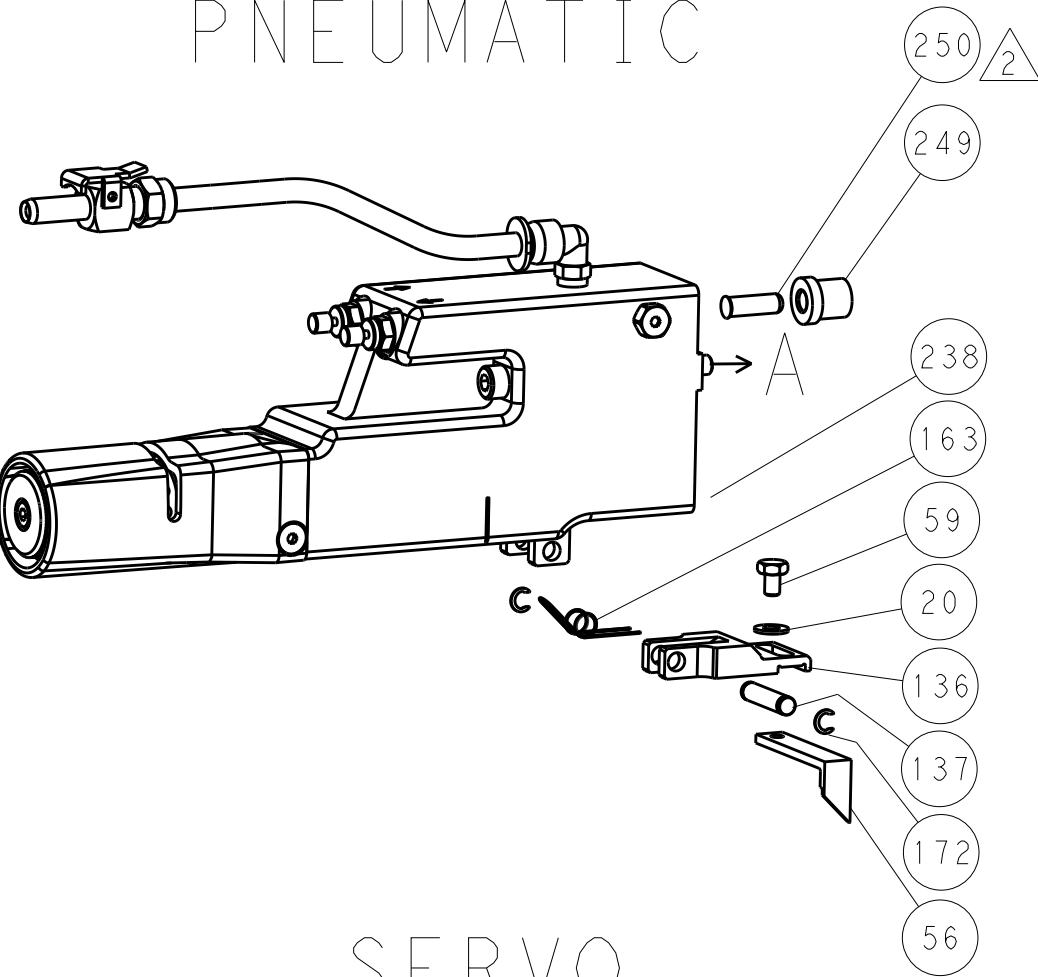


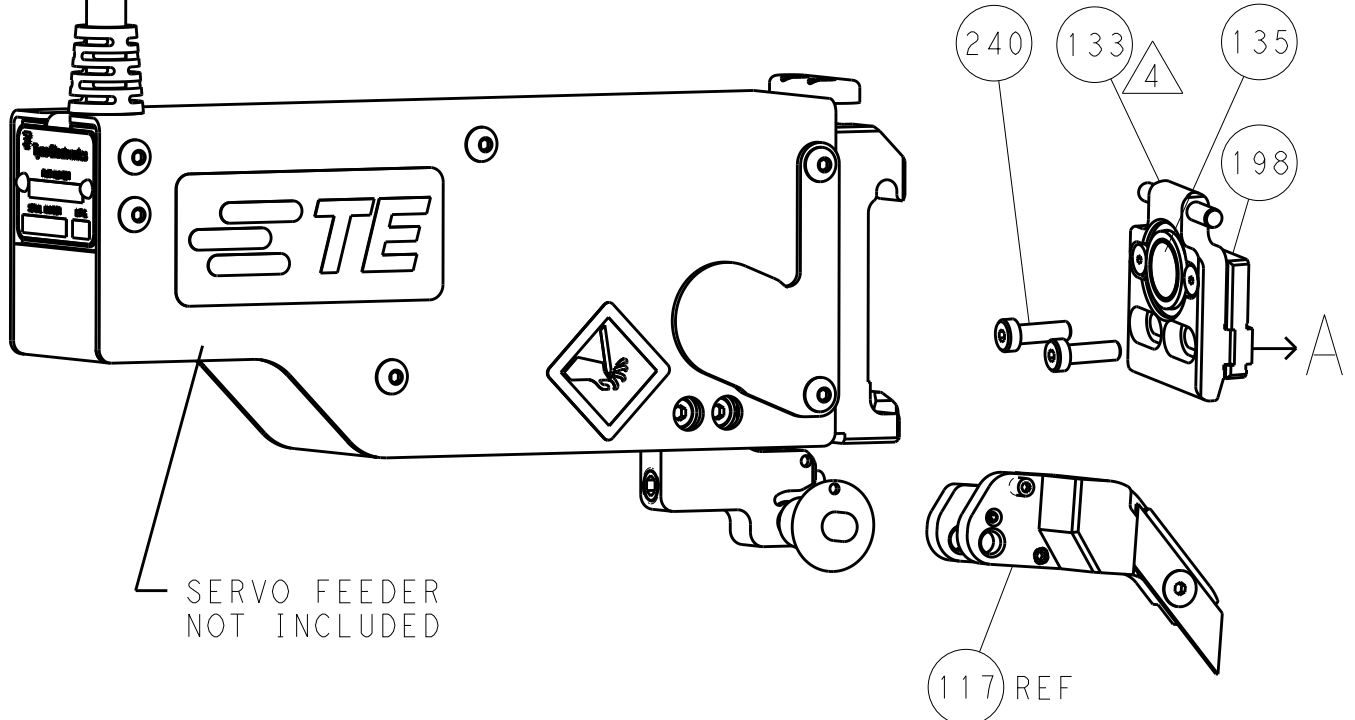
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

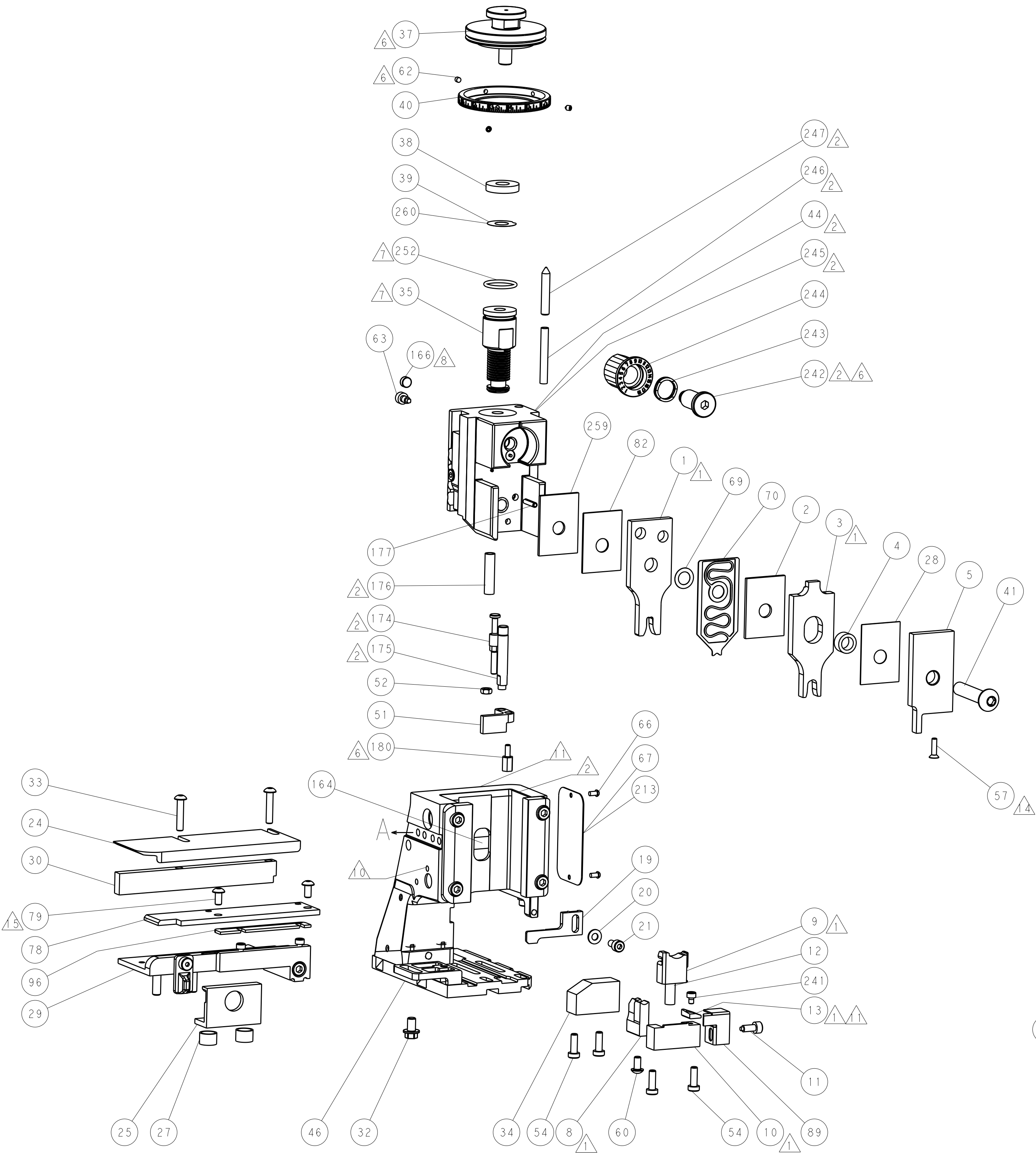
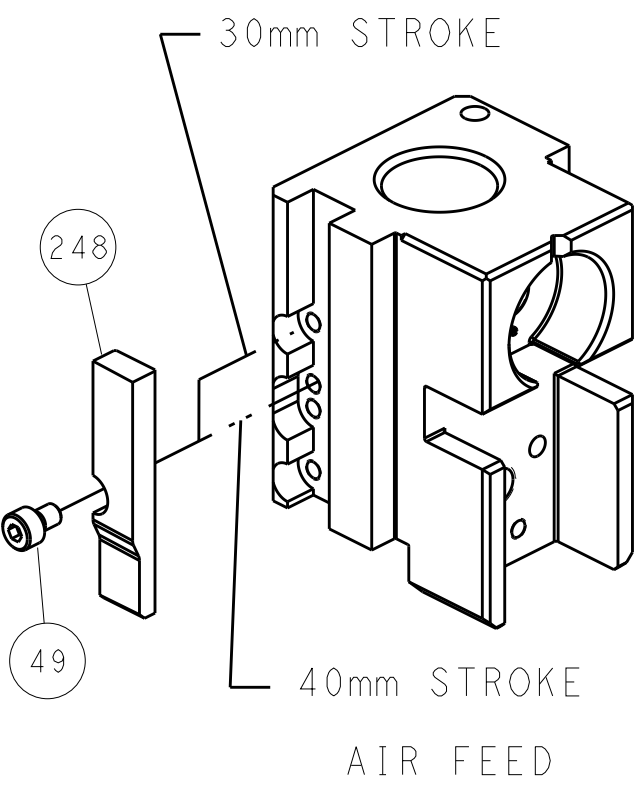
PNEUMATIC

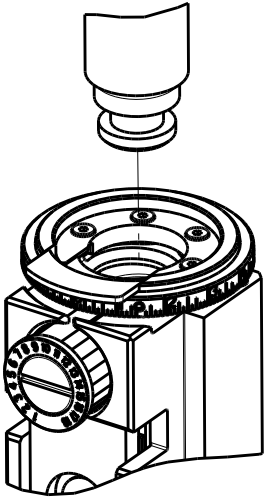


SERVO LATCH PLATE

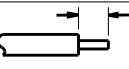


CAM POSITION



8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2151853-2	B	FINE CRIMP HEIGHT ADJUST
	2-2151853-5	B	FINE CRIMP HEIGHT ADJUST
	2-2151853-7	B	FINE CRIMP HEIGHT ADJUST
	7-2151853-7	B	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.06 mm [.160]	F
INSUL	6.10 mm [.240]	OV
APPLICATOR INSTRUCTIONS 408-10389 		

TERMINAL DATA: PRONER TERMINAL		PRONER CRIMP SPECIFICATION	
TERMINAL NAME: CLIP 8mm NG1		CAPACITE 3 A 6mm	
WIRE STRIP LENGTH 5.95-5.96 mm [.234-.235 IN]			INSULATION DIAMETER RANGE Ø3.20-4.10 mm [.126-.161 IN]
TERMINAL APPLICATION SPECIFICATION 	PRONER SPEC	-	-
TERMINALS APPLIED 			
TE TERMINAL	PRONER TERMINAL	TE SEAL	PRONER SEAL
1544227-1	2398-D-001	1544316-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
6.00mm2		3.10+/-0.05 [.122+/- .002]		5.8
5.00mm2		3.00+/-0.05 [.118+/- .002]		6.9
4.00mm2		2.72+/-0.05 [.107+/- .002]		9.5
3.00mm2		2.54+/-0.05 [.100+/- .002]		11.4



-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. 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: 8-2151853-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151853-5
5. 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 ITEM 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.
-  THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
-  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.
-  GRIND 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	1803078-5	SPACER, PRECISION	259
-	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	2161314-1	RAM, STEPPED, ATLANTIC, SF, NON-ADJ	245
-	1	1	1	2119082-3	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
-77	-27	-25	-22	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	2063440-2	AIR FEED MODULE	238
-	-	1	-	2119740-2	TAG,IDENTIFICATION	213
-	-	1	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	1-1752354-9	STANDOFF,HOLD-DOWN	180
-	1	1	1	6-9931111-6	PIN, SLOTTED SPRING 3.0 X 14.0	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	2119656-4	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	2161312-1	RAM, STEPPED, 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
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	1	1	318563-1	GUARD, FRONT CHIP	89
-	1	1	1	455888-8	SPACER, CRIMPER	82
-	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1	1633470-2	EXTENSION PLATE	78
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-6	DEPRESSOR, WIRE	70
-	1	1	1	2119943-1	WASHER, SPACER	69
-	1	-	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	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	1	1	985575-4	SCR, FLT SKT HD CAP M3 X 12.0	57
-	-	-	1	1338683-8	FEED PAWL	56
-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	2161311-1	RAM, STEPPED, AMP STYLE, SIDE FEED	44
-	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	41
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	2119644-4	RAM WASHER, PRECISION	38
-	1	1	1	1752356-3	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	1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	2119959-5	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-4	SPACER, CRIMPER	28
-	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1320928-4	STRIP GUIDE	24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	2	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	2119805-2	SHEAR HOLDER, FRONT	10
-	1	1	1	318059-4	FLOATING SHEAR, FRONT	9
1	1	1	1	6-1633620-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	1	2-2119781-7	DEPRESSOR, SHEAR	5
-	1	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4
1	1	1	1	1803101-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1-455888-7	SPACER, CRIMPER	2
1	1	1	1	1-1633738-7	CRIMPER, WIRE	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

THIS DOCUMENT IS CONTROLLED DOCUMENT AND IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. NO OTHER ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN T. YIN CHK G. BAILEY APVD S. XI	14JAN2013 14JAN2013 14JAN2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC		SIZE A1	
MATERIAL -		APPLICATION SPEC		CASE CODE 00779	
		WEIGHT -		DRAWING NO C=2151853	
		Customer Accessible Production Drawing		RESTRICTED TO -	
		SCALE 1:2		SHEET 3 OF 4	
				REV B	

PNEUMATIC 1C

250
249
238
163
59
20
136
137
172
56

350

SERVO FEEDER
NOT INCLUDED

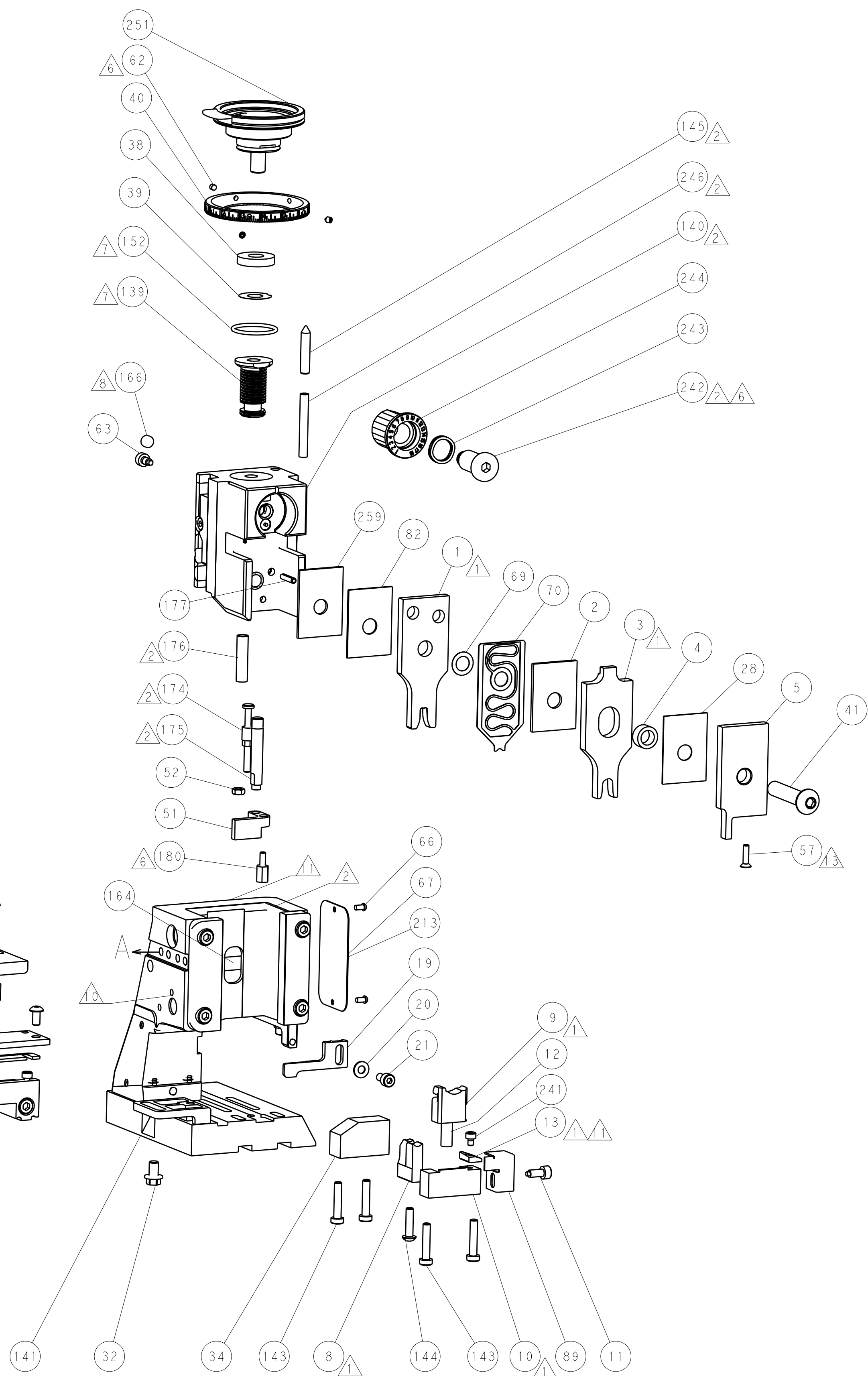


Diagram illustrating the terminal support location. It shows two views of a component. The left view shows a cross-section with a dimension of 8 REF. The right view shows a side view with a dimension of 6.8 ± 0.5 and a dimension of 34 REF.

Diagram illustrating the Holddown Set-up. The diagram shows a vertical assembly with two main components labeled 140 REF and 180 REF. A dimension line indicates a vertical distance of 17.4 ± 0.5 between the top of the 180 REF component and the bottom of the 140 REF component.

ITEM 30 LOCATED AT FRONT HOLES

30 REF

FEED TRACK POSITION
MADE 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)

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 4 PLC ±. ANGLES ±.		NAME APVD X.SI 14JAN2013 PRODUCT SPEC - APPLICATION SPEC -	
		SIZE -		CAGE CODE A1 00779	
MATERIAL -		FINISH -		DRAWING NO C=2151853	
WEIGHT -		RESTRICTED TO -		SCALE 1:1 SHEET 4 OF 4 REV A	
Customer Accessible Production Drawing					