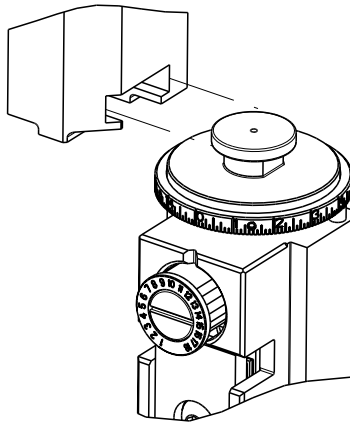
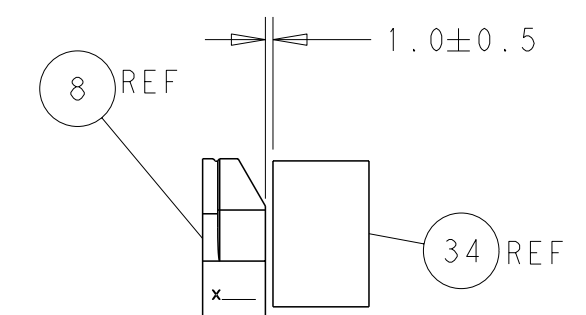
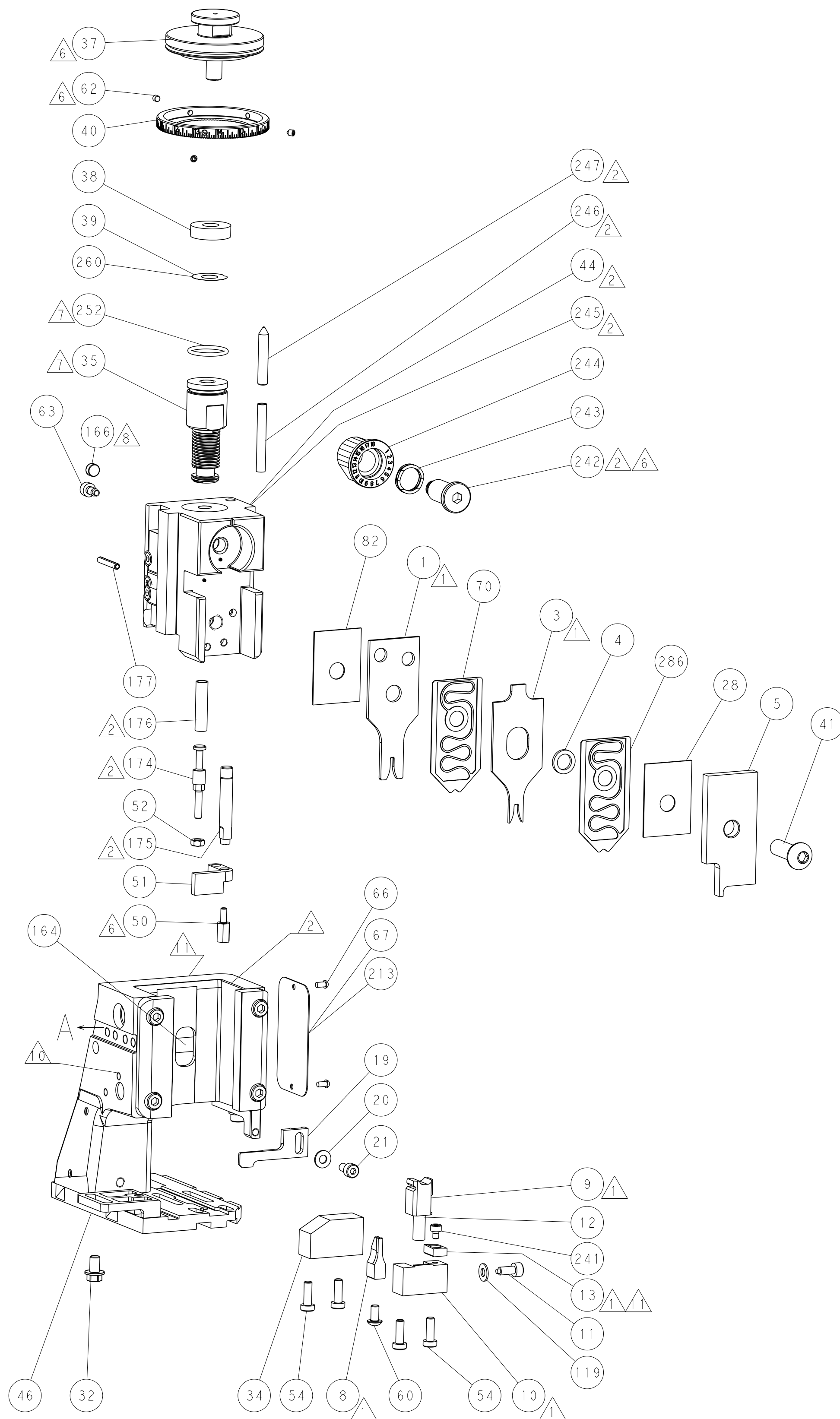


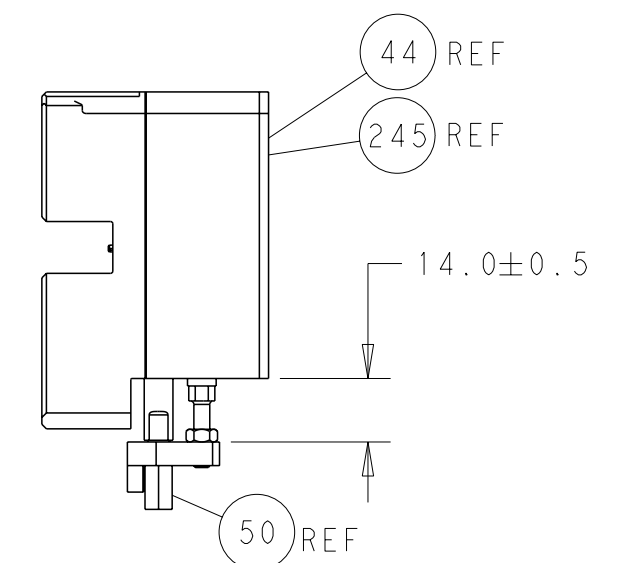
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
		2151113-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
						SERVO LATCH PLATE	2119951-1	-	8-2151113-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2151113-4	-	-	-
		2151113-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
						SERVO LATCH PLATE	2119951-1	-	8-2151113-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2151113-4	-	-	-
		2151113-5	F	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
		2151113-6	F	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	-
						-	-	-	-	-	-	-
		2151113-7	F	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
		7-2151113-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

[illegible]

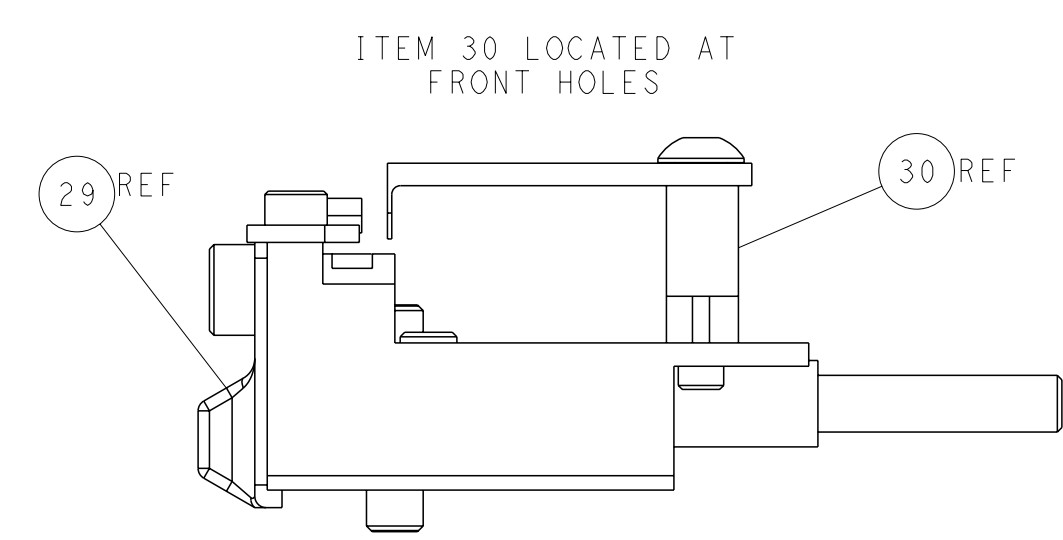
SERVO FEEDER NOT INCLUDED



TERMINAL SUPPORT LOCATION

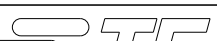
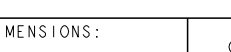


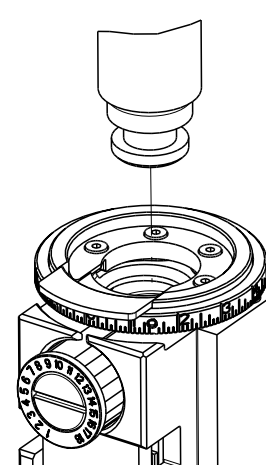
HOLDDOWN SET-UP



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)

*THIS DRAWING IS A CONTROLLED DOCUMENT FOR ISO ELECTRONICS CORPORATION IT IS SUBJECT TO THE SAME CONTROL AS THE PRODUCT IT REPRESENTS. ANY REVISION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN K. HUANG 28SEP2011 CHK S. XI 28SEP2011 APVD I. CRUZ 28SEP2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.05 1 PLC ±.13 2 PLC ±.013 4 PLC ±0.0001 ANGLES ±.		NAME Ocean Side Feed Applicator -	
MATERIAL FINISH - -		WEIGHT -		SIZE A CAGE CODE 00779 DRAWING NO C=251113 RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 of 4 REV F	

8		7		6		5		4		3		
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
		2-2151113-1	F	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	-	8-2151113-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2151113-4	-	-	-
		2-2151113-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
						SERVO LATCH PLATE	2119951-1	-	8-2151113-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2151113-4	-	-	-
		2-2151113-5	F	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
		2-2151113-7	F	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
		7-2151113-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.60 mm [.102]	F

APPLICATOR INSTRUCTIONS
408-10389



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ECONOMY POWER(EP) CONN.REC CONT			
WIRE STRIP LENGTH 2.70-3.30 mm [1.06-.130 IN]		INSULATION DIAMETER RANGE Ø1.70-3.00 mm [1.067-.118 IN]	
TERMINAL APPLICATION 		(A)114-5253	
SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1123721-1	1123721-2	647662-1	

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ECONOMY POWER(EP) CONN.REC CONT			
WIRE STRIP LENGTH 2.69-3.30 mm [.106-.130 IN]		INSULATION DIAMETER RANGE Ø1.70-2.90 mm [.067-.114 IN]	
TERMINAL APPLICATION  (B)114-13265		-	
SPECIFICATION -		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1744144-1	1744144-2	1744144-3	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.75-0.89mm (#18)		1.15+/-0.05 [0.045+/-0.002]		4.6
0.5-0.56mm (#20)		1.10+/-0.05 [0.043+/-0.002]		4.9
0.3-0.35mm (#22)		1.00+/-0.05 [0.039+/-0.002]		6.0

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.75-0.89mm (#18)			1.15+/-0.05 [0.045+/-0.002]		4.6
0.5-0.56mm (#20)			1.10+/-0.05 [0.043+/-0.002]		4.9
0.3-0.35mm (#22)			1.00+/-0.05 [0.039+/-0.002]		6.0



 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: 8-2151113-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151113-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151113-5

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 ITEM 50 & 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

 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 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET
FOR ADDITIONAL INFORMATION.

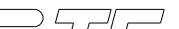
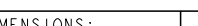
 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	286
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
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-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-77	-27	-25	-22	-21	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)

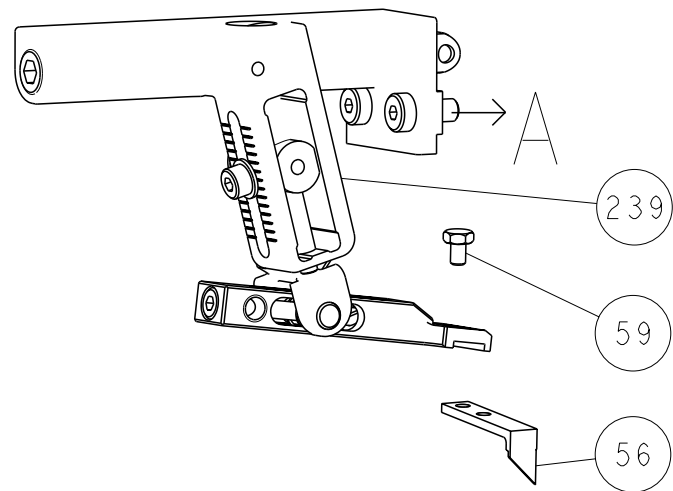
2		1				
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
P	LTR	DESCRIPTION		DATE	DWN	APVD
	-	SEE SHEET 1		-	-	-

	-	1	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
	-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
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	-	-	-	1	-	-	2119641-2	FEED CAM, AIR FEED	151
	-	1	1	1	1	1	2119798-2	DETENT PIN	145
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	-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33

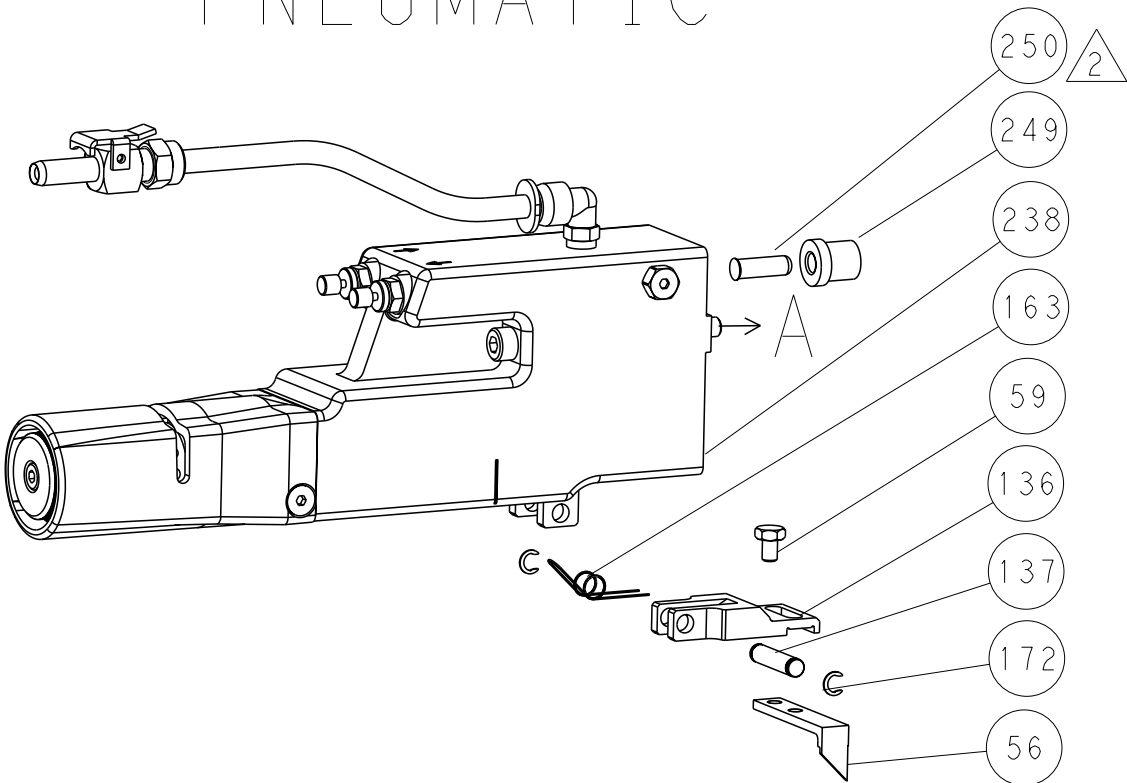
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.0005 1 PLC ±.0013 2 PLC ±.0013 3 PLC ±.0013 ANGLES ±.0001		NAME Ocean Side Feed Applicator	
		APVD 1 CRU7 28SEP2011 PRODUCT SPEC -		SIZE A 1 00779 C=2151113	
MATERIAL -		APPLICATION SPEC -		RESTRICTED TO -	
FINISH -		WEIGHT -		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
				SCALE 1:2 SHEET 3 OF 4 REV 1	

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

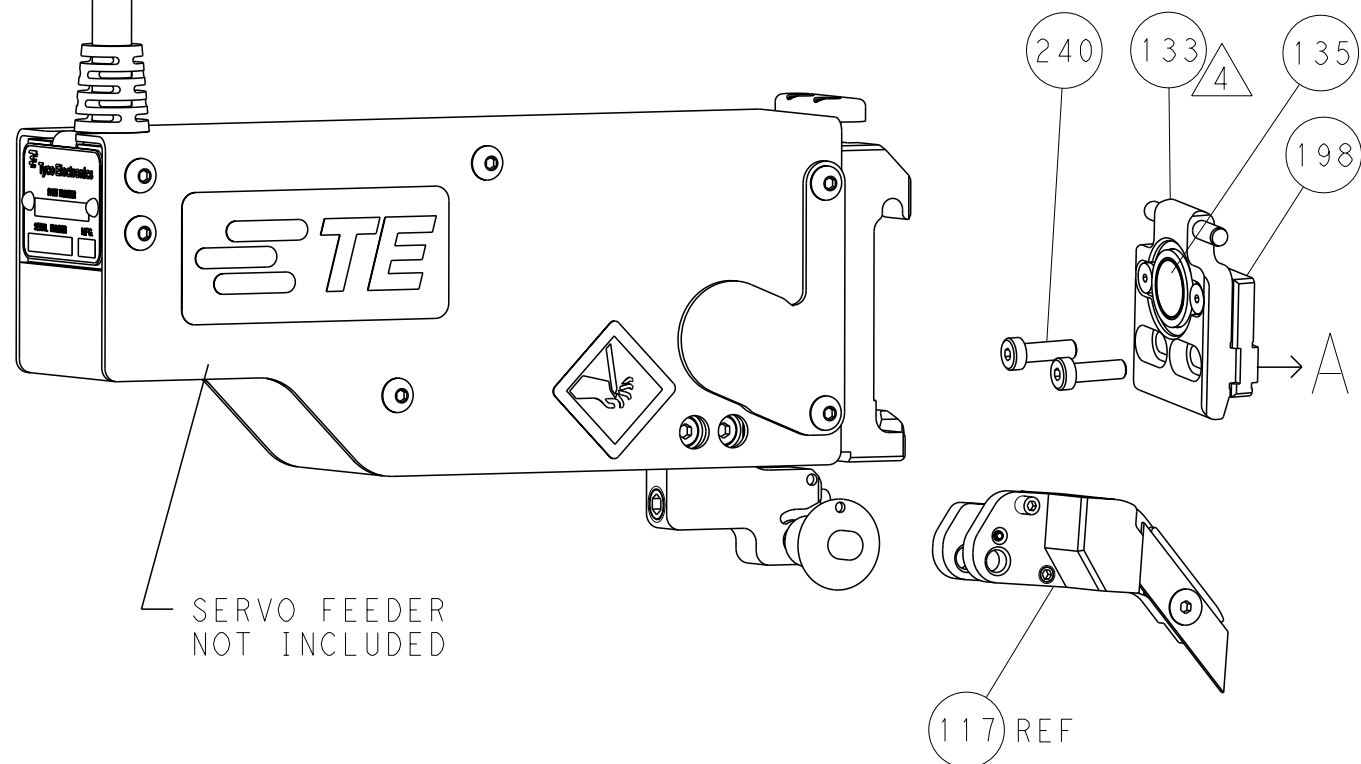
FEED TYPE
MECHANICAL



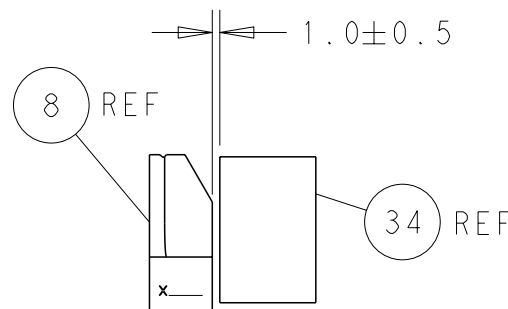
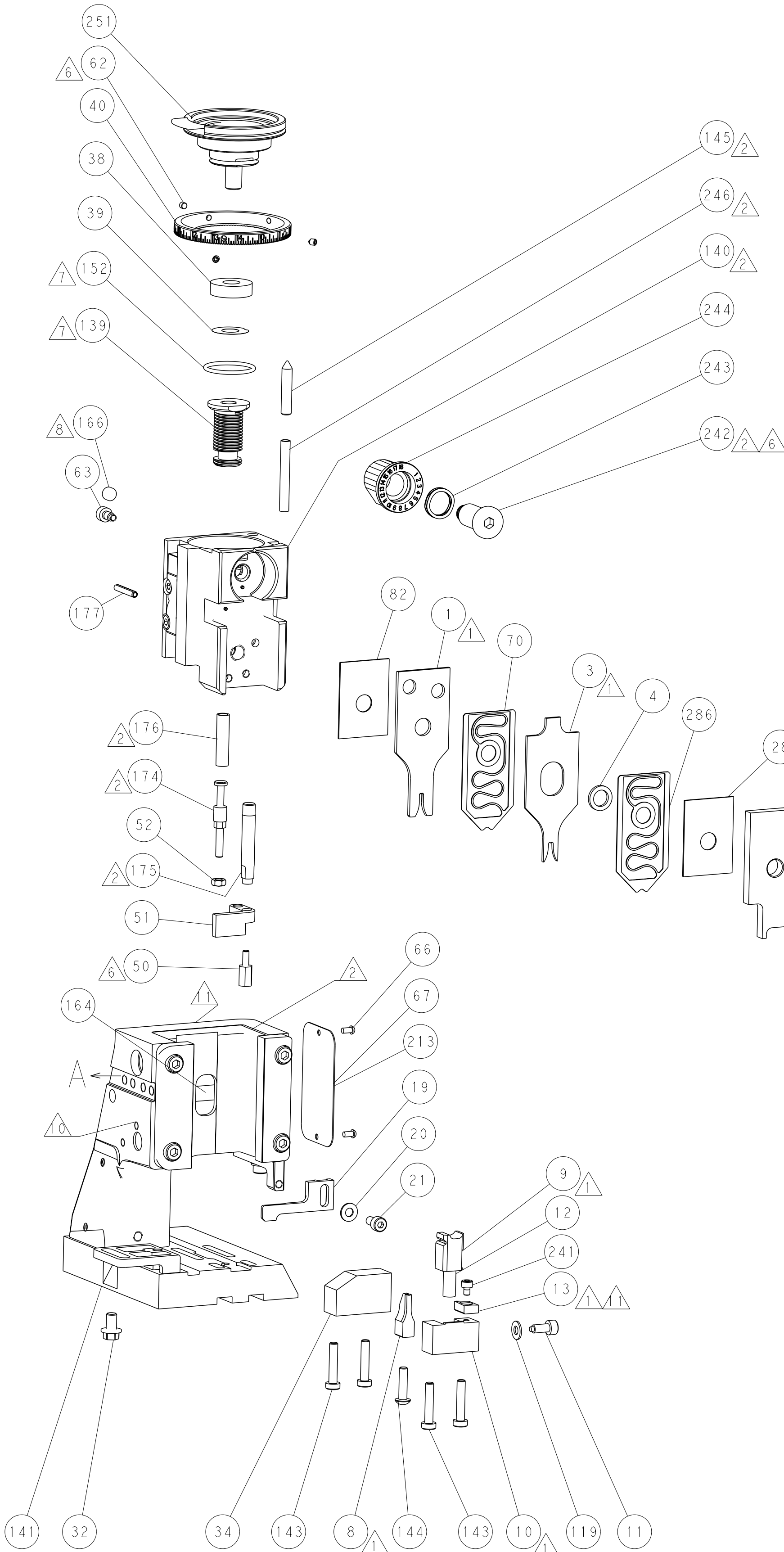
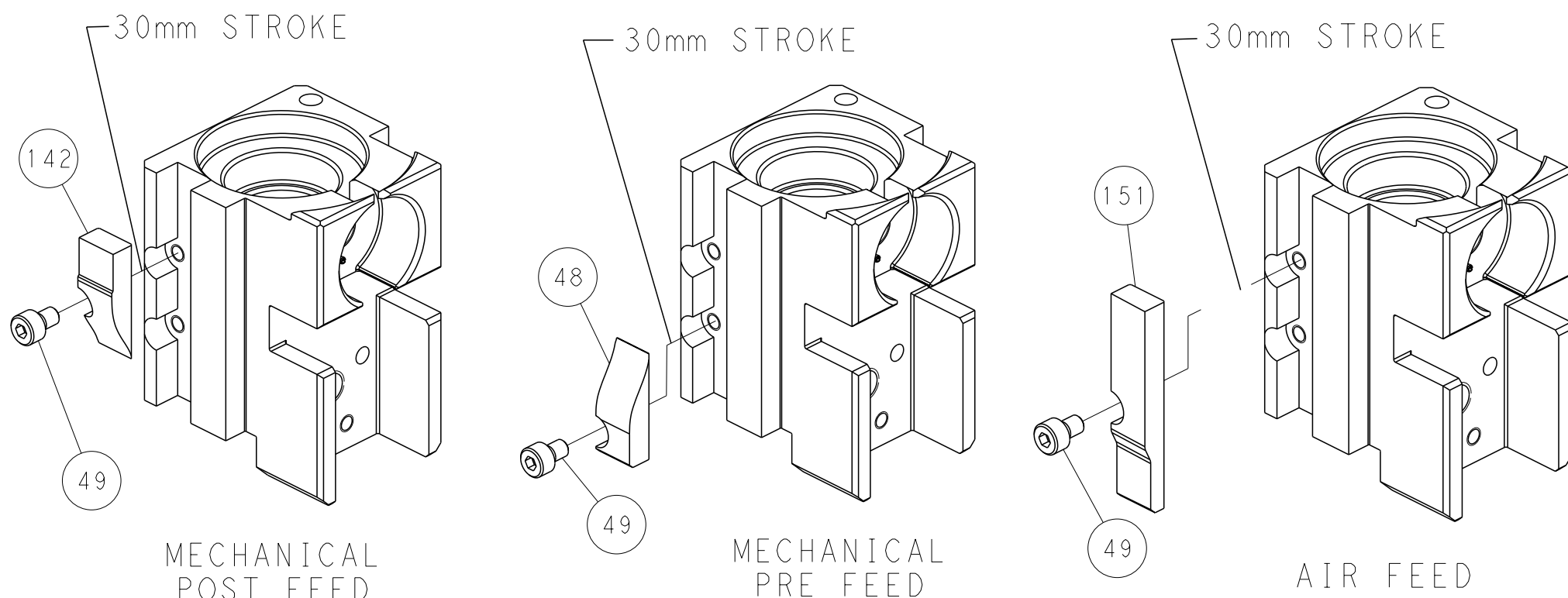
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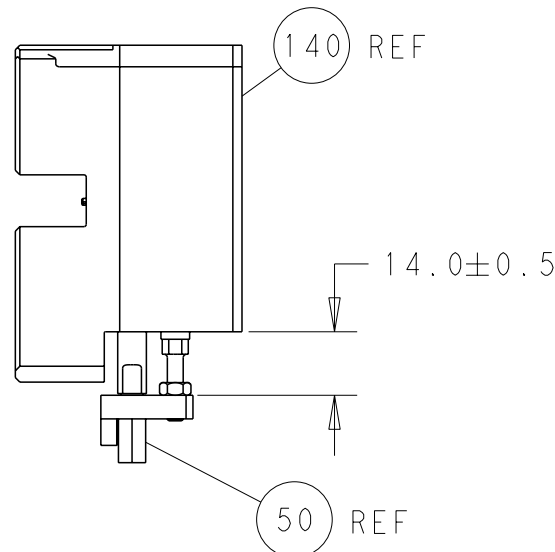
SERVO
LATCH PLATE



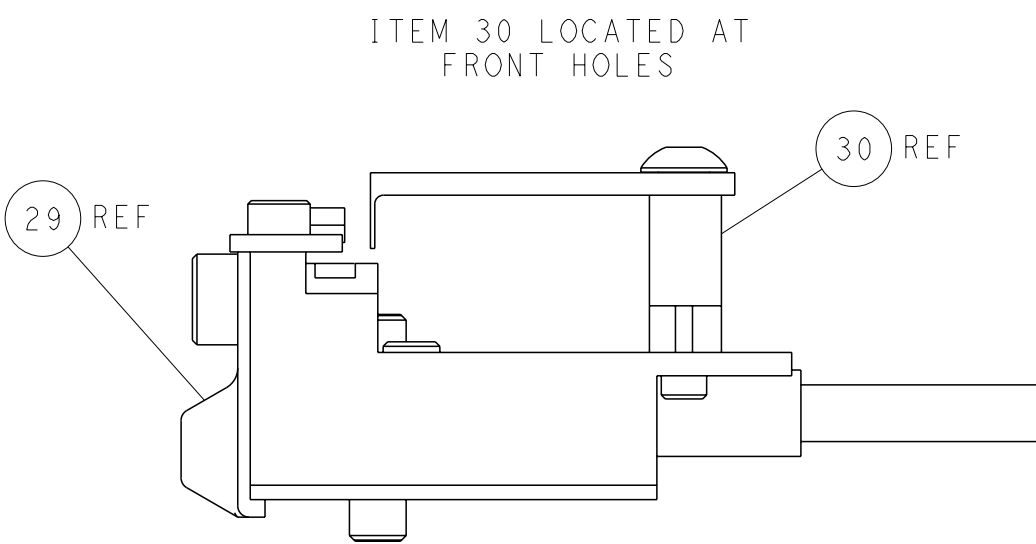
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE 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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN K. HUANG 28SEP2011		APVD S. XI 28SEP2011		NAME Ocean Side Feed Applicator	
mm		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.001		PRODUCT SPEC		APPLICATION SPEC		SIZE A1	
MATERIAL		FINISH		WEIGHT		CAGE CODE 00779		DRAWING NO 2151113	
				Customer Accessible Production Drawing		SCALE 1:2		SHEET 4	
								OF 4	
								REV F1	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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