

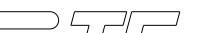
SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS				
P	CLR	DESCRIPTION			DATE	DWN	APVD	
1		ORIGINAL			19NOV2013	GH	TE	
	A	RELEASED			18DEC2013	GH	TE	

-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2161314-1	RAM, STEPPED, ATLANTIC, SF, NON-ADJ	245
-	1	1	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
6	-	-	2	2	-	2168400-6	SHCS, LOW HEAD, RøHS, M5 X 16	240
								239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
								213
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	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	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	1-455888-6	SPACER, CRIMPER	82
-	1	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	1	854769-4	HOLDER, INS	74

[illegible]

6	-	1	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
							992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 x 8)	60
	-	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 x 6.0	59
	-	1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	-	-	-	1	1	1338685-1	PAWL, FEED	56

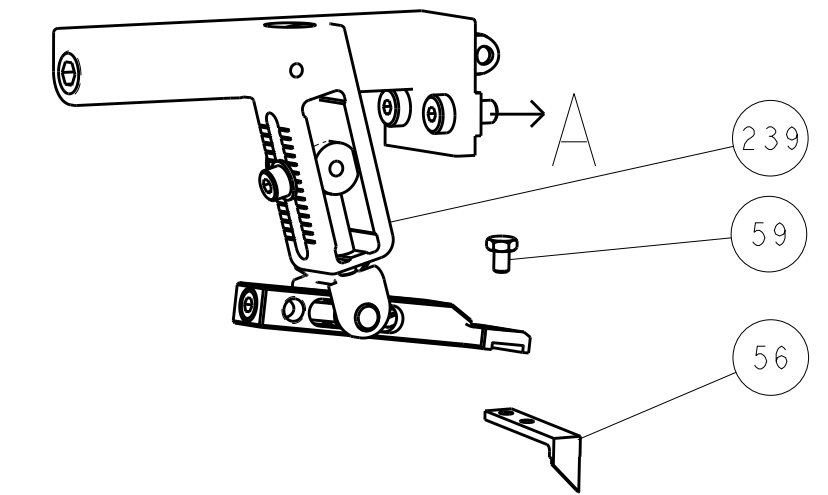
	-	4	4	4	1	4	2168400-1	SACS, LOW HEAD, ROHS, M4 X 12	:54
	-	2	2	2	2	2	21680083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	:53
	-	1	1	1	1	1	5018030-1	NUT, HEX, REG, ROHS, M3	:52
	-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	:51
	-	1	1	1	1	1	690753-2	SPACER, TONKER	:50
	-	-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	:49
	-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	:48
	-	-	-	-	-	-	-	-	:47

THIS DRAWING IS A CONTROLLED DOCUMENT FOR FPD ELECTRONICS CORPORATION IT IS SUBJECT TO COMPANY AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN HOFFNER 18NOV2013 CHK T.FELBIN 19NOV2013 APVD T.FELBIN 19NOV2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOL. DIMENSIONS, UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A1	
MATERIAL -		FINISH -		DRAWING NO 00779	
WEIGHT -		RESTRICTED TO -		SCALE 1:2	
SHEET 1		OF 4		REV A	
Customer Accessible Production Drawing					

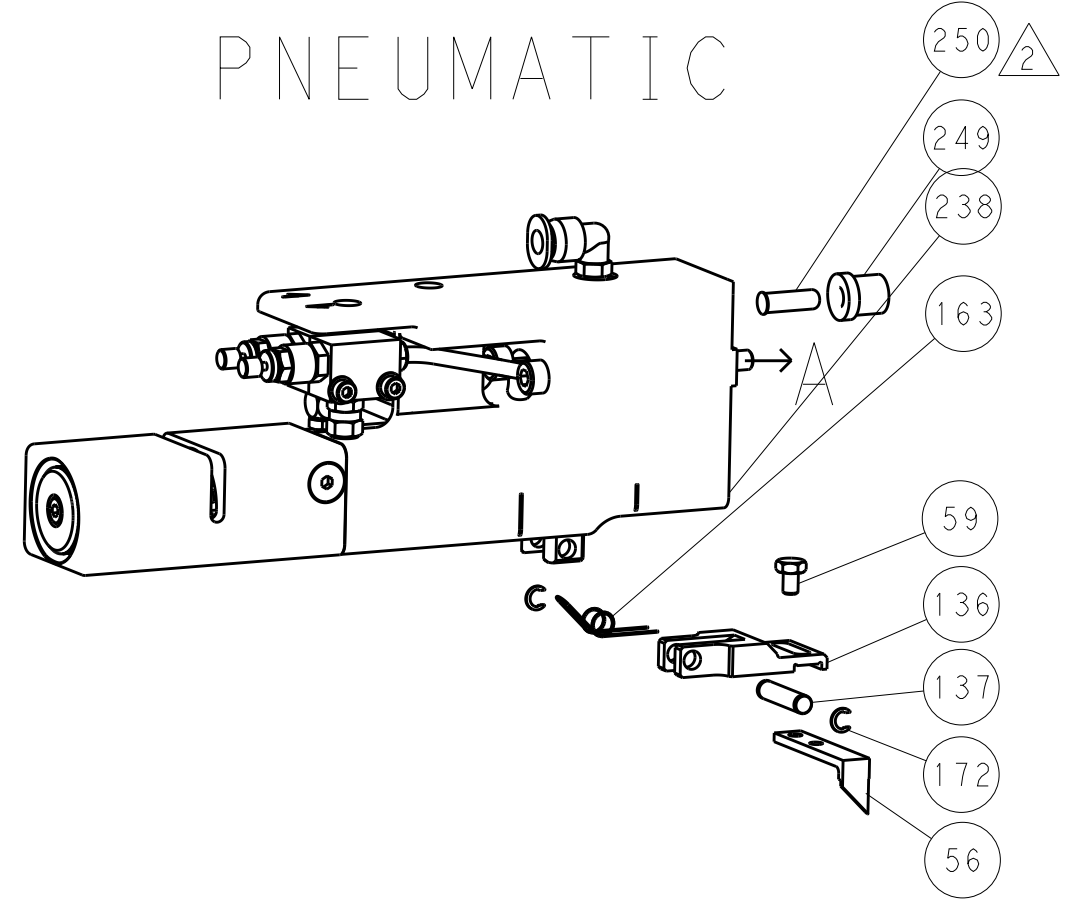
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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

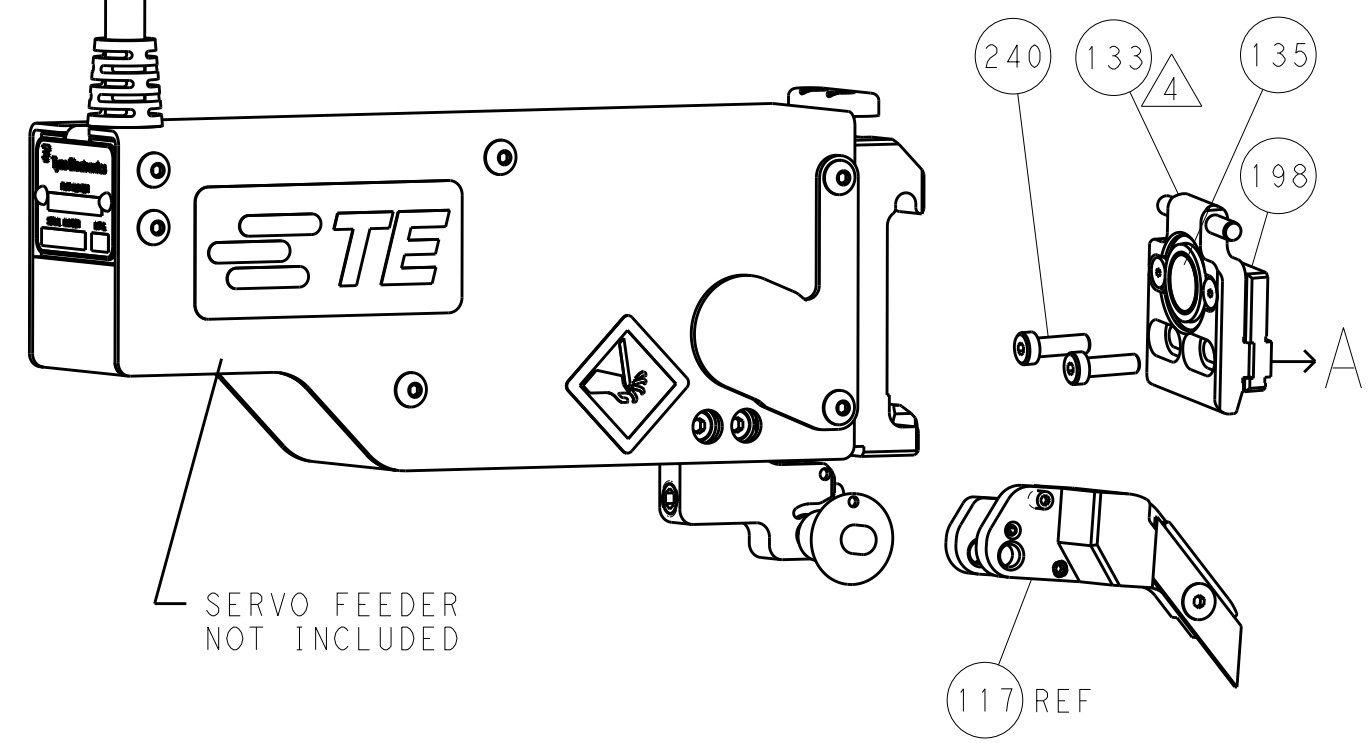
FEED TYPE MECHANICAL



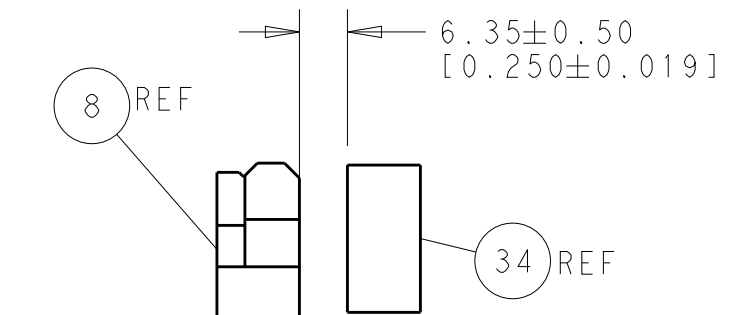
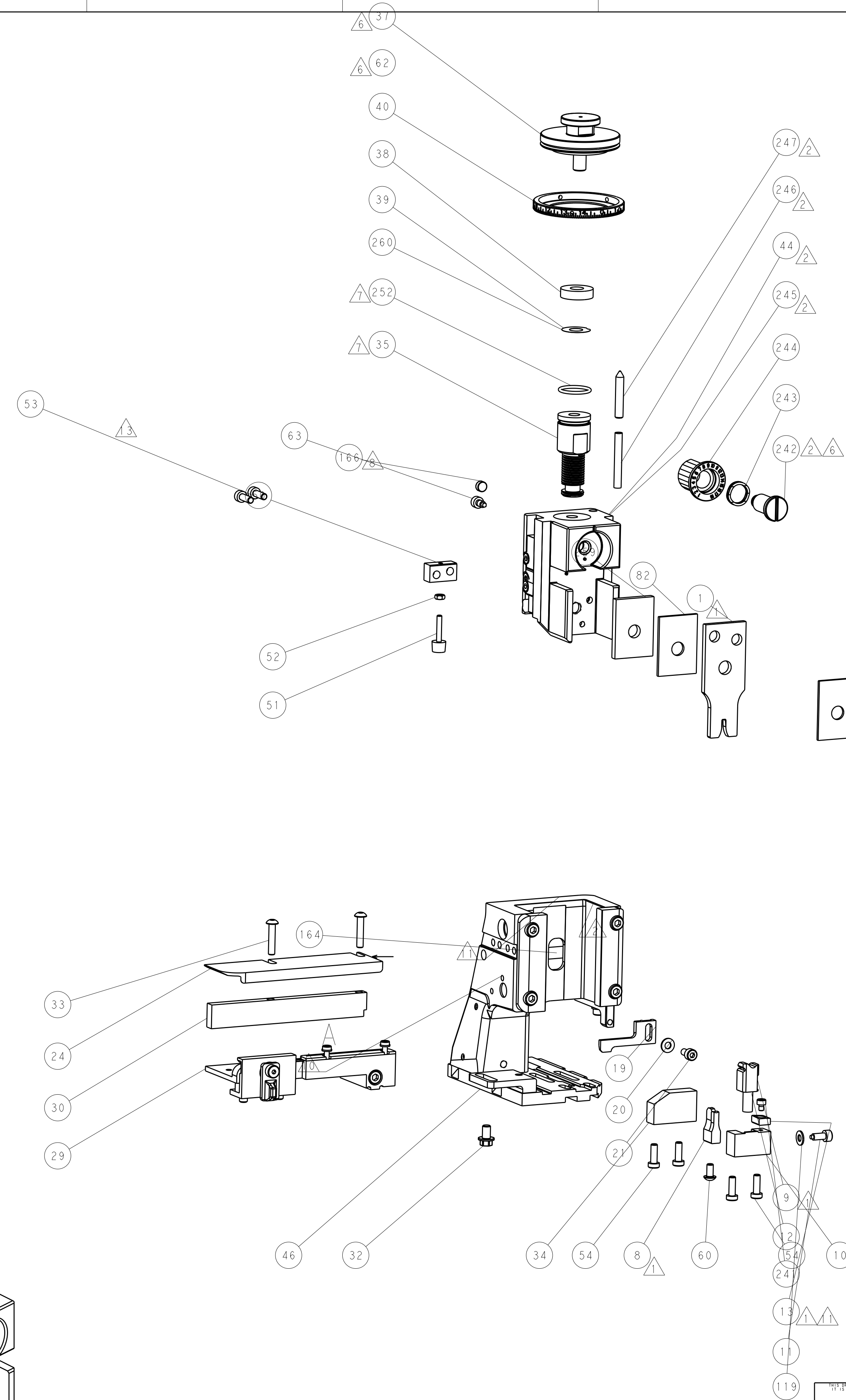
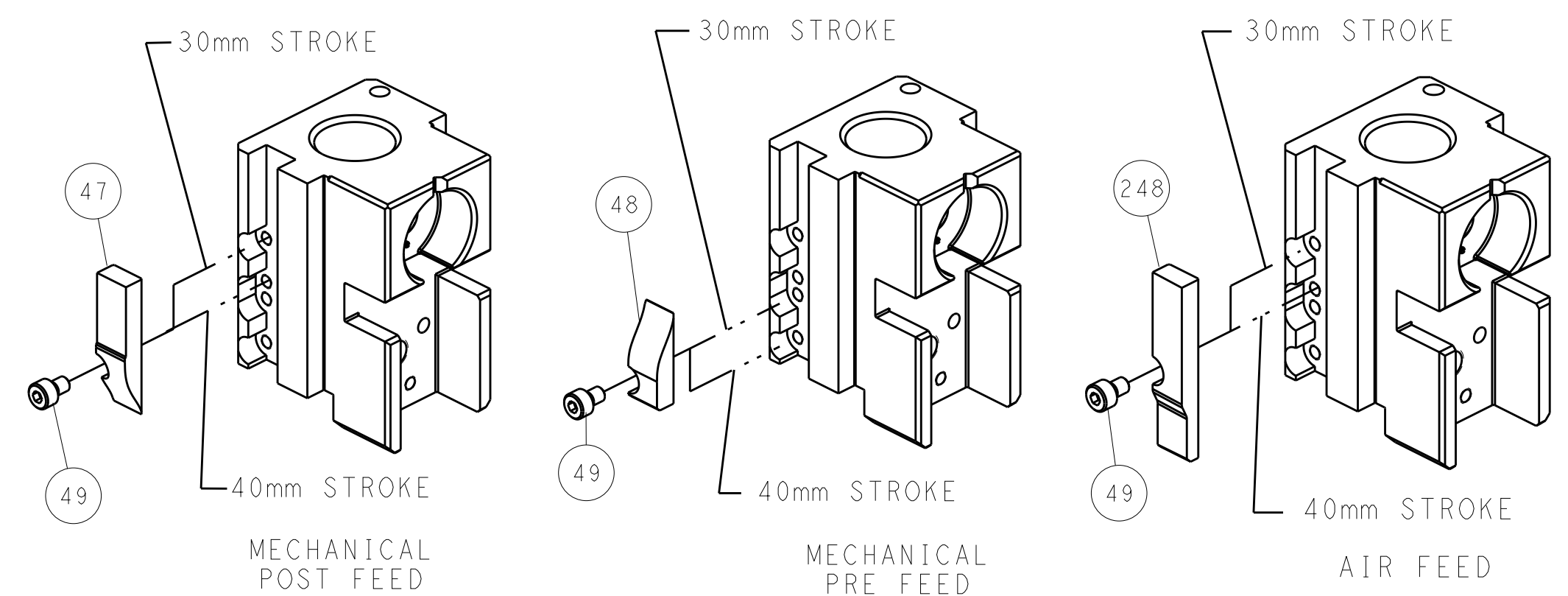
PNEUMATIC



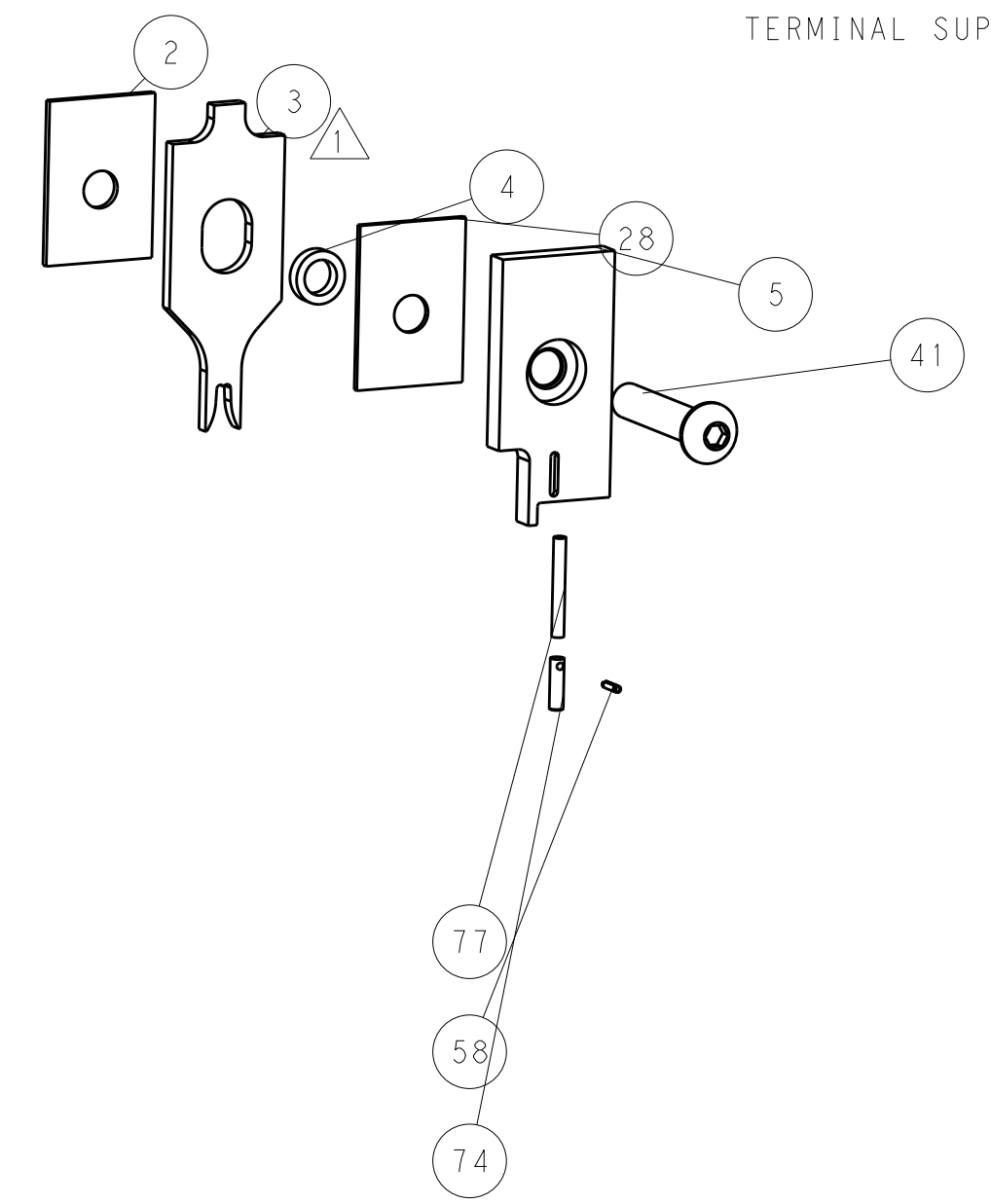
SERVO LATCH PLATE



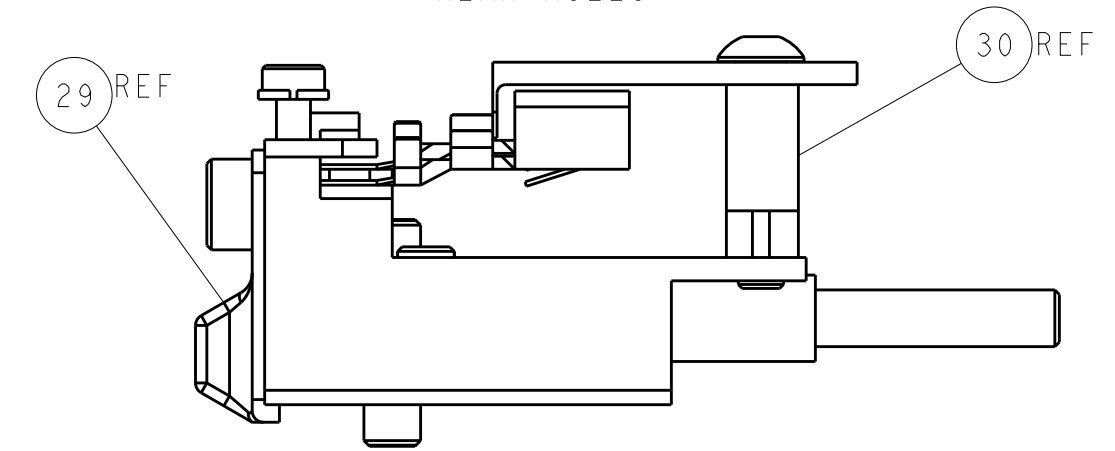
CAM POSITIONS



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT REAR HOLES



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: HOFFNER 18NOV2013		CHK: TELBIN 19NOV2013		APVD: TELBIN 19NOV2013		NAME: Ocean Side Feed Applicator	
mm		0 PLC ±0.5		1 PLC ±0.5		2 PLC ±0.13		3 PLC ±0.13		4 PLC ±0.001	
ANGLES		FINISH		WEIGHT		SIZE: A1		CAGE CODE: 00779		DRAWING NO: C=2266153	
MATERIAL		RESTRICTED TO		Customer Accessible Production Drawing		SCALE: 1:2		SHEET: 2 of 4		REV: A	

	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266153-1	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	-	8-2266153-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266153-4	-	-	-
	2-2266153-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266153-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266153-4	-	-	-
	2-2266153-5	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
	2-2266153-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266153-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.49 mm [.098]	F
INSUL	3.56 mm [.140]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION			
TERMINAL NAME: TAXI TERMINAL F M/P 630			
WIRE STRIP LENGTH 5.16-5.95 mm [.203-.234 IN]		INSULATION DIAMETER RANGE Ø3.14-3.97 mm [.124-.156 IN]	
TERMINAL APPLICATION SPECIFICATION	-	-	-
TERMINALS APPLIED			
TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
286723-1	12066614		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
2.00mm2		1.85+/-0.05 [.073+/-0.002]		4.2
1.50mm2		1.75+/-0.05 [.069+/-0.002]		4.8
1.00mm2		1.65+/-0.05 [.065+/-0.002]		6



- 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: 8-2266153-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266153-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266153-5
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 & 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. CUT TO LENGTH AT ASSEMBLY.

*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.

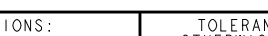
-	1	1	1	1	1803078-3	SPACER, PRECISION	259
							251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

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

			2		1						
SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS							
				P	LTR	DESCRIPTION			DATE	OWN	APVD
					-	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	2119082-6	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	-	2063440-1	AIR FEED MODULE	239
-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	1901094-3	SPACER, FEEDER	213
-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	198
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	172
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	166
-	-	-	1	-	240638-1	SPRING, FEED FINGER	164
							163
							152
							151
							145
							144
							143
							142
-	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	2161312-1	RAM, STEPPED, 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
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	1-455888-6	SPACER, CRIMPER	82
-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	1	854769-4	HOLDER, INS	74
							71
							67
							66
-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
					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	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	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	1752356-1	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	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-1	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	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	6-1633927-8	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	6
-	1	1	1	1	1-2119780-2	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	3-2119582-8	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1-455888-4	SPACER, CRIMPER	2
-	1	1	1	1	4-1633305-2	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE ORGANIZATION SHALL BE CONTACTED FOR THE LATEST REVISION.				OWN T. ELBIN 18NOV2013	CHK T. ELBIN 19NOV2013	TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		APVD T. ELBIN 19NOV2013	NAME Ocean Side Feed Applicator	SIZE A1	CAGE CODE 00779	DRAWING NO C=2266153	RESTRICTED TO -
MATERIAL -		FINISH -		PRODUCT SPEC -	APPLICATION SPEC -	Customer Accessible Production Drawing			
				WEIGHT -	SCALE 1:2		SHEET 3	OF 4	REV A

TEST DRAWING: IS A CONTROLLED DOCUMENT FOR TWO ELECTRONIC COMPONENTS THIS IS DERIVED FROM THE ORIGINAL DRAWING AND THE CONTROL INSTRUCTIONS TO ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST VERSION.		OWN: HOFFNER 18NOV2013 CHK: T.ELBIN 19NOV2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±0.5 3 PLC ±0.13 5 PLC ±0.013 4 PLC ±0.0001 ANGLES ±		NAME: Ocean Side Feed Applicator -	
		PRODUCT SPEC APPLICATION SPEC		SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO: A 00779 C=2266153 -	
MATERIAL: FINISH:		WEIGHT: -		Customer Accessible Production Drawing SCALE: 1:2 SHEET 4 OF 4 REV A	