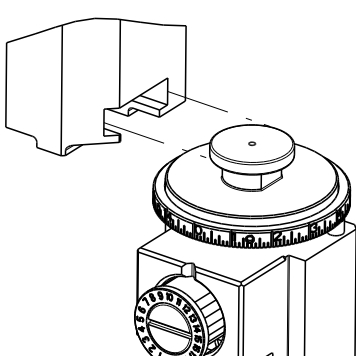


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	ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
						-	-	-	-	-	-	
						SERVO LATCH PLATE	2119951-1	-	8-2151823-5	1901094-3	2-1752354-2	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2151823-4	-	-	-
						-	-	-	-	-	-	-
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-2
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APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.03 mm [.080]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: MOLEX TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL, WIRE SNAP ON FEMALE			
WIRE STRIP LENGTH 4.19-4.57 mm [.165-.180 IN]		INSULATION DIAMETER RANGE Ø0.00-1.65 mm [.000-.065 IN]	
TERMINAL APPLICATION SPECIFICATION		TERMINAL APPLICATION SPECIFICATION	
TERMINALS APPLIED		TERMINALS APPLIED	
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113200-1	F65B-14474-SB	2113200-2	33112-0004

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
18 AWG			1.47+/-0.05 [0.58+/- .002]		10.1	
20 AWG			1.31+/-0.05 [0.52+/- .002]		11.7	



 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: 8-2151823-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151823-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151823-6

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 & 180.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.

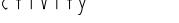
10 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

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 OF 4.33.

AMP 4805 REV 31MAR2000

			2		1			
SET UP GAUGE 2119599-1			LOC A	DIST 66	REVISIONS			
		P	LTR	DESCRIPTION		DATE	DRN	APVD
			A	RELEASED		11JAN2013	LG	TE
			B	ECR-13-001589		28JAN2013	L.Z	S.X
			C	ECR-18-001651		01FEB2018	TB	CT
6	-	-	1	1	-	2119740-2	TAG, IDENTIFICATION	213
	-	-	1	1	-	1901094-3	SPACER, FEEDER	198
	-	1	1	1	1	2-1752354-2	STANDOFF, HOLD-DOWN	180
	-	1	1	1	1	9931111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
8	-	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	-	-	-	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
6	-	-	-	-	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
6	-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
	-	-	REF	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
	-	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
6	-	1	1	1	1	318563-1	GUARD, FRONT CHIP	89
	-	1	1	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	22278-8	SPRING, COMPRESSION	77
	-	1	1	1	1	854769-4	HOLDER, INS	74
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
6	-	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 PNT, M3 x 4.0	62
	-	2	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0	61
6	-	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	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	-	-	-	1	1338685-1	PAWL, FEED	56
	-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
6	-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
	-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	-	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
6	-	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
6	-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	1	1	1	1	3-1752356-3	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	1320908-3	SPACER, STRIP GUIDE	30
6	-	1	1	1	1	1901086-5	PLATE, STRIP GUIDE	29
	-	1	1	1	1	455888-3	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	240792-2	DRAG, TERMINAL	25
6	-	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	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	8-1333203-3	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	6-1633961-3	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-5	SPACER, CRIMPER	2
	1	1	1	1	1	456404-9	CRIMPER, WIRE PREMIUM	1
	-77	7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

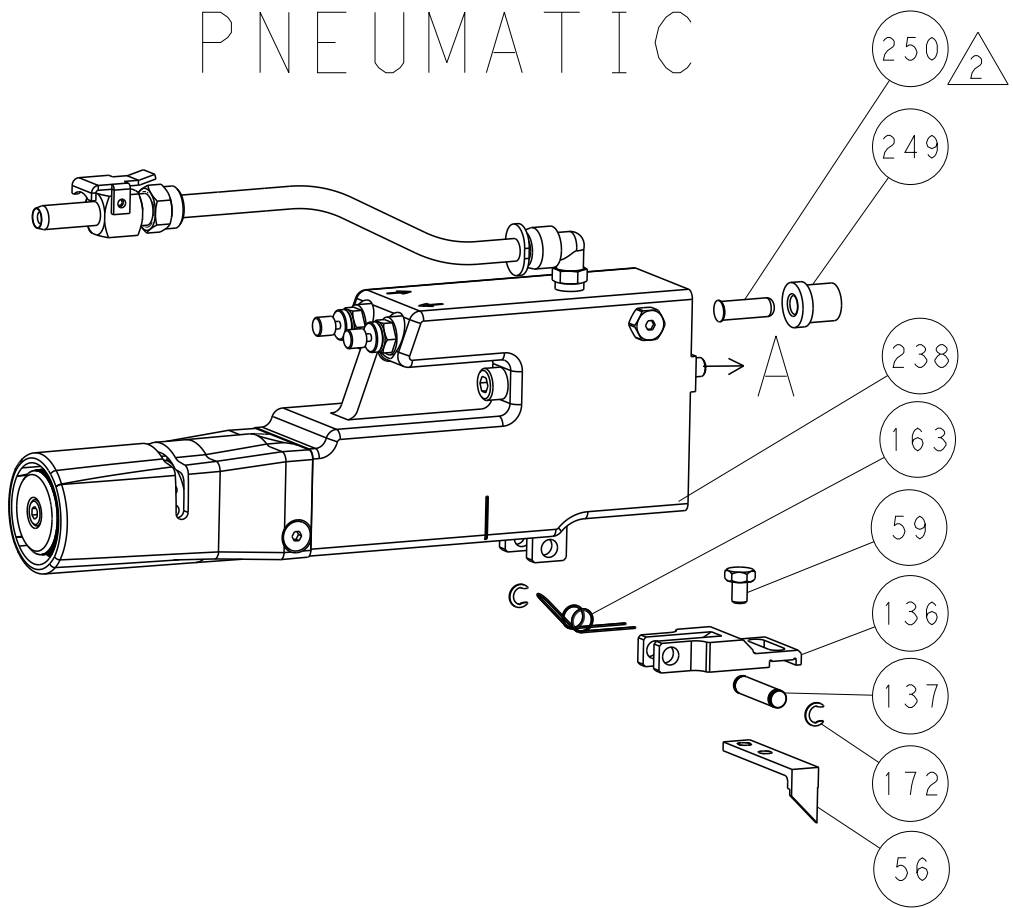
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						CDR K. J. STAKEM 30DEC2012			
DIMENSIONS: mm						TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±° FINISH		NAME Ocean Side Feed Applicator -	
						ARVD L. ELBIN 30DEC2012			
						PRODUCT SPEC			
						APPLICATION SPEC			
MATERIAL -						SIZE A 00779		DRAWING NO C=2151823	
WEIGHT -						RESTRICTED TO -			
Customer Accessible Production Drawing						SCALE 1:2		SHEET 1 of 4 REV C	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

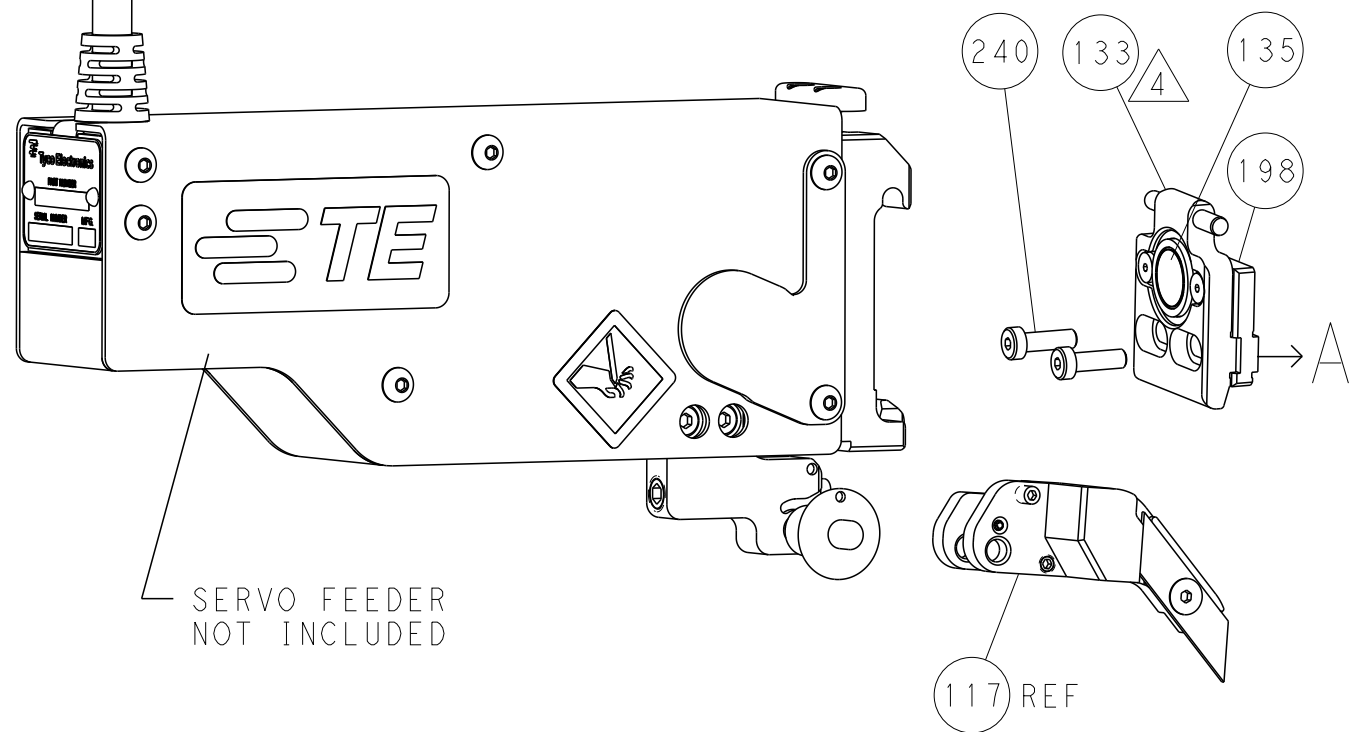
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

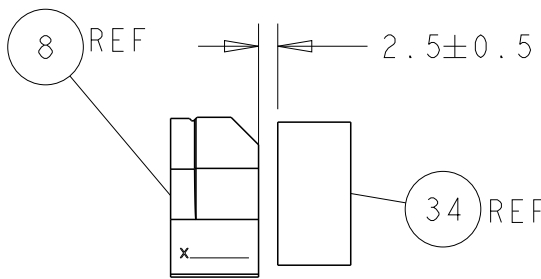
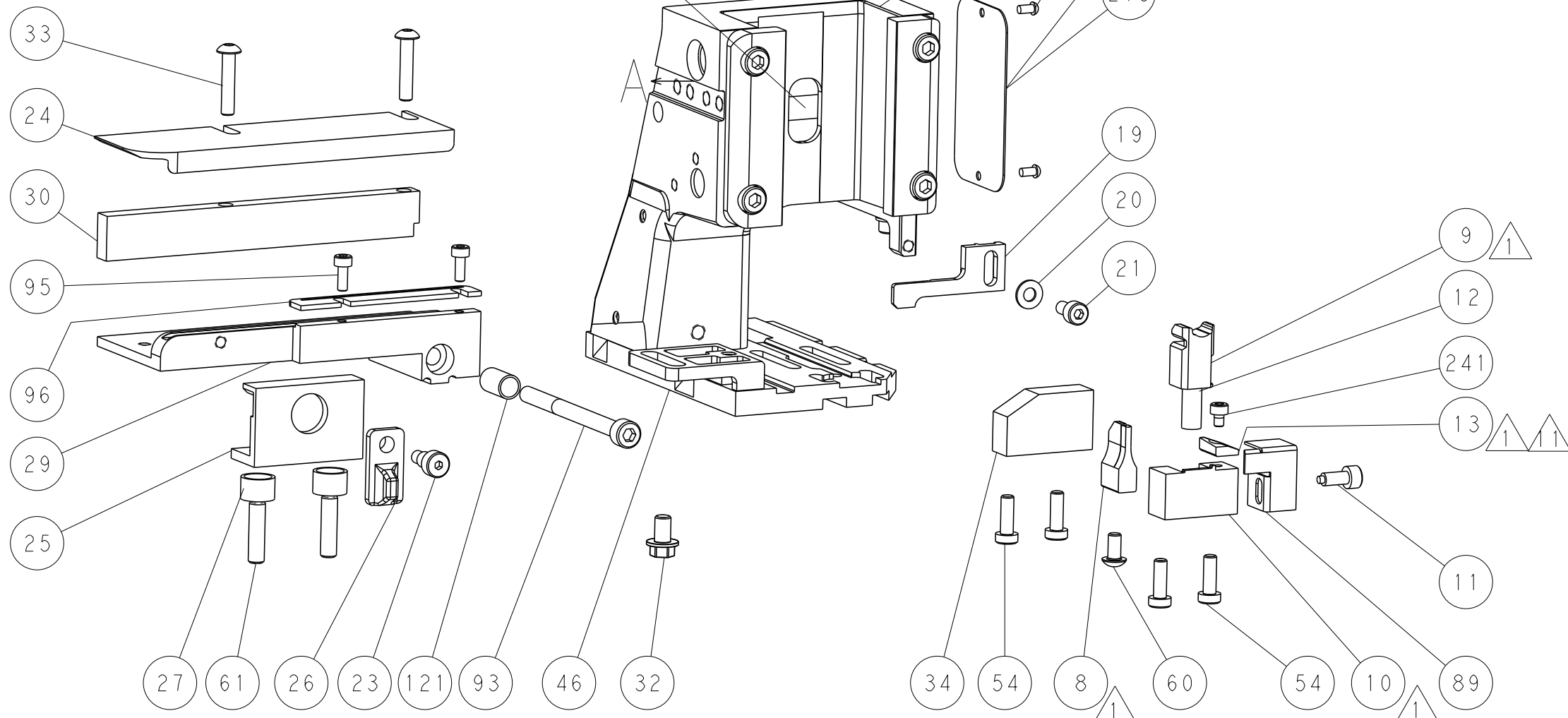
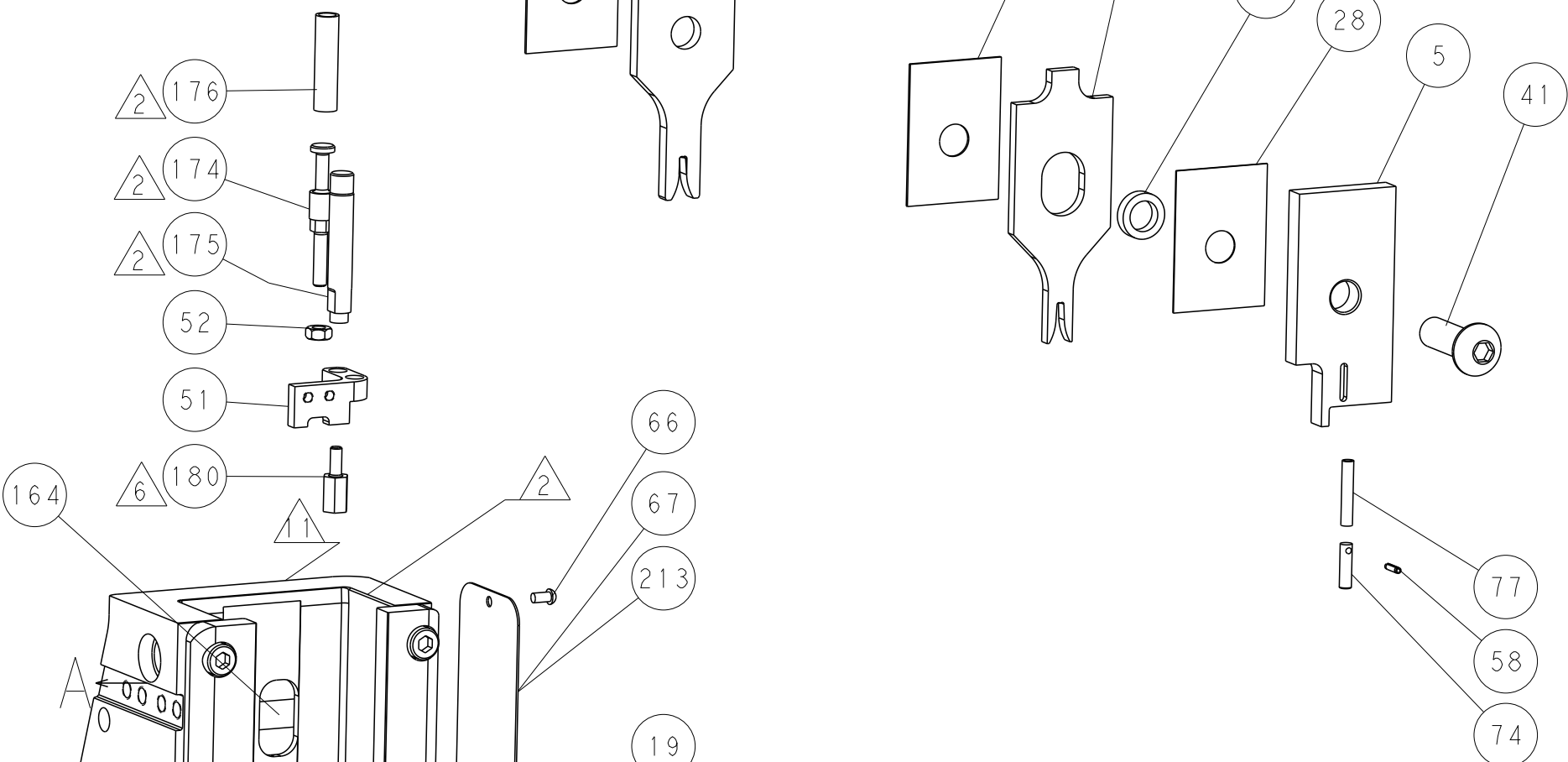
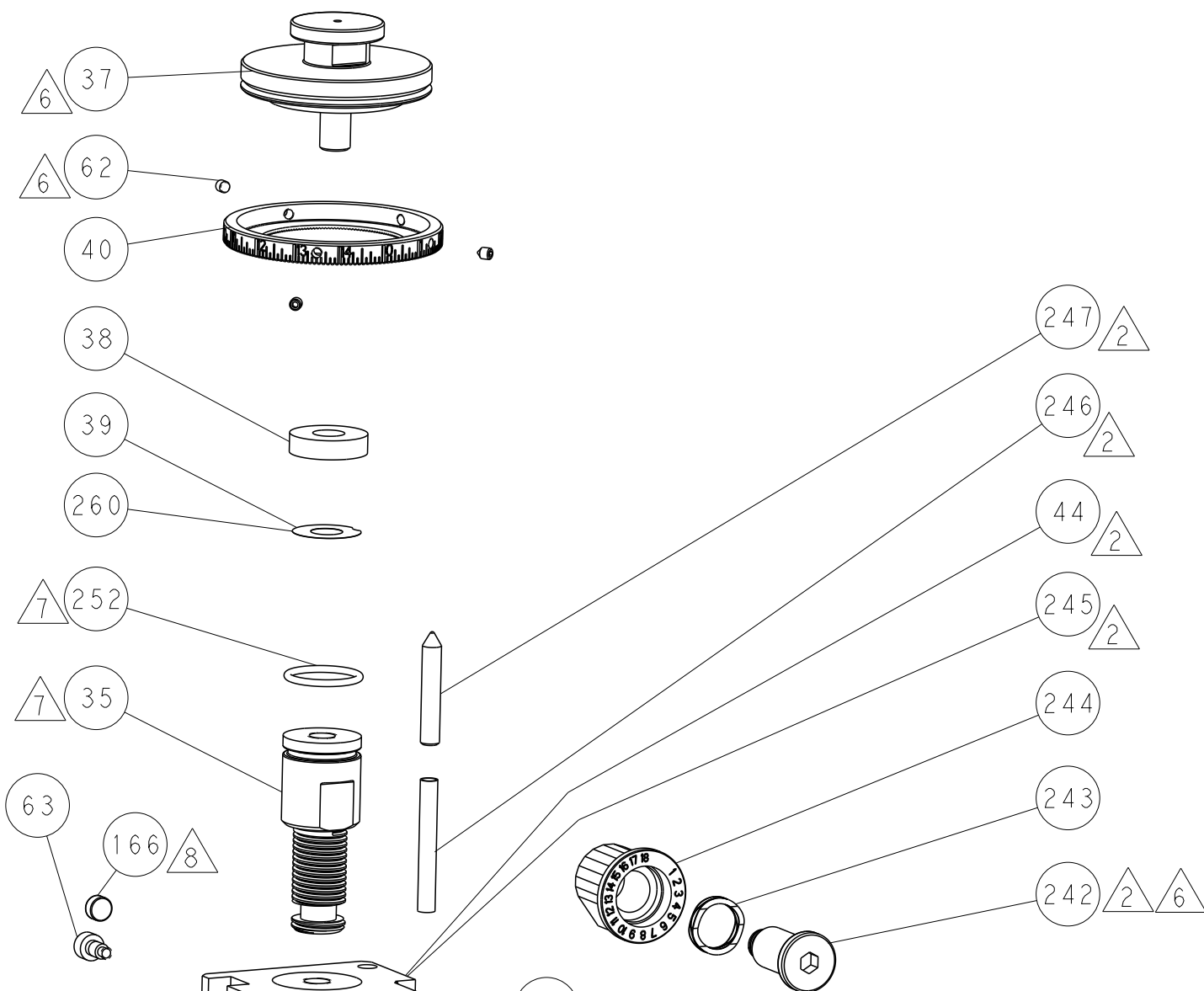
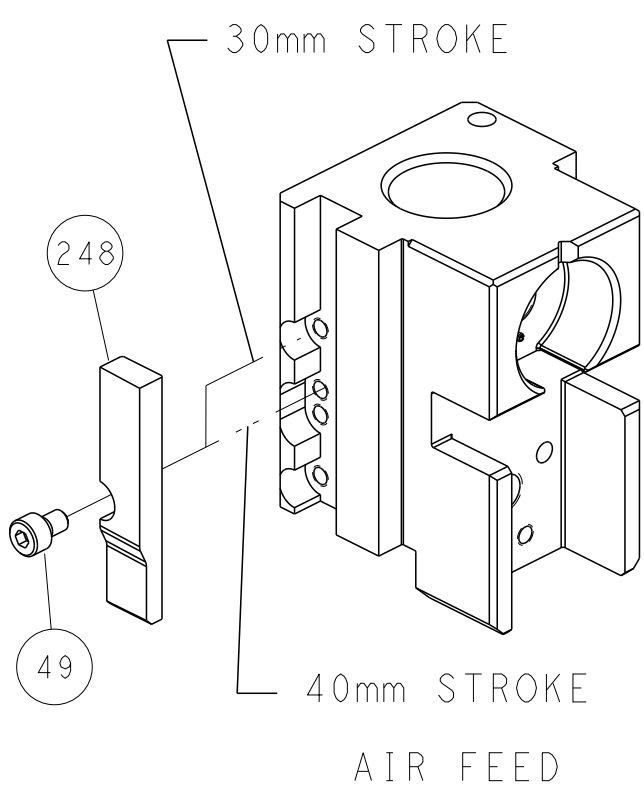
PNEUMATIC



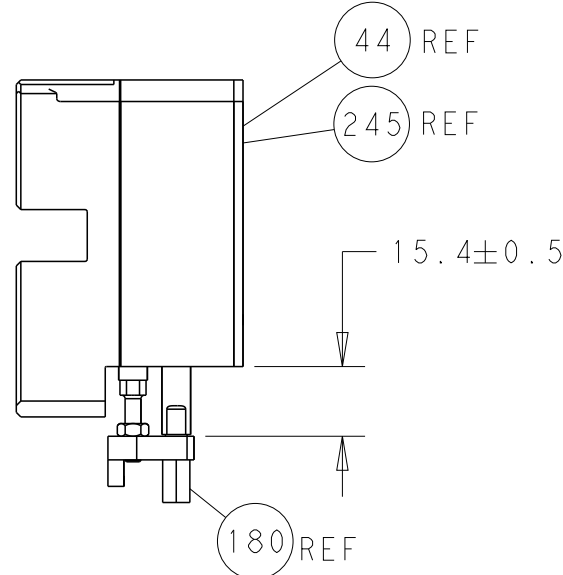
SERVO LATCH PLATE



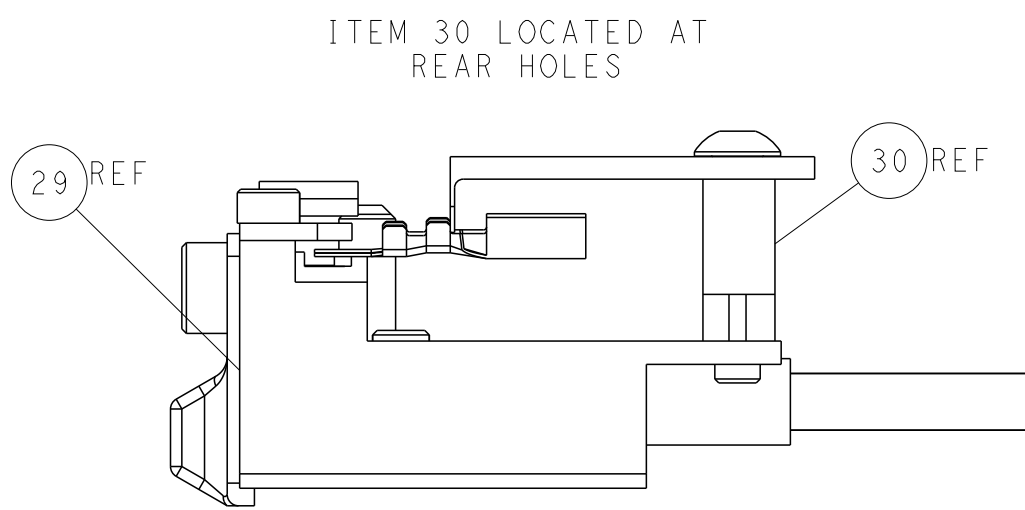
CAM POSITION



TERMINAL SUPPORT LOCATION



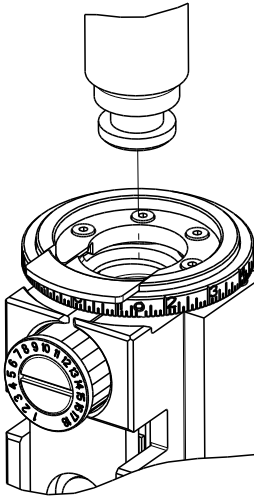
HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

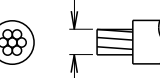
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator	
MATERIAL		WEIGHT		RESTRICTED TO	
-		-		-	
Customer Accessible Production Drawing		SCALE 1:2	SHEET 2 of 4	REV C	

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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2-2151823-2	C	FINE CRIMP HEIGHT ADJUST
	2-2151823-5	C	FINE CRIMP HEIGHT ADJUST
	2-2151823-7	C	FINE CRIMP HEIGHT ADJUST
	7-2151823-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.03 mm [.080]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: MOLEX TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL, WIRE SNAP ON FEMALE			
WIRE STRIP LENGTH 4.19-4.57 mm [.165-.180 IN]		INSULATION DIAMETER RANGE Ø0.00-1.65 mm [.000-.065 IN]	
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
TERMINALS APPLIED ¹⁰			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113200-1	F65B-14474-SB	2113200-2	33112-0004

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
18 AWG		1.47+/-0.05 [.058+/- .002]		10.1
20 AWG		1.31+/-0.05 [.052+/- .002]		11.7



- 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: 8-2151823-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151823-5
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 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO HREADS OF ITEM 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.

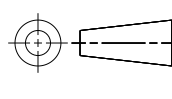
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	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	2119082-9	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	2063440-2	AIR FEED MODULE	238
-	-	1	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	-	1901094-3	SPACER, FEEDER	198
-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 2119599-1	LOC A	DIST 66	REVISIONS				
P	LTR	DESCRIPTION			DATE	OWN	APVD
-	-	SEE SHEET 1			-	-	-

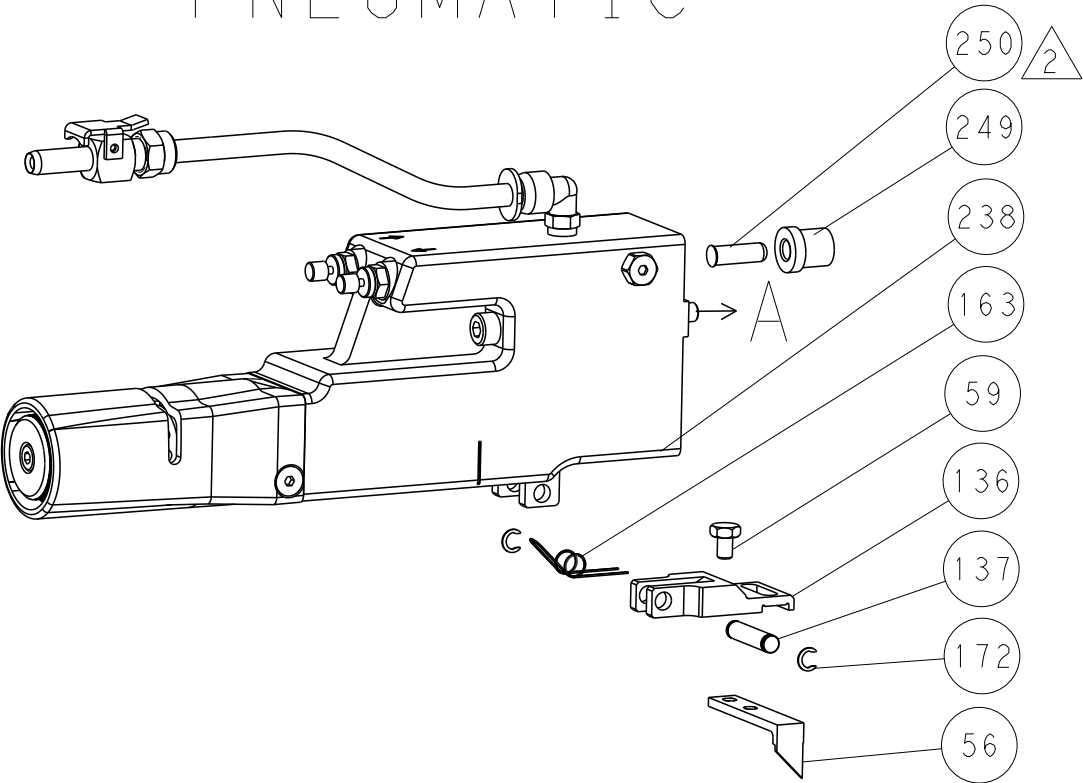
6	-	1	1	1	2-1752354-2	STANDOFF,HOLD-DOWN	180
	-	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	1	8-22280-7	SPRING, COMPRESSION	176
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	-	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
7	-	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
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	-	1	1	1	318563-1	GUARD, FRONT CHIP	89
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	-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
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6	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
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	-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
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	-	1	1	1	455888-5	SPACER, CRIMPER	2
1	1	1	1	1	456404-9	CRIMPER, WIRE PREMIUM	1
	-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator			
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		PRODUCT SPEC		SIZE A1	
MATERIAL -		-		APPLICATION SPEC		CASE CODE 00779	
				WEIGHT -		DRAWING NO C=2151823	
				Customer Accessible Production Drawing		RESTRICTED TO -	
				SCALE 1:2		SHEET 3	
				OF 4		REV C	

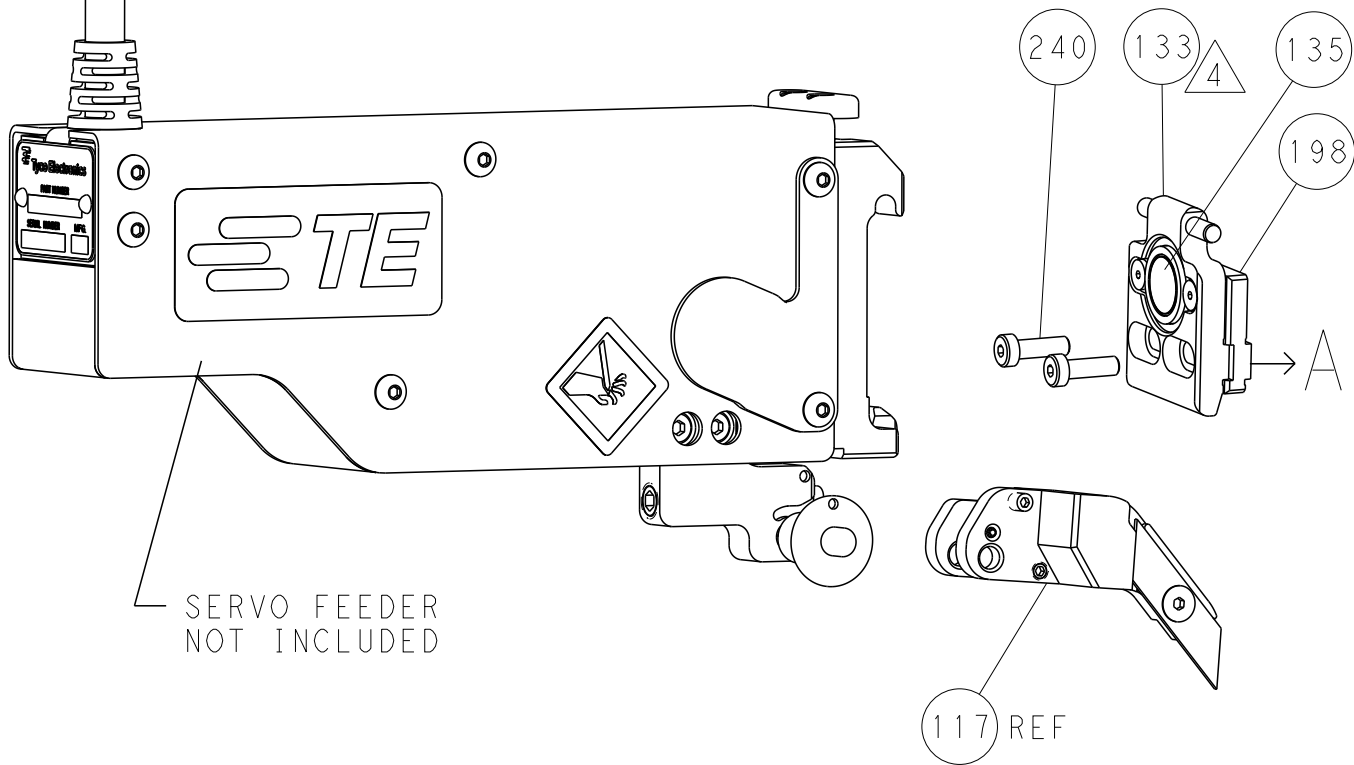
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

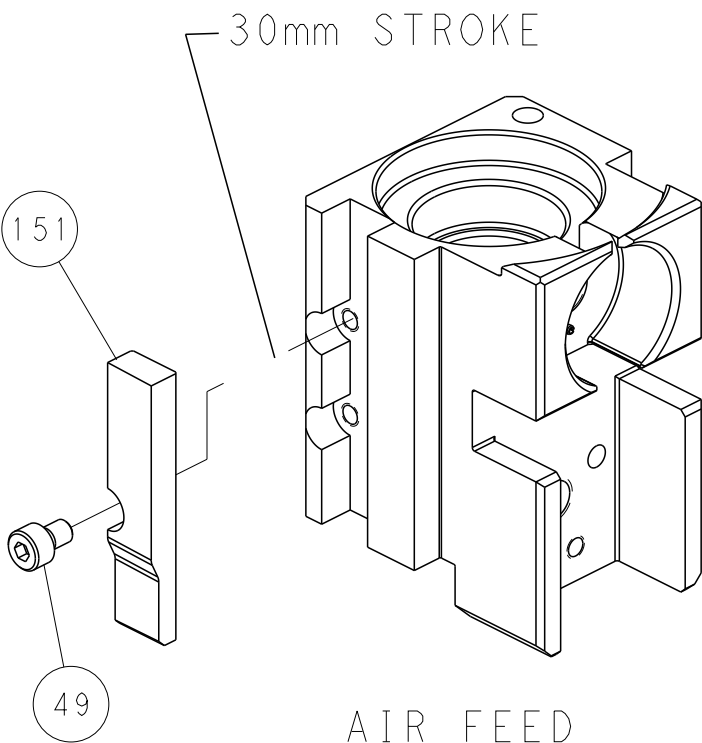
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PNEUMATIC



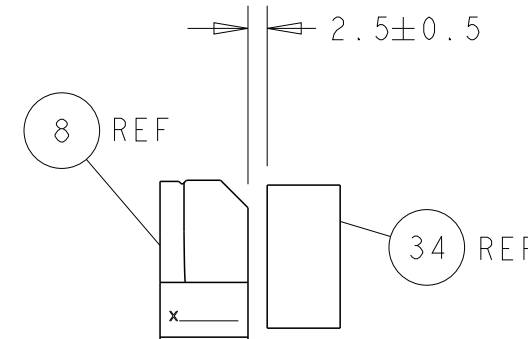
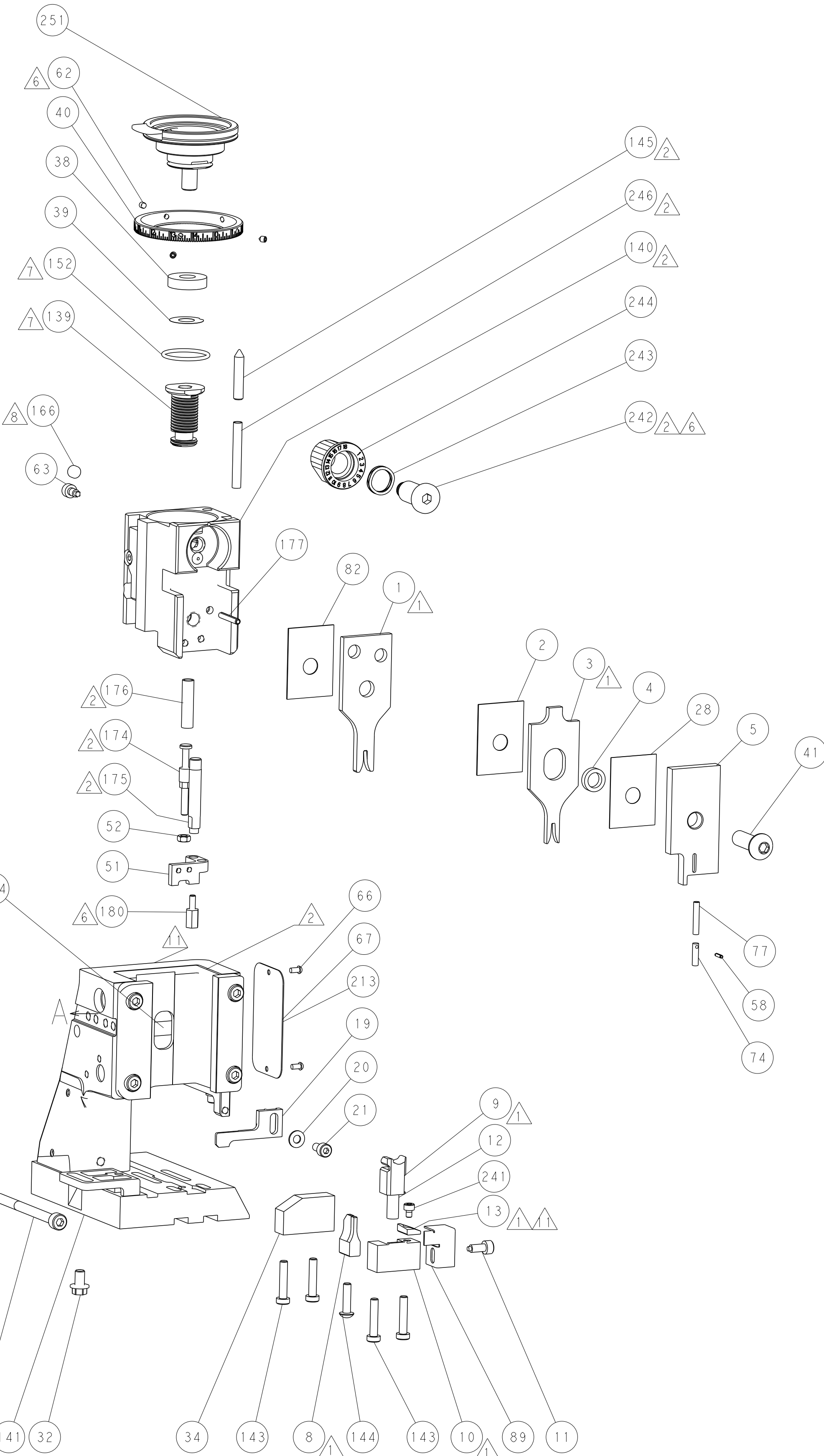
SERVO
LATCH PLATE



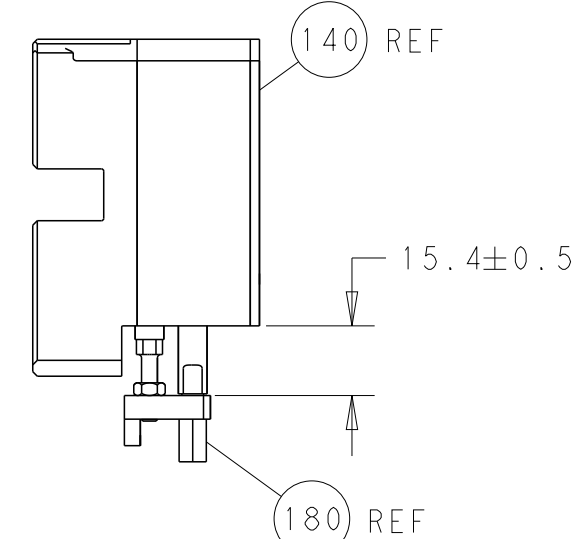
CAM POSITION



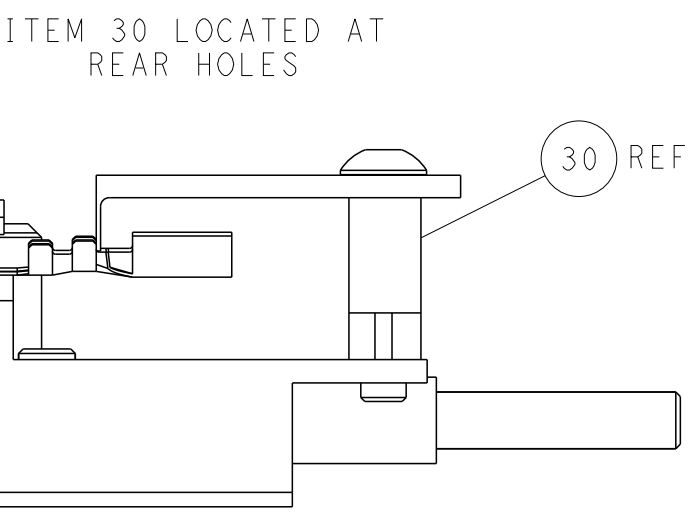
AIR FEED



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY WIRE BARREL

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

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CHK K.J. STAKEM 30DEC2012				APVD T.L. ELBIN 30DEC2012		NAME Ocean Side Feed Applicator	
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE A1	
0 PLC 1 PLC 2 PLC 3 PLC 4 PLC				± ± ± ± ±		CAGE CODE 00779	
MATERIAL -				FINISH -		DRAWING NO C-2151823	
				WEIGHT -		Customer Accessible Production Drawing	
				SCALE 1:2		SHEET 4	
						REV C	

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