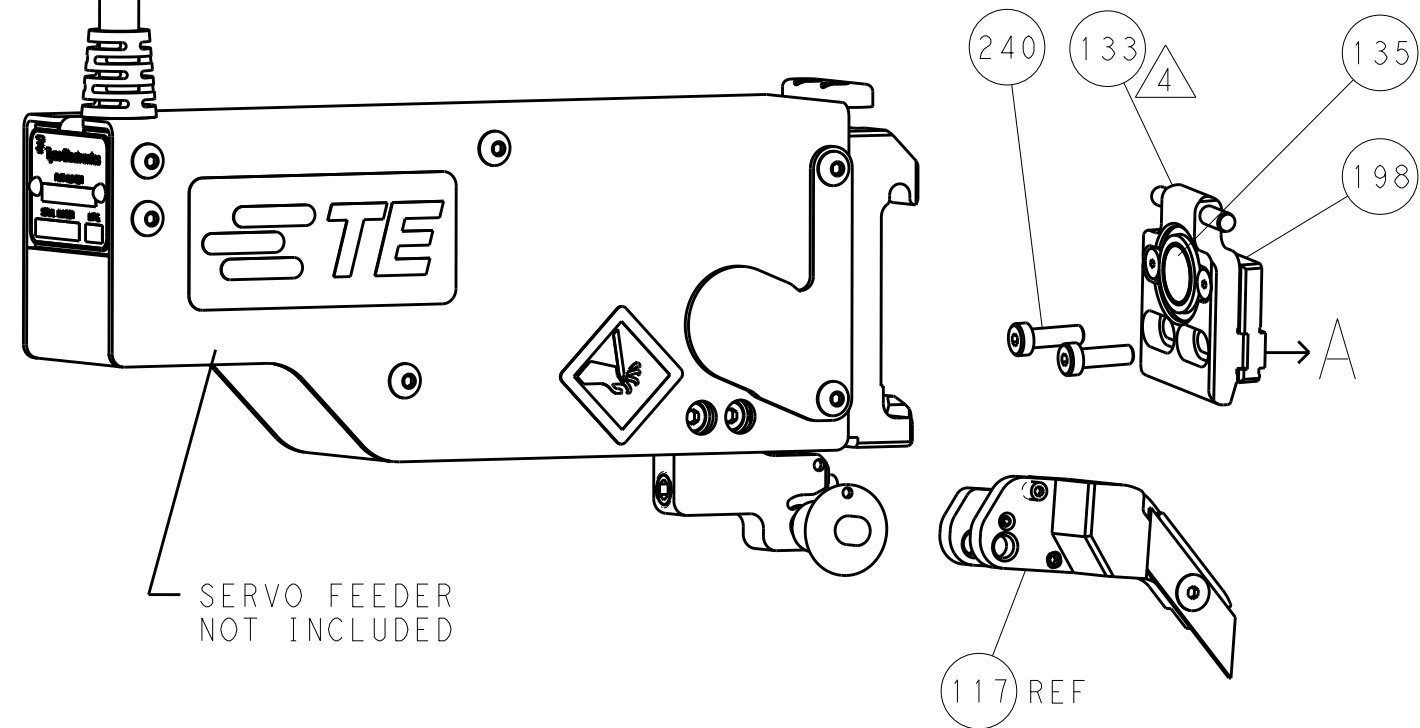


LOC		DIST		REVISIONS			
P	LTR	DESCRIPTION		DATE	DWN	APVD	
-	-	SEE SHEET 1		-	-	-	

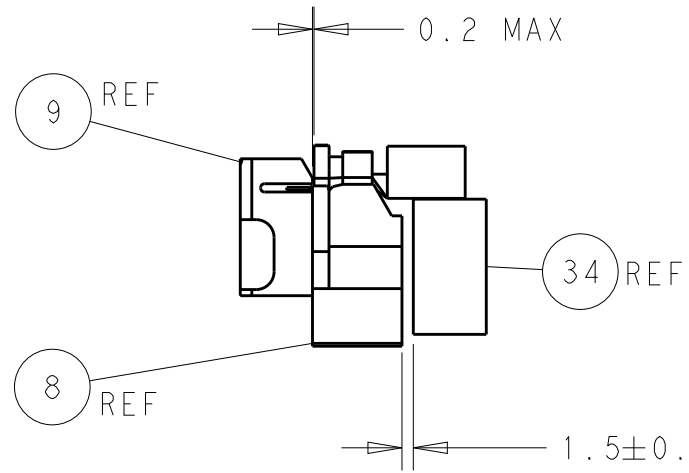
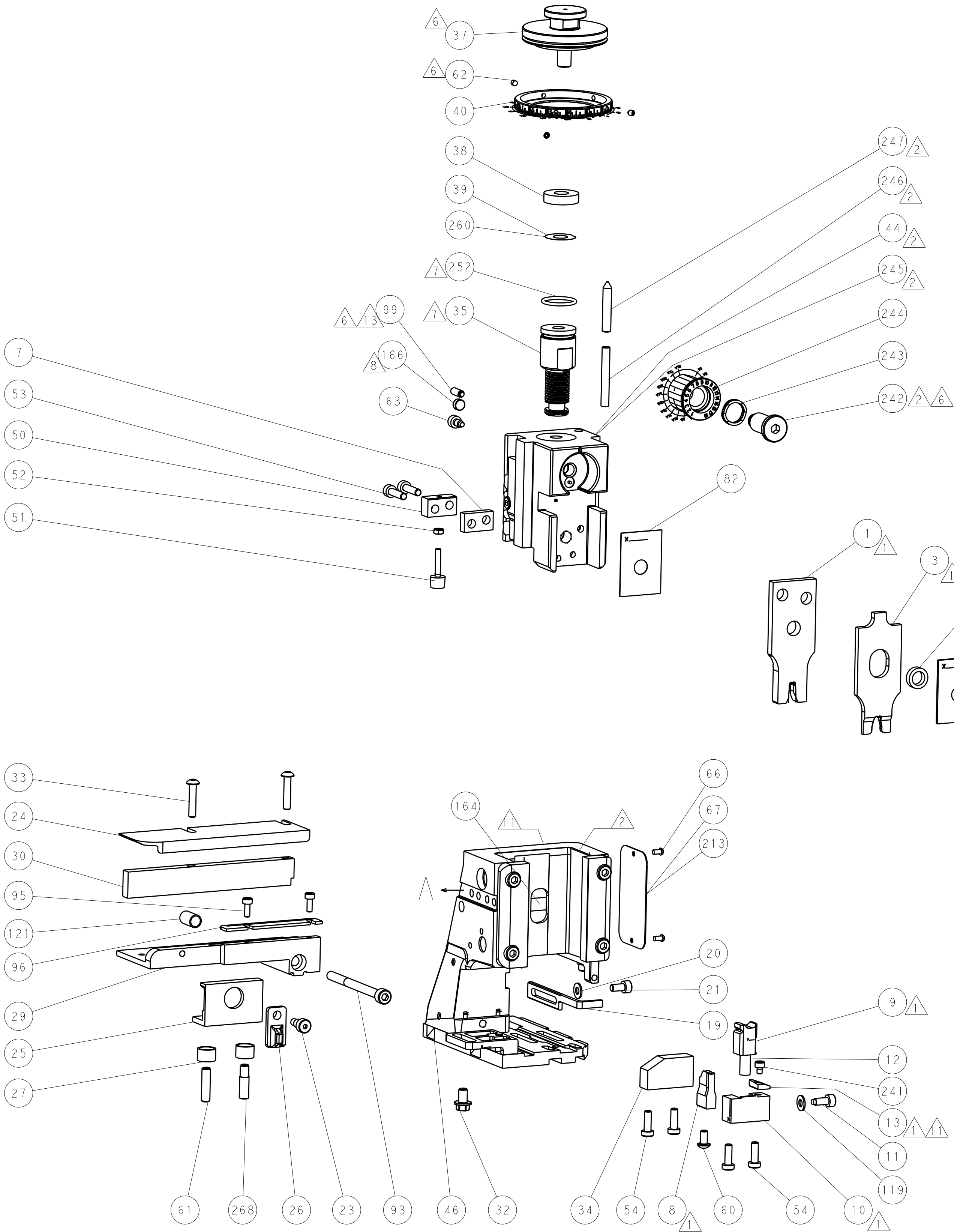
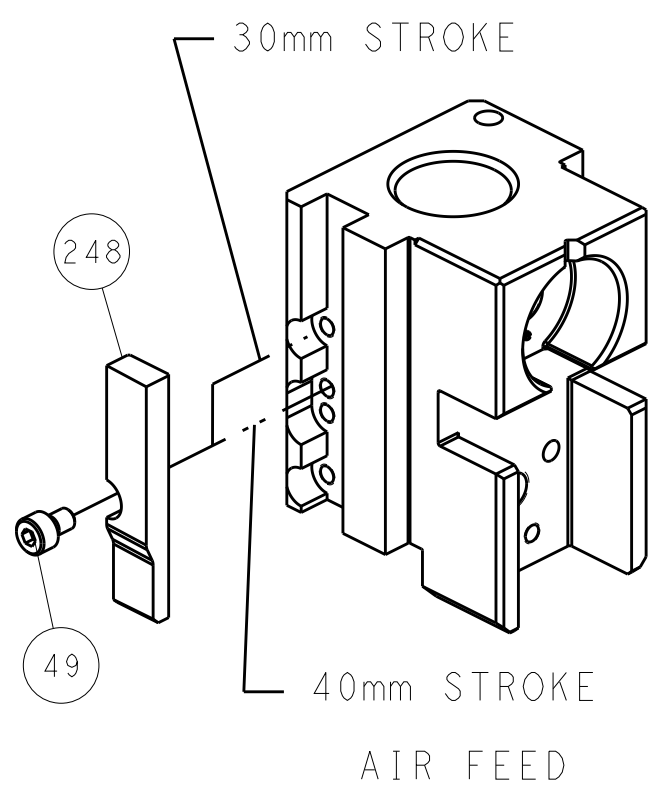
FEED TYPE
PNEUMATIC



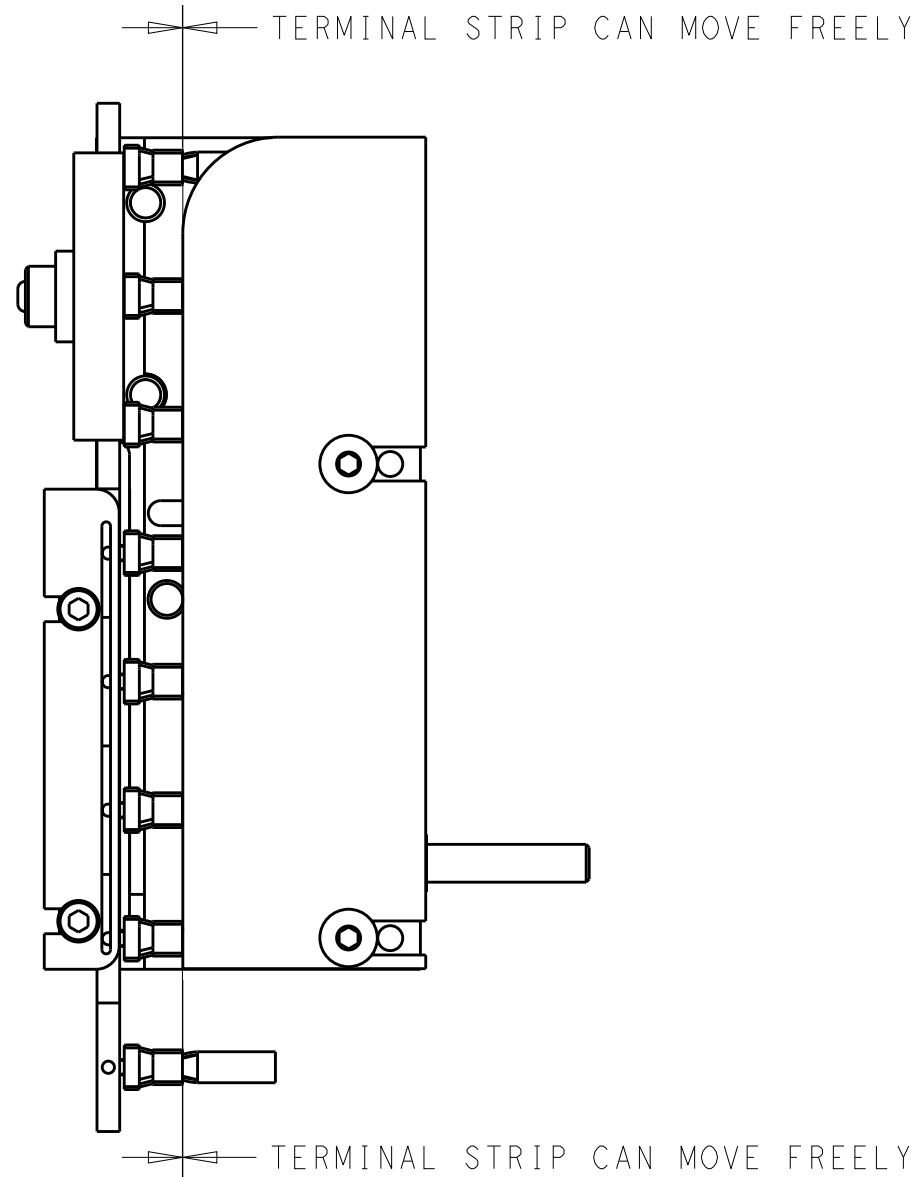
SERVO
LATCH PLATE



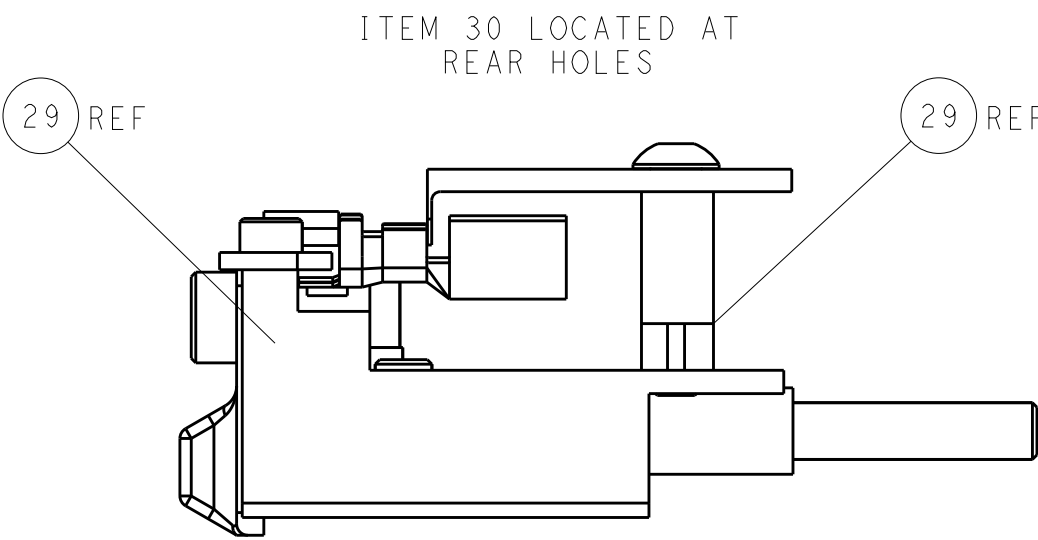
CAM POSITIONS



TERMINAL SUPPORT LOCATION

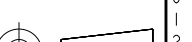


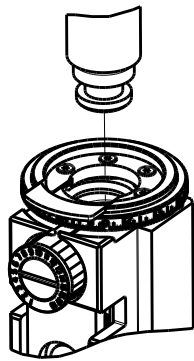
FEED TRACK POSITION



FEED TRACK POSITION
GUIDE BY WIRE BARREL

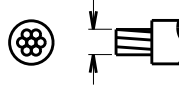
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

1. NOT DRAWN TO SCALE. DIMENSIONS FOR INFORMATION ONLY. TOLERANCES UNLESS OTHERWISE SPECIFIED.				DWN 07FEB2013		TE Connectivity	
				K. HUANG		Harrisburg, PA 17105-3608	
				S. XI			
				S. XI 07FEB2013			
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm				PRODUCT SPEC		Ocean Side Feed	
				APPLICATION SPEC		Applicator	
				WEIGHT		-	
MATERIAL				SIZE		RESTRICTED TO	
-				A1 00779 C=2151817		-	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV F	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						-	-	-	-	-	-
	2-2151817-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151817-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2151817-5	F	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SMART APPLICATOR	2161326-1	-	8-2151817-4	-	-	-
	2-2151817-7	F	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151817-7	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: SPT LITEALUM CONTACT			
WIRE STRIP LENGTH 3.40-4.00 mm [.134-.157 IN]		INSULATION DIAMETER RANGE Ø 3.56-3.74mm [.140-.147 IN]	
TERMINAL APPLICATION SPECIFICATION		114-94204	
TERMINAL APPLICATION SPECIFICATION		TERMINAL APPLICATION SPECIFICATION	
TERMINALS APPLIED			
TE TERMINAL		TE TERMINAL	
2-1862001-1		2-1862001-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
4.00mm2		1.90±0.04 [.0748±.0016]		8.2



- 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: 8-2151817-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151817-5
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.

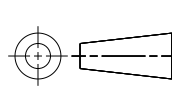
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	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 2119599-1	LOC A	DIST 66	REVISIONS				
			P	LTR	DESCRIPTION	DATE	DWN
			-	-	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	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	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	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	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	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	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	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	1	2119805-1	SHEAR HOLDER, FRONT	10
¹	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

THIS DOCUMENT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY. THE USER SHALL BE CONTACTED FOR THE LATEST EDITION.		DWN R. HUANG 07FEB2013	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK S. XI 07FEB2013	NAME Ocean Side Feed Applicator	
		APVD S. XI 07FEB2013	SIZE CAGE CODE DRAWING NO 00779 ©=2151817	
		PRODUCT SPEC	RESTRICTED TO	
		APPLICATION SPEC	Customer Accessible Production Drawing	
MATERIAL -	FINISH -	WEIGHT -	SCALE 1:2	SHEET 3 OF 4 REV F

PNEUMATIC

250

249

238

163

59

136

137

172

56

A

B

C

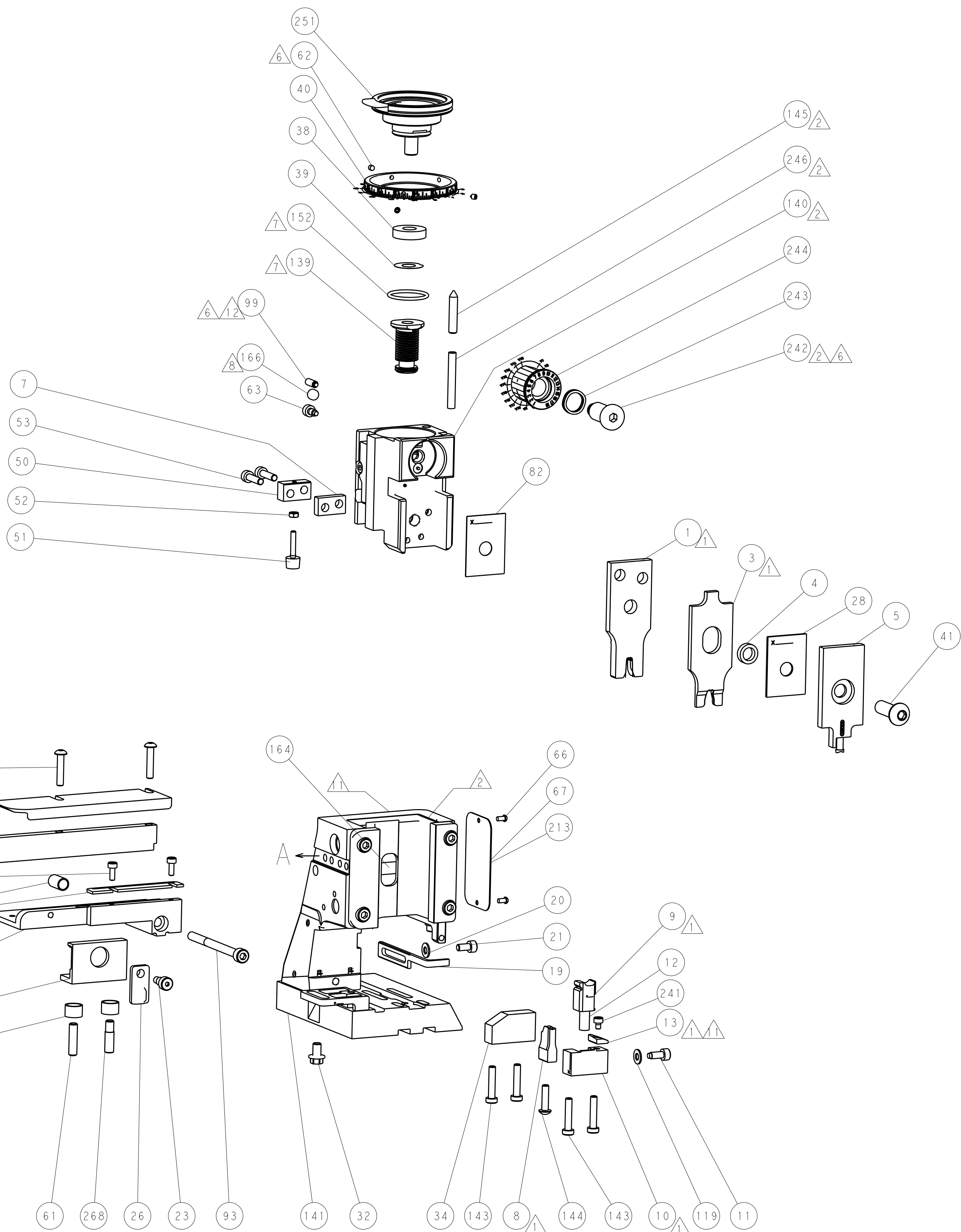
SERVO FEEDER
NOT INCLUDED

30mm STROKE

151

49

AIR FEED



Technical drawing of the front view of the assembly. It shows a cross-section of the components. Callouts include:

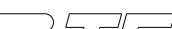
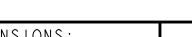
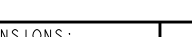
- 9 REF: Points to the leftmost component.
- 8 REF: Points to the middle component.
- 34 REF: Points to the rightmost component.
- 0.2 MAX: Dimension for the gap between the middle and right components.
- 1.5 ± 0.5: Dimension for the total width of the assembly.

Diagram showing the connection of a terminal strip to the control panel. The terminal strip is connected to the control panel terminals, which are labeled with numbers 1 through 6. The terminal strip is also connected to the control panel terminals, which are labeled with numbers 1 through 6.

TERMINAL STRUT CAN MOVE FREELY
WITH A MINIMUM OF SIDE CLEARANCE

Technical drawing of a mechanical assembly. Two callouts, both labeled '29 REF', point to different components of the assembly. The first callout points to a small, rectangular component on the left side. The second callout points to a larger, cylindrical component on the right side.

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

TEC CONNECTIVITY IS COMPLETELY RESPONSIBLE FOR THE DESIGNATION OF THIS PRODUCT AND ANY OTHER INFORMATION SHOULD BE CONTACTED FOR THE LATEST VERSION.										OWN S.HUANG		07FEFB2013		 TE Connectivity		Harrisburg, PA 17105-3608											
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 						CHG S.XI		07FEFB2013		NAME Ocean Side Feed Applicator													
										APPROV S.XI		07FEFB2013															
				PRODUCT SPEC - P.L.C. ± P.L.C. ± P.L.C. ± P.L.C. ± ANGLES ±						APPLICATION SPEC				SIZE CAGE CODE DRAWING NO		RESTRICTED TO											
														MATERIAL -		FINISH -		WEIGHT -		A 00779 C=2151817		-					
Customer Accessible Production Drawing														SCALE		1:2		SHEET		4		OF		REV		F	