

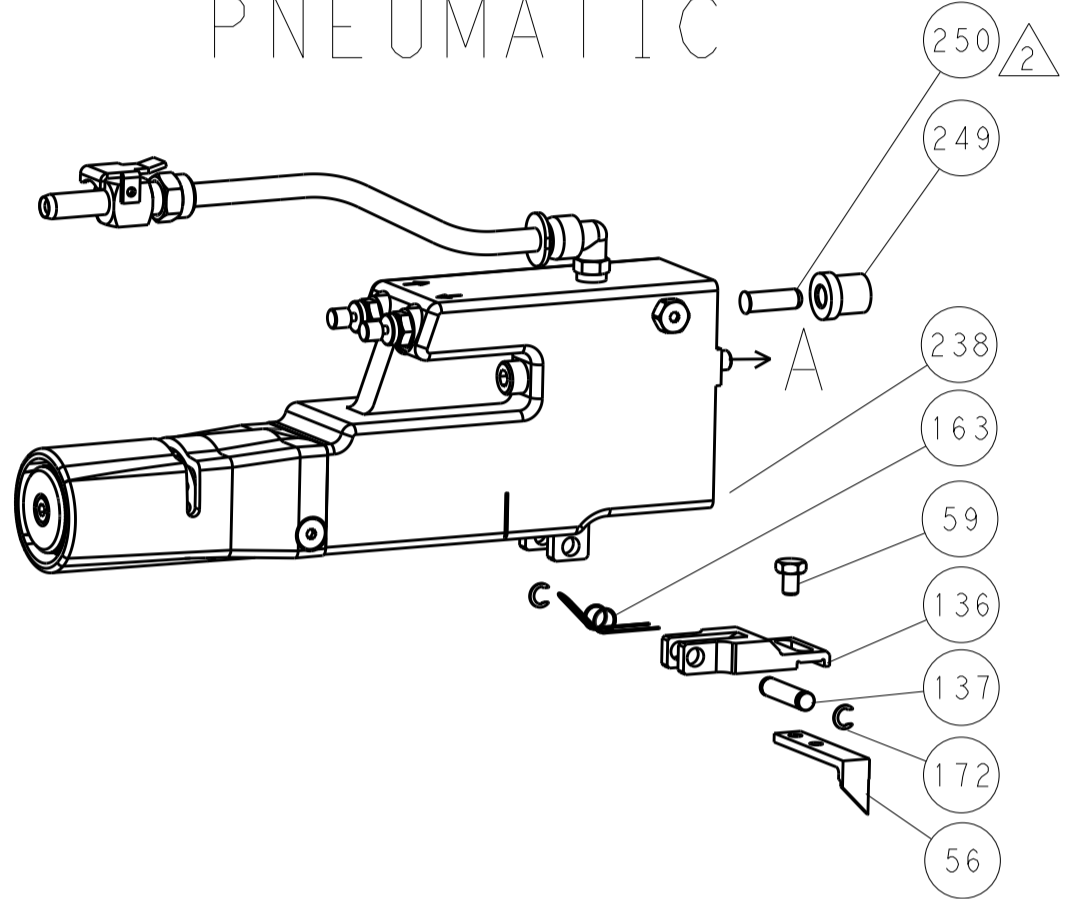


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

### FEED TYPE MECHANICAL



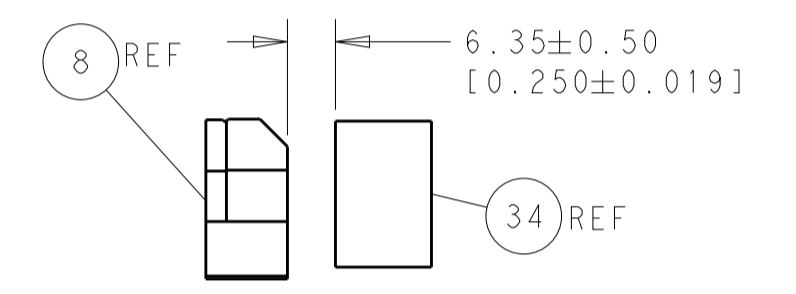
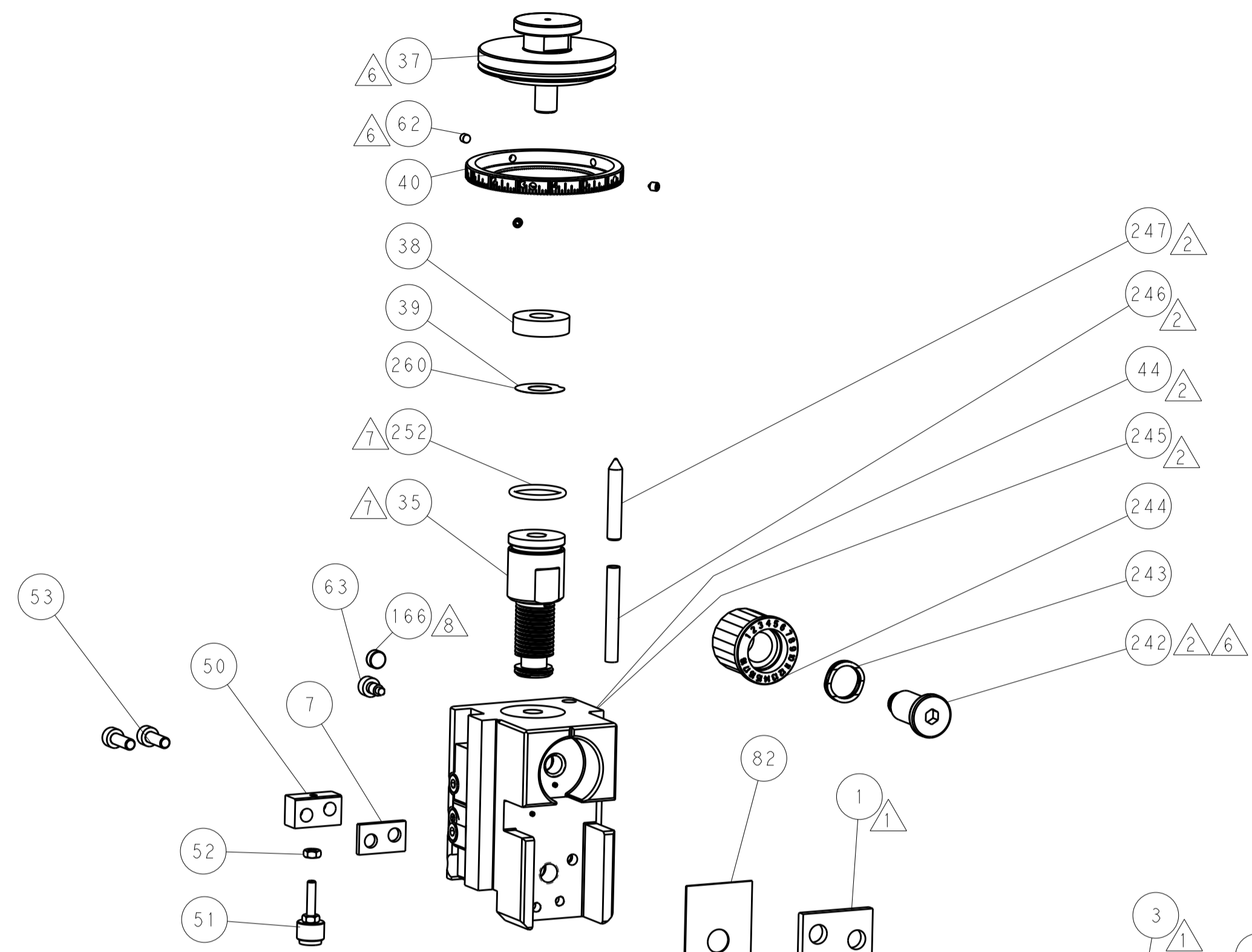
### PNEUMATIC



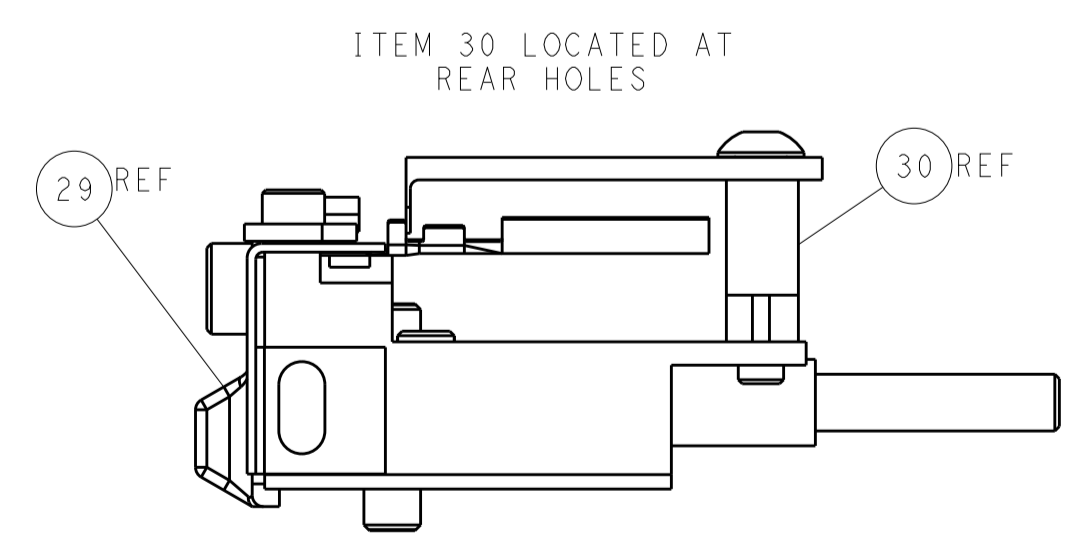
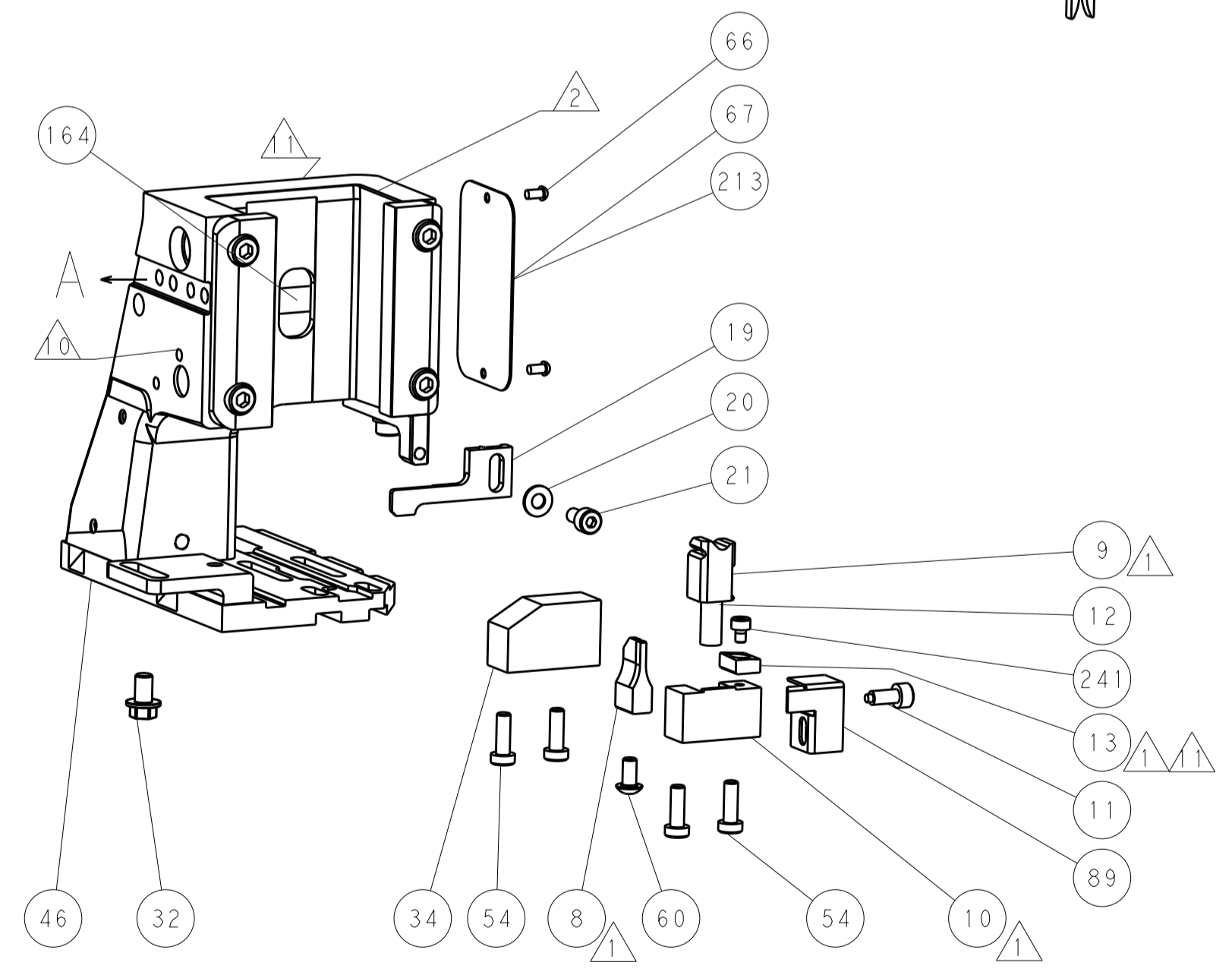
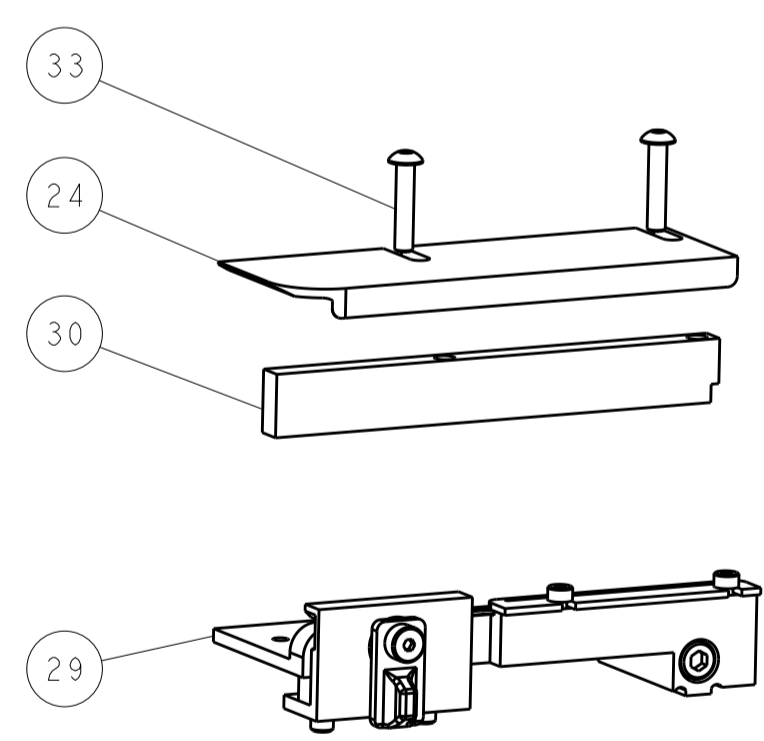
### SERVO LATCH PLATE



### CAM POSITIONS



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT REAR HOLES

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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: J.HOU 18SEP2014		TE Connectivity	
mm		0 PLC ±0.5		CHK: Y.YIN 18SEP2014		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.13		APVD: H.GUO 18SEP2014		NAME: Ocean Side Feed Applicator	
H		3 PLC ±0.013		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO:	
A		4 PLC ±0.001		APPLICATION SPEC		RESTRICTED TO:	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2 SHEET 2 OF 4 REV: B1	
Customer Accessible Production Drawing				A11 00779 ©=2151896			

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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED
2-2151896-1	B	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 - 8-2151896-5 1901094-3 - - 2168400-6 (QUANTITY 2)
2-2151896-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1 1338685-1 5-18022-5 2119653-2 - - -
				SERVO LATCH PLATE	2119951-1 - 8-2151896-5 1901094-3 - - 2168400-6 (QUANTITY 2)
2-2151896-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2161326-1 - 8-2151896-4 - - -	-
2-2151896-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-
7-2151896-7	B	CRIMP TOOLING KIT	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.73 mm [.068]	F
INSUL	2.02 mm [.080]	F

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION

TERMINAL NAME: TAXI TERMINAL

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.37-5.13 mm [1.72-.202 IN]	1.20-1.70 mm [.047-.067 IN]

TERMINAL APPLICATION SPECIFICATION 15304701 PG 1 OF 19 Rev - -

TERMINALS APPLIED

TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
286849-1	15304701	286849-3	15393149
286849-2	12176694		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.10+/-0.05 [1.043+/-0.02]	6.7
0.35mm2	1.05+/-0.05 [1.041+/-0.02]	7.3



- 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: 8-2151896-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151896-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151896-5
- 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 ITEM 62.  
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

	251	250	249
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
-77 -27 -25 -22 -21	PART NO	DESCRIPTION	ITEM NO

**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	APP'D
			-	SEE SHEET 1		

REV	DATE	BY	APP'D	DESCRIPTION	ITEM NO	
-	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
-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	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
-	-	-	1	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	318563-1	GUARD, FRONT CHIP	89
-	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	5-547505-2	SPRING, COMPRESSION	77
-	1	1	1	854769-4	HOLDER, INS	74
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	-	-	1	1338685-1	PAWL, FEED	56
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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
-	-	-	1	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	1752356-3	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	455888-3	SPACER, CRIMPER	28
-	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	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	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	2-1803055-5	ANVIL, COMBINATION	8
-	1	1	1	1-240641-3	SPACER	7
-	-	-	-	-	-	6
-	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1	6-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	2
-	1	1	1	2-1673600-4	CRIMPER, WIRE	1
-	-	-	-	-	-	0

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	18SEP2014	18SEP2014
	3 PLC ±0.013	4 PLC ±0.001		18SEP2014	
	ANGLES				
MATERIAL	FINISH	WEIGHT	SCALE	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
			1:2	SHEET 3 OF 4	

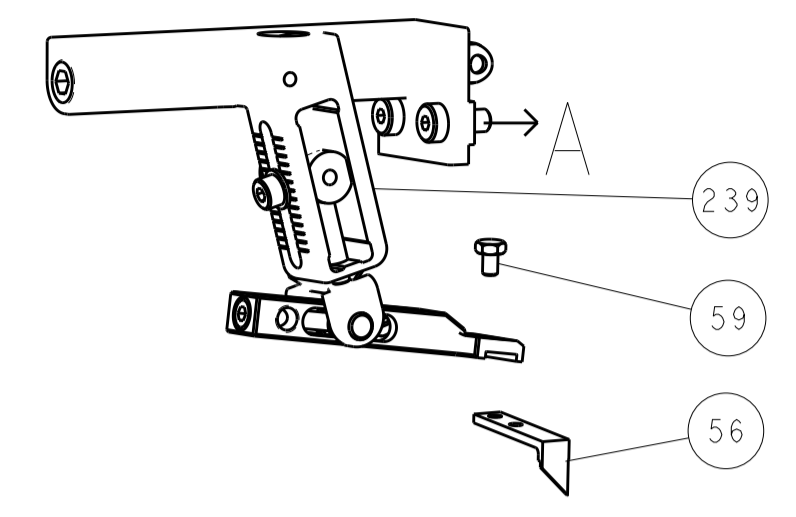
Customer Accessible Production Drawing

Customer Accessible Production Drawing

Customer Accessible Production Drawing

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

# FEED TYPE MECHANICAL



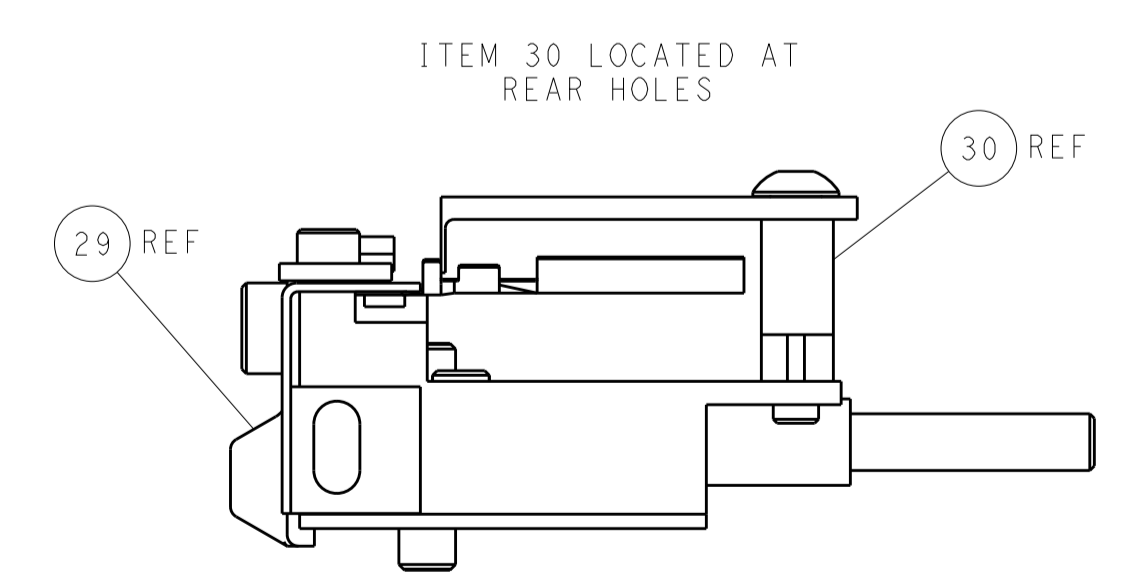
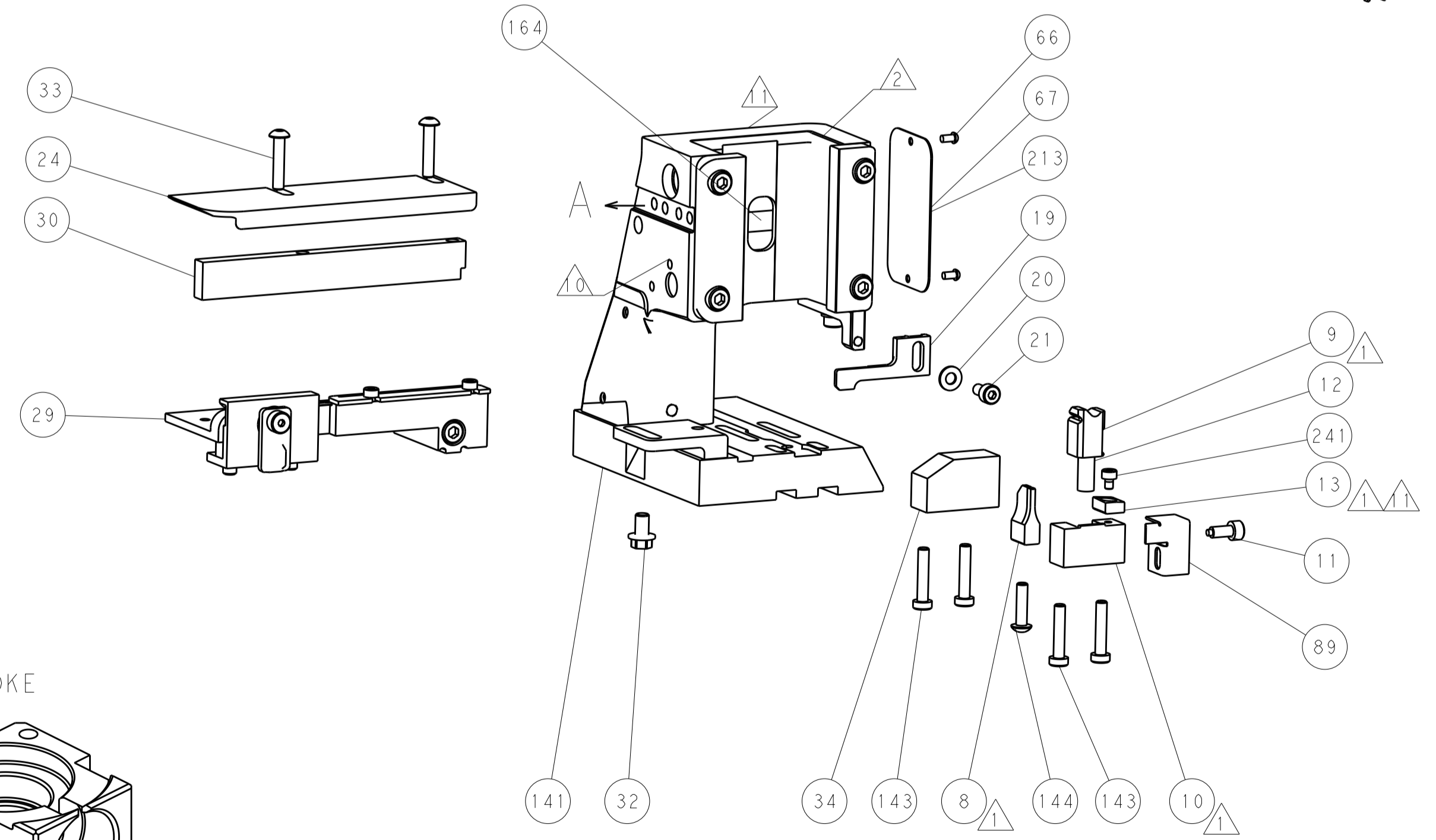
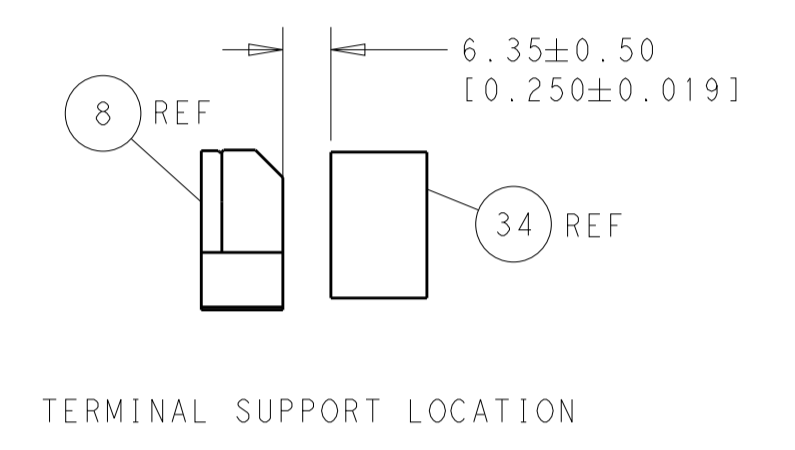
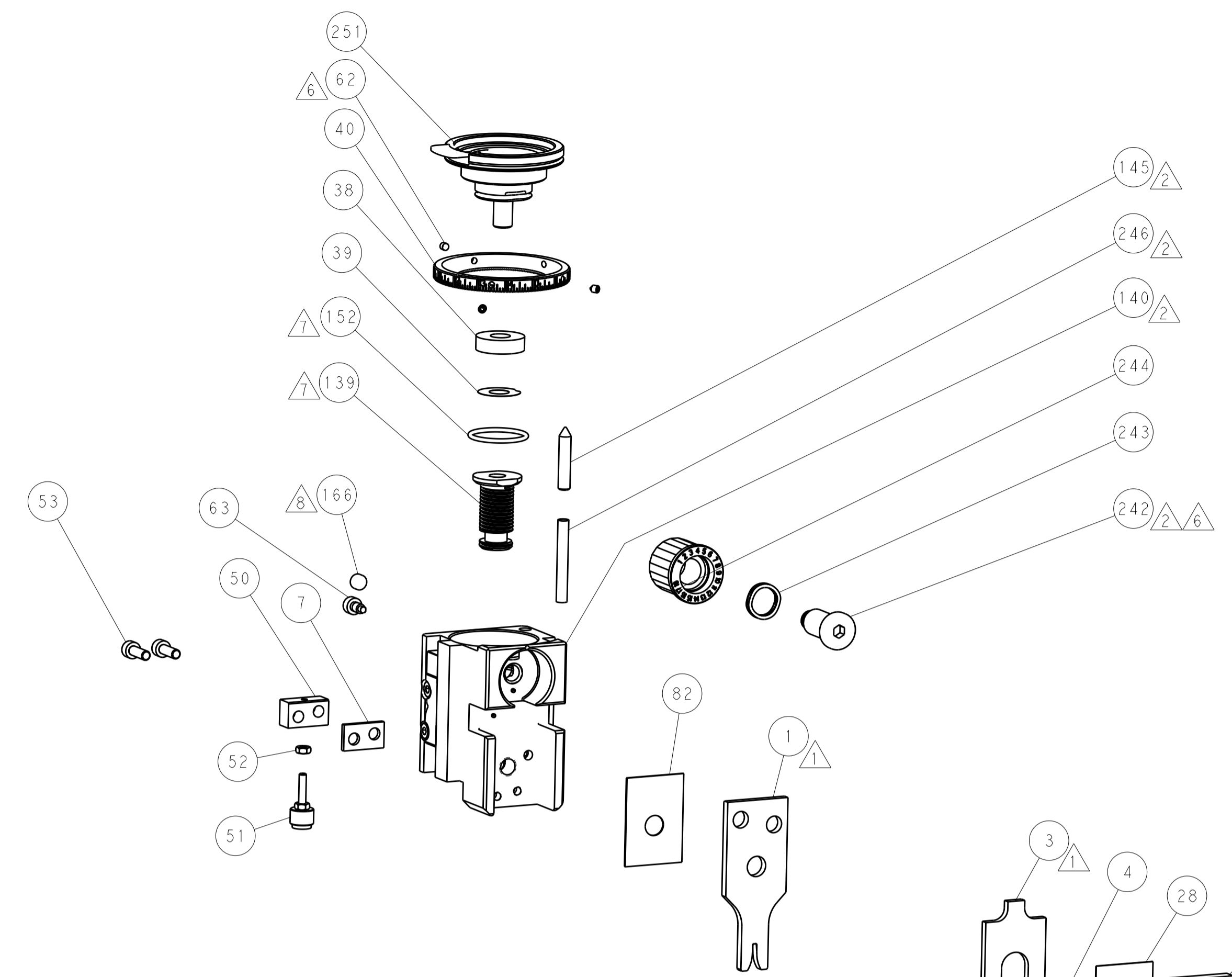
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



FEED TRACK POSITION  
GUIDE BY 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 J.HOU 18SEP2014		STE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD Y.YIN 18SEP2014	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		PRODUCT SPEC:		NAME	
				APPLICATION SPEC:		Ocean Side Feed Applicator	
				WEIGHT:		SIZE CAGE CODE DRAWING NO	
				A 00779		C=2151896	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 4 OF 4 REV B1	