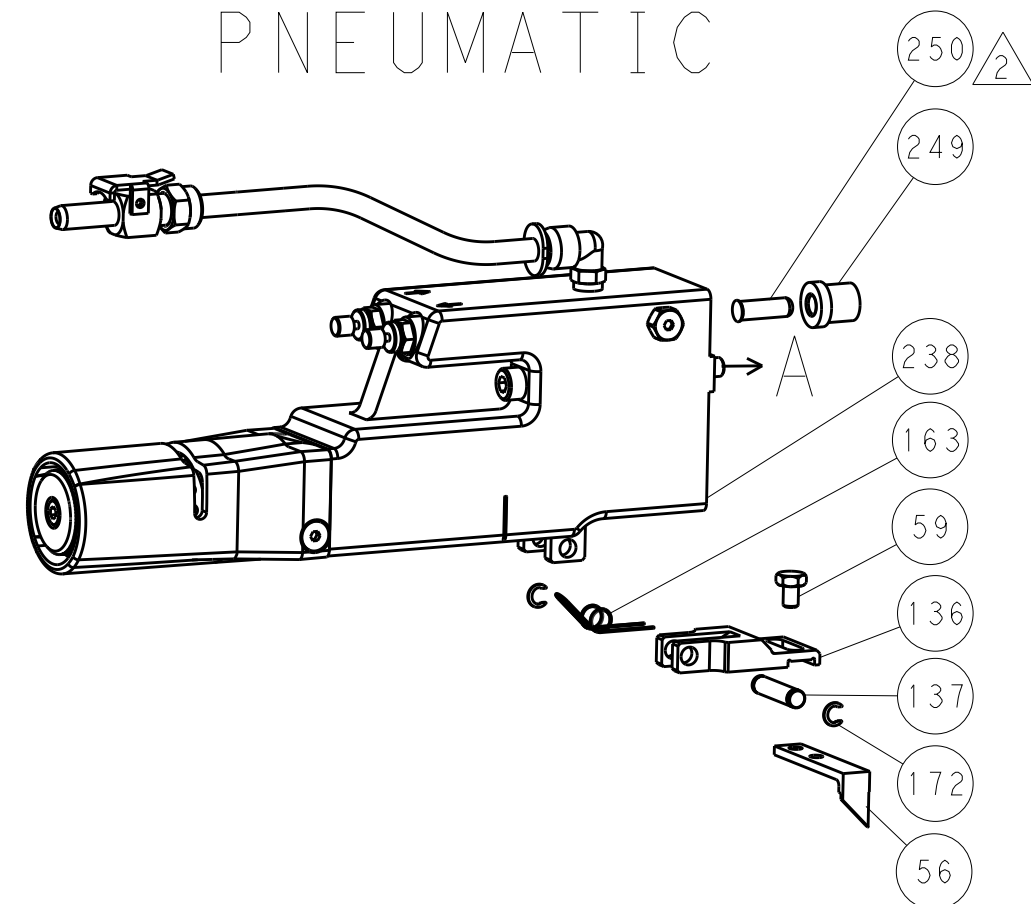


PNEUMATIC



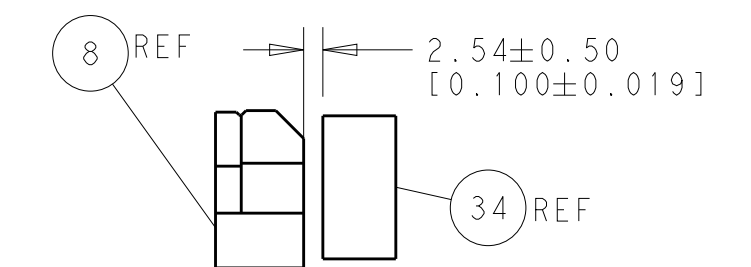
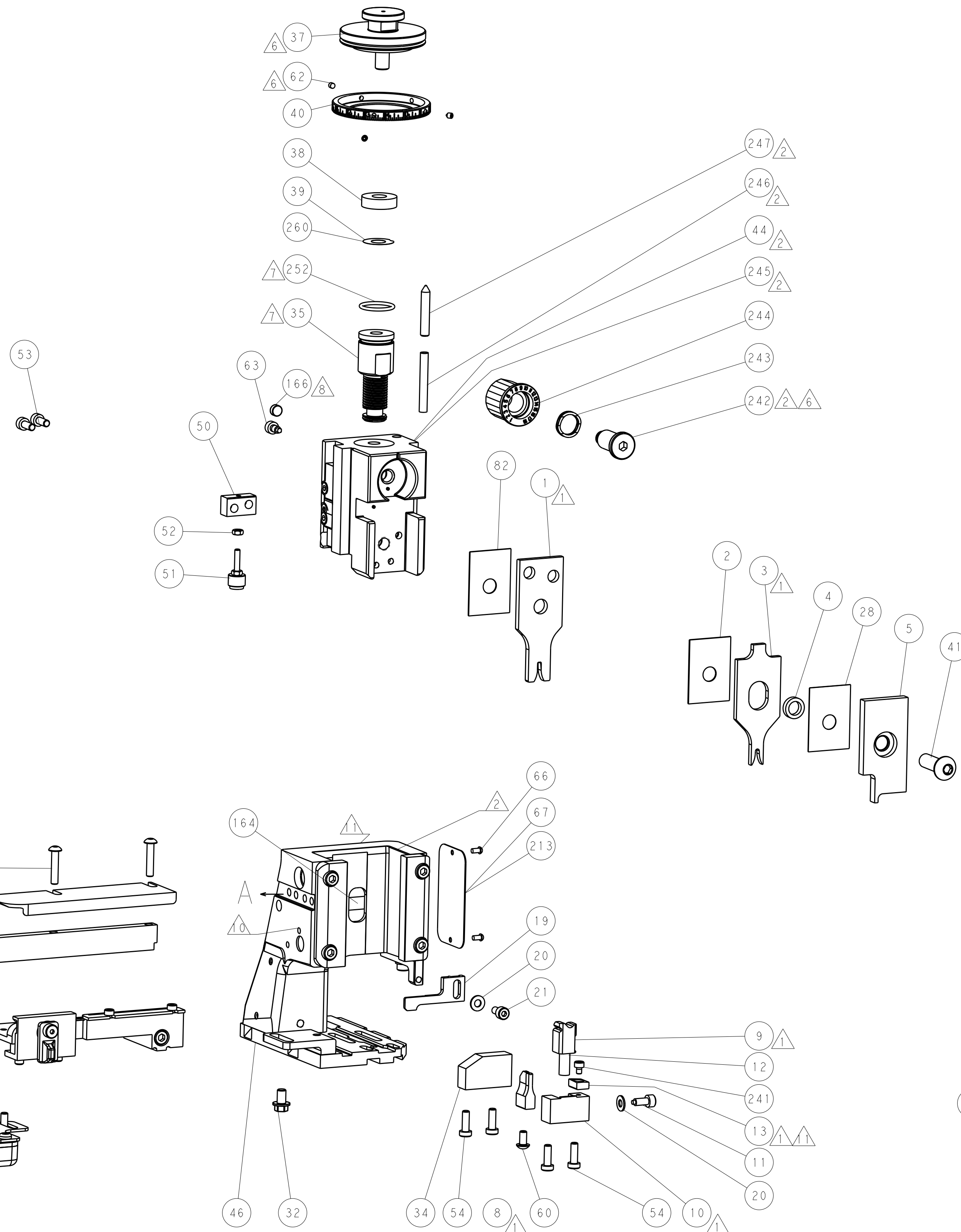
LATCH PLATE

SERVO FEEDER
NOT INCLUDED

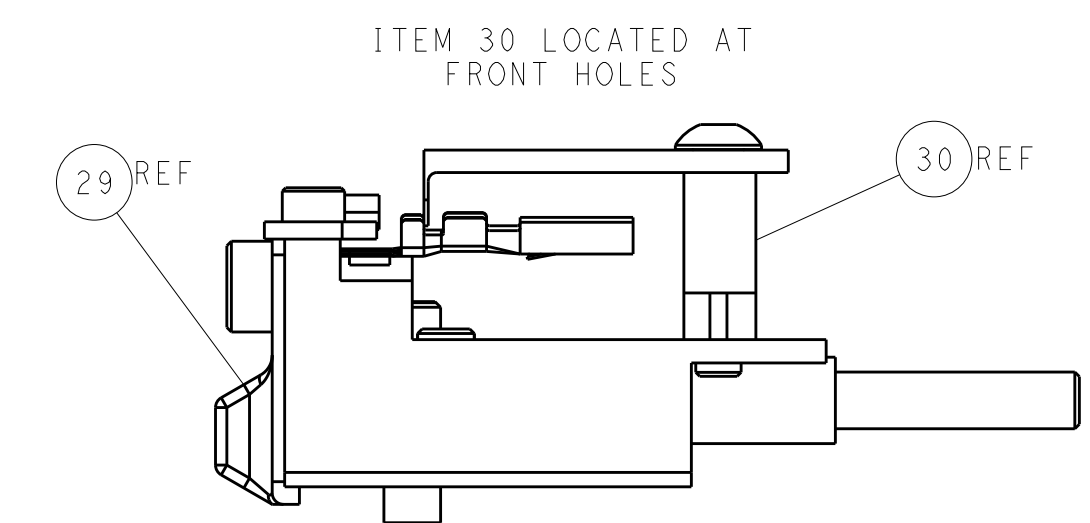
240 133 135 198 117 REF

The diagrams illustrate three types of mechanical feed systems:

- MECHANICAL POST FEED:** Shows a 30mm STROKE and a 40mm STROKE. Callouts include 47 (a vertical plate) and 49 (a horizontal plate).
- MECHANICAL PRE FEED:** Shows a 30mm STROKE and a 40mm STROKE. Callouts include 48 (a vertical plate) and 49 (a horizontal plate).
- AIR FEED:** Shows a 30mm STROKE and a 40mm STROKE. Callouts include 248 (a vertical plate) and 49 (a horizontal plate).

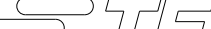
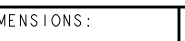


TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.05 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.		NAME PRODUCT SPEC APPLICATION SPEC SIZE CASE CODE DRAWING NO RESTRICTED TO	
MATERIAL FINISH WEIGHT		OCEAN SIDE FEED APPLICATOR - A 00779 C=2266675 Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV A	

8

7

6

5

4

3

2

1

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RELEASED FOR PUBLICATION

20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

REVISION

DESCRIPTION

FEED TYPE

2-2266675-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

2-2266675-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2-2266675-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

2-2266675-7

A

FINE CRIMP HEIGHT ADJUST

NONE

7-2266675-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.99 mm [.078]

F

INSUL

2.53 mm [.100]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: FCI/DELPHI TERMINAL

FCI CRIMP SPECIFICATION

TERMINAL NAME: 1.50mm APEX 150 FEMALE TERMINAL

WIRE STRIP LENGTH

4.19-4.95 mm [.165-.195 IN]

INSULATION DIAMETER RANGE

2.40mm [.094 IN] MAX

TERMINAL APPLICATION SPECIFICATION

J54009 Rev -

-

-

TERMINALS APPLIED

TE TERMINAL

FCI/DELPHI TERMINAL

TE TERMINAL

FCI/DELPHI TERMINAL

2113053-1

5400-1625

2113053-3

13779835

2113053-2

5400-1627

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING⁹

16 AWG

1.20+/-0.05 [.047+/- .002]

6.8

18 AWG

1.15+/-0.05 [.045+/- .002]

7.2

RECOMMENDED SPARE PARTS

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: 8-2266675-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266675-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266675-5

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.

PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4

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

AMP 4805 REV 31MAR2000

SET UP GAUGE
2119599-1

LOC
A

DIST
66

REVISIONS

P

LTR

DESCRIPTION

DATE

OWN

APVD

-

-

SEE SHEET 1

-

-

-

-

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

2119082-5

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

-

-

-

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

-

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

-

-

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

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

2119644-1

RAM WASHER, PRECISION

38

-

1

1

1

1

3-1752356-3

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

1-1320908-0

SPACER, STRIP GUIDE

30

-

1

1

1

1

2119959-1

ASSEMBLY, STRIP GUIDE

29

-

1

1

1

1

455888-3

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

-

2

2

2

2

1-18028-2

WASHER, FLAT, REG M4

20

-

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

1803095-1

FLOATING SHEAR, FRONT

9

-

1

1

1

1

1

5-1633711-2

ANVIL, COMBINATION

8

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7

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6

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1

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1

2119757-8

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

455888-6

SPACER, CRIMPER

2

-

1

1

1

1

1

4-568176-6

CRIMPER, WIRE

1

-77

-27

-25

-22

-21

PART NO

DESCRIPTION

ITEM NO

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DIMENSIONS:
mm

0 PLC ±.5

1 PLC ±0.5

2 PLC ±0.13

3 PLC ±0.013

4 PLC ±0.0001

ANGLES ±.

FINISH

DRAWN
K. HUANG
CHK
L. ZHANG
APVD
J. GUO

10FEB2015
10FEB2015
10FEB2015

TE Connectivity
Harrisburg, PA 17105-3608

NAME
Ocean Side Feed
Applicator

SIZE
A1

CAGE CODE
00779

DRAWING NO
C=2266675

RESTRICTED TO
-

PRODUCT SPEC
-

APPLICATION SPEC
-

WEIGHT
-

Customer Accessible Production Drawing

SCALE
1:2

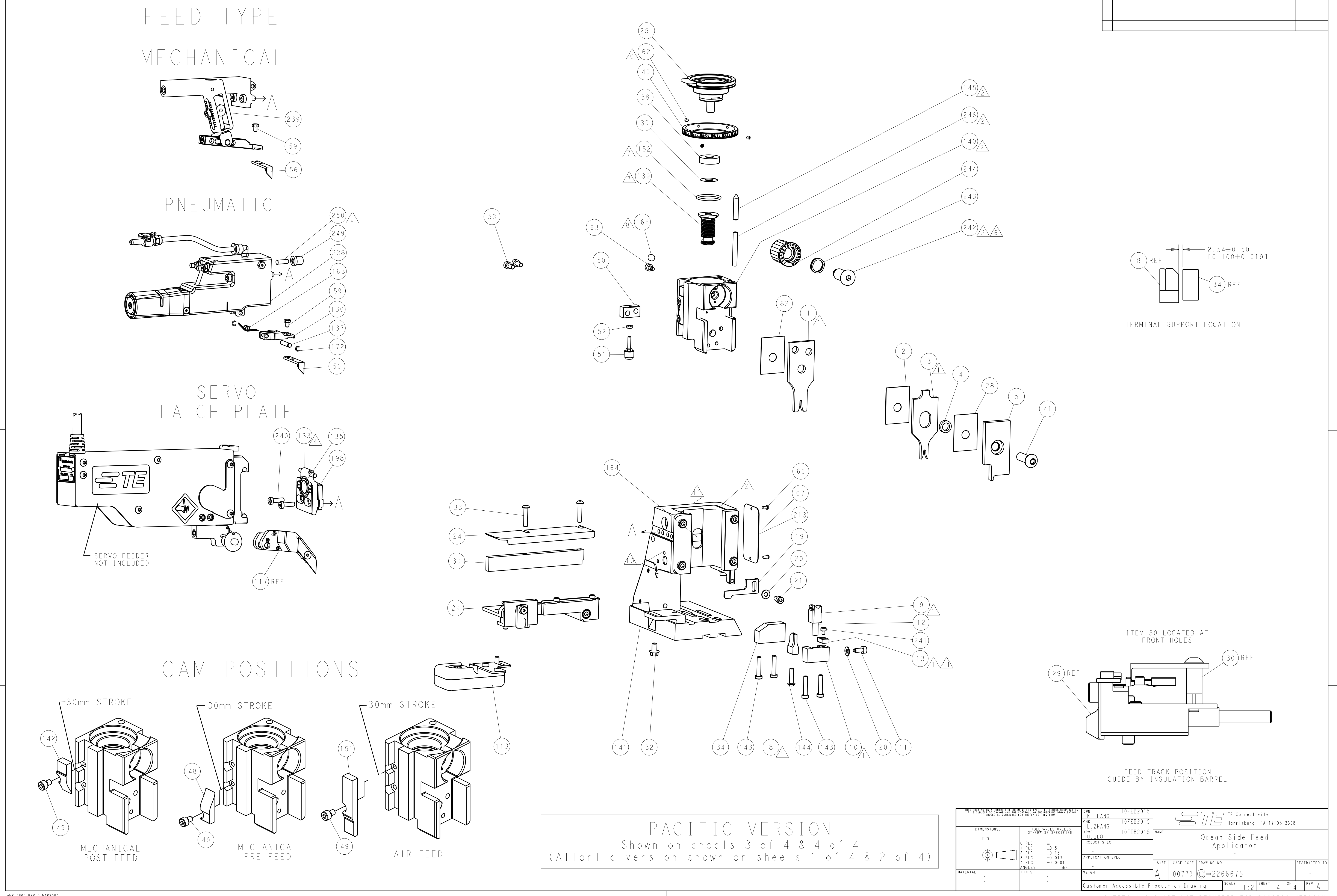
SHEET
3

OF
4

REV
A

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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



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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator	
				PRODUCT SPEC			
				APPLICATION SPEC			
				SIZE		CAGE CODE	DRAWING NO
				A1		00779	C=2266675
MATERIAL		FINISH		WEIGHT		RESTRICTED TO	
-		-		-		-	
Customer Accessible Production Drawing				SCALE		1:2	
				SHEET		4 OF 4	
				REV		A	