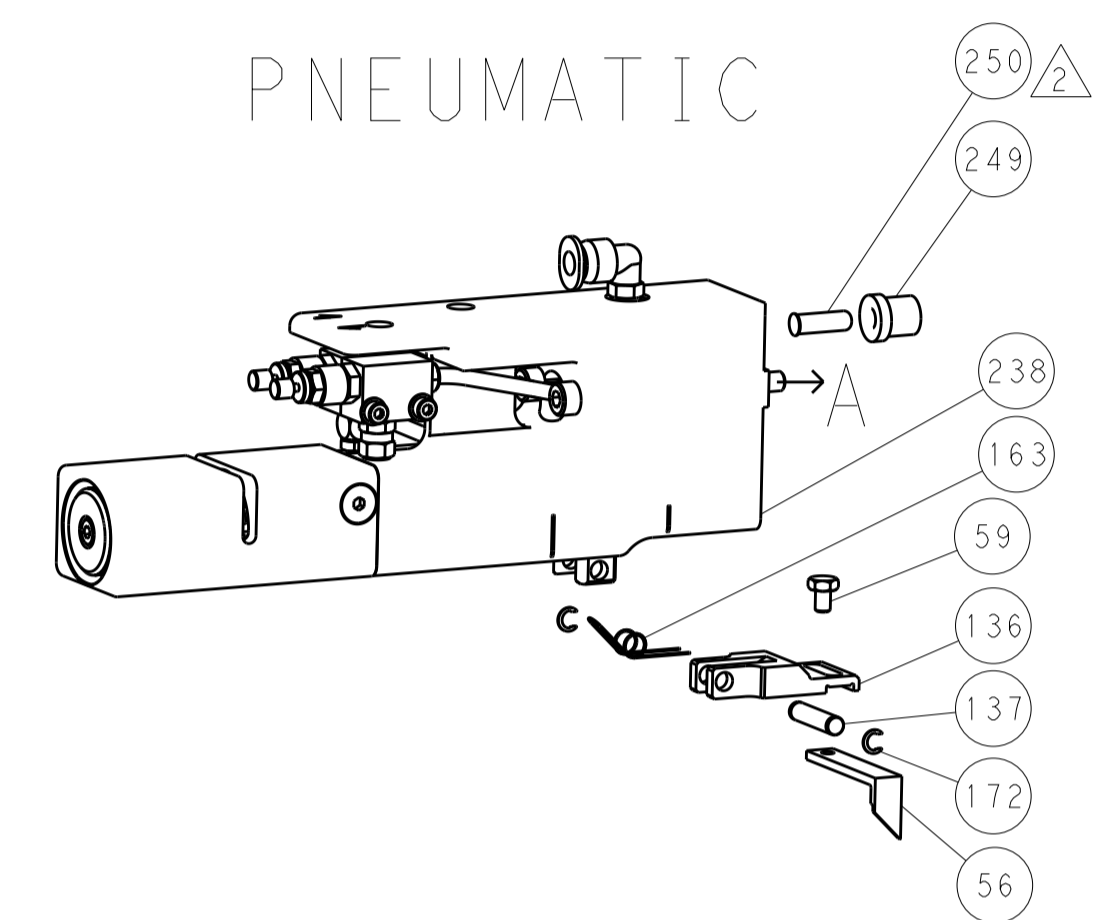


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE

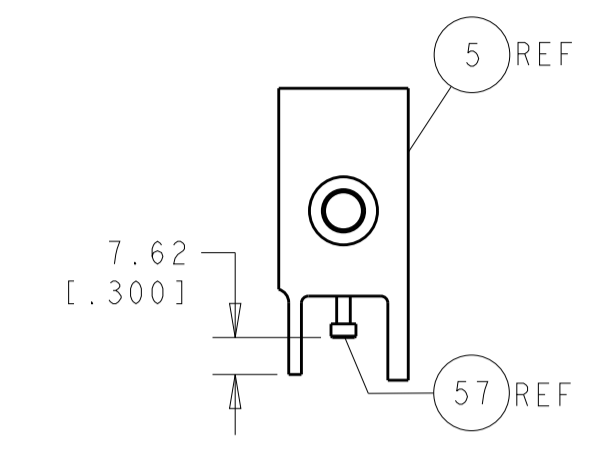
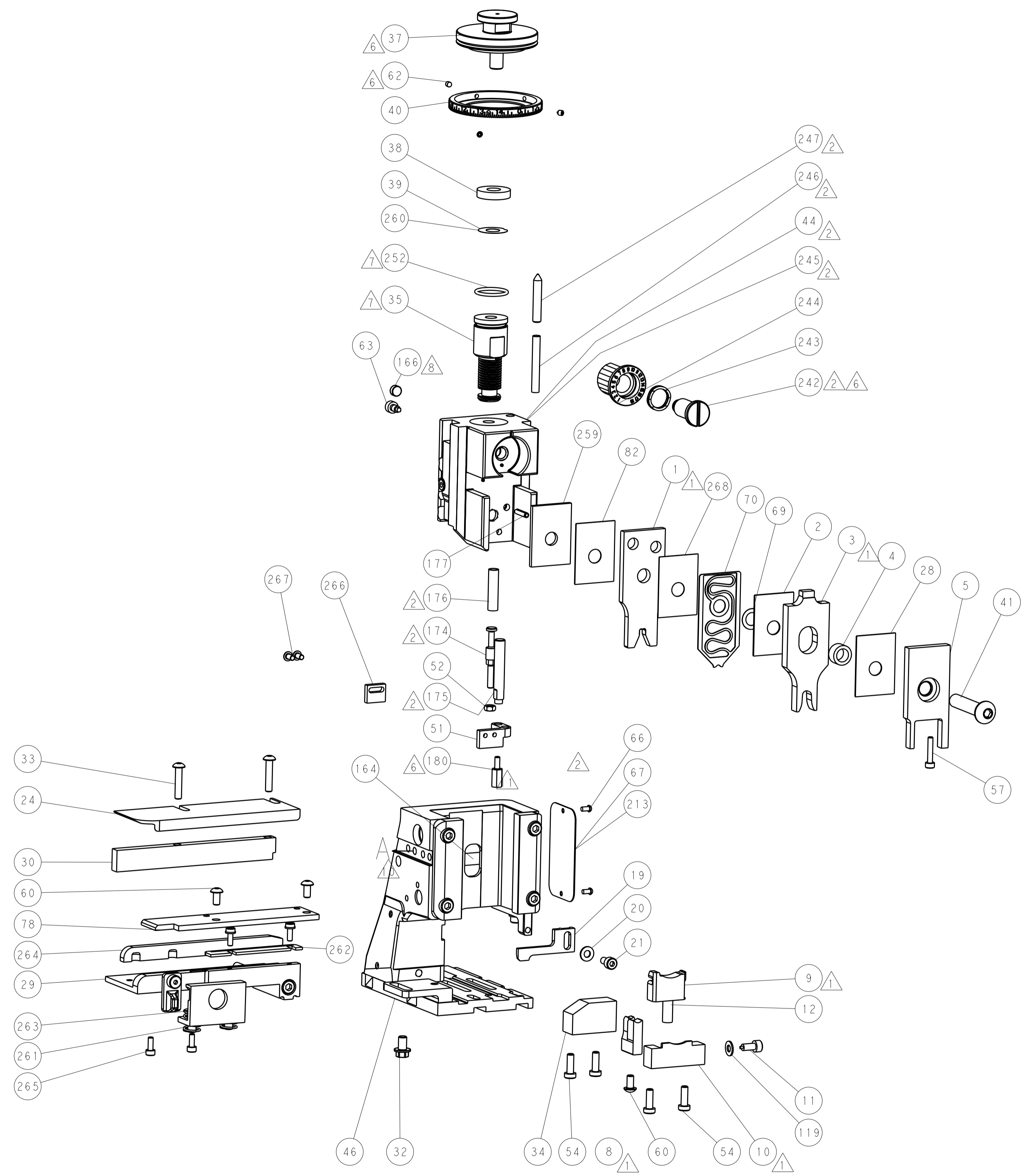
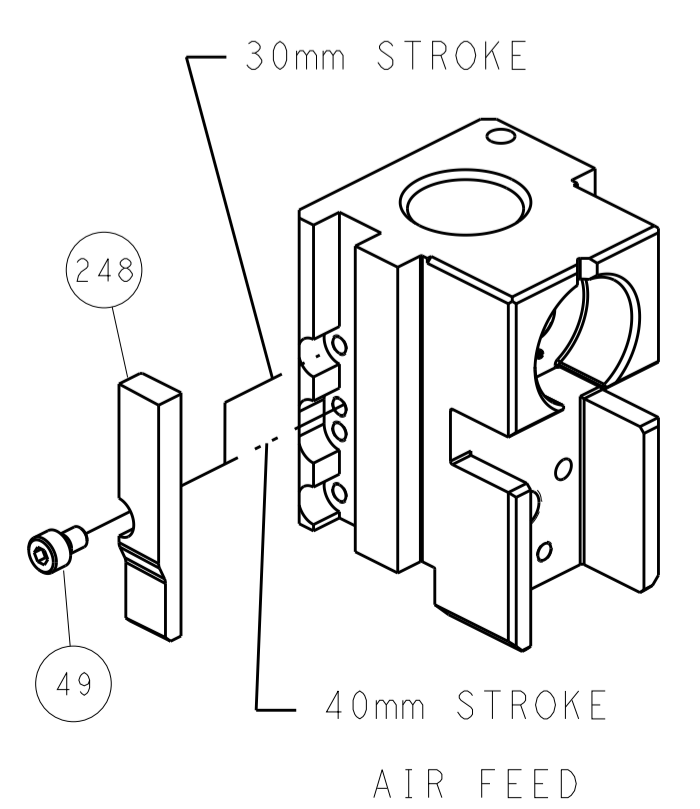
PNEUMATIC



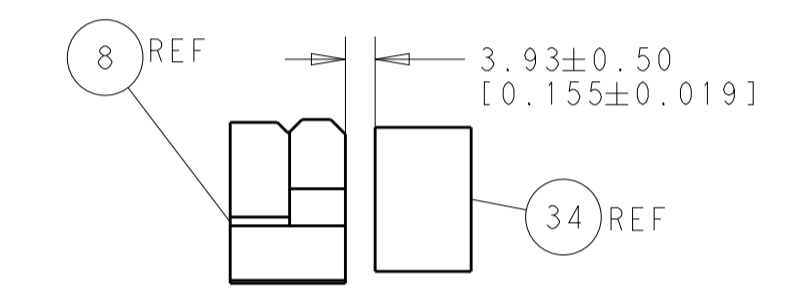
SERVO LATCH PLATE



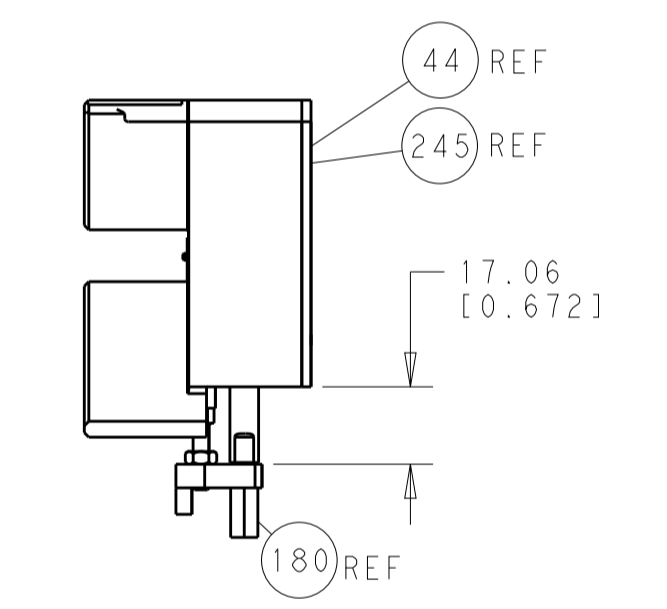
CAM POSITION



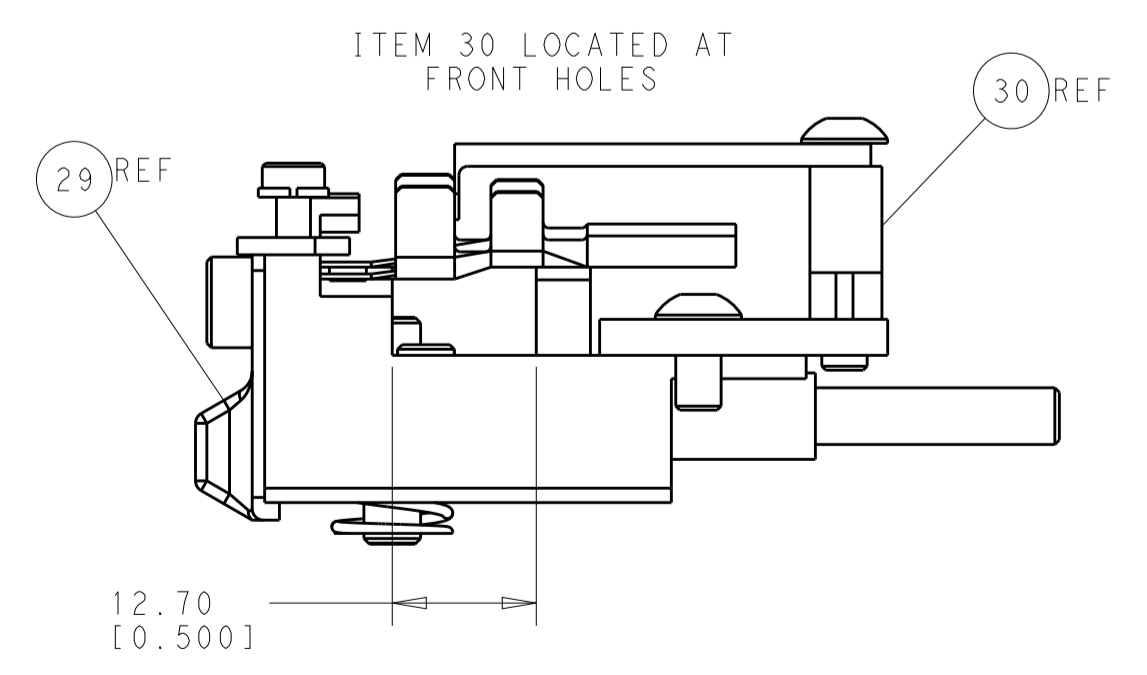
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



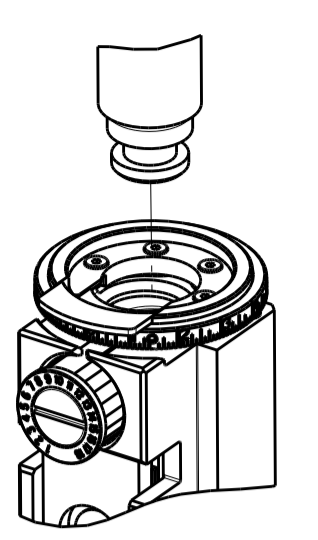

HOLDDOWN SET-UP




FEED TRACK POSITION GUIDE BY INSULATION BARREL

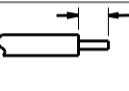
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)


DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001		DWN C. CHEN 28APR2013 CHK U. GUO 28APR2013 APVD J. CRUZ 28APR2013		NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151951	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 2 OF 4 REV A	


PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2151951-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2151951-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 
	2-2151951-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2151951-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.00 mm [1.57]	F
INSUL	6.20 mm [2.44]	OV












APPLICATOR INSTRUCTIONS
408-10389 

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 8mm NGI+ FEMALE TERMINAL W/SEAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
6.20-6.58 mm [2.44-.259 IN]		Ø3.34-4.69 mm [1.31-.185 IN]	
TERMINAL APPLICATION SPECIFICATION	114-15106		

TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1544965-1	1544965-2	1544316-1	1544664-1
		1544316-2	1544664-2
		1544970-1	1544970-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING 
7.00mm ²	2.80 +/- 0.05 [1.10 +/- .002]	6.2
6.00mm ²	2.80 +/- 0.05 [1.10 +/- .002]	6.3
5.00mm ²	2.45 +/- 0.05 [1.096 +/- .002]	10.0



-  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: 8-2151951-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151951-5
- 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 ITEMS 62, 180 & 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. REFER TO APPLICATION SPECIFICATION FOR PROPER WIRE SIZE & 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.

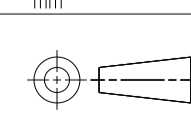
***WARNING**
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	455888-3	SPACER, CRIMPER	268
-	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	267
-	1	1	1	1976053-2	LOCATER BLOCK, TERMINAL	266
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	265
-	1	1	1	1633782-4	FENCE	264
-	2	2	2	22283-1	SPRING, COMPRESSION	263
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	262
-	1	1	1	240792-1	DRAG, TERMINAL	261
-	1	1	1	1803078-2	SPACER, PRECISION	259
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-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)

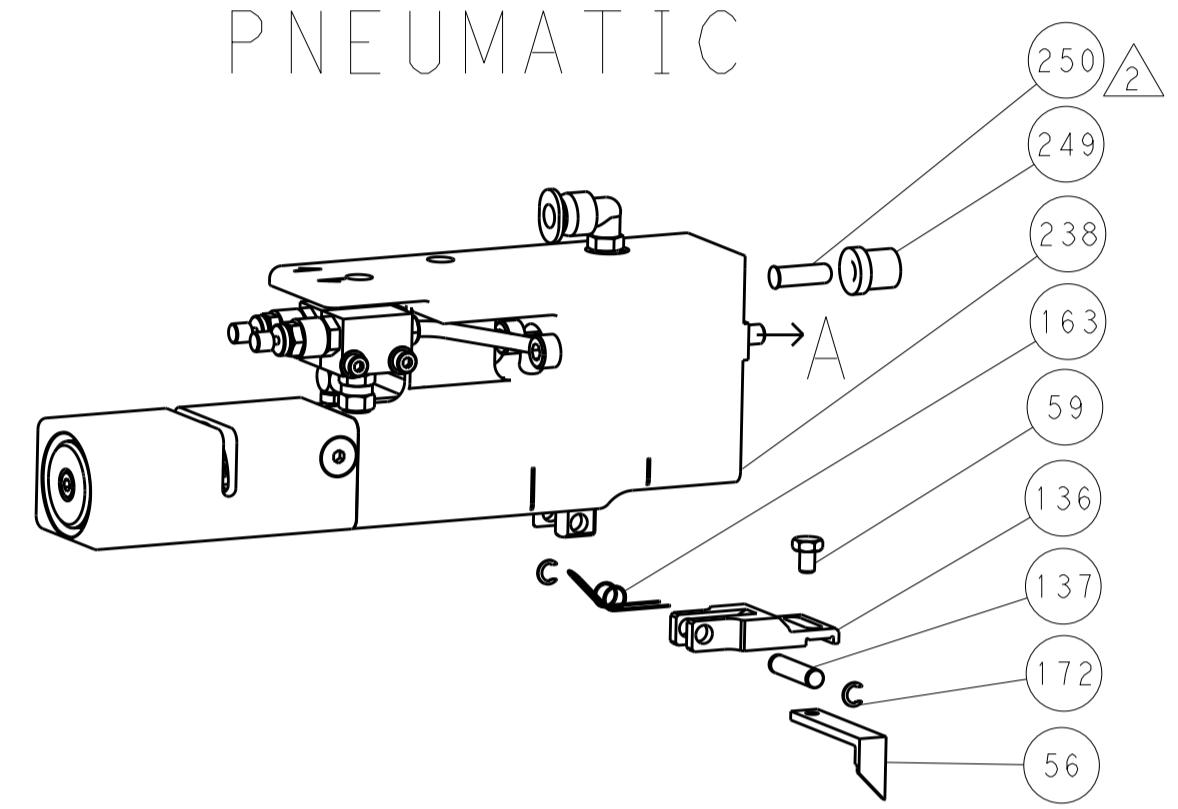
SET UP GAUGE		LOC	DIST	REVISIONS			
2119599-1		A	66	P. LTR	DESCRIPTION	DATE	OWN
-	-	-	-	-	SEE SHEET 1	-	-

-	1	1	1	2119082-6	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
-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	1	2063440-2	AIR FEED MODULE	238
-	-	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	-	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	2-1752354-8	STANDOFF, HOLD-DOWN	180
-	1	1	1	6-993111-6	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
-	-	-	-	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
-	-	-	-	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1-2119656-8	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
-	-	-	-	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	455888-4	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	1-2119791-1	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
-	-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57
-	-	-	-	1338683-8	FEED PAWL	56
-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1901681-4	HOLDDOWN, TERMINAL	51
-	-	-	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	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	2119644-3	RAM WASHER, PRECISION	38
-	1	1	1	1752356-6	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	455888-5	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	4-22280-7	SPRING, COMPRESSION	12
-	1	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	1	1-2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	318059-9	FLOATING SHEAR, FRONT	9
-	1	1	1	4-1803054-0	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	1	1803080-4	DEPRESSOR, SHEAR	5
-	1	1	1	5-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	1	4-2119785-8	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	455888-7	SPACER, CRIMPER	2
-	1	1	1	3-1633860-0	CRIMPER, WIRE	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

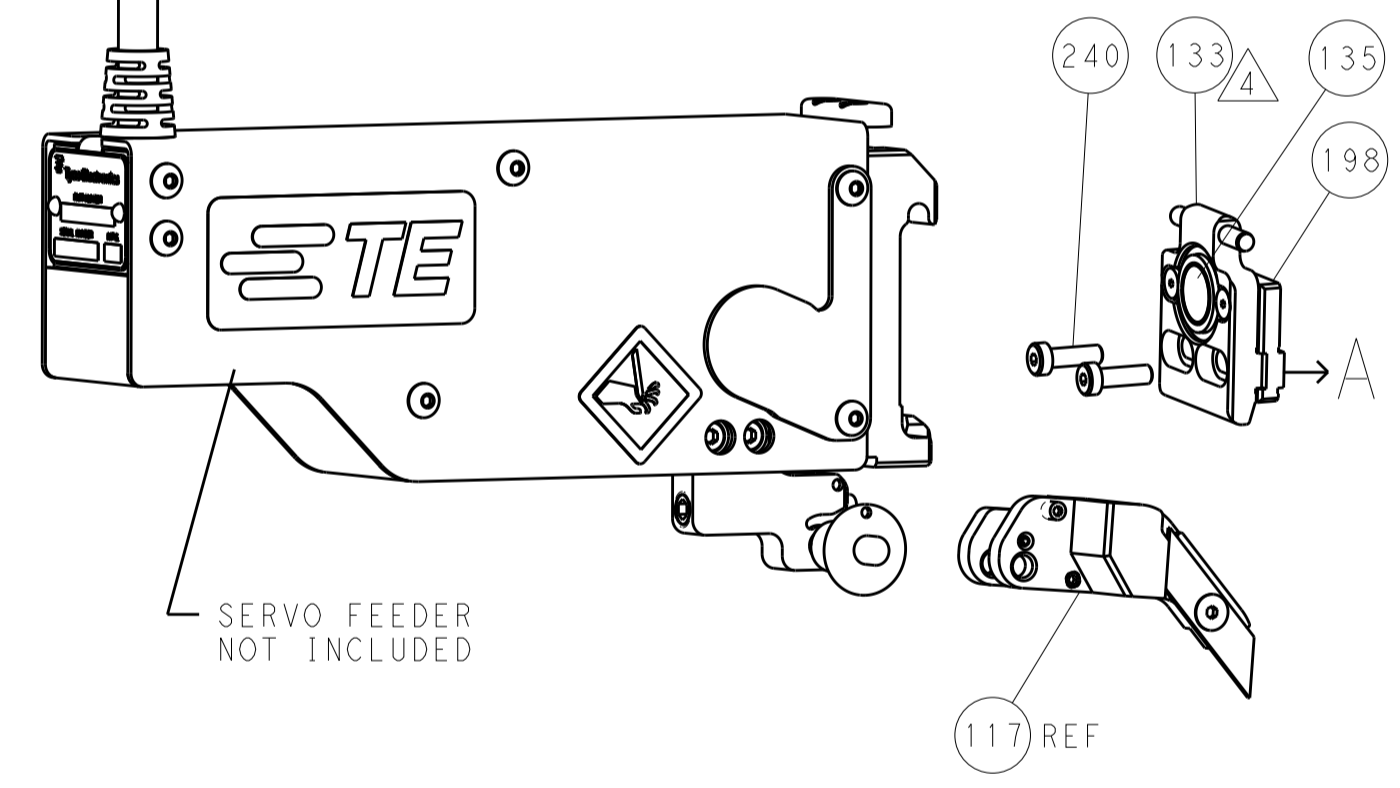
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	ANGLES ±0.0001	FINISH		28APR2013	1
MATERIAL	FINISH	WEIGHT	SCALE	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE 1:2 SHEET 3 OF 4 REV A

LOC	DIST	REV	DATE	BY	APPV
A	66				

FEED TYPE PNEUMATIC



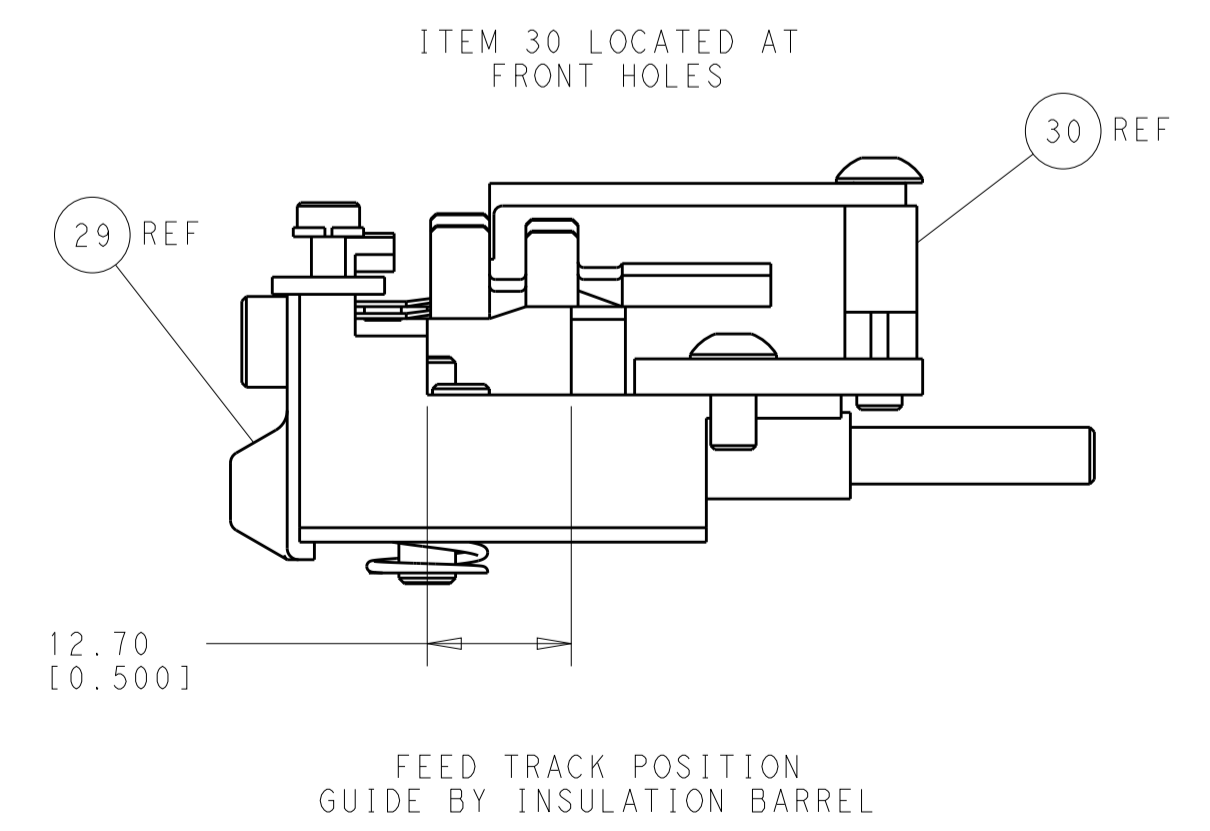
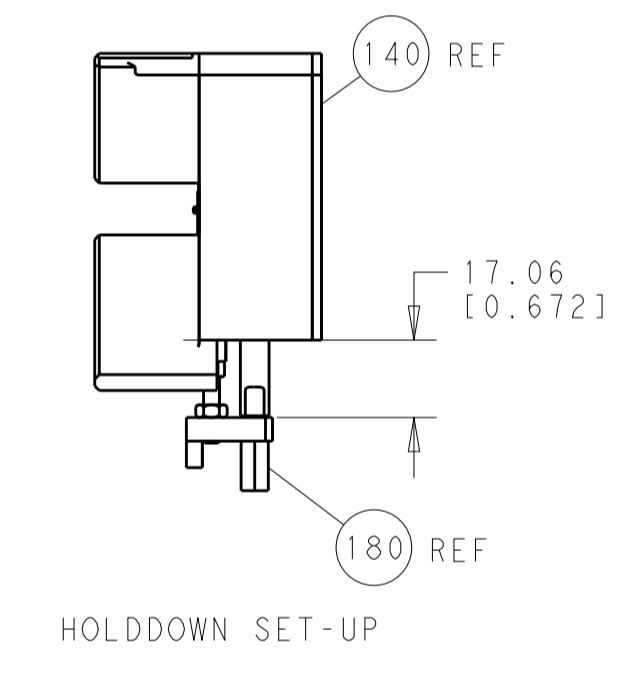
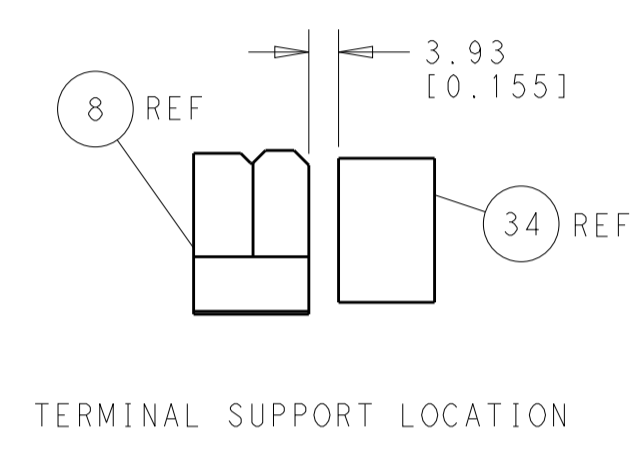
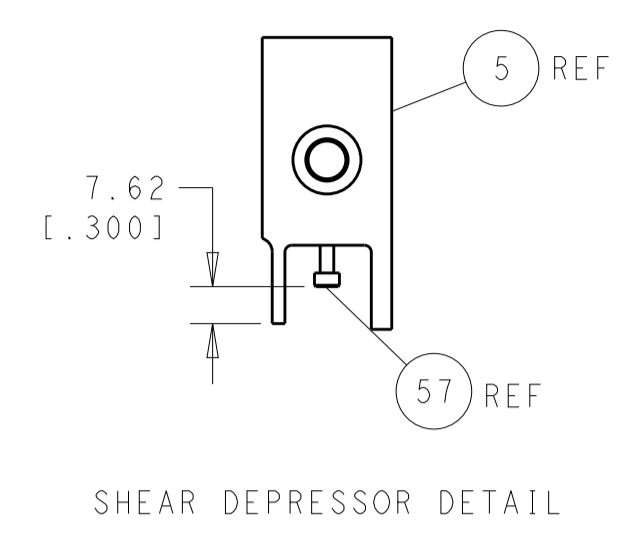
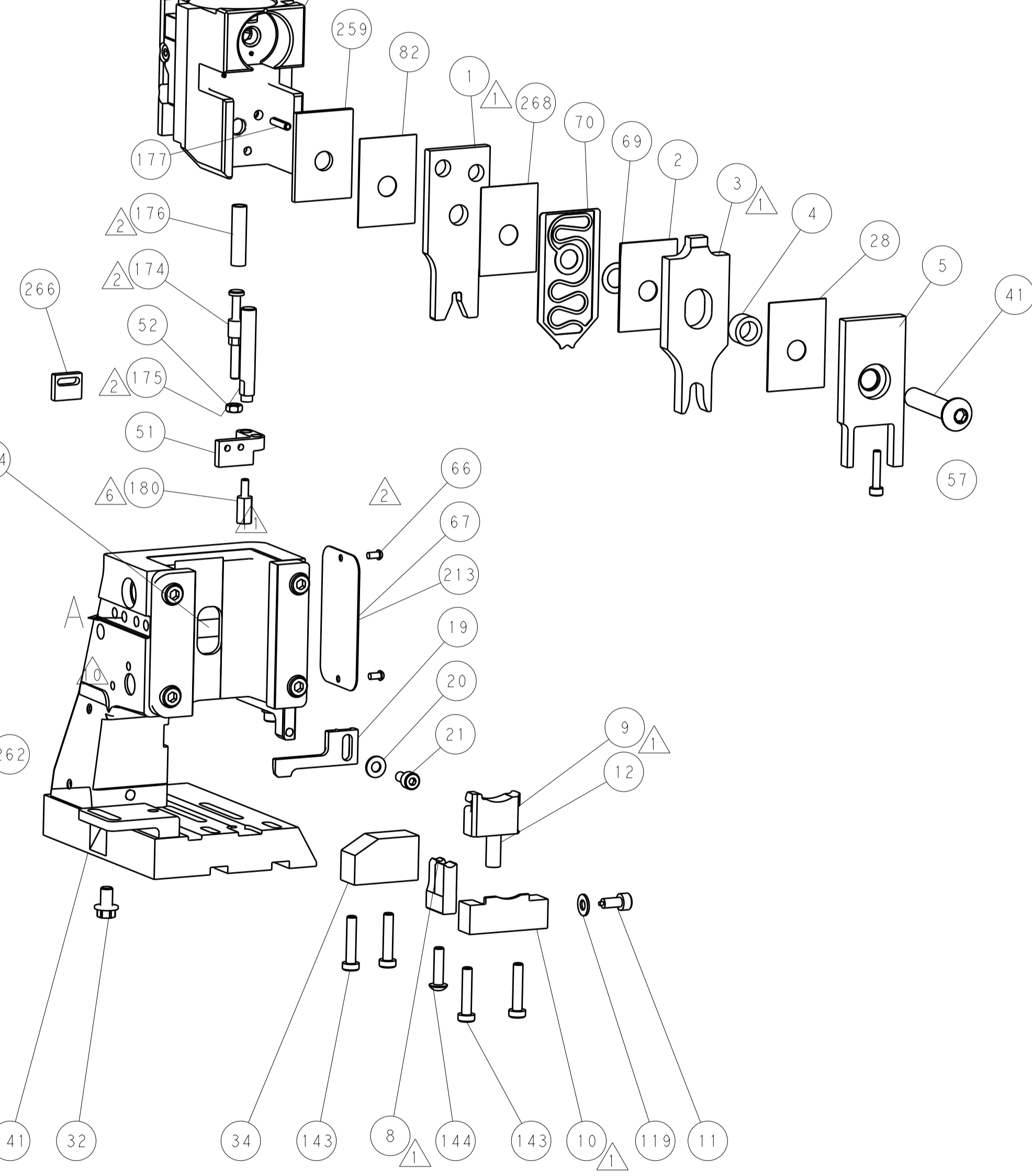
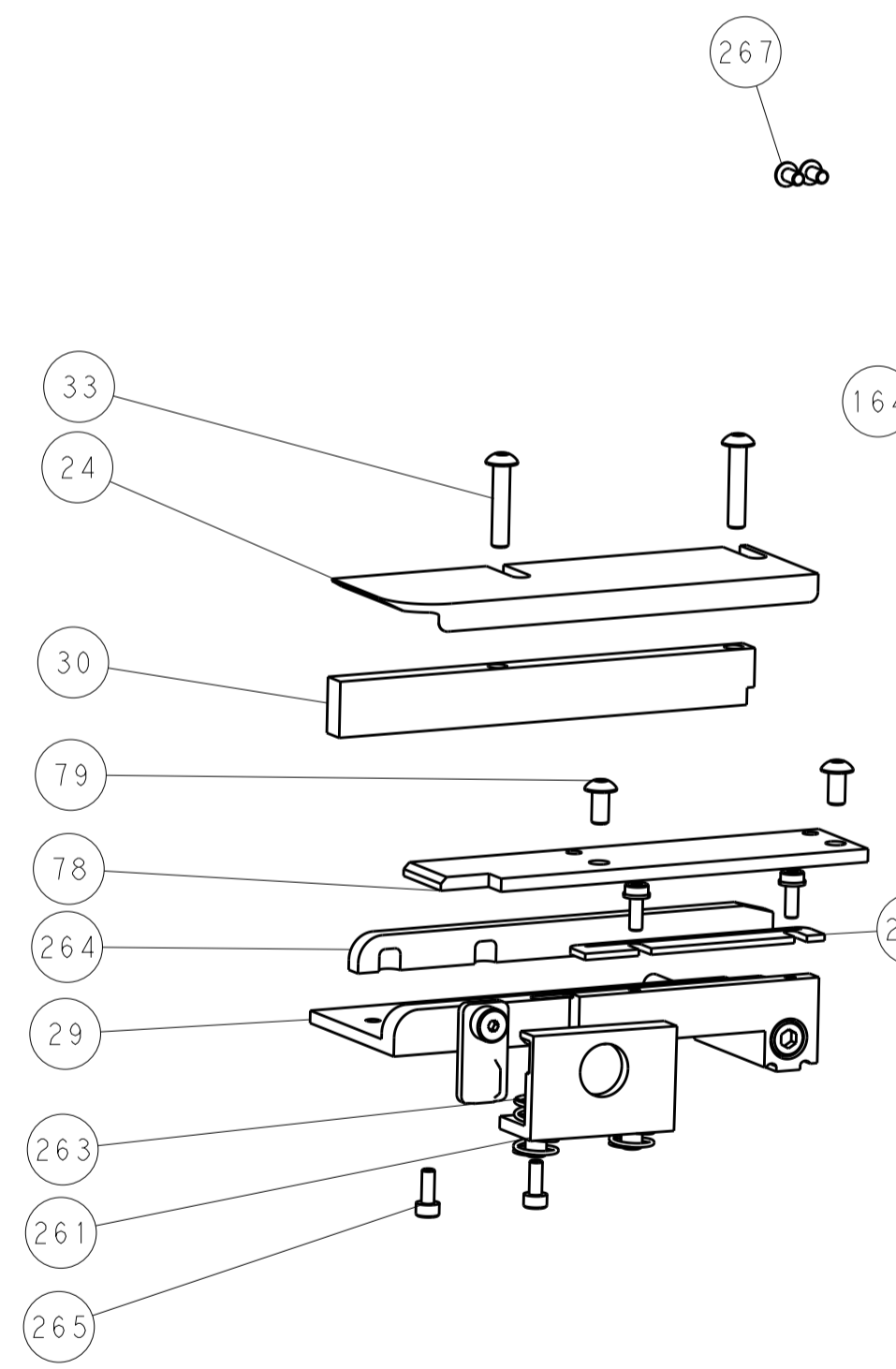
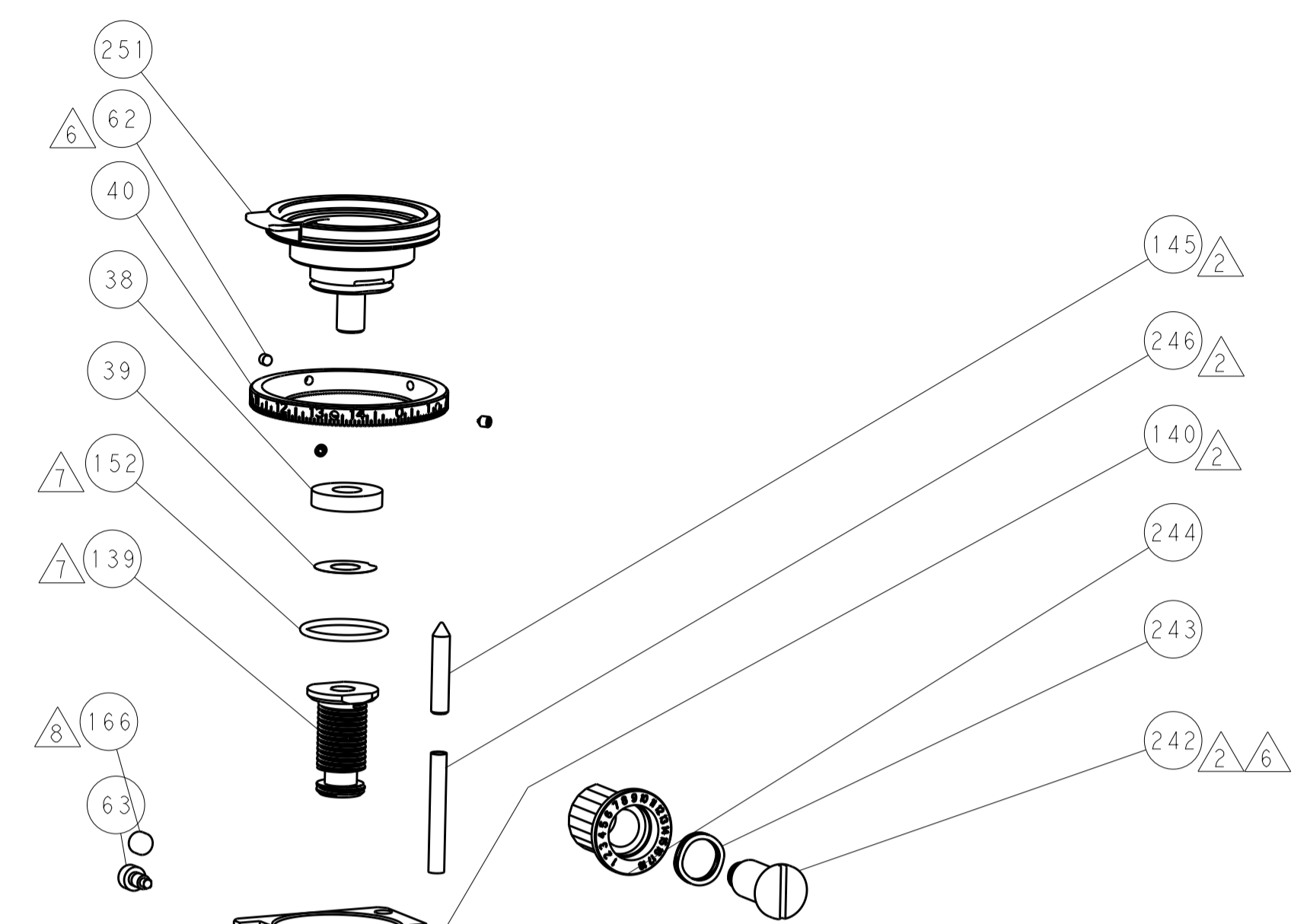
SERVO LATCH PLATE



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		DWN C. CHEN 28APR2013 CHK U. GUO 28APR2013 APVD J. CRUZ 28APR2013		NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151951	
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 4 OF 4 REV A	