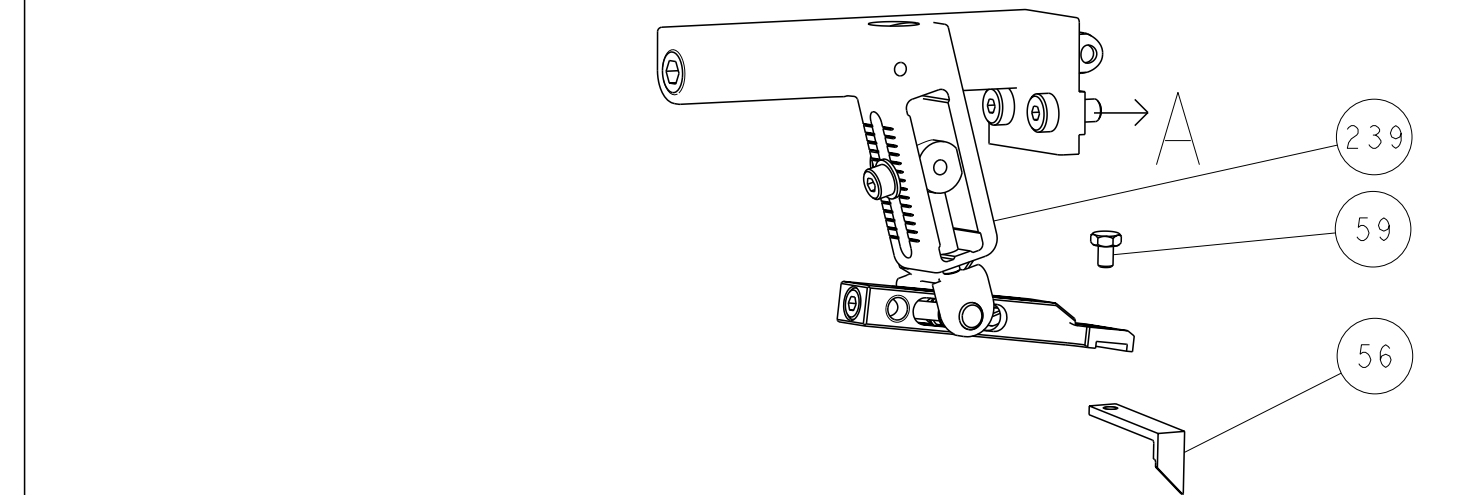
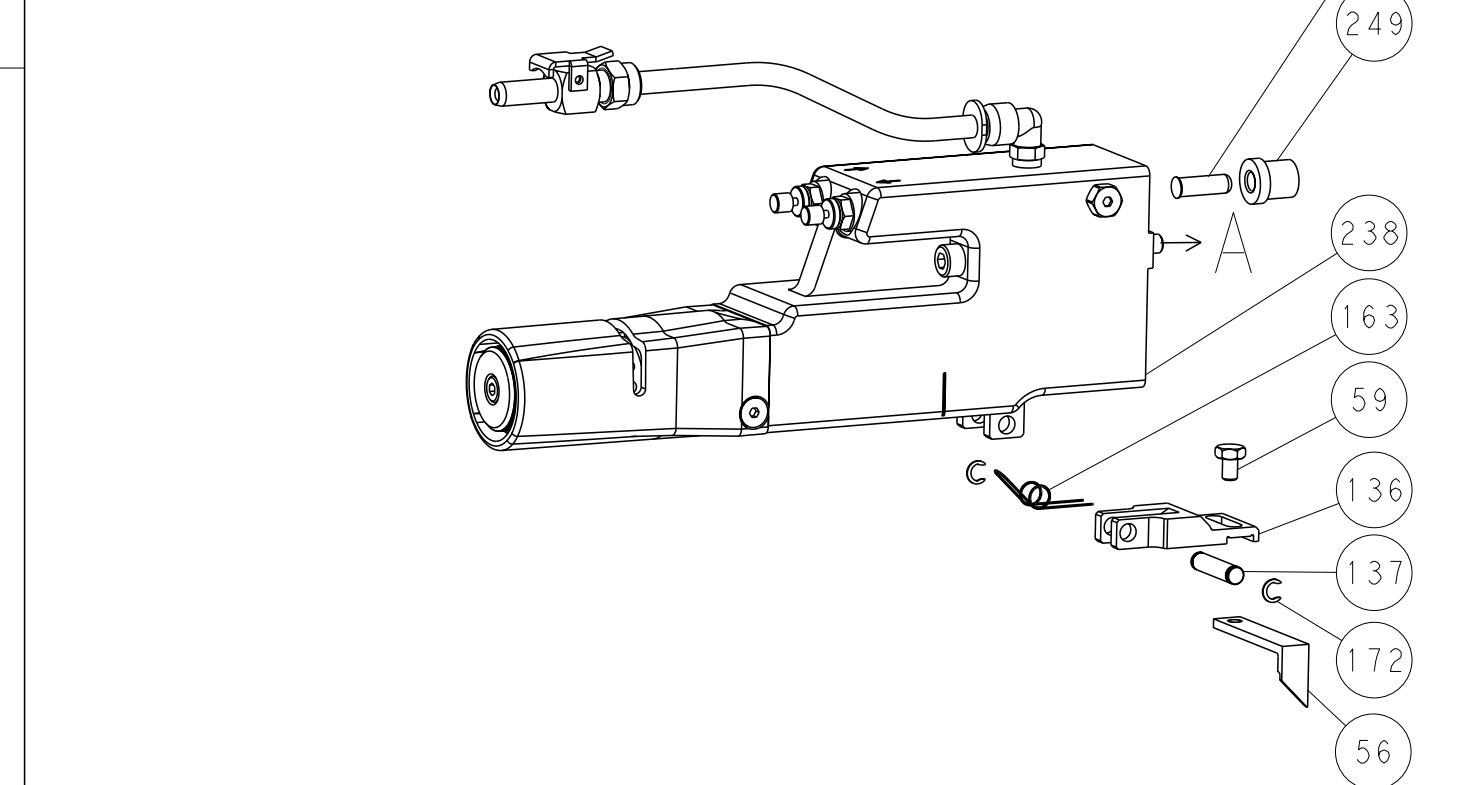


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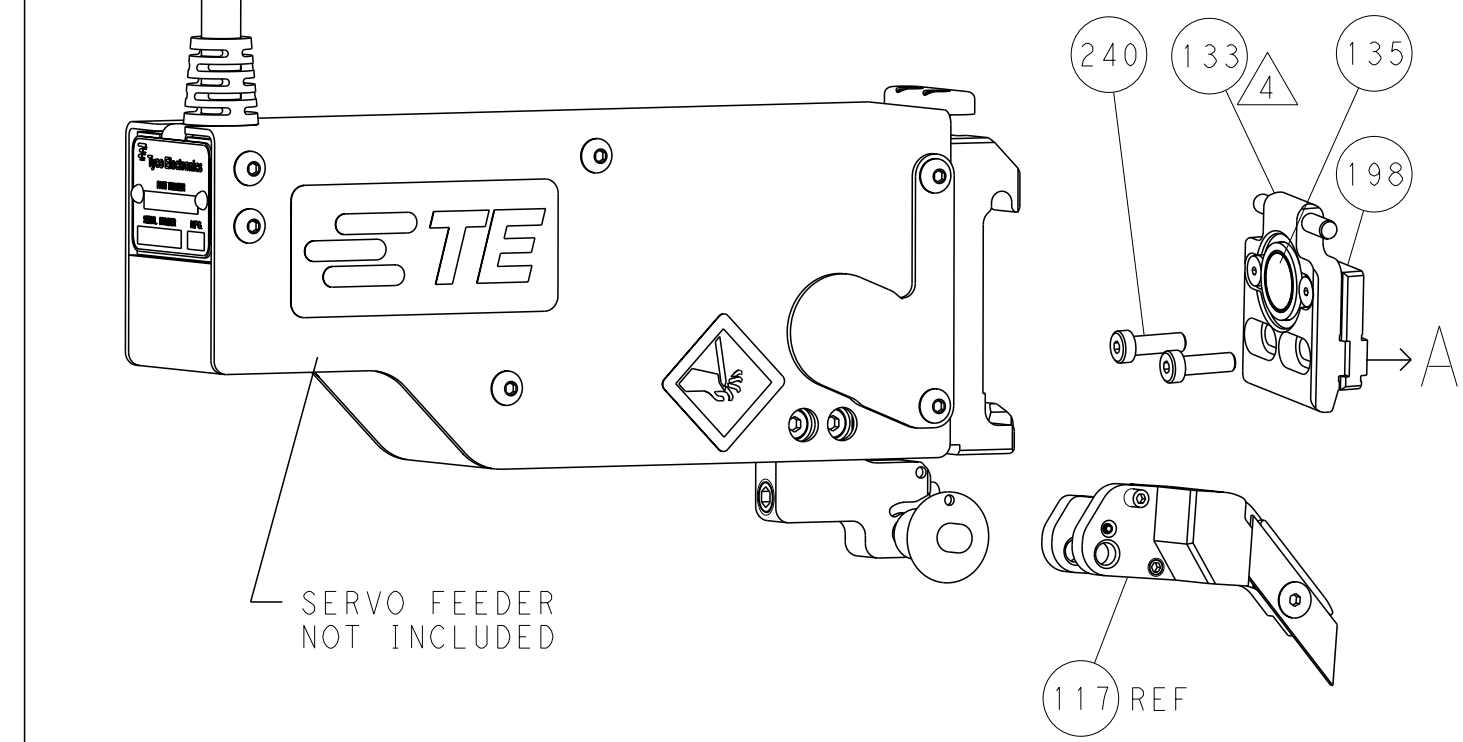
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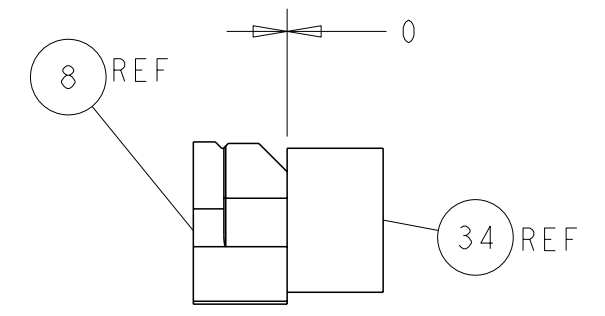
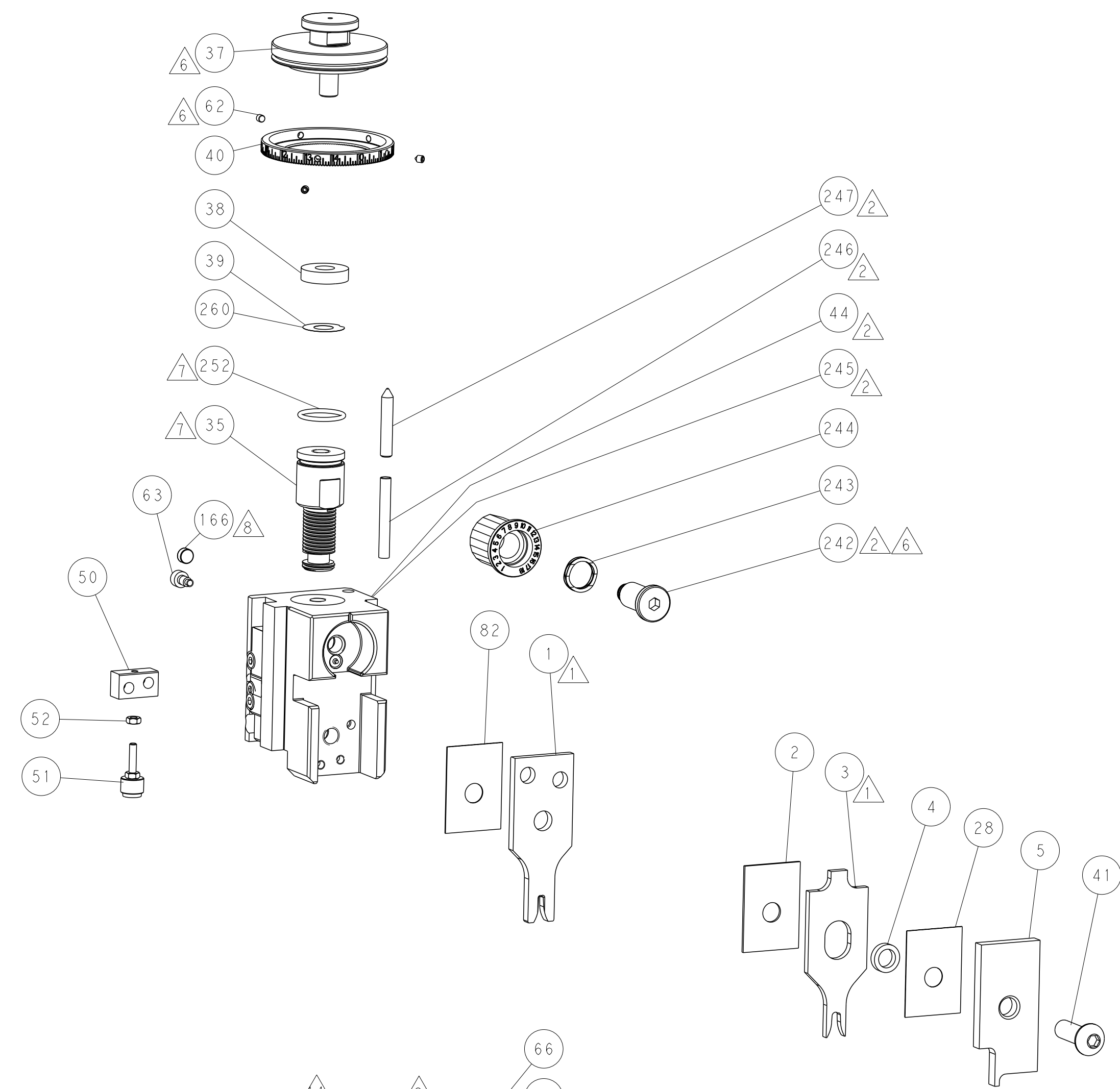
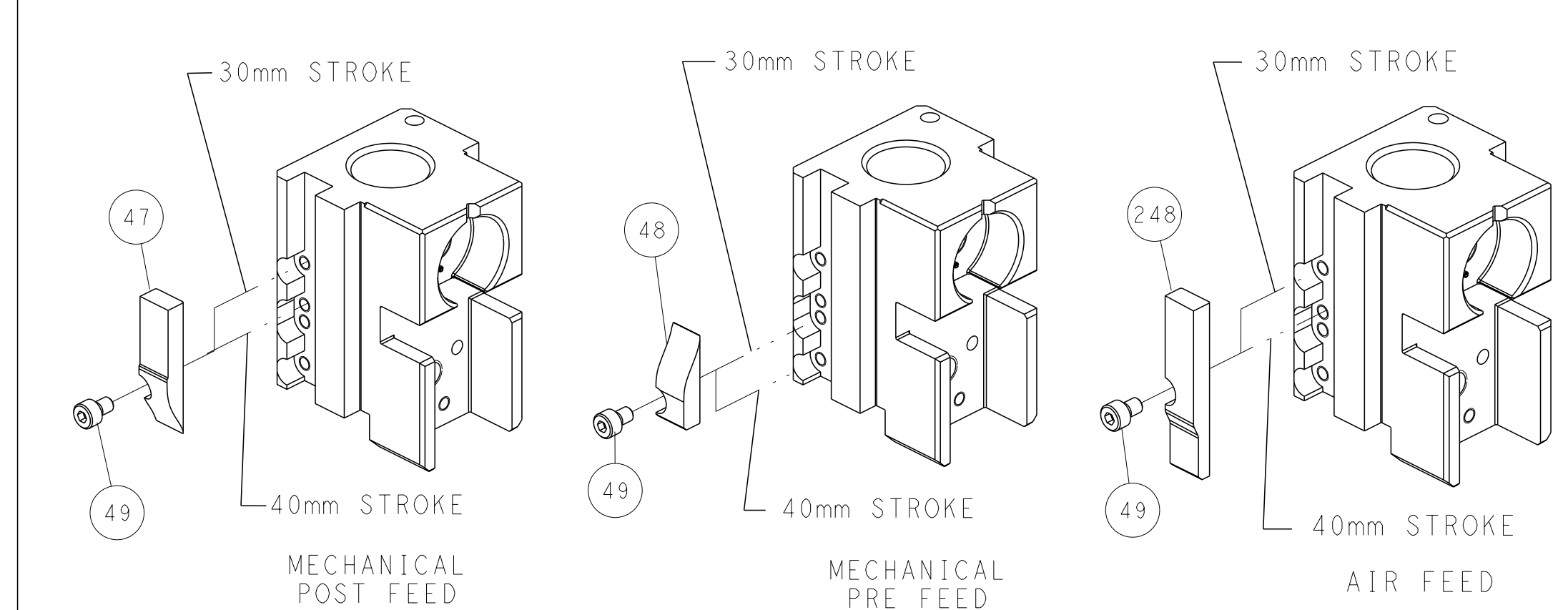
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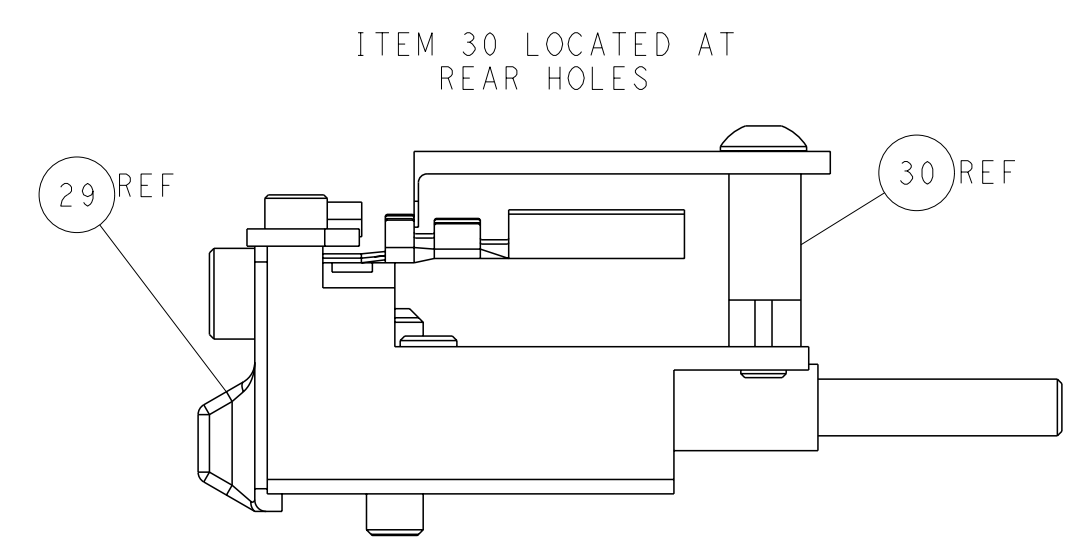
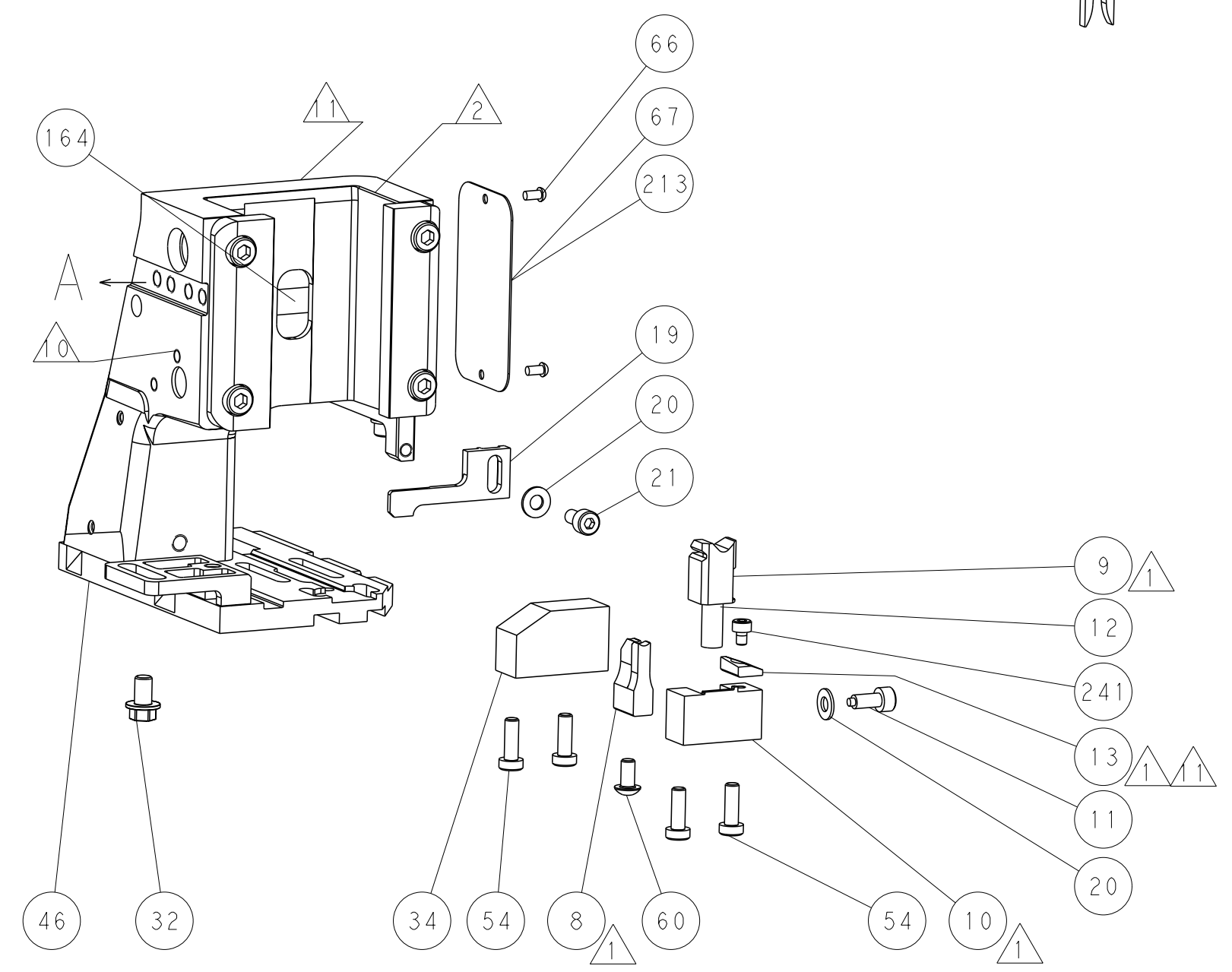
SERVO LATCH PLATE



CAM POSITIONS



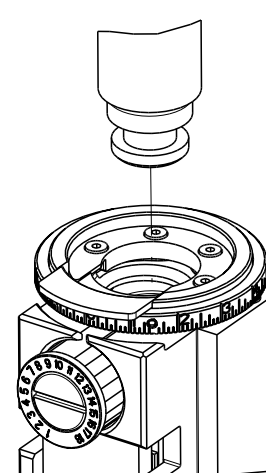
TERMINAL SUPPORT LOCATION



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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		CHK	L. ZHANG	28OCT2015		
		APVD	U. GUO	28OCT2015	NAME	
		PRODUCT SPEC			Ocean Side Feed Applicator	
		APPLICATION SPEC				
		WEIGHT			SIZE	
					A1 00779	
		Customer Accessible Production Drawing			SCALE	
					1:2	
					SHEET	
					2 of 4	
					REV	
					B	

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						
		2-2266637-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-2	2119799-1	2063440-1	
						SERVO LATCH PLATE	2119951-1	-	8-2266637-5	1901094-3	-	2168400-6 (QUANTITY 2)	
						SMART APPLICATOR	2161326-1	-	8-2266637-4	-	-	-	
		2-2266637-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-2	-	-	
						SERVO LATCH PLATE	2119951-1	-	8-2266637-5	1901094-3	-	2168400-6 (QUANTITY 2)	
						SMART APPLICATOR	2161326-1	-	8-2266637-4	-	-	-	
		2-2266637-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-2	-	-	
						PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-2	2119799-1	2063440-1	
		2-2266637-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
		7-2266637-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	4.06 mm [.160]	OV
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE		TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, FUSE CONTACT					
WIRE STRIP LENGTH				INSULATION DIAMETER RANGE	
4.80-5.60 mm [.189-.220 IN]				Ø2.00-3.00 mm [.079-.118 IN]	
TERMINAL APPLICATION 		114-37000 Rev B		-	
SPECIFICATION		-		-	
TERMINALS APPLIED					
TE TERMINAL		TE TERMINAL		TE TERMINAL	
880397-2					

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.50mm2			1.78+/- 0.05 [.070+/- .002]		7.5
1.00mm2			1.60+/- 0.05 [.063+/- .002]		8.8
0.75mm2			1.50+/- 0.05 [.059+/- .002]		9.8
0.50mm2			1.40+/- 0.05 [.055+/- .002]		10.8

```
*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. 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: 8-2266637-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266637-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266637-5
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 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.
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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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	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	1-22279-3	SPRING, COMPRESSION	246
	-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
6	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	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	-	-	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
8	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
7	-	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	2119798-2	DEENT PIN	145
	-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
	-	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	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
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
	-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
	-	1	1	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	-	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
6	-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 x 4.0	62
	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	-	1	1	1338683-8	FEED PAWL	56
	-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
	-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	1	690753-2	SPACER, TONKER	50
	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	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
	-	1	1	1	1	2119644-2	RAM WASHER, PRECISION	38
	-	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
	-	1	1	1	1	1-1320908-2	SPACER, STRIP GUIDE	30
	-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-3	SPACER, CRIMPER	28
	-	1	1	1	1	1320928-6	STRIP GUIDE	24
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20
1	-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	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	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	1	1	1	1	2-1633921-3	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	4-2119785-3	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	1	1	1	455888-9	SPACER, CRIMPER	2
1	1	1	1	1	1	7-456406-3	CRIMPER, WIRE PREMIUM	1

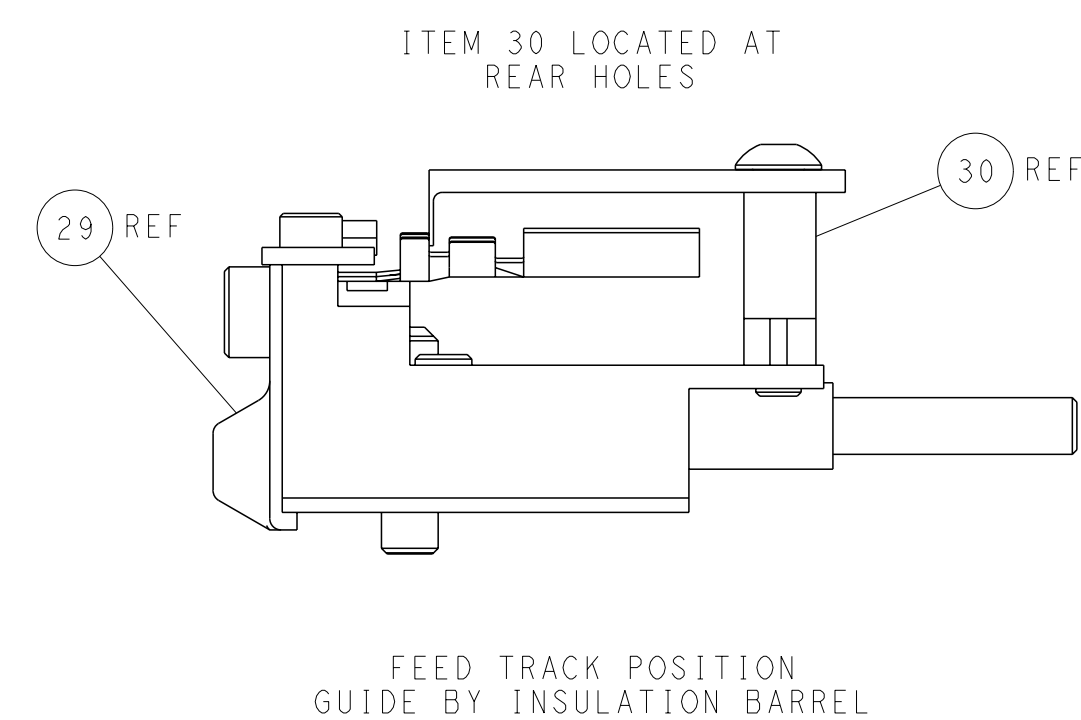
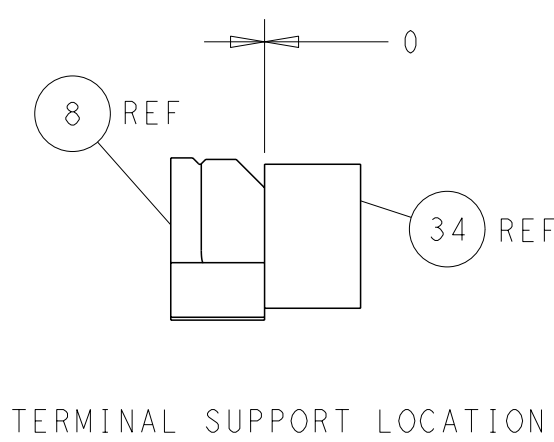
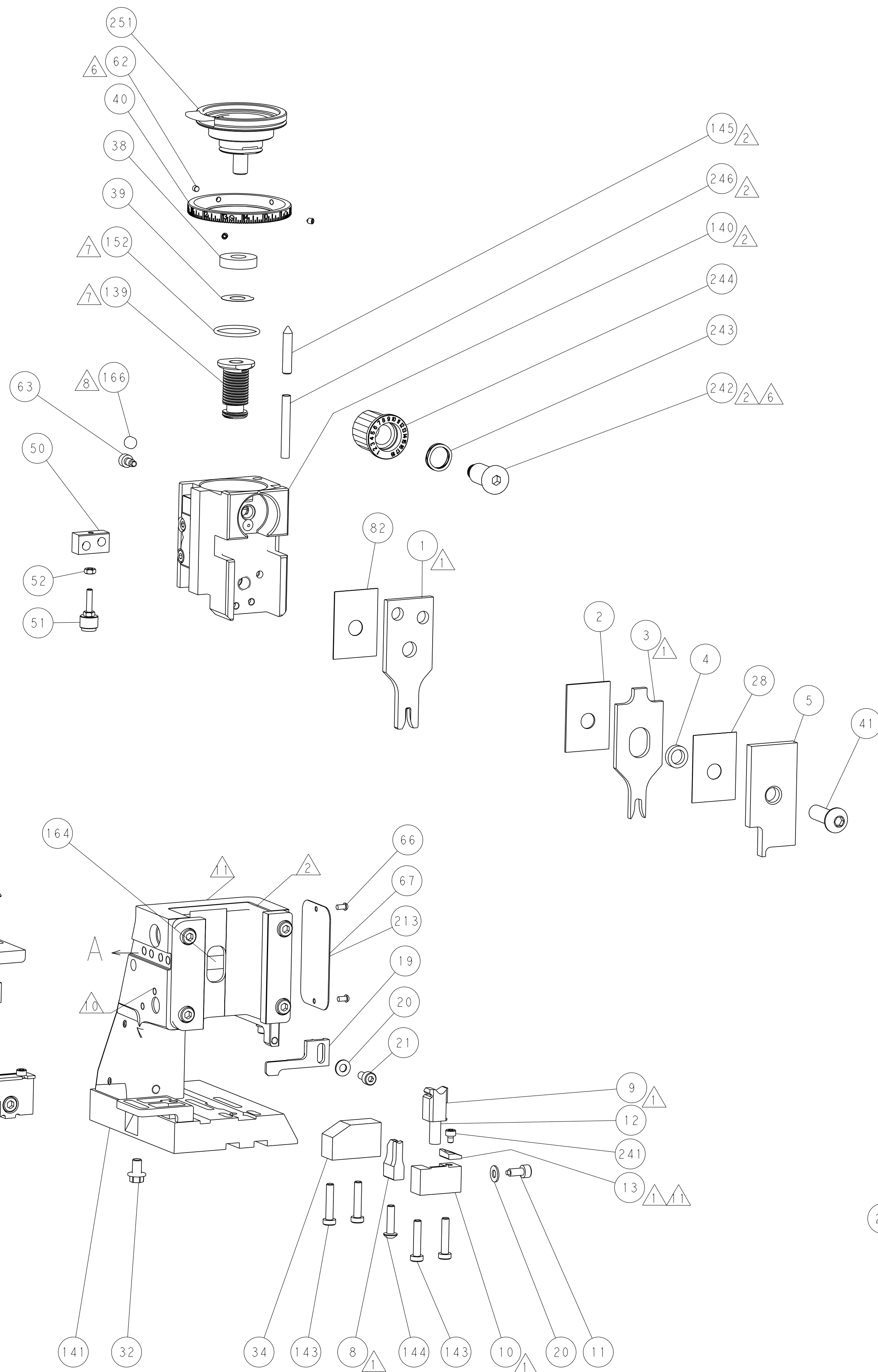
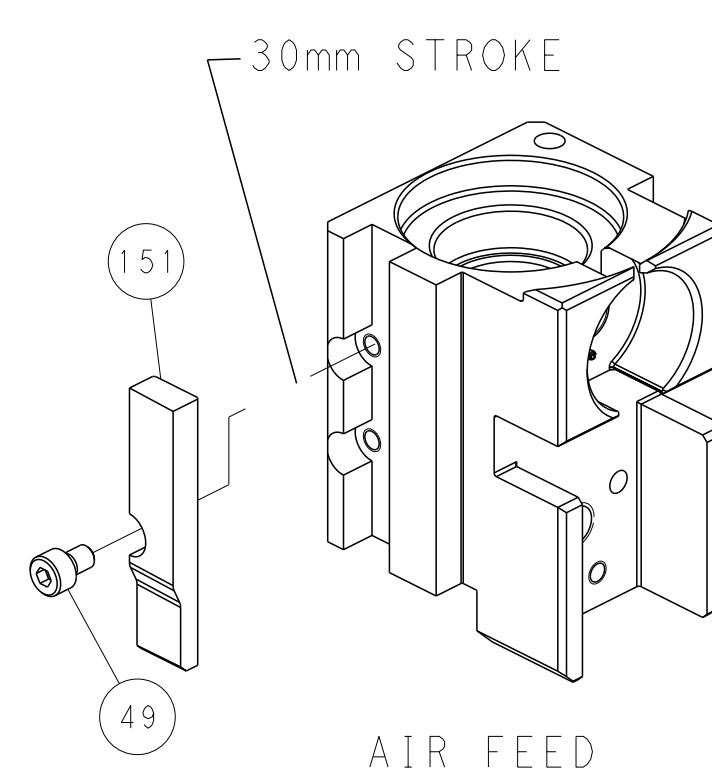
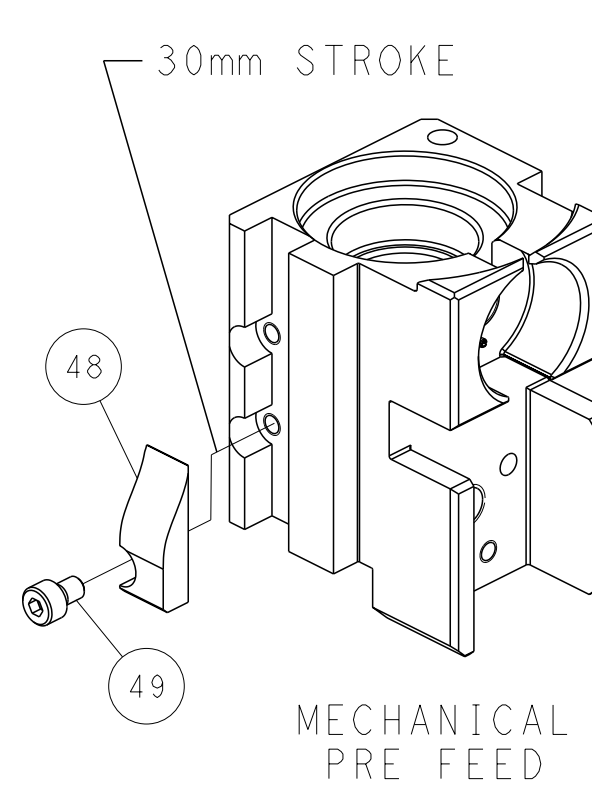
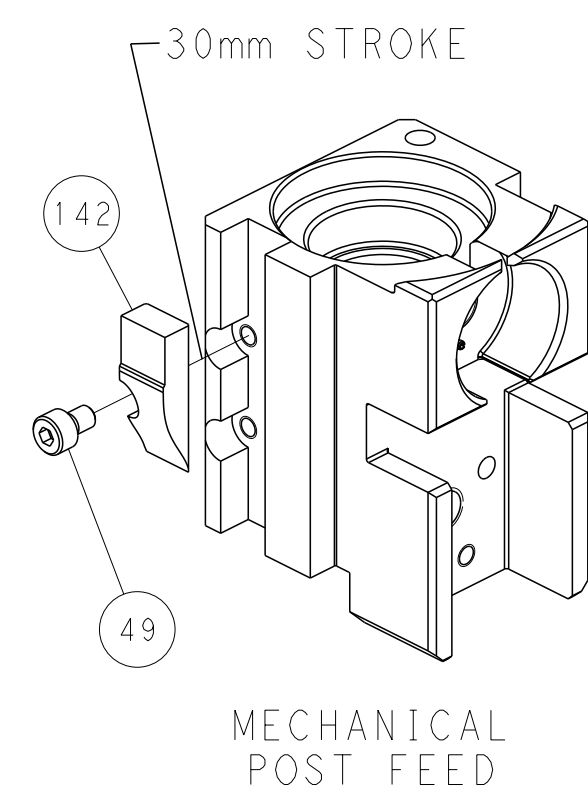
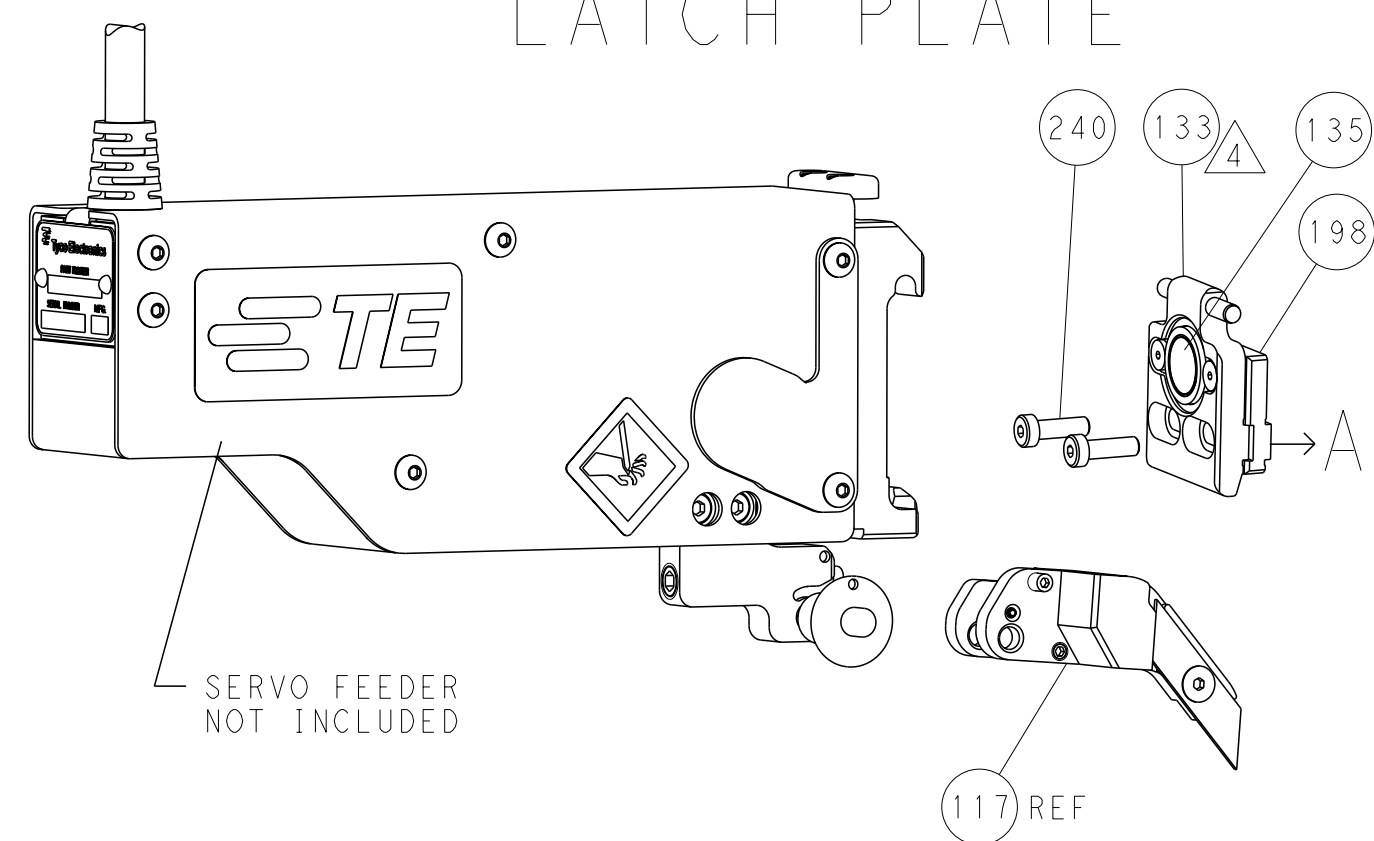
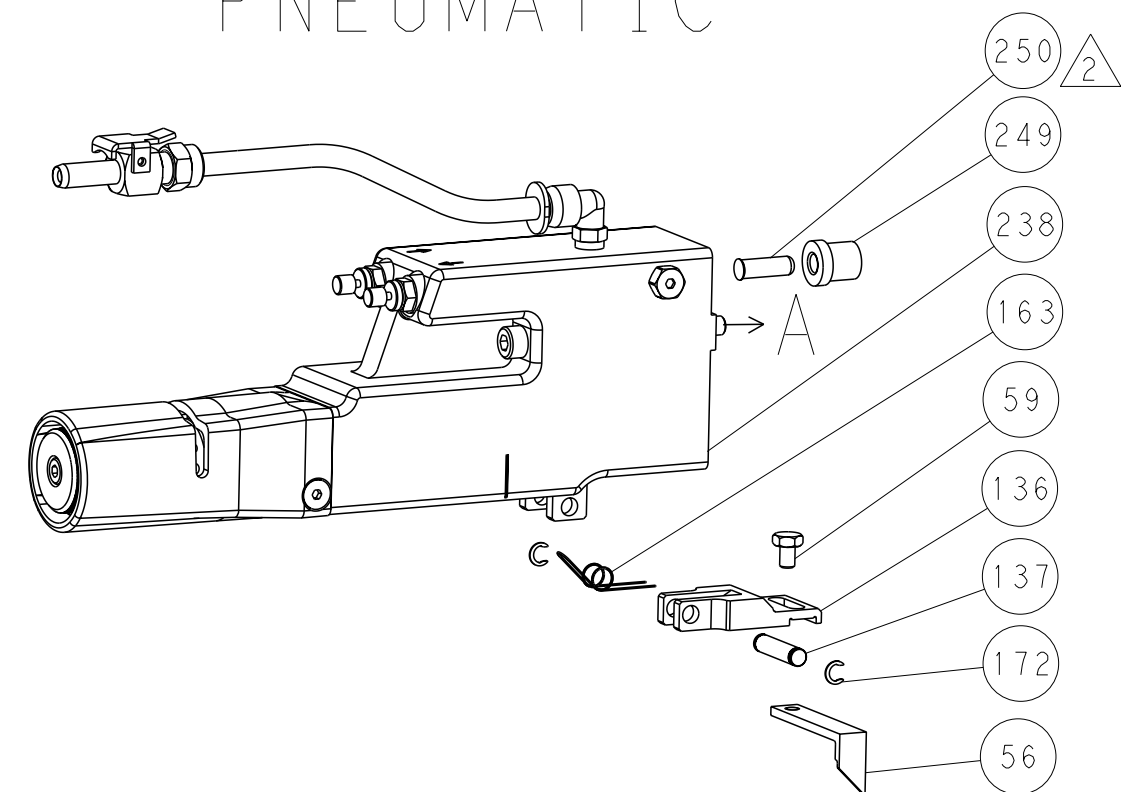
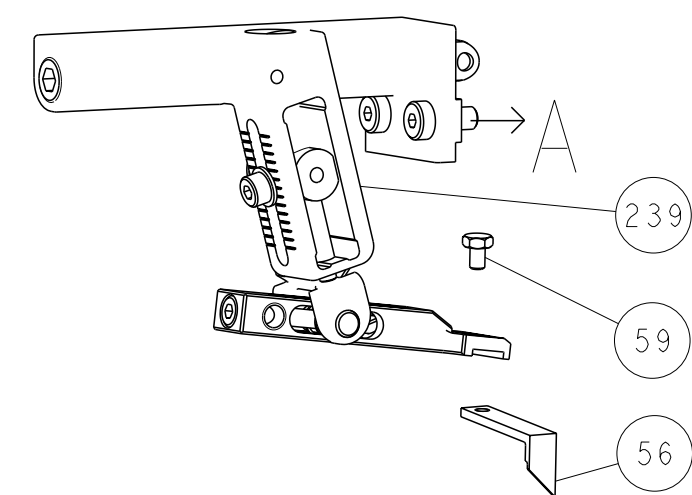
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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:								CHK L. ZHANG 280C1201S		NAME	
mm										APP'D H. GUO 280C1201S		Ocean Side Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±								PRODUCT SPEC -		-	
										APPLICATION SPEC		-	
MATERIAL		FINISH								WEIGHT		SIZE A 00779 C=2266637	
-		-								-		RESTRICTED TO -	
Customer Accessible Production Drawing										SCALE 1:2		SHEET 3 OF 4	
										REV B			

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

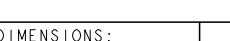
PNEUMATIC

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)

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DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator -	
MATERIAL -		FINISH -		WEIGHT -	
		SIZE A1		CAGE CODE 00779	
		DRAWING NO C=2266637		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 4 OF 4 REV B	