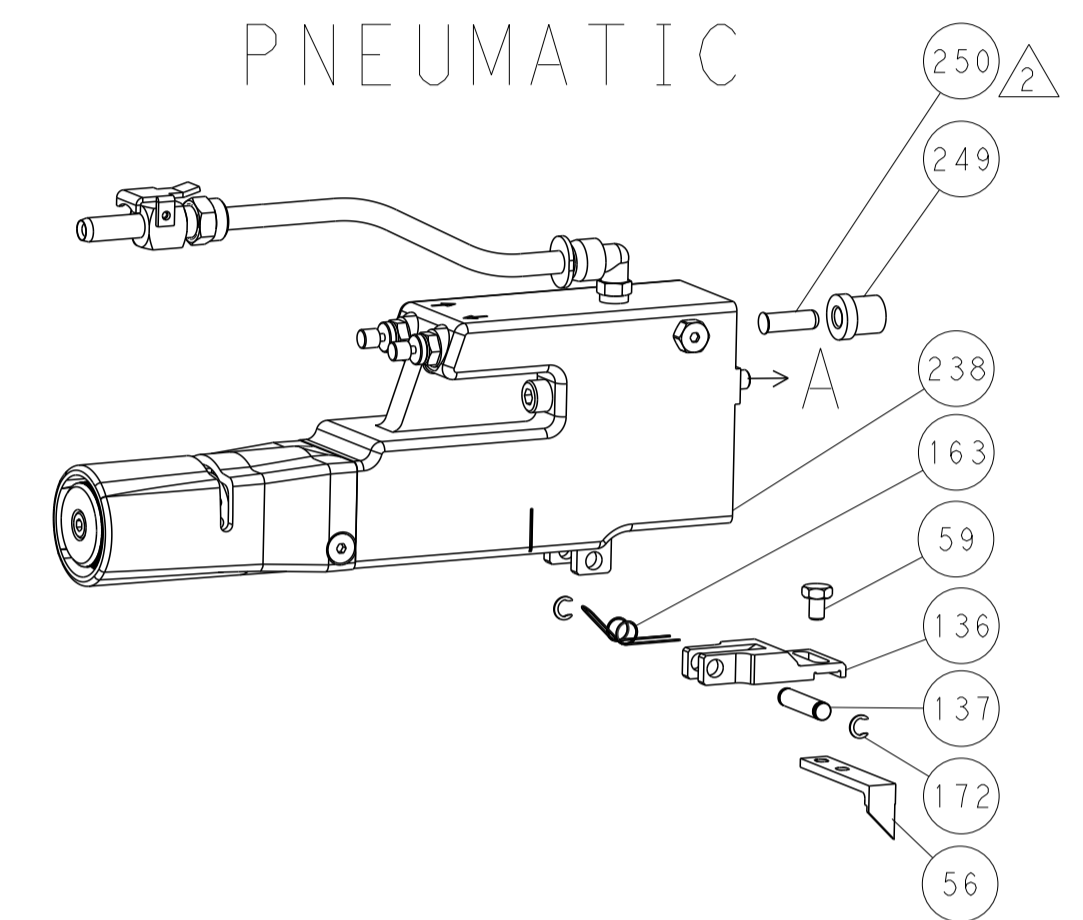


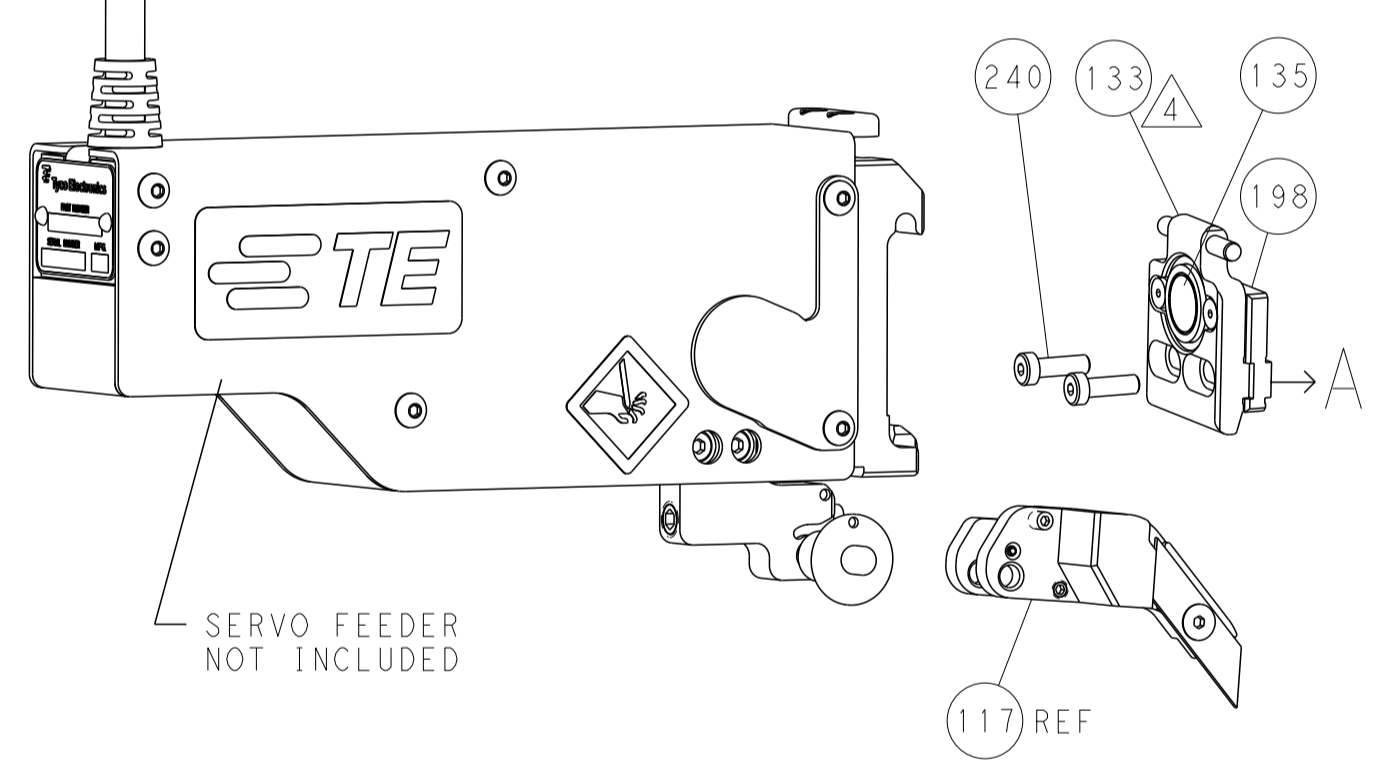
LOC		DIST		REVISIONS			
P	LTN	DESCRIPTION	DATE	OWN	APVD		
A	66	SEE SHEET 1					

FEED TYPE

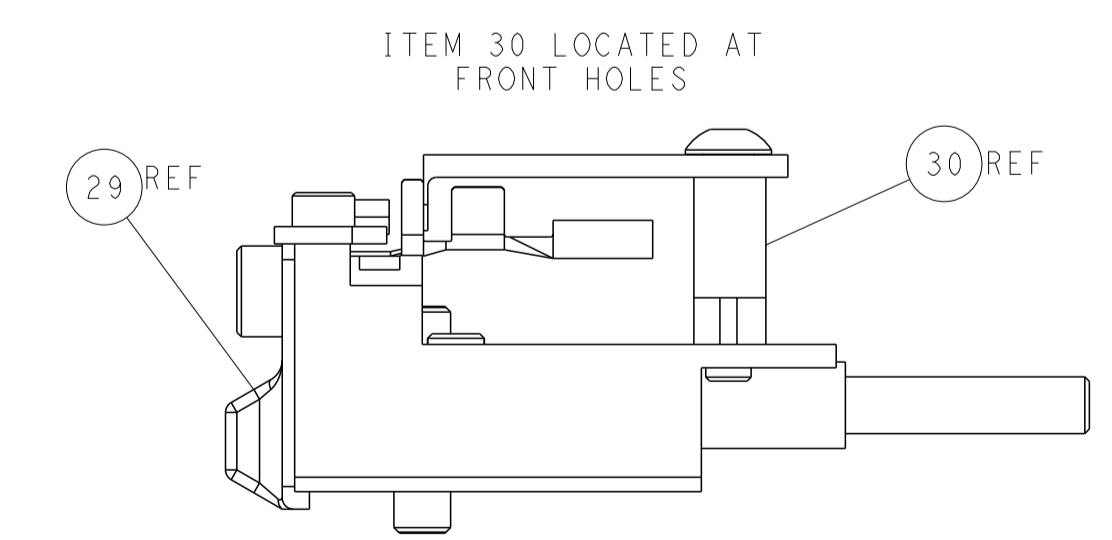
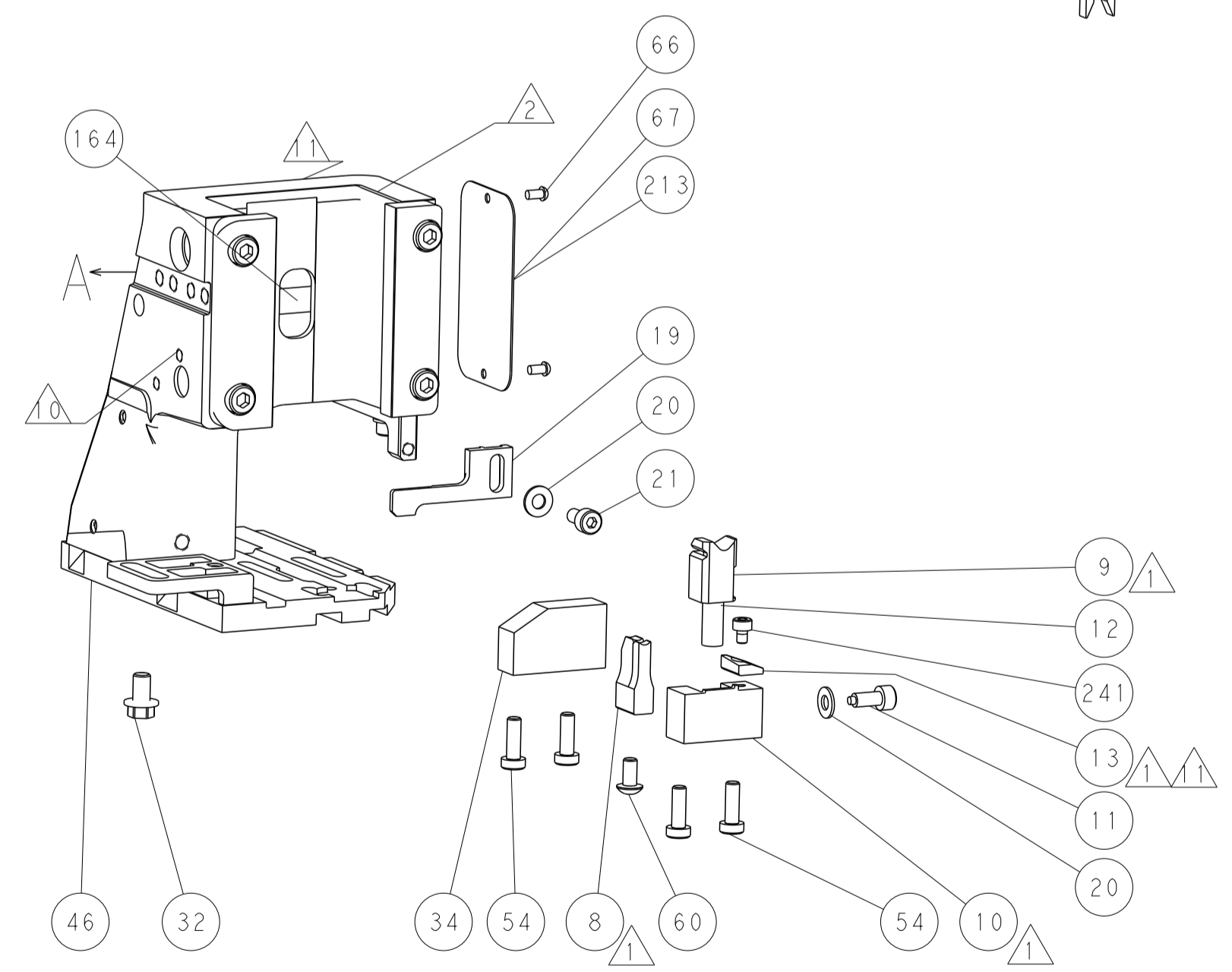
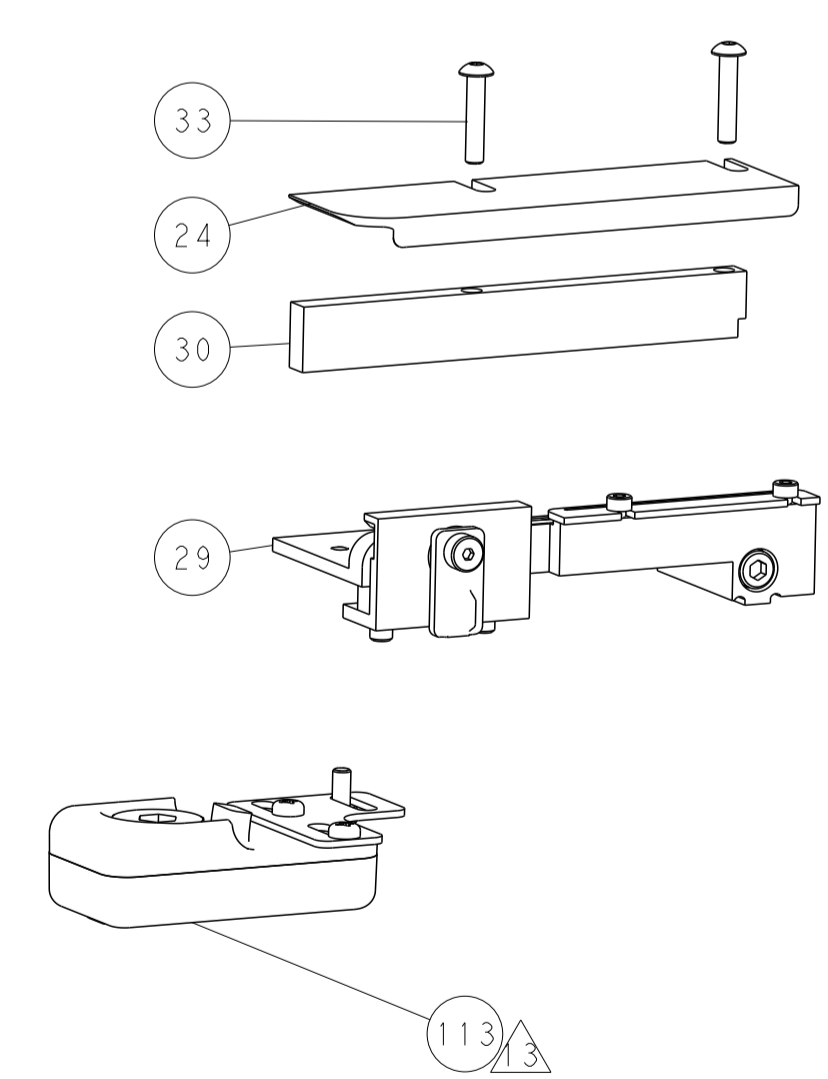
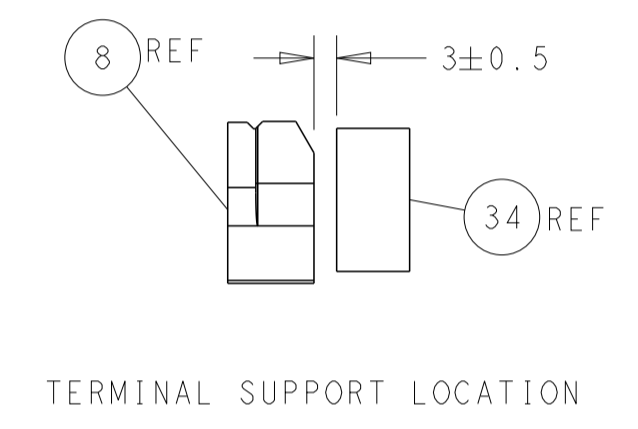
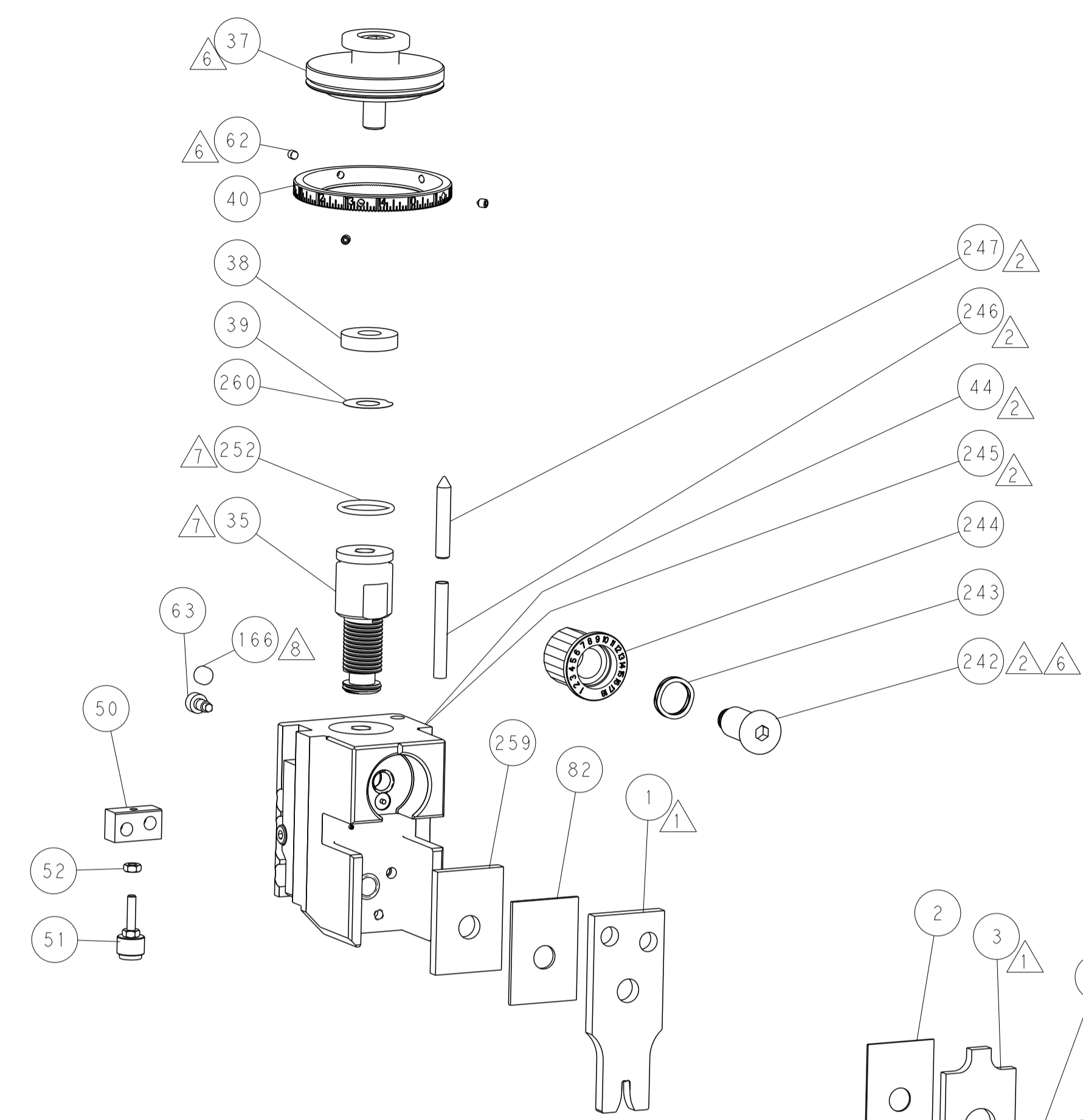
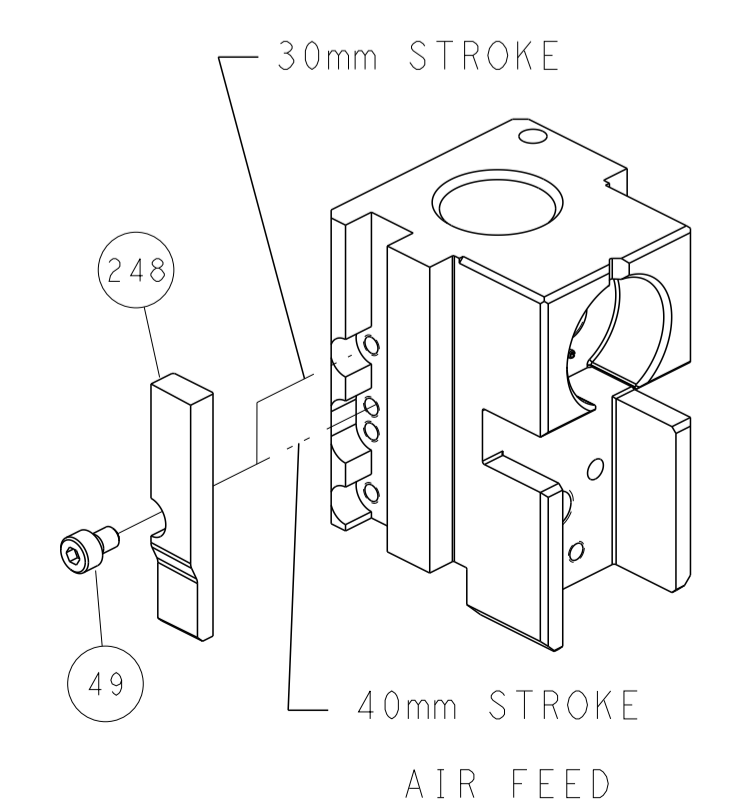
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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)

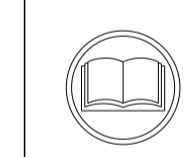
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: K. HUANG 05MAY2017		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD: L. ZHANG 05MAY2017		NAME: Ocean Side Feed Applicator	
				PRODUCT SPEC:		RESTRICTED TO:	
				APPLICATION SPEC:		SIZE: A1	
				WEIGHT:		CAGE CODE: 00779	
				SCALE: 1:2		DRAWING NO: C=2836746	
				SHEET: 2 OF 4		REV: A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2836746-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2836746-5	1901094-3	-
	2-2836746-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE Δ	-	-	-	-	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1
2-2836746-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
7-2836746-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [1.20]	F
INSUL	4.00 mm [1.57]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: ZBN TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: ZBN TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
5.89-6.65 mm [1.232-.262 IN]		\varnothing 2.39-3.18 mm [1.094-.125 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED Δ Δ Δ			
TE TERMINAL	ZBN TERMINAL	TE TERMINAL	ZBN TERMINAL
2318278-1	DJ628-6.3C		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING Δ
3.00mm2	2.45+/-0.05 [1.096+/-0.002]	6.0
2.50mm2	2.32+/-0.05 [1.091+/-0.002]	7.0
2.00mm2	2.18+/-0.05 [1.086+/-0.002]	8.5



- Δ 1 RECOMMENDED SPARE PARTS
- Δ 2 GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- Δ 4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2836746-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2836746-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- Δ 6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- Δ 7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- Δ 8 MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- Δ 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.
- Δ 10 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- Δ 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.
- Δ 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.

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

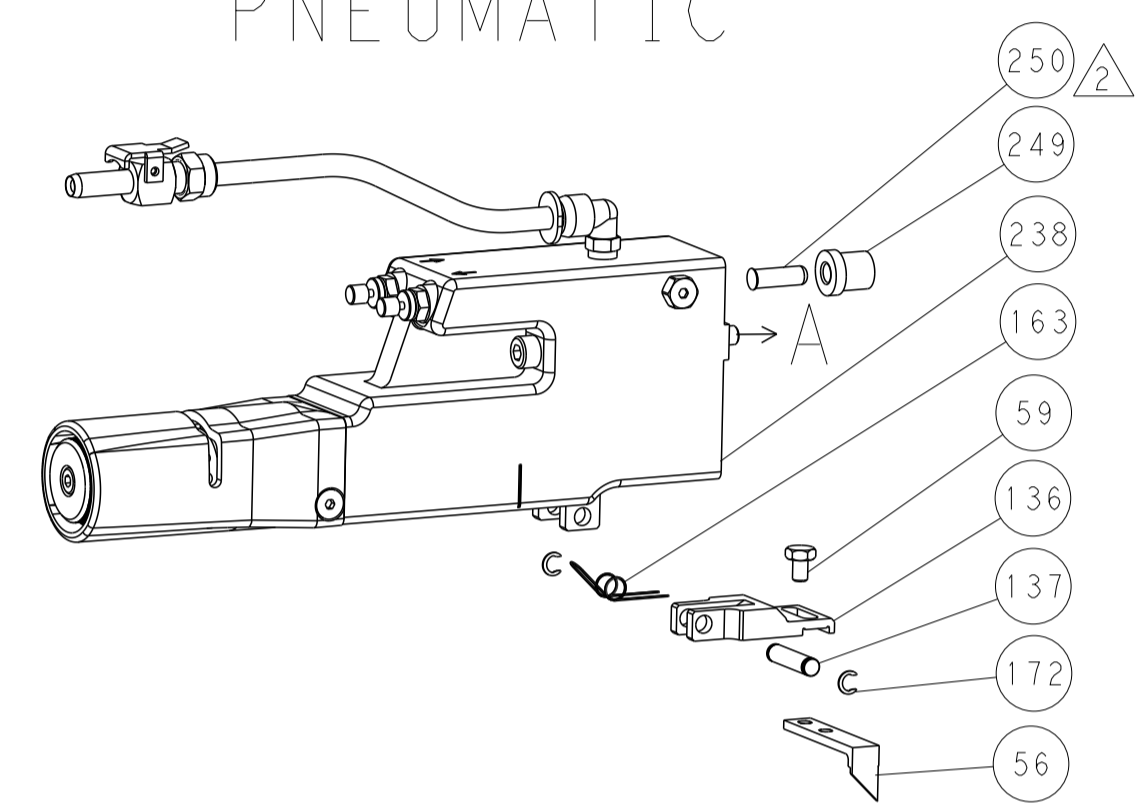
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1	-	-

-	1	1	1	1803078-3	SPACER, PRECISION	259	
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251	
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250	
-	-	-	1	1803259-1	BUSHING, FLANGED	249	
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246	
-	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
Δ 6	-	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	2063440-2	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	
Δ 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	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1	1	2161312-1	RAM, STEPPED, ASIAN STYLE, SIDE FEED	140	
Δ 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	
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
Δ 12	-	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1-455888-2	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	
Δ 6	-	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	1338685-1	PAWL, FEED	56	
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	1-2119644-3	RAM WASHER, PRECISION	38	
-	1	1	1	3-1752356-3	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	1-1320908-0	SPACER, STRIP GUIDE	30	
-	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1320928-2	STRIP GUIDE	24	
-	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	
Δ 11	-	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	
Δ 1	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
Δ 1	-	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
Δ 1	1	1	1	1	1-1633925-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	7	
-	-	-	-	-	-	6	
-	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5	
-	1	1	1	5-238011-7	BLOCK, CRIMPER SPACER	4	
Δ 1	1	1	1	1	5-1803017-7	CRIMPER, INSULATION F	3
-	1	1	1	455888-6	SPACER, CRIMPER	2	
Δ 1	1	1	1	1	3-456409-6	CRIMPER, WIRE .120 "F" PREMIUM	1

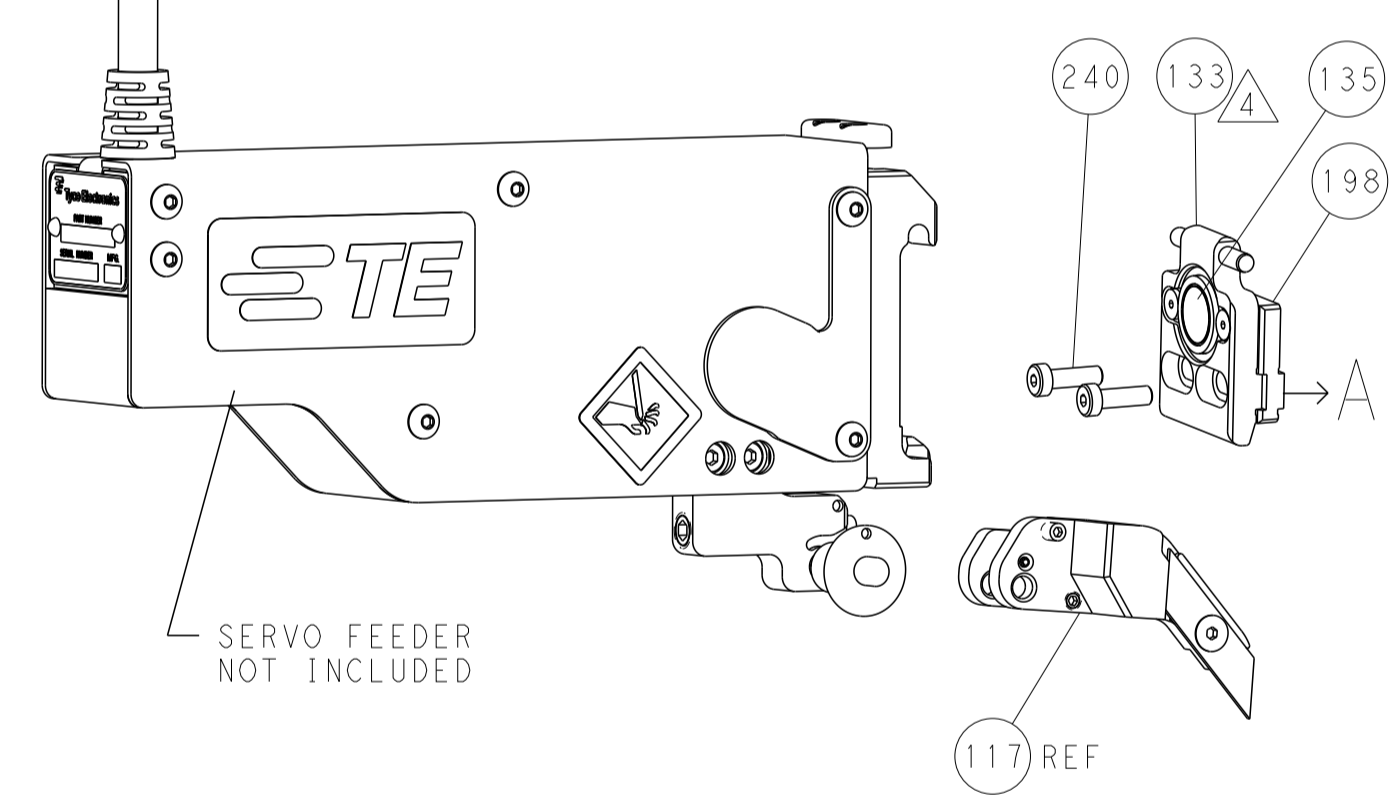
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	1 PLC	±	05MAY2017	Ocean Side Feed	
	3 PLC	±		Applicator	
	4 PLC	±		SIZE CAGE CODE DRAWING NO	
	ANGLES	±		RESTRICTED TO	
	FINISH	±		A1 00779 C=2836746	
MATERIAL			WEIGHT	Customer Accessible Production Drawing	
				SCALE 1:2 SHEET 3 OF 4 REV A	

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

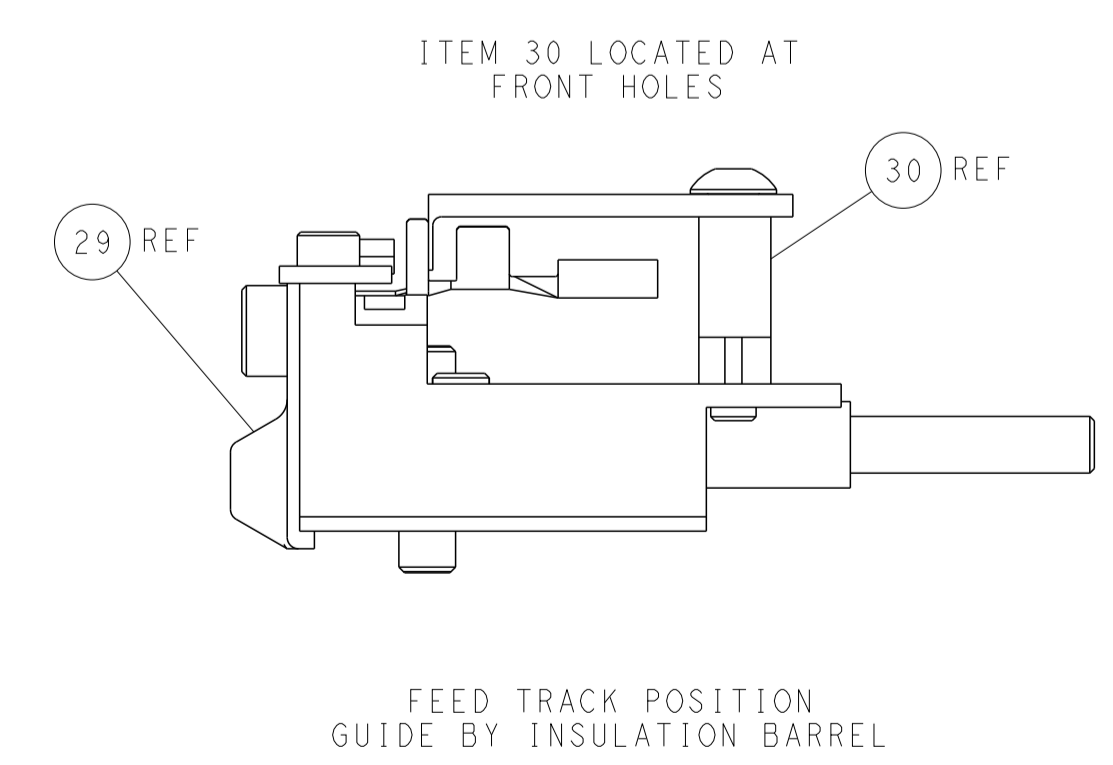
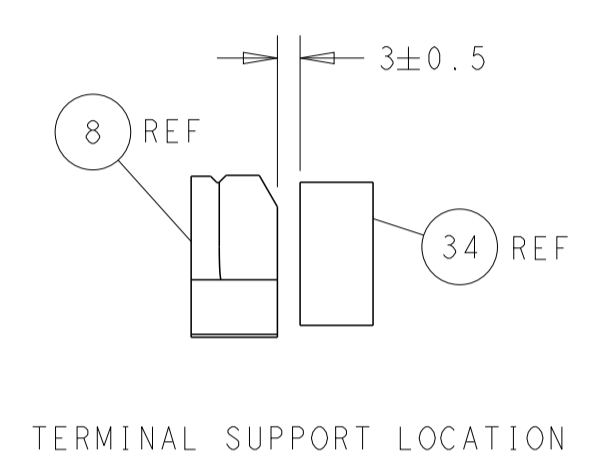
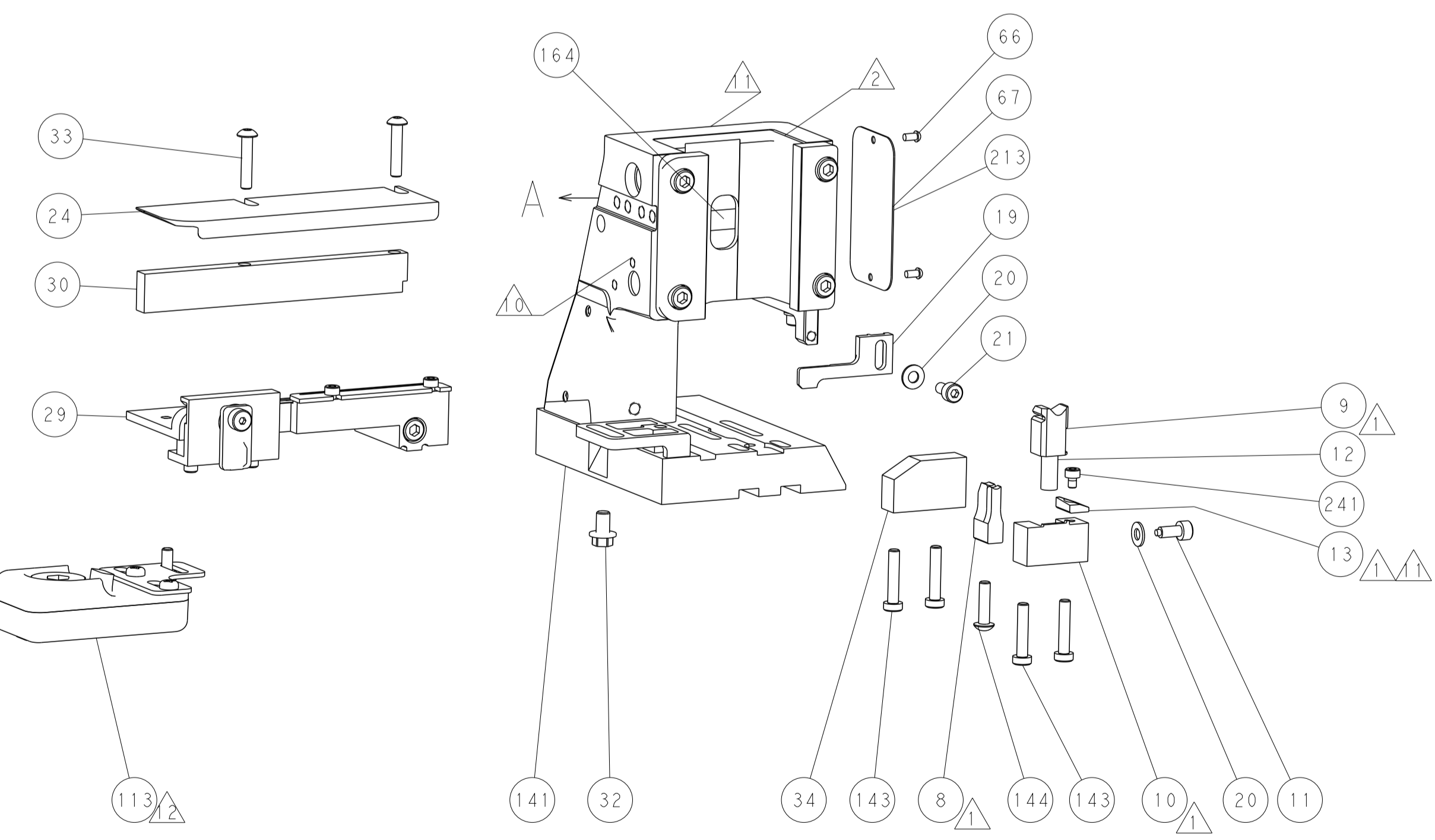
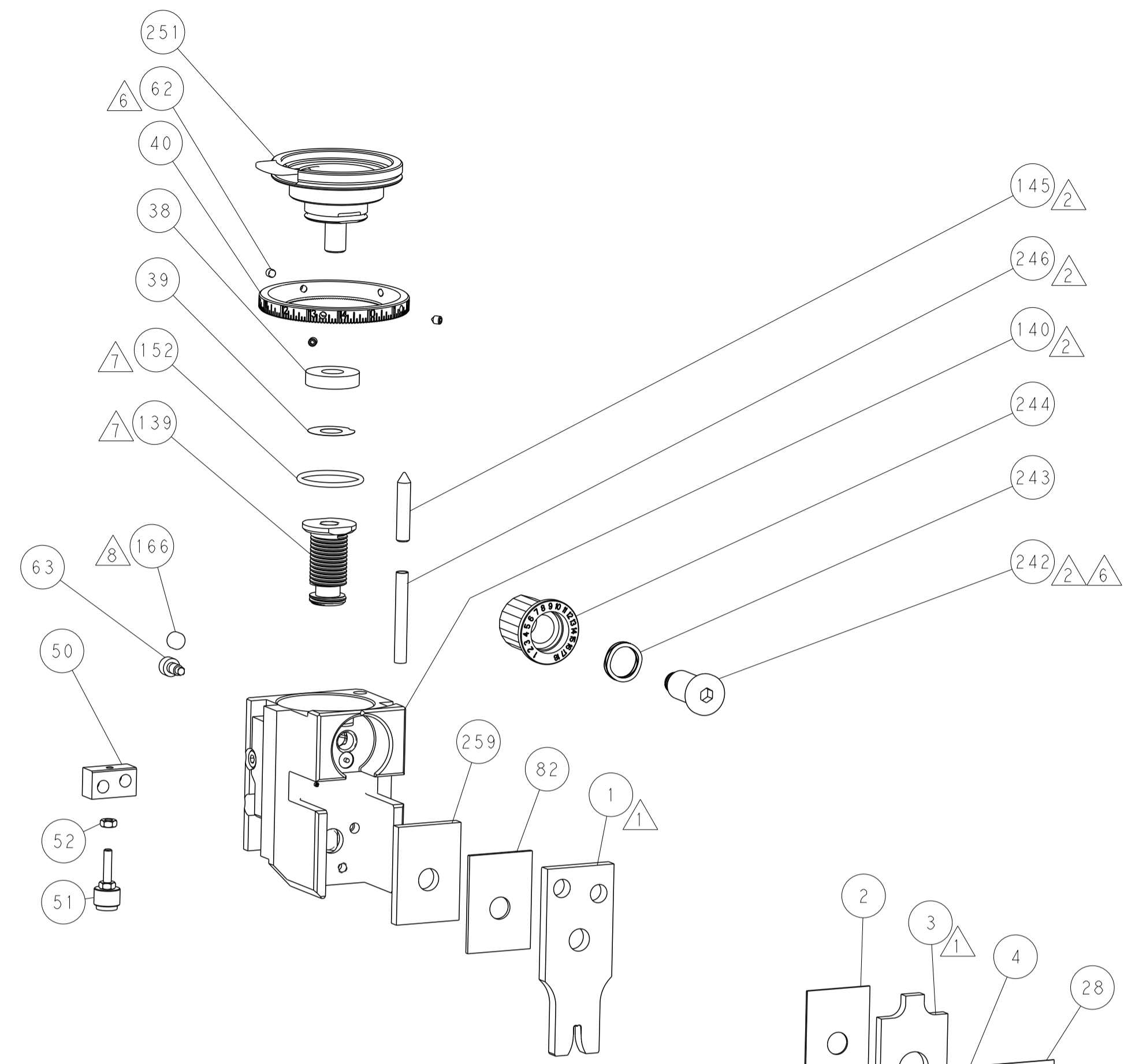
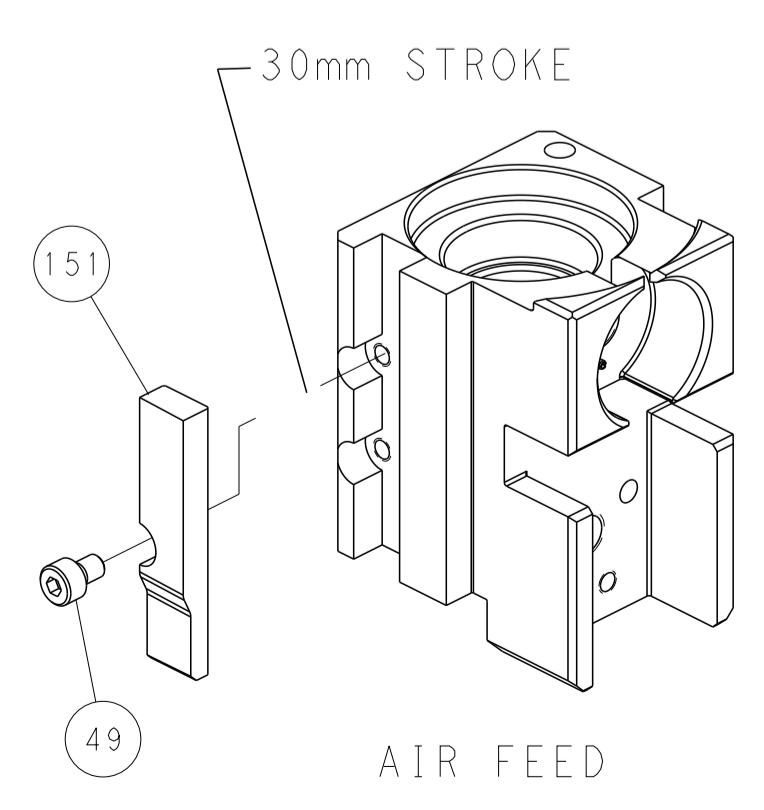
FEED TYPE PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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 ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN K. HUANG 05MAY2017 CHK K. HUANG 05MAY2017 APVD L. ZHANG 05MAY2017 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2836746 SCALE 1:2 SHEET 4 OF 4 REV A		RESTRICTED TO -	
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