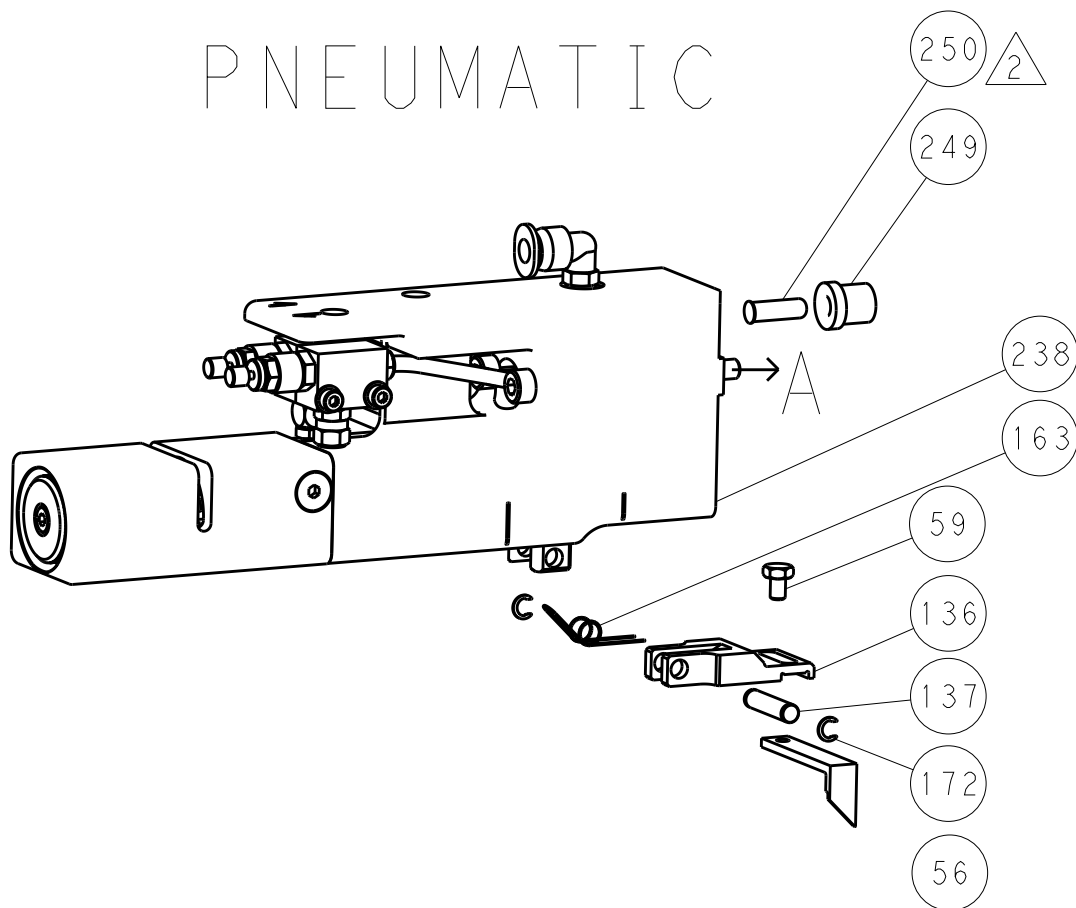


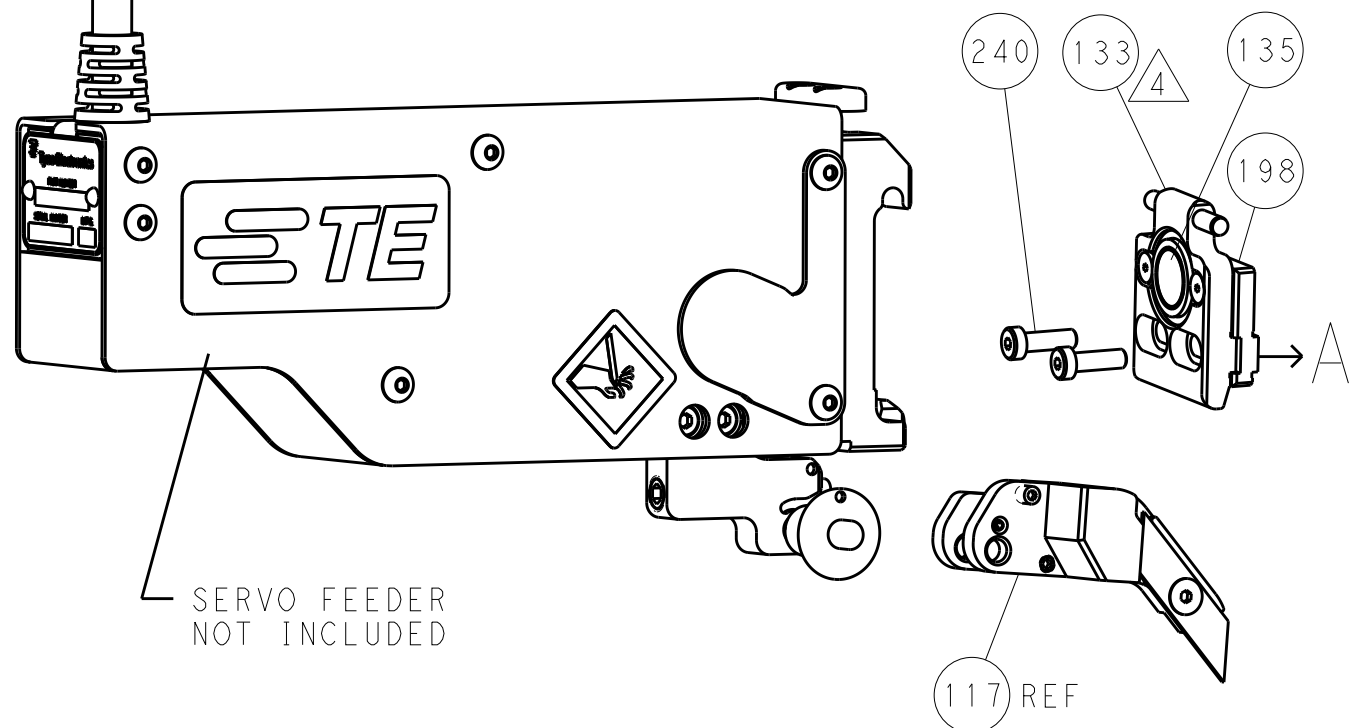
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		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

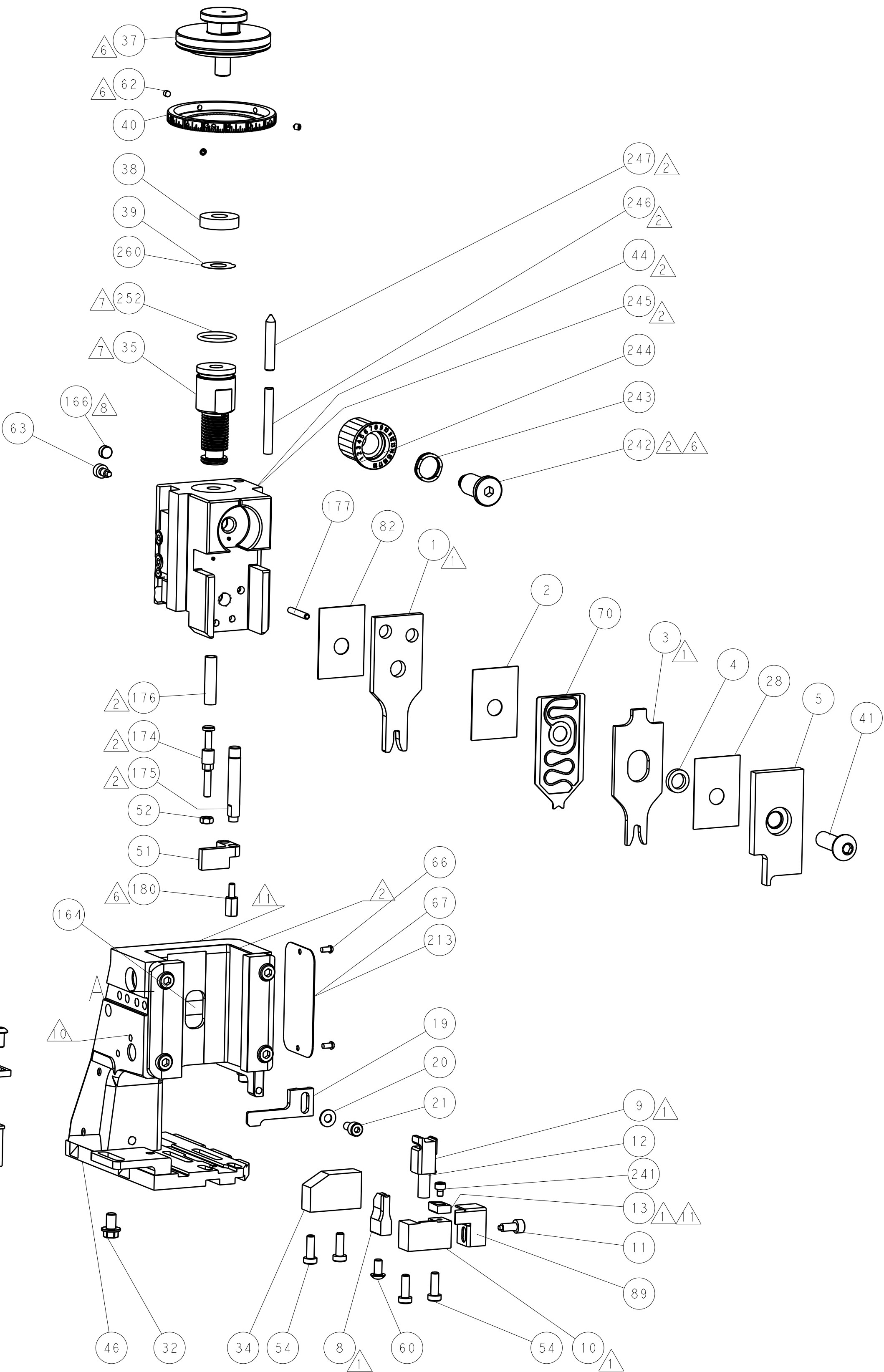
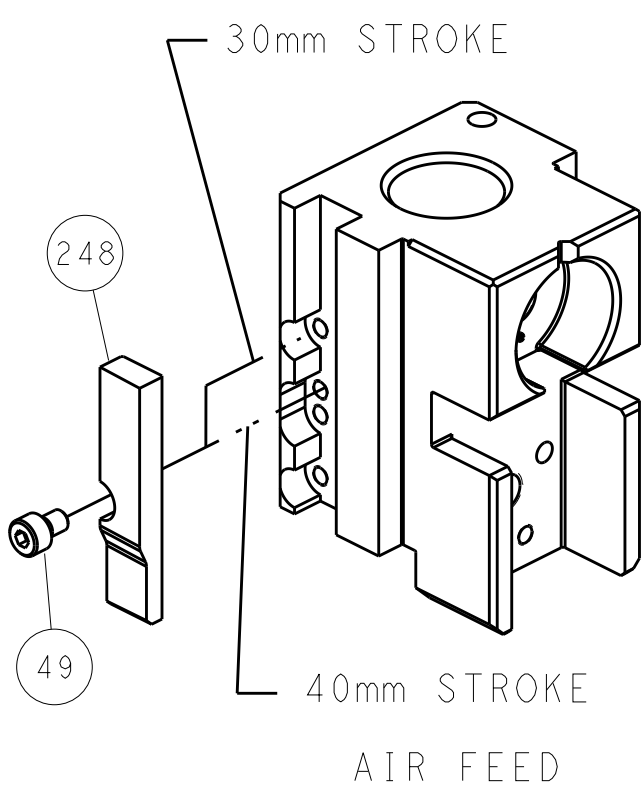
PNEUMATIC



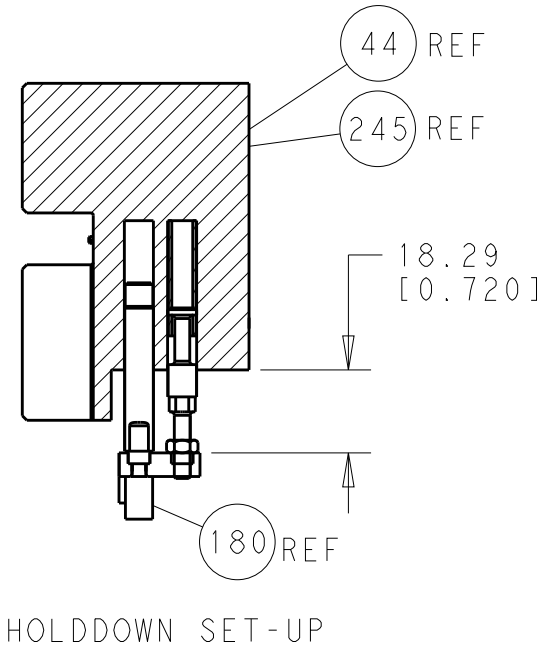
SERVO LATCH PLATE



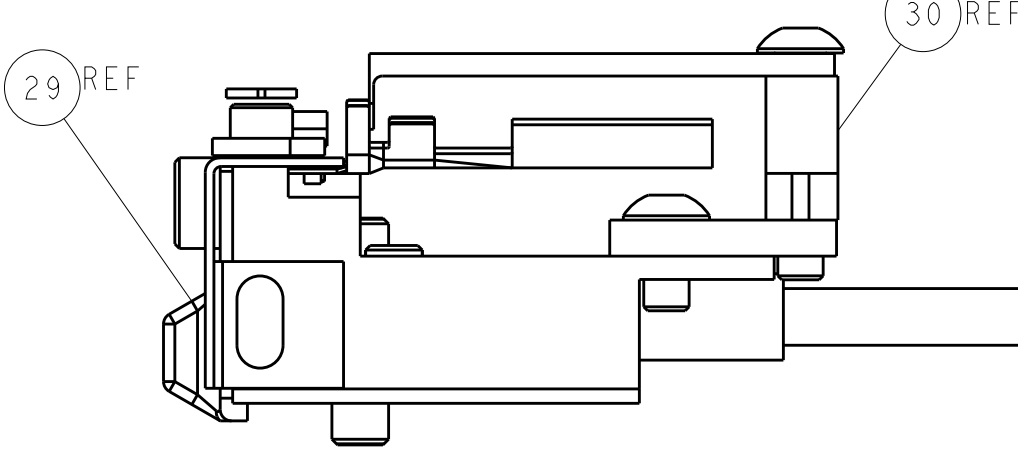
CAM POSITION



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT FRONT HOLES

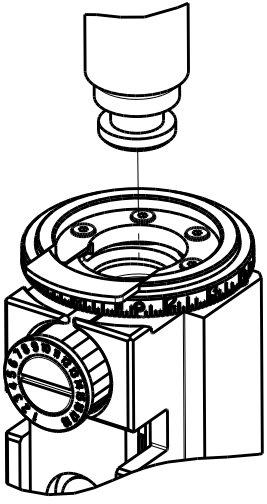


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

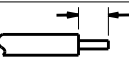
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm		CHK G. BAILEY 13AUG2014	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.1		APVD G. BAILEY 13AUG2014	PRODUCT SPEC APPLICATION SPEC	
MATERIAL -		WEIGHT -	SIZE A1	
FINISH -		Customer Accessible Production Drawing	SCALE 1:2	
		SHEET 2	OF 4	
		REV A		

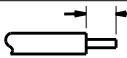
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2151403-2	A	FINE CRIMP HEIGHT ADJUST
	2-2151403-5	A	FINE CRIMP HEIGHT ADJUST
	2-2151403-7	A	FINE CRIMP HEIGHT ADJUST
	7-2151403-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.00 mm [.118]	F
INSUL	3.75 mm [.148]	OV
APPLICATOR INSTRUCTIONS  408-10389		

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: 6.3mm YESC UNSEALED MALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-6.00 mm [.217-.236 IN]		Ø2.20-3.40 mm [.087-.134 IN]	
TERMINAL APPLICATION SPECIFICATION 	YPES-15-599E Rev 01	-	-
TERMINALS APPLIED 	-	-	-
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1949106-1	7114-4121-02	-	-

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
12 AWG OR 3.00mm2		1.80+/-0.05 [.071+/-0.002]		7.5
14 AWG OR 2.00mm2		1.80+/-0.05 [.071+/-0.002]		7.5
16 AWG OR 1.25mm2		1.55+/-0.05 [.061+/-0.002]		9.5
2x18 AWG OR 0.85mm2		1.65+/-0.05 [.065+/-0.002]		9.1
2X20 AWG OR 0.50mm2		1.65+/-0.05 [.065+/-0.002]		9.1

TERMINAL DATA: YAZAKI TERMINAL YAZAKI CRIMP SPECIFICATION			
TERMINAL NAME: 6.3mm YESC UNSEALED FEMALE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.50-6.00 mm [.217-.236 IN]		Ø2.20-3.40 mm [.087-.134 IN]	
TERMINAL APPLICATION SPECIFICATION 	YPES-15-599E Rev 01	-	-
TERMINALS APPLIED 	-	-	-
TE TERMINAL	YAZAKI TERMINAL	TE TERMINAL	YAZAKI TERMINAL
1949107-1	7116-4121-02	-	-

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
12 AWG OR 3.00mm2		1.85+/-0.05 [.073+/-0.002]		7.5
2x 2.50mm2		1.80+/-0.05 [.071+/-0.002]		7.5
14 AWG OR 2.00mm2		1.75+/-0.05 [.069+/-0.002]		8.4
16 AWG OR 1.25mm2		1.65+/-0.05 [.065+/-0.002]		9.1
18 AWG OR 0.85mm2		1.65+/-0.05 [.065+/-0.002]		9.1

*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.



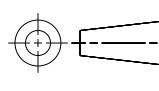
-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151403-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151403-5
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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

-	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
-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)

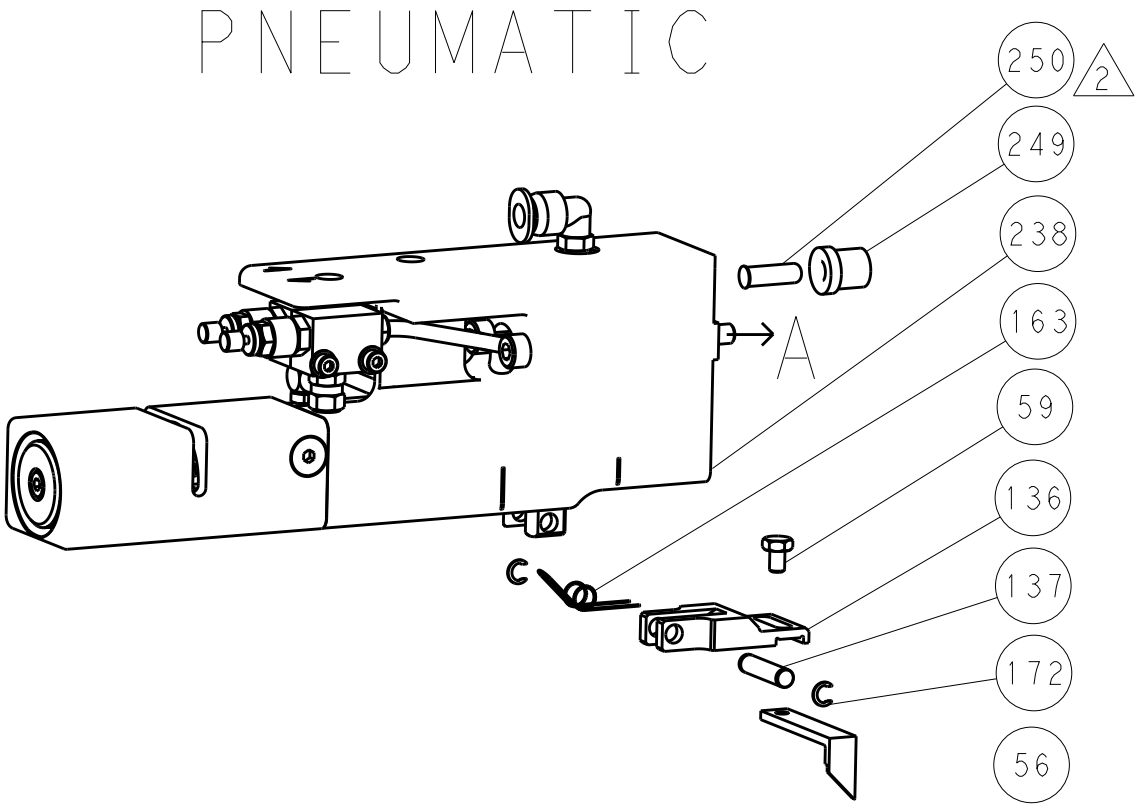
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				-	SEE SHEET 1	-

-	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
 6	-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	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
	-	-	-	2063440-1	AIR FEED MODULE	238
	-	-	1	2119740-2	TAG, IDENTIFICATION	213
 6	-	-	1	1901094-3	SPACER, FEEDER	198
	-	1	1	2-1752354-2	STANDOFF, HOLD-DOWN	180
	-	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	-	240638-1	SPRING, FEED FINGER	163
	-	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152
	-	-	-	2119641-2	FEED CAM, AIR FEED	151
	-	1	1	2119798-2	DETENT PIN	145
	-	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
	-	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
	-	-	-	2119653-2	FEED CAM, POST FEED	142
	-	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
	-	1	1	2119092-2	BOLT, ADJUSTMENT	139
	-	-	-	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
	-	-	REF	2119944-1	FEED FINGER ASSEMBLY, SF	117
	-	1	1	318563-1	GUARD, FRONT CHIP	89
	-	1	1	455888-5	SPACER, CRIMPER	82
	-	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
	-	1	1	1803096-1	EXTENSION PLATE	78
	-	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	-	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
 6	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	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
	-	-	-	1338683-8	FEED PAWL	56
	-	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1901681-9	HOLDDOWN, TERMINAL	51
	-	-	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1-2119644-2	RAM WASHER, PRECISION	38
	-	1	1	1752356-1	SUPPORT, TERMINAL	34
	-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
	-	1	1	1320908-1	SPACER, STRIP GUIDE	30
	-	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
	-	1	1	455888-3	SPACER, CRIMPER	28
	-	1	1	1320928-4	STRIP GUIDE	24
	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
 1	-	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1-356885-4	STOP, SHEAR	11
 1	-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
 1	-	1	1	454276-5	FLOATING SHEAR, FRONT	9
 1	1	1	1	1-1803056-8	ANVIL, COMBINATION	8
	-	-	-	-	-	7
	-	-	-	-	-	6
	-	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	238011-4	BLOCK, CRIMPER SPACER	4
 1	1	1	1	2-1633963-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	1	455888-5	SPACER, CRIMPER	2
 1	1	1	1	5-1633305-9	CRIMPER, WIRE PREMIUM	1
-77-27	-25	-22	PART NO	DESCRIPTION	ITEM NO	

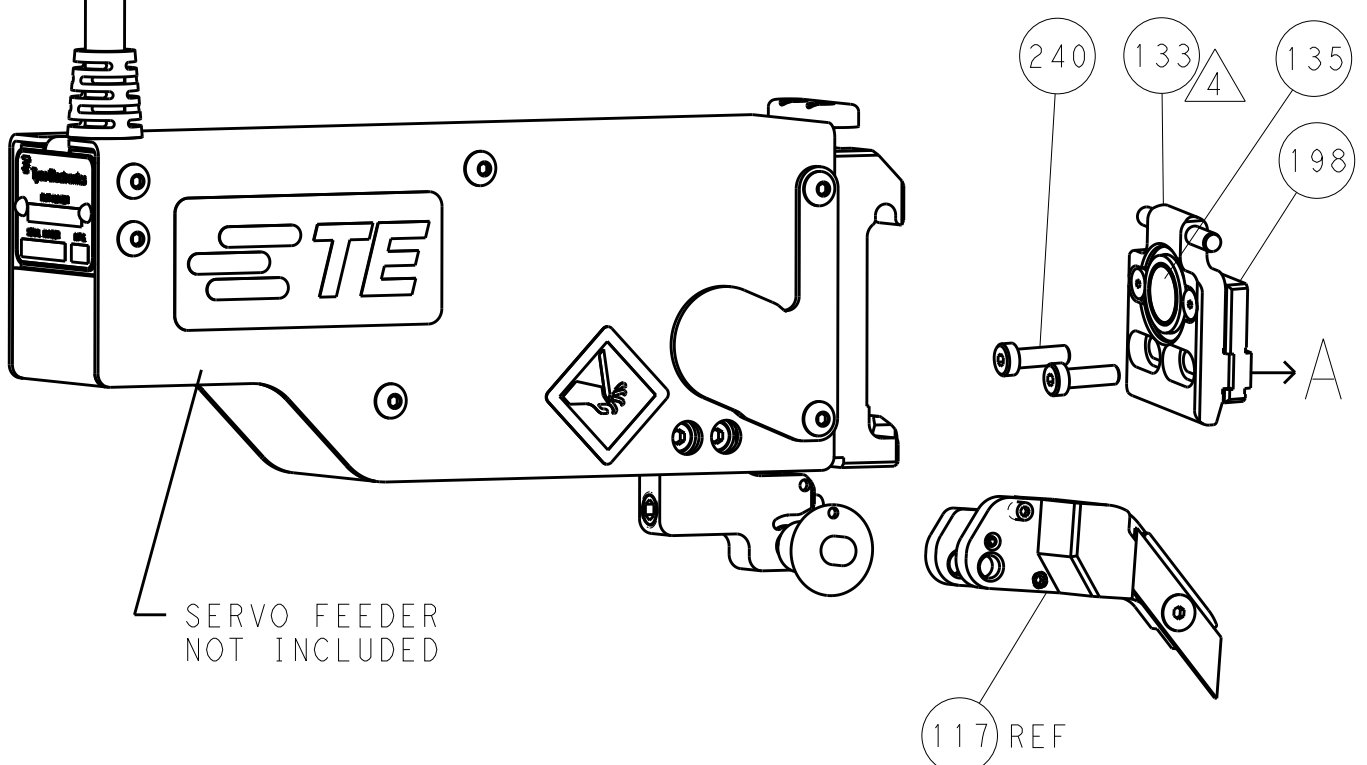
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DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	NAME		Ocean Side Feed Applicator	
mm	0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5	PRODUCT SPEC		SIZE	
		APPLICATION SPEC		CAGE CODE DRAWING NO	
MATERIAL	FINISH	WEIGHT		A1 00779 ©=2151403	
Customer Accessible Production Drawing		SCALE		1:2 SHEET 3 OF 4 REV A	

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

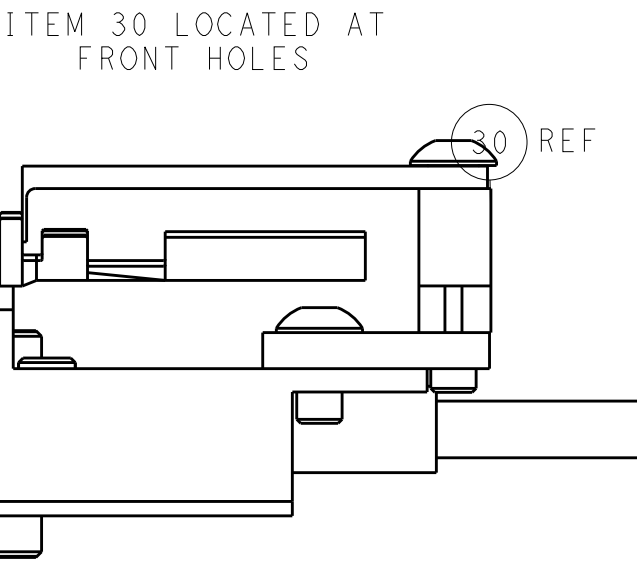
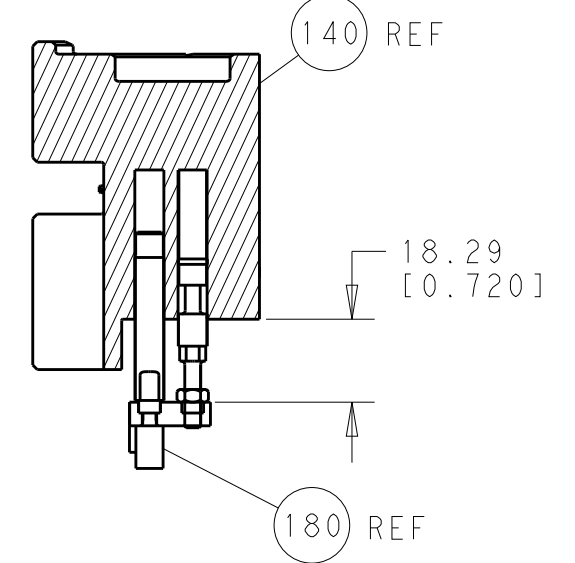
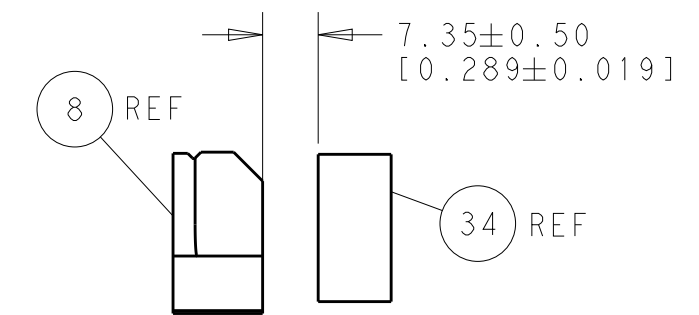
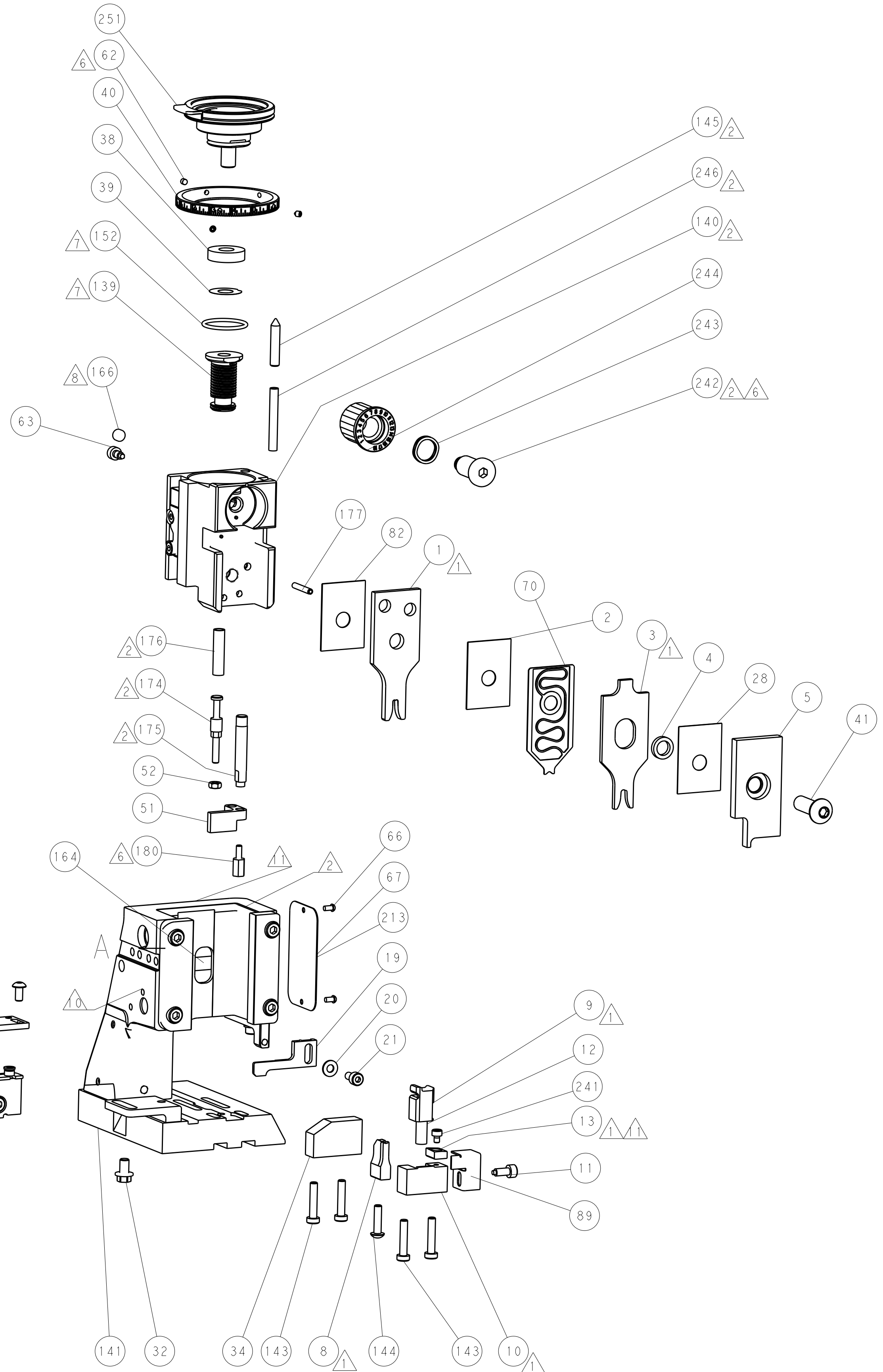
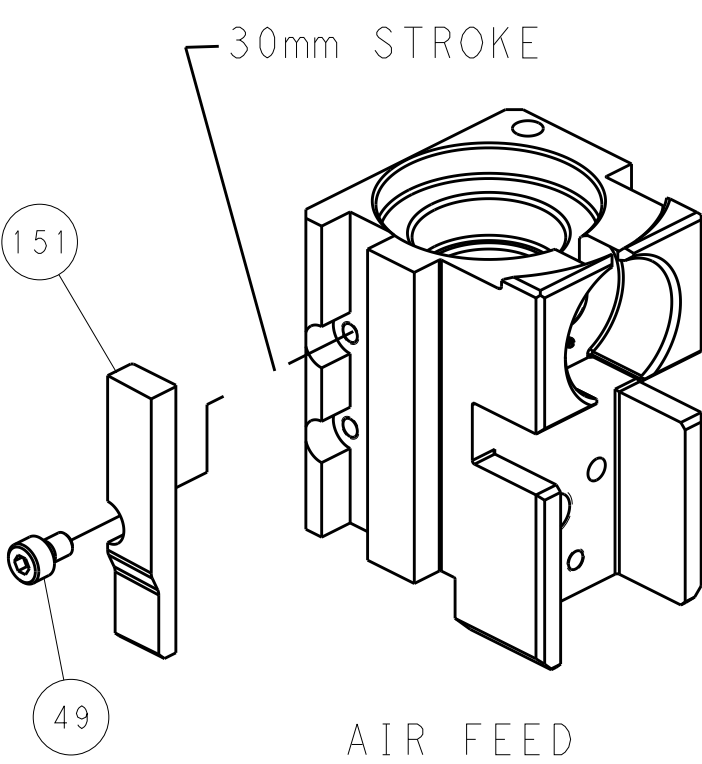
FEED TYPE
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITION



PACIFIC VERSION
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(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:				NAME: Ocean Side Feed Applicator			
mm				0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001				SIZE: A1			
MATERIAL:				FINISH:				CAGE CODE: 00779			
								DRAWING NO: 2151403			
								RESTRICTED TO: -			
								Customer Accessible Production Drawing			
								SCALE: 1:2			
								SHEET: 4 OF 4			
								REV: A			