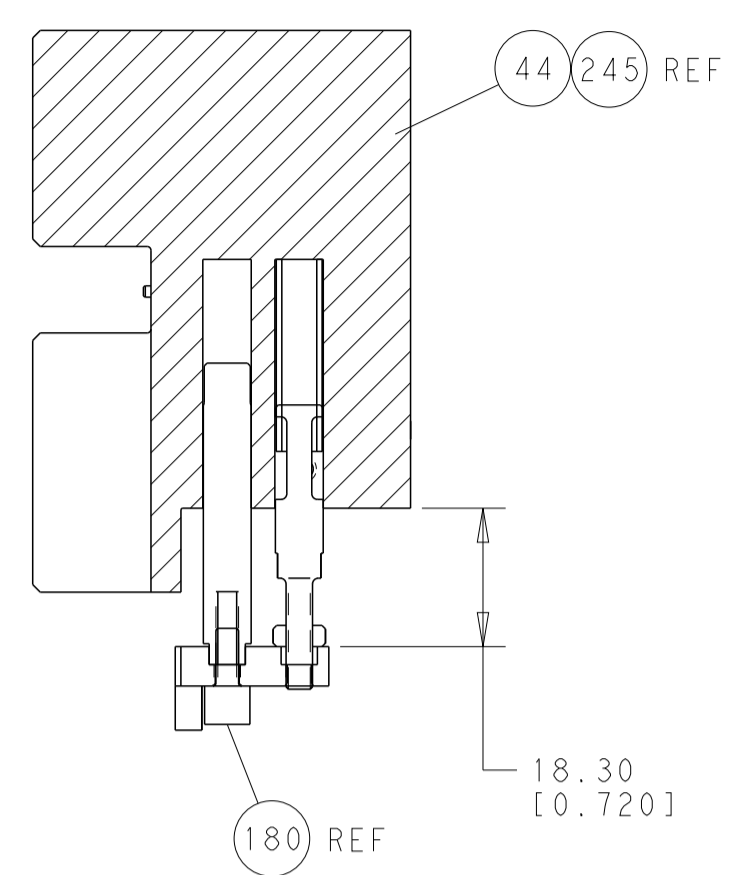
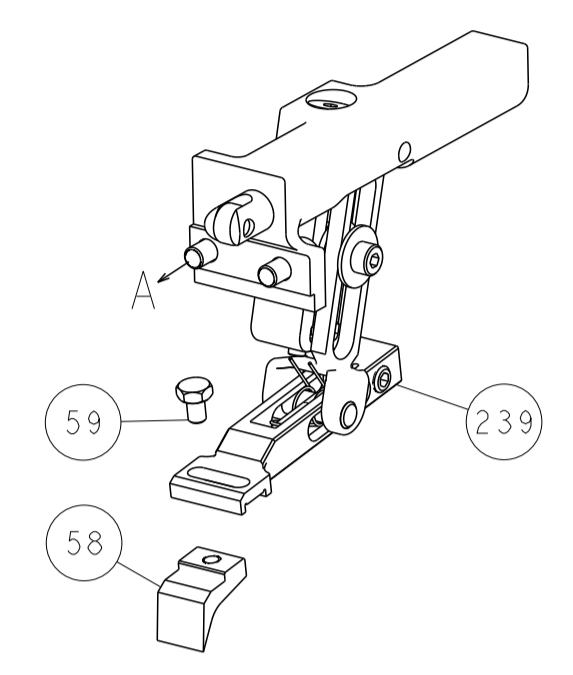


LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DATE	BY	APPV
- SEE SHEET 1			-	-	-

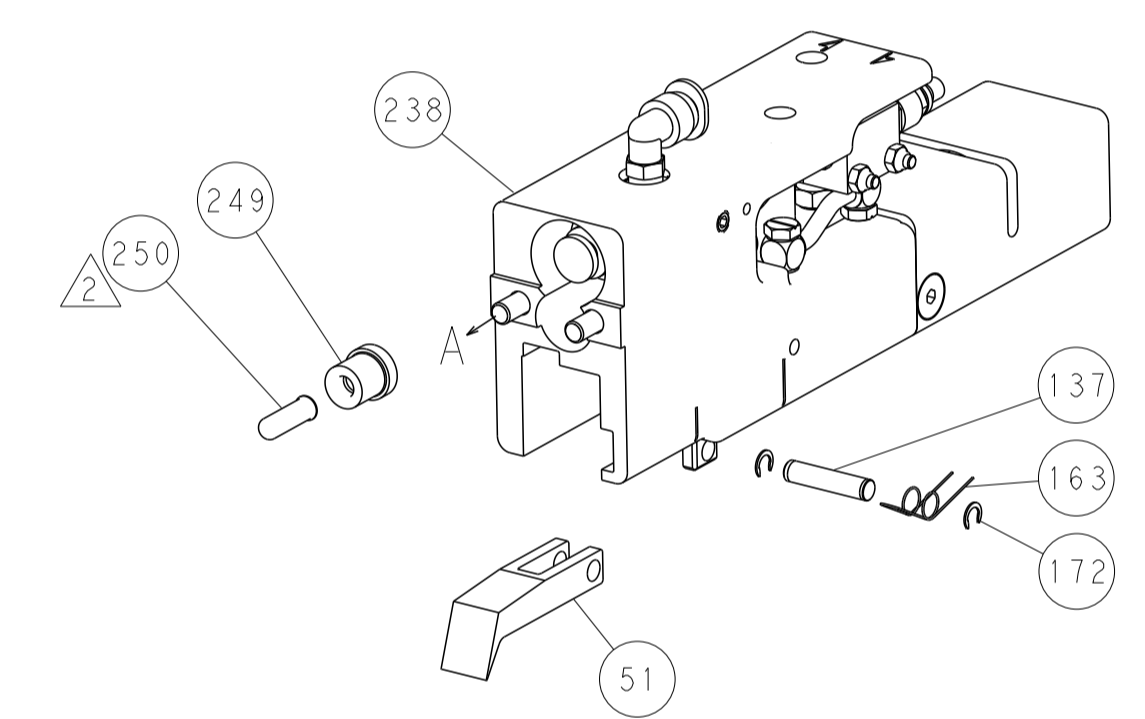


HOLDDOWN SET-UP

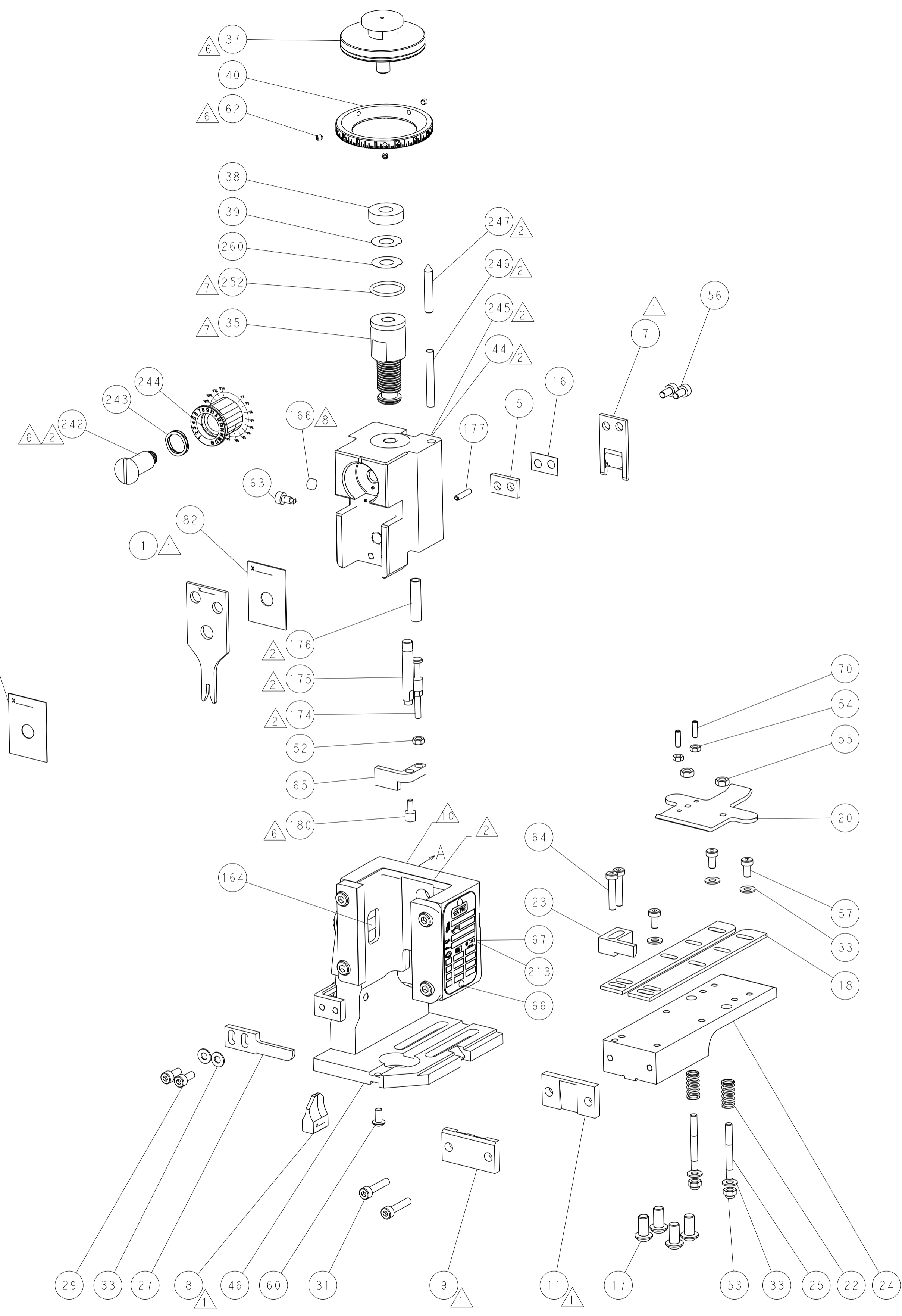
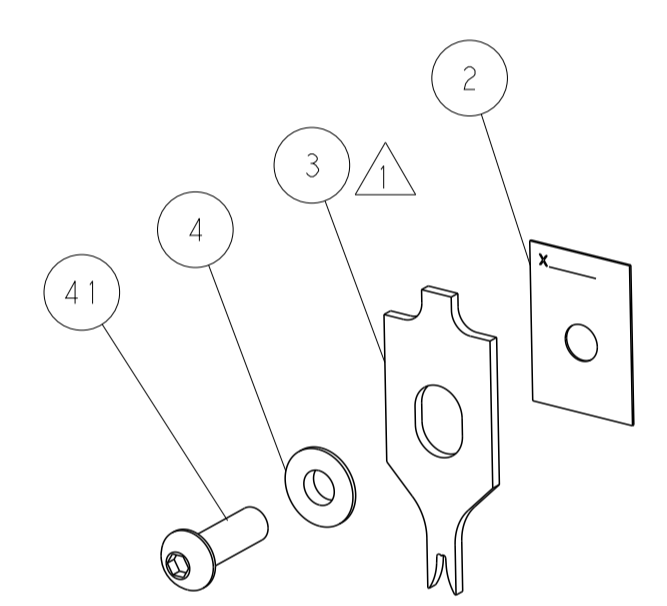
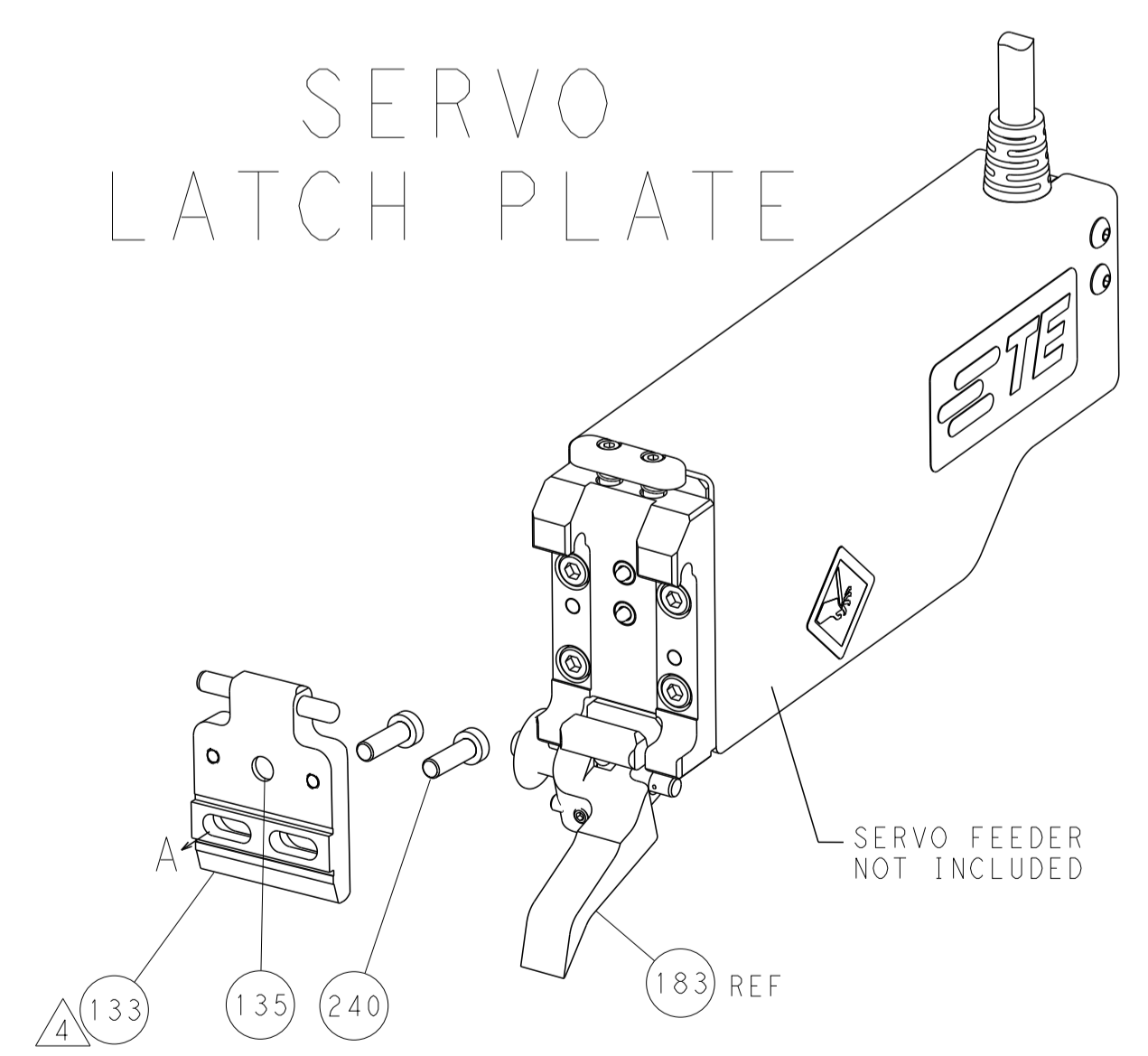
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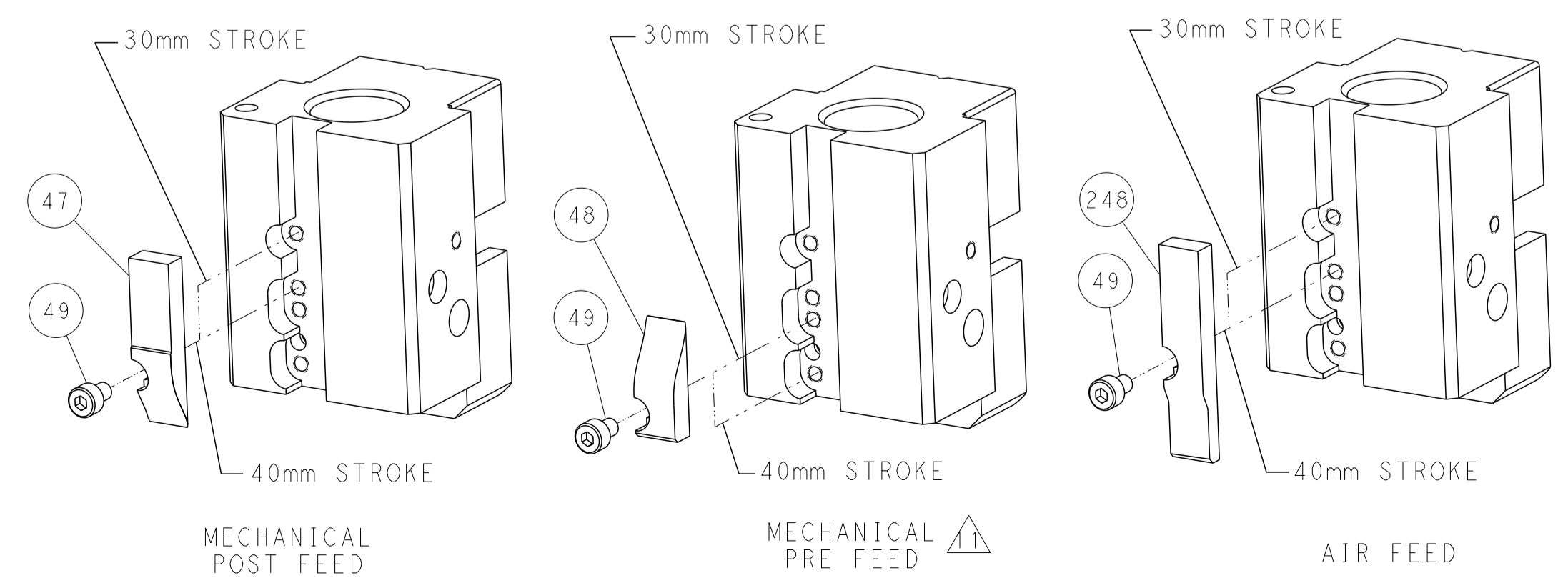
PNEUMATIC



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.013 3 PLC ±0.001 4 PLC ±0.001 ANGLES FINISH		DWN K. HUANG 07AUG2014 CHK L. ZHANG 07AUG2014 APVD JJ. GUO 07AUG2014 NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2150468 Customer Accessible Production Drawing SCALE 1:1 SHEET 2 OF 4 REV A	
MATERIAL:		FINISH:		WEIGHT:	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						PNEUMATIC FEED	2119950-1	2119792-2	-	2119641-2	-
	2-2150468-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150468-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150468-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150468-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	1901697-1	8-2150468-5	-	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150468-4	-	-	-
					MECHANICAL FEED	2119949-1	2063961-1	5-18022-5	2119653-2	-	-
	2-2150468-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119950-1	2119792-2	-	-	2119641-2	-	2063440-1
	2-2150468-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2150468-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.40 mm [.094]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: STOCKO TERMINAL STOCKO CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH 3.00-4.00 mm [.118-.157 IN]		INSULATION DIAMETER RANGE 2.80 mm [.110 IN] MAX	
TERMINAL APPLICATION SPECIFICATION F129 Rev -			
TERMINALS APPLIED			
TE TERMINAL	STOCKO TERMINAL	TE TERMINAL	STOCKO TERMINAL
2113552-1	RSB7990.001 F 2.8-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.21+/-0.02 [.048+/-0.001]	6.4
0.75mm2	1.13+/-0.02 [.044+/-0.001]	7.1
20 AWG OR 0.50mm2	1.06+/-0.02 [.042+/-0.001]	7.9

- 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: 8-2150468-4
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150468-4
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150468-5
- 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 ITEMS 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
- 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 THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.

***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.

-77-27-25-22-21	PART NO	DESCRIPTION	ITEM NO
- 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	1-22279-3	SPRING, COMPRESSION	246
- 1 1 1 1 1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243

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

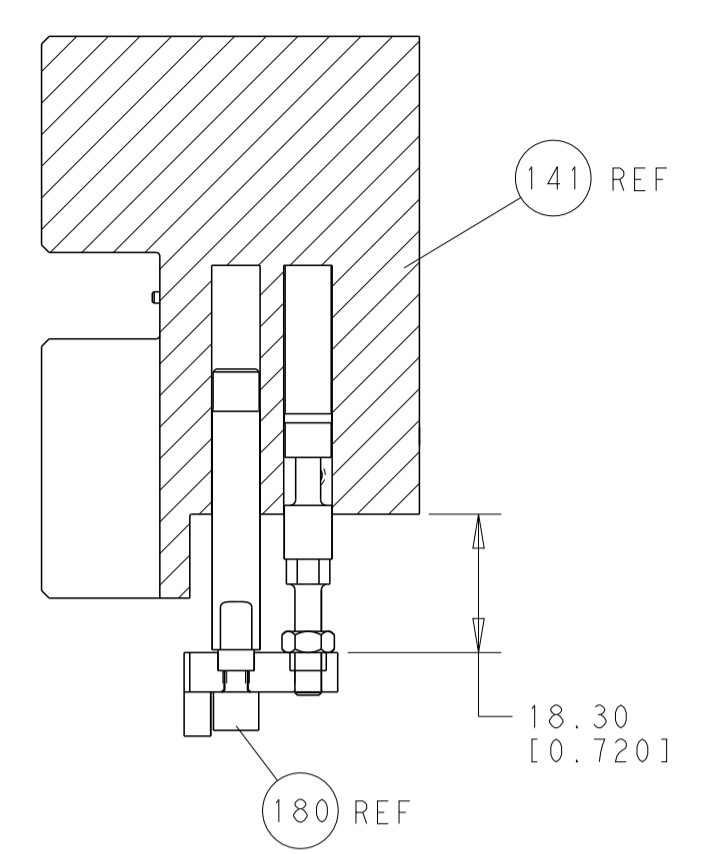
SET UP GAUGE	LOC	DIST	REV	DATE	BY	CHK
2119599-2	A	66				

REVISIONS							
P	LTN	DESCRIPTION	DATE	OWN	APVD		
-	-	SEE SHEET 1	-	-	-	-	
6	-	1 1 1 1	2119083-1	RETAINER, INSULATION DIAL		242	
-	-	2 - - -	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10		240	
-	-	- - - 1	2119580-1	MECHANICAL FEED ASSEMBLY		239	
-	-	- - - 1	2063440-1	AIR FEED MODULE		238	
-	-	- 1 - -	2119740-2	TAG, IDENTIFICATION		213	
-	-	4 4 4 4	2079383-9	SCR, BHSC, RoHS (M6 X 20)		186	
-	-	- REF - -	1901697-1	FEED FINGER ASSEMBLY, EF		183	
6	-	1 1 1 1	1752354-5	STANDOFF, HOLD-DOWN		180	
-	-	1 1 1 1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0		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	994969-1	MAGNET, RARE EARTH HIGH ENERGY		166	
-	-	REF REF REF REF	994970-2	COUNTER, MAGNETIC		164	
-	-	- - 1 -	240638-1	SPRING, FEED FINGER		163	
-	-	1 1 1 1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.		153	
-	-	- - 1 -	2119641-2	FEED CAM, AIR FEED		152	
-	-	1 1 1 1	2119798-2	DETENT PIN		145	
-	-	1 1 1 1	2079383-8	SCR, BHSC, RoHS (M4 X 16)		144	
-	-	- - - 1	2119653-2	FEED CAM, POST FEED		142	
-	-	1 1 1 1	2119655-6	APPLICATOR BASIC ASSEMBLY, EF		141	
-	-	1 1 1 1	2119651-1	RAM, ASIAN STYLE, END FEED		140	
-	-	1 1 1 1	2119092-2	BOLT, ADJUSTMENT		139	
-	-	- - 1 -	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854		137	
-	-	- REF - -	SEE NOTE 4	MEMORY CHIP, PROGRAMMED		135	
-	-	1 - - -	1633743-1	SERVO FEED LATCH ASM		133	
-	-	1 1 1 1	455888-7	SPACER, CRIMPER		82	
-	-	1 1 1 1	2119956-2	DOCUMENTATION PACKAGE		71	
-	-	2 2 2 2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0		70	
-	-	1 - 1 1	2119740-1	TAG, IDENTIFICATION		67	
-	-	2 2 2 2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66	
-	-	1 1 1 1	1901681-5	HOLDDOWN, TERMINAL		65	
-	-	2 2 2 2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20		64	
-	-	1 1 1 1	2119793-1	LIMITER, ADJUSTMENT BOLT		63	
6	-	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	2063961-1	FEED FINGER		58	
-	-	3 3 3 3	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8		57	
-	-	2 2 2 2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		56	
-	-	2 2 2 2	5018030-2	NUT, HEX, REG, RoHS, M4		55	
-	-	2 2 2 2	5018030-1	NUT, HEX, REG, RoHS, M3		54	
-	-	2 2 2 2	986965-8	NUT, LOCK, HEX, TORQUE (M4)		53	
-	-	1 1 1 1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5		52	
-	-	- - 1 -	2119792-2	PAWL, EF, AIR		51	
-	-	- - 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	2119644-1	RAM WASHER, PRECISION		38	
-	-	7 7 7 7	1-18028-2	WASHER, FLAT, REG M4		33	
-	-	2 2 2 2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20		31	
-	-	2 2 2 2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		29	
-	-	1 1 1 1	240639-1	STRIPPER (MACHINING)		27	
-	-	2 2 2 2	1320906-1	STUD, THREADED		25	
-	-	1 1 1 1	1-1752371-6	PLATE, STRIP GUIDE		24	
-	-	1 1 1 1	240825-6	PLATE, STRIP HOLD DOWN		23	
-	-	2 2 2 2	2-22281-3	SPRING, COMPRESSION		22	
-	-	1 1 1 1	1752373-4	DRAG		20	
-	-	2 2 2 2	1901259-4	GUIDE, LOWER STRIP		18	
-	-	1 1 1 1	4-240641-3	SPACER		16	
-	-	1 1 1 1	1-240644-7	PLATE, REAR SHEAR		11	
-	-	- - - -	-	-		10	
1	1	1	1	1	3-690482-2	PLATE, FRONT SHEAR	9
1	1	1	1	1	1-1803060-0	ANVIL, COMBINATION, END FEED	8
1	1	1	1	1	1-2217206-0	BLADE, SLUG	7
-	-	- - - -	-	-	-	-	6
-	-	1 1 1 1	240641-7	SPACER		5	
-	-	1 1 1 1	238009-4	BLOCK, FL CRIMPER SPACER		4	
1	1	1	1	1	2-1803016-3	CRIMPER, INSULATION F	3
-	-	1 1 1 1	455888-4	SPACER, CRIMPER		2	
1	1	1	1	1	3-456405-4	CRIMPER, WIRE PREMIUM	1

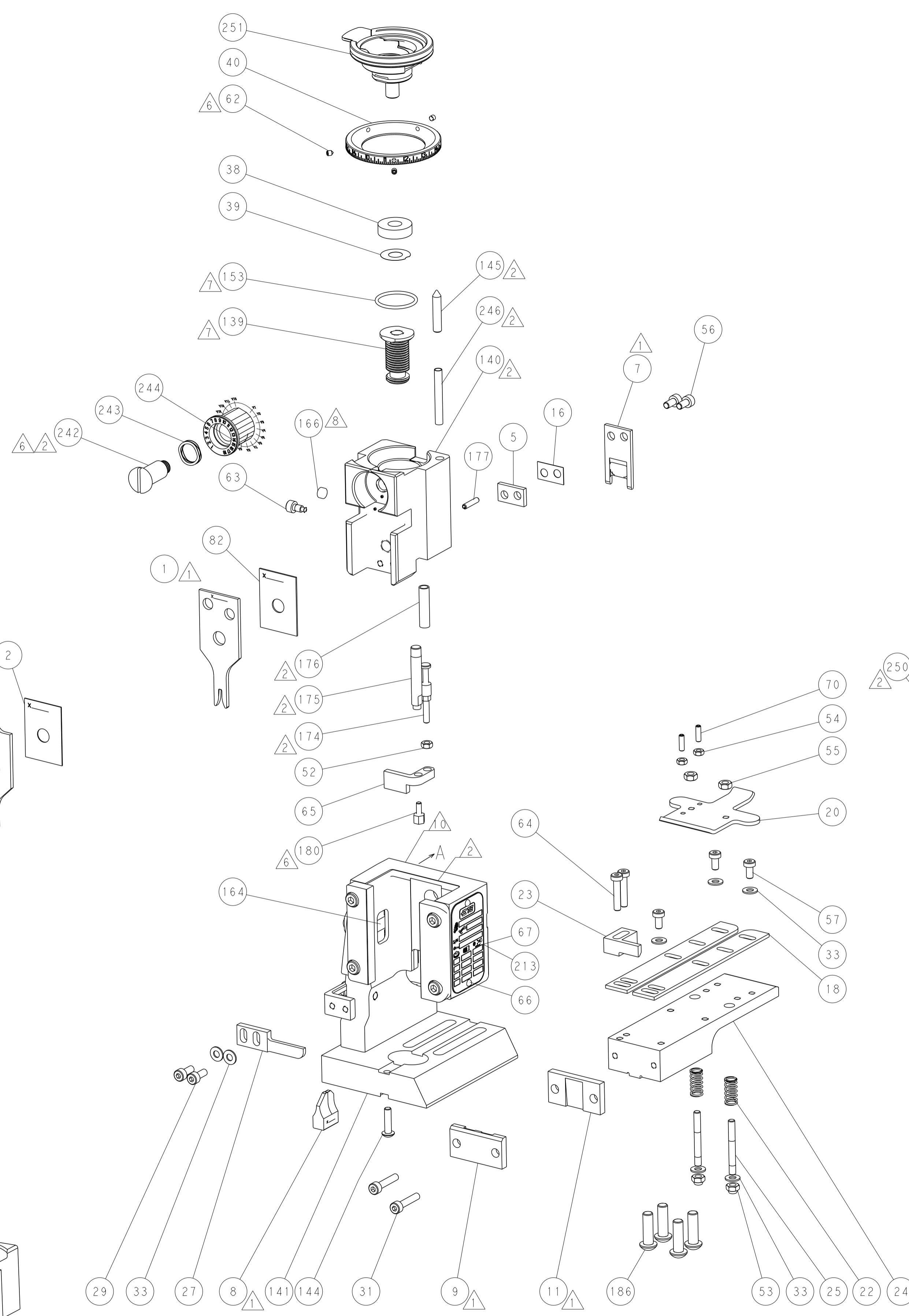
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MATERIAL:		FINISH:		DWG	
-		-		R. HUANG	
-		-		L. ZHANG	
-		-		APVD	
-		-		U. GUO	
-		-		07AUG2014	
-		-		NAME	
-		-		Ocean End Feed	
-		-		Applicator	
-		-		SIZE	
-		-		A1	
-		-		CAGE CODE	
-		-		00779	
-		-		DRAWING NO	
-		-		2150468	
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-		-		-	
-		-		Customer Accessible Production Drawing	
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LOC	DIST	REV	DATE	BY	APPV
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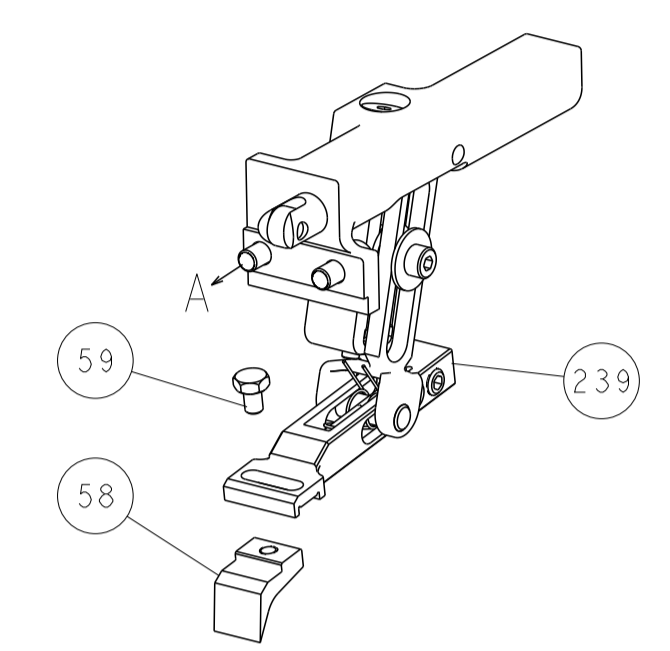
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NO.	DESCRIPTION	DATE	BY
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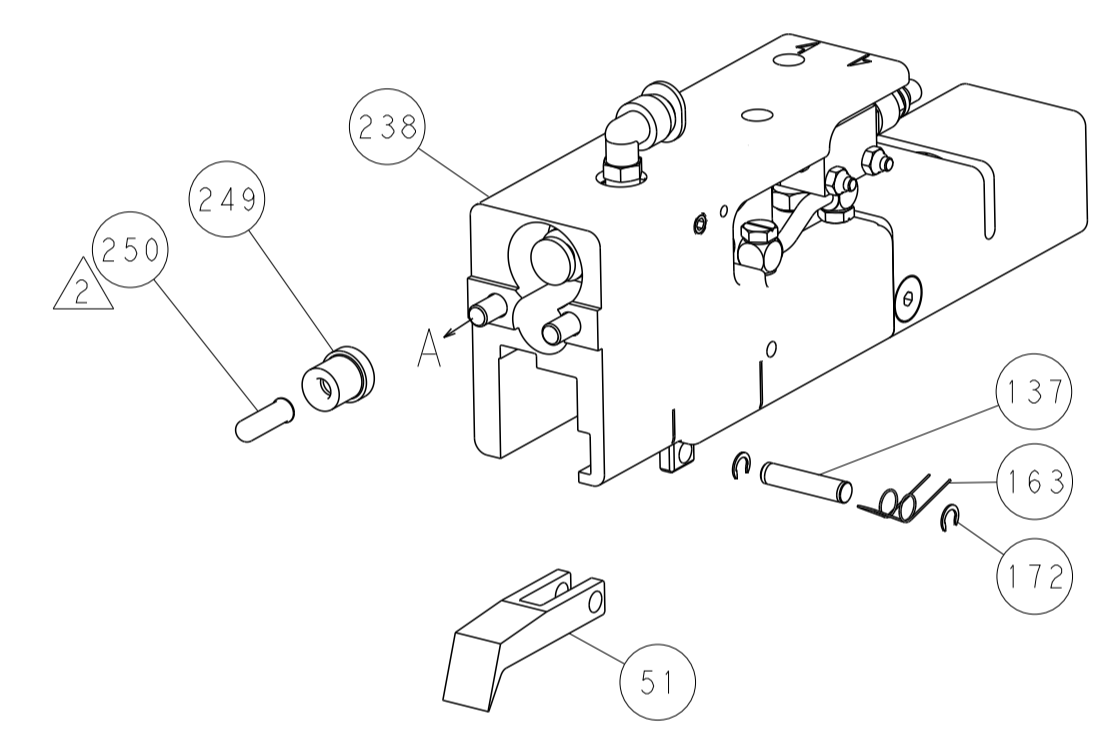
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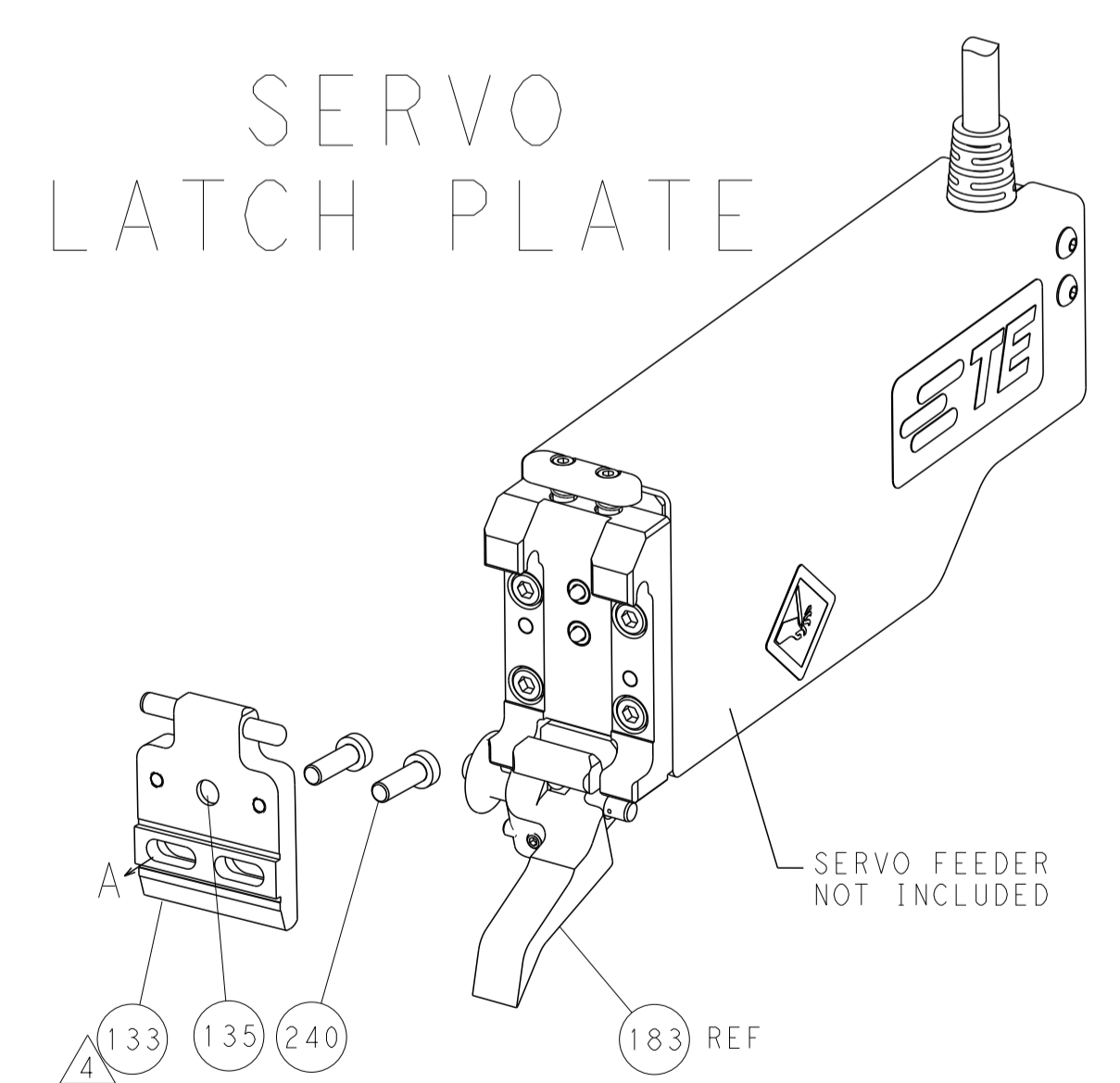
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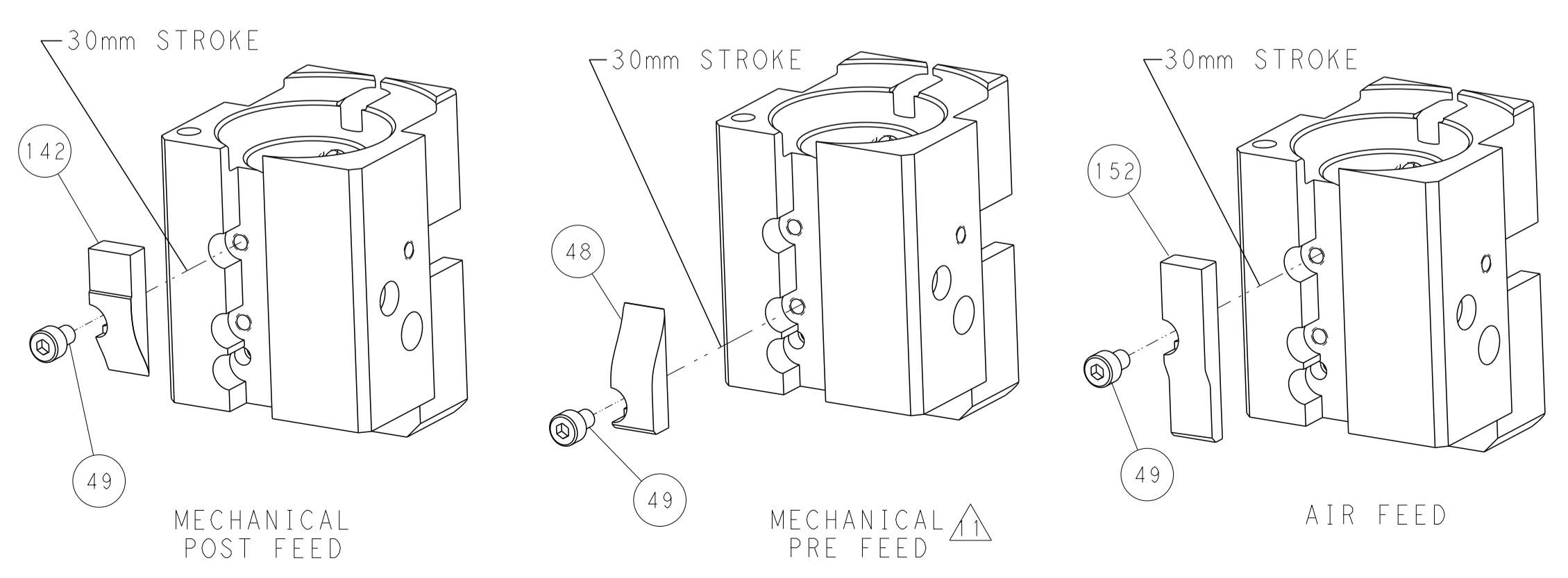
PNEUMATIC



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH ±.		DWN R. HUANG 07AUG2014 CHK L. ZHANG 07AUG2014 APVD JJ. GUO 07AUG2014 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean End Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2150468 SCALE 1:1 SHEET 4 OF 4 REV A		RESTRICTED TO - - -	
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