

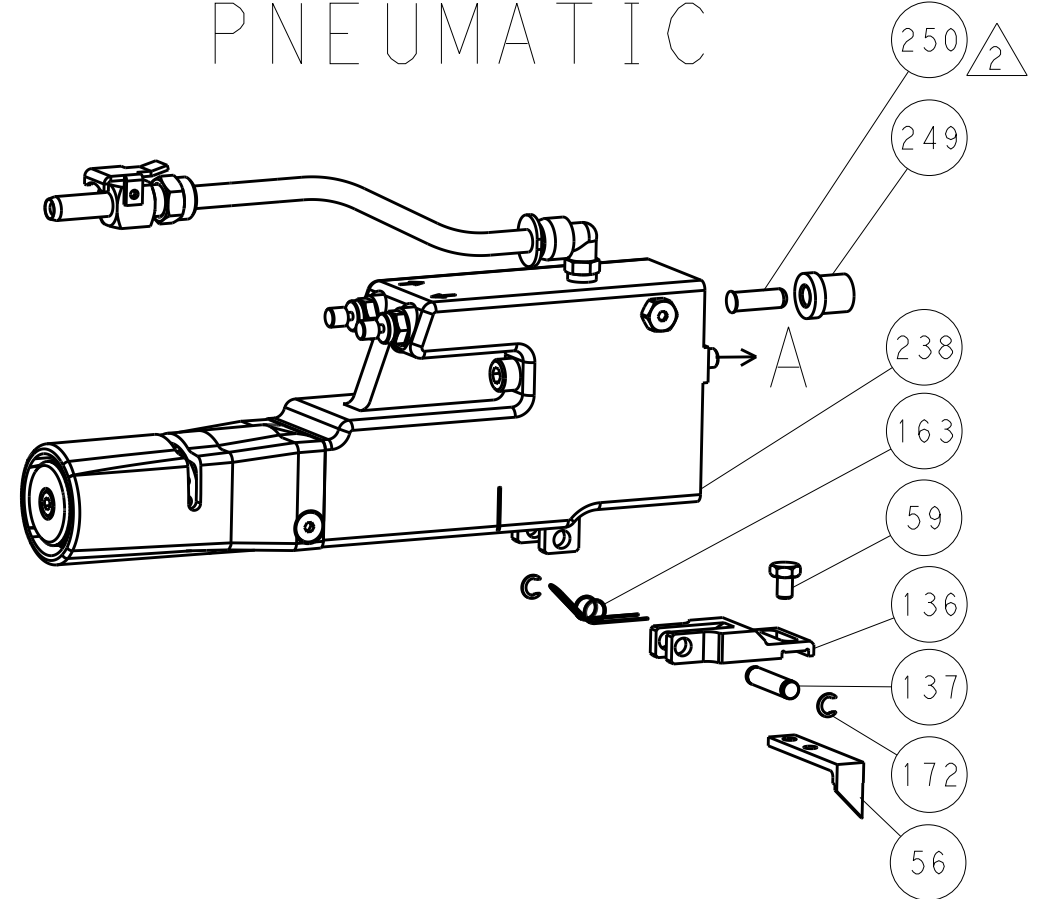


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

### FEED TYPE MECHANICAL



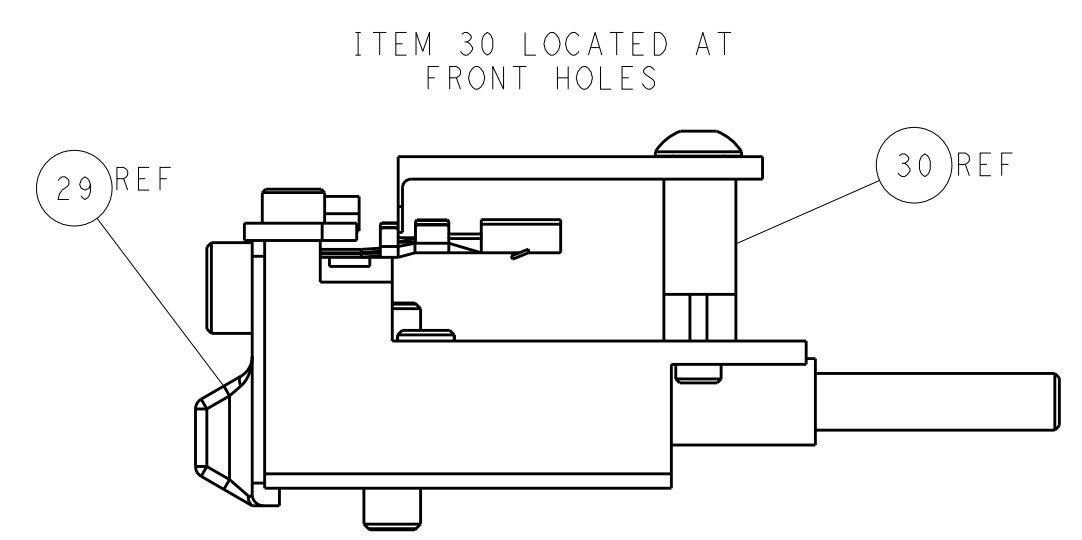
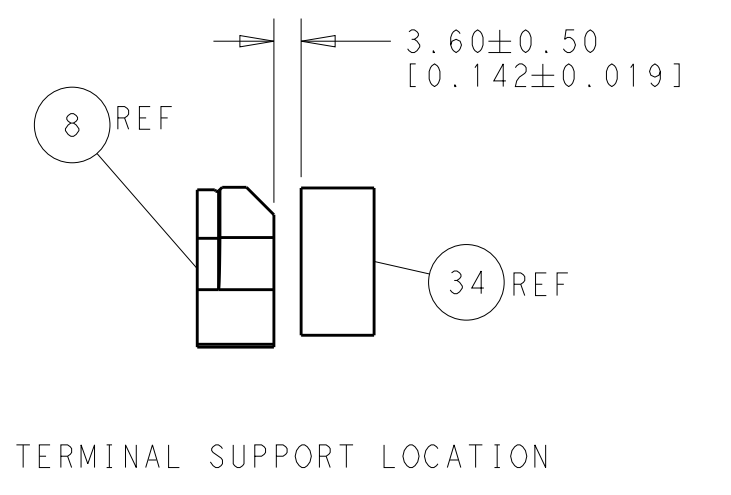
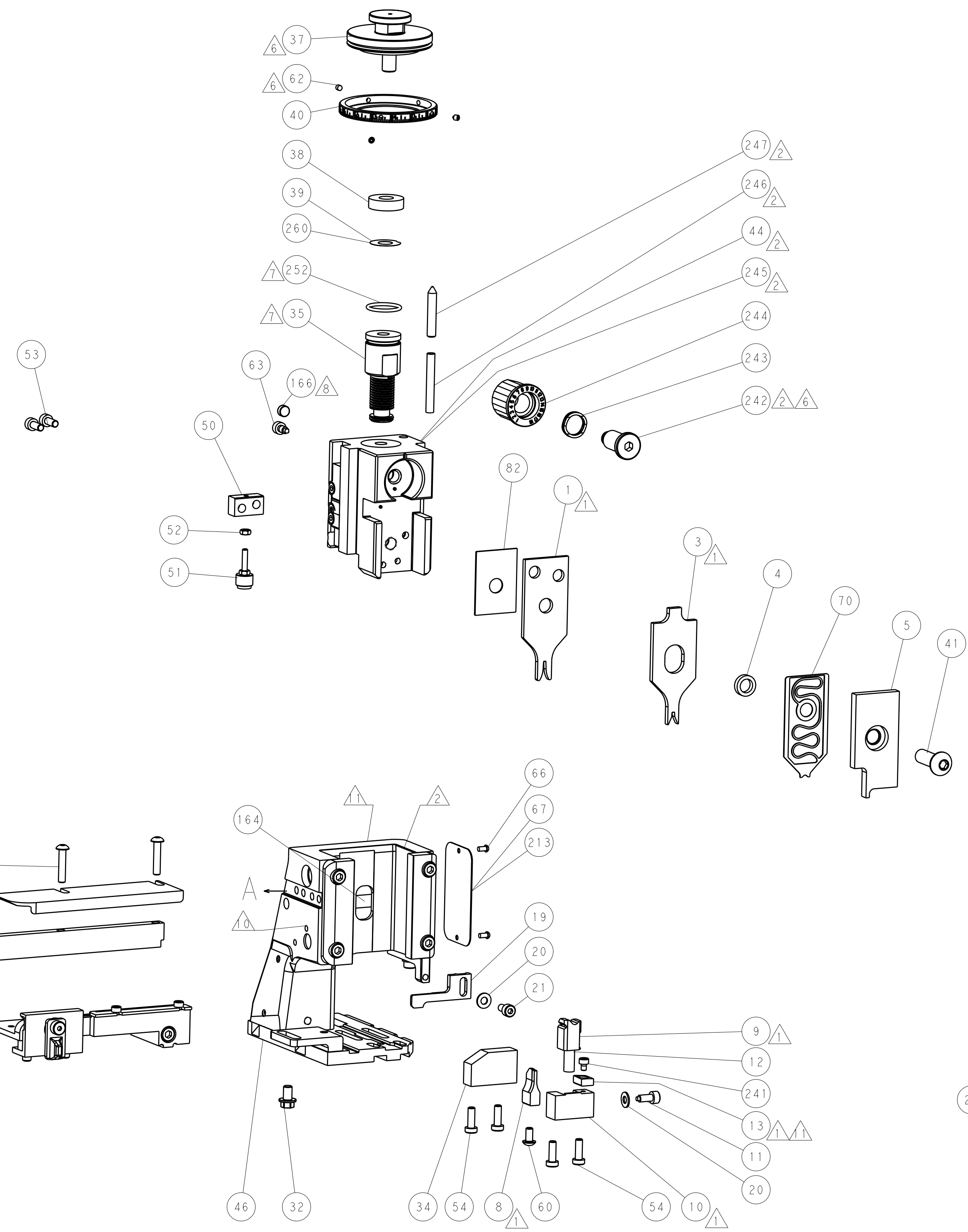
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J. HOU 24APR2015		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	CHK: L. ZHANG 24APR2015	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: H. GUO 24APR2015		NAME: Ocean Side Feed Applicator	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 2 OF 4		REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266767-1	A	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	-	8-2266767-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266767-4	-	-	-
	2-2266767-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266767-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266767-4	-	-	-
	2-2266767-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	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
	2-2266767-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266767-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.73 mm [.068]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: DELPHI PACKARD TERMINAL DELPHI PACKARD CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL	
WIRE STRIP LENGTH 3.70-4.46 mm [1.46-.176 IN]	INSULATION DIAMETER RANGE Ø 1.70-1.90 mm [.067-.075 IN]
TERMINAL APPLICATION SPECIFICATION 15443789 PAGE 6 OF 10 Rev 10-30-2013	
TERMINALS APPLIED	
TE TERMINAL	DELPHI PACKARD TERMINAL
1949697-1	15443789

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.80mm2	1.10+/-0.05 [.043+/-0.002]	6.5



- △ RECOMMENDED SPARE PARTS
- △ 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: 8-2266767-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266767-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266767-5
- 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.
- △ 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.

\*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.

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	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO
-	-	-	-	2119782-1 FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	2119640-1 PUSH ROD, AIR FEED	250
-	-	-	-	2079988-1 BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3 SPRING, COMPRESSION	246
-	1	1	1	2119082-5 CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1 RETAINER, INSULATION DIAL	242
-	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
-	-	-	-	2119580-1 MECHANICAL FEED ASSEMBLY	239
-	-	-	-	2063440-1 AIR FEED MODULE	238
-	-	1	-	2119740-2 TAG, IDENTIFICATION	213
-	-	1	-	1901094-3 SPACER, FEEDER	198
-	-	-	2	21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	994969-1 MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	994970-2 COUNTER, MAGNETIC	164
-	-	-	1	240638-1 SPRING, FEED FINGER	163
-	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	2119798-2 DETENT PIN	145
-	1	1	1	2079383-8 SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	2168400-5 SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	2119653-2 FEED CAM, POST FEED	142
-	1	1	1	1-2119656-0 APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	2119650-1 RAM, ASIAN STYLE, SIDE FEED	140
-	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	455888-6 SPACER, CRIMPER	82
-	1	1	1	2119956-1 DOCUMENTATION PACKAGE	71
-	1	1	1	2119791-6 DEPRESSOR, WIRE	70
-	1	-	1	2119740-1 TAG, IDENTIFICATION	67
-	2	2	2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	2119793-1 LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	992763-5 SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-	-	-	1	5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1338685-1 PAWL, FEED	56
-	2	2	2	1-2168083-0 SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	5018030-1 NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5 BUMPER, HOLD DOWN	51
-	1	1	1	690753-2 SPACER, TONKER	50
-	-	-	1	18023-9 SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	2119652-1 FEED CAM, PRE FEED	48
-	1	1	1	2079383-7 SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	2119957-1 APPLICATOR SHIM PACK	39
-	1	1	1	2119644-1 RAM WASHER, PRECISION	38
-	1	1	1	1752356-1 SUPPORT, TERMINAL	34
-	2	2	2	2079383-5 SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	2161328-1 HEX HEAD, FLANGED, M5 X 8mm LONG	32
-	1	1	1	1320908-3 SPACER, STRIP GUIDE	30
-	1	1	1	2119959-1 ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1320928-2 STRIP GUIDE	24
-	1	1	1	2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	1-18028-2 WASHER, FLAT, REG M4	20
-	1	1	1	2119533-1 STRIPPER, SIDE FEED	19
-	1	1	1	2119806-1 INSERT, SHEAR	13
-	1	1	1	3-22280-3 SPRING, COMPRESSION	12
-	1	1	1	1-356885-4 STOP, SHEAR	11
-	1	1	1	2119805-1 SHEAR HOLDER, FRONT	10
-	1	1	1	1803095-3 FLOATING SHEAR, FRONT	9
-	1	1	1	2-1633918-7 ANVIL, COMBINATION	8
-	-	-	-	-	7
-	-	-	-	-	6
-	1	1	1	1-2119757-2 DEPRESSOR, SHEAR	5
-	1	1	1	238011-2 BLOCK, CRIMPER SPACER	4
-	1	1	1	6-1803017-3 CRIMPER, INSULATION F	3
-	-	-	-	-	2
-	1	1	1	1333281-4 CRIMPER, WIRE PREMIUM	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013
	ANGLES	±.0001			
MATERIAL	FINISH				

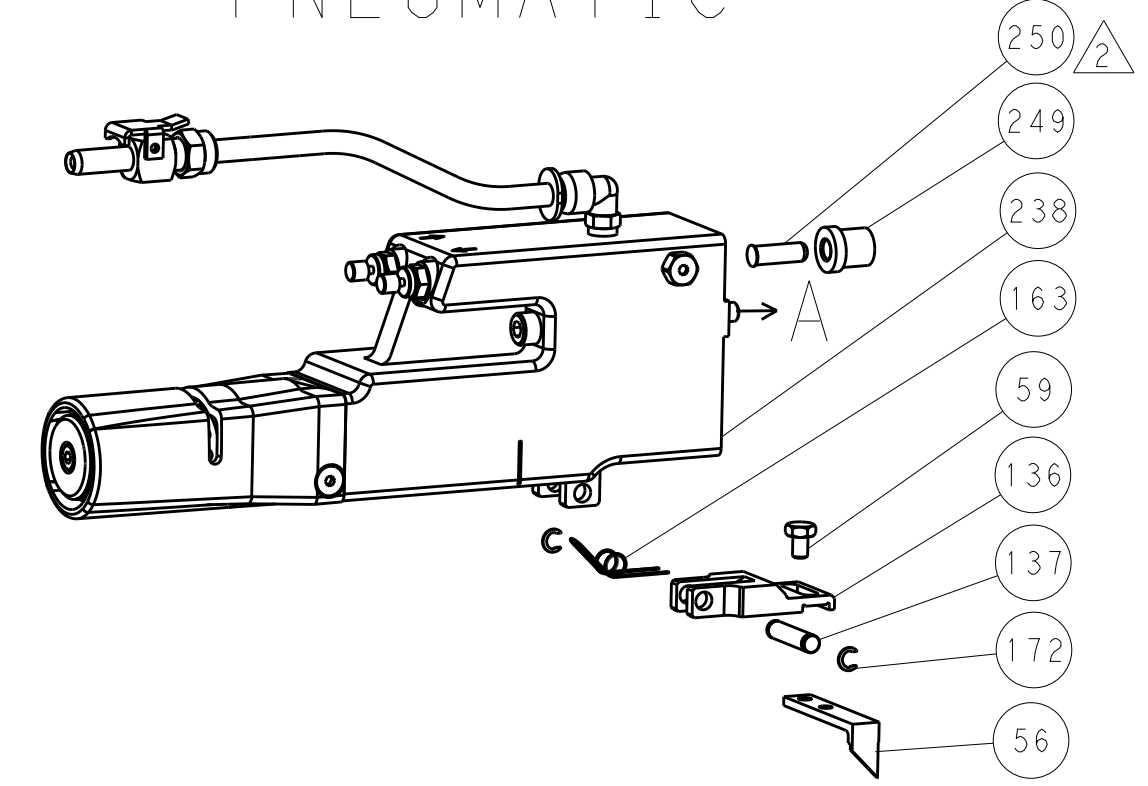
CHK	L. ZHANG	24APR2015
APVD	J. GUO	24APR2015
NAME	Ocean Side Feed Applicator	
SIZE	CAGE CODE	DRAWING NO
A1	00779	2266767
Customer Accessible Production Drawing		SCALE 1:2 SHEET 3 OF 4 REV A

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

# FEED TYPE MECHANICAL



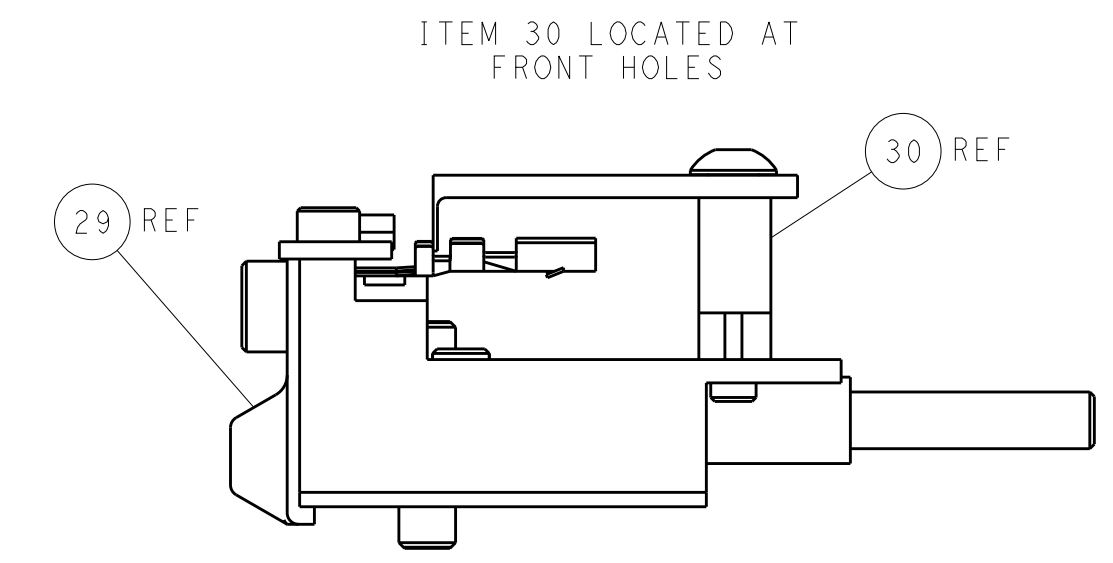
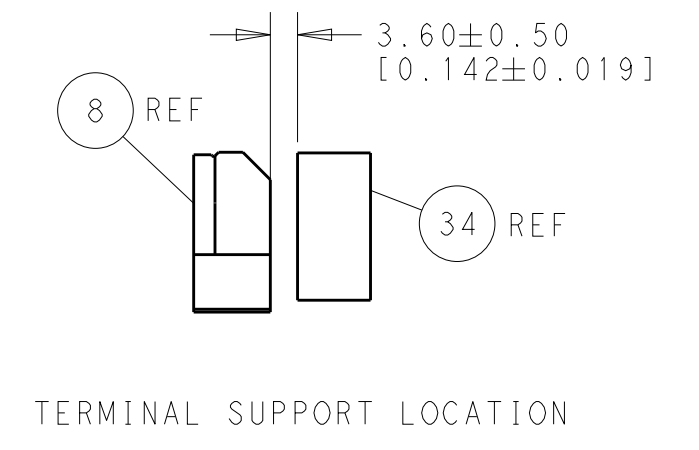
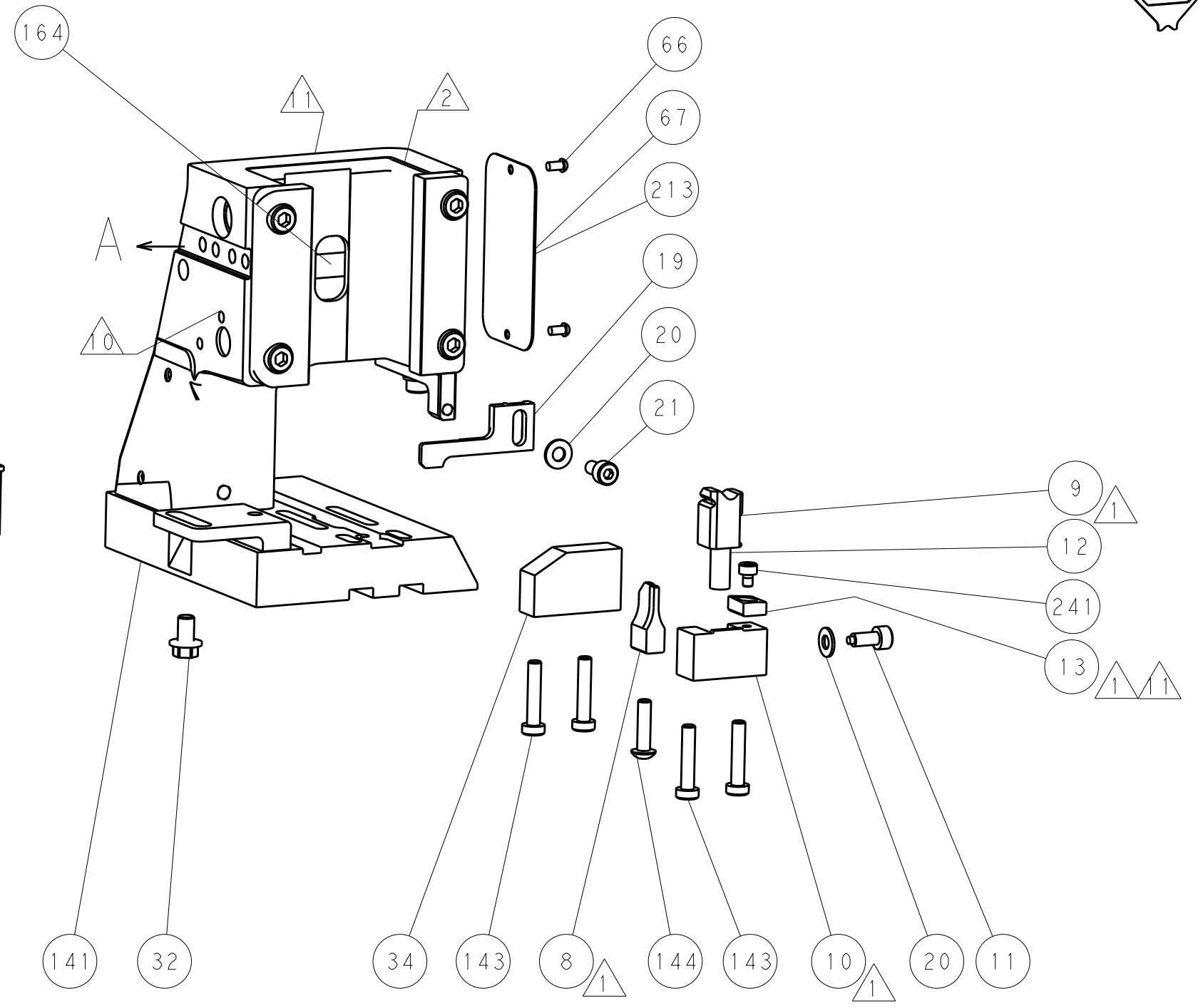
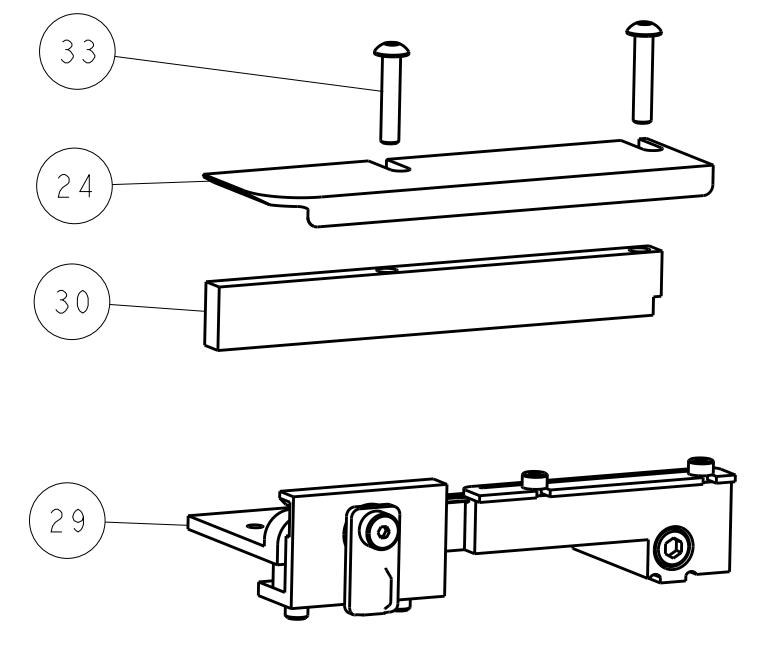
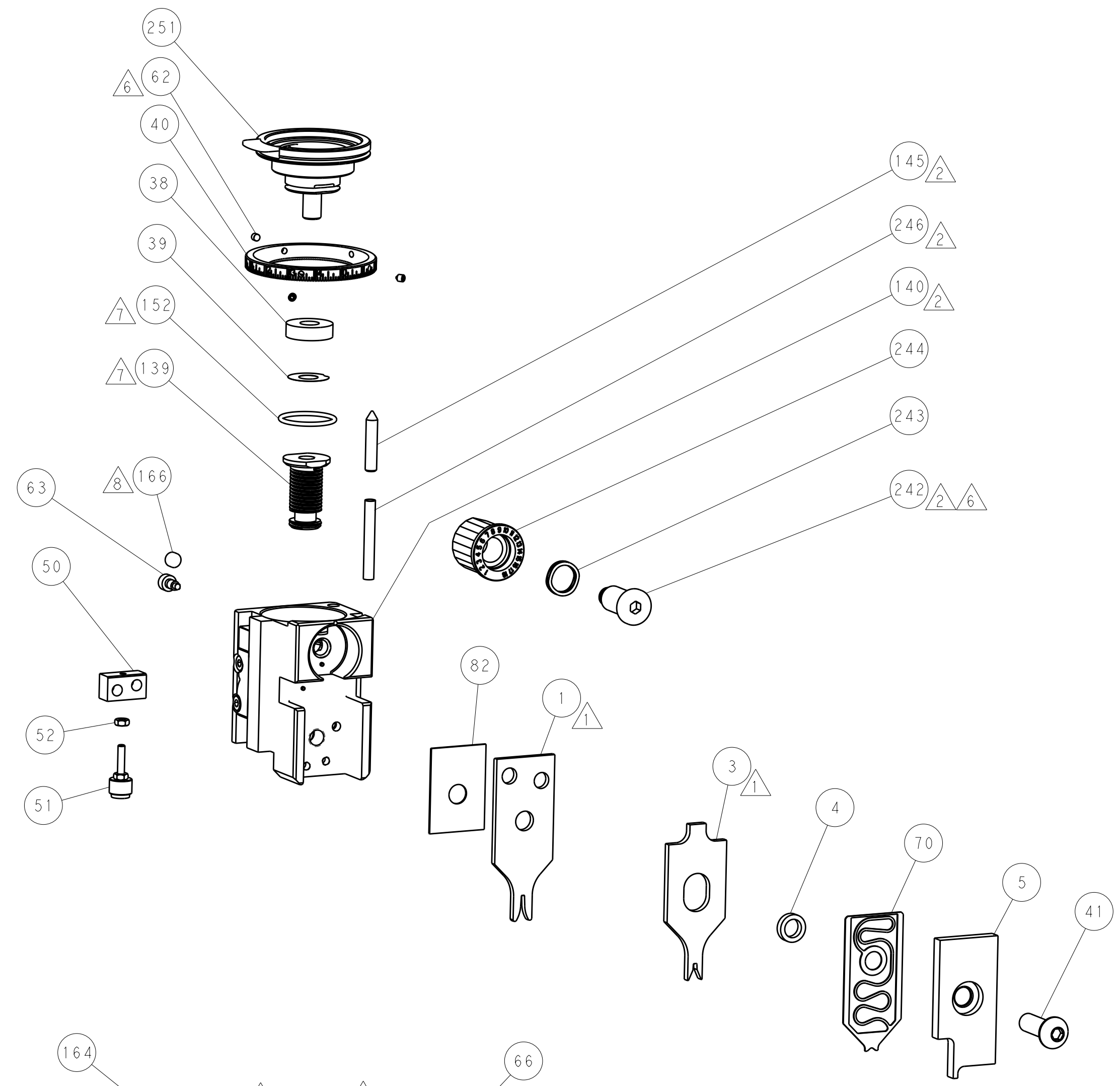
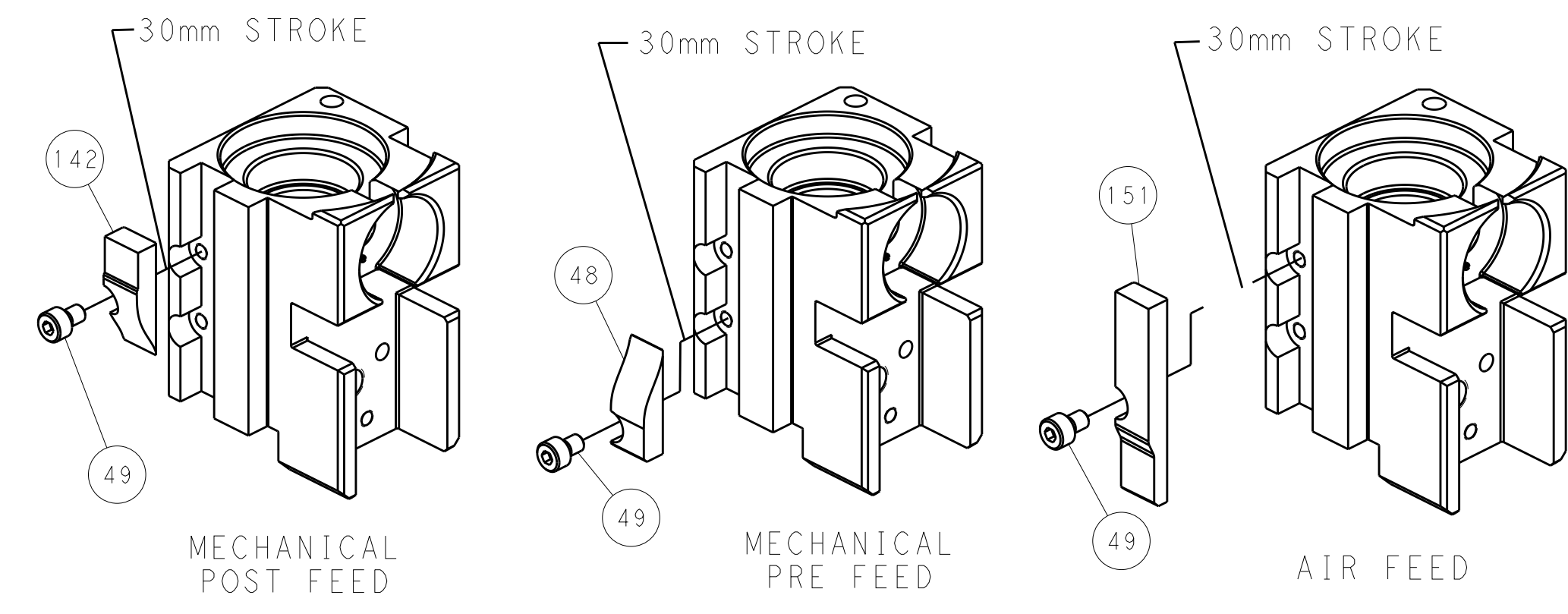
# PNEUMATIC



# 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: J. HOU 24APR2015		CHK: L. ZHANG 24APR2015		APVD: H. GUO 24APR2015		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	ANGLES ±0.001	MATERIAL:		FINISH:		RESTRICTED TO:
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2		SHEET 4 OF 4		REV A	