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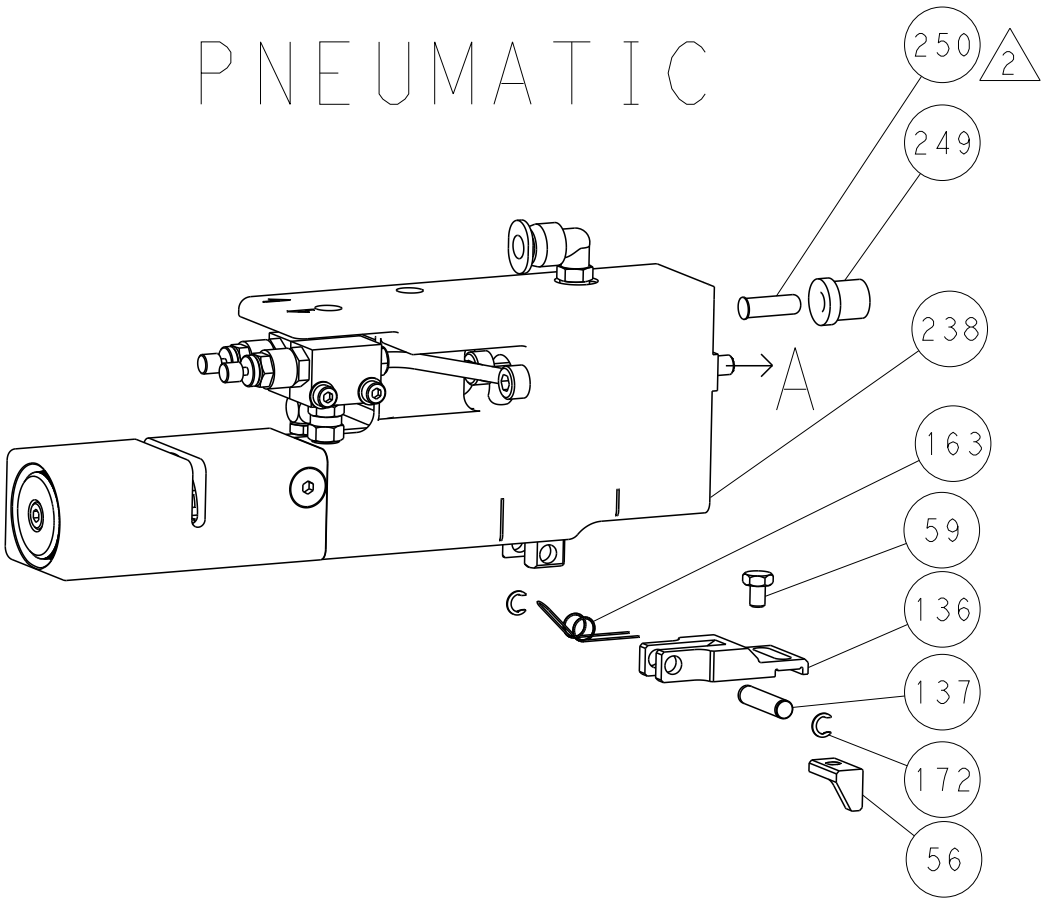
Address: A1208, Overseas Decoration Building, #122 Zhenhua RD., Futian, Shenzhen, China



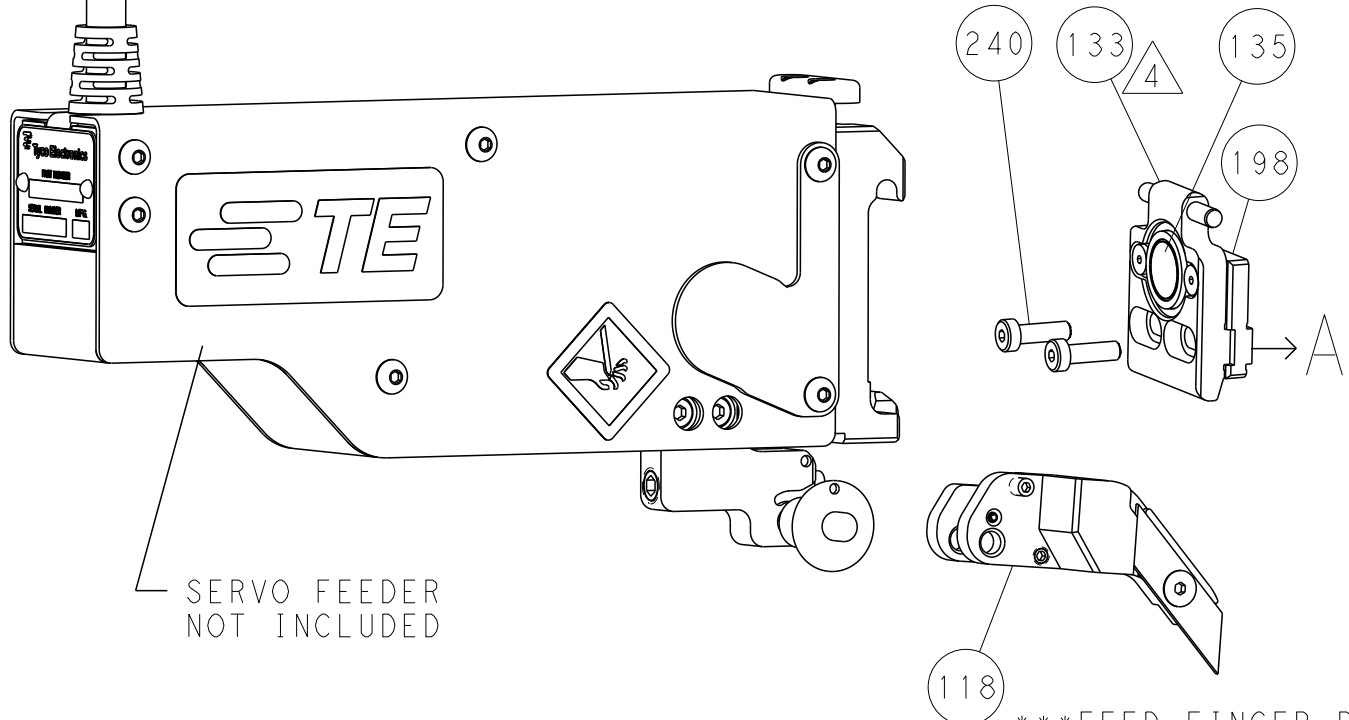
LOC		DIST		REVISIONS				
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
		-	-	SEE SHEET 1	-	-	-	

FEED TYPE

PNEUMATIC

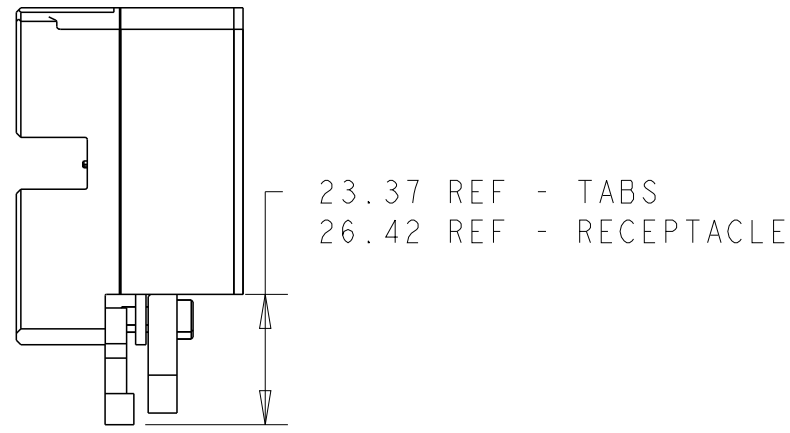
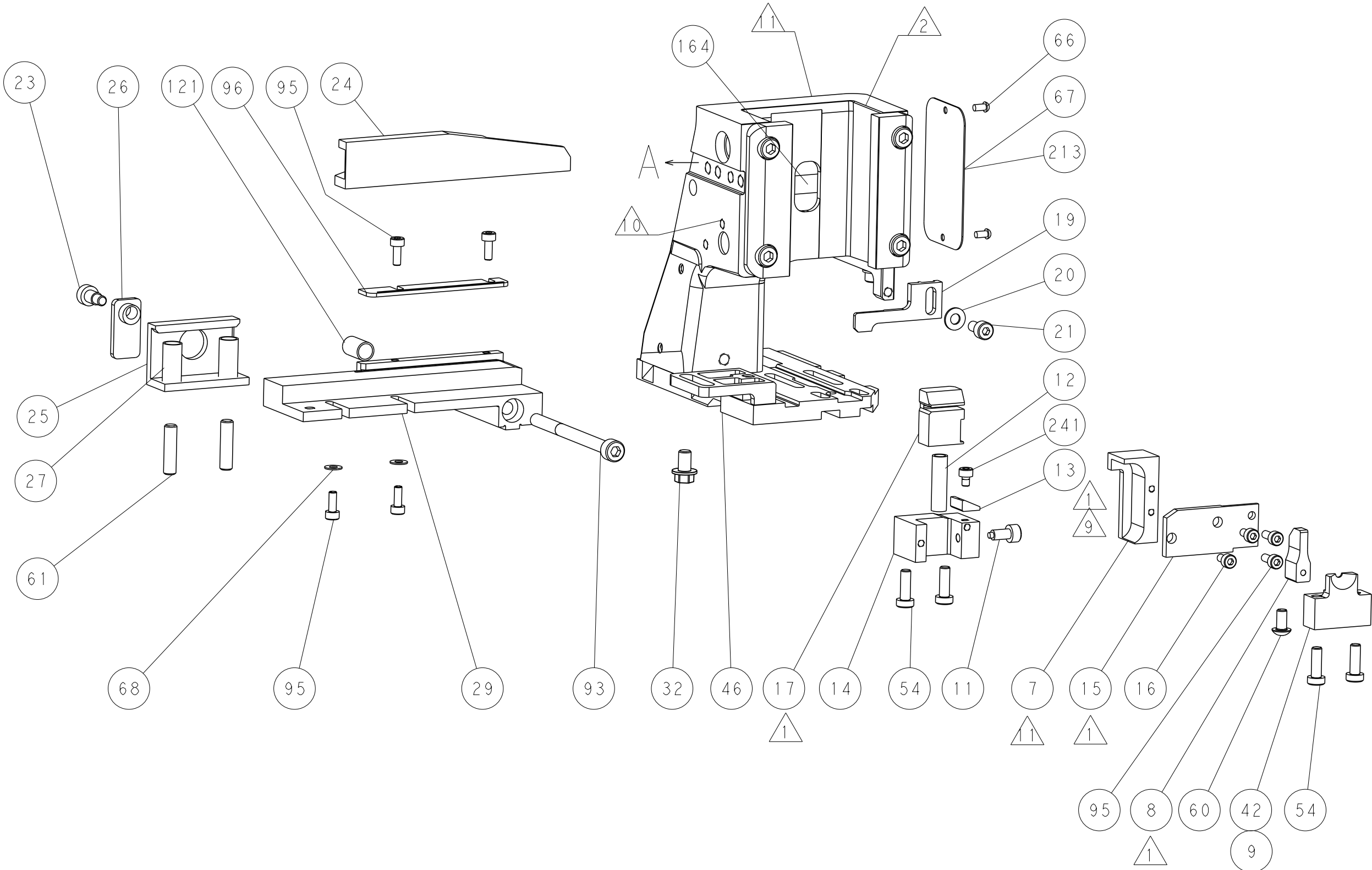
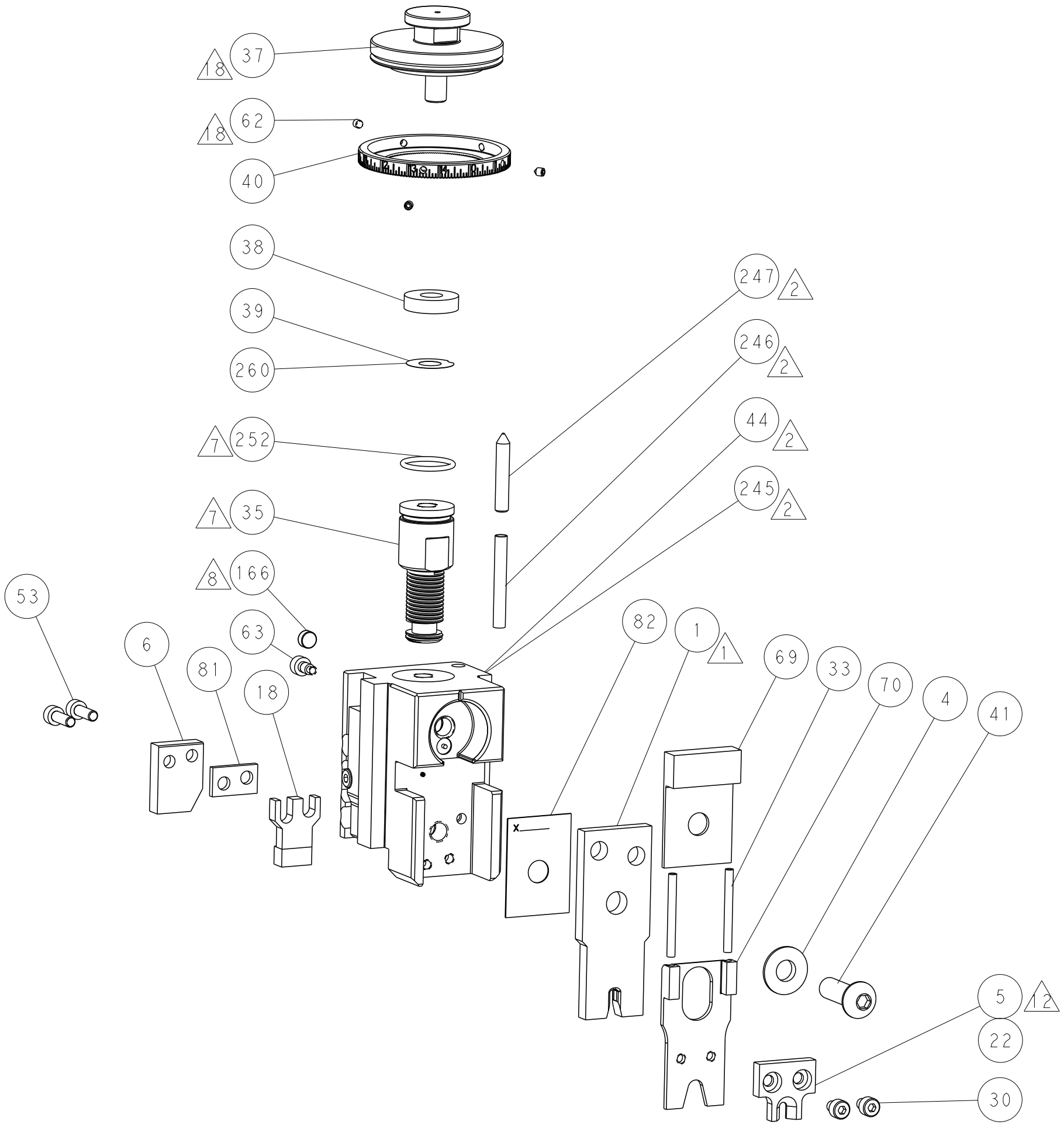
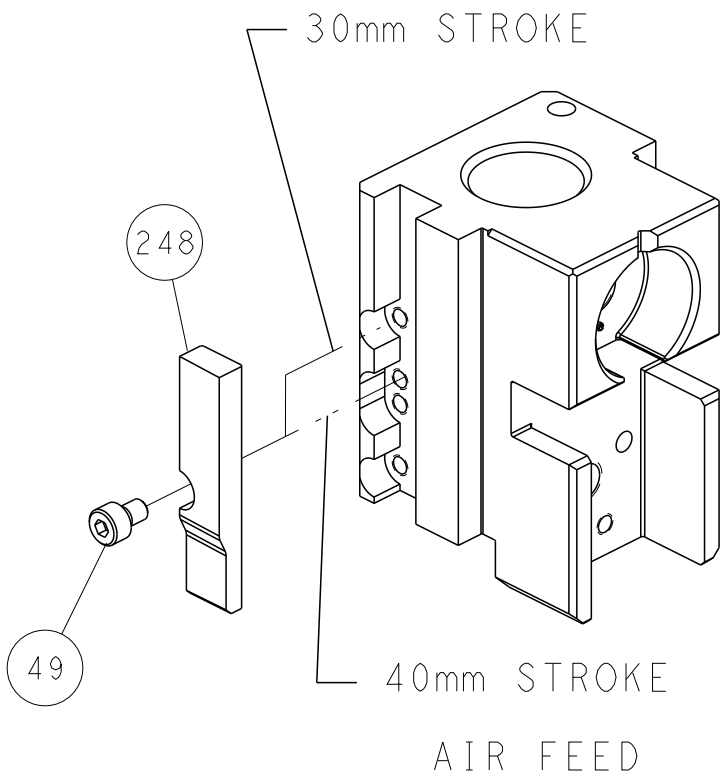


SERVO LATCH PLATE

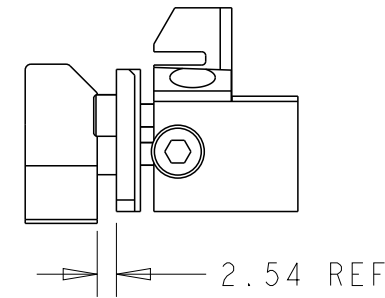


***FEED FINGER REPRESENTATION ABOVE MAY DIFFER FROM ACTUAL FEED FINGER THAT IS REQUIRED BY THIS APPLICATOR

CAM POSITIONS



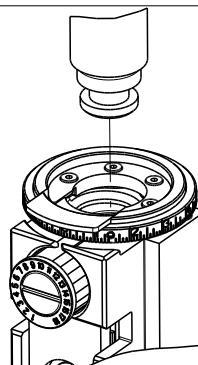
HOLDDOWN SET-UP



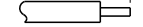
LOWER TOOLING SET-UP

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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.				DWN B. WEAVER CHK G. HOFFNER APVD T. ELBIN	12JUN2012 12JUN2012 12JUN2012	TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator		
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC ANGLES FINISH				± ± ± ± ± ± ±		SIZE A1		
MATERIAL -				WEIGHT -		CAGE CODE 00779		
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE 1:1		SHEET 2 OF 4		
						REV B		

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2151693-2	B	FINE CRIMP HEIGHT ADJUST
	2-2151693-5	B	FINE CRIMP HEIGHT ADJUST
	2-2151693-7	B	FINE CRIMP HEIGHT ADJUST
	7-2151693-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	.136 [3.45 mm]	D
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL			TE CRIMP SPECIFICATION		
TERMINAL NAME: FULLY INSULATED FASTON					
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE		
.265-.297 IN [6.73-7.54 mm]			Ø .105 MAX		
TERMINAL APPLICATION SPECIFICATION			114-2123	-	-
		-	-	-	-
TERMINALS APPLIED 					
TE TERMINAL		TE TERMINAL		TE TERMINAL	
7-520365-2					

WIRE SIZE		CRIMP HEIGHT INCH [mm]		CRIMP HEIGHT REFERENCE SETTING	Ø SOLDER
22		0.065+/-0.002 [1.65+/-0.05]		6.0	.12 IN [3.05mm]
24 OR 26		0.060+/-0.002 [1.52+/-0.05]		7.4	.12 IN [3.05mm]



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: 8-2151693-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151693-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151693-6

5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

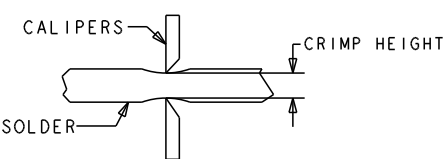
CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

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.

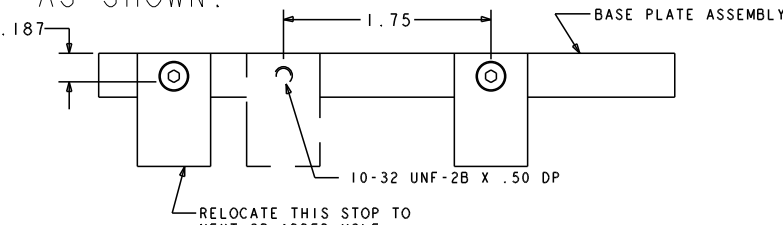
ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.

ITEMS 5/22 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.

TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.12 IN [3.05mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.



ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.

ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.

TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.

ITEMS NOT SHOWN.

ITEM 261 REQUIRED WHEN APPLICATOR IS REMOVED FROM LEADMAKER AND PLACED IN AMP-O-LECTRIC® TERMINATING UNIT.

*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.

	8	-	1	1	1	1-18023-1	SCR, SHC, M4x10	262
	8	-	1	1	1	803931-1	BRACKET, HOLD DOWN	261
	8	-	REF	REF	REF	462992-7	GUARD ASSEMBLY	257
	8	-	REF	REF	REF	679532-1	INSERT, GUARD	256
	8	-	1	1	1	189728-1	BRACKET, SPACER	255
	8	-	1	1	1	568681-1	SPACER, BASE PLATE	253
		-	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	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-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	-

-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	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
-	-	-	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	2-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	2119650-1	RAM, 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
-	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	6	6	6	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	240641-9	SPACER	81
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	2161332-3	DEPRESSOR, WIRE FUNNEL	70
-	1	1	1	2161331-1	SPACER, WIRE FUNNEL DEPRESSOR	69
-	2	2	2	1-18028-4	WASHER, FLAT, REG M3	68
-	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
-	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	462427-2	FINGER, FEED	56
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	462433-9	SUPPORT, INSULATION	42
-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	2119644-2	RAM WASHER, PRECISION	38
-	2	2	2	5-22278-1	SPRING, COMPRESSION	33
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	2	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	30
-	1	1	1	2161336-1	PLATE, REAR STRIP GUIDE	29
-	2	2	2	22281-9	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	684042-4	GUIDE, STRIP, FRONT	24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	462431-6	WIRE FUNNEL	22
-	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	463460-2	HOLD DOWN, TERMINAL	18
-	1	1	1	469542-3	REAR FLOATING SHEAR	17
-	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1	2161335-2	SHEAR PLATE, REAR	15
-	1	1	1	2119862-2	SHEAR HOLDER, REAR	14
-	1	1	1	2280441-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	356885-4	STOP, SHEAR	11
-	1	1	1	462843-8	TERMINAL SUPPORT	9
-	1	1	1	464291-6	ANVIL, SAND-BLASTED 22-18	8
-	1	1	1	803925-2	GUIDE, CARRIER SCRAP	7
-	1	1	1	2-690468-5	DEPRESSOR SHEAR, REAR	6
-	1	1	1	462431-3	WIRE FUNNEL	5
-	1	1	1	1-238009-4	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	464290-2	CRIMPER, SEMI-FLAT 22-18	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator					
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		PRODUCT SPEC		RESTRICTED TO					
MATERIAL		FINISH		APPLICATION SPEC		SIZE		CASE CODE		DRAWING NO	
-		-		-		A1		00779		C=2151693	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				WEIGHT		SCALE		SHEET		REV	
				-		1:1		3 OF 4		B	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

