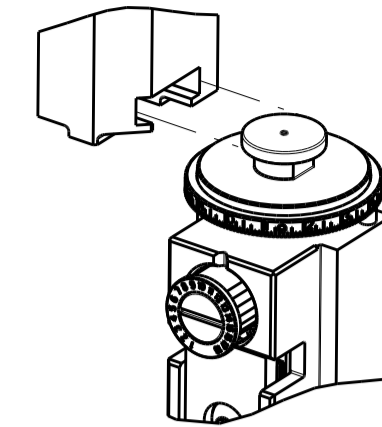


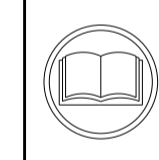
APPLICATOR STYLE CONVERSION CHART. Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.



APPLICATOR DATA. Table with columns: CRIMP, SIZE, TYPE. Includes WIRE 4.00 mm, INSUL 6.20 mm.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Table with columns: TE TERMINAL, TE SEAL.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.



- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
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
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151951-6
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.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 242.
GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.00.
THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.REFER TO APPLICATION SPECIFICATION FOR PROPER WIRE SIZE & SEAL.
APPLY TORO-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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists various components like SPACER, CRIMPER, SCR, BHSC, RoHS (M3 X 6), etc.

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

SET UP GAUGE 2119599-1. Table with columns: LOC, DIST, REVISIONS, DATE, DWN, APVD.

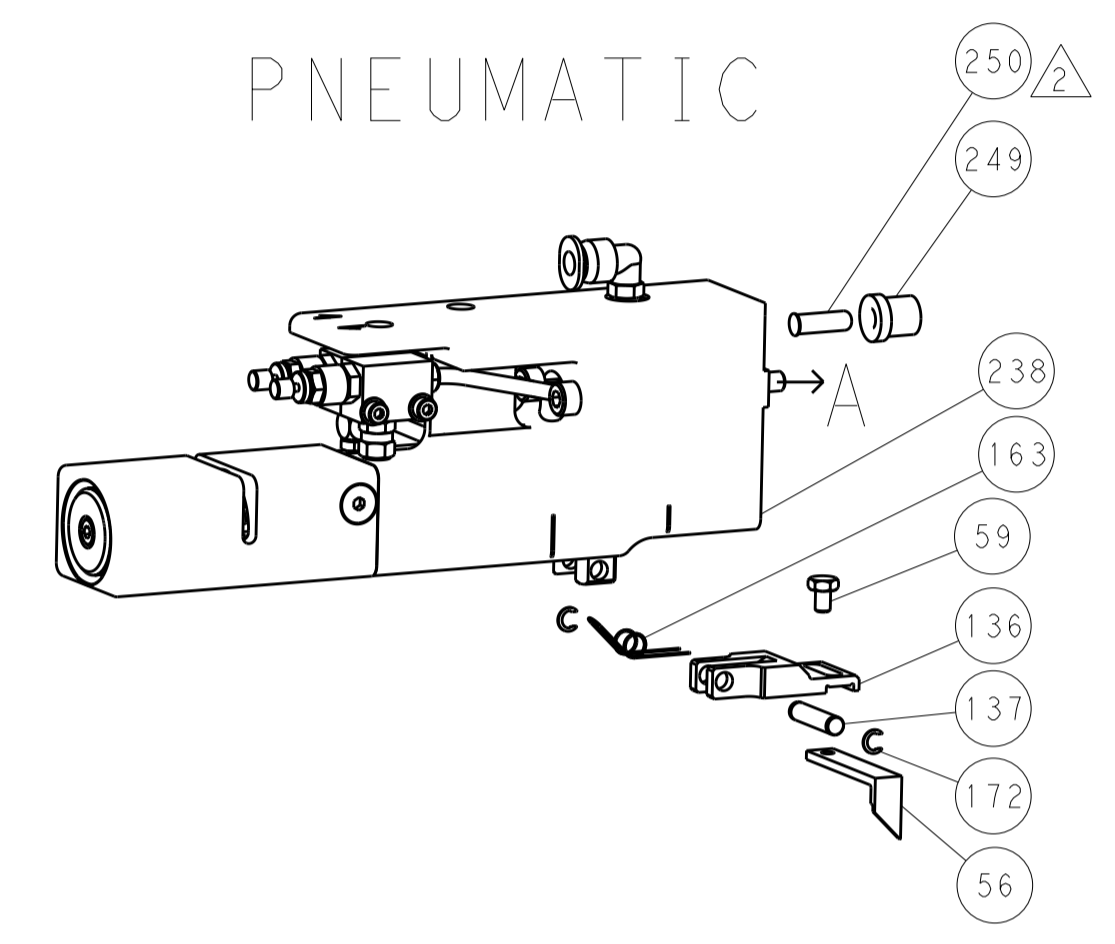
Main parts list table with columns: PART NO, DESCRIPTION, ITEM NO. Lists numerous components like DETENT PIN, SPRING, COMPRESSION, RAM, STEPPED, ATLANTIC, SF, NON-ADJ, etc.

Product specification block including dimensions, tolerances, material, finish, weight, and customer accessible production drawing information.

LOC	DIST	REV	DATE	BY	APPV
A	66				

FEED TYPE

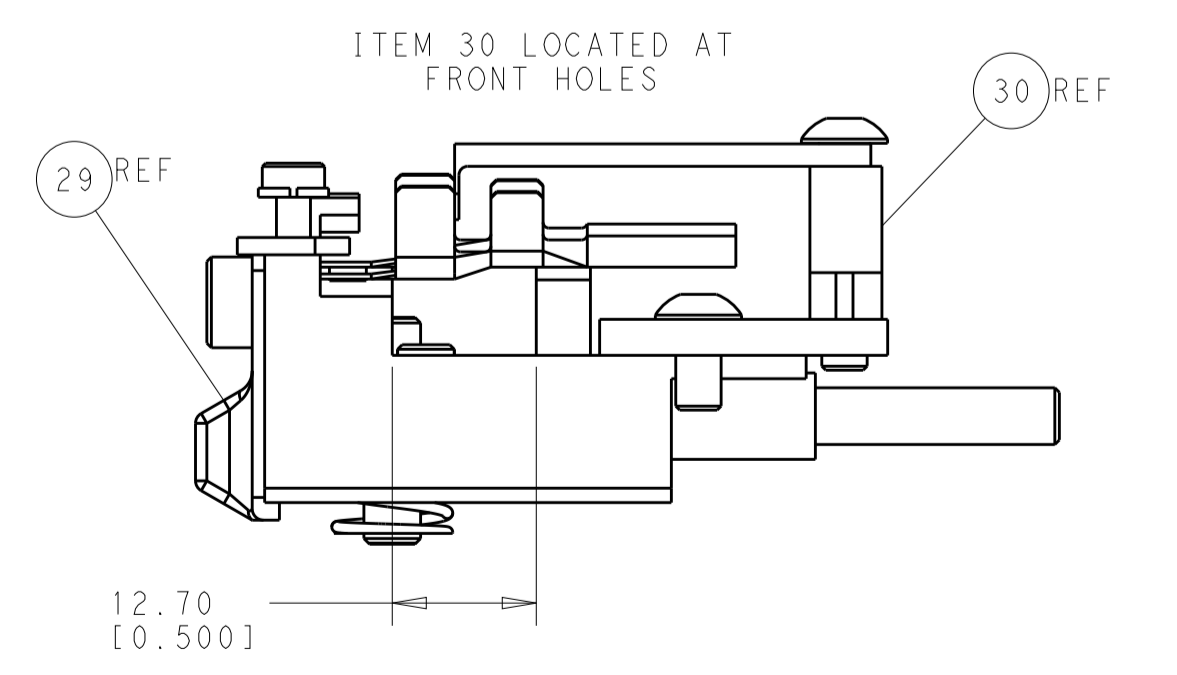
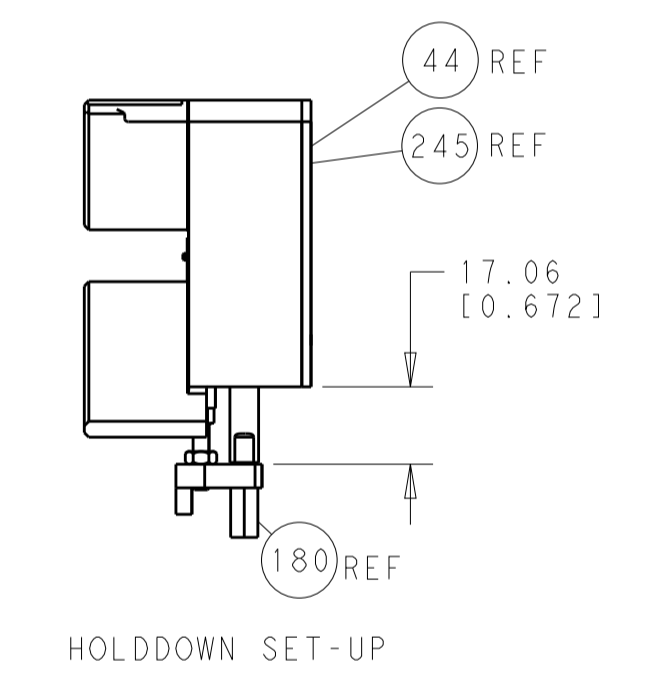
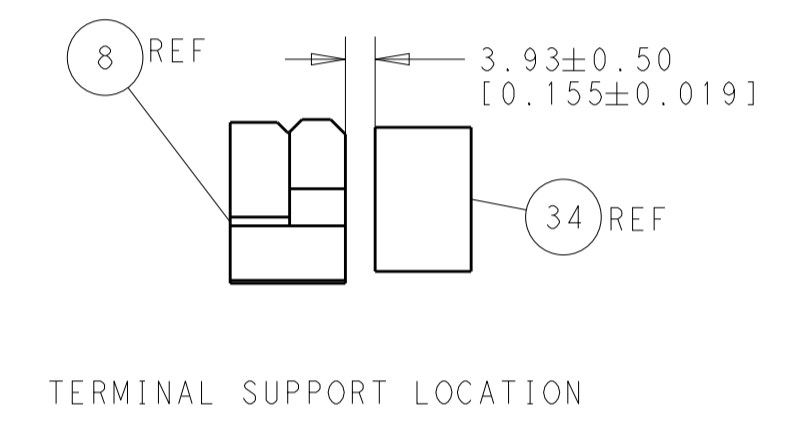
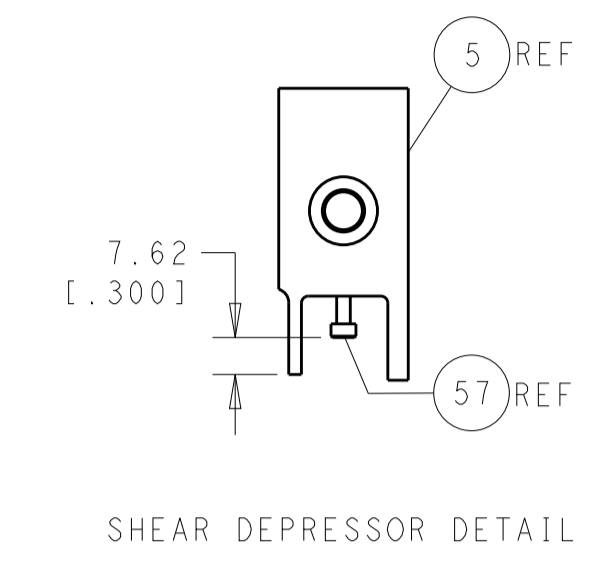
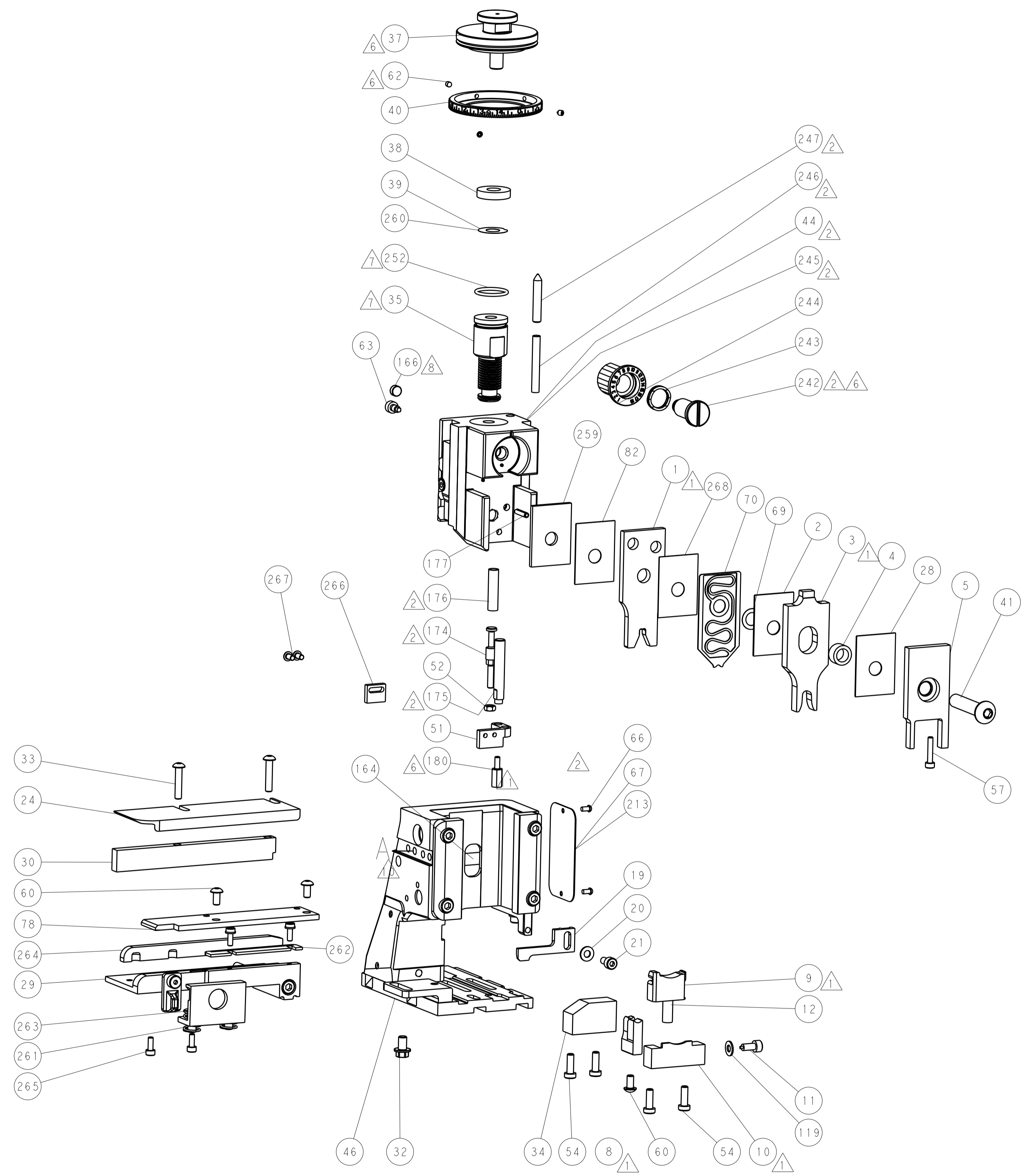
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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

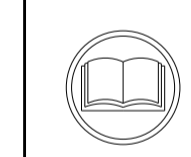
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.001		DWN C. CHEN 28APR2013 CHK U. GUO 28APR2013 APVD J. CRUZ 28APR2013		NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C-2151951	
Customer 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 ⁴
	2-2151951-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2151951-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
INSUL	4.00 mm [1.57]	F
	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 ¹⁰ ¹¹ ¹²			
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 ⁹
7.00mm2	2.80 +/- 0.05 [1.10 +/- .002]	6.2
6.00mm2	2.80 +/- 0.05 [1.10 +/- .002]	6.3
5.00mm2	2.45 +/- 0.05 [1.096 +/- .002]	10.0



- ¹ 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:
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.
- ⁶ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62, 180 & 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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. REFER TO APPLICATION SPECIFICATION FOR PROPER WIRE SIZE & 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.

***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)

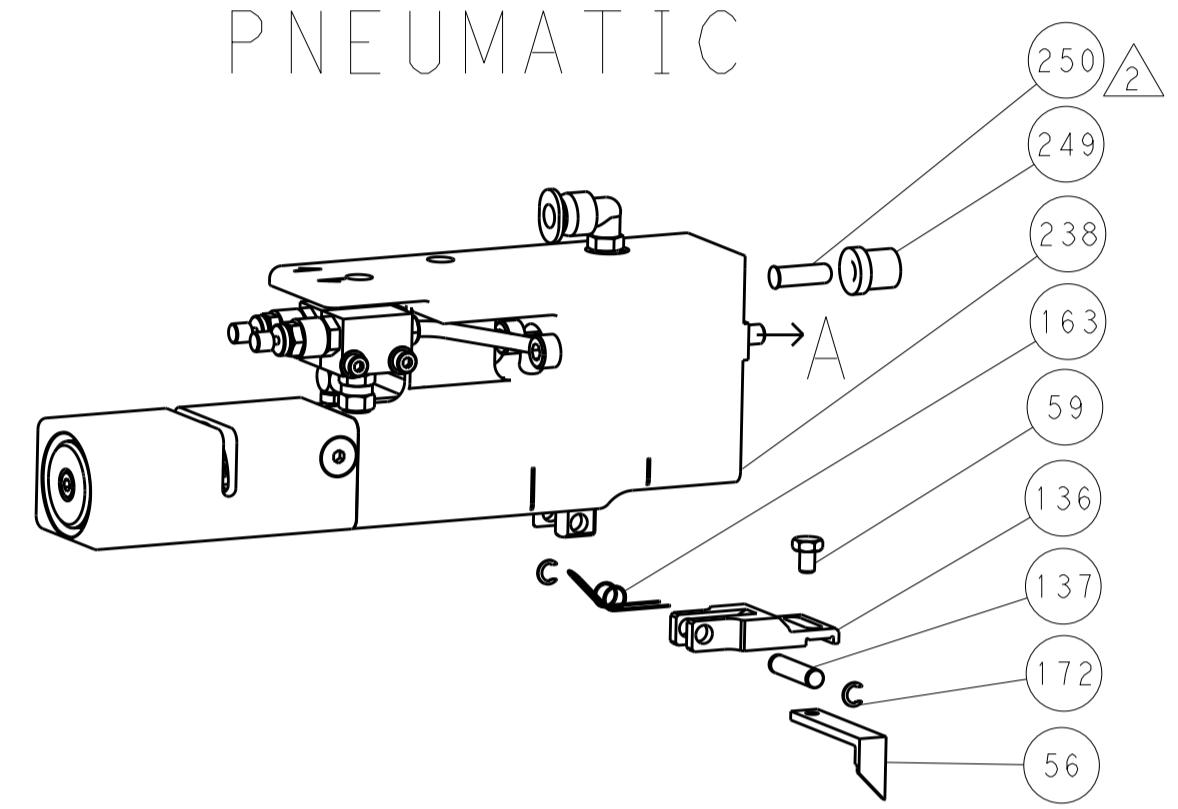
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	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
-	-	1	-	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
-	-	-	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
-	-	-	-	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
-	-	-	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	1-18028-2	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
-	-	-	1	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
-	-	-	1	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
-	-	-	1	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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±.5	1 PLC ±.13	2 PLC ±.013	3 PLC ±.0001	ANGLES
MATERIAL:		FINISH:		WEIGHT:	
Customer Accessible Production Drawing				SCALE	SHEET 3 OF 4
				REV	A

LOC	DIST	REV	DATE	BY	APPV
A	66				

FEED TYPE PNEUMATIC



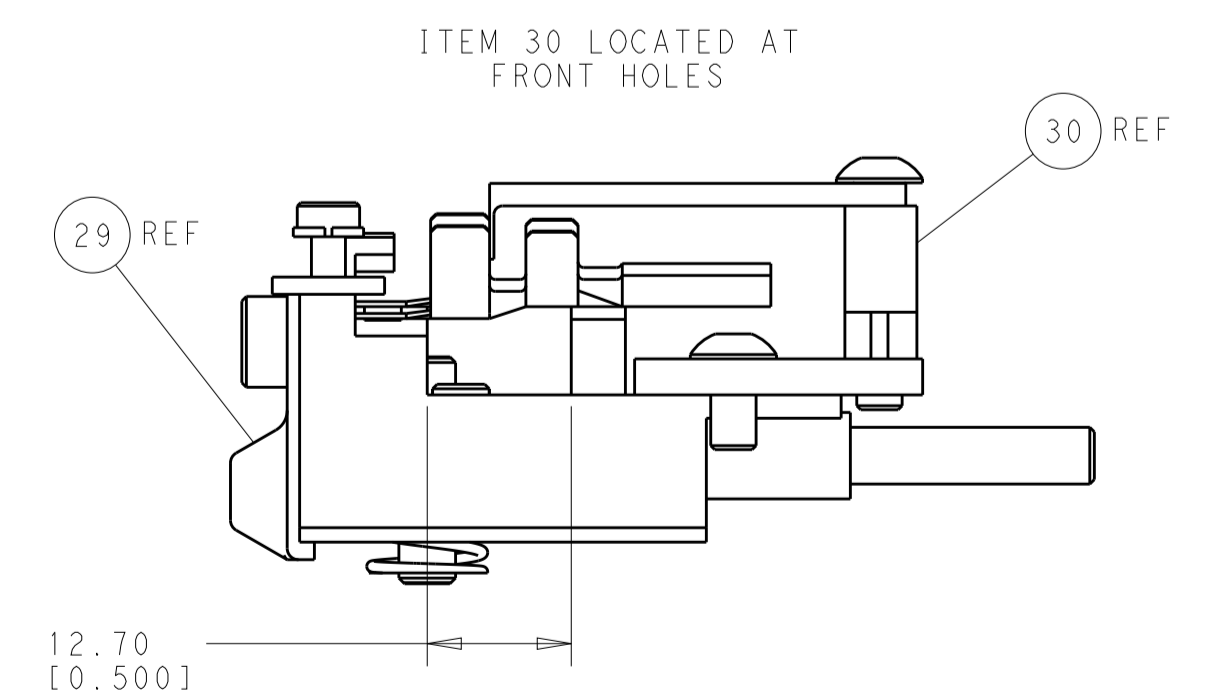
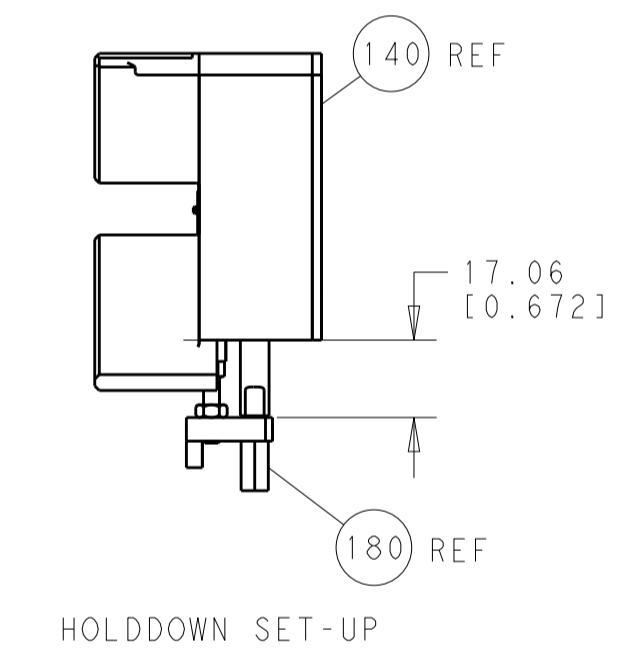
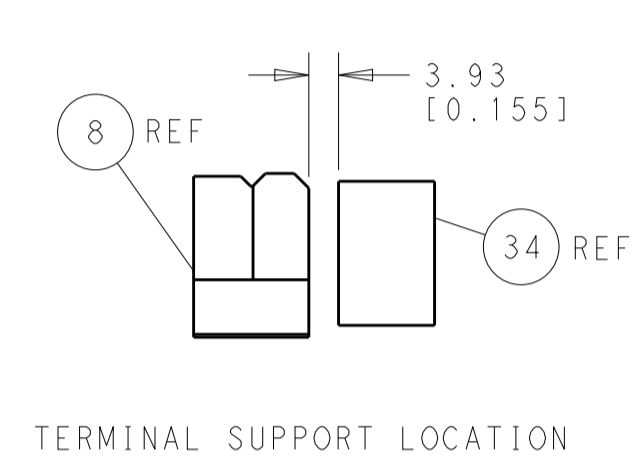
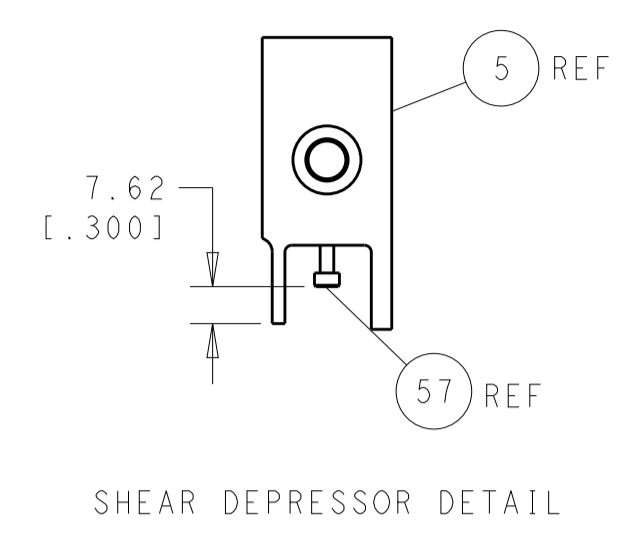
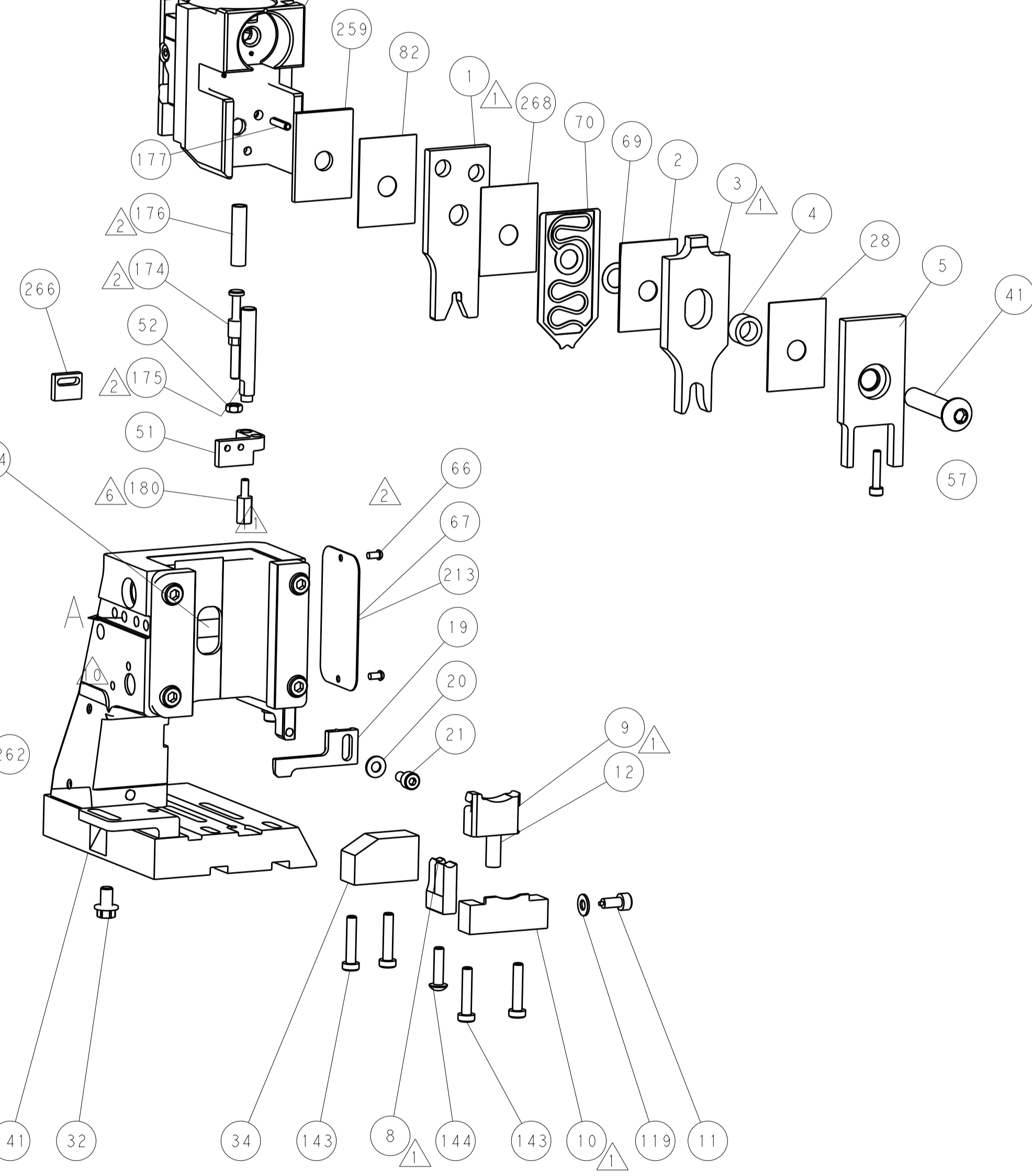
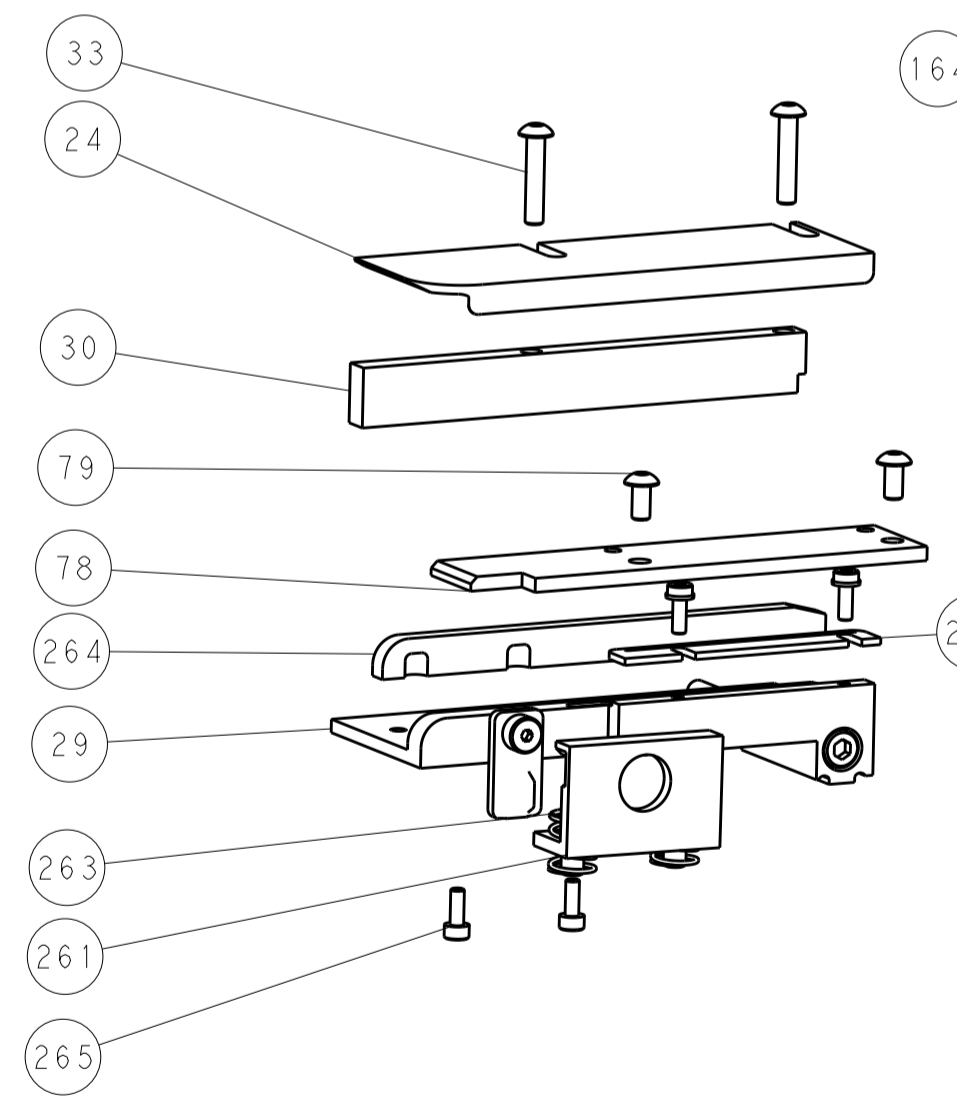
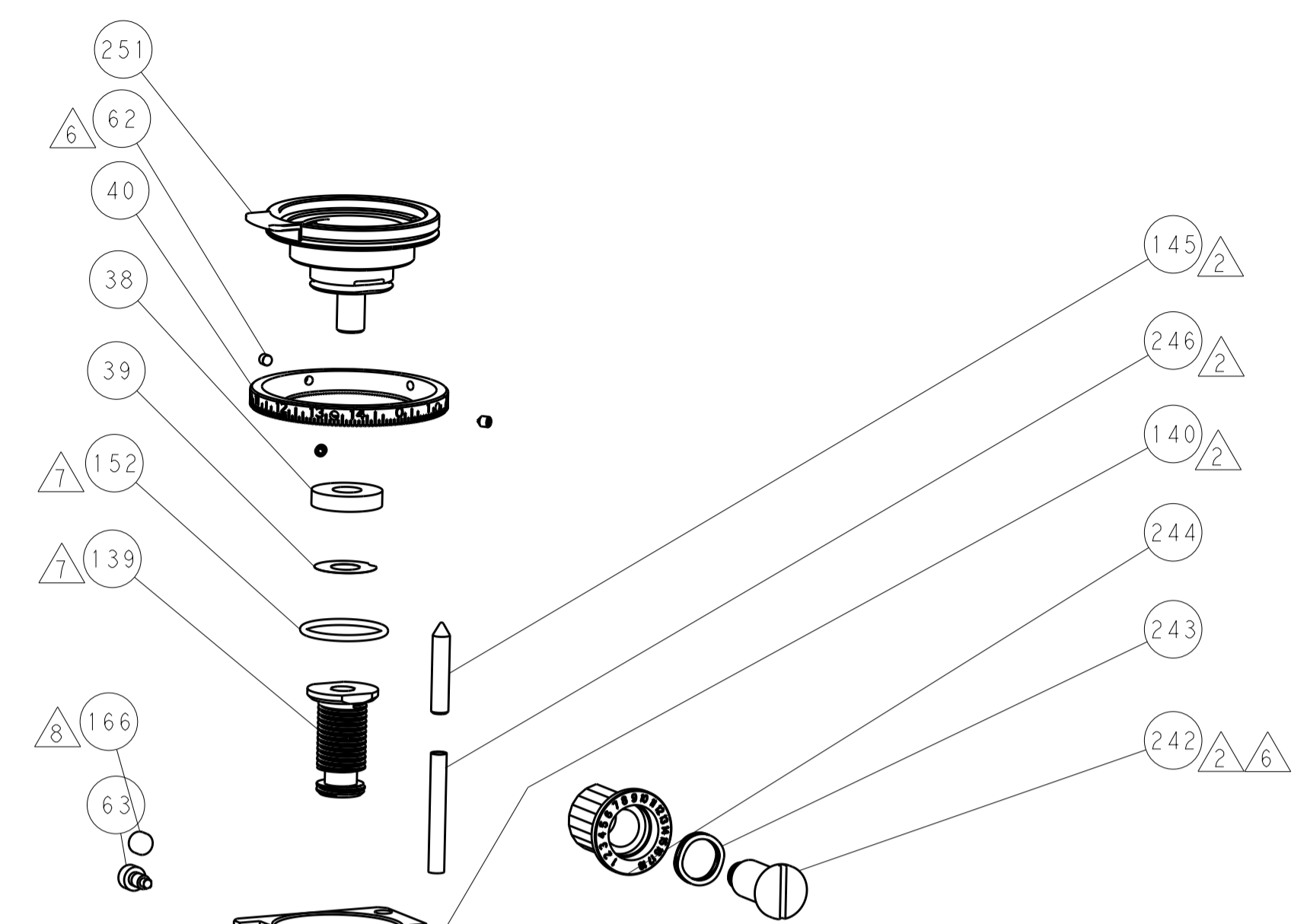
SERVO LATCH PLATE



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	