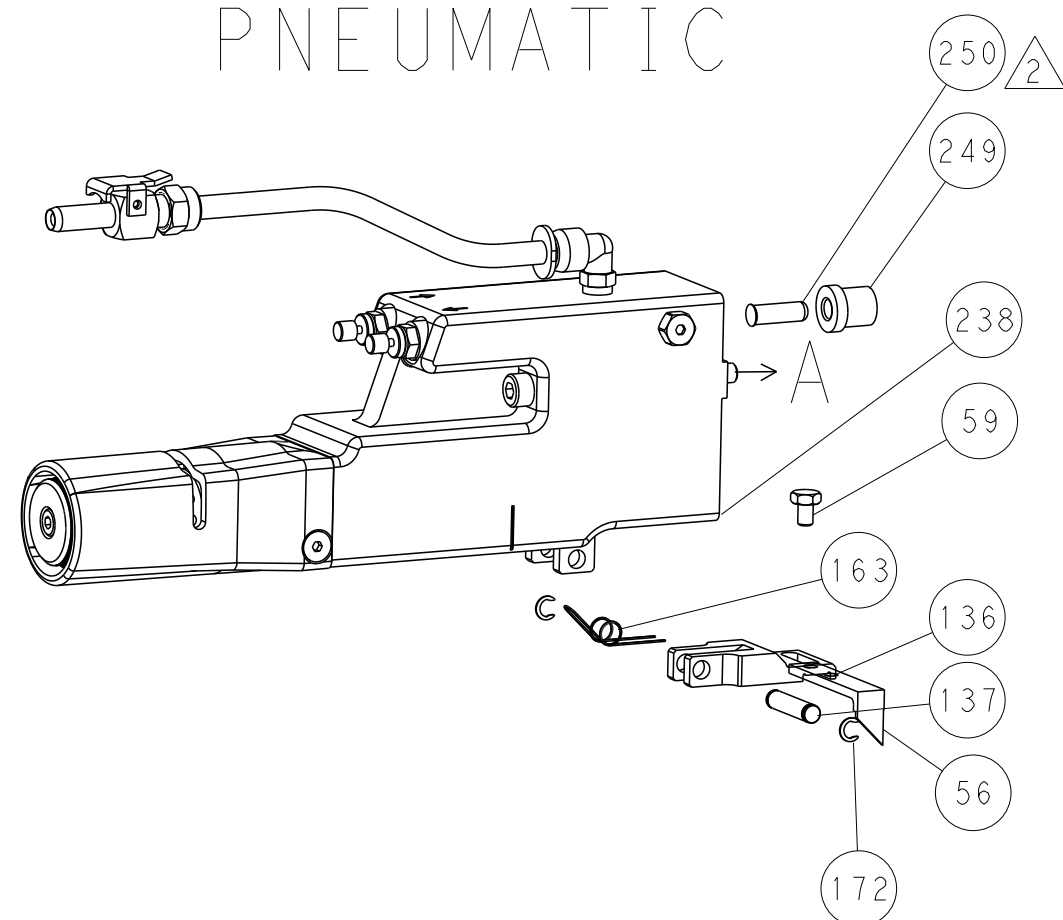
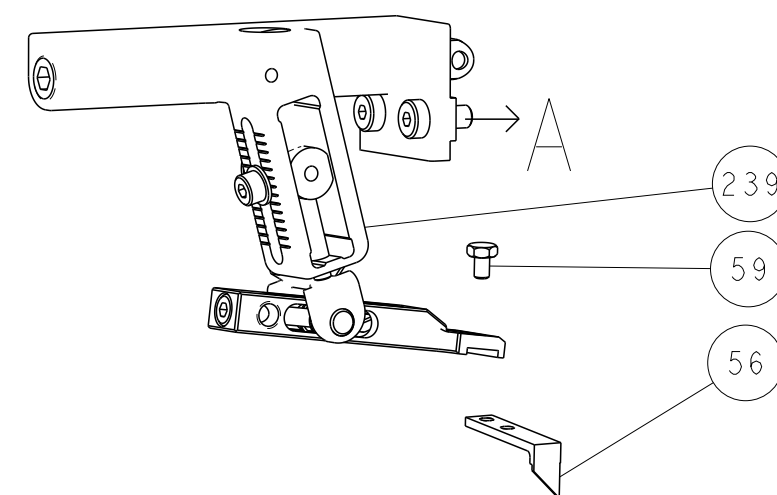


PNEUMATIC



LATCH PLATE

SERVO FEEDER
NOT INCLUDED

240 133 4 135 198

117 REF

30mm STROKE

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

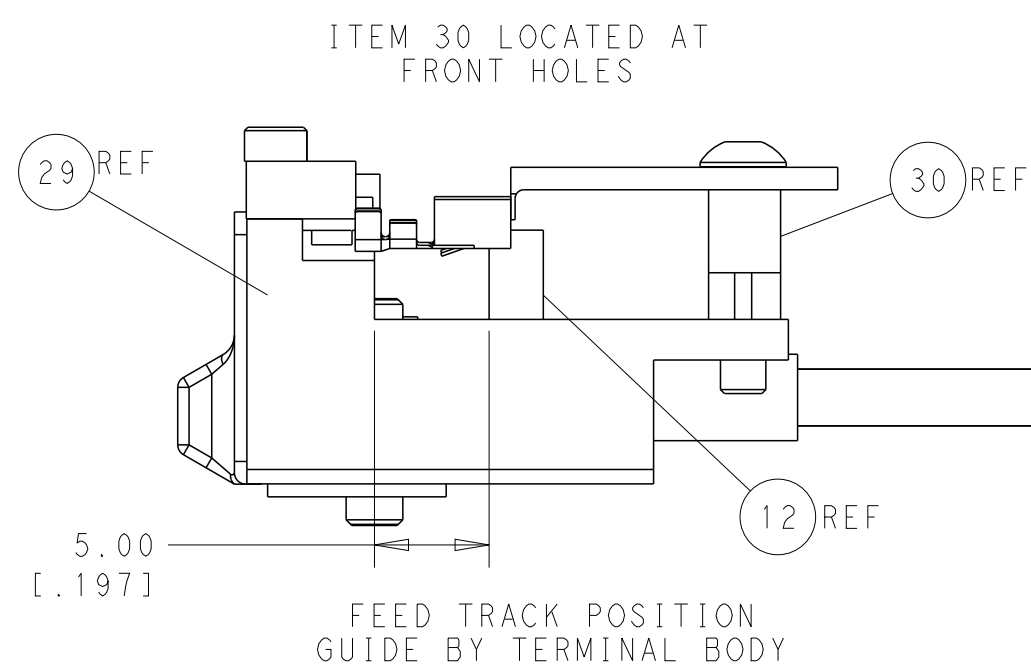
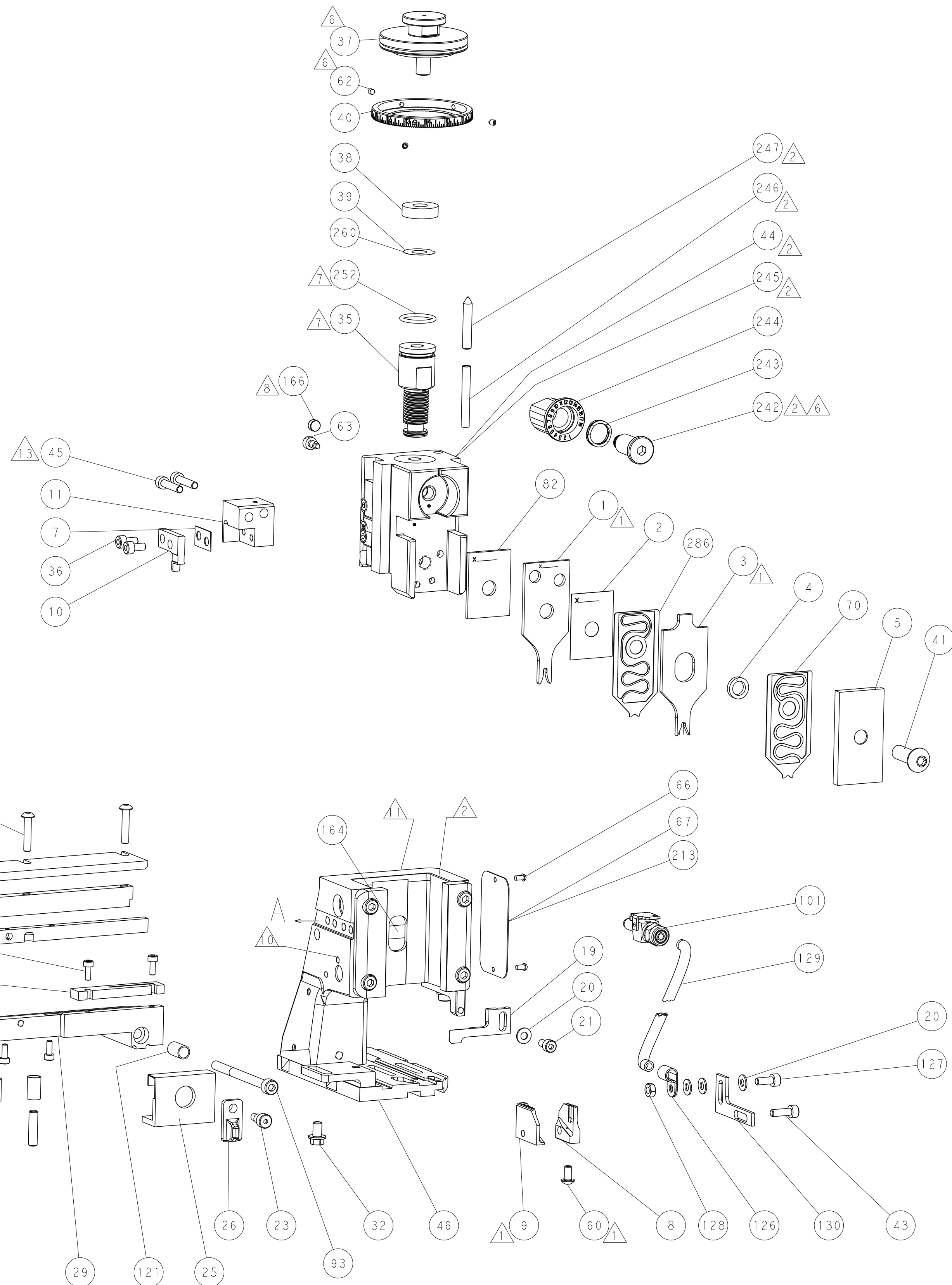
40mm STROKE

MECHANICAL PRE FEED

30mm STROKE

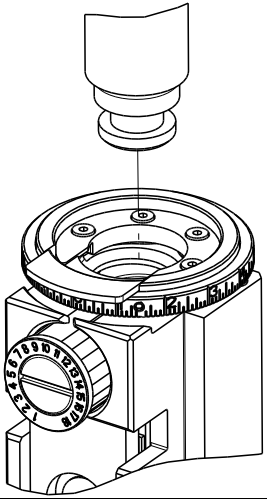
40mm STROKE

AIR FEED



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 THE PURPOSES OF THE ISO 9001 CERTIFICATION IT SHOULD BE CONTROLLED FOR THE LATEST REVISION				DWN 30MAY2012 R.O.WILSON		 TE Connectivity Harrisburg, PA 17105-3608					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		CHK J.J.STAKEM 15JUN2012		NAME Ocean Side Feed Applicator					
mm		0 PLC ±. 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.		APD F.LBIN 18JUN2012		SIZE CASE CODE DRAWING NO					
				PRODUCT SPEC		A 00779 C=2151433					
				APPLICATION SPEC		RESTRICTED TO					
MATERIAL		FINISH		WEIGHT		Customer Accessible Product Drawing					
-		-		-		SCALE 1:2		SHEET 2 of 4		REV D	

8		7		6		5		4		3		
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20								
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	PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
						SERVO LATCH PLATE	2119951-1	-	8-2151433-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2151433-4	-	-	-
						MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
						SERVO LATCH PLATE	2119951-1	-	8-2151433-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2151433-4	-	-	-
						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	
						-	-	-	-	-	-	
						-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.00 mm [.079]	F
INSUL	2.49 mm [.098]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: MOLEX TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: KK CRIMP TERMINAL, 3.96mm PITCH			
WIRE STRIP LENGTH .108-.123 IN [2.74-3.12 mm]		INSULATION DIAMETER RANGE Ø.000-.110 IN [0.00-2.79 mm]	
TERMINAL APPLICATION SPECIFICATION	ATS-639007200	-	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1572397-1	08-50-0105	1-1572397-1	08-53-0811
1572397-2	08-52-0071	1-1572397-2	08-55-0133
1572397-3	08-58-0121	1-1572397-3	08-58-0103
1572397-4	08-56-0105	1-1572397-4	08-58-0114
1572397-5	08-65-0114	1-1572397-5	39-00-0286
1572397-6	08-55-0103	1-1572397-6	39-00-0347
1572397-7	08-50-0015	1-1572397-7	40-01-1118
1572397-8	08-50-0119	1-1572397-8	50-29-1689
1572397-9	08-50-0281	1-1572397-9	50-29-1768
1-1572397-0	08-52-0811		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.81mm2	1.12+/-0.05 [.044+/- .002]	5.6
18 AWG OR 0.80mm2	1.12+/-0.025 [.044+/- .001]	5.9
20 AWG OR 0.50mm2	1.05+/-0.025 [.042+/- .001]	6.5
22 AWG OR 0.35mm2	1.00+/-0.025 [.039+/- .001]	6.8
24 AWG OR 0.20mm2	0.94+/-0.03 [.037+/- .001]	7.3

- 
- 

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: 8-2151433-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151433-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151433-5
- 

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. CUT TO LENGTH AT ASSEMBLY.
- 

13. SPECIAL APPLICATION FOR USE WITH 18AWG UL1015, 16 STRAND (.010") [.081mm2 .254mm] ONLY.

TERMINAL DATA: MOLEX TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: KK CRIMP TERMINAL, 3.96mm PITCH			
WIRE STRIP LENGTH .108-.123 IN [2.74-3.12 mm]		INSULATION DIAMETER RANGE Ø.000-.110 IN [0.00-2.79 mm]	
TERMINAL APPLICATION SPECIFICATION	ATS-639007200	-	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
286984-1	08-58-0110	286984-6	08-50-0024
286984-2	08-58-0187	286984-7	08-58-0105
286984-3	08-50-0187	286984-8	08-58-0118
286984-4	08-52-0112		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.80mm2	1.12+/-0.025 [.044+/- .001]	5.9
20 AWG OR 0.50mm2	1.05+/-0.025 [.042+/- .001]	6.5

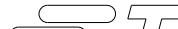
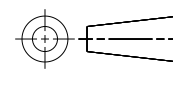
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	286
-	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	2119082-9	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
-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-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	-	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
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	2119656-2	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
-	1	1	1	1	2217068-1	BRACKET, AIR BLAST	130
-	457	457	457	457	2030758-3	TUBING, POLYURETHANE	129
-	1	1	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	128
-	1	1	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	127
-	1	1	1	1	986220-3	CLAMP, CABLE, BLACK	126
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	23238-1	INSERT, COUPLING	101
-	1	1	1	1	1-690487-3	GUIDE, FRONT STRIP	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	1-455888-9	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-7	DEPRESSOR, WIRE	70
-	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
-	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	45
-	1	1	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	43
-	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
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	36
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	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	1320908-9	SPACER, STRIP GUIDE	30
-	1	1	1	1	1-1901086-9	PLATE, STRIP GUIDE	29
-	2	2	2	2	22281-7	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	4-690754-5	DRAG, SPECIAL	25
-	1	1	1	1	1-1320928-0	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	4	4	4	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-4	STRIPPER, SIDE FEED	19
-	1	1	1	1	1-2119928-5	FENCE	12
-	1	1	1	1	2119830-8	HOLDER, SLUG BLADE	11
-	1	1	1	1	1633579-1	BLADE, SLUG	10
-	1	1	1	1	1633578-3	PLATE, REAR SHEAR	9
1	1	1	1	1	1633576-4	ANVIL, SPECIAL	8
-	1	1	1	1	2-240641-1	SPACER	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1803203-1	BLOCK, FRONT DEPRESSOR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	5-1633966-3	CRIMPER, INSULATION O	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	1	6-1633609-6	CRIMPER, WIRE	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator					
		0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.013 3 PLC ±0.0001 ANGLES ±.5°		PRODUCT SPEC		SIZE CASE CODE DRAWING NO RESTRICTED TO					
MATERIAL		FINISH		WEIGHT		A1 00779 C=2151433					
Customer Accessible Production Drawing						SCALE 1:2		SHEET 3 of 4		REV D	

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

D

C

B

A

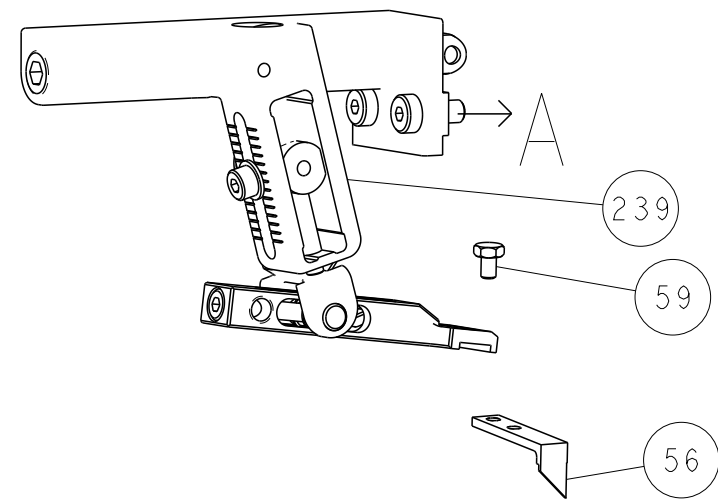
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C

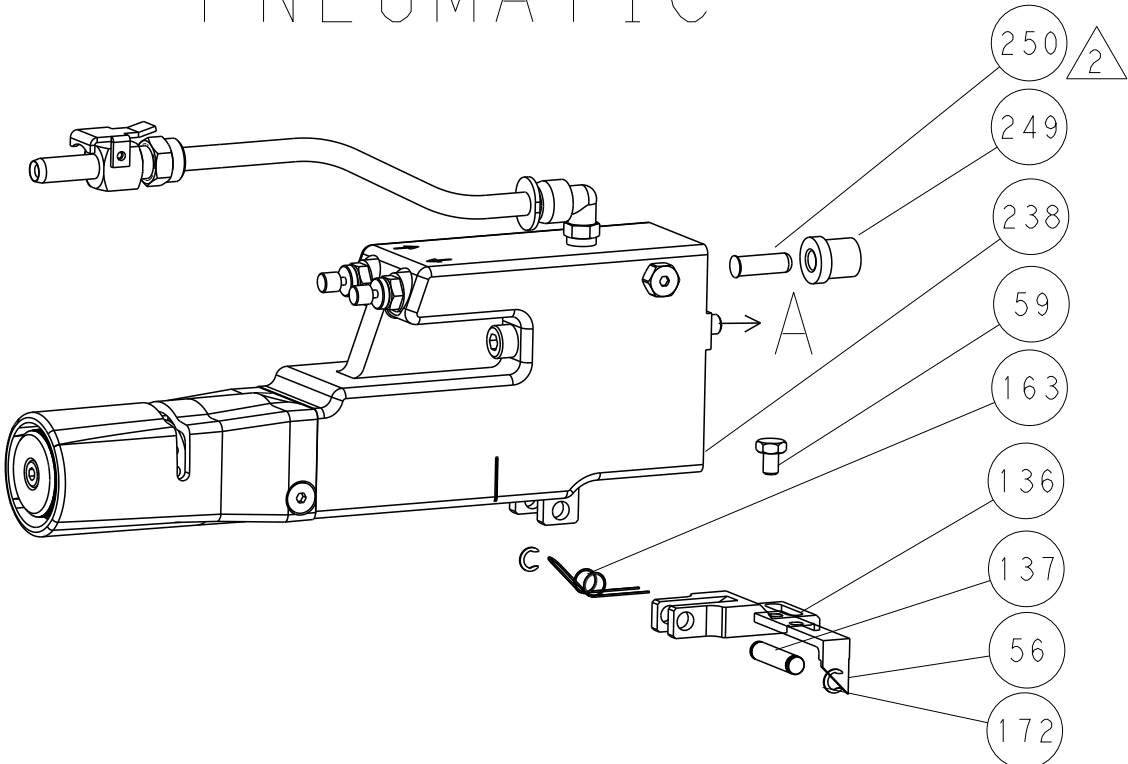
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A

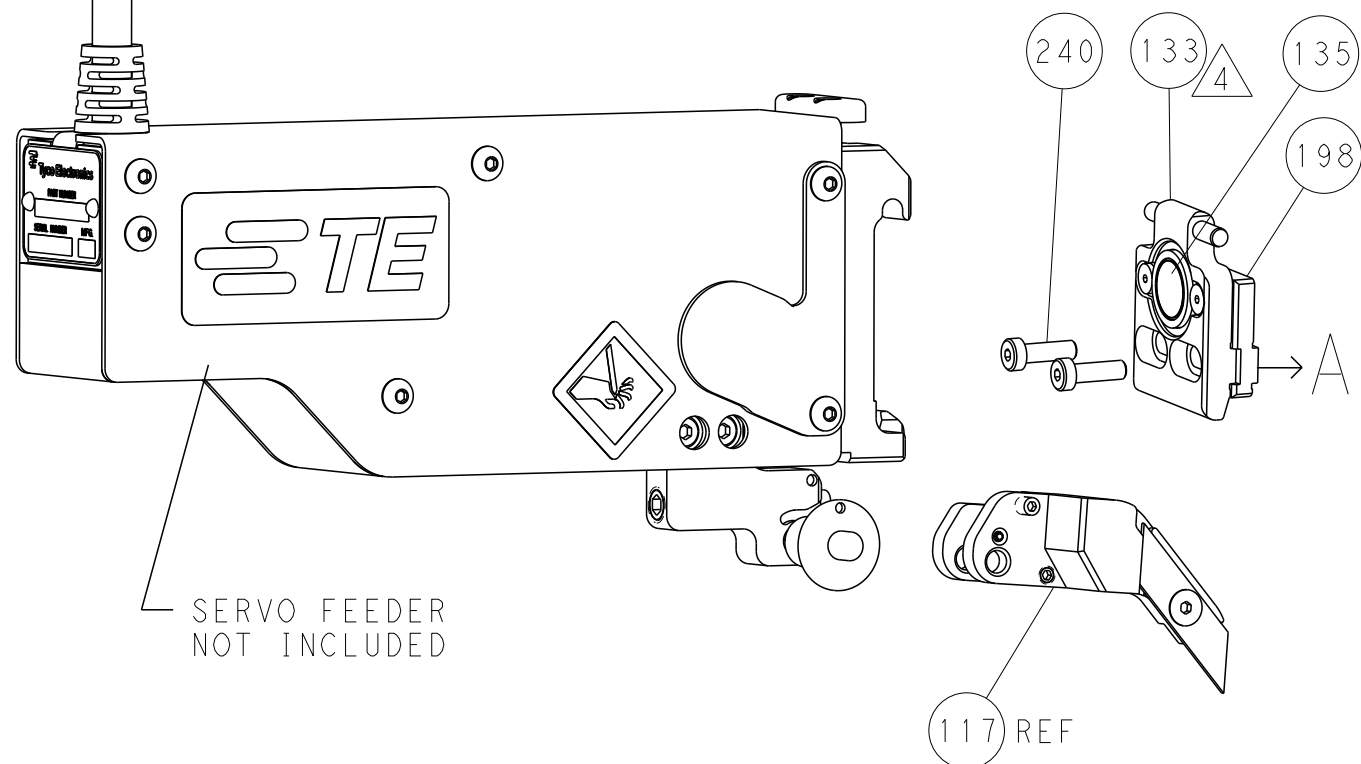
FEED TYPE MECHANICAL



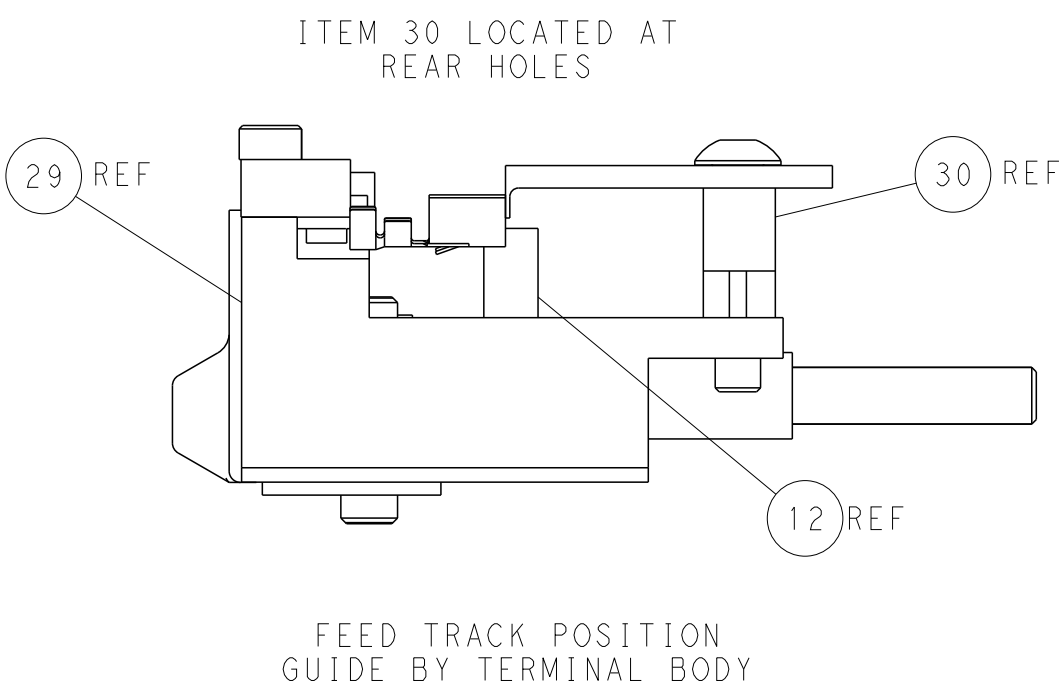
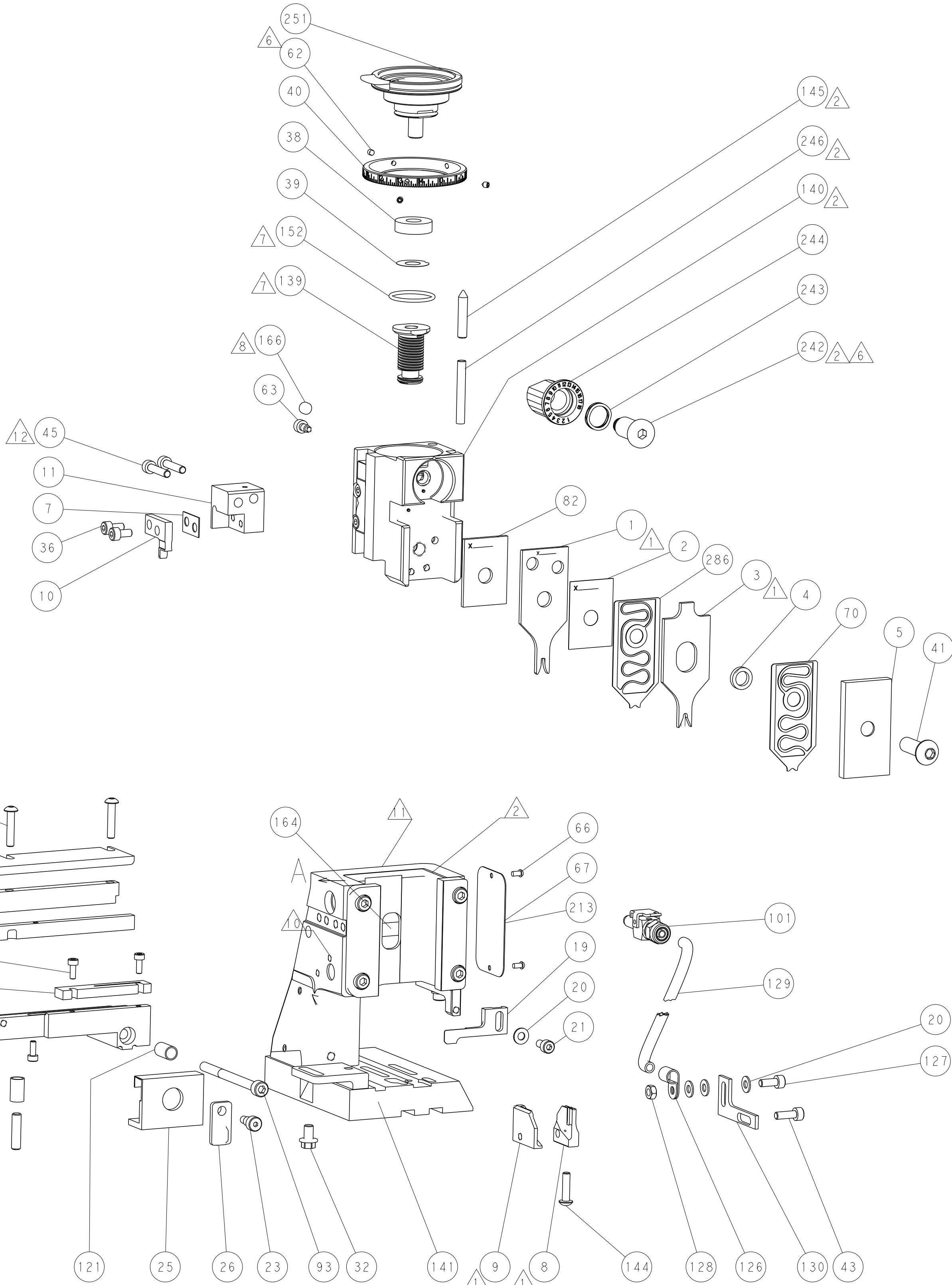
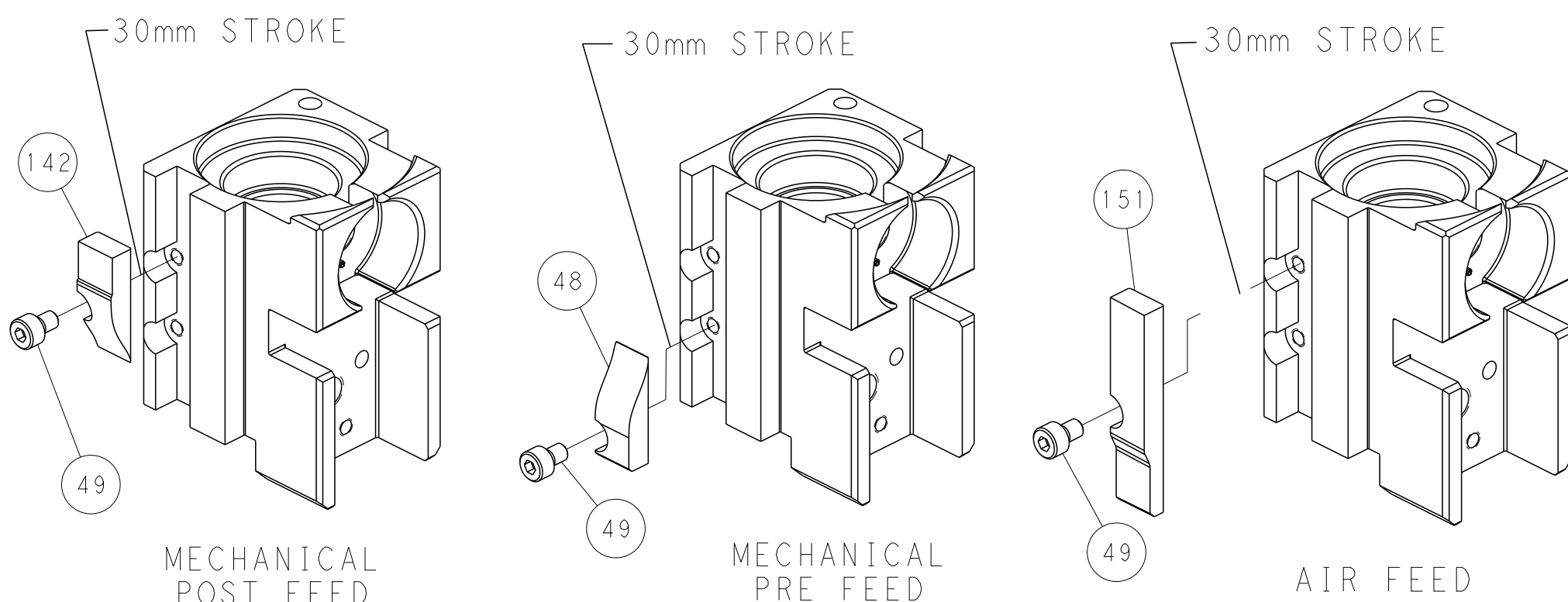
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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 R.O.WILSON 30MAY2012		STE TE Connectivity	
mm		0 PLC ±.5		CHK K.J.STAKEM 15JUN2012		Harrisburg, PA 17105-3608	
		1 PLC ±0.5		APVD T.ELBIN 18JUN2012		NAME Ocean Side Feed Applicator	
MATERIAL		2 PLC ±0.13		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
		3 PLC ±0.013		APPLICATION SPEC		A 00779 C=2151433	
		4 PLC ±0.0001		WEIGHT		Customer Accessible Production Drawing	
		ANGLES FINISH		SCALE 1:2		SHEET 4 OF 4	
						REV D	