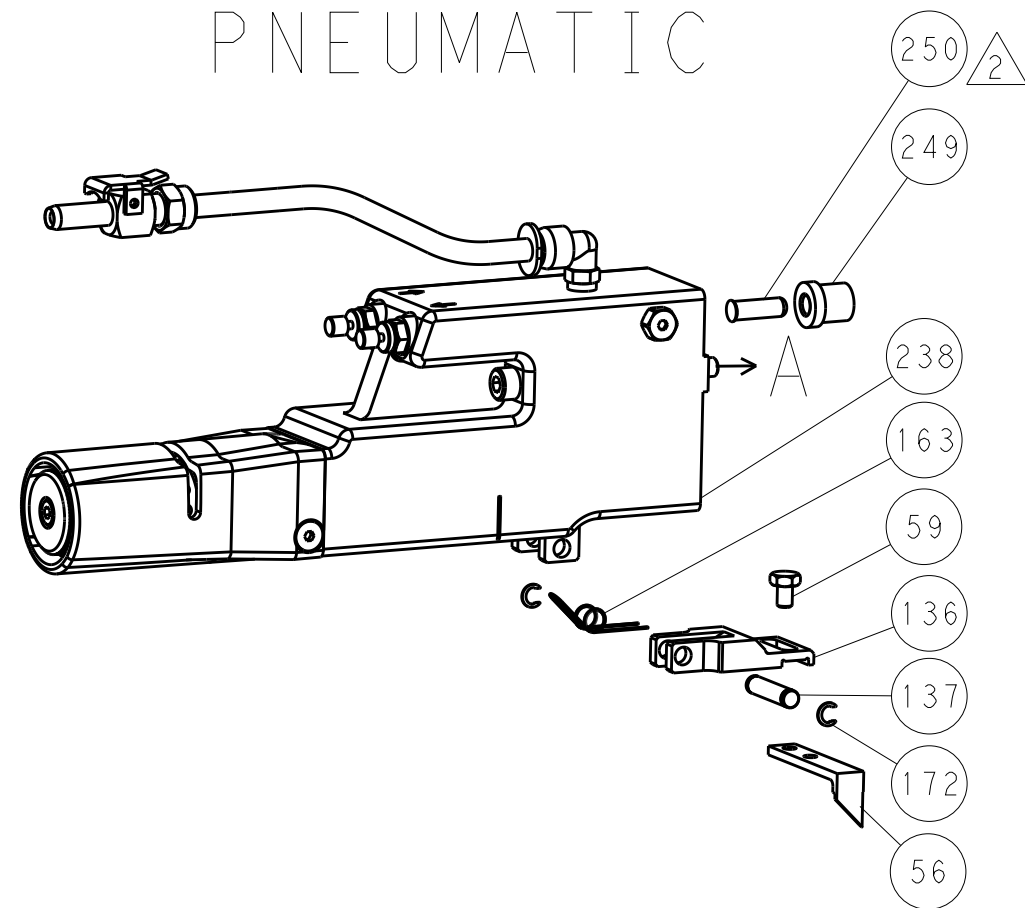


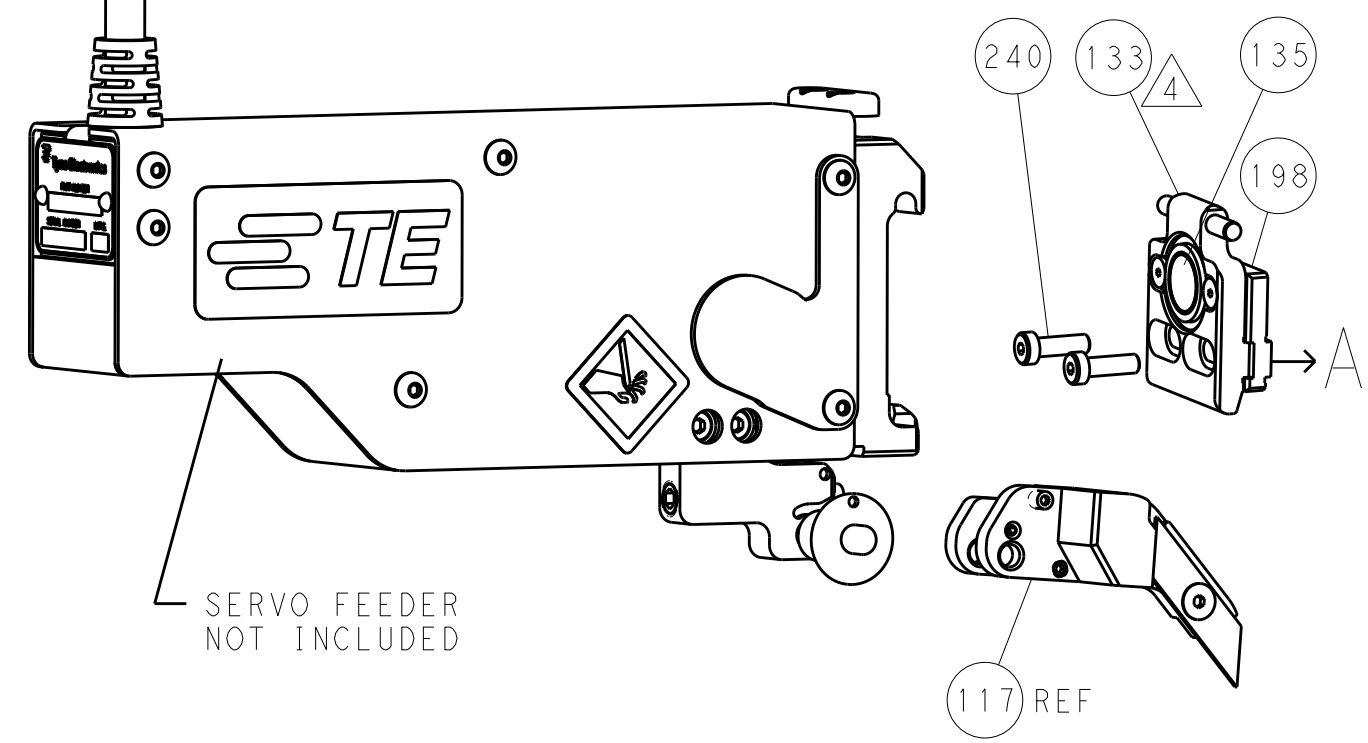
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE

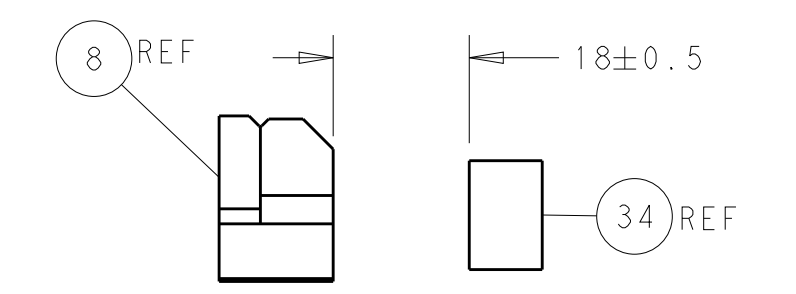
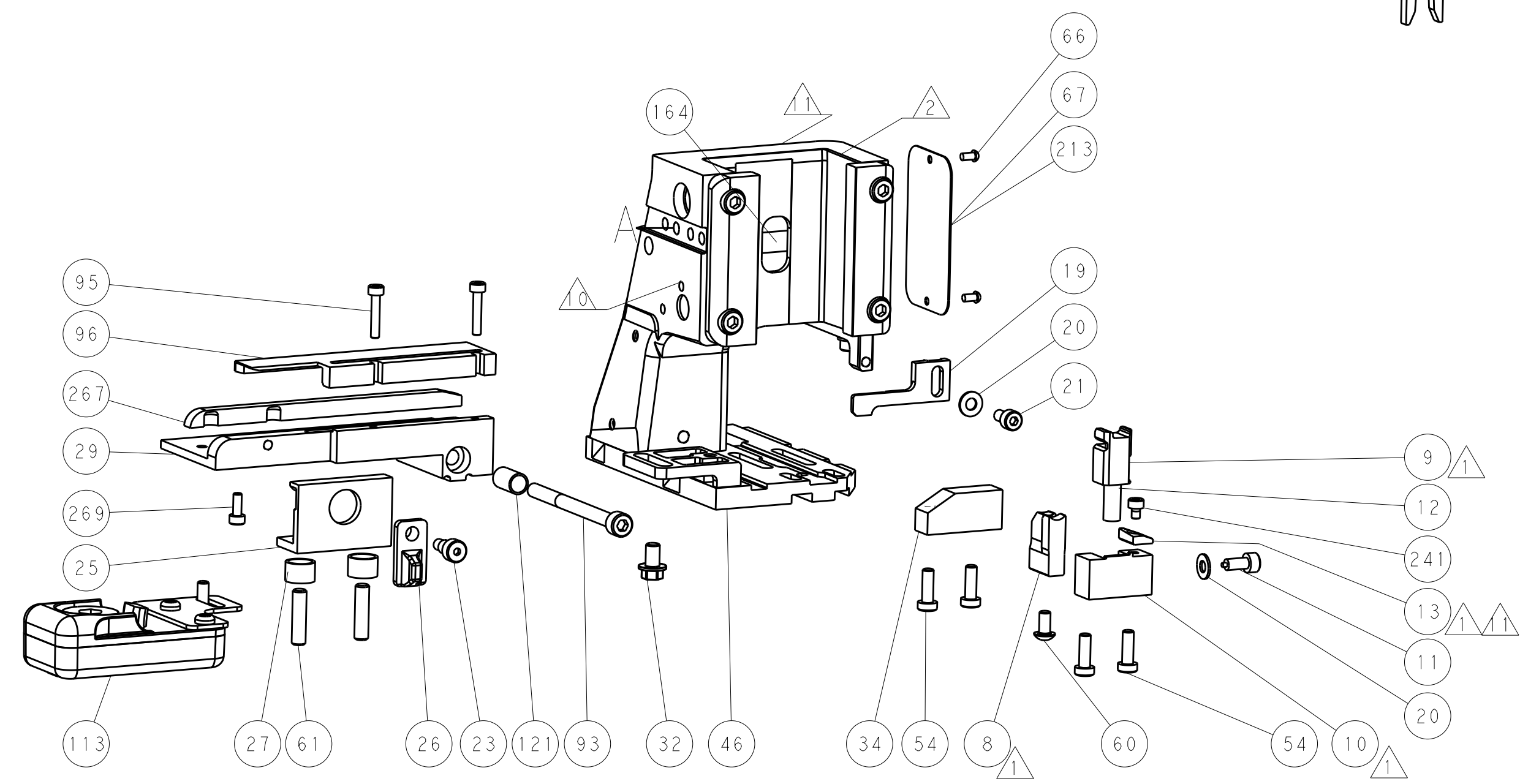
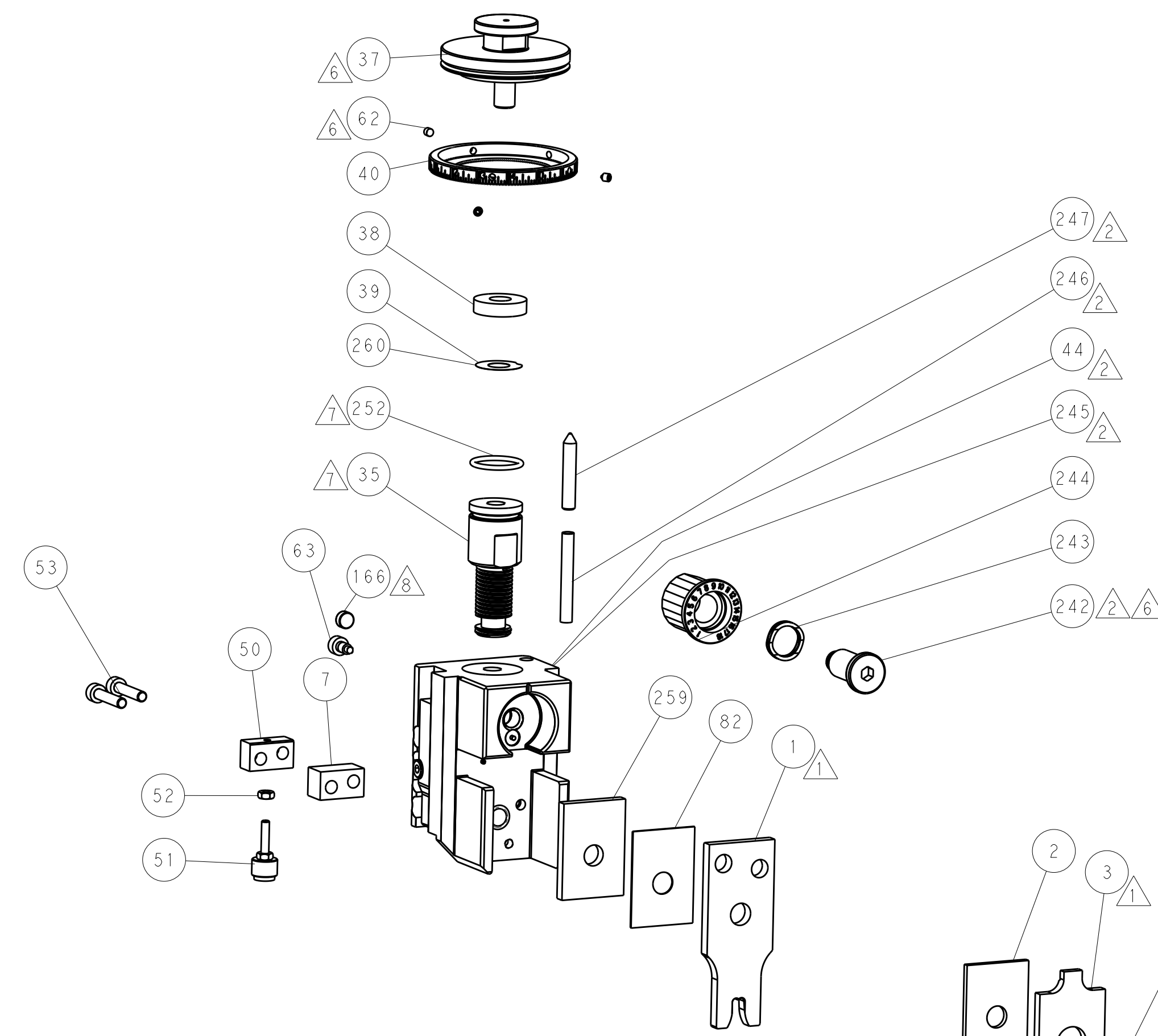
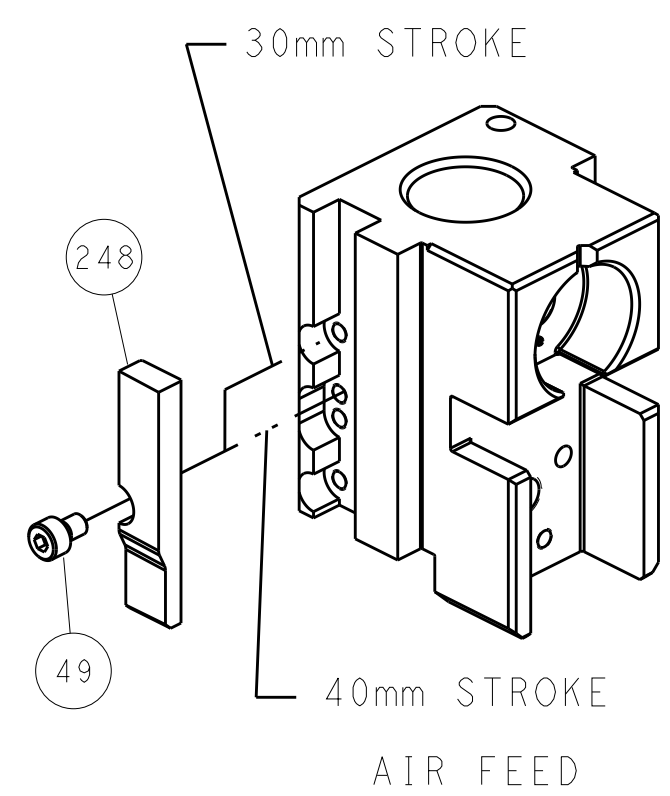
PNEUMATIC



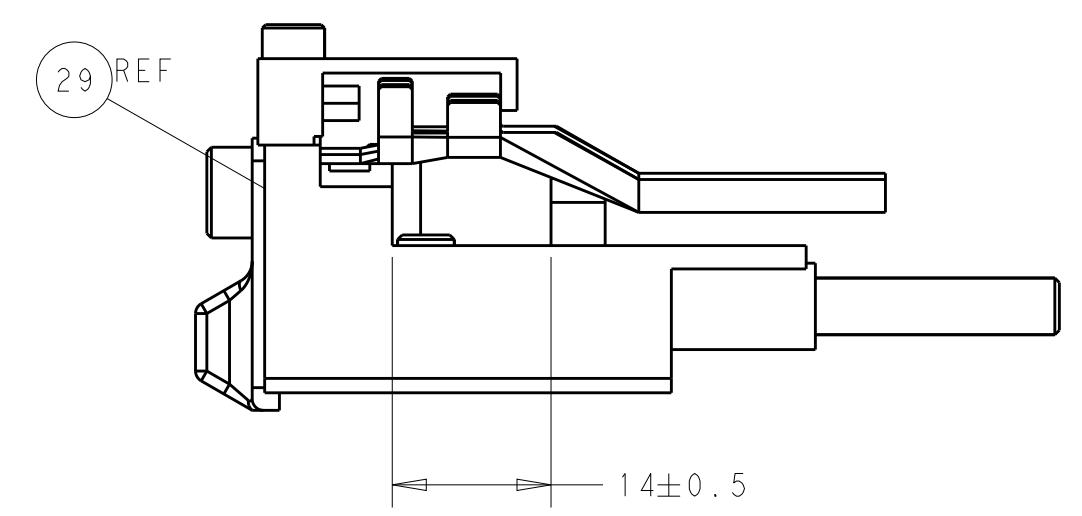
SERVO LATCH PLATE



CAM POSITION



TERMINAL SUPPORT LOCATION



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

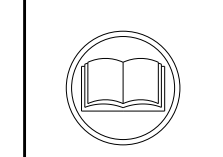
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. HUANG 30SEP2015		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD L. ZHANG 30SEP2015	NAME Ocean Side Feed Applicator
MATERIAL	FINISH	WEIGHT	SCALE	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
			1:2	A1	00779	©=2836005	
Customer Accessible Production Drawing				SHEET	2	OF	4
				REV	A		

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2836005-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2836005-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴
	2-2836005-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2836005-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 5.03 mm [.198]	F	
INSUL 6.78 mm [.267]	F	
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: KET TERMINAL LEONI CRIMP SPECIFICATION	
TERMINAL NAME: EARTH RING TERMINAL	
WIRE STRIP LENGTH 6.21-6.98 mm [.245-.275 IN]	INSULATION DIAMETER RANGE Ø3.45-4.60 mm [.136-.181 IN]
TERMINAL APPLICATION SPECIFICATION LEONI Rev -	
TERMINALS APPLIED ¹⁰ ¹¹	
TE TERMINAL 2113867-1	KET TERMINAL ST710991-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
AVSSXF 1.25+AESXF 2	2.45+/-0.05 [.096+/- .002]	5.7
(2) AVSSXF 0.85	2.40+/-0.05 [.094+/- .002]	5.3
AVSSXF 1.25+AESXF 0.75	2.35+/-0.05 [.093+/- .002]	6.4
AVSSXF 1.25 + 0.5	2.30+/-0.05 [.091+/- .002]	6.9



- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836005-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836005-5
- 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 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 TERMINAL LUBRICANT IS RECOMMENDED.

***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	PART NO	DESCRIPTION	ITEM NO
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
-	1	1	1	1-1633782-0	FENCE	267
-	1	1	1	1803078-3	SPACER, PRECISION	259
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249

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	P	LTN	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	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
-	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
-	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	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	2161312-1	RAM, STEPPED, 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
-	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1-1490899-3	GUIDE, FRONT STRIP	96
-	2	2	2	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	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
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	2	2	2	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
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	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	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	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	4-1752356-6	SUPPORT, TERMINAL	34
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1901086-3	PLATE, STRIP GUIDE	29
-	1	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	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
-	2	2	2	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	1-356885-3	STOP, SHEAR	11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
-	1	1	1	2-1333229-6	ANVIL, COMBINATION	8
-	1	1	1	5-240641-3	SPACER	7
-	-	-	-	-	-	6
-	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	1	238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	1	1-1803017-4	CRIMPER, INSULATION F	3
-	1	1	1	2-455888-1	SPACER, CRIMPER	2
-	1	1	1	1-1803241-4	CRIMPER, WIRE F	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE		NAME	
mm	0 PLC ±	1 PLC ±	2 PLC ±	30SEP2015	CHK	HUANG	30SEP2015
	3 PLC ±	4 PLC ±	ANGLES ±	APVD	LI	ZHANG	30SEP2015
MATERIAL	FINISH	WEIGHT	SCALE	Customer Accessible Production Drawing			
			1:2	SHEET 3 OF 4			

