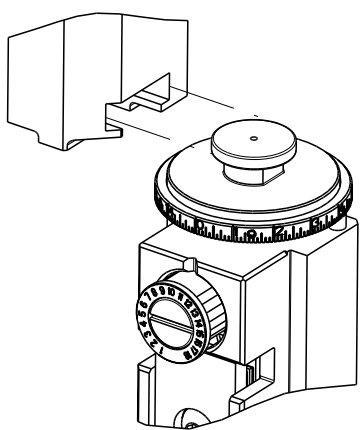


8		7		6		5		4		3		
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
		2151113-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC 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 	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 	-	-	-	-	-	-	-
						-	-	-	-	-	-	-
2151113-7	F	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-		
7-2151113-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-		

[illegible]

SERVO FEEDER NOT INCLUDED

30mm STROKE

47

49

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

48

49

40mm STROKE

MECHANICAL PRE FEED

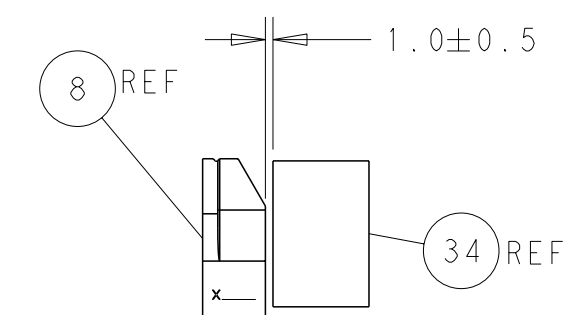
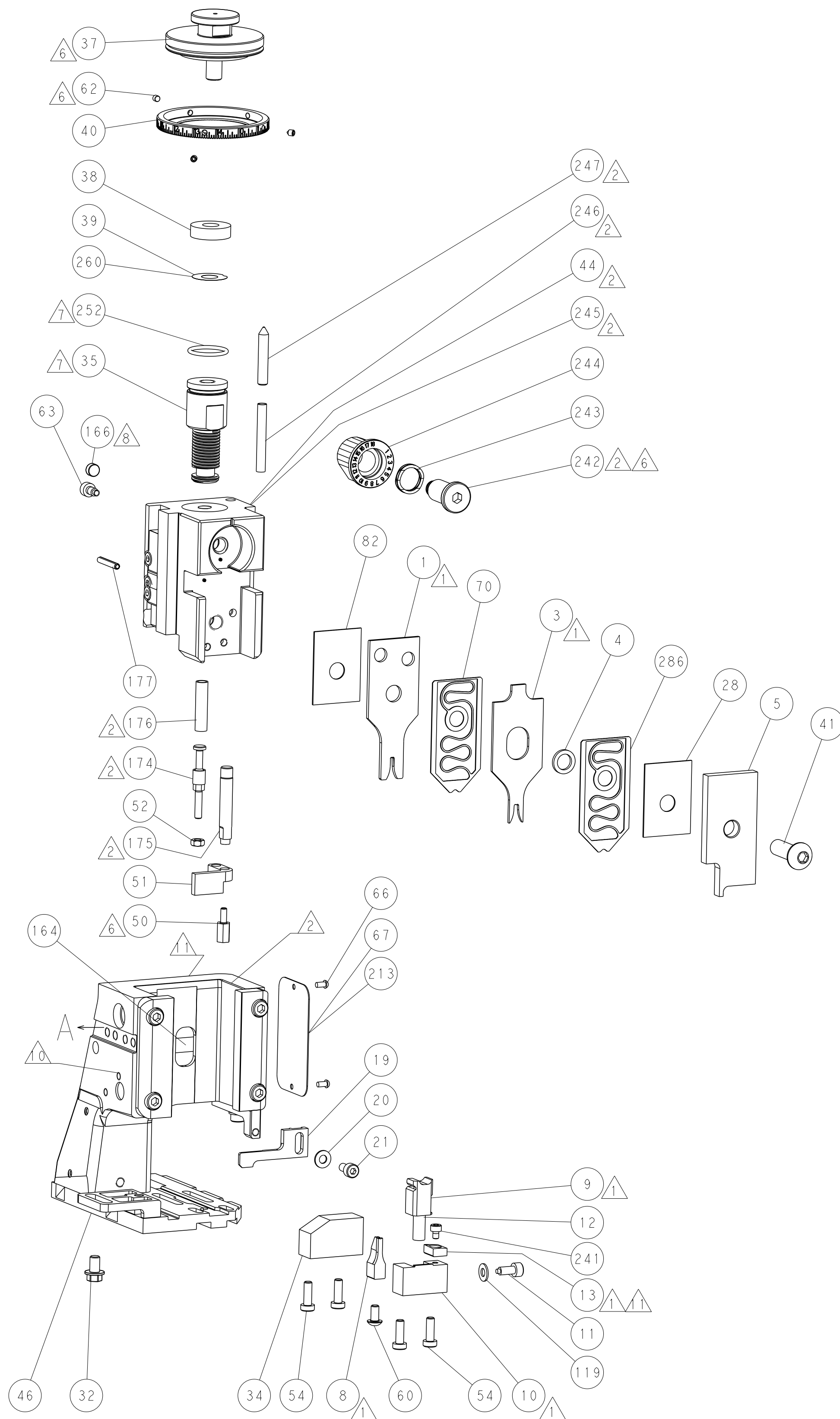
30mm STROKE

248

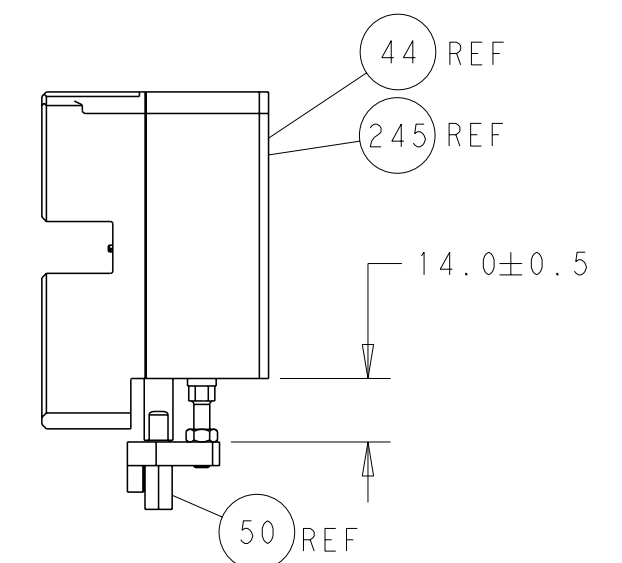
49

40mm STROKE

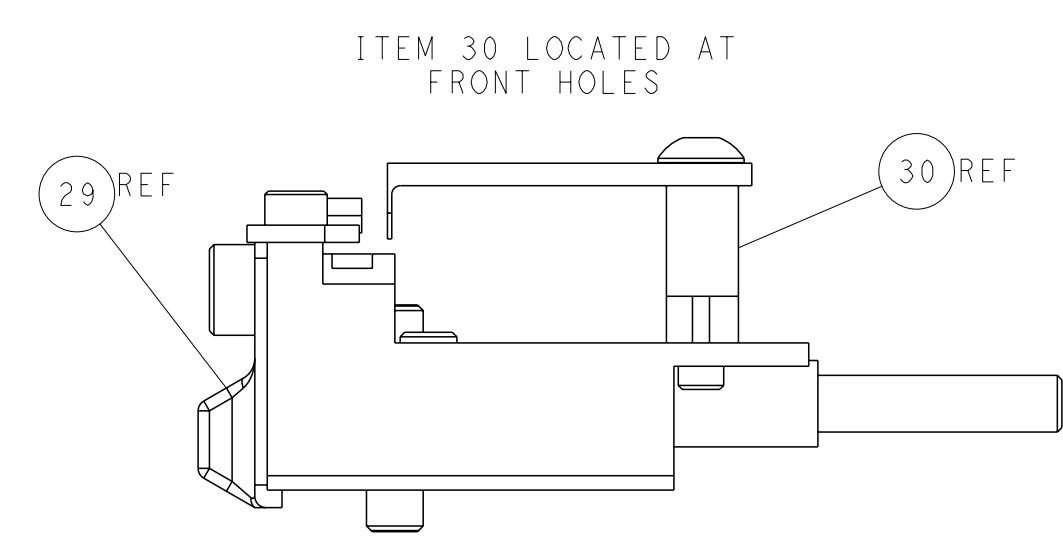
AIR FEED



TERMINAL SUPPORT LOCATION

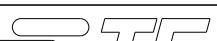
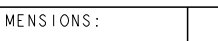


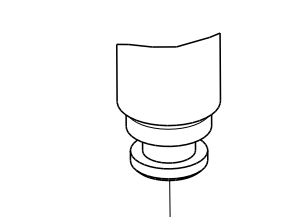
HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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-9001 ELECTRONICS CORPORATION IT IS SUBJECT TO THE SAME AS THE DRAWING OF THE ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN K. HUANG 28SEP2011		 TE Connectivity Harrisburg, PA 17105-3608	
		CHK S. XI 28SEP2011			
		APVD I. CRUZ 28SEP2011			
		NAME Ocean Side Feed Applicator -			
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.05 1 PLC ±.13 2 PLC ±.013 3 PLC ±.0001 4 PLC ANGLES ±.		SIZE A	
MATERIAL FINISH - -		WEIGHT -		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+/- .002]		4.6
0.5-0.56mm (#20)		1.10+/- 0.05 [0.043+/- .002]		4.9
0.3-0.35mm (#22)		1.00+/- 0.05 [0.039+/- .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.

- 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.

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

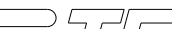
- 11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	286
-	1	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
-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)

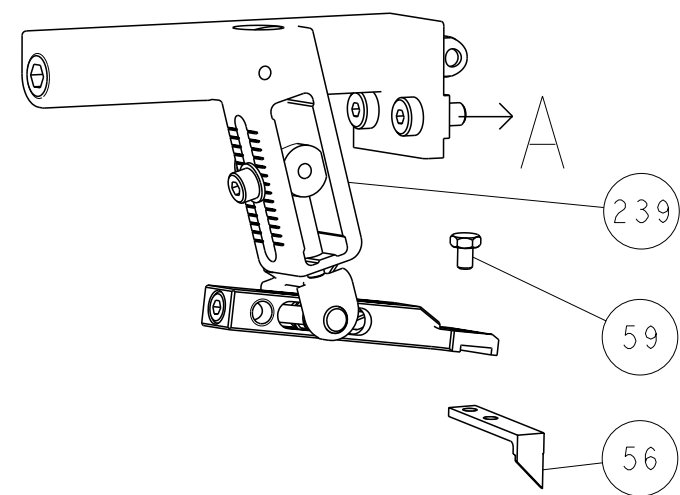
2		1			
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS		
P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

	-	1	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
	-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	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
	-	-	-	-	-	1	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
	-	1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	-	-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
8	-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	-	1	-	-	240638-1	SPRING, FEED FINGER	163
7	-	1	1	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	1	1	2119798-2	DETENT PIN	145
	-	1	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
	-	4	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
	-	-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
	-	1	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
7	-	1	1	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	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	-	REF	-	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
	-	1	1	1	1	1	455888-6	SPACER, CRIMPER	82
	-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	1	-	1	1	1	2119740-3	TAG, IDENTIFICATION	67
	-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
6	-	3	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	-	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	-	1	1	1	1338685-1	PAWL, FEED	56
	-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	51
6	-	1	1	1	1	1	2-1752354-3	STANDOFF, HOLD-DOWN	50
	-	-	-	1	2	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	-	-	1	1	2119652-1	FEED CAM, PRE FEED	48
	-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	1	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
	-	1	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33

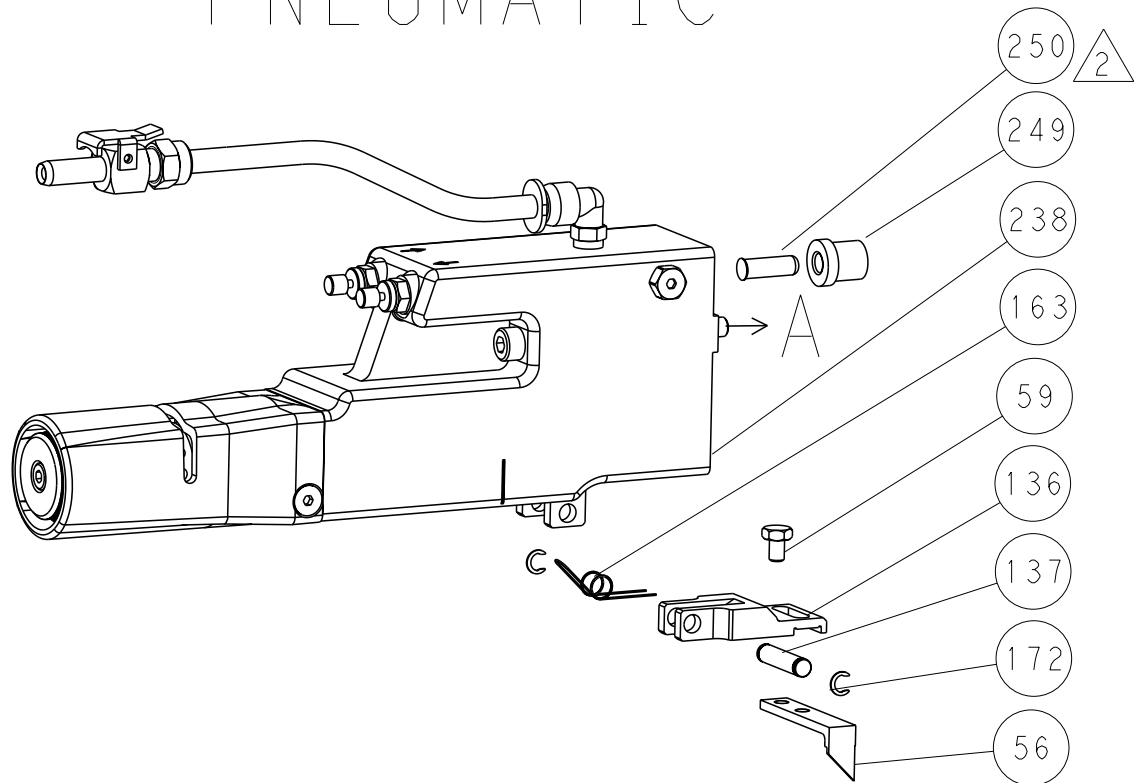
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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±°		NAME Ocean Side Feed Applicator -	
		APPLICATION SPEC -		SIZE CAGE CODE DRAWING NO A1 00779 C-2151113	
MATERIAL FINISH -		WEIGHT -		RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 OF 4 REV F1	

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

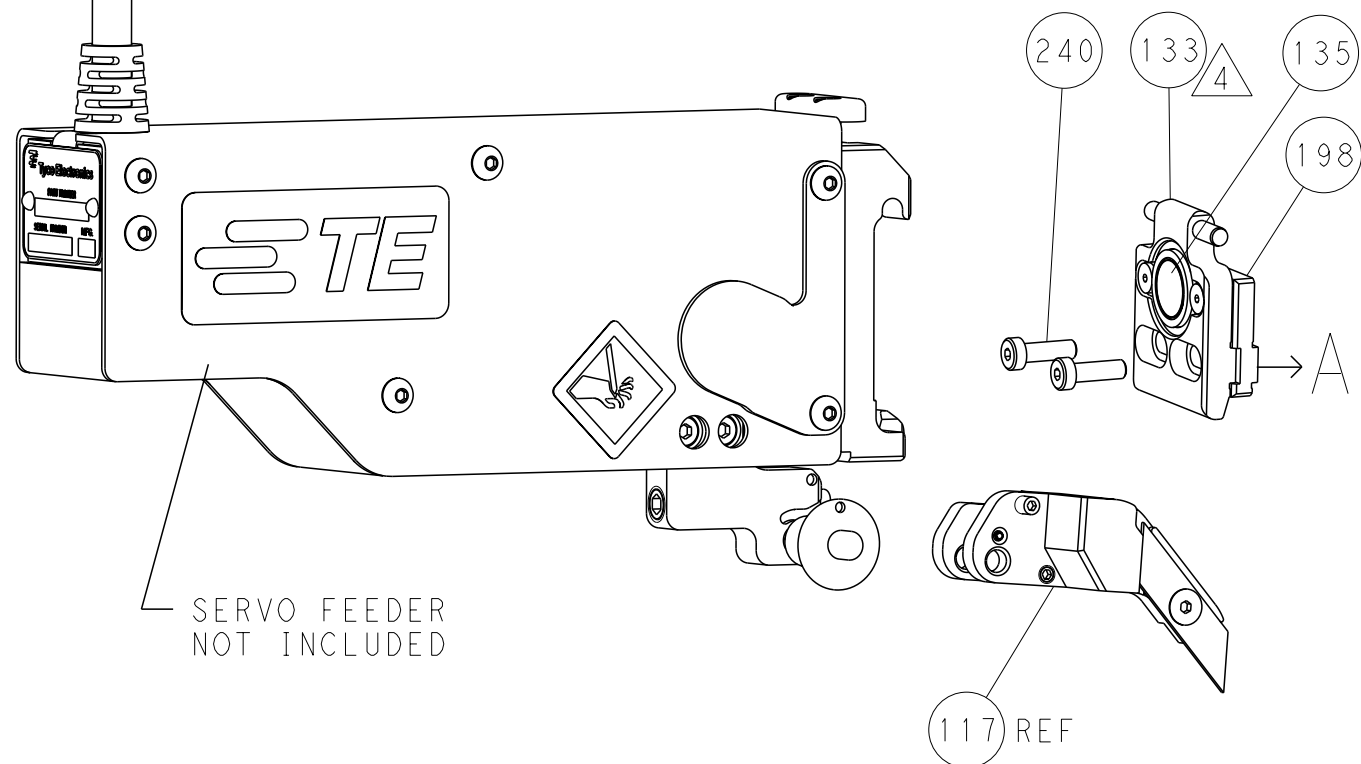
FEED TYPE MECHANICAL



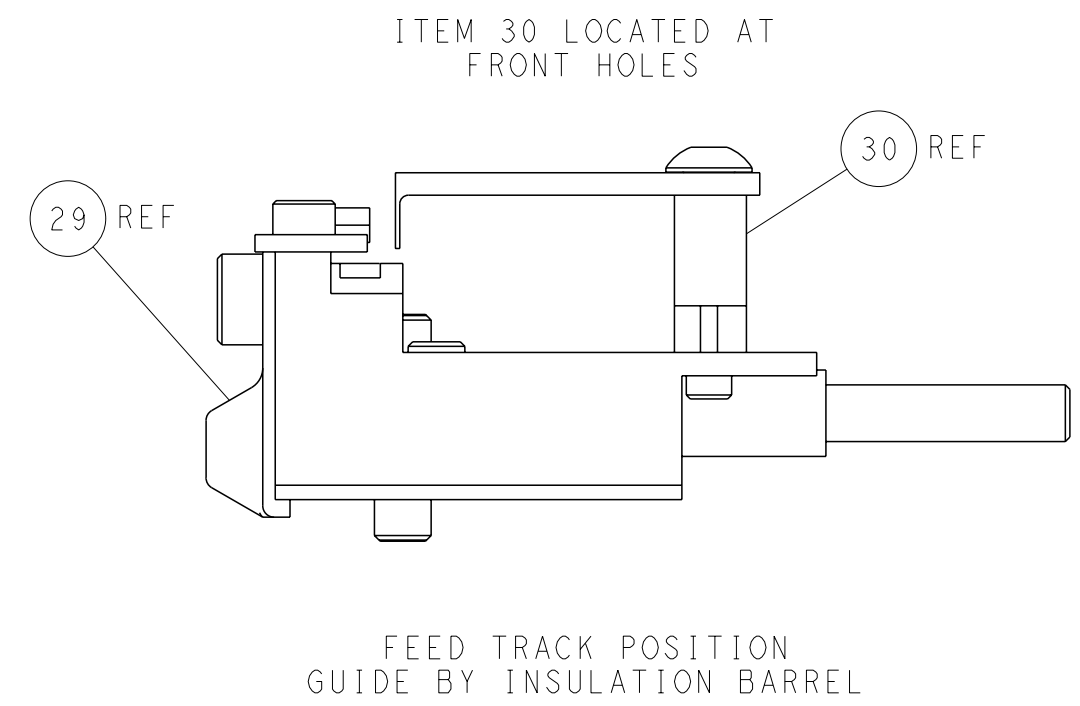
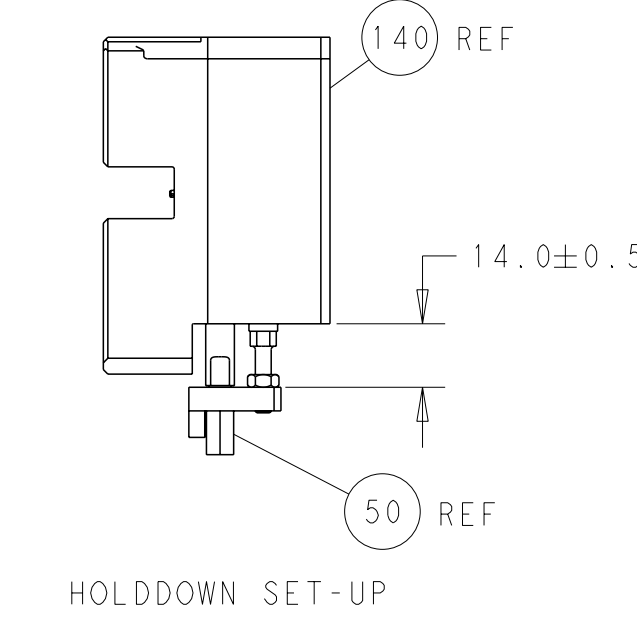
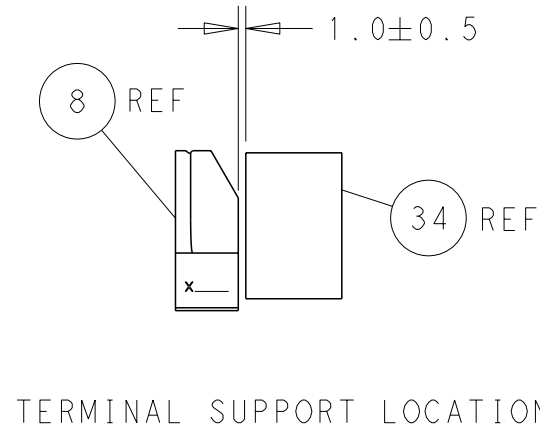
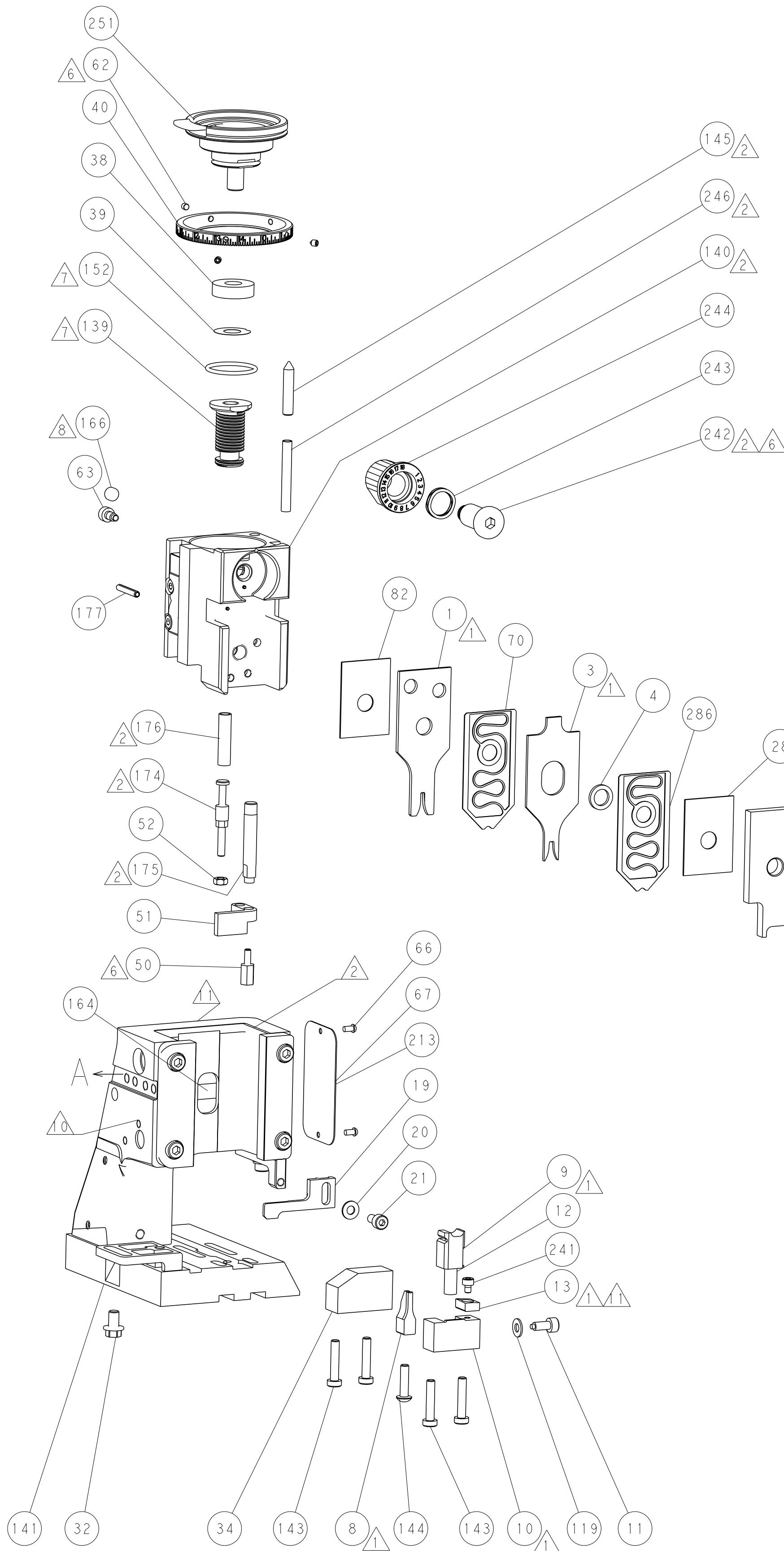
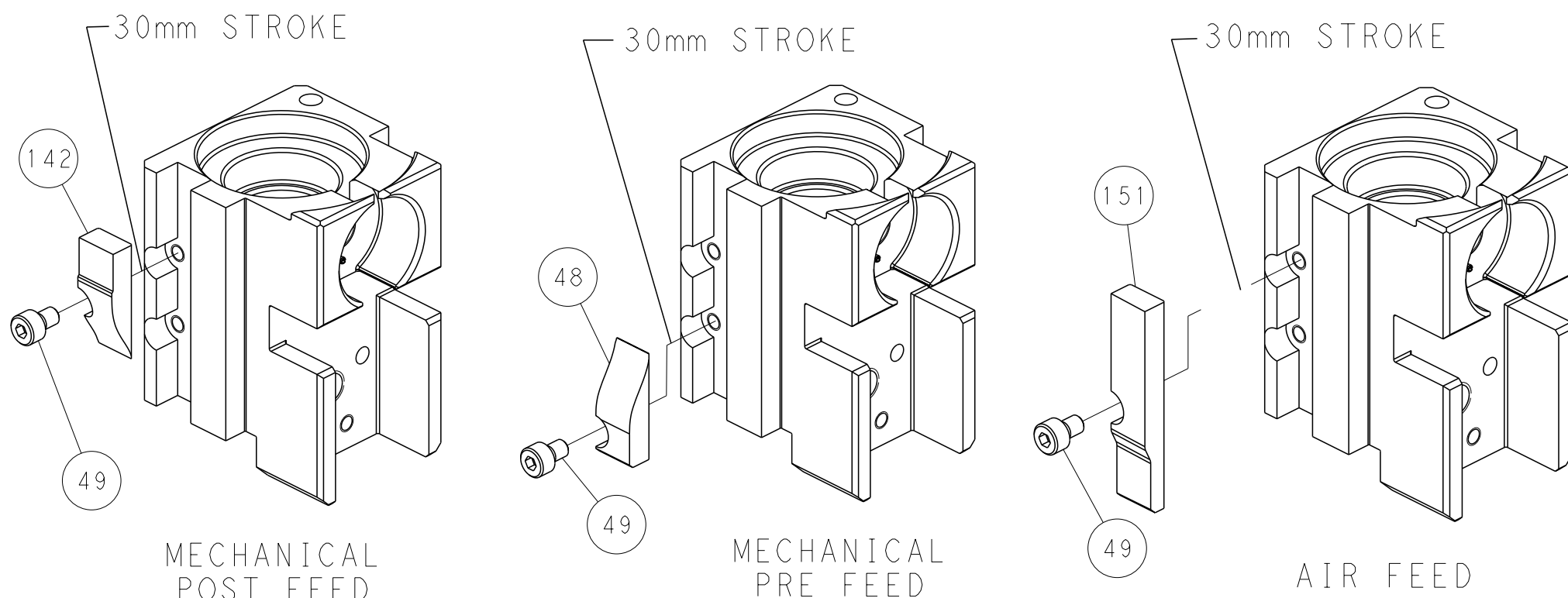
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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		CNY S. XI 28SEP2011		APVD J. CRUZ 28SEP2011		NAME Ocean Side Feed Applicator	
mm		0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001		PRODUCT SPEC		APPLICATION SPEC		SIZE A1		CAGE CODE 00779	
FINISH		-		WEIGHT		-		DRAWING NO C=2151113		RESTRICTED TO	
MATERIAL		-		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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