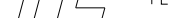


1. RECOMMENDED SPARE PARTS
2. GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
4. APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151247-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151247-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151247-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151247-6
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.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM
7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
8. MAGNET, ITEM 166 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.
11. 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.
12. WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT
13. NOMINAL WIRE SIZES SHOWN. FOR SPECIFIC WIRE SIZES SEE APPLICATION SPECIFICATION.

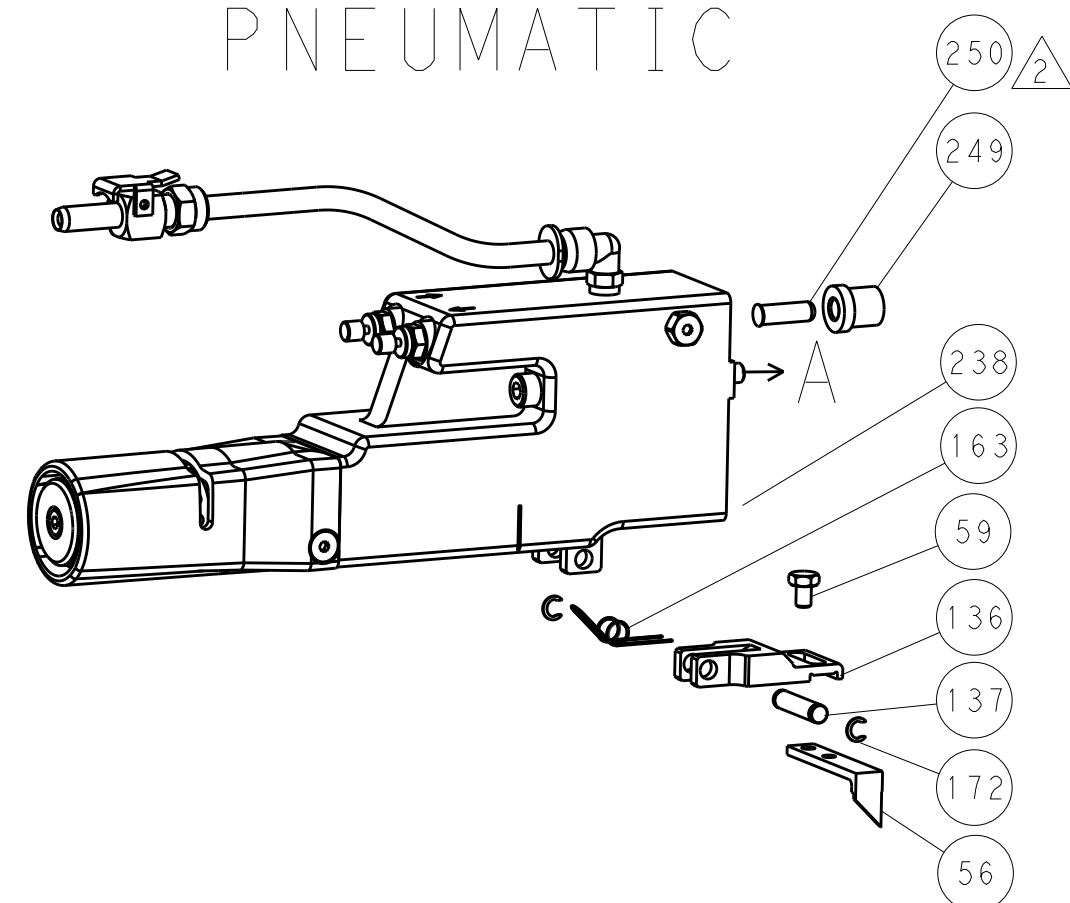
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

	-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244	
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
6	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241	
	-	-	2	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	1	-	2119740-2	TAG, IDENTIFICATION	213	
	-	-	1	1	-	1901094-3	SPACER, FEEDER	198	
	-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
	-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174		
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
-	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	
-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	-	-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	-	REF	REF	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135	
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133	
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	-	REF	REF	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
-	1	1	1	1	1	455888-3	SPACER, CRIMPER	82	
-	1	1	1	1	1	22278-8	SPRING, COMPRESSION	77	
-	1	1	1	1	1	854769-4	HOLDER, INS	74	
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
6	-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
	-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
	-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
	-	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	-	-	-	1	1	1338685-1	PAWL, FEED	56
	-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
	-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
	-	1	1	1	1	1	1-1752354-5	STANDOFF, HOLD-DOWN	50
-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48	
-	-	-	-	-	1	2119653-1	FEED CAM, POST FEED	47	
-	1	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44	
-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39	
6	-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
	-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
	-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	1	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
	-	1	1	1	1	1	1320908-6	SPACER, STRIP GUIDE	30
	-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	1	455888-3	SPACER, CRIMPER	28
	-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
1	-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	1	1633861-1	SHEAR, FLOATING	9
	1	1	1	1	1	1	5-1333201-0	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7	
	-	-	-	-	-	-	-	6	
	-	1	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1-1803019-4	CRIMPER, INSULATION O	3	
	-	-	-	-	-	-	-	2	
	1	1	1	1	1	1	3-1333281-2	CRIMPER, WIRE PREMIUM	1
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

(1) IF DIMENSION IS CONTAINED WITHIN DIMENSIONAL TOLERANCE SPECIFICATION, THE DIMENSIONAL TOLERANCE OF EACH FEATURE SHALL BE CONTROLLED TO THE TOLERANCE SPECIFIED. DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0.150 mm ±0.13 0.250 mm ±0.13 0.375 mm ±0.13 0.500 mm ±0.0001 ANGLES: ±1°		DWN 23NOV2011 CHK S.Xi 23NOV2011 APPV CRUZ 23NOV2011 PRODUCT SPEC APPLICATION SPEC		 TE Connectivity Harrisburg, PA 17105-3608	
				NAME Ocean Side Feed Applicator -			
MATERIAL -		FINISH -		WEIGHT -		SIZE CAGE CODE DRAWING NO A 00779 C=2151247	
				Customer Accessible Production		SCALE 1:2 SHEET 1 OF 4 REV A	

PNEUMATIC



LATCH PLATE

SERVO FEEDER
NOT INCLUDED

240 133 135 198 4

117 REF

30mm STROKE

47

49

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

48

49

40mm STROKE

MECHANICAL PRE FEED

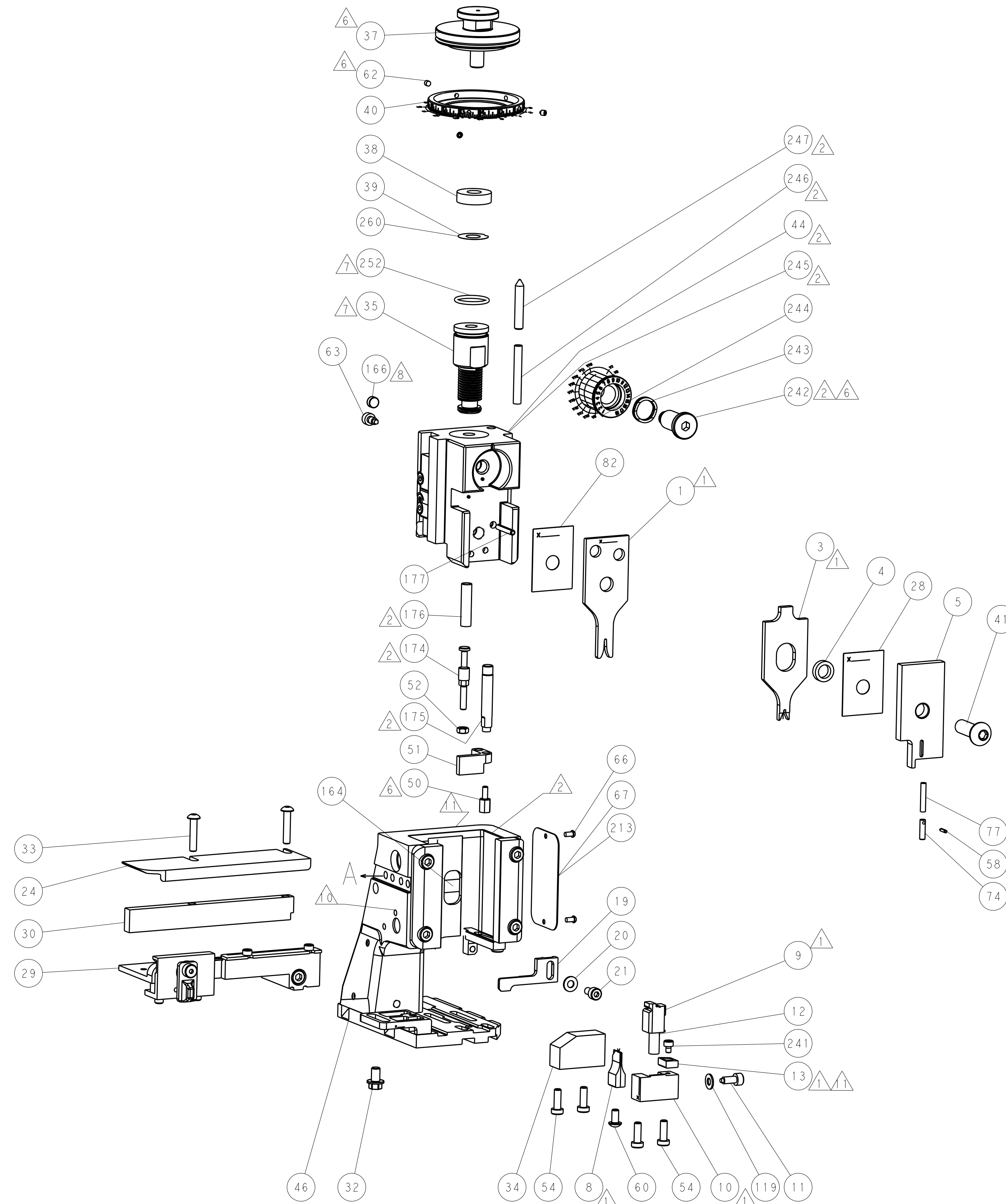
30mm STROKE

248

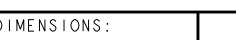
49

40mm STROKE

AIR FEED



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 VETO ENGINEERING CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION MUST BE KEPT ADVISED OF ANY CHANGES TO THIS DRAWING		DWN 23NOV2011 CHK K HUANG 23NOV2011 DES X.XI APPV L.CRUZ 23NOV2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.0 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
MATERIAL -		FINISH -		RESTRICTED TO -	
WEIGHT -		A1 00779 C=2151247		SCALE 1:2 SHEET 2 OF 4 REV A1	
Customer Accessible Production Drawing					

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

D

C

B

A

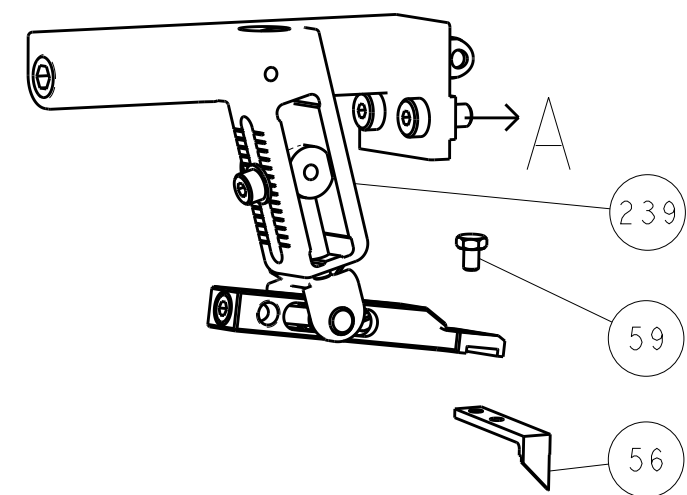
D

C

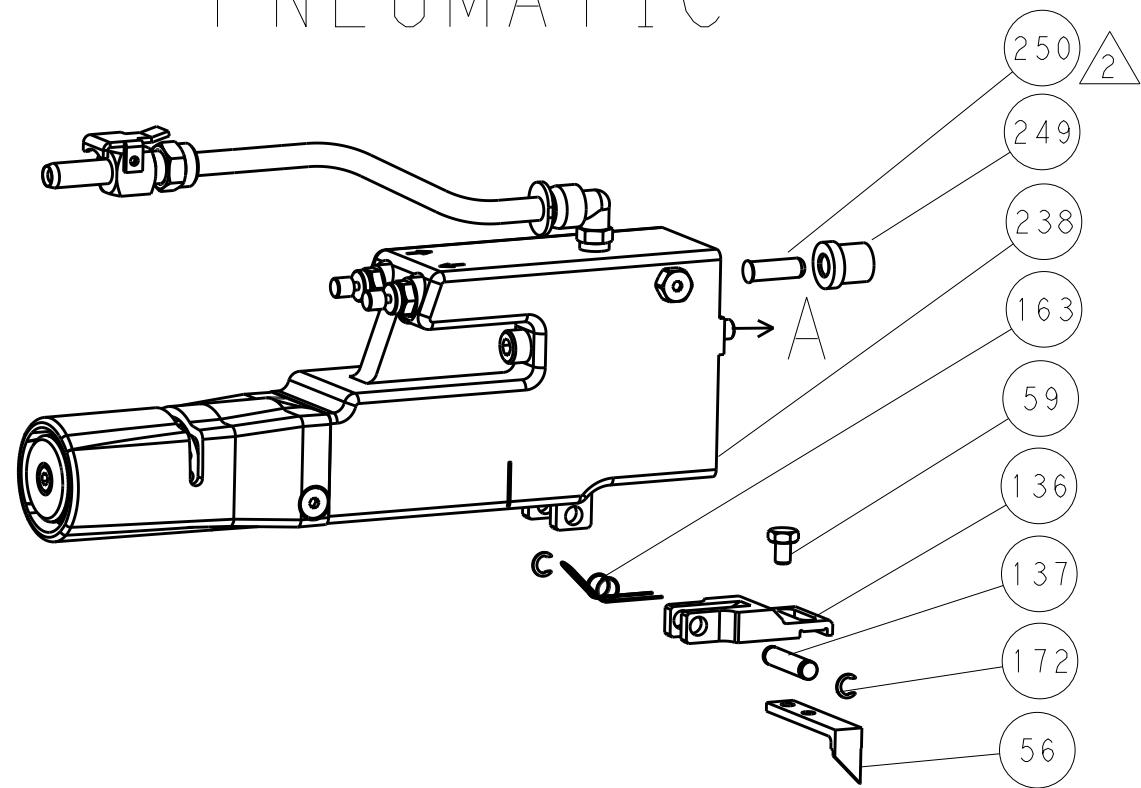
B

A

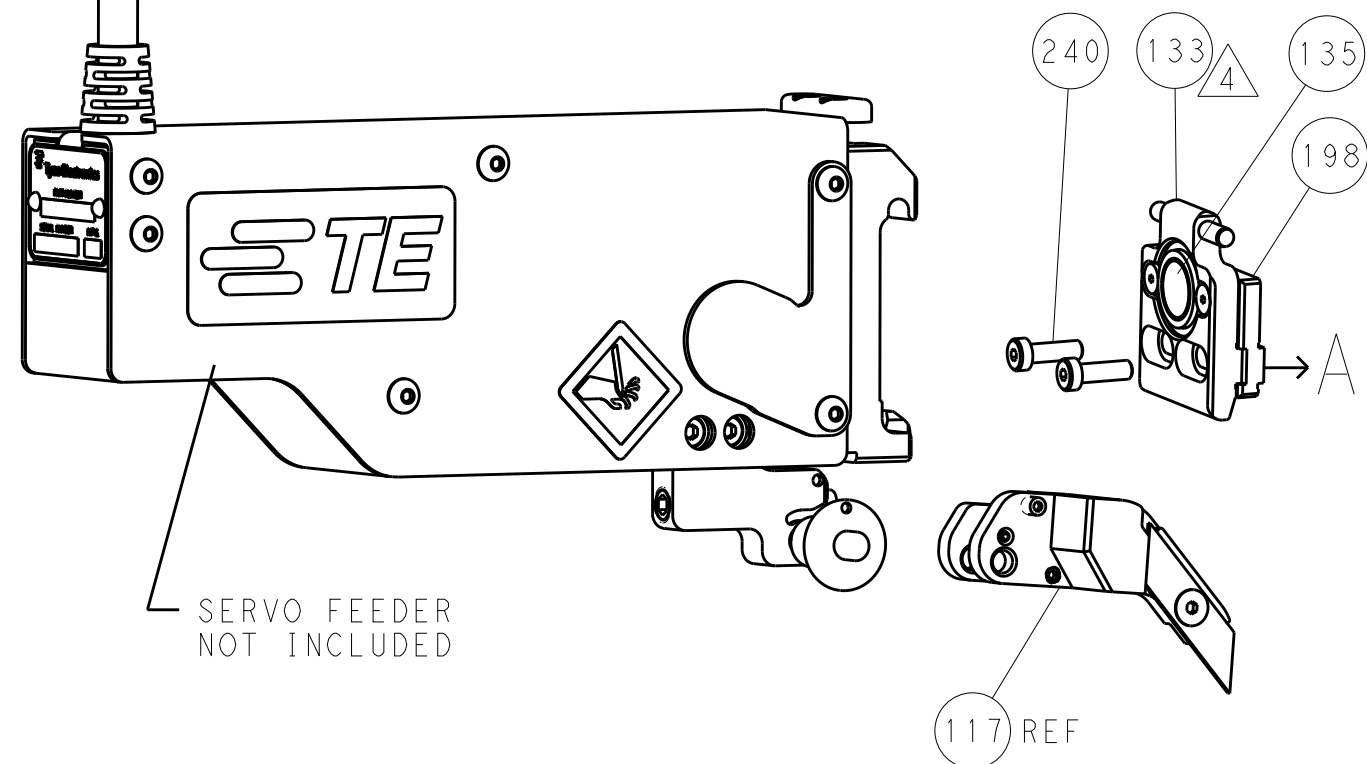
FEED TYPE MECHANICAL



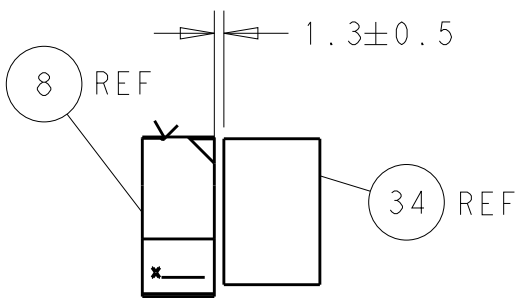
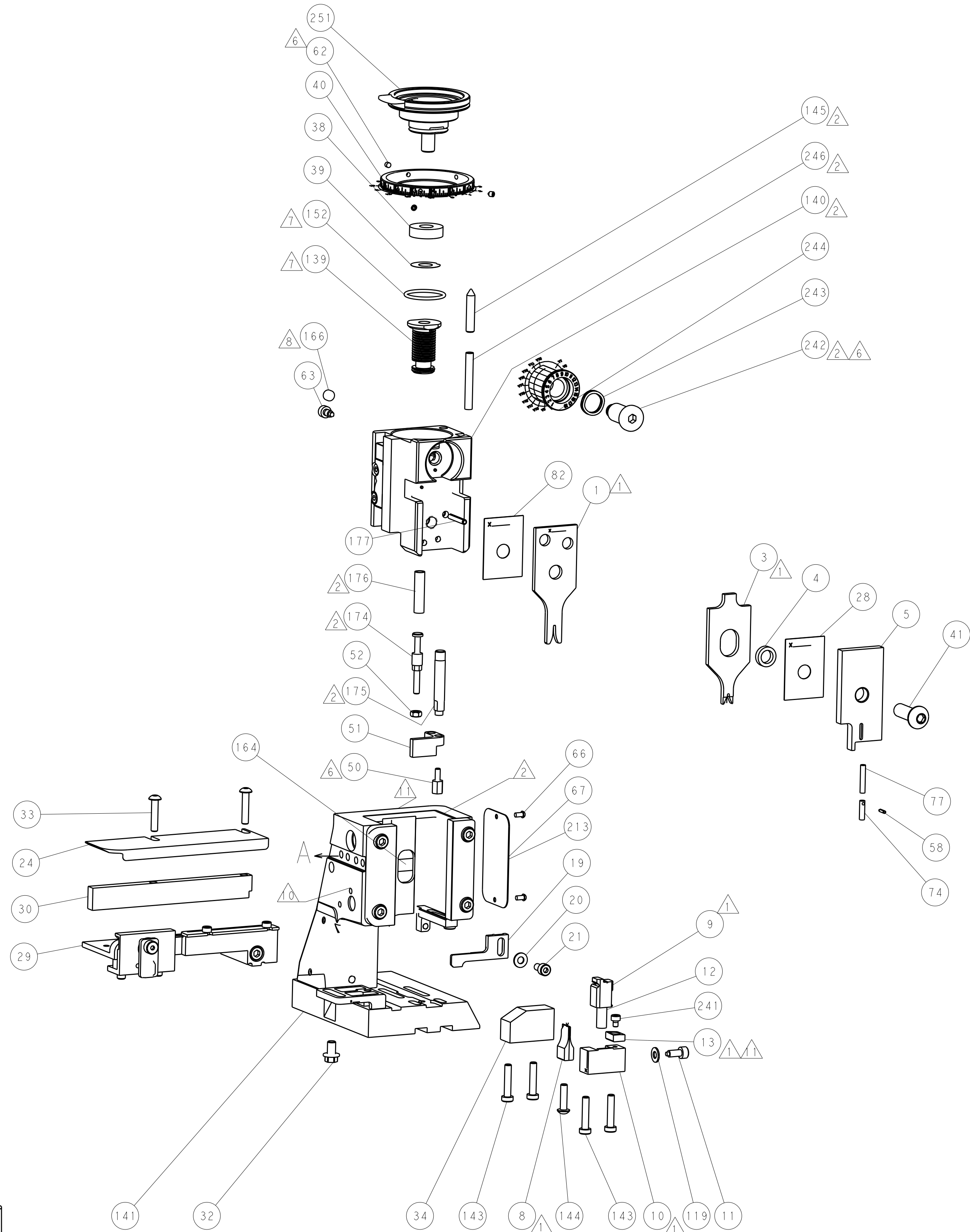
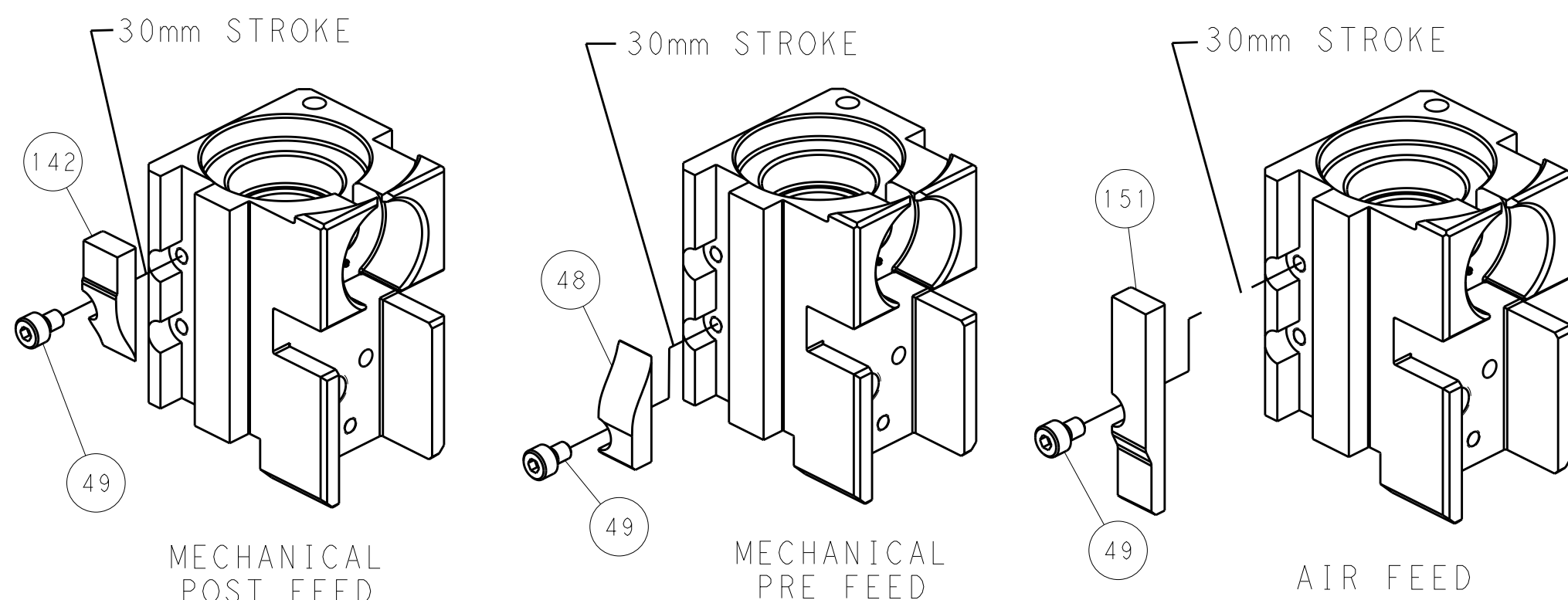
PNEUMATIC



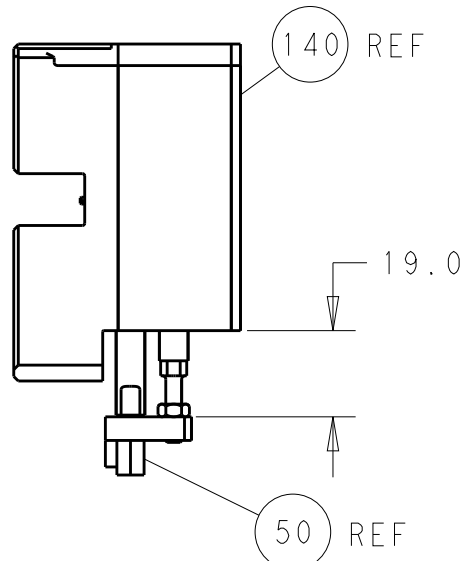
SERVO LATCH PLATE



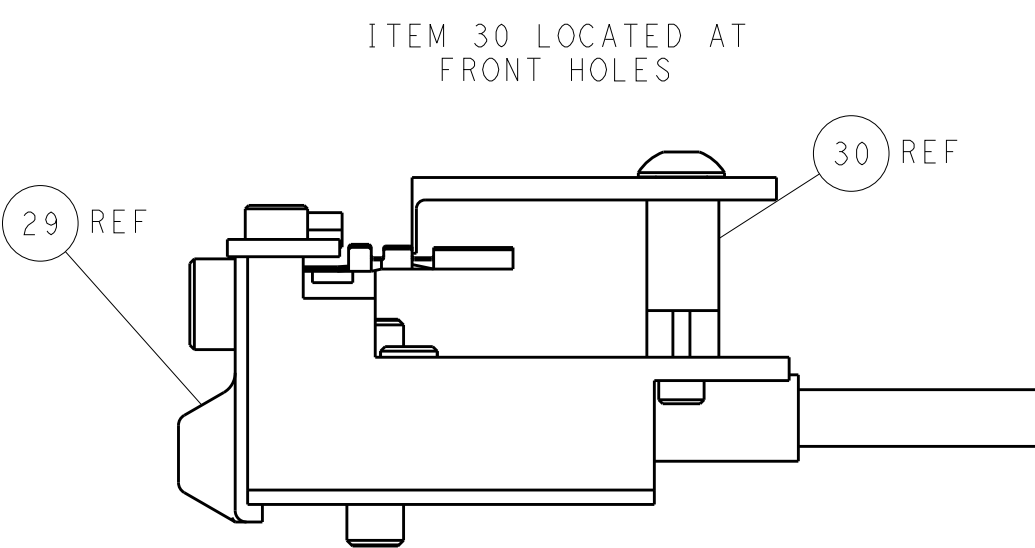
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY WIRE BARREL

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

1. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN K. HUANG 23NOV2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK S. XI 23NOV2011		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		APVD J. CRUZ 23NOV2011	NAME Ocean Side Feed Applicator	
MATERIAL		PRODUCT SPEC	SIZE A1	
		APPLICATION SPEC	CAGE CODE 00779	
		WEIGHT	DRAWING NO 2151247	
		FINISH	RESTRICTED TO Customer Accessible Production Drawing	
			SCALE 1:2	
			SHEET 4	
			OF 4	
			REV A1	