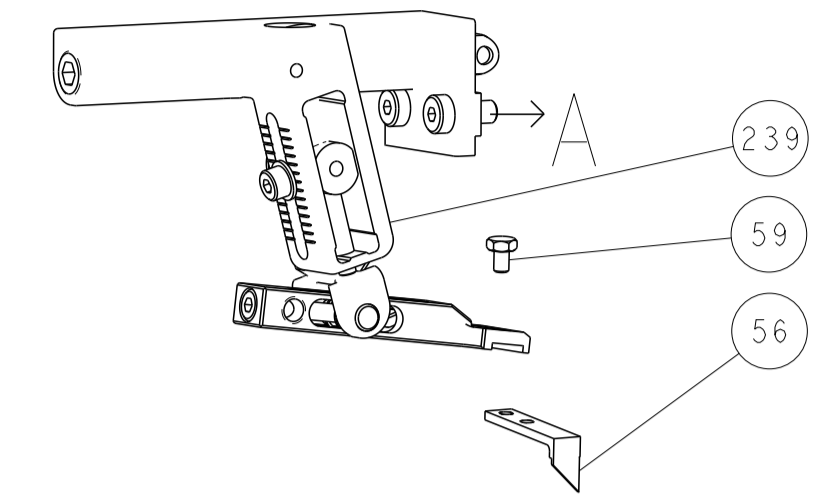
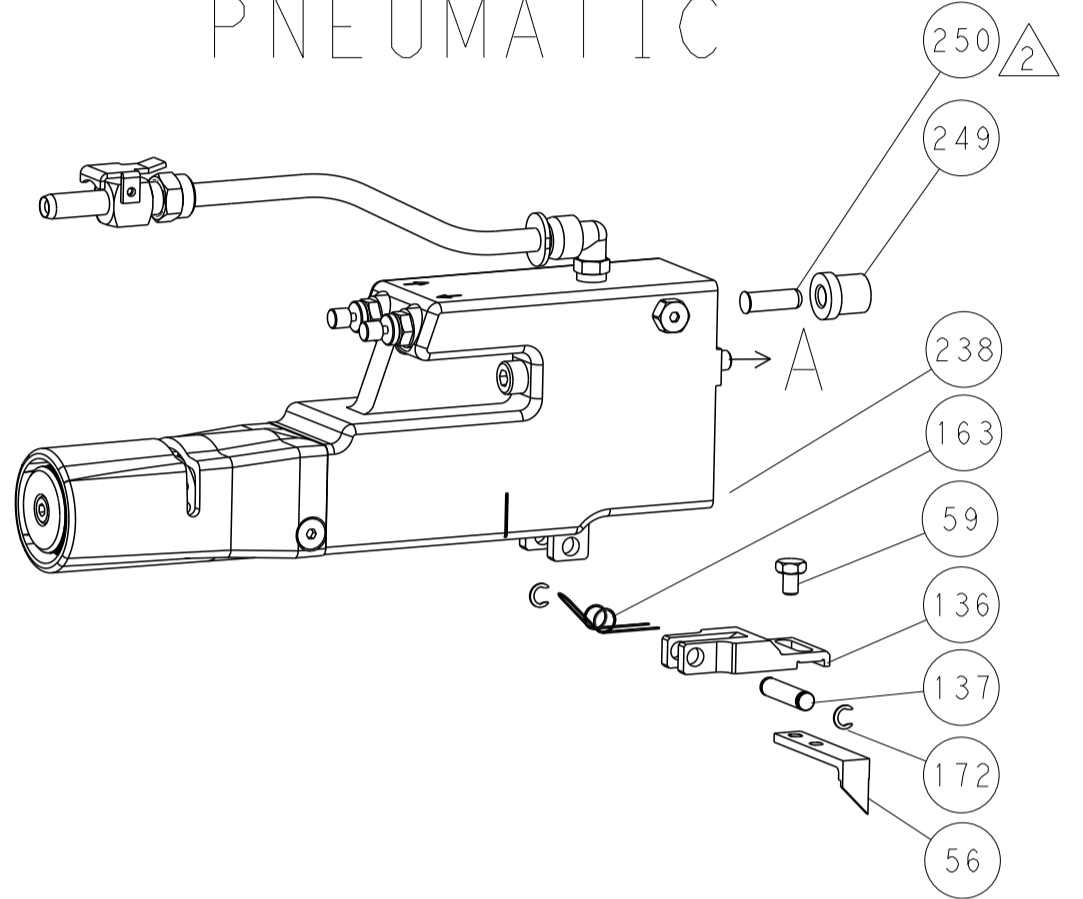


LOC	DIST	REV	DATE	BY	APPV
A	66				

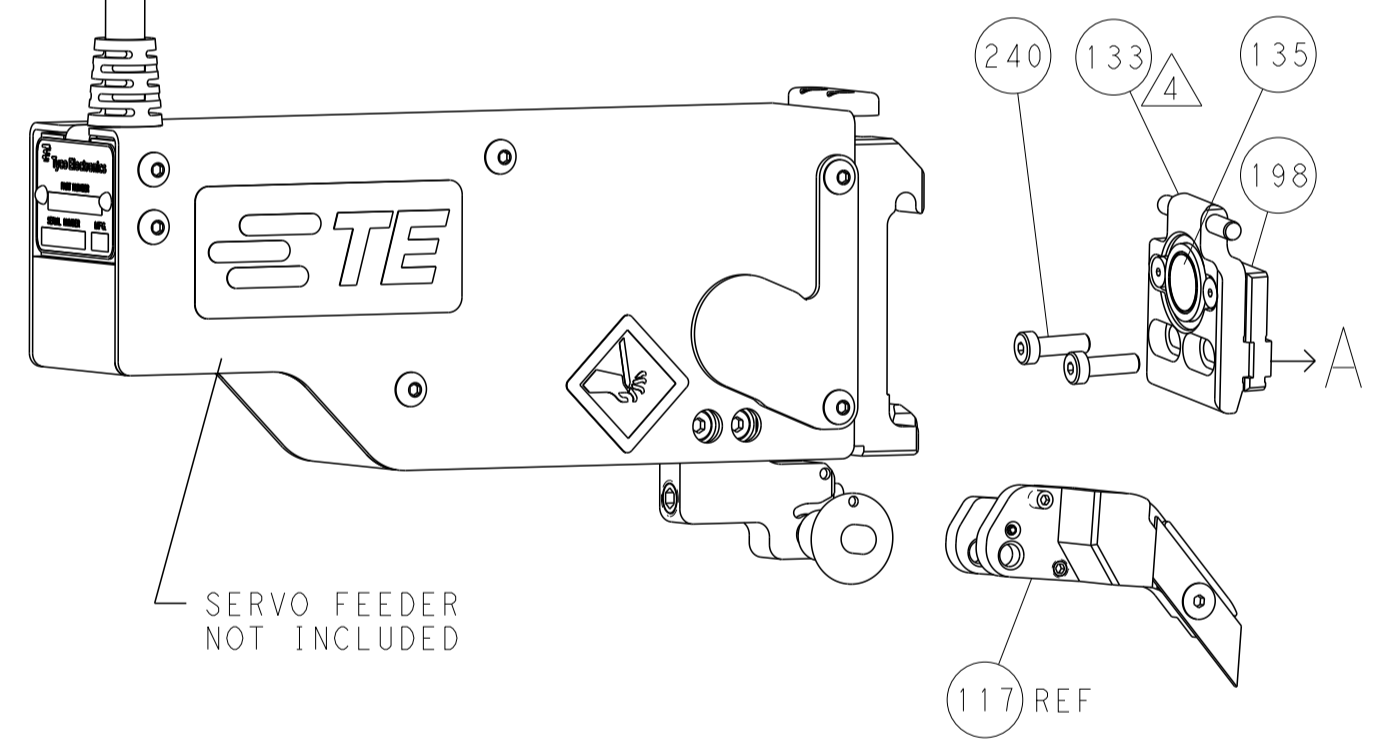
FEED TYPE MECHANICAL



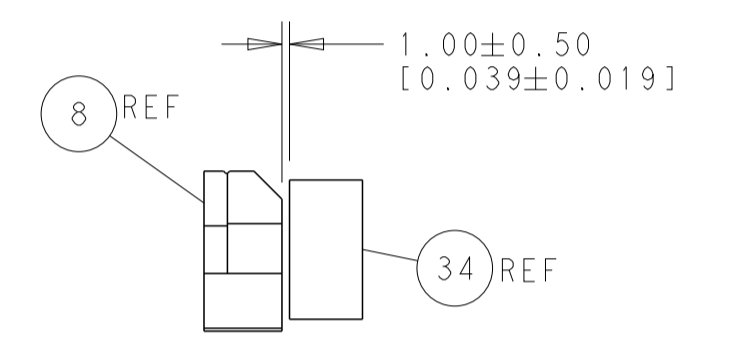
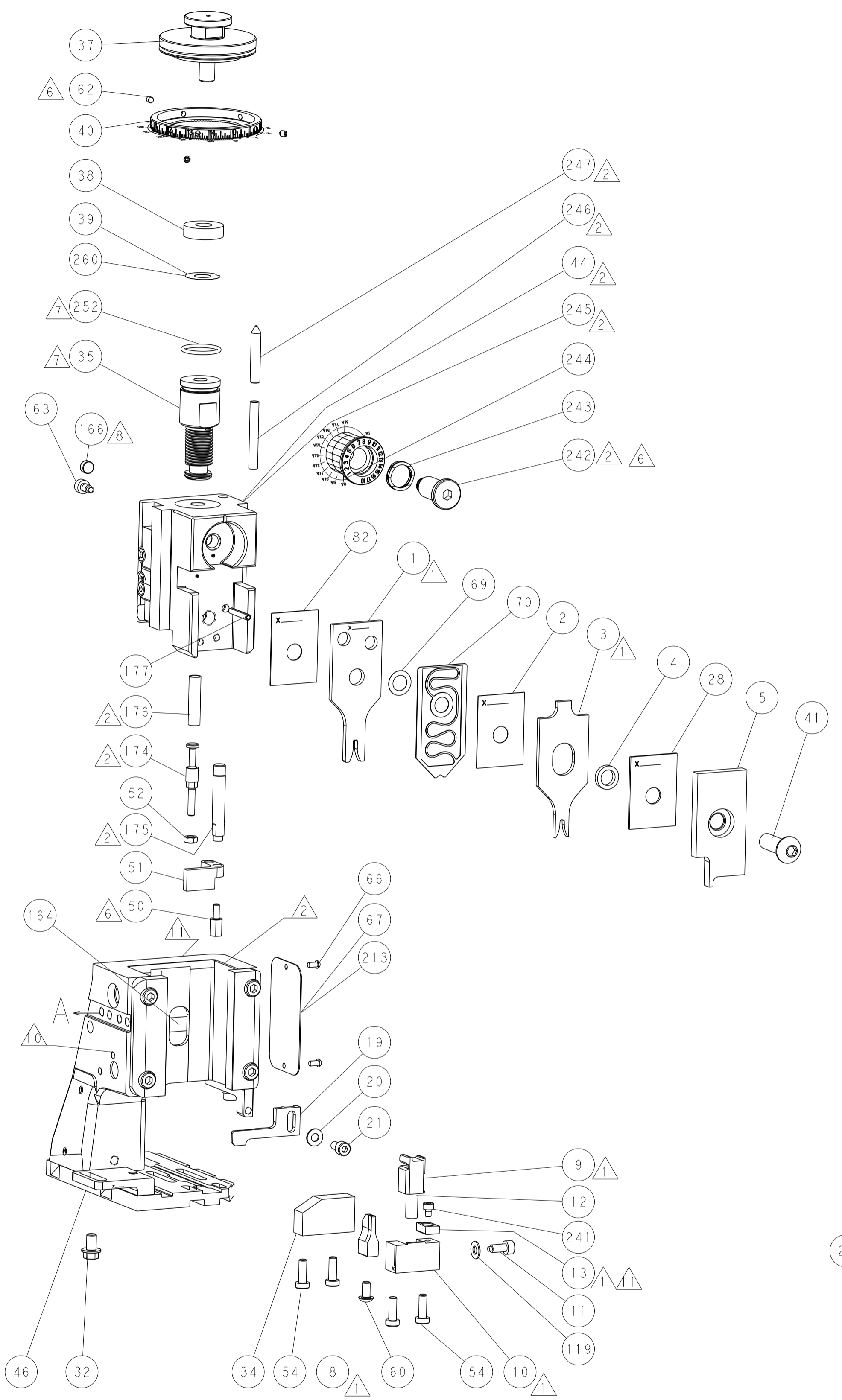
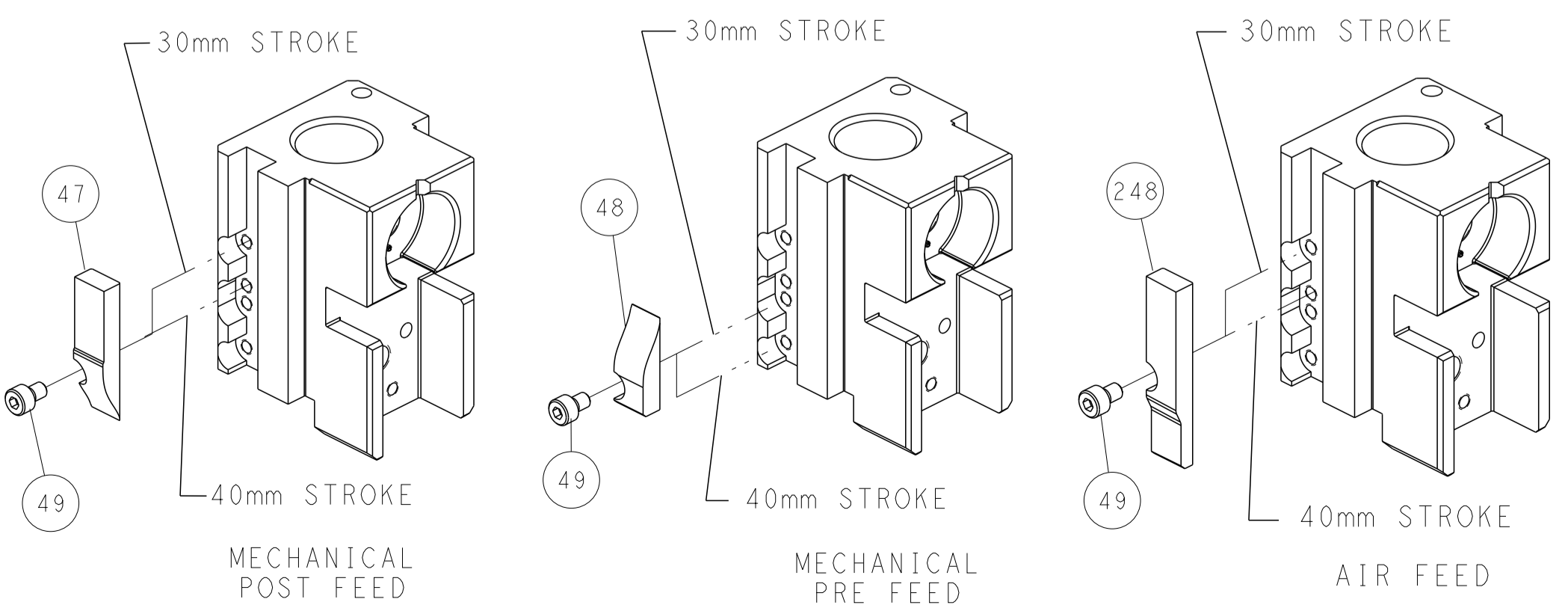
PNEUMATIC



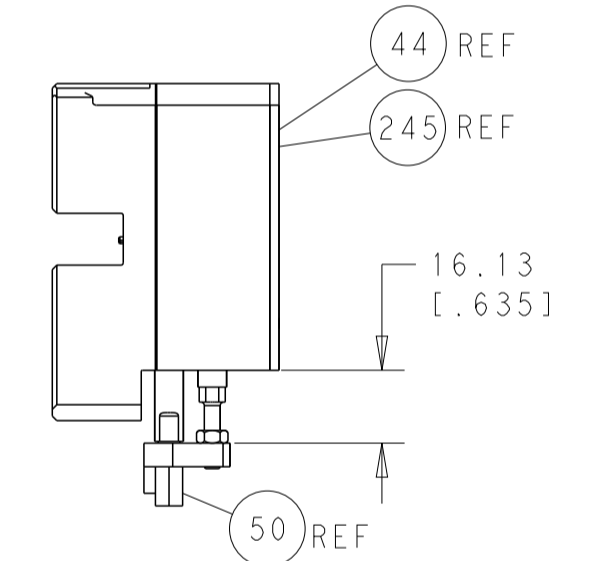
SERVO LATCH PLATE



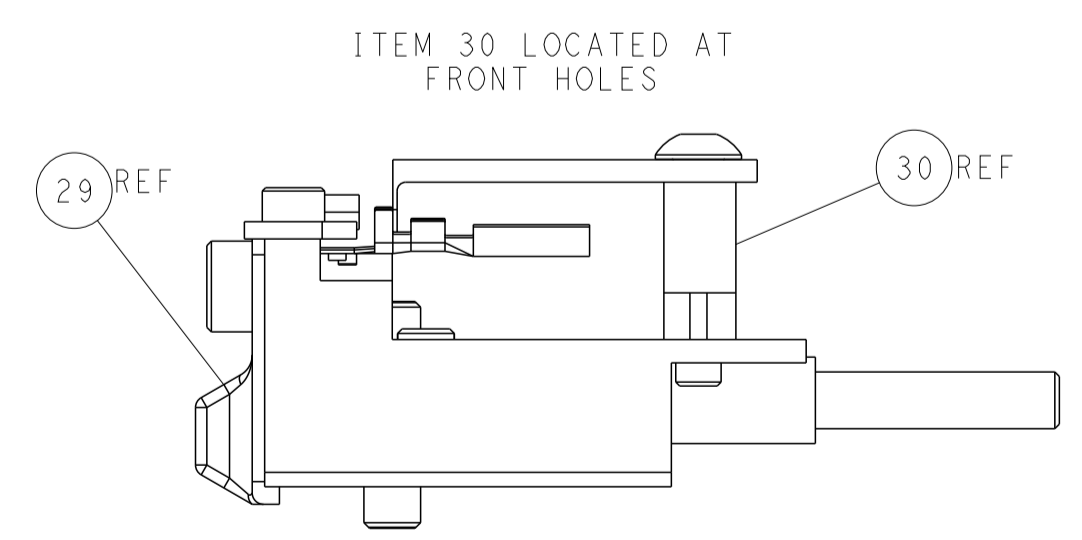
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.0001		DWN C. CHEN 27AUG2012 CHK S. XI 27AUG2012 APVD J. CRUZ 27AUG2012		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151481	
MATERIAL:		FINISH:		WEIGHT:		SCALE 1:2 SHEET 2 OF 4 REV B	

APPLICATOR STYLE CONVERSION CHART
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER
PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED

APPLICATOR DATA
CRIMP SIZE TYPE
WIRE 2.03 mm [.080] F
INSUL 2.54 mm [.100] OV
APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION
TERMINAL NAME: TAB 1.6 X 0.6 MM
WIRE STRIP LENGTH INSULATION DIAMETER RANGE
TERMINAL APPLICATION SPECIFICATION
TERMINALS APPLIED

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION
TERMINAL NAME: TAB 1.6 X 0.6 MM
WIRE STRIP LENGTH INSULATION DIAMETER RANGE
TERMINAL APPLICATION SPECIFICATION
TERMINALS APPLIED

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING
1.00mm2 1.20 +/- 0.05 [.047 +/- .002] 4.9
0.75mm2 1.18 +/- 0.05 [.046 +/- .002] 5.1
0.50mm2 1.15 +/- 0.05 [.045 +/- .002] 5.4

WIRE SIZE CRIMP HEIGHT WIRE CRIMP UNIT CRIMP HEIGHT REFERENCE SETTING
1.00mm2 1.36 +/- 0.05 [.054 +/- .002] 3.5
0.75mm2 1.27 +/- 0.05 [.050 +/- .002] 4.3
0.50mm2 1.18 +/- 0.05 [.046 +/- .002] 5.1



- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151481-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151481-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151481-5
- 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 50 & 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.

Table with 4 columns: Part No, Description, Item No. Rows include items 251, 250, 249, 246, 244, and a summary row for parts -77, -27, -25, -22, -21.

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

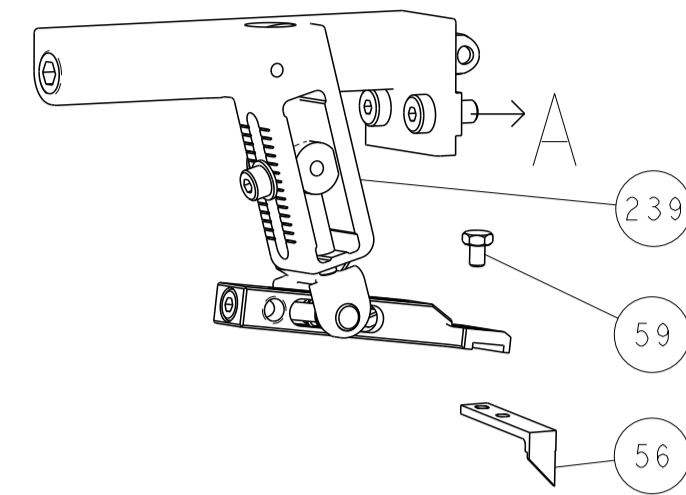
REVISIONS
SET UP GAUGE 2119599-1
LOC A
DIST 66
REV LTR DESCRIPTION DATE DWN APVD

Large table of parts and their specifications, including items like WASHER, WAVE SPRING, CREST-TO-CREST, RETAINER, INSULATION DIAL, SCR, SKT HD CAP M3 X 4.0, SHCS, LOW HEAD, RoHS, M5 X 16, MECHANICAL FEED ASSEMBLY, AIR FEED MODULE, TAG, IDENTIFICATION, SPACER, FEEDER, PIN, SLOTTED SPRING 3.0 X 20.0, SPRING, COMPRESSION, GUIDE PIN, HOLDDOWN, RING, RETAIN, EXTERN, 3/16 CRESCENT, MAGNET, RARE EARTH HIGH ENERGY, COUNTER, MAGNETIC, SPRING, FEED FINGER, O-RING, .801 ID, .070 DIA. MAT., FEED CAM, AIR FEED, DETENT PIN, SCR, BHSC, RoHS (M4 X 16), SHCS, LOW HEAD, RoHS, M4 X 20, FEED CAM, POST FEED, APPLICATOR BASIC ASSEMBLY, SF, RAM, ASIAN STYLE, SIDE FEED, BOLT, ADJUSTMENT, PIN, RETAIN, GRVD, 3/16 X .854, HOLDER, FEED FINGER, AF, MEMORY CHIP, PROGRAMMED, SERVO FEED LATCH ASM, WASHER, FLAT, REG M4, FEED FINGER ASSEMBLY, SF, SPACER, CRIMPER, DOCUMENTATION PACKAGE, DEPRESSOR, WIRE, WASHER, SPACER, TAG, IDENTIFICATION, SCREW, DRIVE, RH, RoHS, 2 x .188, LIMITER, ADJUSTMENT BOLT, SCR, SET, SOC, CONE POINT, M3 x 4.0, SCR, HEX HD CAP, M4 X 6.0, PAWL, FEED, NUT, HEX, REG, RoHS, M3.5, HOLDDOWN, TERMINAL, STANDOFF, HOLD-DOWN, SCR, SKT HD CAP M4 X 6.0, FEED CAM, PRE FEED, SCR, BHSC, RoHS (M8 X 25), DISC, NUMBERED FA WIRE ADJUSTMENT, APPLICATOR SHIM PACK, RAM WASHER, PRECISION, SUPPORT, TERMINAL, SCR, BHSC, RoHS (M4 X 20), HEX HEAD, FLANGED, M5 x 8mm LONG, SPACER, STRIP GUIDE, ASSEMBLY, STRIP GUIDE, SPACER, CRIMPER, STRIP GUIDE, SCR, SKT HD CAP, RoHS, M4 X 8.0, WASHER, FLAT, REG M4, STRIPPER, SIDE FEED, INSERT, SHEAR, SPRING, COMPRESSION, STOP, SHEAR, SHEAR HOLDER, FRONT, FLOATING SHEAR, FRONT, ANVIL, COMBINATION .080, DEPRESSOR, SHEAR, BLOCK, CRIMPER SPACER, CRIMPER, INSULATION OVERLAP PREMIUM, SPACER, CRIMPER, CRIMPER, WIRE PREMIUM.

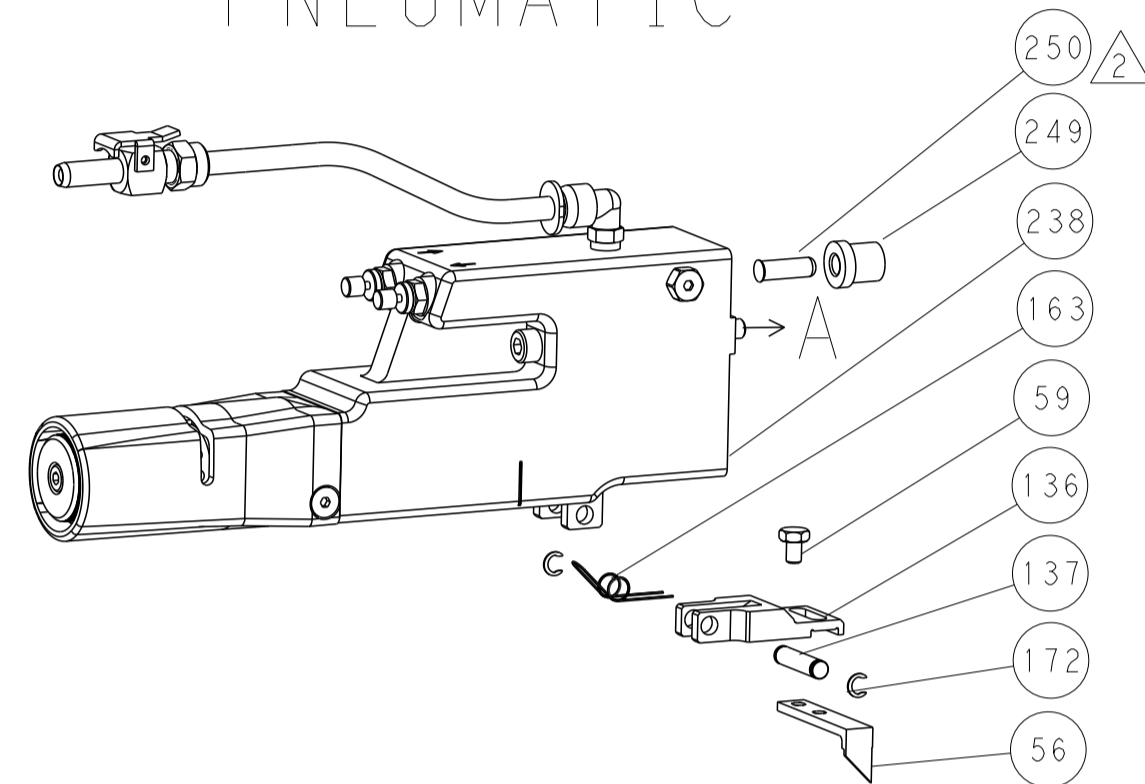
STE TE Connectivity
Ocean Side Feed Applicator
DIMENSIONS: mm
TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±.5
1 PLC ±0.5
2 PLC ±0.13
3 PLC ±0.013
4 PLC ±0.0001
ANGLES ±.5
FINISH
MATERIAL
DWN L.C. CHEN 27AUG2012
CHK S.XI 27AUG2012
APVD J. CRUZ 27AUG2012
PRODUCT SPEC
APPLICATION SPEC
SIZE CAGE CODE DRAWING NO RESTRICTED TO
A1 00779 C=2151481
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 of 4 REV B

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

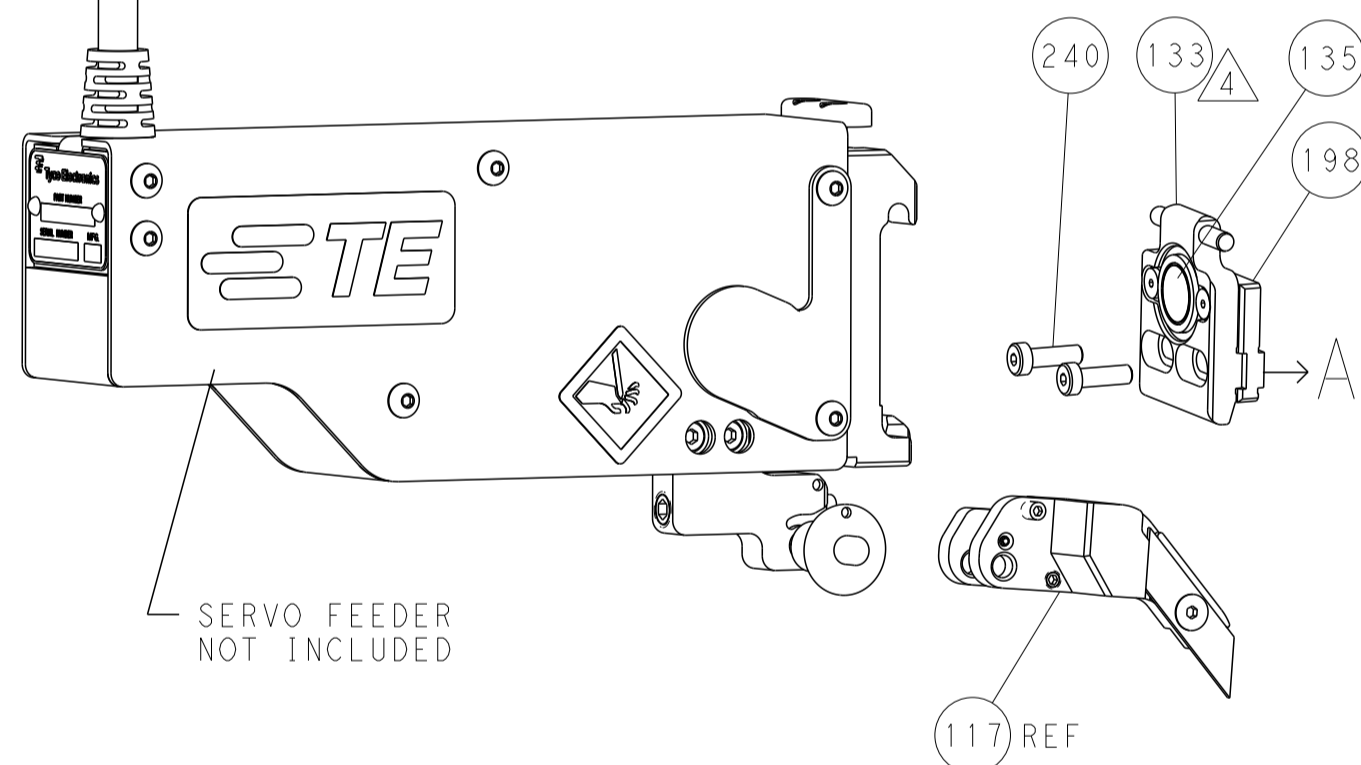
FEED TYPE MECHANICAL



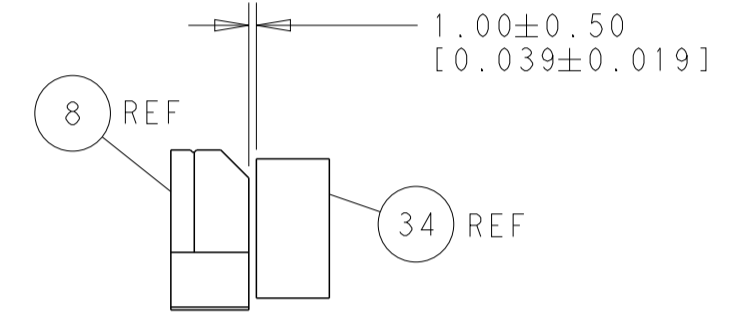
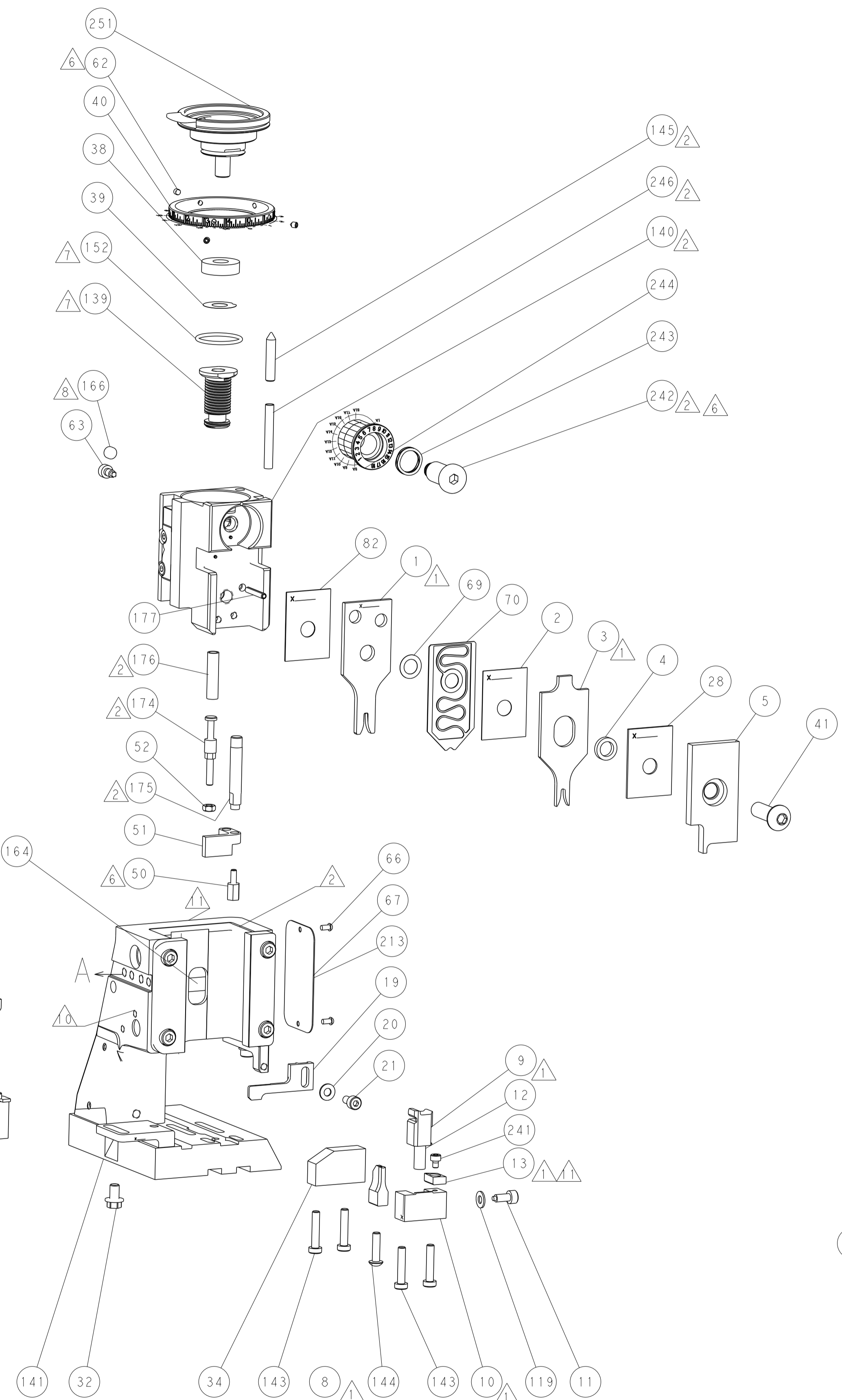
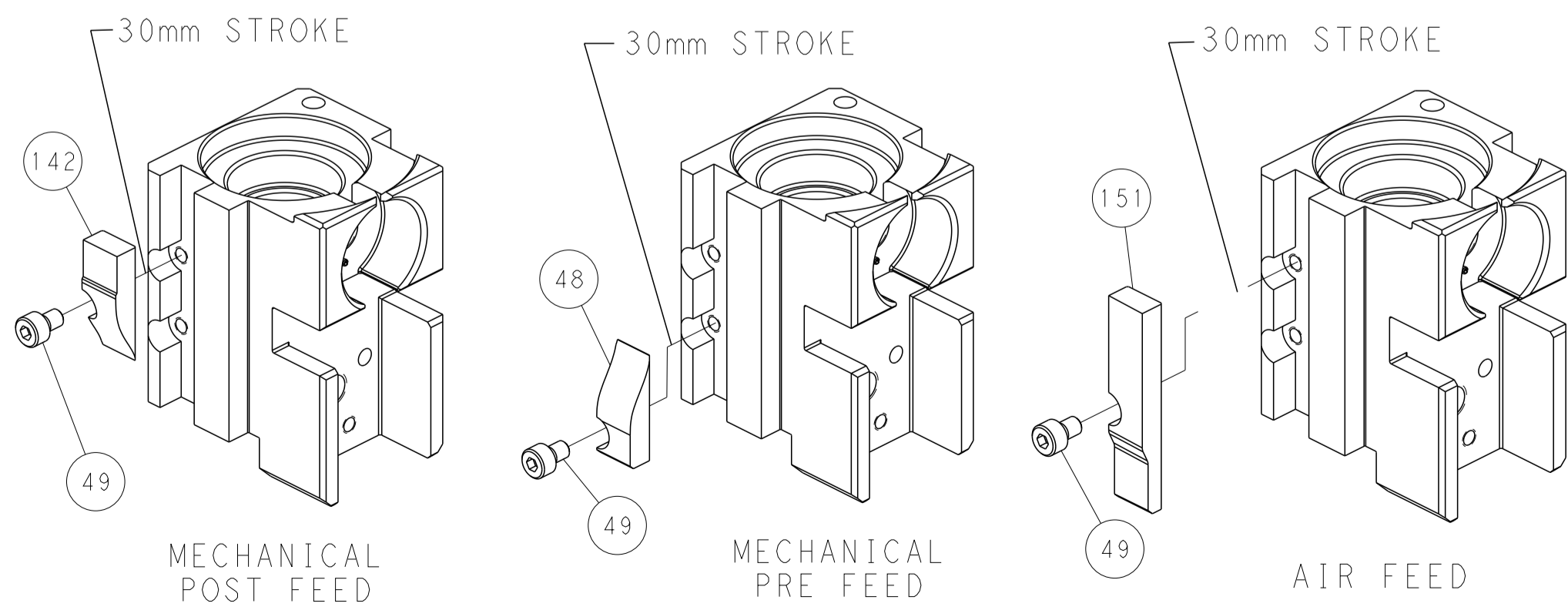
PNEUMATIC



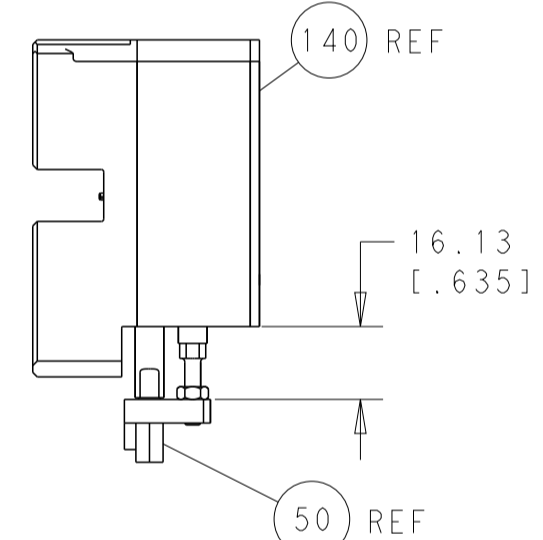
SERVO LATCH PLATE



CAM POSITIONS

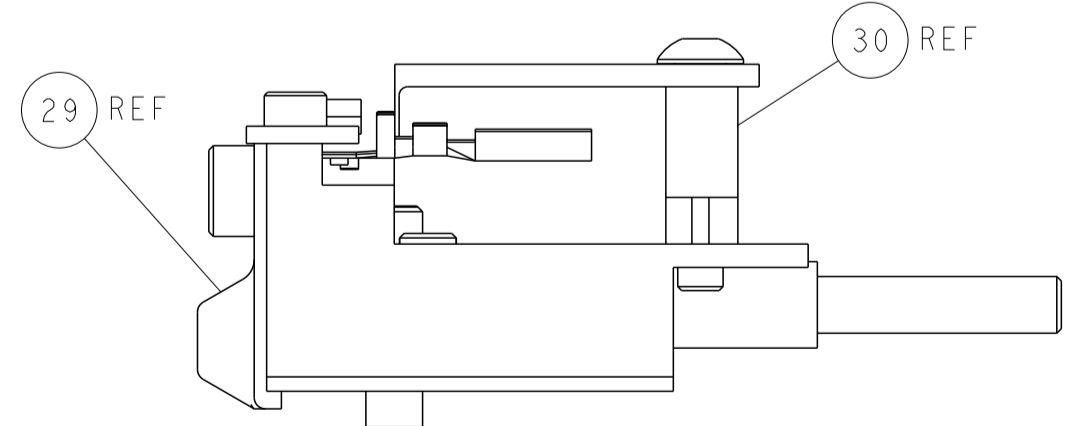


TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 C. CHEN 27AUG2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD J. CRUZ 27AUG2012	NAME Ocean Side Feed Applicator
MATERIAL:		FINISH:		WEIGHT:		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
				A1 00779 ©=2151481		Customer Accessible Production Drawing SCALE 1:2 SHEET 4 OF 4 REV B	