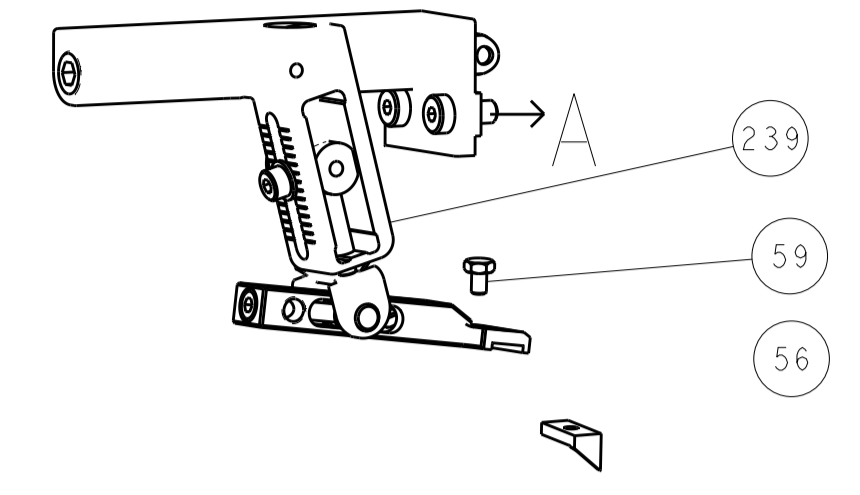


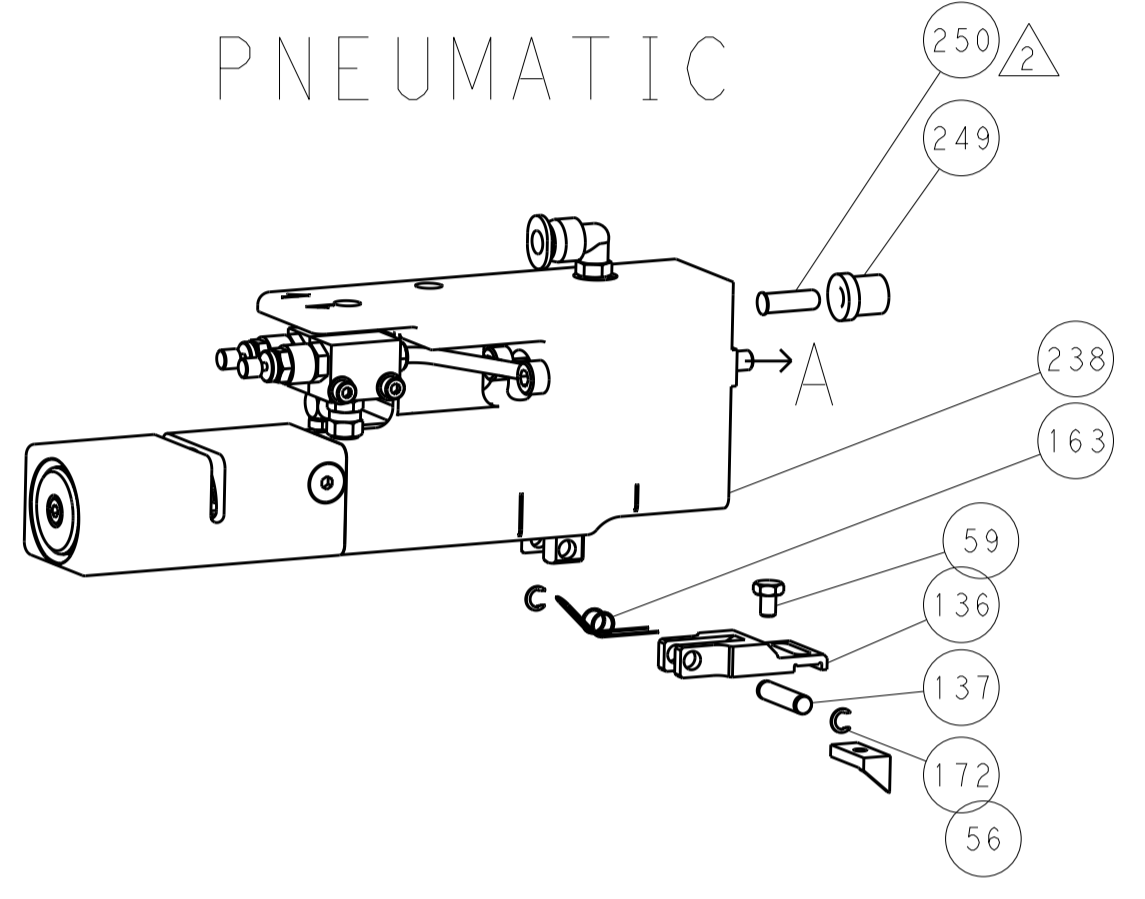


LOC		DIST		REVISONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

### FEED TYPE MECHANICAL



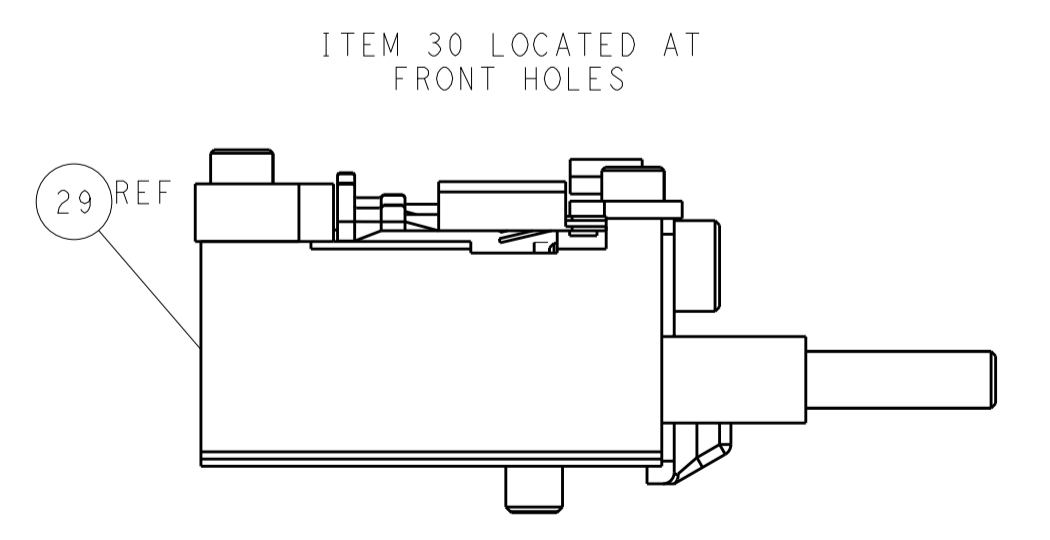
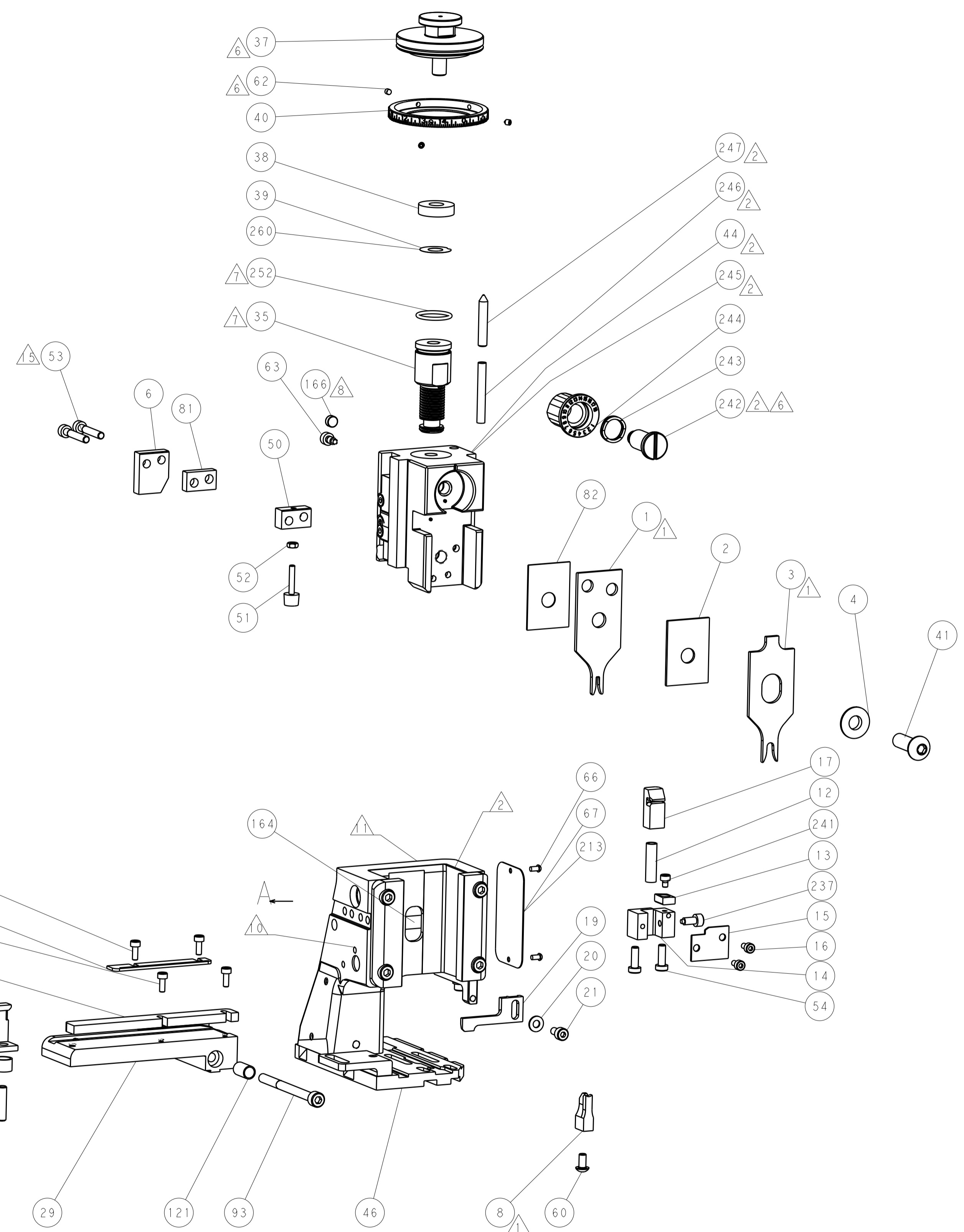
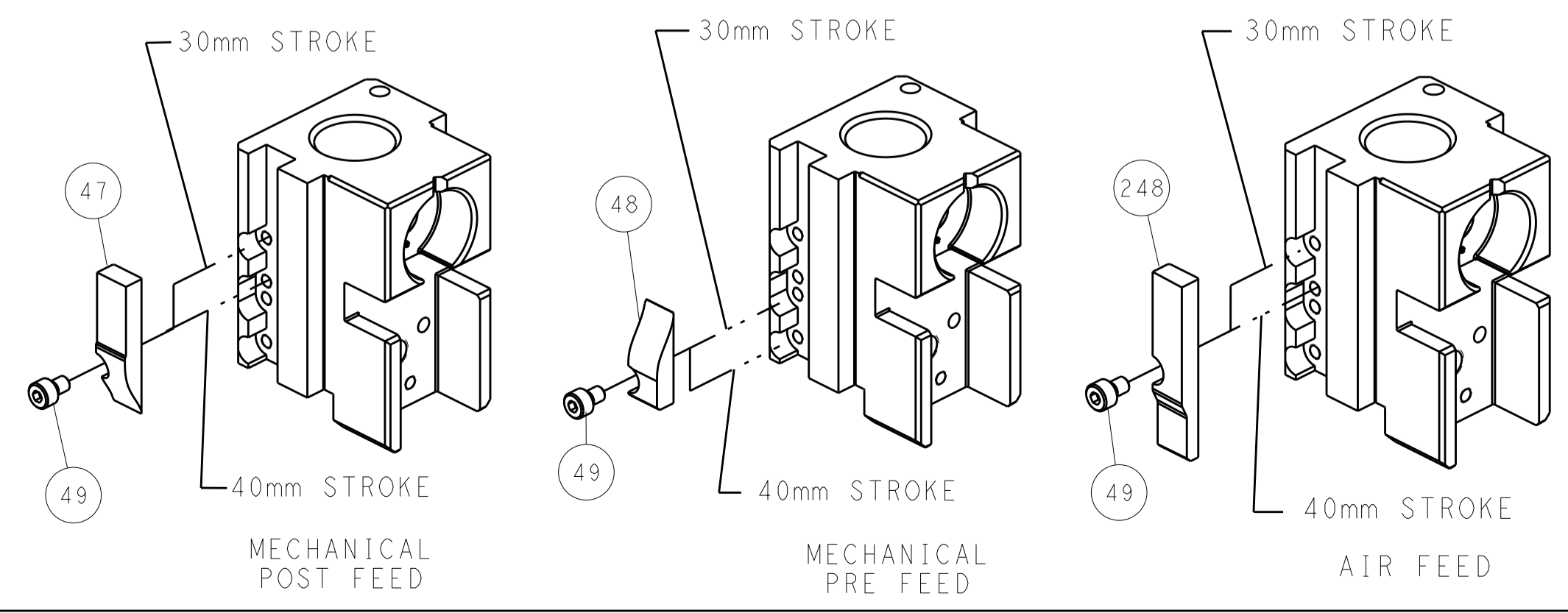
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



FEED TRACK POSITION GUIDE BY GUIDE\_BY\_STR

**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:		DWN Y. YIN 11APR2014		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	CHK G. BAILEY 11APR2014	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD H. GUO 11APR2014		NAME	
				PRODUCT SPEC		Ocean Side Feed	
				APPLICATION SPEC		Applicator	
				WEIGHT		SIZE CAGE CODE DRAWING NO	
				Customer Accessible Production Drawing		A1 00779 ©=2266255	
				SCALE 1:2		RESTRICTED TO	
				SHEET 2 OF 4		REV A	

APPLICATOR STYLE CONVERSION CHART. Table with columns: CONVERT TO, PART NUMBERS REQUIRED. Includes rows for PNEUMATIC FEED, SERVO LATCH PLATE, SMART APPLICATOR, MECHANICAL FEED, etc.

APPLICATOR DATA. Table with columns: CRIMP SIZE TYPE, WIRE INSUL. Includes values like 1.78 mm [ .070 ] F, 4.32 mm [ .170 ] O.

TERMINAL DATA: XENIA TERMINAL TE CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, and TERMINALS APPLIED table.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Includes values like 0.50mm2, 1.20+/-0.05 [ .047+/- .002 ], 9.6.



- 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: 8-2266255-4 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266255-4 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266255-5
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 62 & 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.
THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
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.
CUT TO LENGTH AT ASSEMBLY.

\*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 columns: PART NO, DESCRIPTION, ITEM NO. Includes items like 2119782-1 FINE ADJUST HEAD ASM, PACIFIC STYLE, 2119640-1 PUSH ROD, AIR FEED, etc.

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

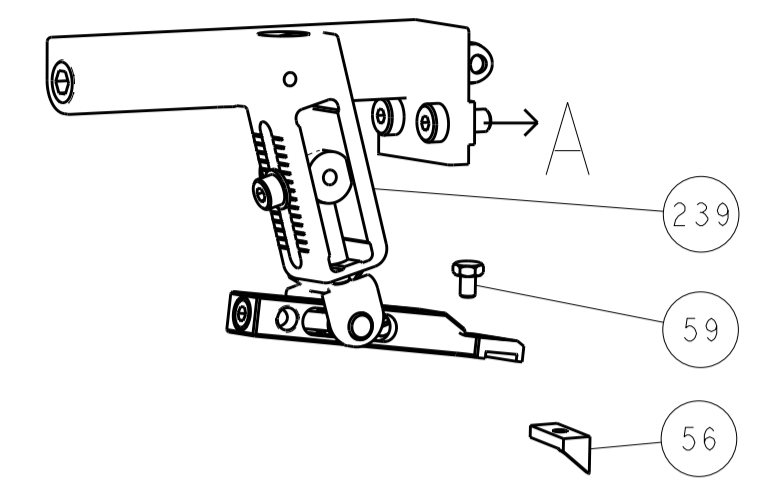
SET UP GAUGE 2119599-1, LOC A, DIST 66. REVISIONS table with columns: REV, LTR, DESCRIPTION, DATE, DWN, APVD.

Main parts list table with columns: QTY, PART NO, DESCRIPTION, ITEM NO. Includes items like 2119580-1 MECHANICAL FEED ASSEMBLY, 2063440-1 AIR FEED MODULE, 356885-4 STOP, SHEAR, etc.

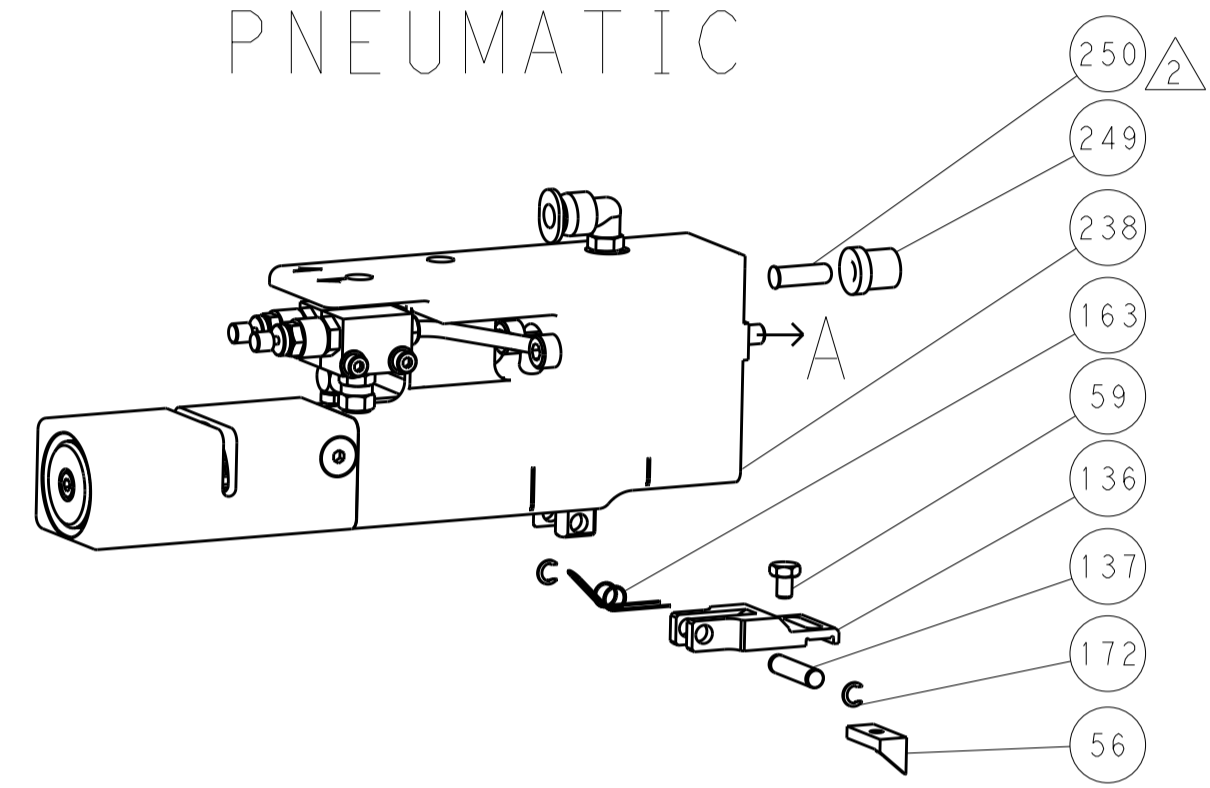
Technical drawing header/footer including dimensions, tolerances, materials, and drawing information like DATE 11APR2014, DRAWN BY Y. LIN, CHECKED BY G. BAILEY, and drawing number 00779.

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

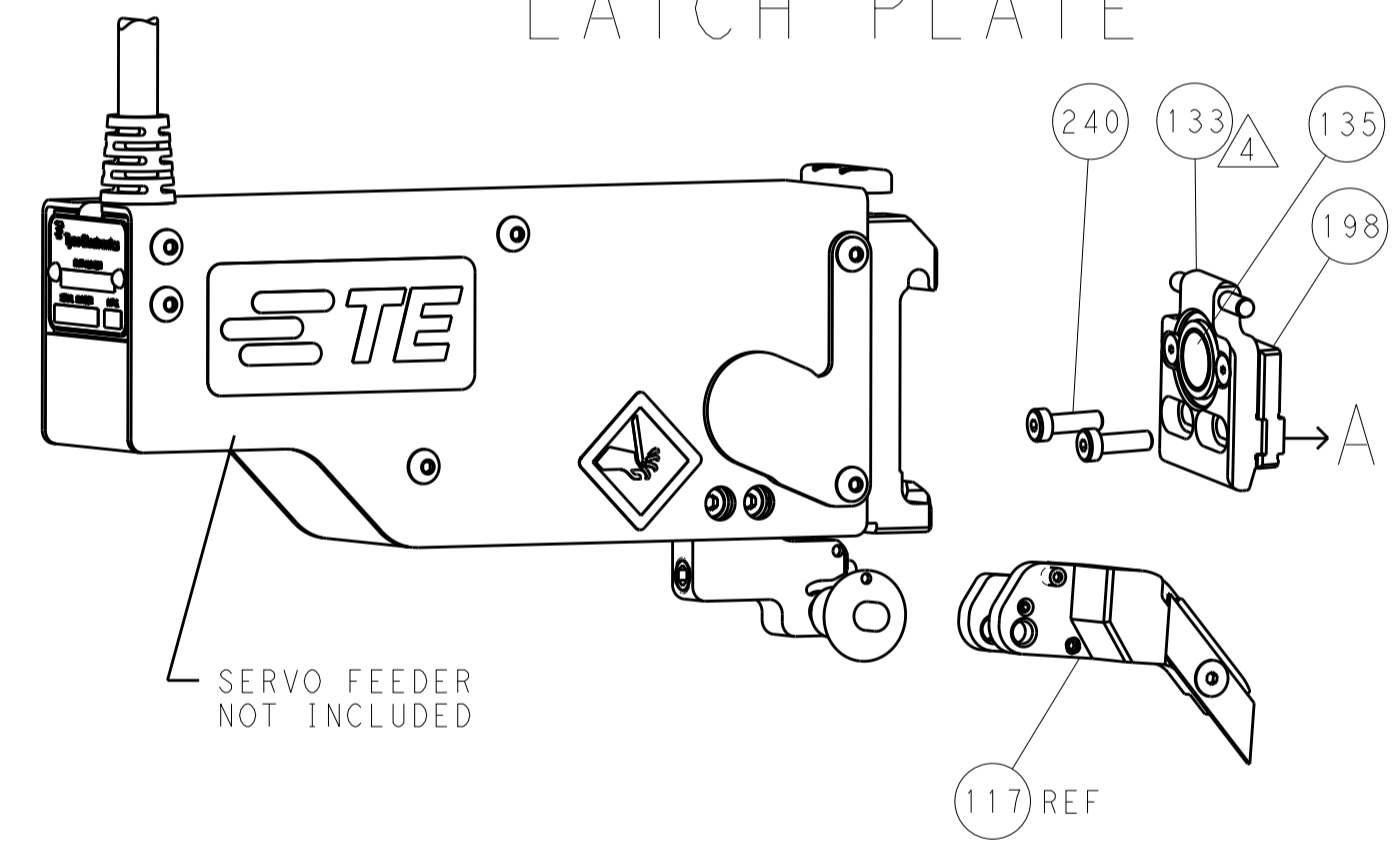
# FEED TYPE MECHANICAL



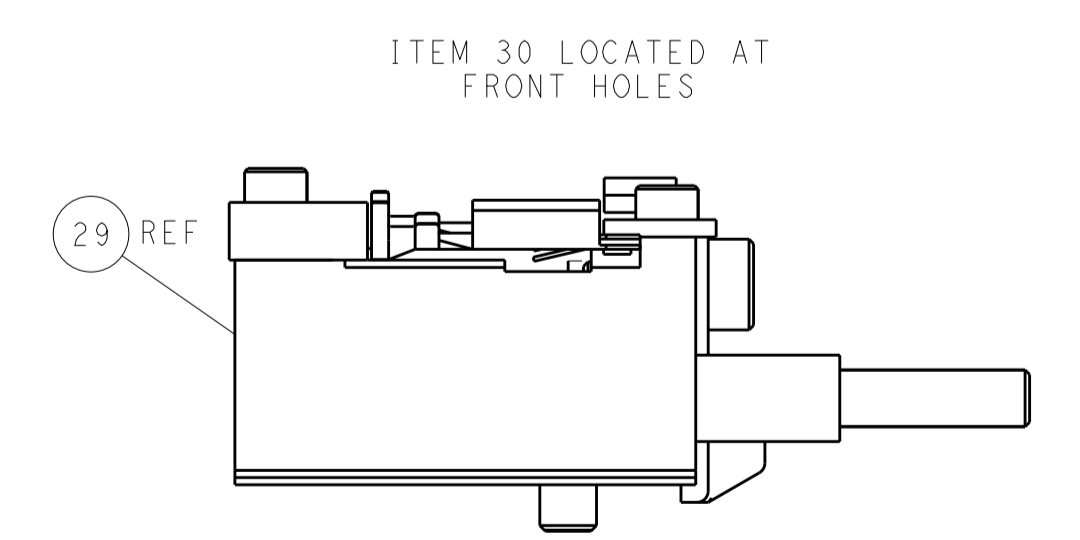
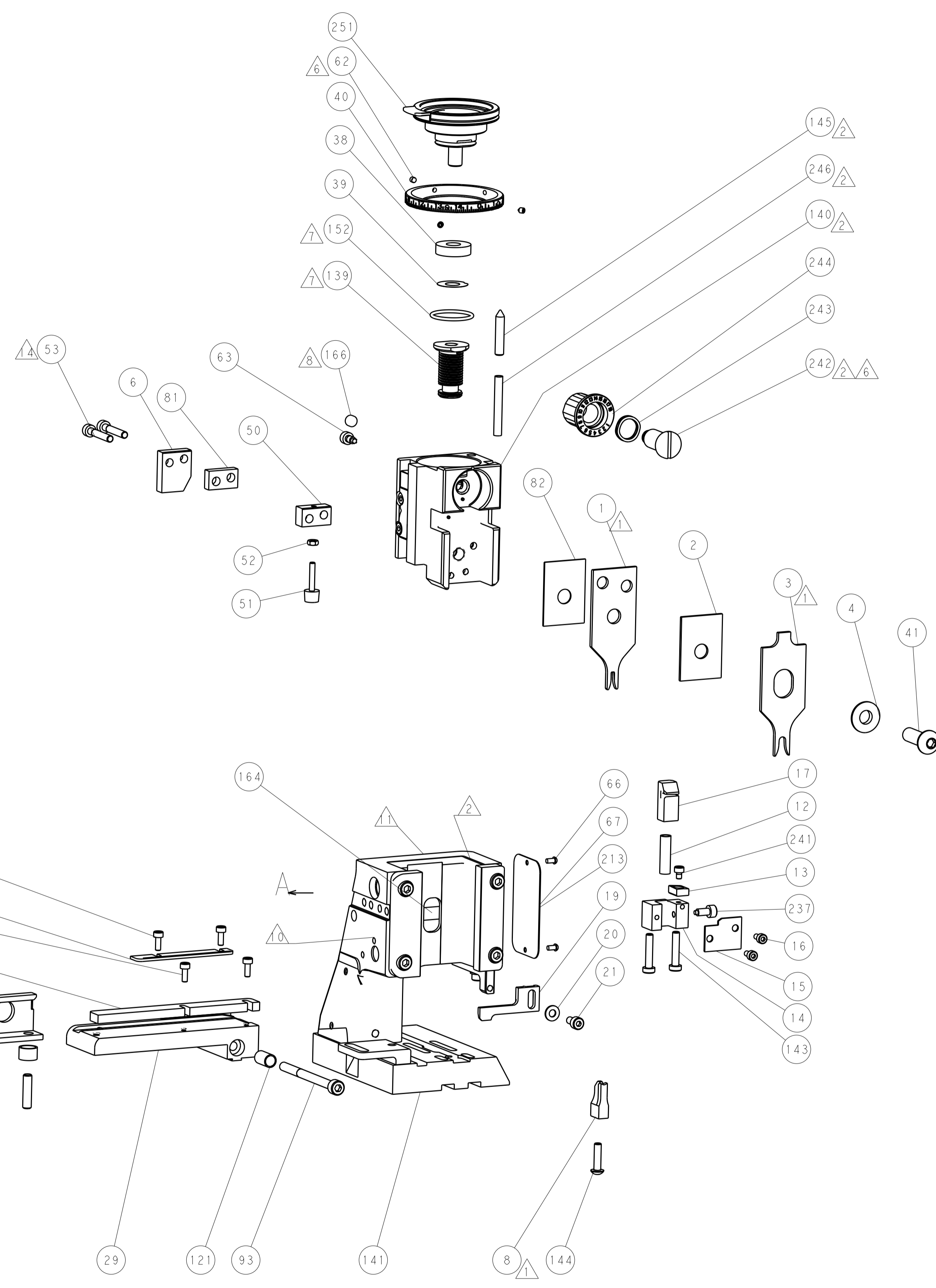
# PNEUMATIC



# 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:		DWG: Y. YIN 11APR2014		CHK: G. BAILEY 11APR2014		APVD: H. GUO 11APR2014		NAME: Ocean Side Feed Applicator	
mm	0 PLC ±0.5	1 PLC ±0.13	2 PLC ±0.013	3 PLC ±0.001	4 PLC ±0.001	ANGLES	FINISH	WEIGHT	SIZE: A1	CAGE CODE: 00779	DRAWING NO: C=2266255
MATERIAL:		FINISH:		RESTRICTED TO:		SCALE: 1:2		SHEET: 4 of 4		REV: A	