

-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	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	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	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	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	1	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	-	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	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	1	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	REF	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	66
-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	1	1	3-1752354-5	STANDOFF, HOLD-DOWN	50
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	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	1	2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1-1752356-1	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	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1320928-6	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	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	1333204-7	ANVIL, COMBINATION	8
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1-2119785-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	455888-4	SPACER, CRIMPER	2
1	1	1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1

 $\triangle$

8

7

6

5

4

3

2

1

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

2-2151152-2

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

PNEUMATIC

CONVERT TO

MECHANICAL FEED

PART NUMBERS REQUIRED

2119949-1

2138685-1

5-18022-5

2119653-2

-

-

2-2151152-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE

MECHANICAL FEED

2119951-1

2161326-1

8-2151152-5

1901094-3

-

2168400-6 (QUANTITY 2)

2-2151152-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2151152-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	OV

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: TAB 5.8 X 0.8

WIRE STRIP LENGTH

4.00-4.40 mm [.157-.173 IN]

INSULATION DIAMETER RANGE

Ø1.40-2.10 mm [.055-.083 IN]

TERMINAL APPLICATION SPECIFICATION

114-18052

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

1.00mm2

1.56+/-0.05 [.061+/-0.002]

9.7

0.75mm2

1.47+/-0.05 [.058+/-0.002]

10.5

0.50mm2

1.38+/-0.05 [.054+/-0.002]

11.4

RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151152-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151152-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151152-6

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62 & 242.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

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.

TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

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)

SET UP GAUGE
2119599-1

LOC
A

DIST
66

REVISIONS

P	LYR	DESCRIPTION	DATE	DWN	APVD
-	-	SEE SHEET 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

1-22279-3

SPRING, COMPRESSION

246

-

1

1

1

2119082-8

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

-

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

-

1

1

1

993111-1

PIN, SLOTTED SPRING 3.0 X 20.0

177

-

1

1

1

8-22280-7

SPRING, COMPRESSION

176

-

1

1

1

1752353-2

GUIDE PIN,HOLDDOWN

175

-

1

1

1

1901680-2

GUIDE PIN,HOLDDOWN

174

-

-

-

2

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

-

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

-

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

1-2119656-0

APPLICATOR BASIC ASSEMBLY, SF

141

-

1

1

1

2119650-1

RAM, ASIAN STYLE, SIDE FEED

140

-

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

1-18028-2

WASHER, FLAT, REG M4

119

-

-

REF

-

2119944-1

FEED FINGER ASSEMBLY,SF

117

-

1

1

1

455888-5

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

66

-

1

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

-

3

3

3

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

-

-

-

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

1

1338685-1

PAWL, FEED

56

-

1

1

1

1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

-

1

1

1

1901681-1

HOLDDOWN, TERMINAL

51

-

1

1

1

3-1752354-5

STANDOFF,HOLD-DOWN

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

1-1752356-1

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

1-1320908-0

SPACER, STRIP GUIDE

30

-

1

1

1

2119959-2

ASSEMBLY, STRIP GUIDE

29

-

1

1

1

1-455888-0

SPACER, CRIMPER

28

-

1

1

1

1320928-6

STRIP GUIDE

24

-

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

2119533-1

STRIPPER, SIDE FEED

19

-

1

1

1

2119806-1

INSERT, SHEAR

13

-

1

1

1

3-22280-3

SPRING, COMPRESSION

12

-

1

1

1

1-356885-4

STOP, SHEAR

11

-

1

1

1

2119805-1

SHEAR HOLDER, FRONT

10

-

1

1

1

454276-5

FLOATING SHEAR, FRONT

9

-

1

1

1

1333204-7

ANVIL, COMBINATION

8

-

1

1

1

2119757-8

DEPRESSOR, SHEAR

5

-

1

1

1

1-238011-0

BLOCK, CRIMPER SPACER

4

-

1

1

1

1-2119785-0

CRIMPER, INSULATION OVERLAP PREMIUM

3

-

1

1

1

455888-4

SPACER, CRIMPER

2

-

1

1

1

1-456405-6

CRIMPER, WIRE PREMIUM

1

-77

-27

-25

-22

PART NO

DESCRIPTION

ITEM NO

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DRAWN
R. HUANG
CHK
S. XI
APVD
J. CRUZ

17OCT2011
17OCT2011
17OCT2011

DIMENSIONS:
mm

0 PLC
1 PLC
2 PLC
3 PLC
4 PLC
ANGLES
FINISH

±
±0.5
±0.13
±0.013
±0.0001
±

TOLERANCES UNLESS OTHERWISE SPECIFIED:

PRODUCT SPEC
APPLICATION SPEC
WEIGHT

MATERIAL

Customer Accessible Production Drawing

NAME
Ocean Side Feed
Applicator

SIZE
A1

CAGE CODE
00779

DRAWING NO
C=2151152

RESTRICTED TO
-

SCALE
1:2

SHEET
3

OF
4

REV
A

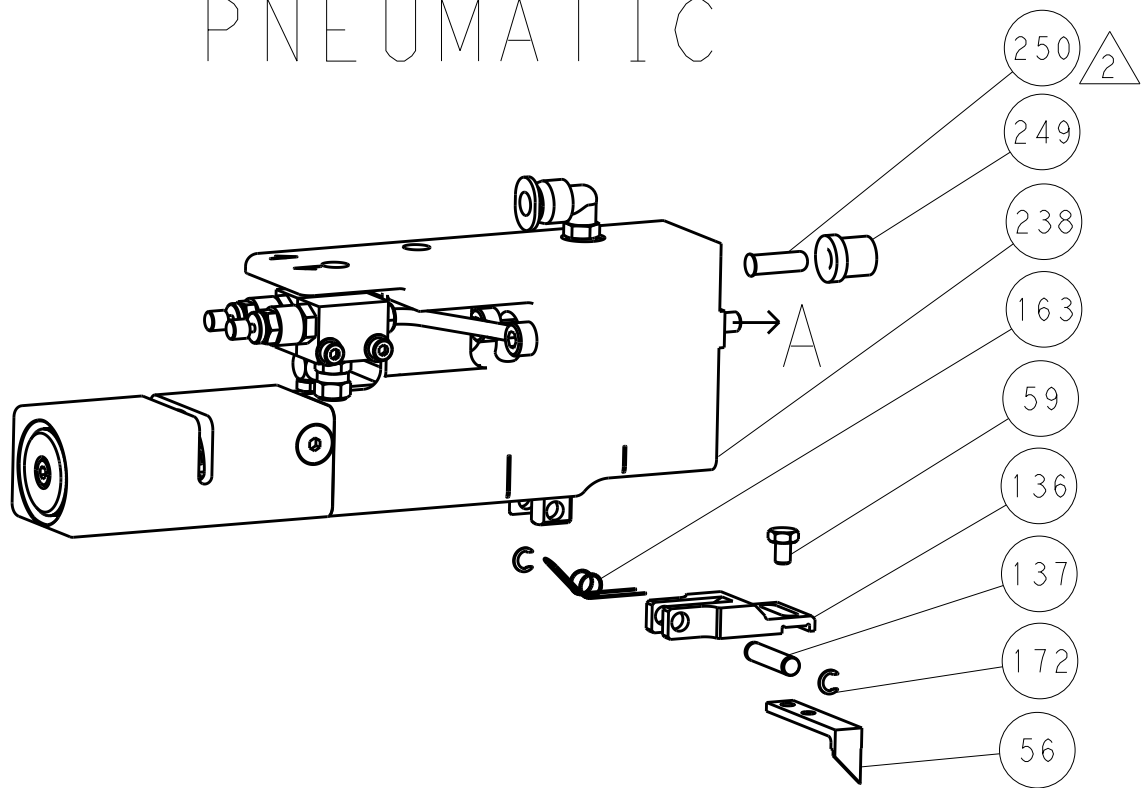
AMP 4805 REV 31MAR2000

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

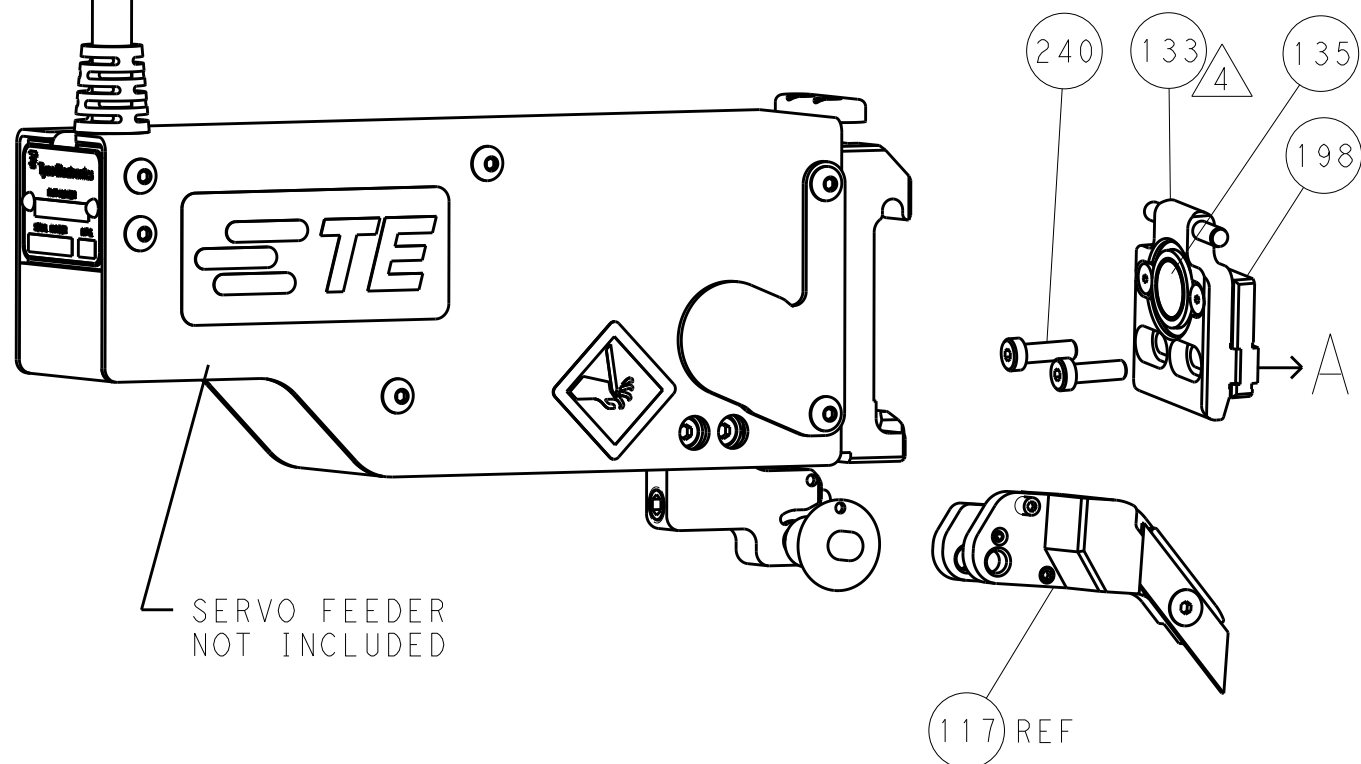
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE

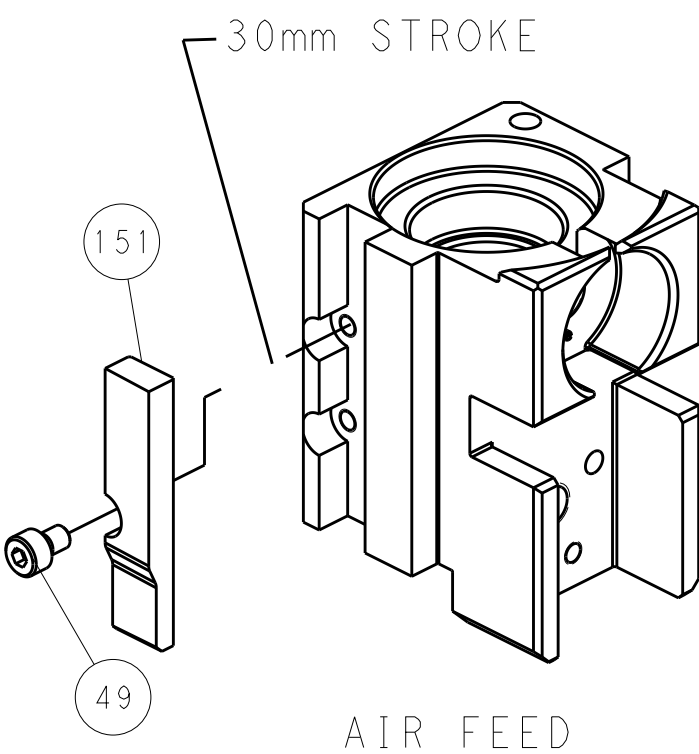
PNEUMATIC



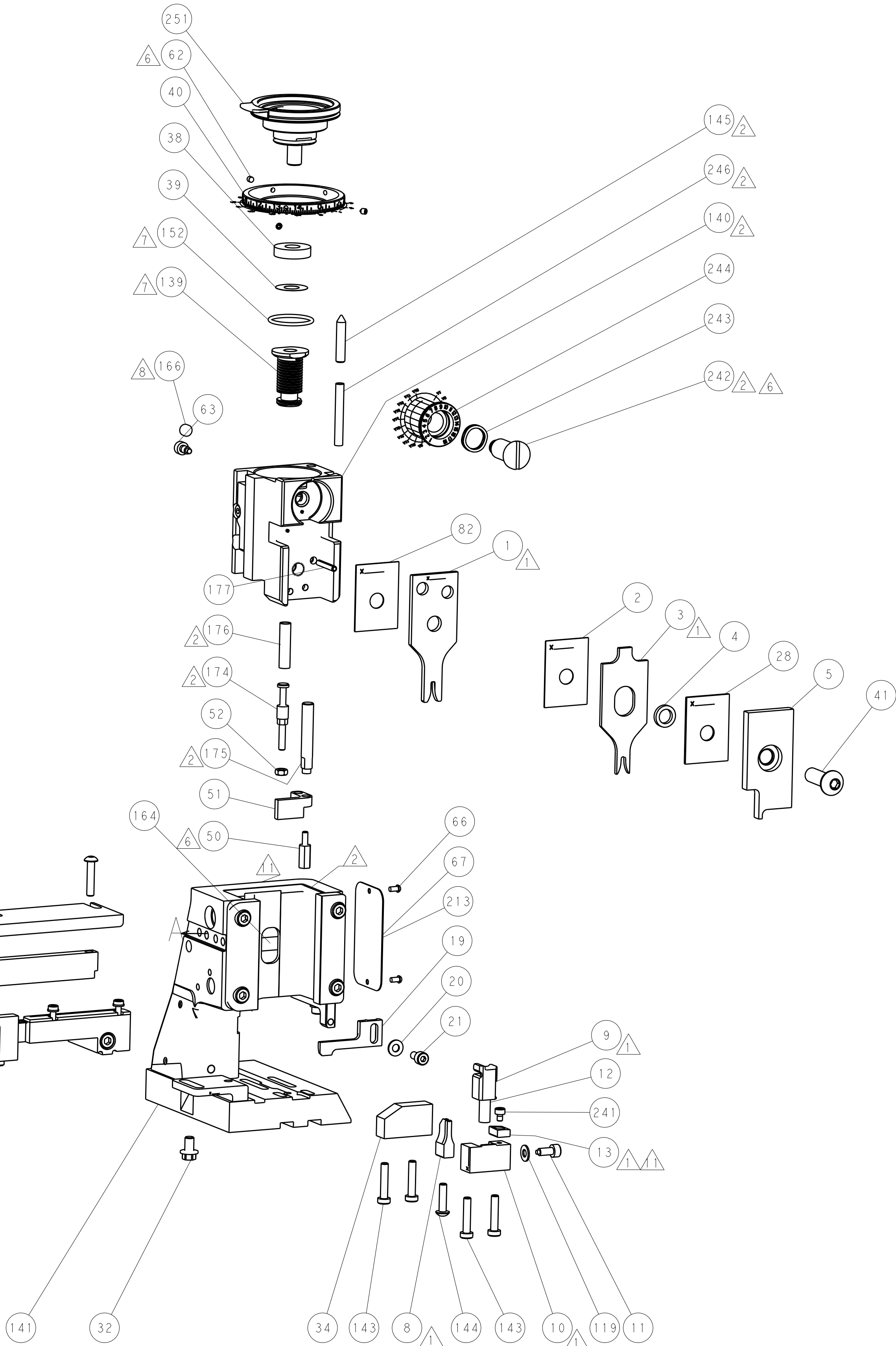
SERVO LATCH PLATE



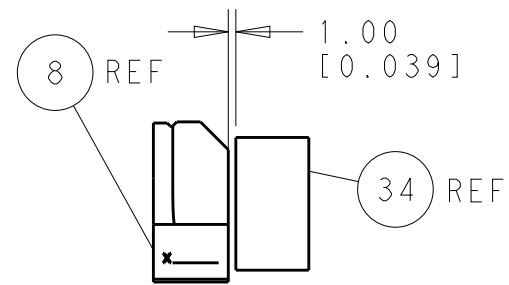
CAM POSITION



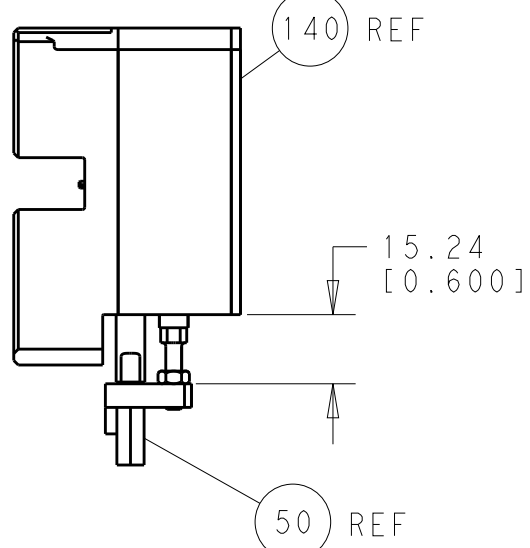
AIR FEED



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

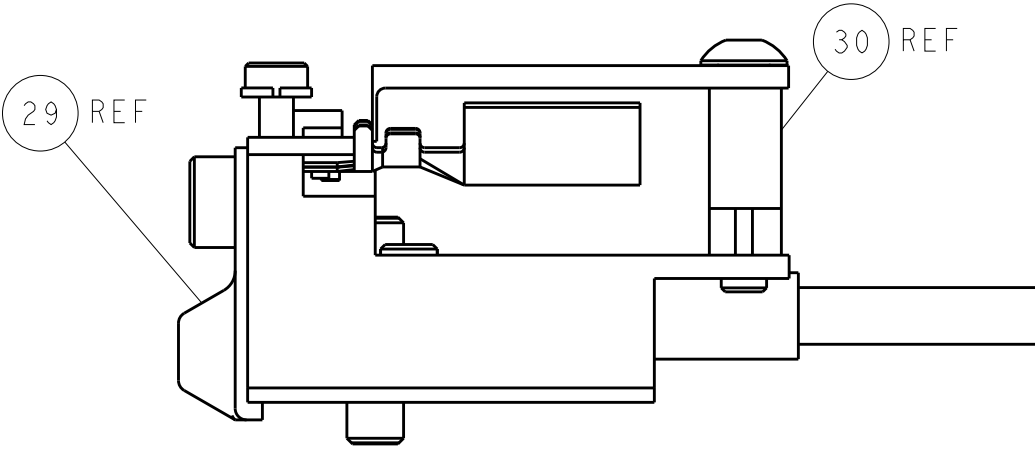


TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP

ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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				CHK S. XI 17OCT2011			
				APVD J. CRUZ 17OCT2011	NAME Ocean Side Feed Applicator		
DIMENSIONS: mm				PRODUCT SPEC			
				APPLICATION SPEC			
MATERIAL				WEIGHT	SIZE A1		
				FINISH	CAGE CODE 00779		
					DRAWING NO C=2151152		
					Customer Accessible Production Drawing		
					SCALE 1:2		
					SHEET 4		
					OF 4		
					REV A		