

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2151615-2 | H | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | - | - | - | - | - | - | |
| | 2151615-5 | H | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | SERVO LATCH PLATE | 2119951-1 | - | 8-2151615-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | 2151615-6 | H | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 |
| | 2151615-7 | H | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2151615-7 | B | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|----------------------|------|--|
| CRIMP SIZE | TYPE | |
| WIRE 2.54 mm [.100] | F | |
| INSUL 3.30 mm [.130] | F | |

APPLICATOR INSTRUCTIONS 408-10389

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|------------------------------------|-------------|-----------------------------|-------------|
| TERMINAL NAME: LITEALUM CONTACT | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.20-3.80 mm [.126-.150 IN] | | 2.88-3.04 mm [.113-.120 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-94204 | | |
| TERMINALS APPLIED ¹⁰ | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 2-2177894-1 | | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|-------------------------|--------------------------------|
| 2.50mm ² | 1.56±0.04 [.0614±.0016] | 12.5 |

- 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151615-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151615-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151615-6
- 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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 99 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- ¹¹ TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- ¹² WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT.
- ¹³ CUT TO LENGTH AT ASSEMBLY.
- ¹⁴ SET THE FINE CRIMP HEIGHT ADJUSTMENT HEAD TO PROPER CRIMP HEIGHT PRIOR TO TIGHTENING/LOCKING THE BRASS TIP SET SCREW, ITEM 99, AGAINST THE ADJUSTMENT BOLT THREADS.
- 15. APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

***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.

| | | | | | | | |
|-----|----|----|----|----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 1 | 1 | 2-1722335-1 | THREAD BOLT GEWINDEBOLZEN | 268 |
| - | - | 1 | - | - | 2119957-2 | APPLICATOR SHIM PACK | 260 |
| - | 1 | - | 1 | 1 | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252 |
| - | - | - | - | 1 | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | - | 1 | 2079988-1 | BUSHING, LCH5-12, MISUMI | 249 |
| - | - | - | - | 1 | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | 1 | - | 1 | 1 | 2119798-1 | DETENT PIN | 247 |
| - | 1 | - | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | - | 1 | - | - | 2119758-1 | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245 |
| -77 | -7 | -6 | -5 | -2 | PART NO | DESCRIPTION | ITEM NO |

ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

| SET UP GAUGE | LOC | DIST | REVISIONS | | | | | |
|--------------|-----|------|-----------|-----|---------------|-----------|-----|------|
| 2119599-1 | A | 66 | P | LTM | DESCRIPTION | DATE | OWN | APVD |
| | | | F2 | | ECR-15-001216 | 25JAN2015 | MR | JT |
| | | | F3 | | ECR-15-003249 | 27FEB15 | RS | LZ |
| | | | G | | ECR-15-015082 | 14OCT2015 | DJG | DS |
| | | | H | | ECR-16-002616 | 23FEB2016 | XZ | CT |

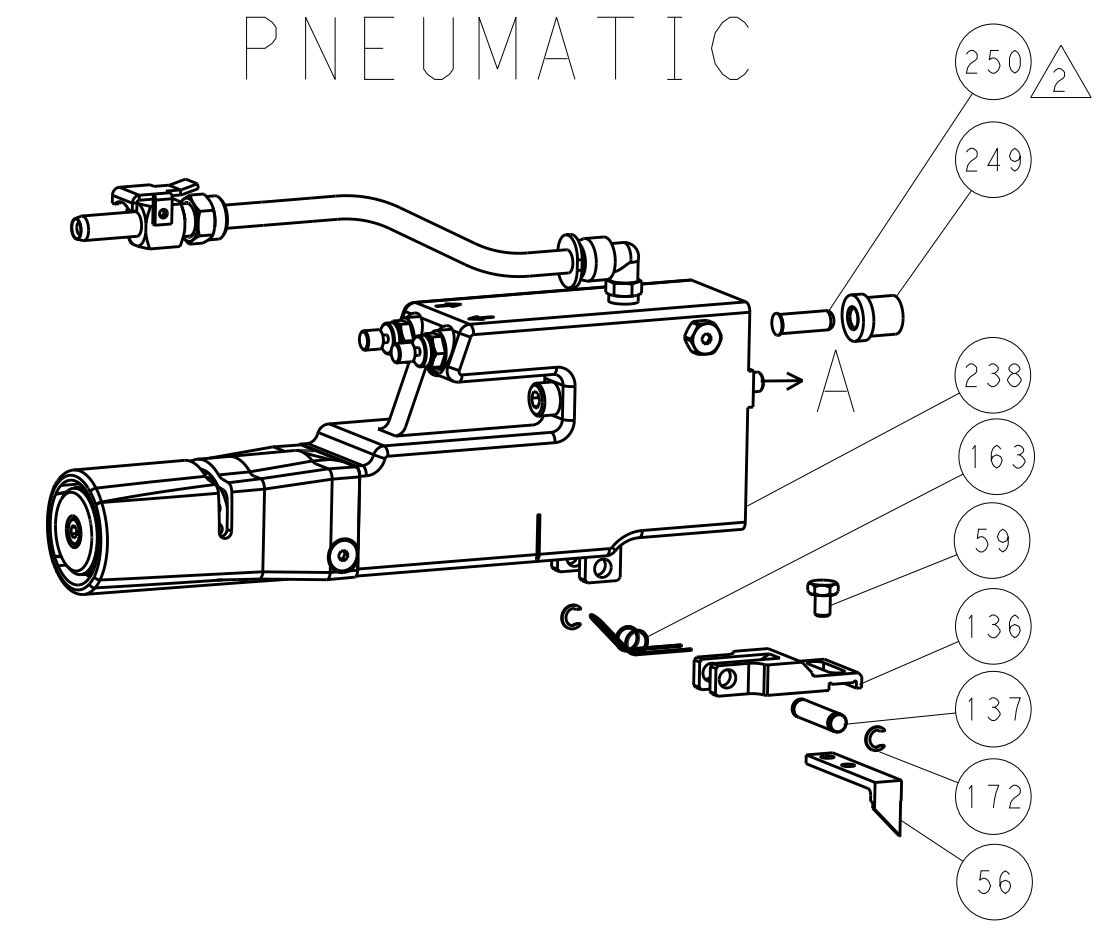
| | | | | | | | |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 1 | 1 | 2119082-4 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 1 | 1 | 1 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | - | 2 | 2 | - | 2168400-6 | SHCS, LOW HEAD, RoHS, M5 X 16 | 240 |
| - | - | - | - | 1 | 2063440-1 | AIR FEED MODULE | 238 |
| - | - | 1 | 1 | - | 2119740-2 | TAG, IDENTIFICATION | 213 |
| - | - | 1 | 1 | - | 1901094-3 | SPACER, FEEDER | 198 |
| - | - | - | - | 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 | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
| - | - | - | - | 1 | 2119799-1 | HOLDER, FEED FINGER, AF | 136 |
| - | - | REF | REF | - | SEE NOTE 4 | MEMORY CHIP, PROGRAMMED | 135 |
| - | - | 1 | 1 | - | 1633743-1 | SERVO FEED LATCH ASM | 133 |
| - | 1 | 1 | 1 | 1 | 1-22281-8 | SPRING, COMPRESSION | 121 |
| - | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | 1 | 1 | 1 | 1 | 2256587-1 | SCR, SET, SOFT TIP, M4 | 99 |
| - | 1 | 1 | 1 | 1 | 1-690438-0 | FRONT STRIP GUIDE | 96 |
| - | 2 | 2 | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 95 |
| - | 1 | 1 | 1 | 1 | 2168083-6 | SCR, SKT HD CAP, RoHS, M5 X 65 | 93 |
| - | 1 | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | - | - | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 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 | 1 | 1 | 1 | 2-18032-5 | SCR, SET, FLT POINT M5 X 20.0 | 61 |
| - | 1 | 1 | 1 | 1 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 60 |
| - | - | - | - | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | - | - | - | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 4 | 4 | 4 | 4 | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 54 |
| - | 2 | 2 | 2 | 2 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 53 |
| - | 1 | 1 | 1 | 1 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 52 |
| - | 1 | 1 | 1 | 1 | 811242-5 | BUMPER, HOLD DOWN | 51 |
| - | 1 | 1 | 1 | 1 | 690753-2 | SPACER, TONKER | 50 |
| - | - | - | - | 1 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | 1 | 1 | 1 | 1 | 2-2119656-3 | APPLICATOR BASIC ASSEMBLY, SF | 46 |
| - | 1 | - | 1 | 1 | 2119370-1 | RAM, AMP STYLE, SIDE FEED | 44 |
| - | 1 | 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 | 1 | 2119644-2 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 |
| - | 1 | - | 1 | 1 | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| - | 1 | 1 | 1 | 1 | 1-1752356-7 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 1 | 1 | 1 | 1 | 2161328-1 | HEX HEAD, FLANGED, M5 x 8mm LONG | 32 |
| - | 1 | 1 | 1 | 1 | 1320908-7 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1901086-1 | PLATE, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | 2 | 2 | 2 | 2 | 22283-1 | SPRING, COMPRESSION | 27 |
| - | 1 | 1 | 1 | 1 | 356835-1 | LEVER, DRAG RELEASE | 26 |
| - | 1 | 1 | 1 | 1 | 1803142-1 | DRAG, TERMINAL | 25 |
| - | 1 | 1 | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 980371-4 | SCR, SKT HD SHLDR 5.0 DIA X 6.0 | 23 |
| - | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1 | 1 | 1 | 690472-2 | STRIPPER | 19 |
| - | 1 | 1 | 1 | 1 | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1 | 1 | 1 | 1-356885-5 | STOP, SHEAR | 11 |
| - | 1 | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1 | 1 | 1 | 462006-6 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 1 | 1 | 1 | 2161316-5 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 2-240641-9 | SPACER | 7 |
| - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1-1722335-0 | SHEAR DEPRESSOR ASSEMBLY | 5 |
| - | 1 | 1 | 1 | 1 | 3-238011-8 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 1 | 1 | 1-1722335-2 | CRIMPER, INSULATION F | 3 |
| - | - | - | - | - | - | - | 2 |
| 1 | 1 | 1 | 1 | 1 | 2217303-2 | CRIMPER, WIRE, CONICAL BLEND | 1 |
| -77 | -7 | -6 | -5 | -2 | PART NO | DESCRIPTION | ITEM NO |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DRAWING NO | |
|-------------|----------|--|---------|------------|---------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± |
| | ANGLES ± | FINISH ± | | | |
| MATERIAL | | WEIGHT | | SCALE | |

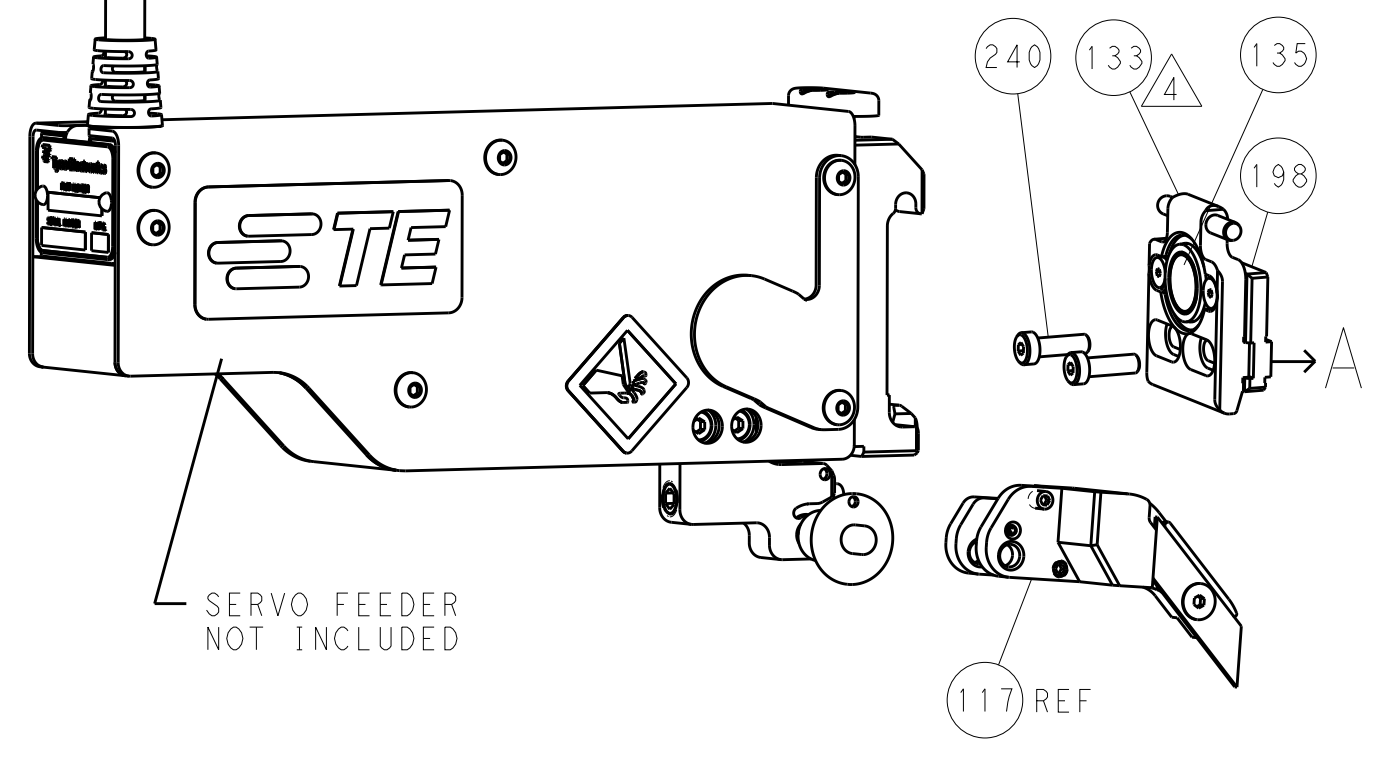
| | | |
|--|----------------------------|------------|
| OWN | R. KNEPPER | 05APR2012 |
| CHK | T. ELBIN | 05APR2012 |
| APVD | M. CLIFFORD | 05APR2012 |
| NAME | Ocean Side Feed Applicator | |
| SIZE | CAGE CODE | DRAWING NO |
| A1 | 00779 | 2151615 |
| Customer Accessible Production Drawing | | |
| SHEET | 1 | OF 4 |
| REV | H | |

| LOC | DIST | REV | DESCRIPTION | DATE | OWN | APVD |
|-----|------|-----|-------------|------|-----|------|
| A | 66 | | SEE SHEET 1 | | | |

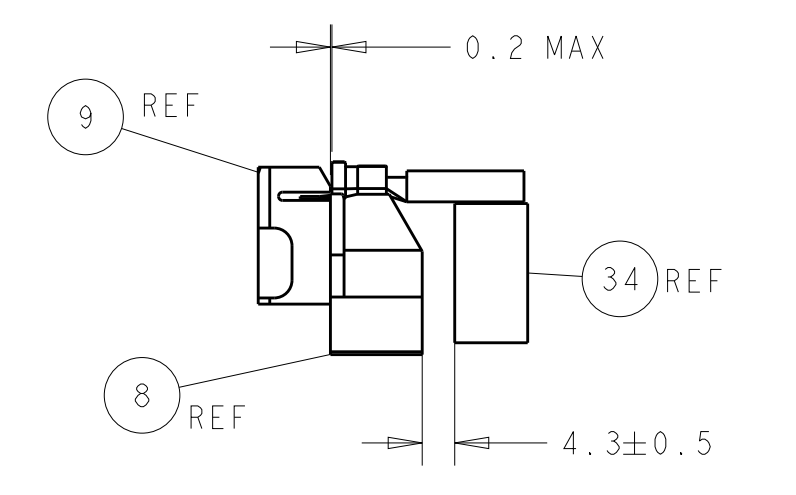
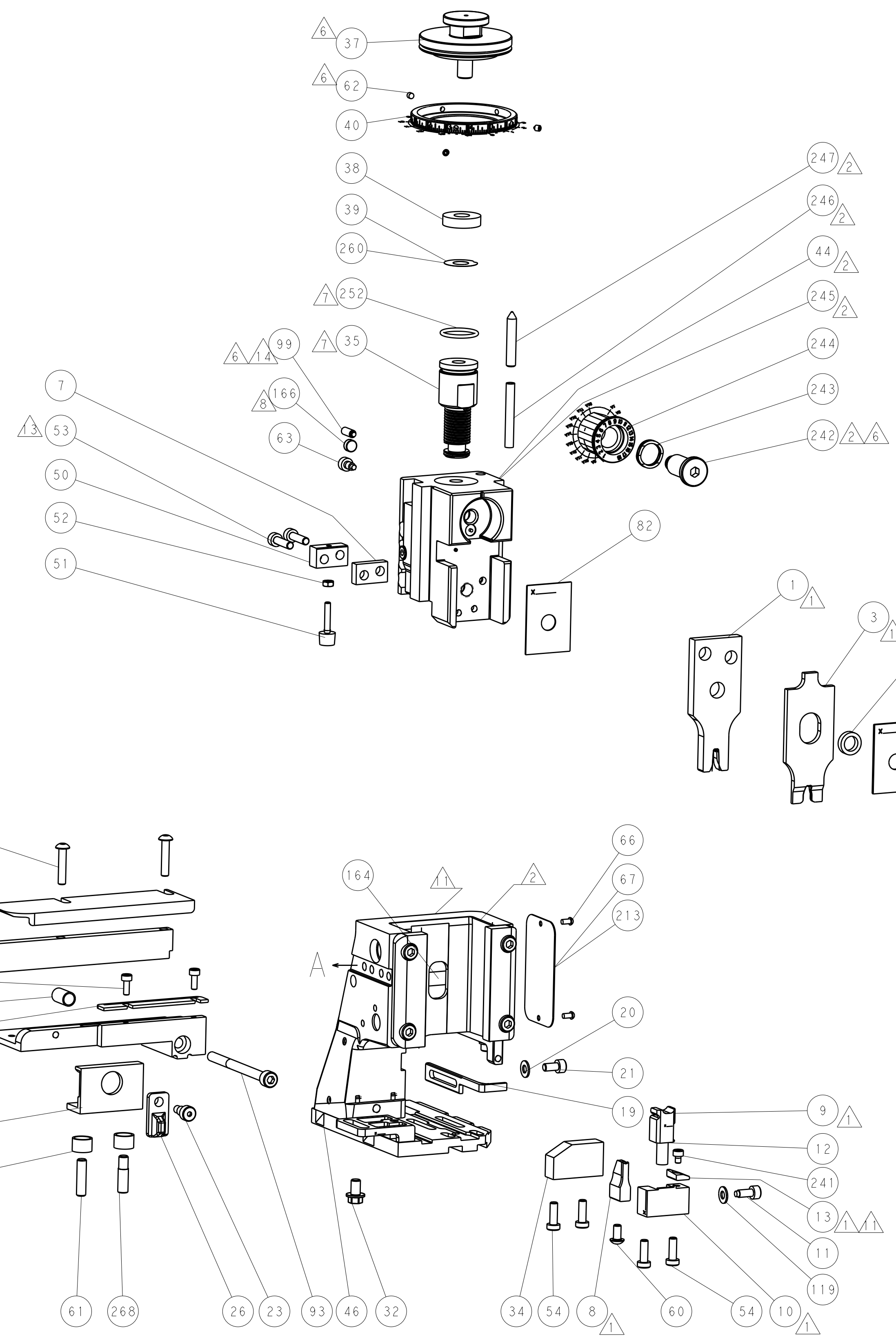
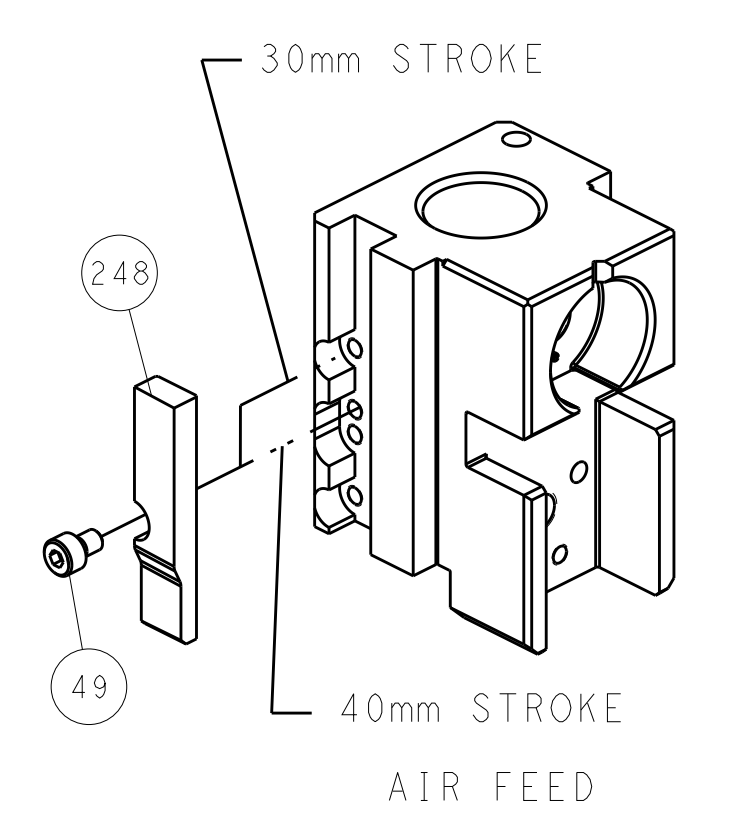
FEED TYPE PNEUMATIC



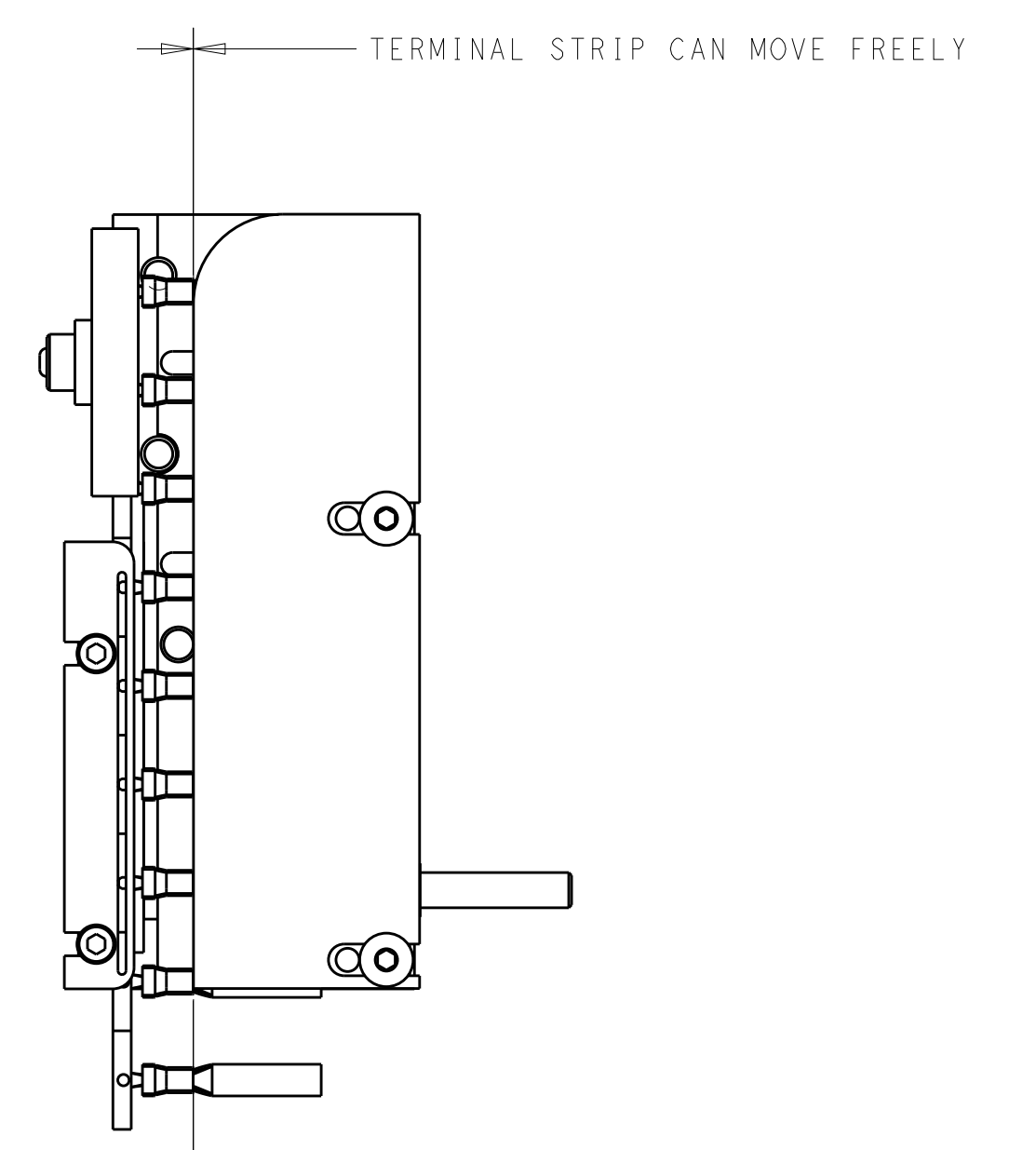
SERVO LATCH PLATE



CAM POSITION

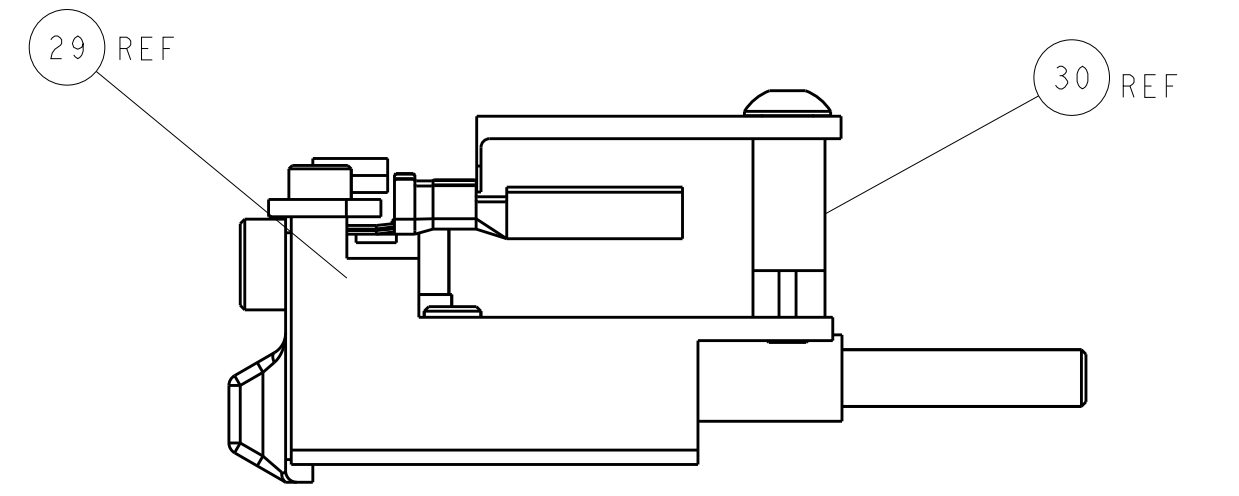


TERMINAL SUPPORT LOCATION



TERMINAL STRIP CAN MOVE FREELY WITH A MINIMUM OF SIDE CLEARANCE

ITEM 30 LOCATED AT REAR HOLES



TERMINAL GUIDE WIRE POSITION

ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

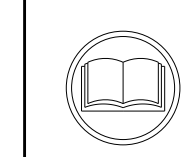
| | | | | | | | |
|-----------------------|--|---|--|--|--|---|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | | DWN R. KNEPPER 05APR2012 CHK T. ELBIN 05APR2012 APVD M. CLIFFORD 05APR2012 PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2 SHEET 2 OF 4 REV H | | NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151615 | |
| MATERIAL FINISH | | | | Customer Accessible Production Drawing | | | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|--------------------------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2151615-2 | H | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | - | 8-2151615-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151615-4 | - | - | - |
| | 2-2151615-5 | H | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 |
| | | | | | - | - | - | - | - | - | - |
| 2-2151615-7 | H | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2151615-7 | B | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.54 mm [.100] | F |
| INSUL | 3.30 mm [.130] | F |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION |
|--|-------------|--|
| TERMINAL NAME: LITEALUM CONTACT | | |
| WIRE STRIP LENGTH 3.20-3.80 mm [1.26-.150 IN] | | INSULATION DIAMETER RANGE 2.88-3.04 mm [1.13-.120 IN] |
| TERMINAL APPLICATION SPECIFICATION 114-94204 | - | - |
| TERMINALS APPLIED ¹⁰ | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 2-2177894-1 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|-------------------------|--------------------------------|
| 2.50mm ² | 1.56±0.04 [.0614±.0016] | 12.5 |



- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151615-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151615-5
- 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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 99 & 242.
- 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. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- ¹⁰ TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- ¹² CUT TO LENGTH AT ASSEMBLY.
- ¹³ SET THE FINE CRIMP HEIGHT ADJUSTMENT HEAD TO PROPER CRIMP HEIGHT PRIOR TO TIGHTENING/LOCKING THE BRASS TIP SET SCREW, ITEM 99, AGAINST THE ADJUSTMENT BOLT THREADS.
- 14. APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

***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.

| | | | | | | |
|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 1 | 2-1722335-1 | THREAD BOLT GEWINDEBOLZEN | 268 |
| - | 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 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | 1 | 1 | 1 | 2119082-4 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| -77 | -27 | -25 | -22 | 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)

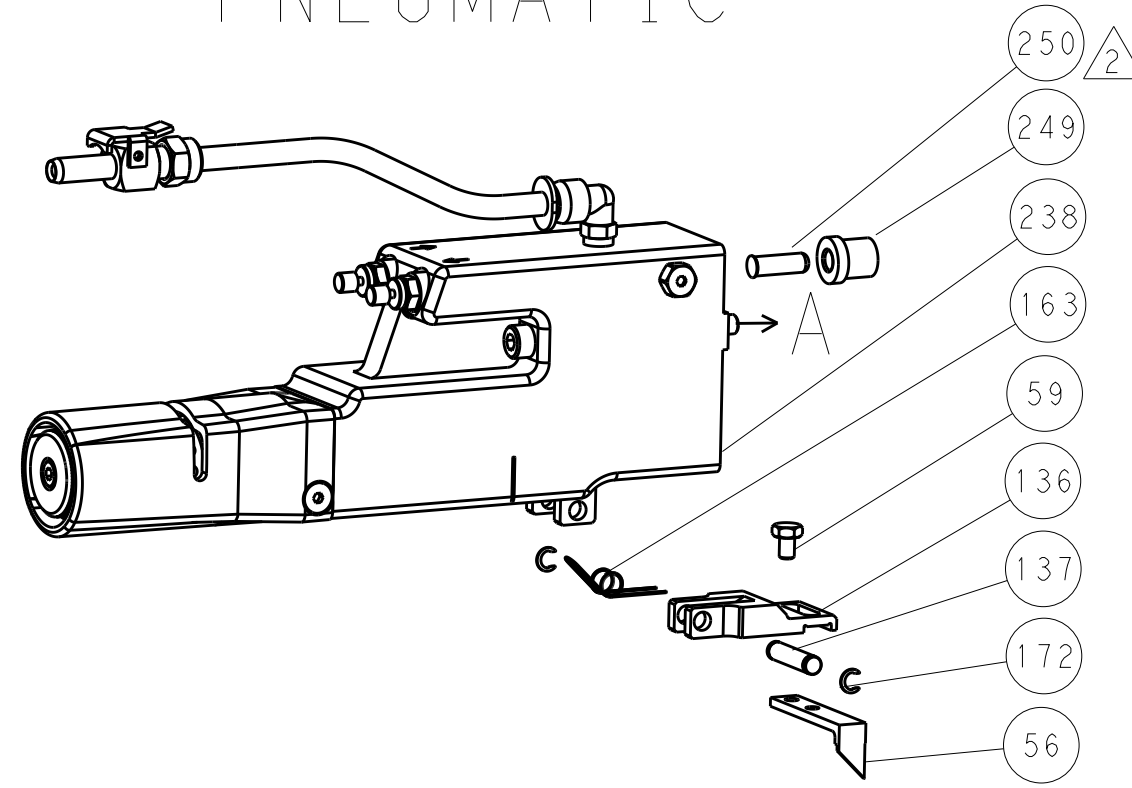
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-------------|------|----|------|
| 2119599-1 | A | 66 | REV | DATE | BY | APPV |
| - | - | - | 1 | - | - | - |
| | | | SEE SHEET 1 | | | |

| | | | | | | | |
|----------------------------|-----|-----|-----|---------|-------------|-------------------------------------|-----|
| ⁶ | - | 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 | 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 |
| ⁸ | - | 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 |
| ⁷ | - | 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 | 1 | 1 | 2-2119656-4 | APPLICATOR BASIC ASSEMBLY, SF | 141 |
| | - | 1 | 1 | 1 | 2119650-1 | RAM, ASIAN STYLE, SIDE FEED | 140 |
| ⁷ | - | 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 |
| | - | 1 | 1 | 1 | 1-22281-8 | SPRING, COMPRESSION | 121 |
| | - | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| ¹³ ⁶ | - | 1 | 1 | 1 | 2256587-1 | SCR, SET, SOFT TIP, M4 | 99 |
| | - | 1 | 1 | 1 | 1-690438-0 | FRONT STRIP GUIDE | 96 |
| | - | 2 | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 95 |
| | - | 1 | 1 | 1 | 2168083-6 | SCR, SKT HD CAP, RoHS, M5 X 65 | 93 |
| | - | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 |
| | - | 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 |
| ⁶ | - | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62 |
| | - | 1 | 1 | 1 | 2-18032-5 | SCR, SET, FLT POINT M5 X 20.0 | 61 |
| | - | - | - | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| | - | - | - | 1 | 1338685-1 | PAWL, FEED | 56 |
| ¹² | - | 2 | 2 | 2 | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 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 | 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 | 2119644-2 | RAM WASHER, PRECISION | 38 |
| | - | 1 | 1 | 1 | 1-1752356-7 | 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 | 1320908-7 | SPACER, STRIP GUIDE | 30 |
| | - | 1 | 1 | 1 | 1901086-1 | PLATE, STRIP GUIDE | 29 |
| | - | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| | - | 2 | 2 | 2 | 22283-1 | SPRING, COMPRESSION | 27 |
| | - | 1 | 1 | 1 | 356835-1 | LEVER, DRAG RELEASE | 26 |
| | - | 1 | 1 | 1 | 1803142-1 | DRAG, TERMINAL | 25 |
| | - | 1 | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| | - | 1 | 1 | 1 | 980371-4 | SCR, SKT HD SHLDR 5.0 DIA X 6.0 | 23 |
| | - | 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 | 690472-2 | STRIPPER | 19 |
| | - | 1 | 1 | 1 | 2119806-1 | INSERT, SHEAR | 13 |
| | - | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| | - | 1 | 1 | 1 | 1-356885-5 | STOP, SHEAR | 11 |
| ¹¹ | - | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| ¹¹ | - | 1 | 1 | 1 | 462006-6 | FLOATING SHEAR, FRONT | 9 |
| ¹¹ | 1 | 1 | 1 | 1 | 2161316-5 | ANVIL, COMBINATION | 8 |
| | - | 1 | 1 | 1 | 2-240641-9 | SPACER | 7 |
| | - | - | - | - | - | - | 6 |
| | - | 1 | 1 | 1 | 1-1722335-0 | SHEAR DEPRESSOR ASSEMBLY | 5 |
| | - | 1 | 1 | 1 | 3-238011-8 | BLOCK, CRIMPER SPACER | 4 |
| ¹¹ | 1 | 1 | 1 | 1 | 1-1722335-2 | CRIMPER, INSULATION F | 3 |
| | - | - | - | - | - | - | 2 |
| ¹¹ | 1 | 1 | 1 | 1 | 2217303-2 | CRIMPER, WIRE, CONICAL BLEND | 1 |
| -77 | -27 | -25 | -22 | PART NO | DESCRIPTION | ITEM NO | |

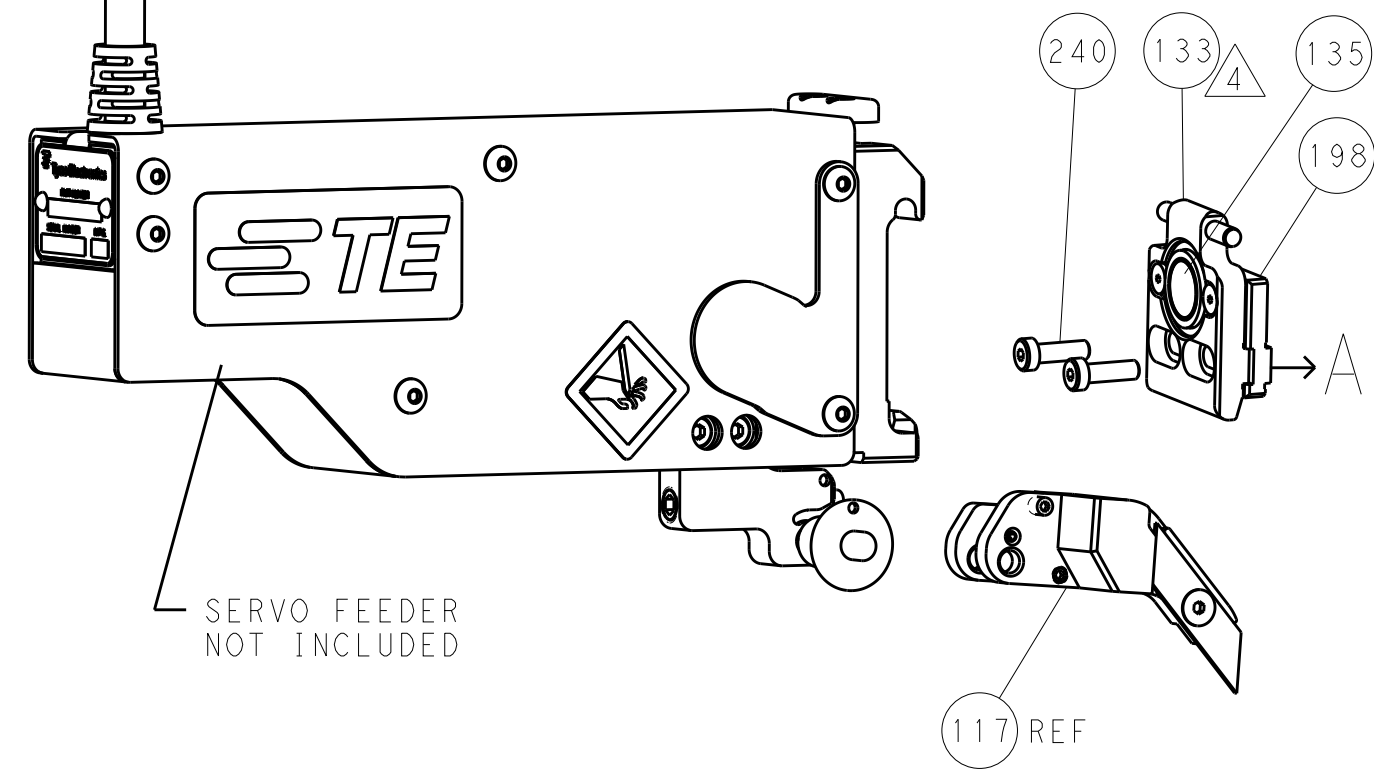
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | MATERIAL: | | FINISH: | | WEIGHT: | | SCALE: | |
|-------------|--------|--|--|-----------|--|---------|--|---------|--|--------|--|
| mm | 0 PLC | ± | | | | | | | | | |
| | 1 PLC | ± | | | | | | | | | |
| | 2 PLC | ± | | | | | | | | | |
| | 3 PLC | ± | | | | | | | | | |
| | 4 PLC | ± | | | | | | | | | |
| | ANGLES | ± | | | | | | | | | |

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

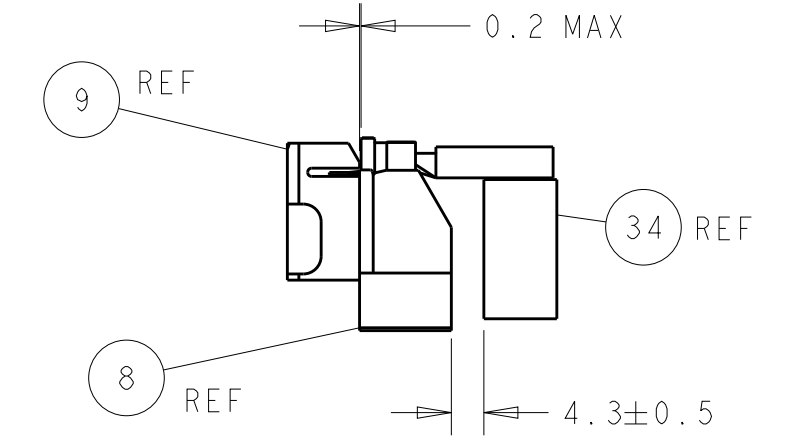
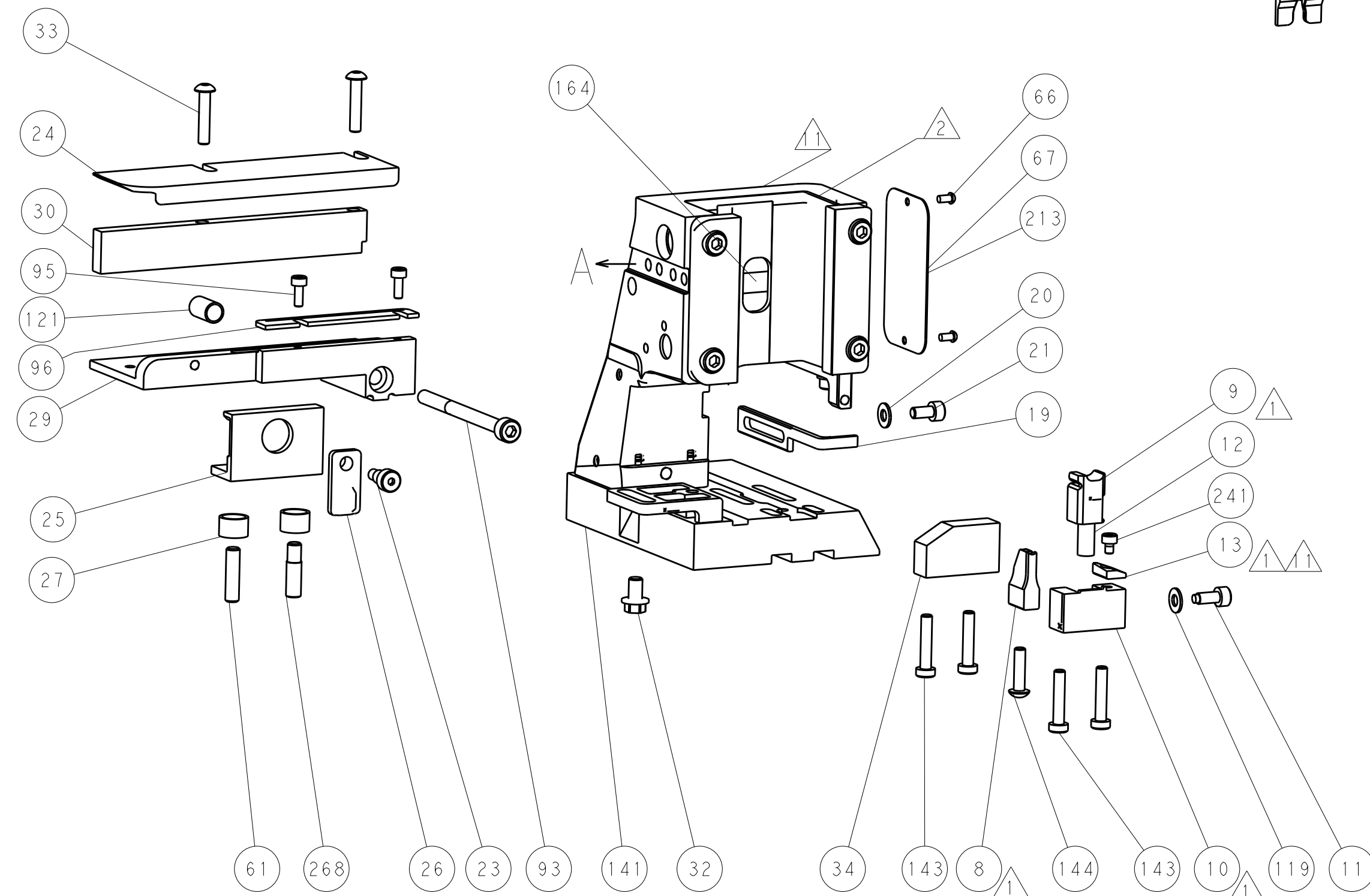
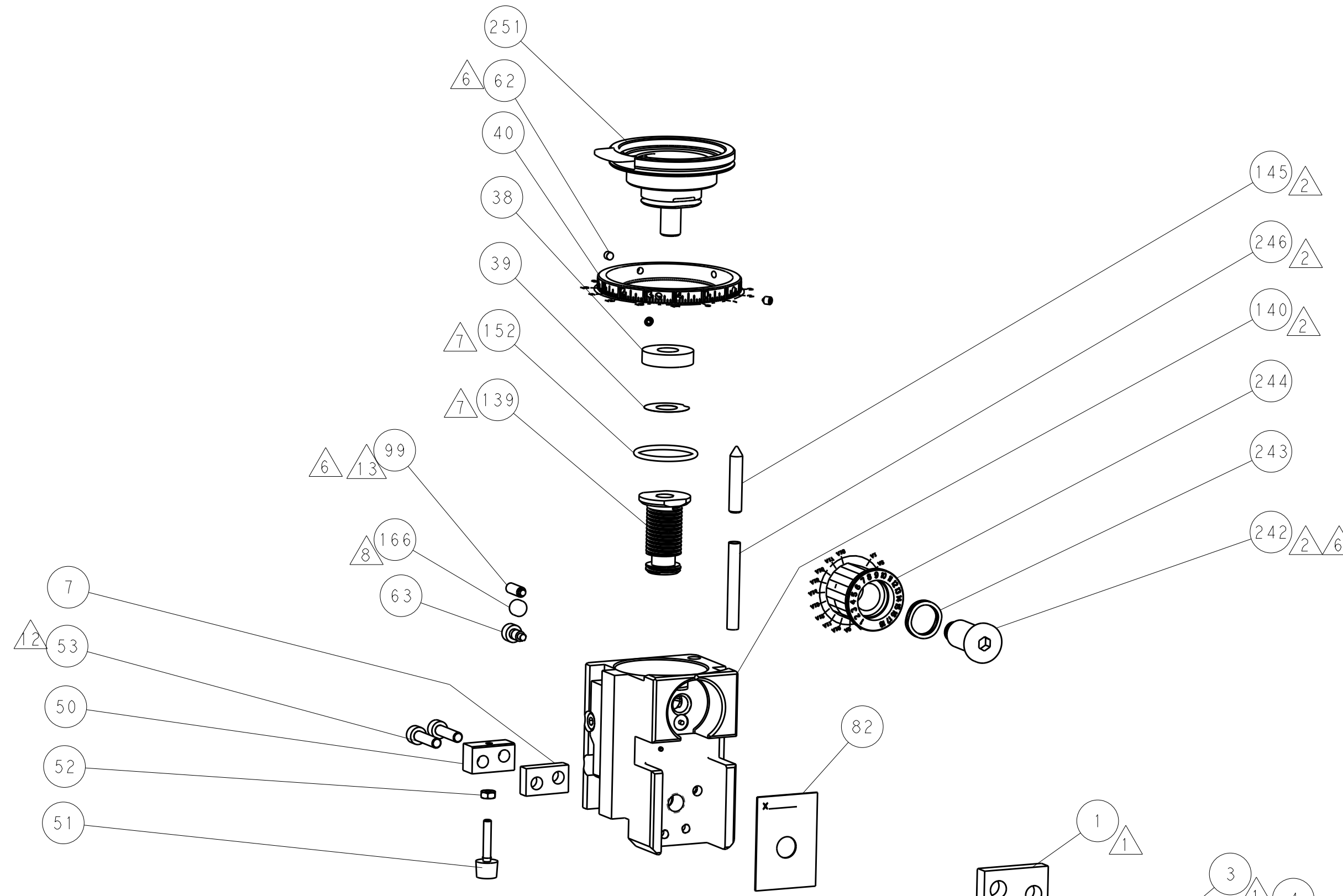
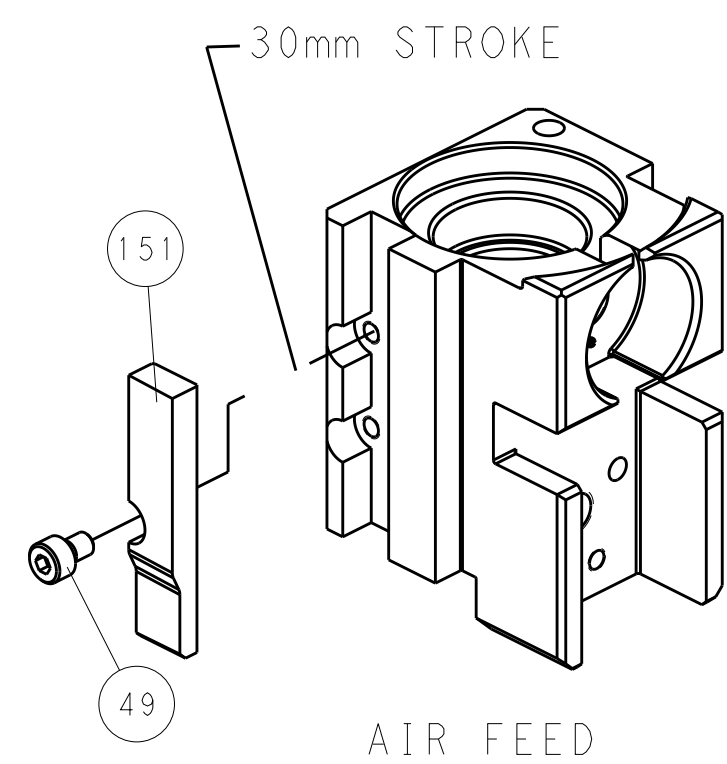
FEED TYPE PNEUMATIC



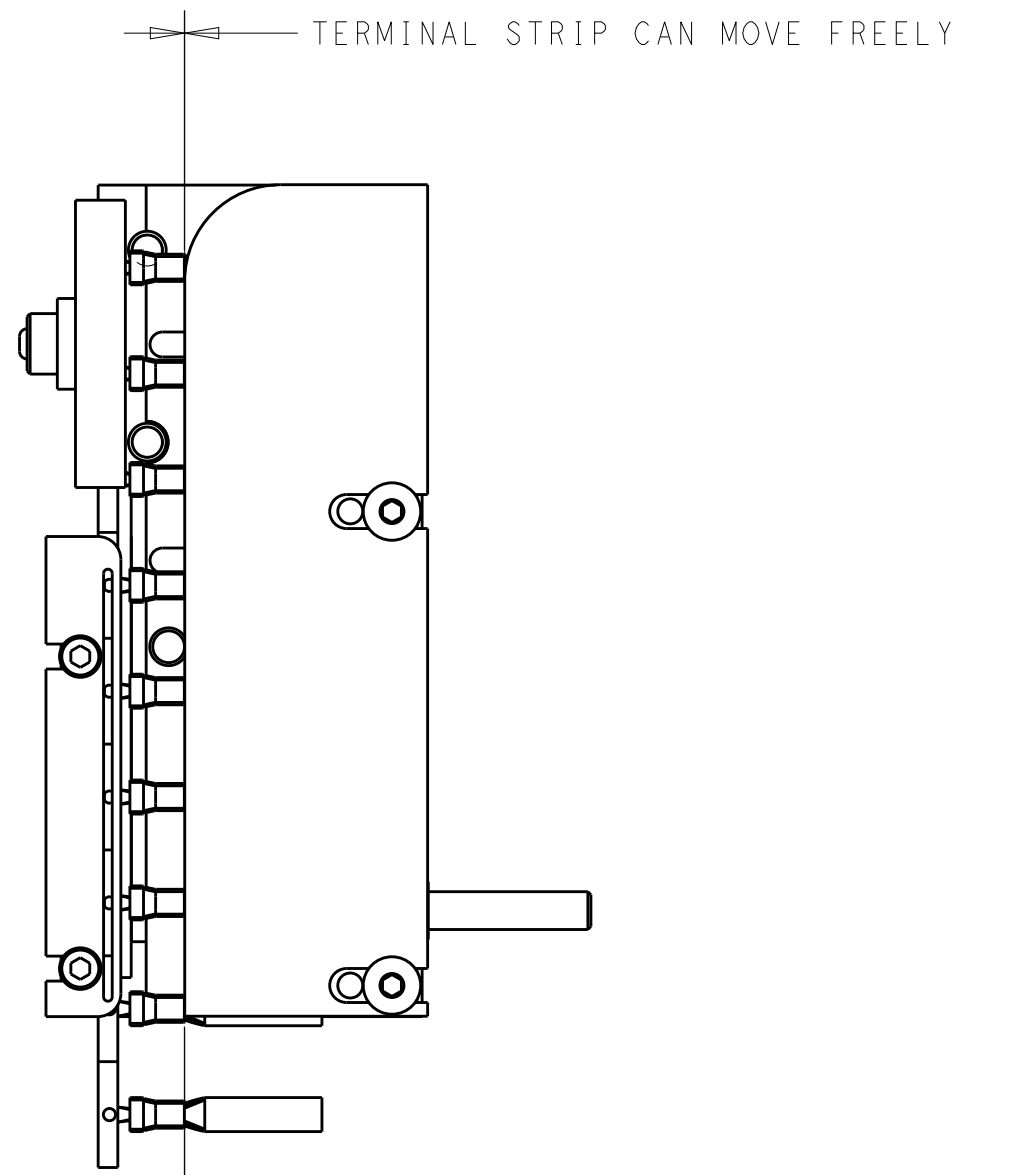
SERVO LATCH PLATE



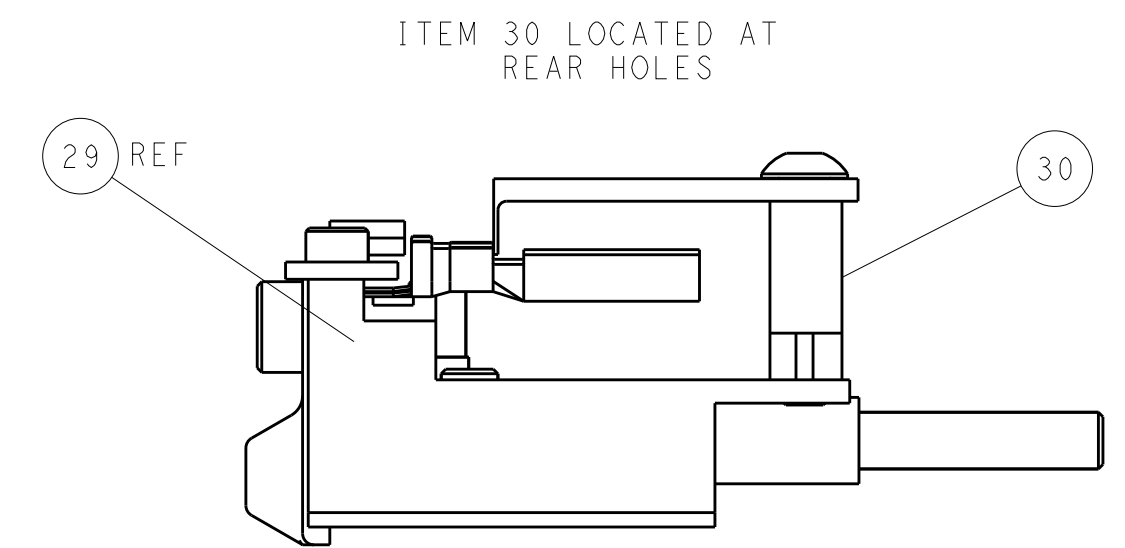
CAM POSITION



TERMINAL SUPPORT LOCATION



TERMINAL STRIP CAN MOVE FREELY WITH A MINIMUM OF SIDE CLEARANCE



TERMINAL GUIDE WIRE POSITION

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 R. KNEPPER 05APR2012 | | STE TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | Harrisburg, PA 17105-3608 | |
| MATERIAL: | | FINISH: | | CHK T. ELBIN 05APR2012 | | NAME Ocean Side Feed Applicator | |
| | | | | APVD M. CLIFFORD 05APR2012 | | SIZE CAGE CODE DRAWING NO | |
| | | | | PRODUCT SPEC | | RESTRICTED TO | |
| | | | | APPLICATION SPEC | | A 00779 ©=2151615 | |
| | | | | WEIGHT | | SCALE 1:2 SHEET 4 OF 4 REV H | |
| | | | | Customer Accessible Production Drawing | | | |