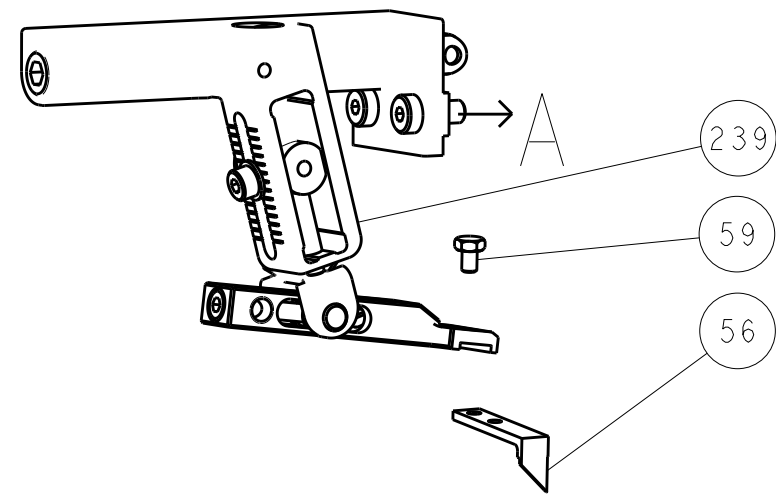
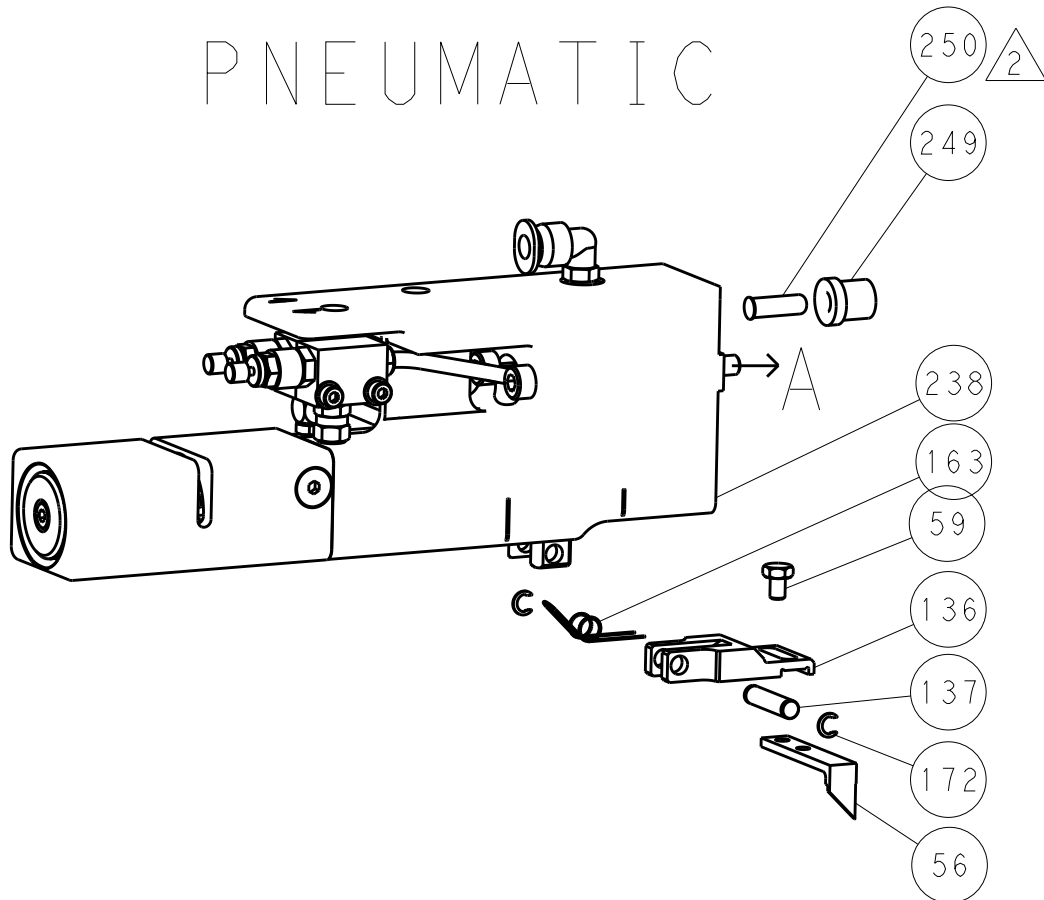


LOC	DIST	REVISIONS					
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
			-	SEE SHEET 1	-	-	-

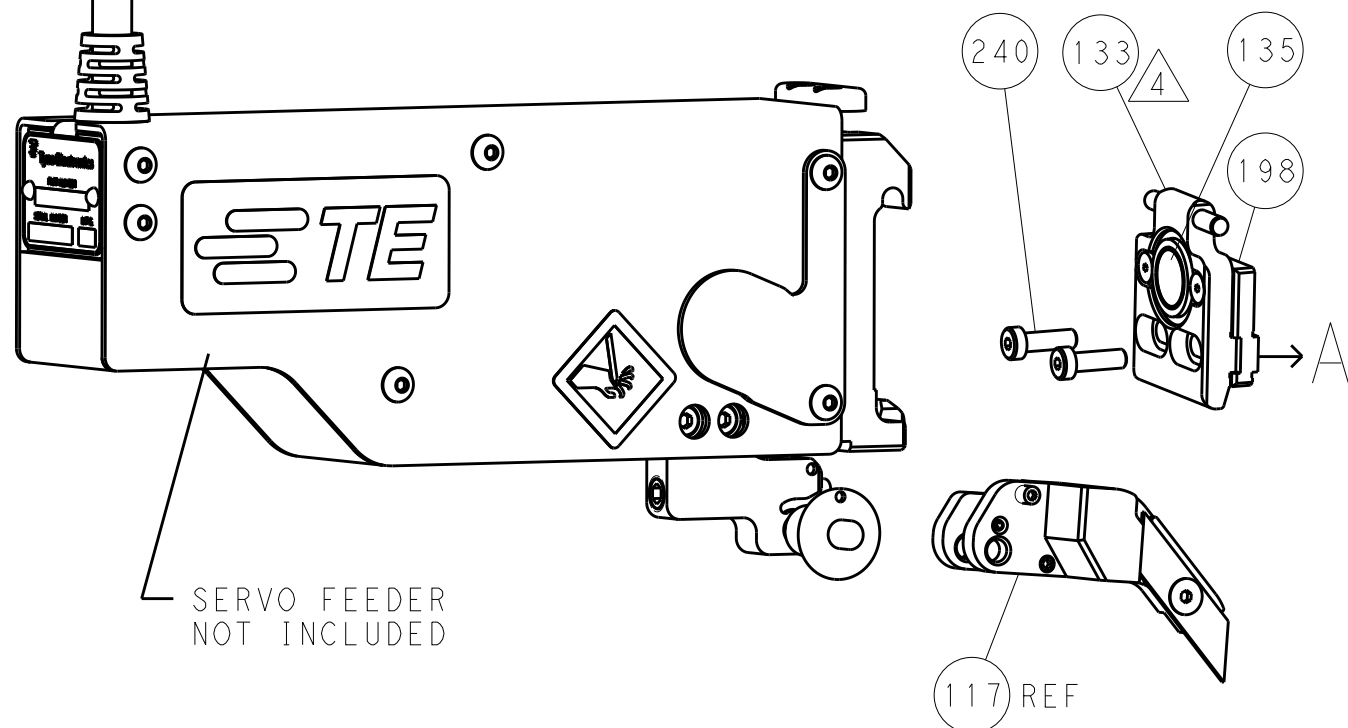
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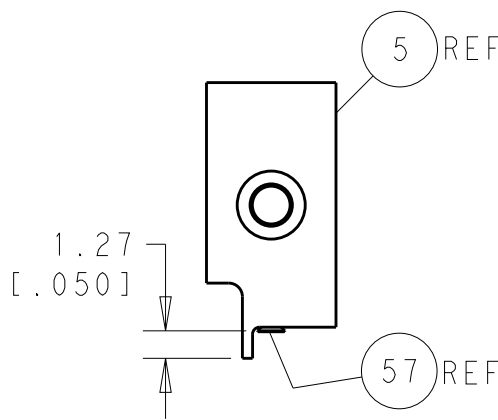
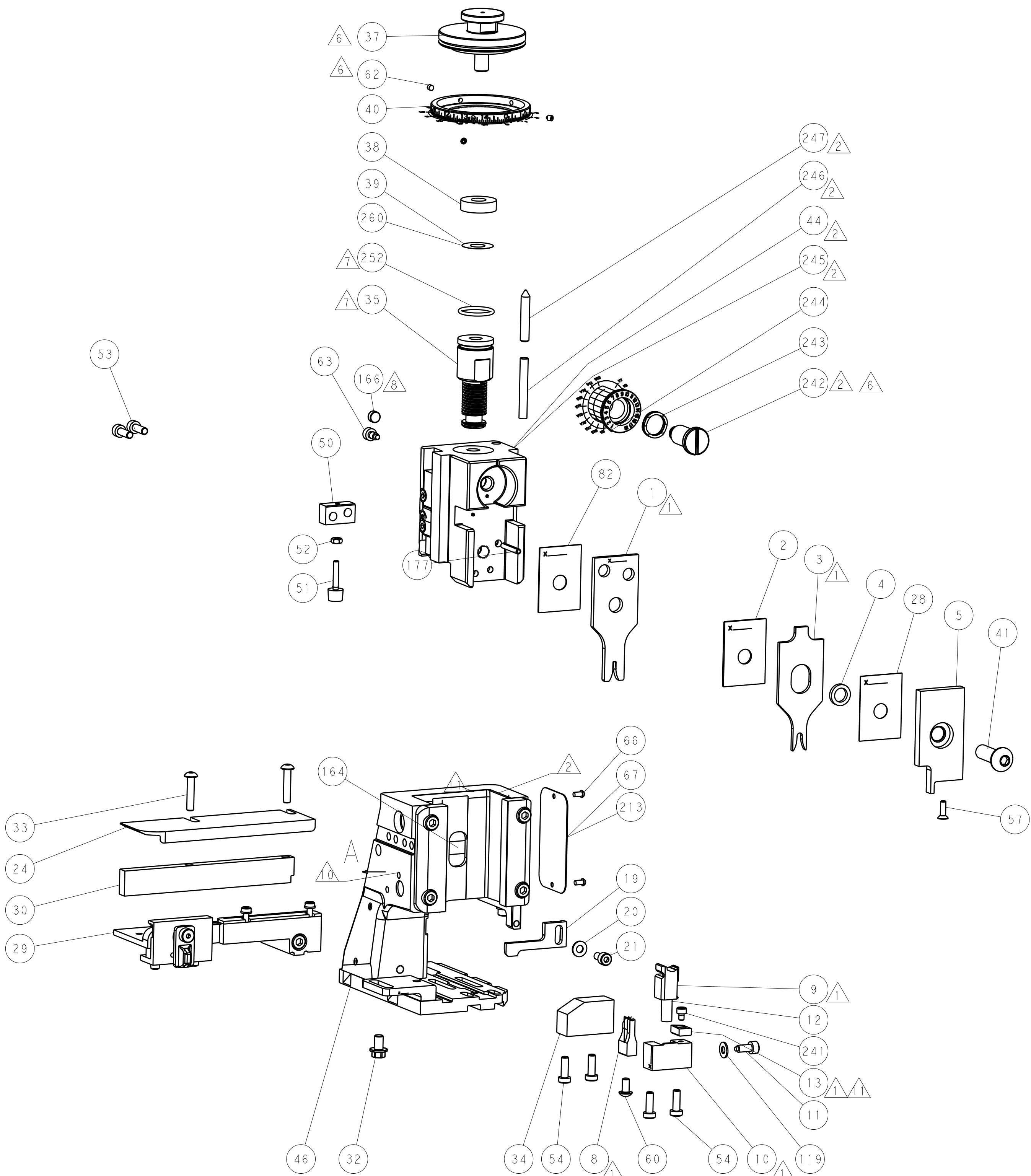
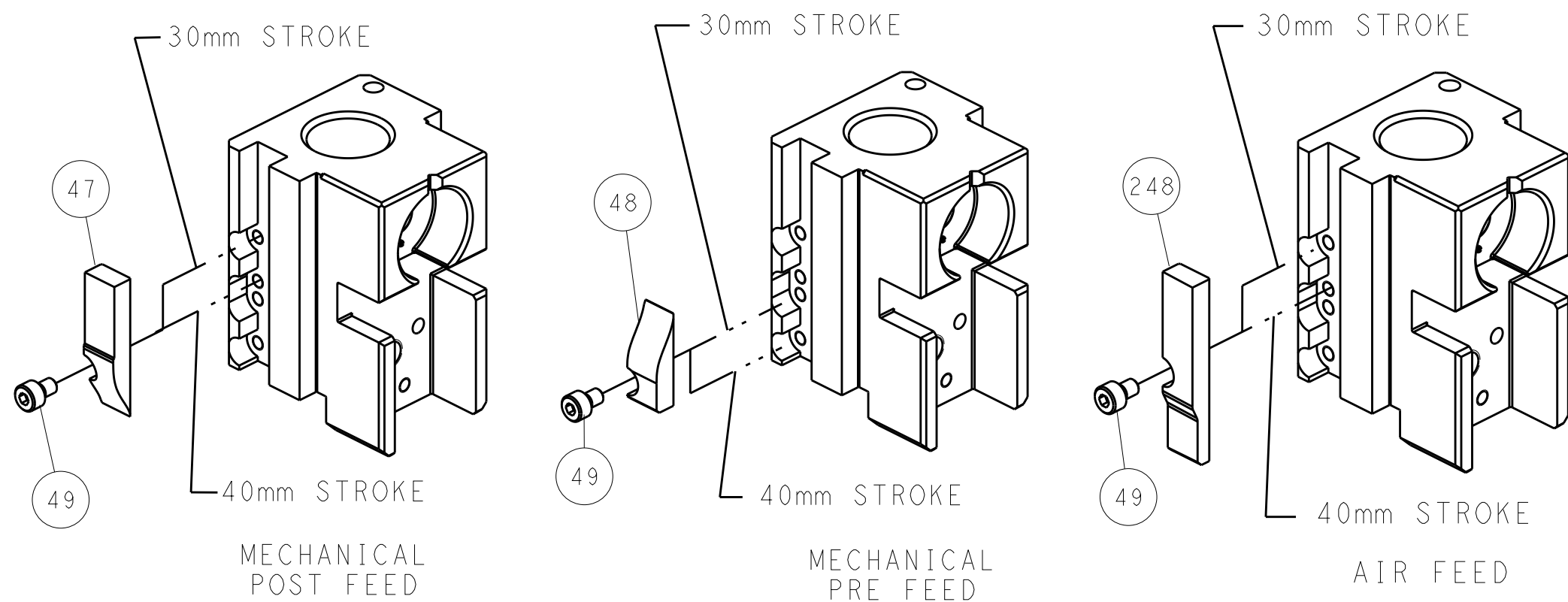
PNEUMATIC



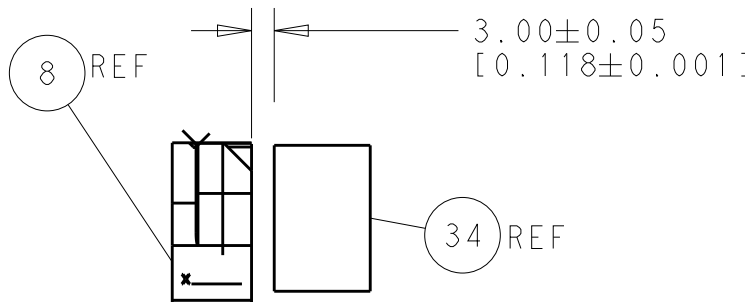
SERVO LATCH PLATE



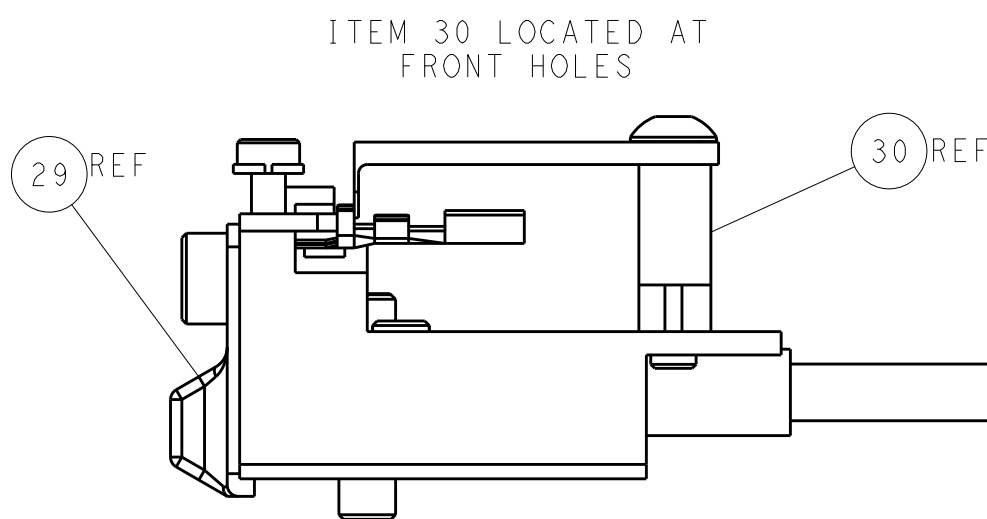
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

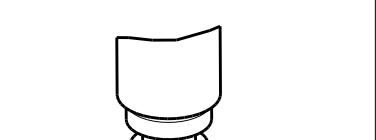


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

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CHK: S. XI 30MAY2011				APVD: J. CRUZ 30MAY2011				Harrisburg, PA 17105-3608			
DIMENSIONS: mm				PRODUCT SPEC				NAME: Ocean Side Feed Applicator			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				APPLICATION SPEC				SIZE: A1			
0 PLC ±0.5				WEIGHT				CAGE CODE: 00779			
1 PLC ±0.13				FINISH				DRAWING NO: 2151105			
2 PLC ±0.13				MATERIAL				SCALE: 1:2			
3 PLC ±0.013				Customer Accessible Production Drawing				SHEET 2 OF 4			
4 PLC ±0.0001				RESTRICTED TO				REV A			
ANGLES				Customer Accessible Production Drawing				SHEET 2 OF 4			

8	7
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151105-1	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	-	8-2151105-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151105-4	-	-	-
	2-2151105-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151105-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151105-4	-	-	-
	2-2151105-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	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
	2-2151105-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151105-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.40 mm [.134]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: RECEPTACLE CONTACT 070 TYPE			
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]		INSULATION DIAMETER RANGE Ø1.40-2.40 mm [.055-.094 IN]	
TERMINAL APPLICATION SPECIFICATION 		114-5082 - -	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
171630-1	171630-2	172746-1	9-172746-1
171630-5	-	178210-1	1-178210-3
		347874-1	347681-1

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.50mm2		1.09+/- 0.05 [.043+/- .002]		6.4
0.30mm2		1.06+/- 0.05 [.042+/- .002]		6.8
0.20mm2		1.00+/- 0.05 [.039+/- .002]		7.4

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PECEPTACLE CONTACT 070 TYPE			
WIRE STRIP LENGTH 4.00-4.50mm [.157-.177 IN]		INSULATION DIAMETER RANGE Ø 1.1-1.8mm [.043-.071 IN]	
TERMINAL APPLICATION SPECIFICATION 		114-3040 - -	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
345808-1	347661-1	172746-1	9-172746-1
-	-	178210-1	1-178210-3
		347874-1	347681-1

WIRE SIZE			CRIMP HEIGHT W1_CRIMP_UNIT		CRIMP HEIGHT REFERENCE SETTING
0.50mm2			1.14+/-0.05 [0.045+/-0.002]		5.7
0.35mm2			1.07+/-0.05 [0.042+/-0.002]		6.8

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: PECEPTACLE CONTACT 070 TYPE			
WIRE STRIP LENGTH 4.00-4.50mm [.157-.177 IN]		INSULATION DIAMETER RANGE Ø 1.1-1.8mm [.043-.071 IN]	
TERMINAL APPLICATION SPECIFICATION	114-3142	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
345808-1	-	172746-1	9-172746-1
-	-	178210-1	1-178210-3
		347874-1	347681-1

WIRE SIZE			CRIMP HEIGHT W1_CRIMP_UNIT		CRIMP HEIGHT REFERENCE SETTING
0.22mm2			1.00+/-0.05 [0.039+/-0.002]		7.4

*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.



 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: 8-2151105-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151105-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151105-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151105-6

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 & 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.

 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.

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

6	-	1	1	1	1	2119782-1	LINE 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	2119082-7	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	
	-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
	-	-	-	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	
	-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	-	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	1	2119740-1	TAG, IDENTIFICATION	67		
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	66		
-	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	
	-	-	-	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	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	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	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	
	-	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	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	318707-1	FLOATING SHEAR, FRONT	9
		1	1	1	1	1	1333202-6	ANVIL, COMBINATION	8
	1	-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
		-	1	1	1	1	5-238011-5	BLOCK, CRIMPER SPACER	4
1		1	1	1	1	1803018-3	CRIMPER, INSULATION O	3	
1	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	2	
	1	1	1	1	1	1-456403-2	CRIMPER, WIRE PREMIUM	1	

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										CHK S.XI 30MAY2011			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:								NAME		Ocean Side Feed Applicator -	
mm										APPROV. CRU7 30MAY2011			
		Ø PLC ± PLC ±0.5 2 PLC ±0.13 2 PLC ±0.013 ANGLES ±0.0001								PRODUCT SPEC			
										APPLICATION SPEC			
MATERIAL	FINISH	WEIGHT								SIZE CAGE CODE DRAWING NO.		RESTRICTED TO	
-	-	-								A 00779 C=2151105		-	
Customer Accessible Production Drawing										SCALE		1:2 SHEET 3 OF 4 REV A	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

AMP 4805 REV 31MAR2000

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

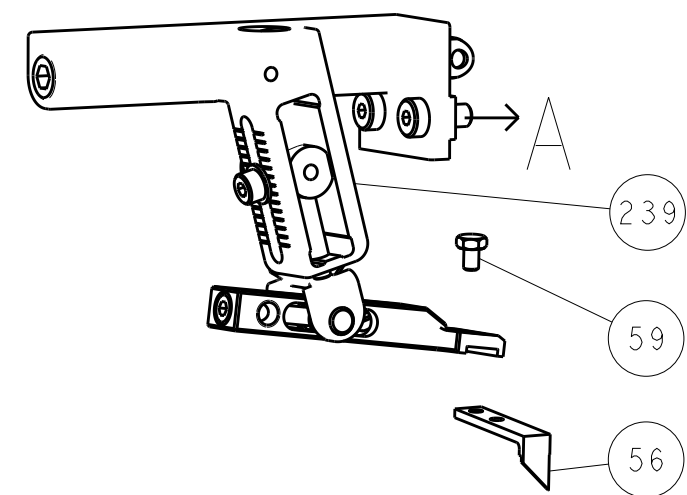
DIMENSIONS AND TOLERANCING PER ASME Y14.5M-2009.

C

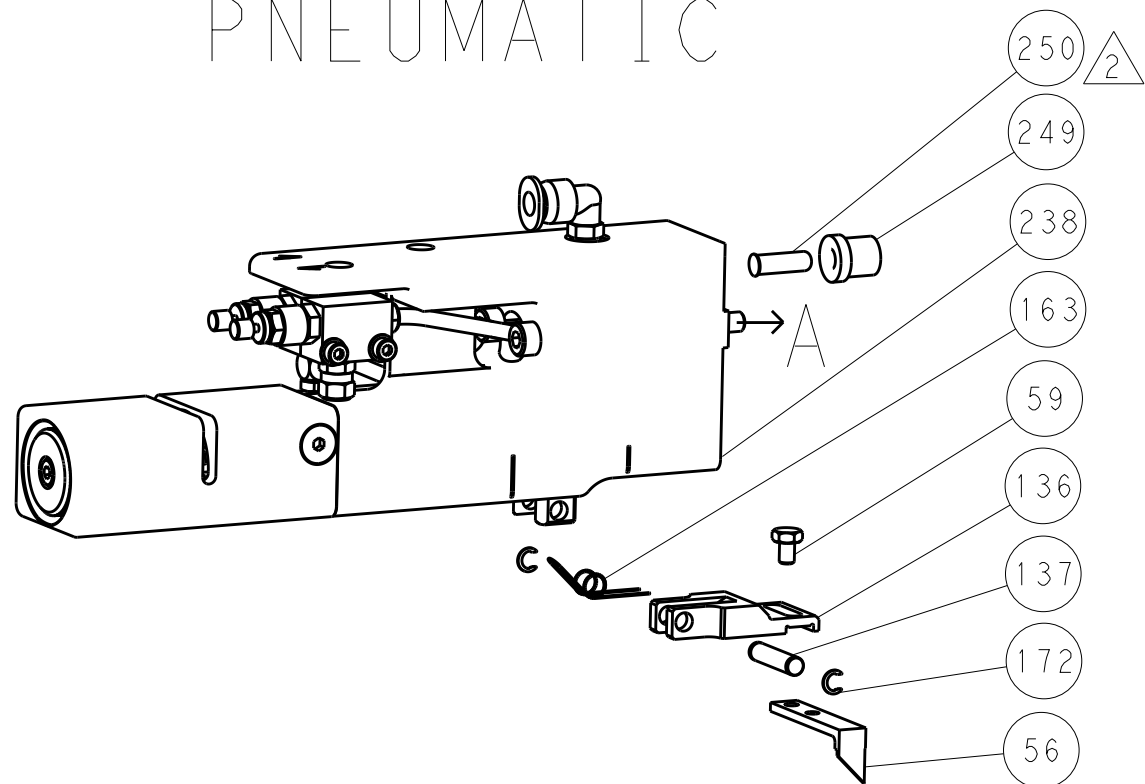
B

A

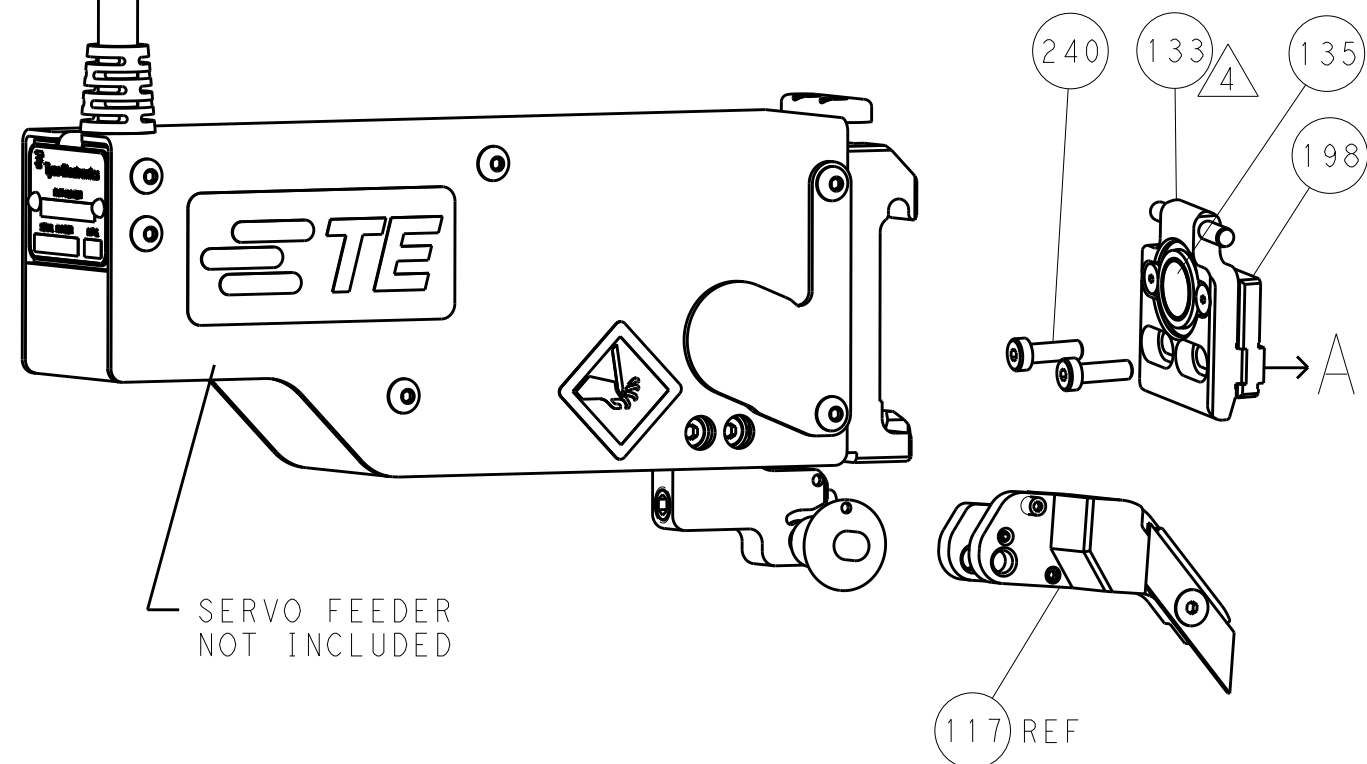
FEED TYPE MECHANICAL



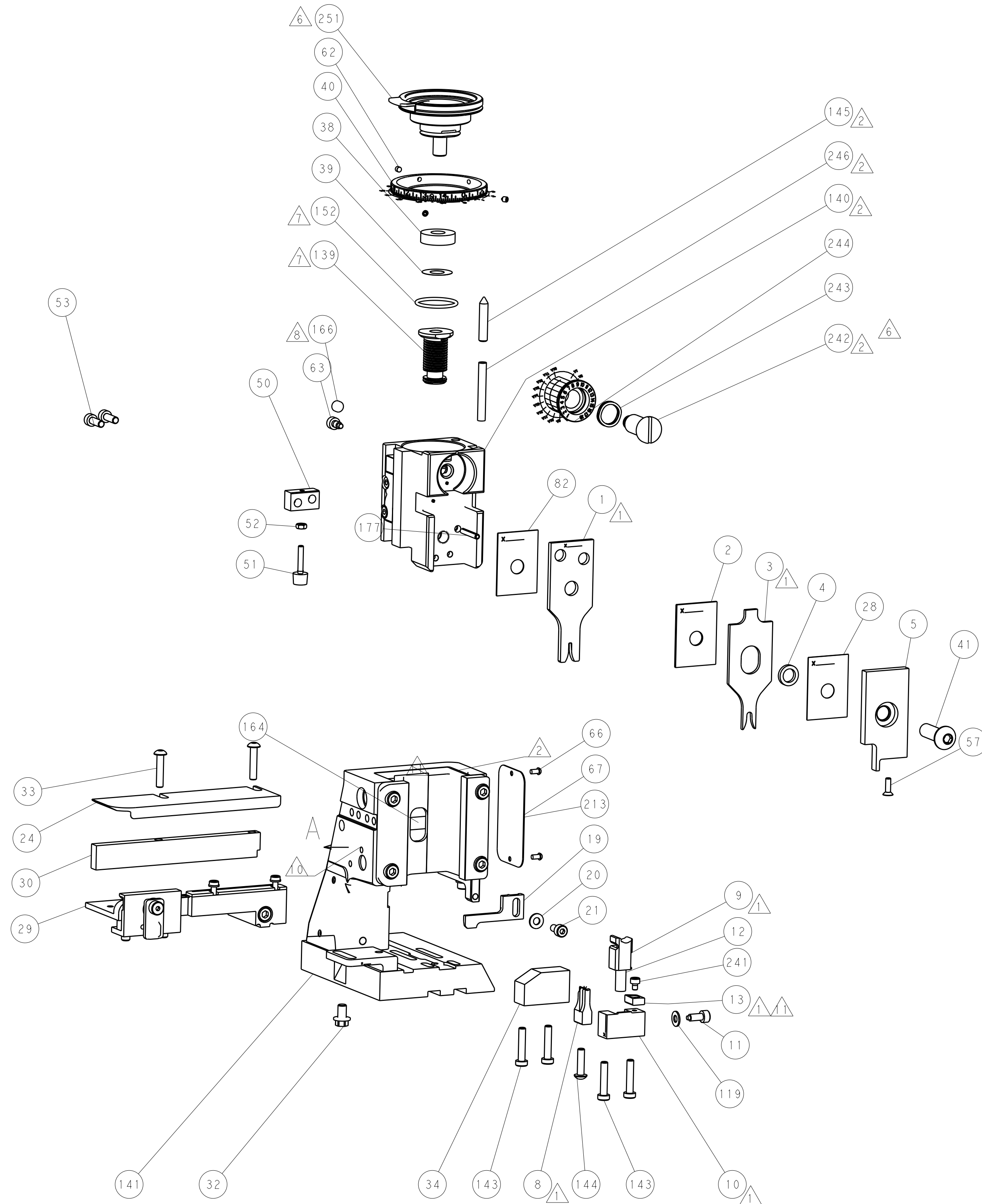
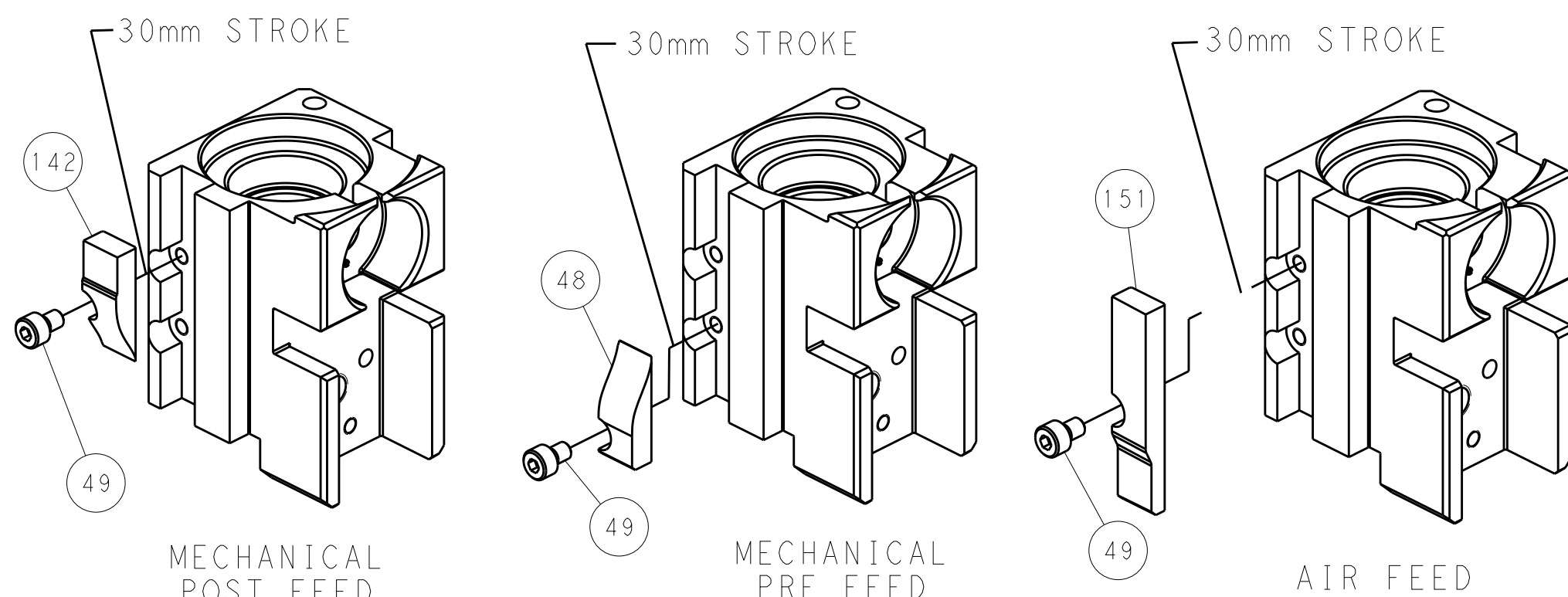
PNEUMATIC



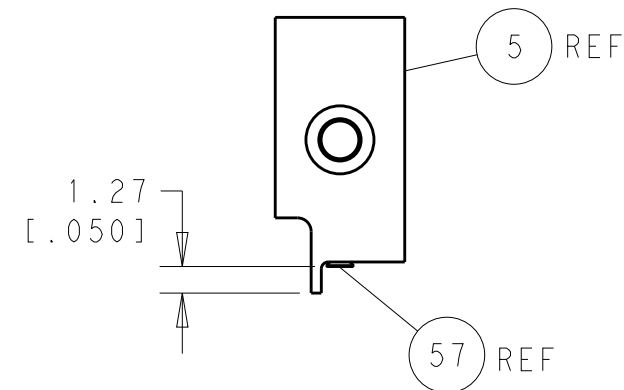
SERVO LATCH PLATE



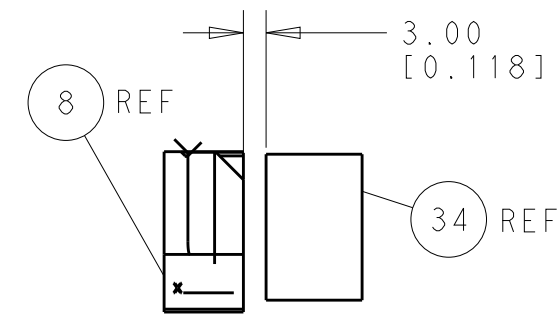
CAM POSITIONS



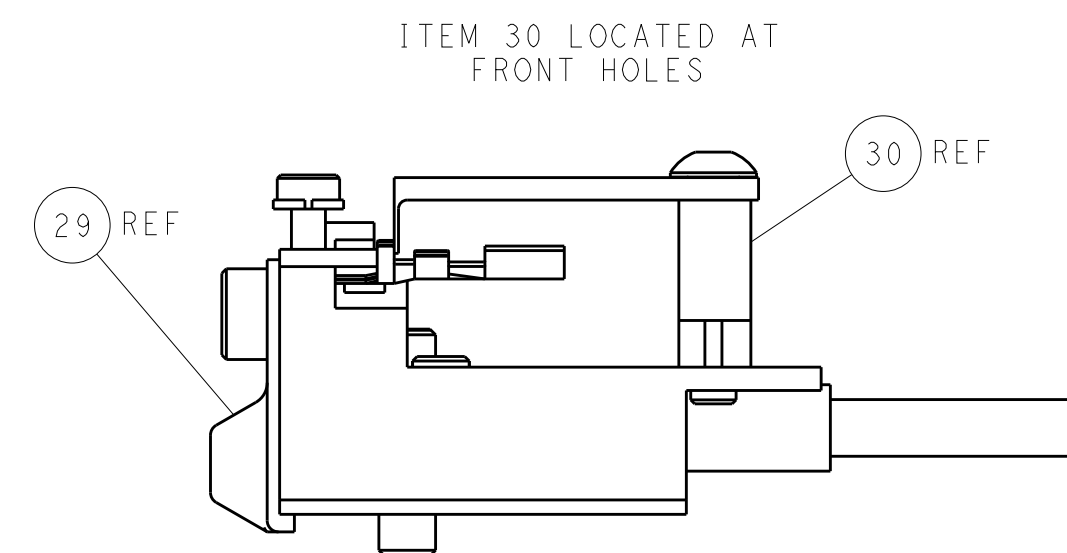
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS: mm		CHK S. XI 30MAY2011	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±.13 2 PLC ±.13 3 PLC ±.013 4 PLC ±.0001 ANGLES ±.1		APVD J. CRUZ 30MAY2011	PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -	SIZE A1 00779 C=2151105	
FINISH -		Customer Accessible Production Drawing	SCALE 1:2	SHEET 4 OF 4 REV A