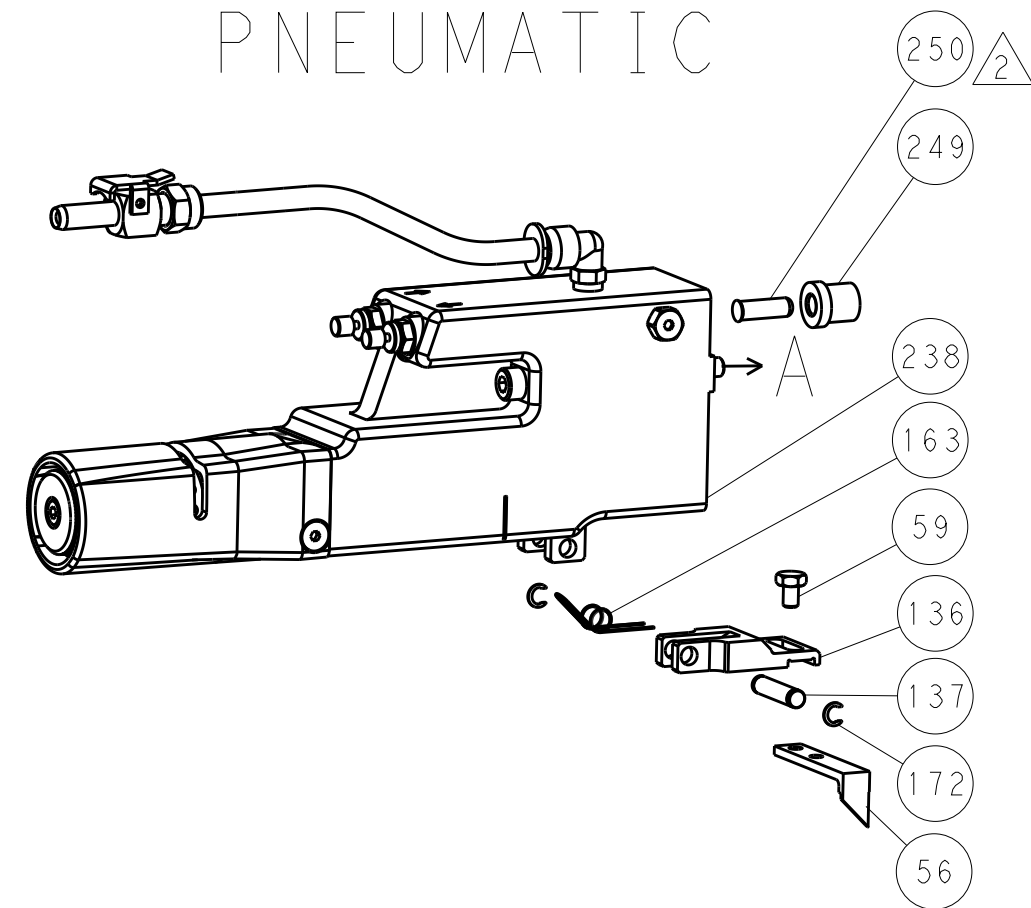


PNEUMATIC



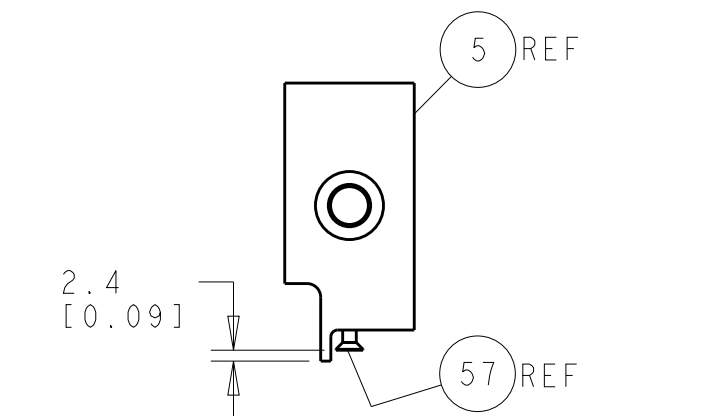
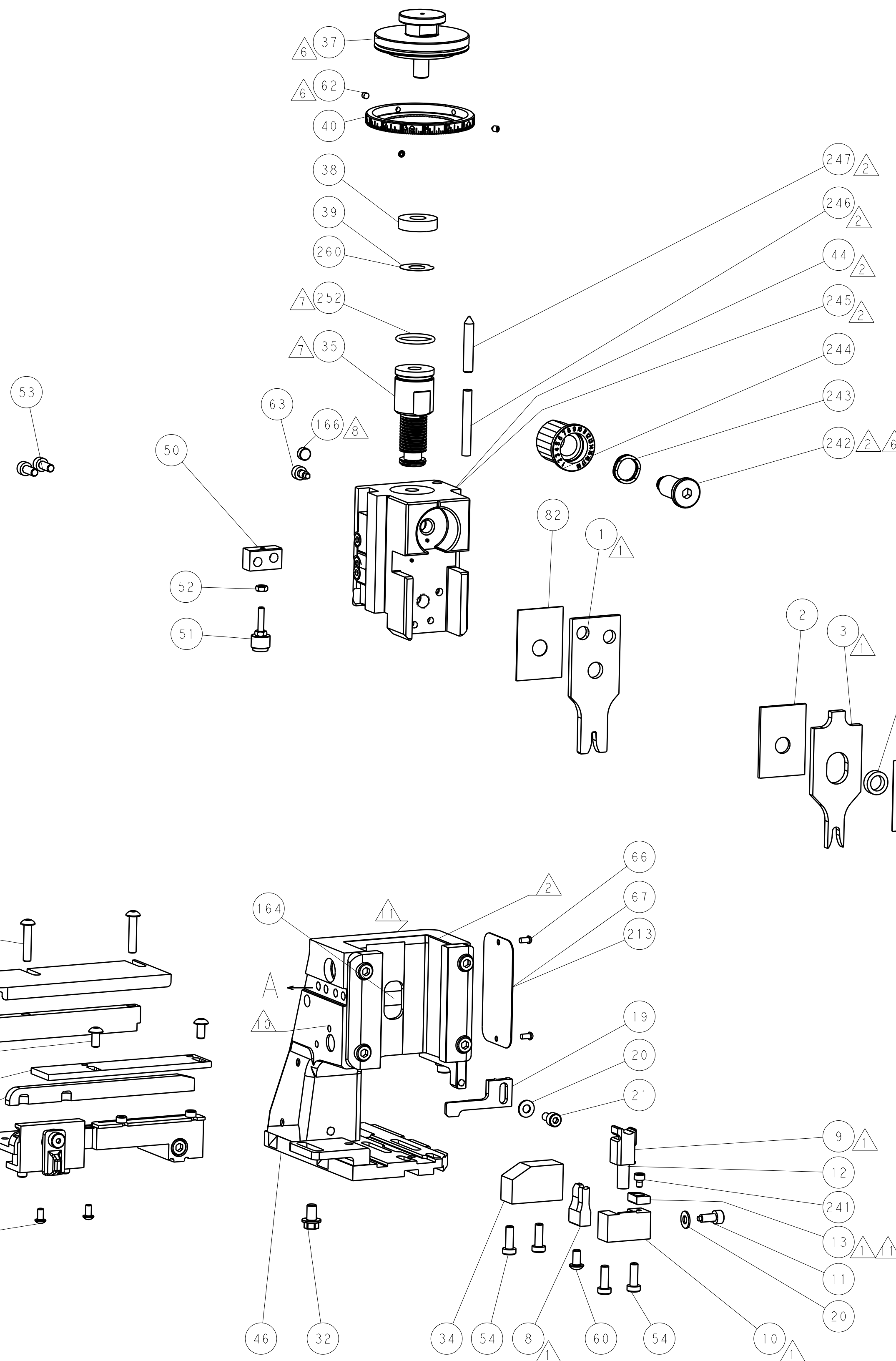
LATCH PLATE

SERVO FEEDER
NOT INCLUDED

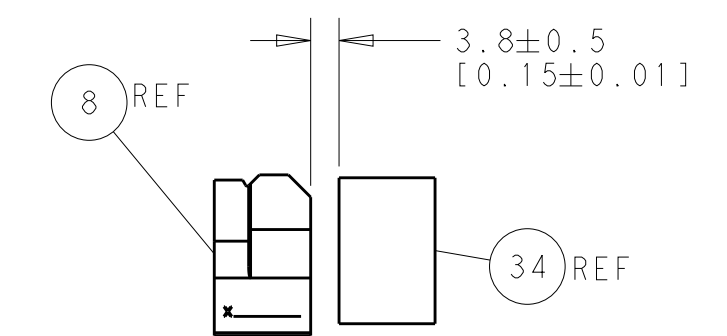
240 133 135 198 117 REF

The diagrams illustrate the mechanical post feed mechanism for three different feed types: Mechanical Post Feed, Mechanical Pre Feed, and Air Feed. Each diagram shows a 30mm stroke and a 40mm stroke, with a 47mm or 48mm dimension and a 49mm dimension.

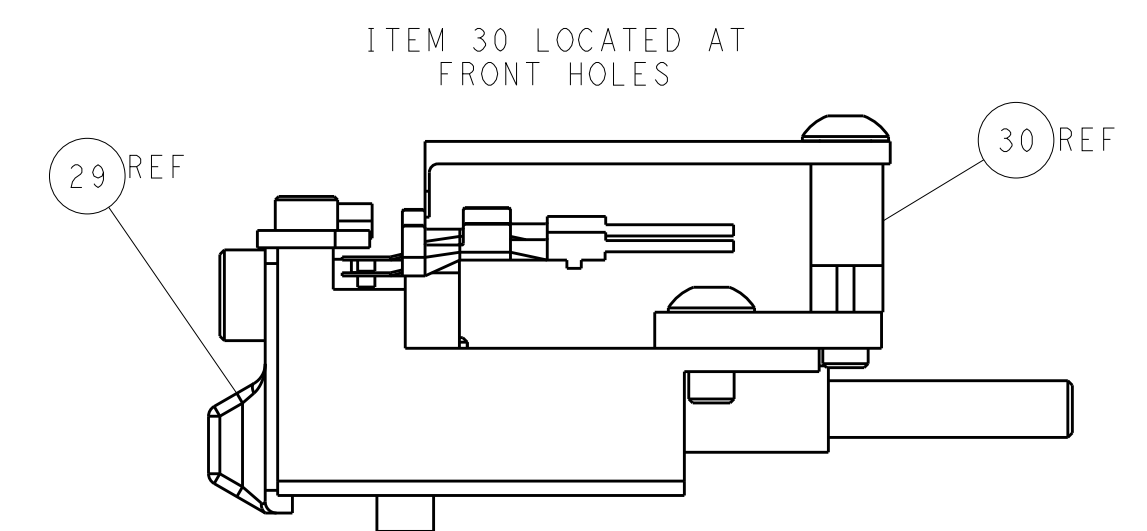
- MECHANICAL POST FEED:** Shows a 30mm stroke and a 40mm stroke. The dimension 47 is indicated for the 30mm stroke, and 49 is indicated for the 40mm stroke.
- MECHANICAL PRE FEED:** Shows a 30mm stroke and a 40mm stroke. The dimension 48 is indicated for the 30mm stroke, and 49 is indicated for the 40mm stroke.
- AIR FEED:** Shows a 30mm stroke and a 40mm stroke. The dimension 248 is indicated for the 30mm stroke, and 49 is indicated for the 40mm stroke.



SHEAR DEPRESSOR DETAIL

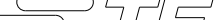
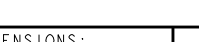


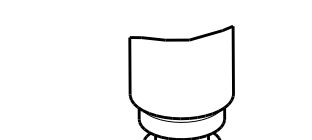
TERMINAL SUPPORT LOCATION



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TECHNOLOGICAL INFORMATION. IT IS THE PROPERTY OF TE CONNECTIVITY. IT IS TO BE KEPT IN A SECURE LOCATION AND SHOULD BE CONTROLLED FOR THE LATEST REVISION. PROHIBITION OF REPRODUCTION.		OWN 270C12014 CUN Y YIN 270C12014 G BAILEY 270C12014 U GUO 270C12014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 P L C ±: 1 P L C ±0.5 2 P L C ±0.13 3 P L C ±0.013 4 P L C ±0.0001 ANGLES ±:		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL -		FINISH -		CAGE CODE 00779	
WEIGHT -		DRAWING NO C-2266555		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 OF 4 REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER 	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266555-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266555-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266555-4	-	-	-
	2-2266555-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266555-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266555-4	-	-	-
	2-2266555-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2266555-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2266555-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

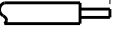
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	4.19 mm [.165]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: YAZAKI TERMINAL		YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH 5.85-6.61 mm [.230-.260 IN]			INSULATION DIAMETER RANGE  
TERMINAL APPLICATION SPECIFICATION 		(A)YPES 72-WT08-846-1 Revision 14/12/26 -	
TERMINALS APPLIED			
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL
(A) 1572003-1	(A) 7114-4151-02	1949064-2	7158-3112-70

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
1.00mm2		1.30+/-0.05 [.051+/- .002]		8.1
0.85mm2		1.20+/-0.05 [.047+/- .002]		8.7
0.75mm2		1.20+/-0.05 [.047+/- .002]		8.7



- 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: 8-2266555-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266555-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266555-5
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 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- ¹³ APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
APPLY #1-23419-5 LOC-TITE TO THREADS.
- ¹⁴ WHEN SWITHCING TERMINALS, FEED ADJUSTMENT IS REQUIRED.

TERMINAL DATA: YAZAKI TERMINAL		YAZAKI CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE			
WIRE STRIP LENGTH 5.85-6.61 mm [.230-.260 IN]		 INSULATION DIAMETER RANGE Ø1.88-2.10 mm [.074-.083 IN]	
TERMINAL APPLICATION SPECIFICATION 		(B)YPES 72 WT10-1782-1 Revision 12/11/23 -	
TERMINALS APPLIED		-	
TE TERMINAL	YAZAKI TERMINAL	TE SEAL	YAZAKI SEAL
(B) 1949535-1	(B) 7116-4151-02	1949064-2	7158-3112-70

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
1.25mm2		1.40+/-0.05 [.055+/- .002]		7.8
1.00mm2		1.30+/-0.05 [.051+/- .002]		8.1
0.85mm2		1.20+/-0.05 [.047+/- .002]		8.7
0.75mm2		1.20+/-0.05 [.047+/- .002]		8.7

*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.

-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	269
-	1	1	1	1	1633782-4	FENCE	267
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-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)

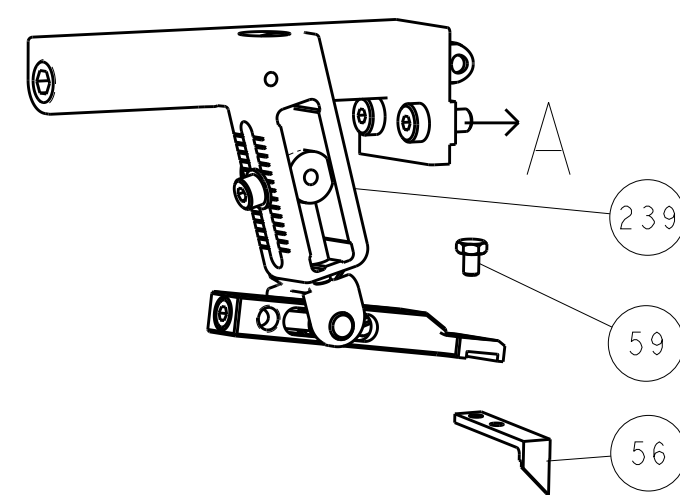
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
			-	-	SEE SHEET 1	-

-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
⁶ -	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	455888-5	SPACER, CRIMPER	82
-	2	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1	1	1803096-1	EXTENSION PLATE	78
-	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
⁶ -	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
⁶ -	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
¹³ -	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	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	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	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	1320908-8	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1320928-4	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	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	1	2119805-1	SHEAR HOLDER, FRONT	10
¹ -	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
¹ -	1	1	1	1	6-1333205-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2-2119781-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	4-238011-5	BLOCK, CRIMPER SPACER	4
¹ -	1	1	1	1	8-1633965-1	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1-455888-5	SPACER, CRIMPER	2
¹ -	1	1	1	1	8-458141-7	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

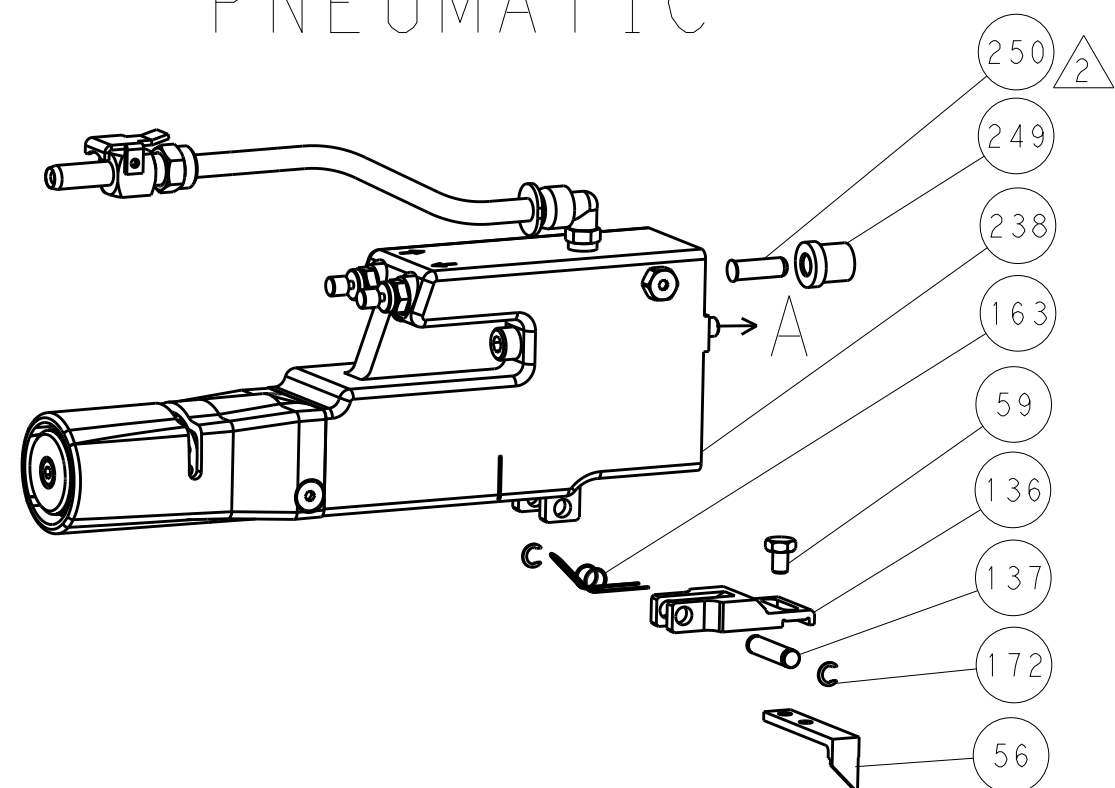
THIS DOCUMENT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. NO OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN T. YIN	27OCT2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY	27OCT2014	NAME Ocean Side Feed Applicator	
		APVD J. GUO	27OCT2014	SIZE A1	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±.1		PRODUCT SPEC -		CAGE CODE 00779	
MATERIAL -		APPLICATION SPEC -		DRAWING NO ©=2266555	
FINISH -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing			SCALE 1:2	SHEET 3	REV A

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

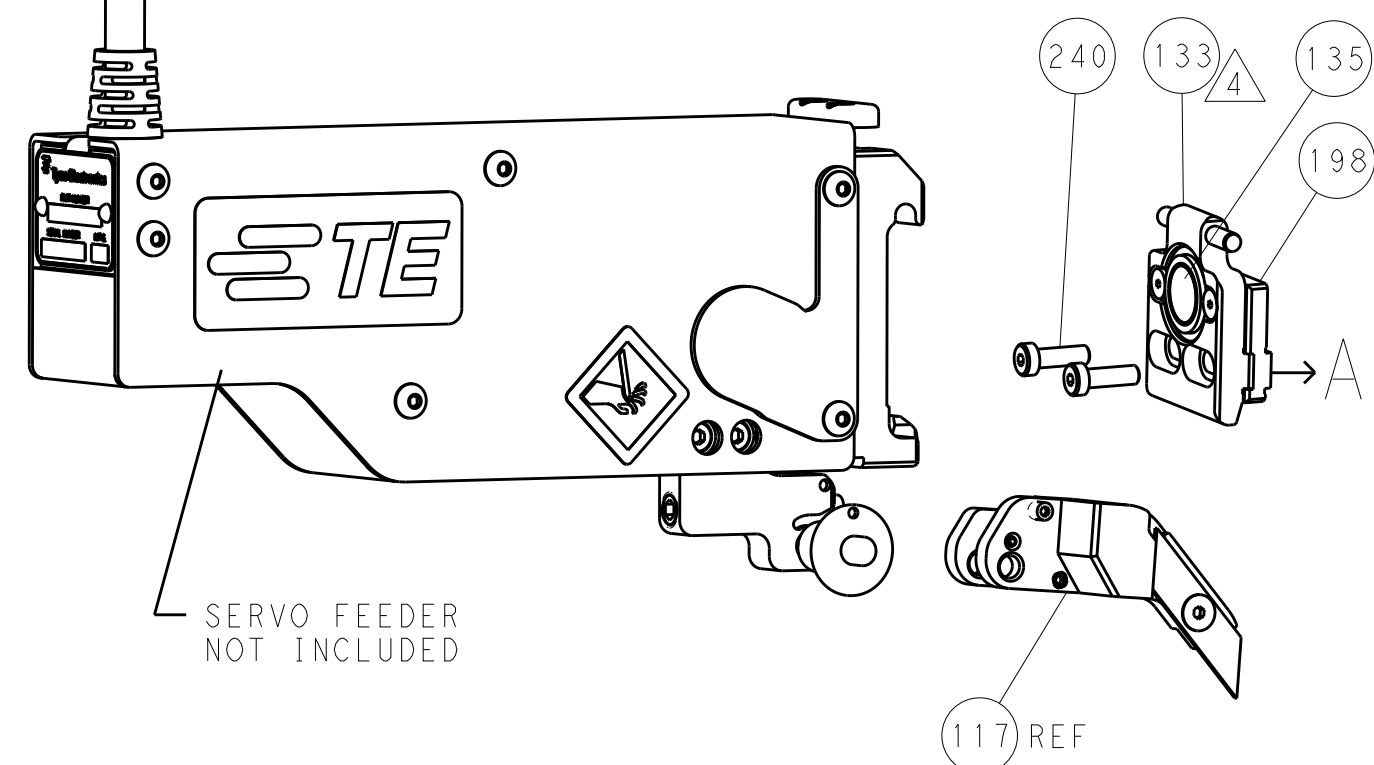
FEED TYPE MECHANICAL



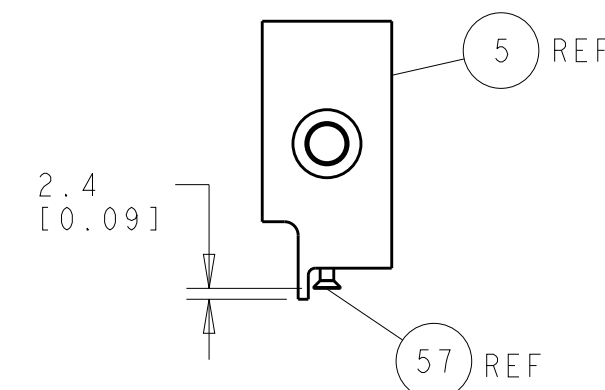
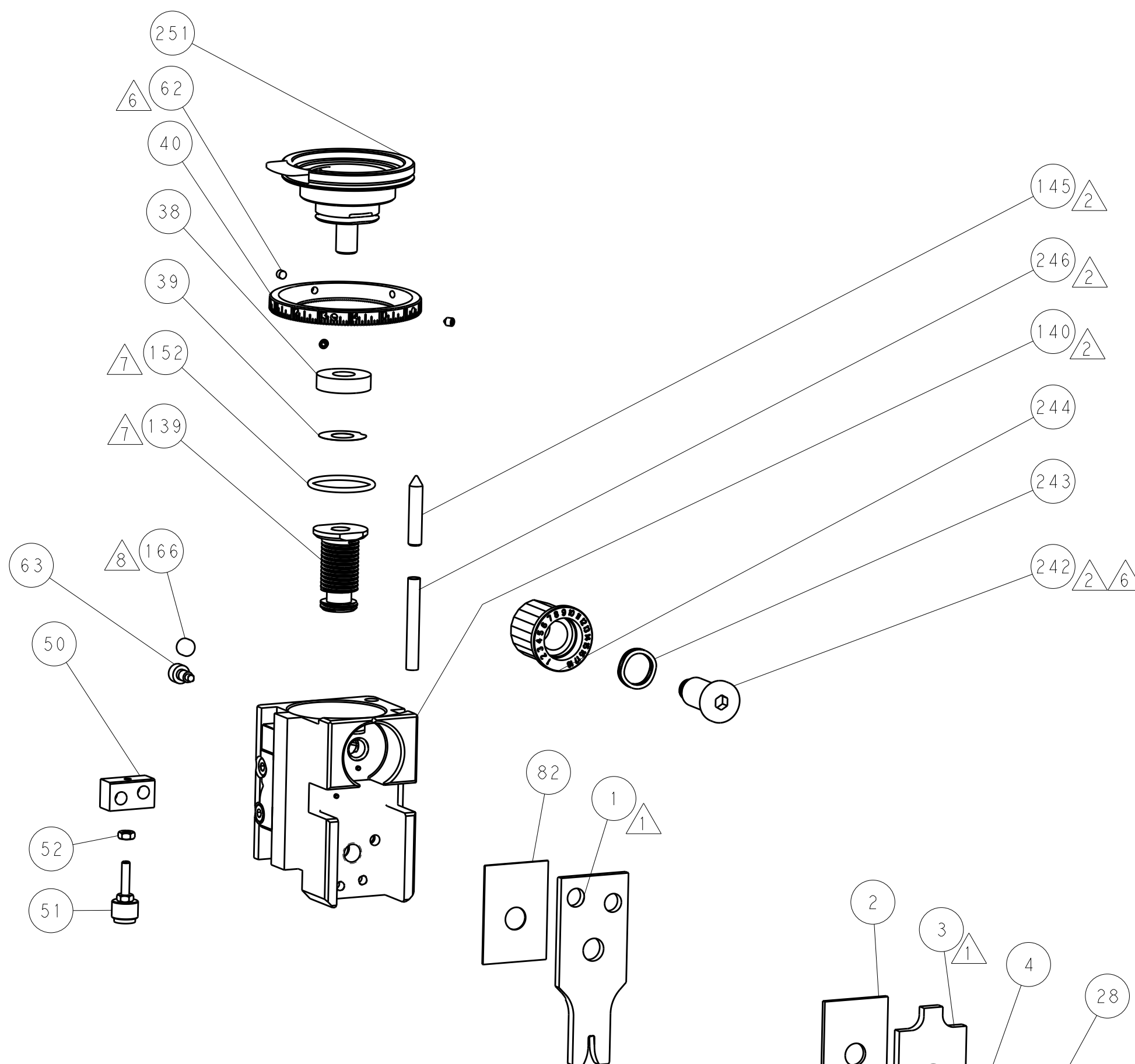
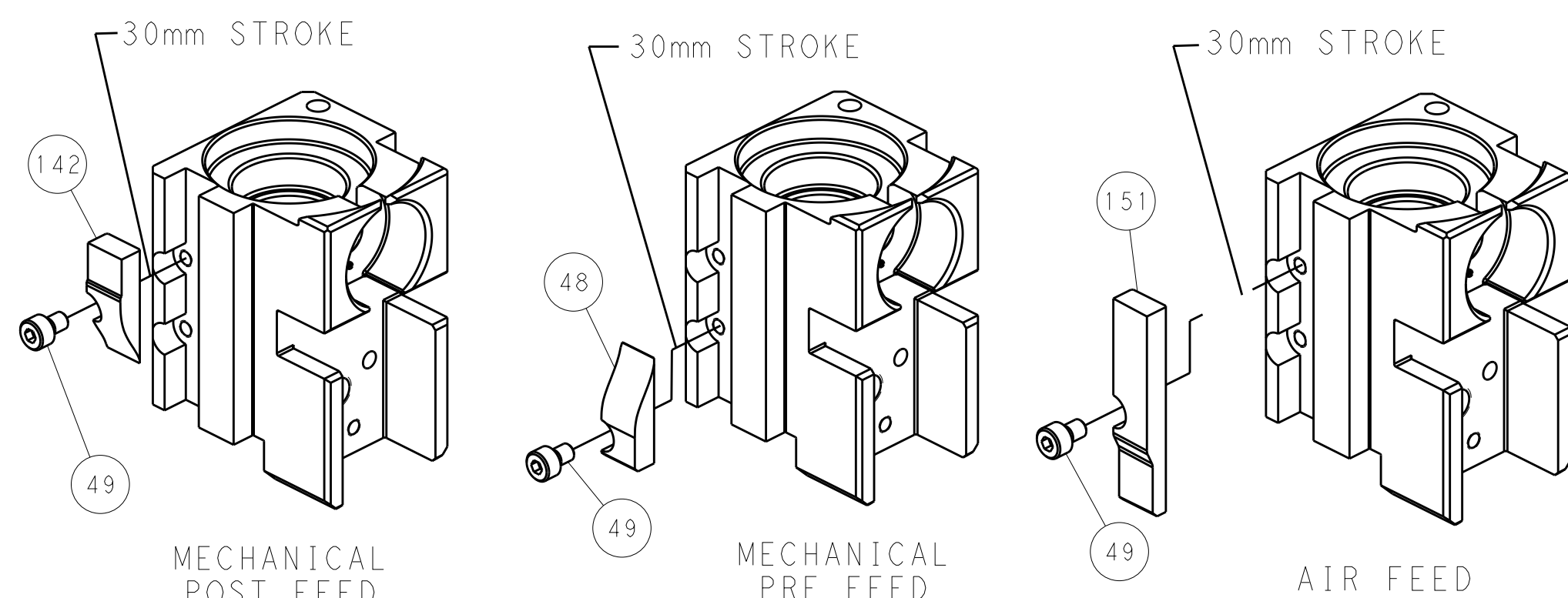
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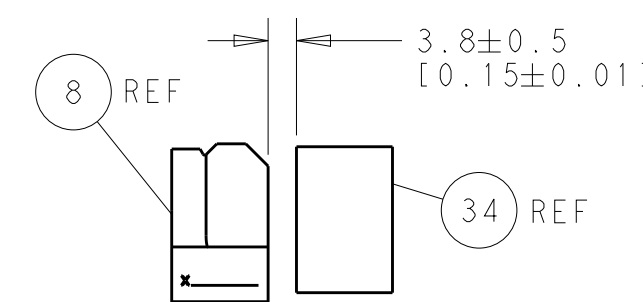
SERVO LATCH PLATE



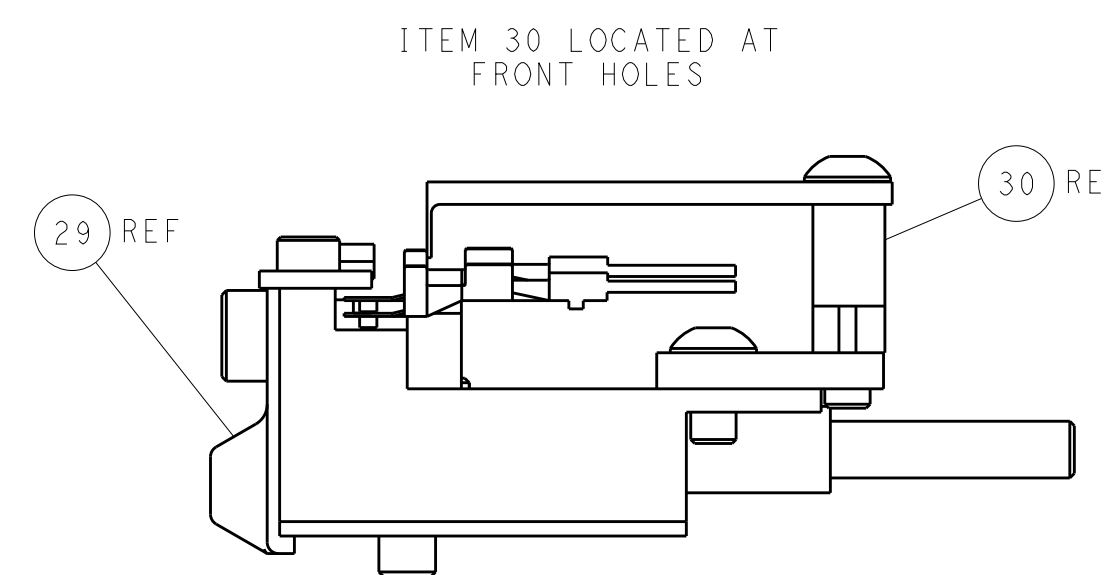
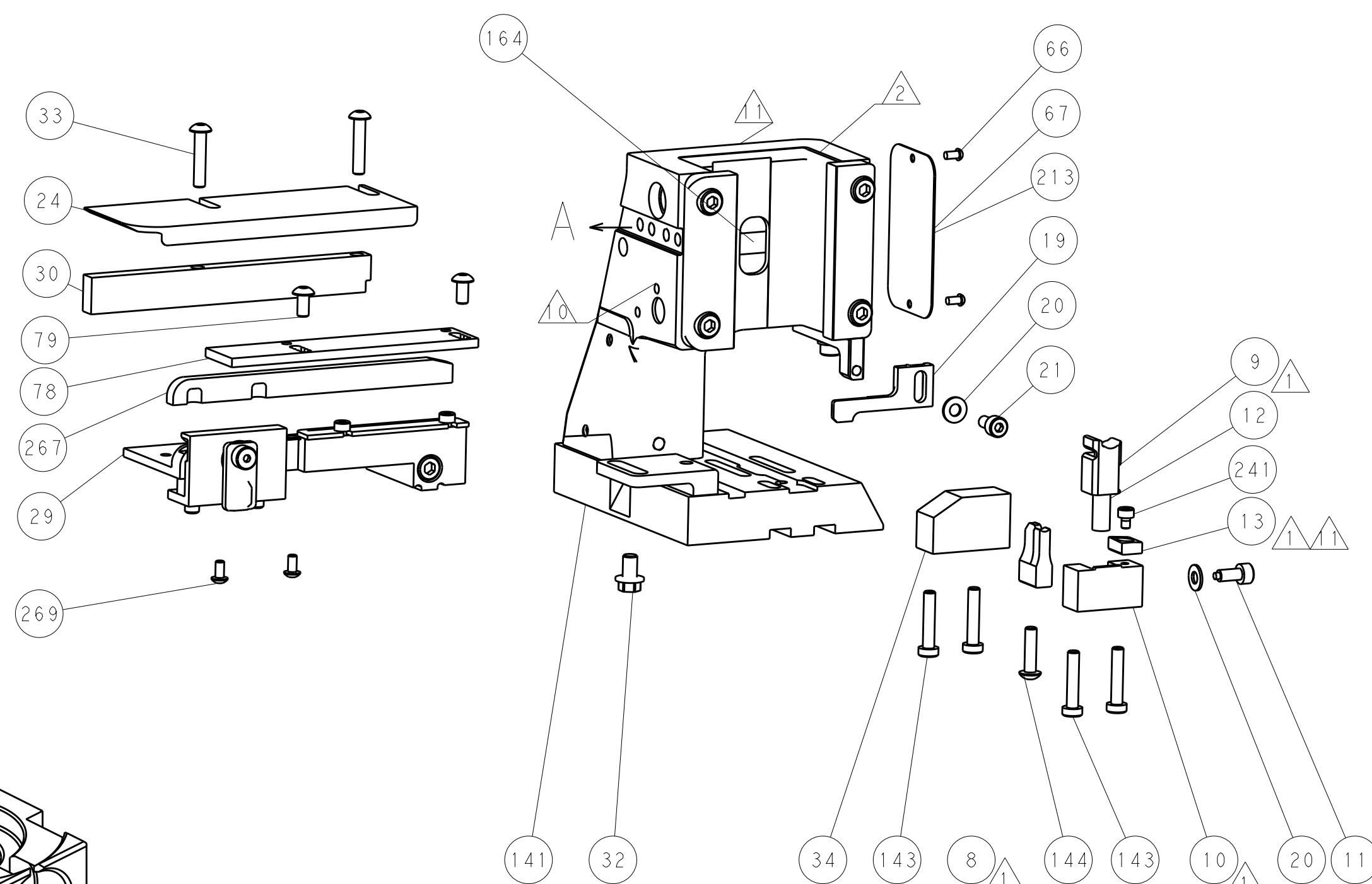
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		Y. YIN		27OCT2014		CHK		G. BAILEY		27OCT2014		APVD		H. GUO		27OCT2014		NAME		Ocean Side Feed Applicator		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
mm		0 PLC ±0.5		PRODUCT SPEC		-		APPLICATION SPEC		-		WEIGHT		-		Customer Accessible Production Drawing		SCALE		1:2		SHEET		4		OF		4		REV		A	
MATERIAL		-		FINISH		-		-		-		-		-		-		-		-		-		-		-		-		-		-	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION