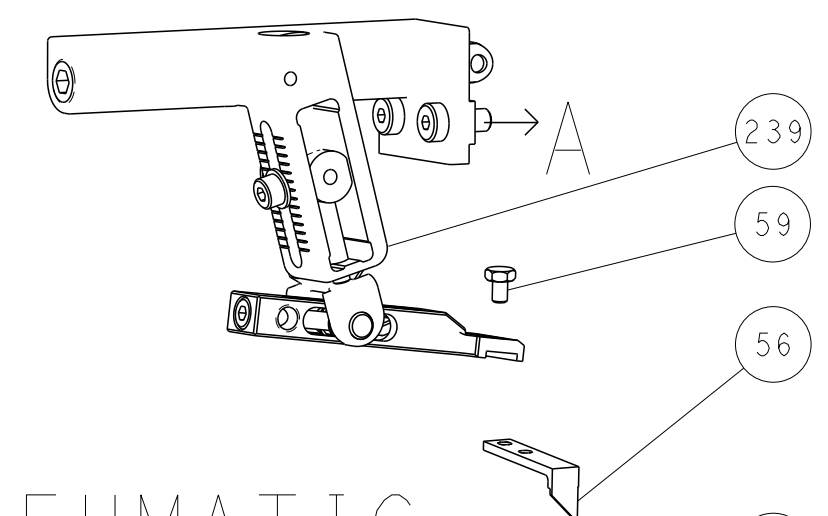


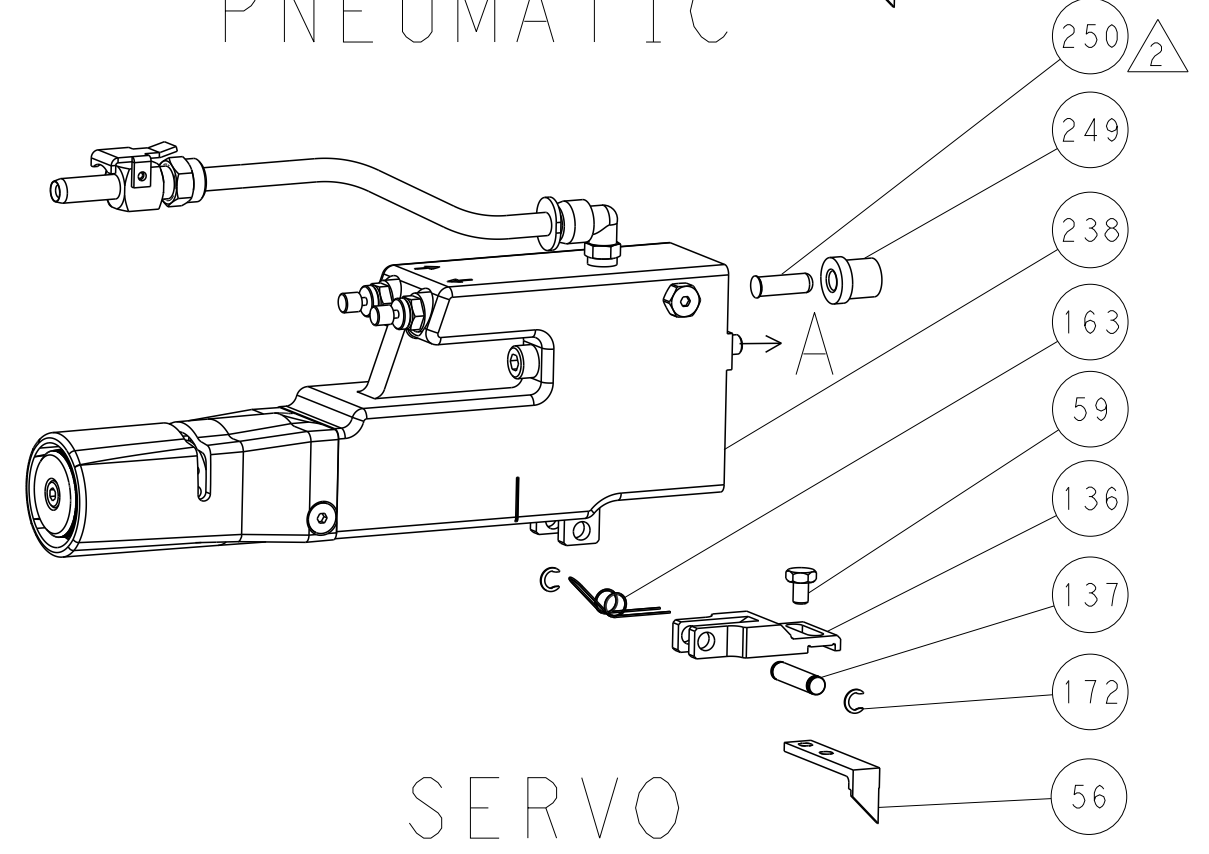


LOC	DIST	REV	DATE	BY	APPV
A	66				

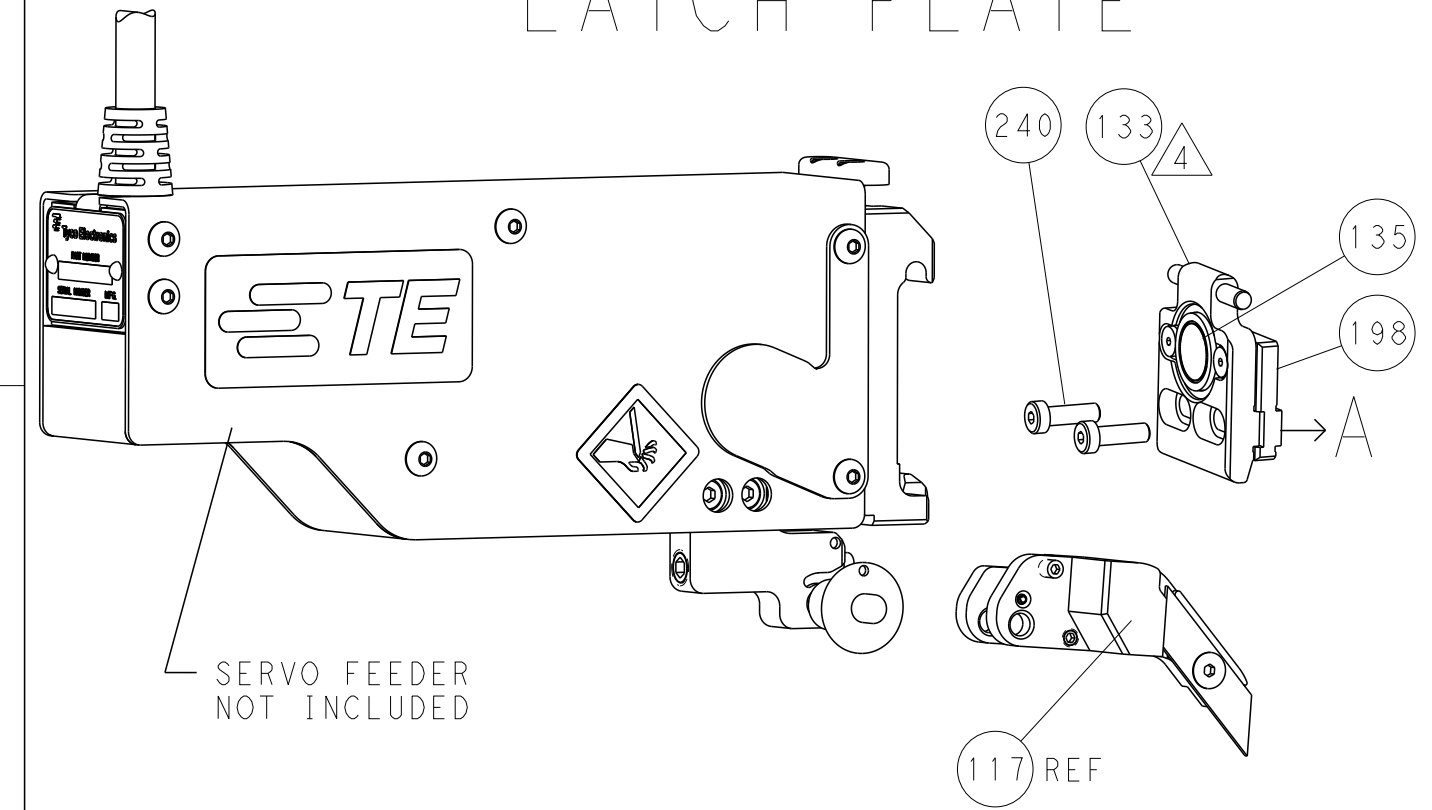
### FEED TYPE MECHANICAL



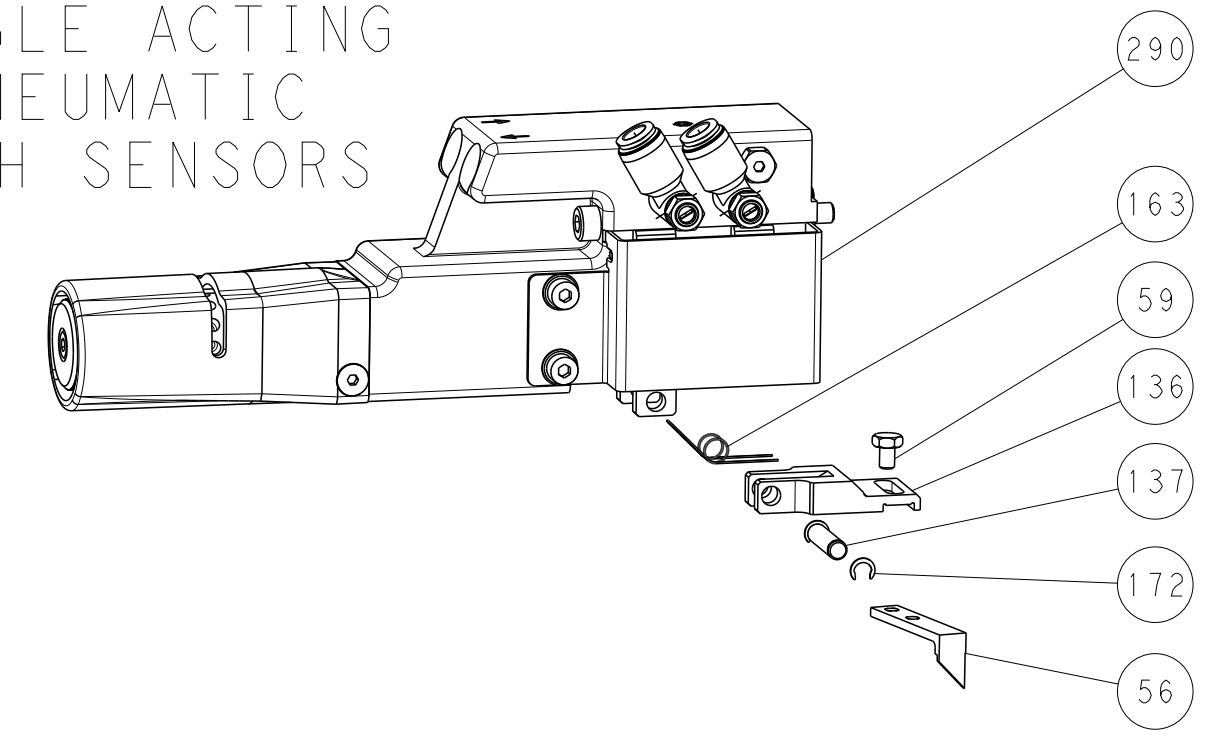
### PNEUMATIC



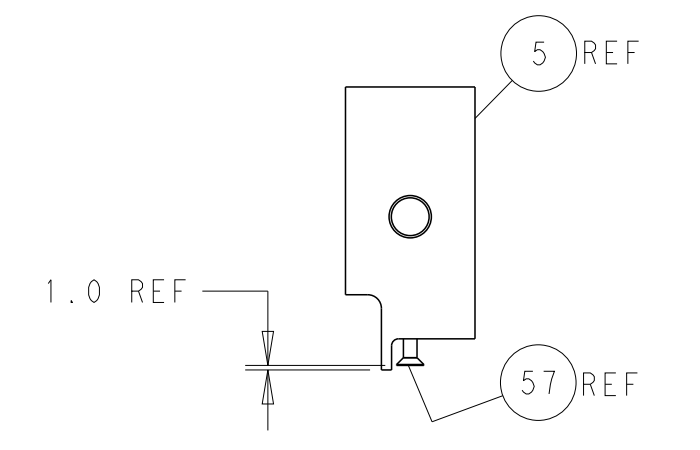
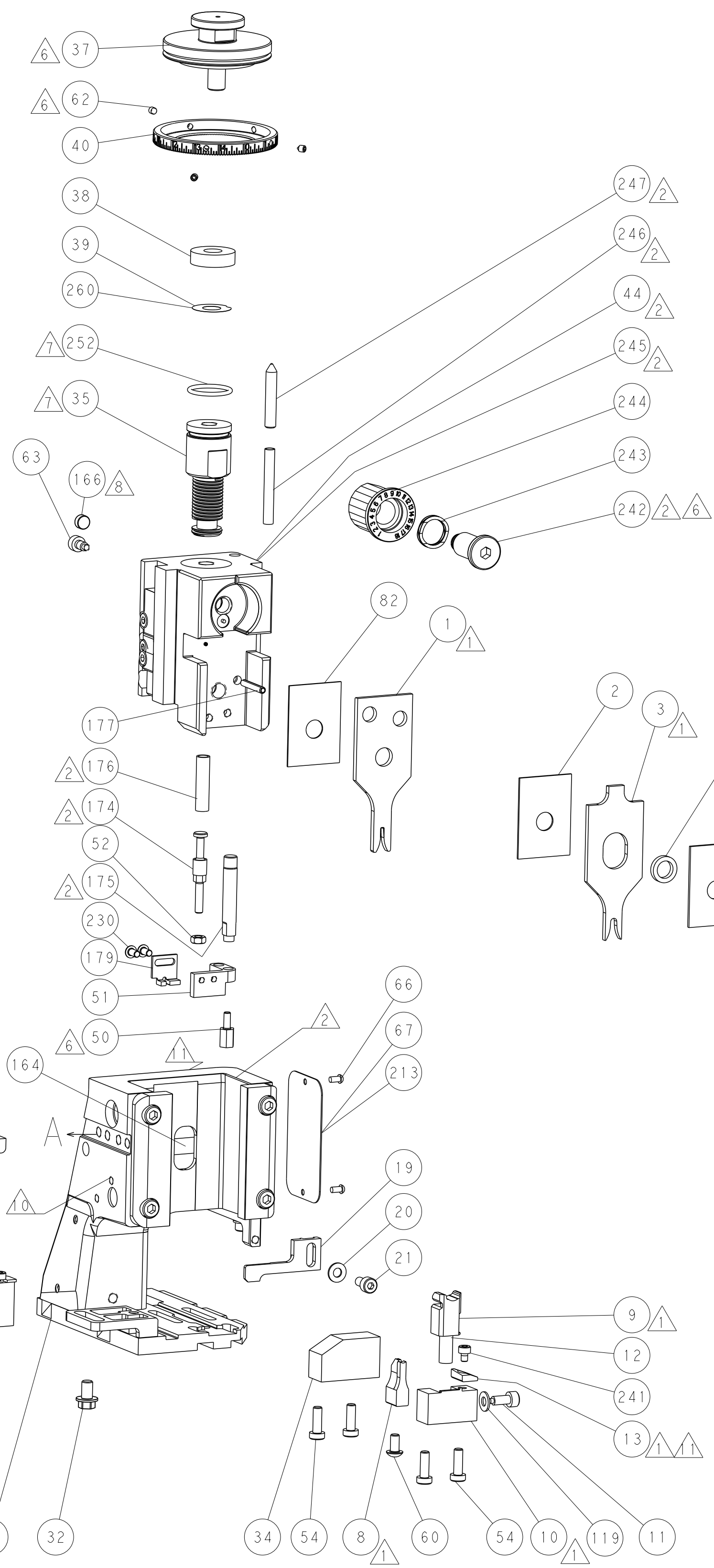
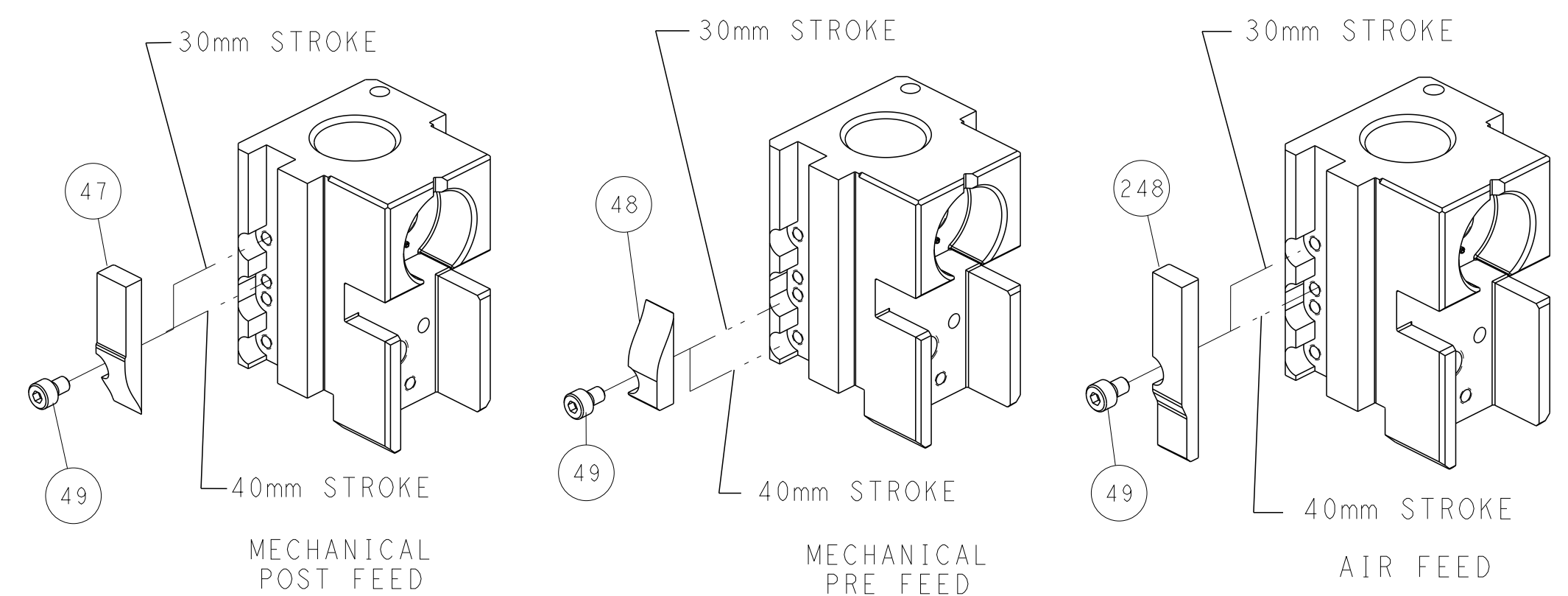
### SERVO LATCH PLATE



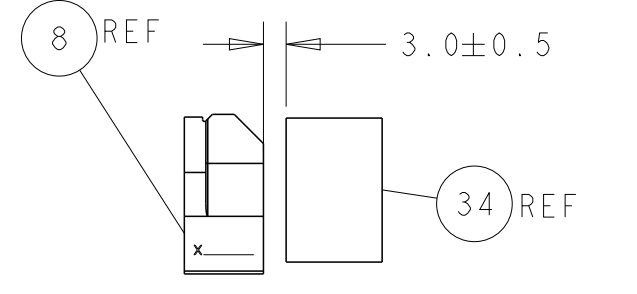
### DOUBLE ACTING PNEUMATIC WITH SENSORS



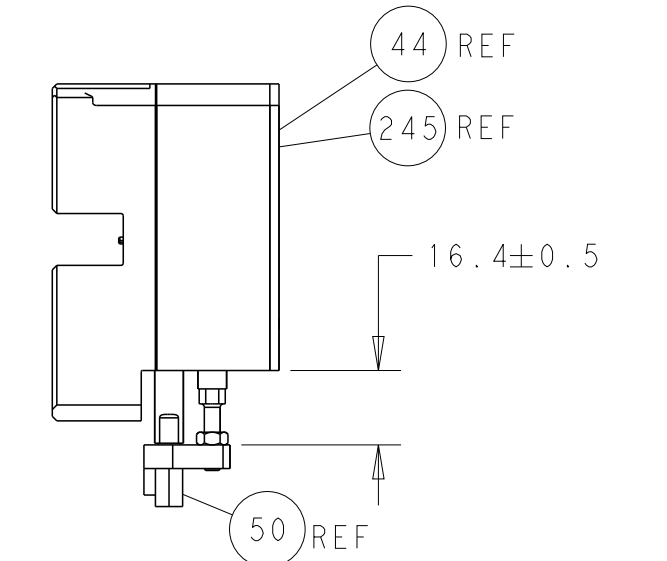
### CAM POSITIONS



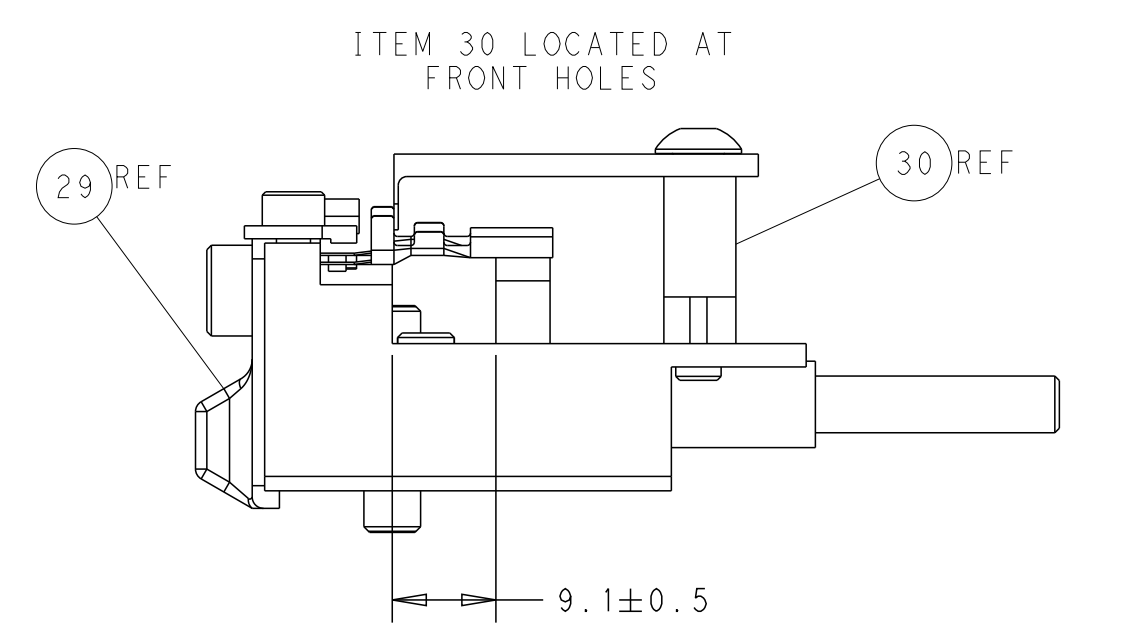
SHEAR DEPRESSOR DETAIL



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 ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN R. HUANG 02SEP2011 CHK S. XI 02SEP2011 APVD S. XI 02SEP2011 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing	NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 ©=2151036 SCALE 1:2 SHEET 2 OF 4 REV G	TE Connectivity Harrisburg, PA 17105-3608
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APPLICATOR STYLE CONVERSION CHART. Table with columns: CONVERT TO, PART NUMBERS REQUIRED. Rows include Pneumatic Feed, Servo Latch Plate, Smart Applicator, Double Acting, Mechanical Feed, Servo Latch Plate, Smart Applicator, Double Acting, Mechanical Feed, Pneumatic Feed, Double Acting, Mechanical Feed, Pneumatic Feed, Smart Applicator.

APPLICATOR DATA. Table with columns: CRIMP, SIZE, TYPE. Rows include Wire (1.40 mm), Insul (3.18 mm), and Applicator Instructions (408-10389).

\*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.

Terminal Data: TE Terminal TE Crimp Specification. Includes wire strip length (3.30-3.90 mm), insulation diameter range (1.40-1.90 mm), terminal application specification (114-18464), and terminals applied table.

Terminal Data: TE Terminal TE Crimp Specification. Includes wire strip length (3.30-3.90 mm), insulation diameter range (1.40-1.90 mm), terminal application specification (114-18464), and terminals applied table.

Wire Size, Crimp Height mm [INCH], Crimp Height Reference Setting table.

Wire Size, Crimp Height mm [INCH], Crimp Height Reference Setting table.

- 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...
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 ITEMS 50,62
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...
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...

- 12 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. REFER TO THE CHART FOR RANGE OF SEALS LISTED ON APPLICATOR DRAWING.
13 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
14 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
15 TERMINAL LUBRICANT IS RECOMMENDED.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Rows include 1803430-1 AIR FEED MODULE (290), 2119782-1 FINE ADJUST HEAD ASM, PACIFIC STYLE (251), 2119640-1 PUSH ROD, AIR FEED (250), 1803259-1 BUSHING, FLANGED (249), 1-22279-3 SPRING, COMPRESSION (246), 2119082-4 CAM, SNAIL, INSULATION ADJUSTMENT (244), 2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST (243), 2119083-1 RETAINER, INSULATION DIAL (242).

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. REVISIONS table with columns: P, LTM, DESCRIPTION, DATE, DWN, APVD.

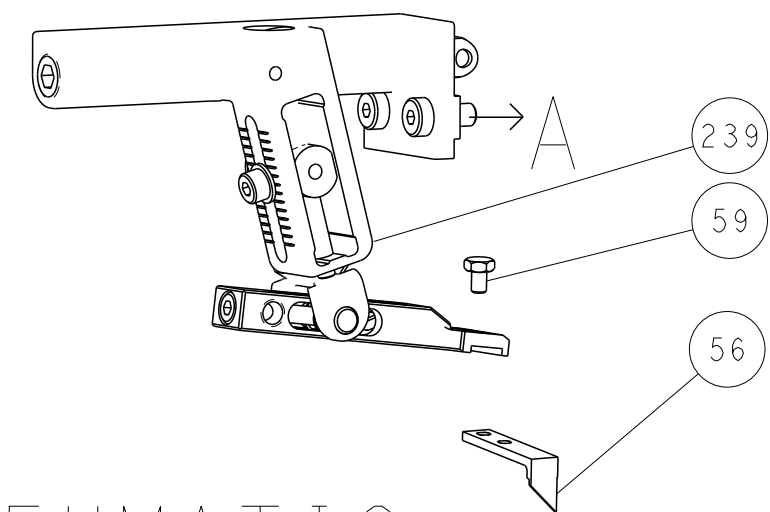
Main parts list table with columns: QTY, PART NO, DESCRIPTION, ITEM NO. Includes items like 7-18023-7 SCR, SKT HD CAP M3 X 4.0 (241), 2168400-6 SHCS, LOW HEAD, RoHS, M5 X 16 (240), 2119580-1 MECHANICAL FEED ASSEMBLY (239), 2063440-1 AIR FEED MODULE (238), 1655785-9 SCR, BTN SKT HD CAP (M3 X 6) (230), 2119740-2 TAG, IDENTIFICATION (213), 1901094-3 SPACER, FEEDER (198), 1976053-4 LOCATER BLOCK, TERMINAL (179), 9931111-1 PIN, SLOTTED SPRING 3.0 X 20.0 (177), 8-22280-7 SPRING, COMPRESSION (176), 1752353-2 GUIDE PIN, HOLLOWDOWN (175), 1901680-2 GUIDE PIN, HOLLOWDOWN (174), 21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT (172), 994969-1 MAGNET, RARE EARTH HIGH ENERGY (166), 994970-2 COUNTER, MAGNETIC (164), 240638-1 SPRING, FEED FINGER (163), 8-21084-1 O-RING, .801 ID, .070 DIA. MAT. (152), 2119641-2 FEED CAM, AIR FEED (151), 2119798-2 DETENT PIN (145), 2079383-8 SCR, BHSC, RoHS (M4 X 16) (144), 2168400-5 SHCS, LOW HEAD, RoHS, M4 X 20 (143), 2119653-2 FEED CAM, POST FEED (142), 1-2119656-0 APPLICATOR BASIC ASSEMBLY, SF (141), 2119650-1 RAM, ASIAN STYLE, SIDE FEED (140), 2119092-2 BOLT, ADJUSTMENT (139), 3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854 (137), 2119799-1 HOLDER, FEED FINGER, AF (136), REF REF REF REF REF SEE NOTE 4 MEMORY CHIP, PROGRAMMED (135), 1633743-1 SERVO FEED LATCH ASM (133), 1-18028-2 WASHER, FLAT, REG M4 (119), 2119944-1 FEED FINGER ASSEMBLY, SF (117), 2119955-1 ASSY, LUBRICATOR, SIDE FEED (113), 1-1-1-1-1-1 455888-5 SPACER, CRIMPER (82), 1-2079383-0 SCR, BHSC, RoHS (M3 X 6) (79), 1633782-2 FENCE (78), 2119956-1 DOCUMENTATION PACKAGE (71), 2119740-1 TAG, IDENTIFICATION (67), 2-2-2-2-2-2 2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188 (66), 2119793-1 LIMITER, ADJUSTMENT BOLT (63), 3-3-3-3-3-3 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), 1-1-1-1-1-1 985575-4 SCR, FLT SKT HD CAP M3 X 12.0 (57), 1-1-1-1-1-1 1338685-1 PAWL, FEED (56), 1-5018030-0 NUT, HEX, REG, RoHS, M3.5 (52), 1901681-4 HOLLOWDOWN, TERMINAL (51), 1-1752354-8 STANDOFF, HOLD-DOWN (50), 18023-9 SCR, SKT HD CAP M4 X 6.0 (49), 2119652-1 FEED CAM, PRE FEED (48), 2079383-7 SCR, BHSC, RoHS (M8 X 25) (41), 2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT (40), 2119957-1 APPLICATOR SHIM PACK (39), 2119644-1 RAM WASHER, PRECISION (38), 1752356-6 SUPPORT, TERMINAL (34), 2-2-2-2-2-2 2079383-5 SCR, BHSC, RoHS (M4 X 20) (33), 1-1-1-1-1-1 2161328-1 HEX HEAD, FLANGED, M5 x 8mm LONG (32), 1-1320908-0 SPACER, STRIP GUIDE (30), 2119959-2 ASSEMBLY, STRIP GUIDE (29), 1-455888-0 SPACER, CRIMPER (28), 1320928-2 STRIP GUIDE (24), 1-1-1-1-1-1 2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0 (21), 1-18028-2 WASHER, FLAT, REG M4 (20), 2119533-1 STRIPPER, SIDE FEED (19), 2119806-1 INSERT, SHEAR (13), 3-22280-3 SPRING, COMPRESSION (12), 1-356885-4 STOP, SHEAR (11), 2119805-1 SHEAR HOLDER, FRONT (10), 318707-1 FLOATING SHEAR, FRONT (9), 6-1333201-7 ANVIL, COMBINATION (8), 2119781-1 DEPRESSOR, SHEAR (5), 238011-4 BLOCK, CRIMPER SPACER (4), 1633965-1 CRIMPER, INSULATION O PREMIUM (3), 455888-7 SPACER, CRIMPER (2), 1-456402-7 CRIMPER, WIRE PREMIUM (1).

Technical drawing footer including dimensions, tolerances, material, weight, and customer information. Includes dimensions: MIN, 0 PLC, 1 PLC, 3 PLC, 4 PLC, ANGLES, FINISH. Tolerances unless otherwise specified: 0 PLC, 1 PLC, 3 PLC, 4 PLC. Material: . WEIGHT: A1 00779. Customer Accessible Production Drawing. SCALE: 1:2. SHEET 3 OF 4. REV G. SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION.

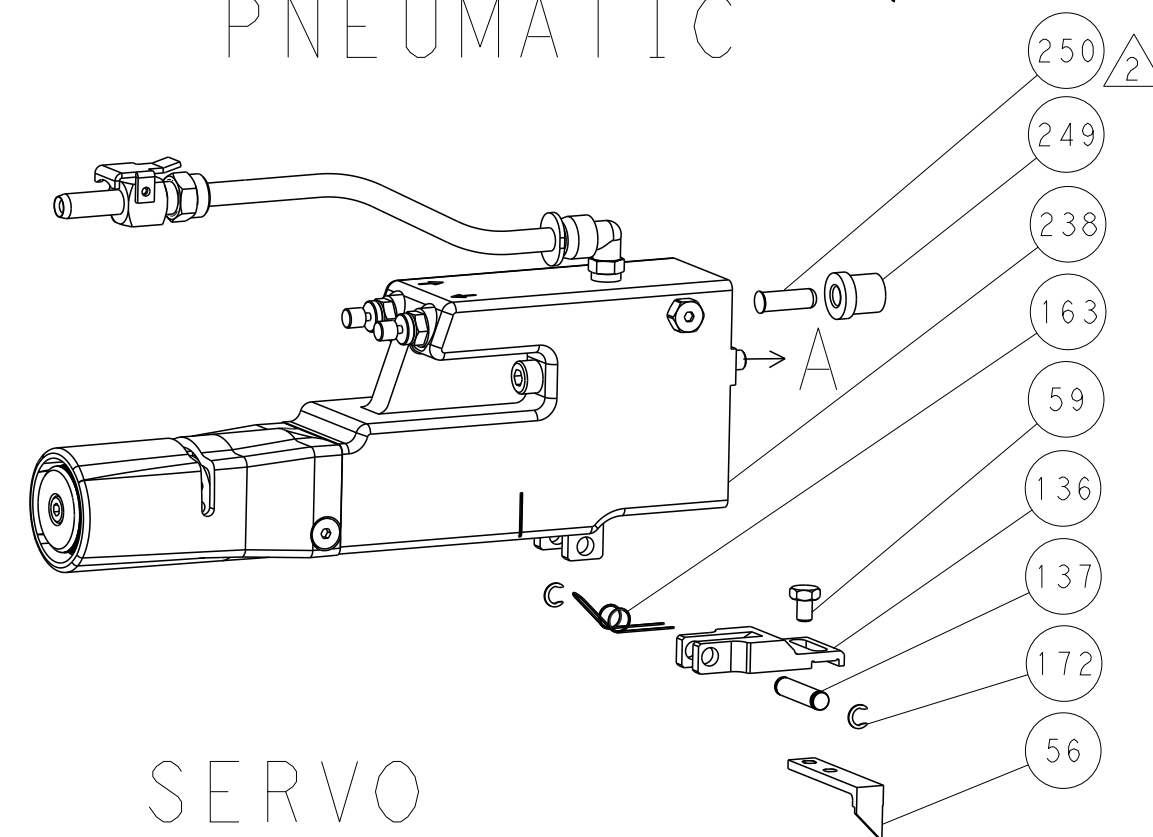


LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1			

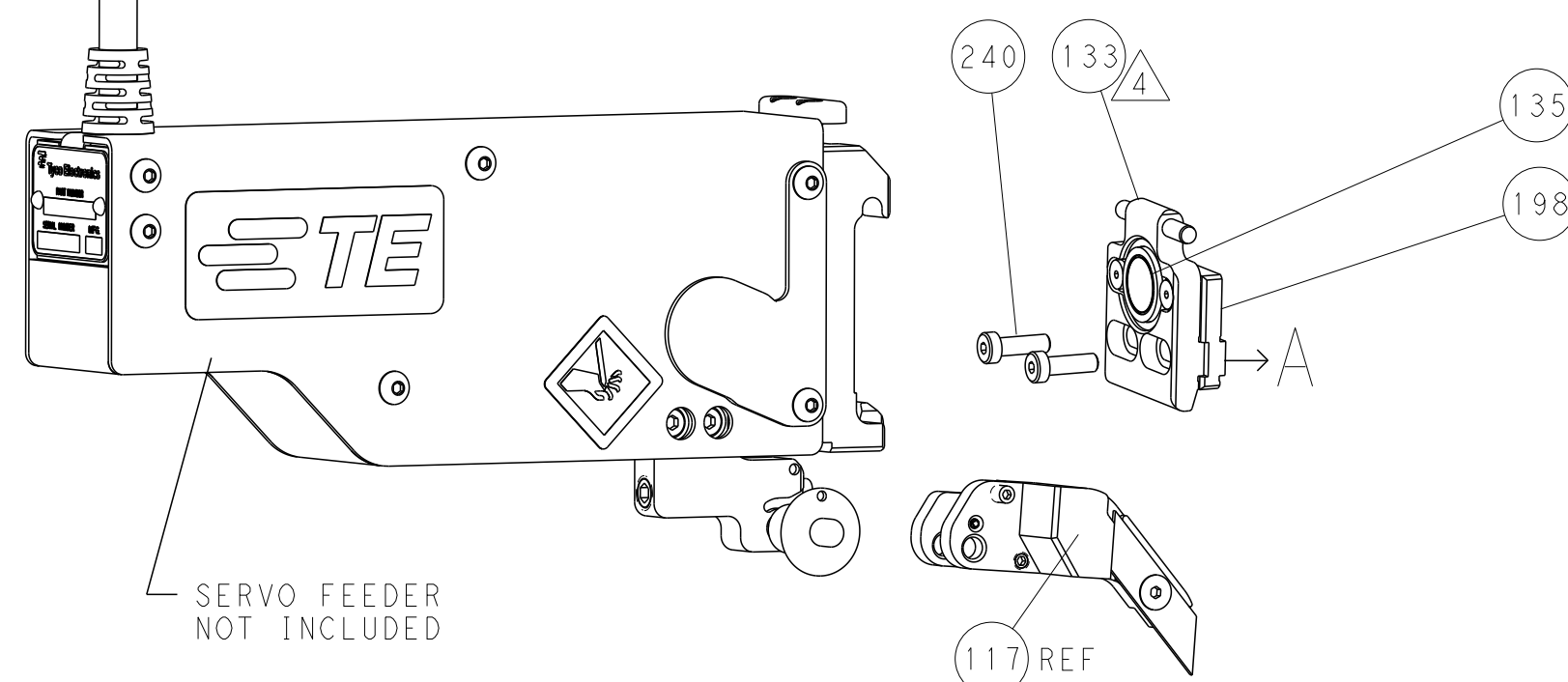
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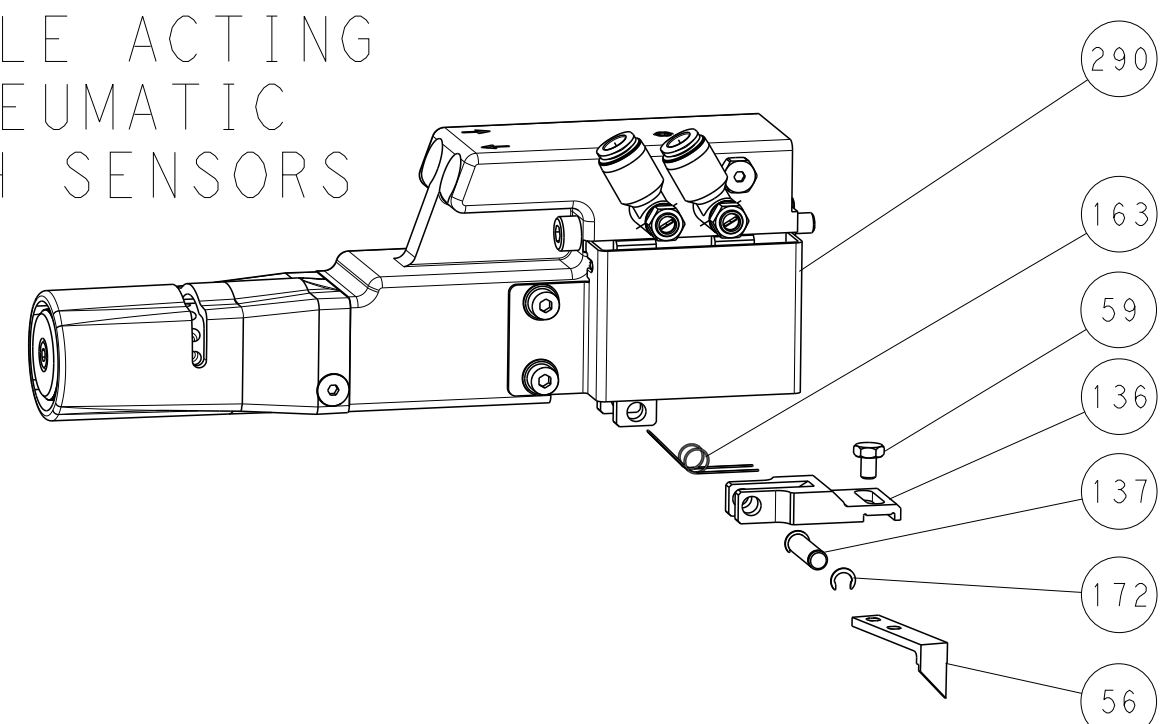
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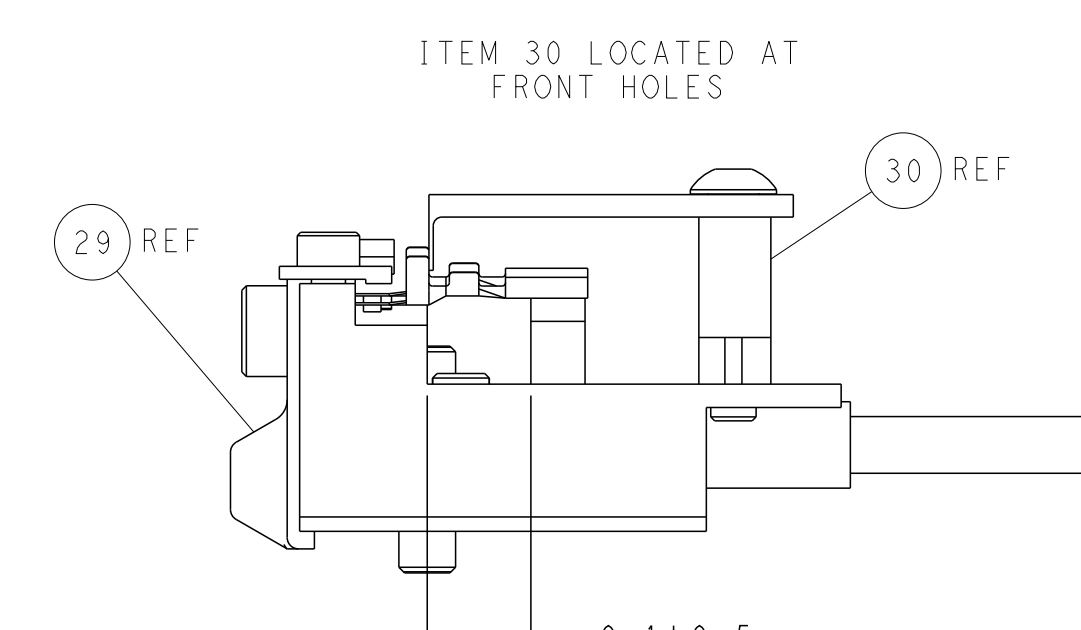
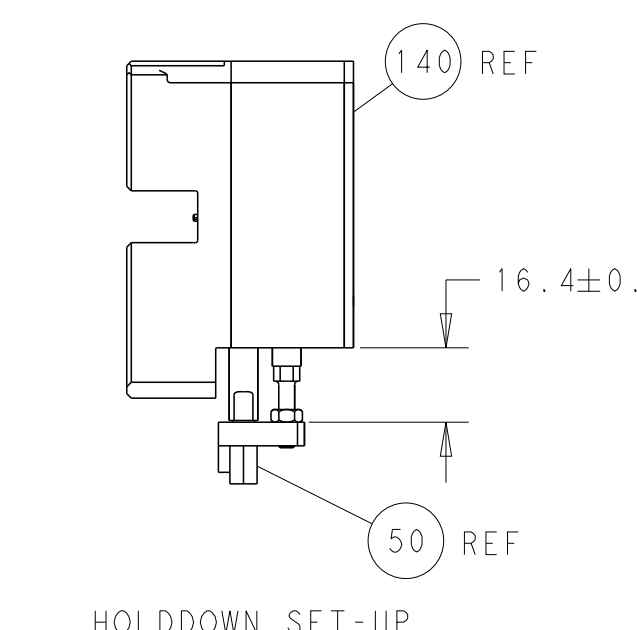
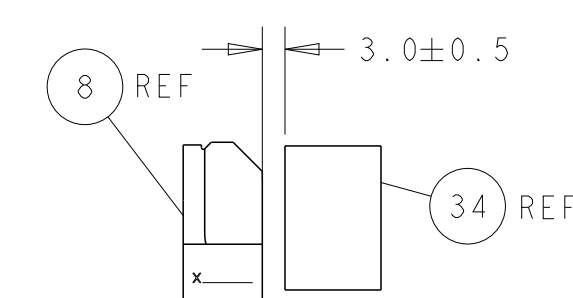
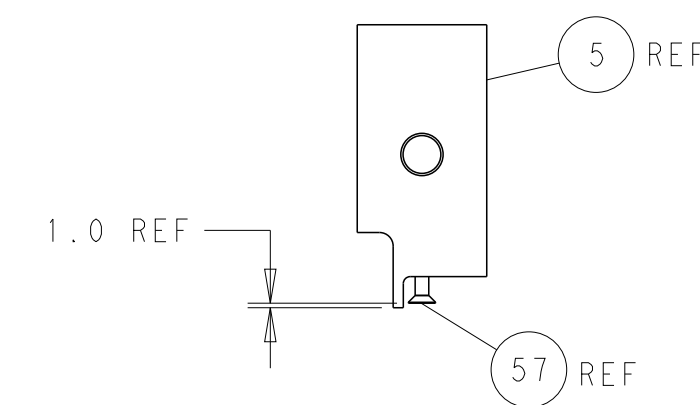
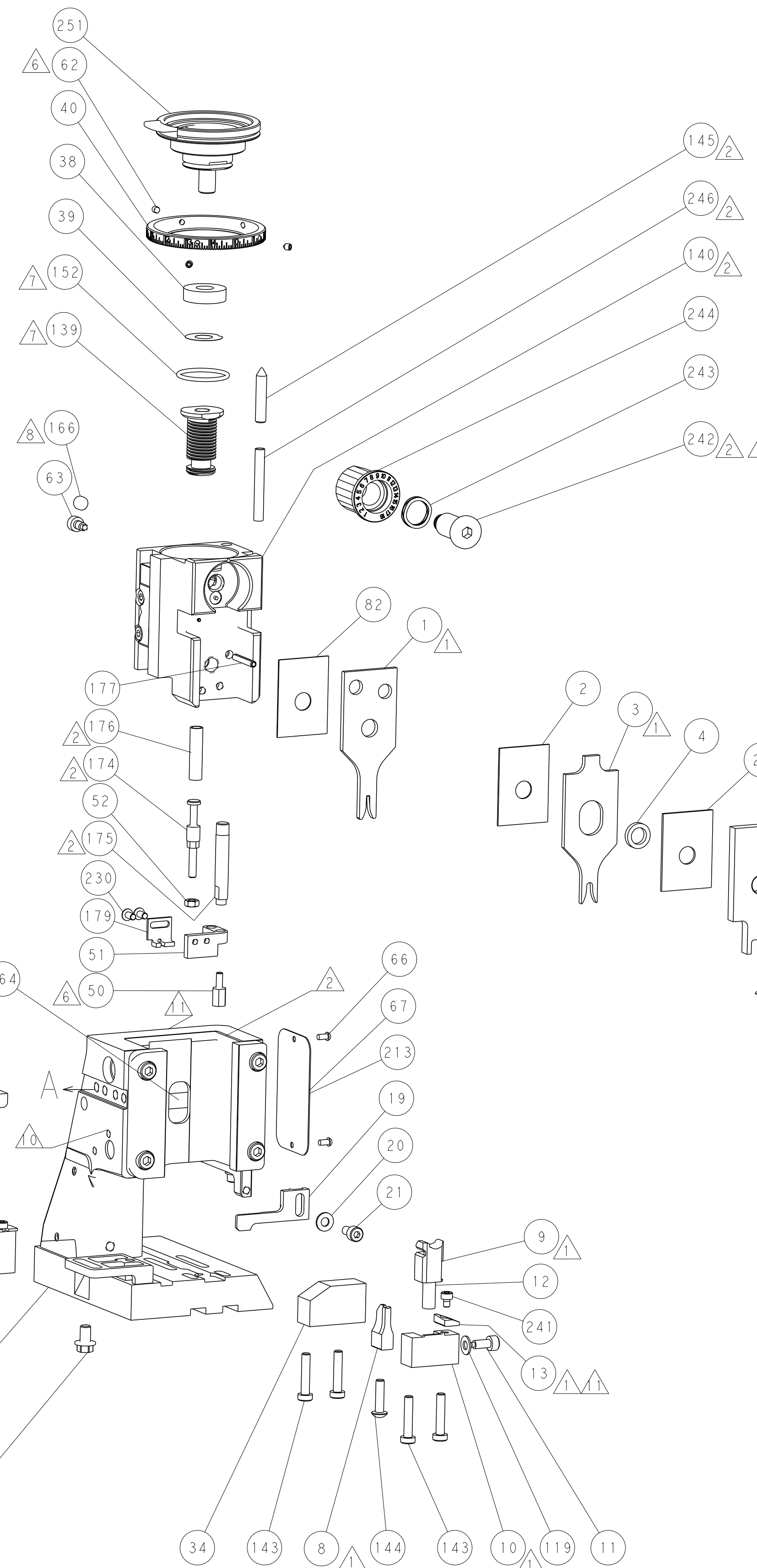
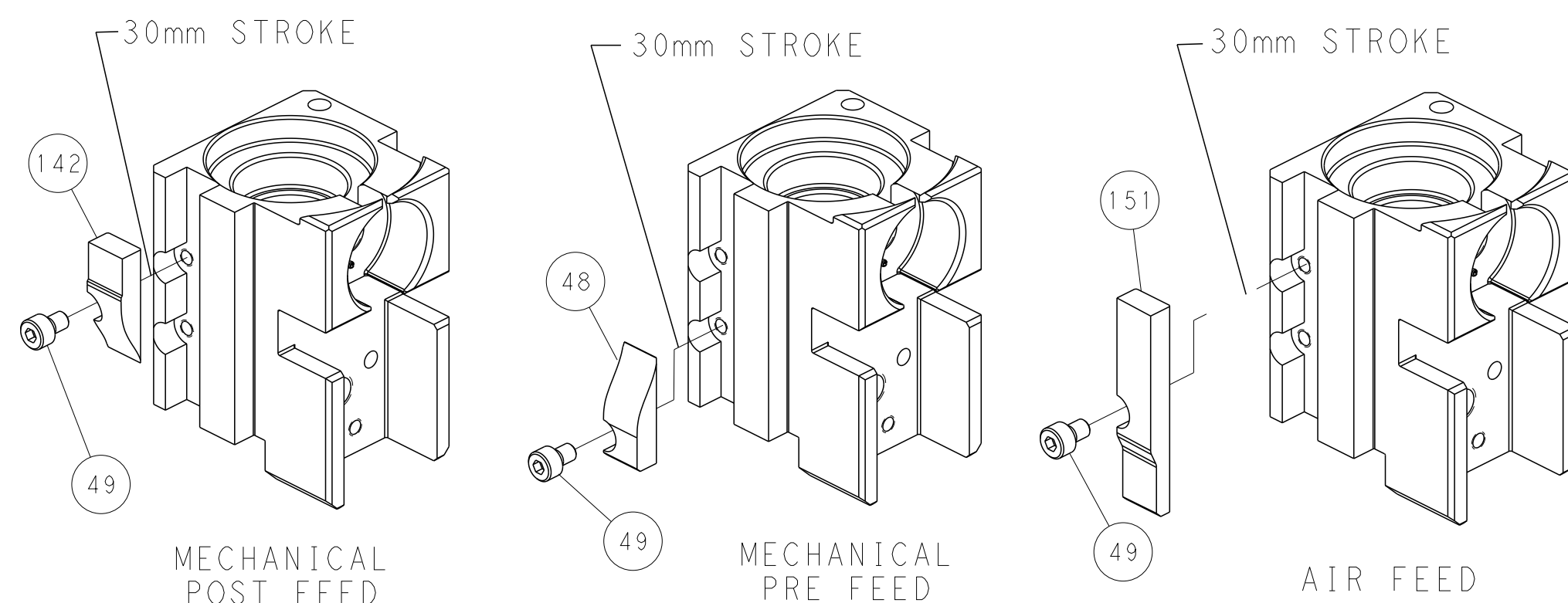
# SERVO LATCH PLATE



# DOUBLE ACTING PNEUMATIC WITH SENSORS



# 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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DWN R. HUANG 02SEP2011 CHK S. XI 02SEP2011 APVD S. XI 02SEP2011 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2151036 SCALE 1:2 SHEET 4 OF 4 REV G	
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