

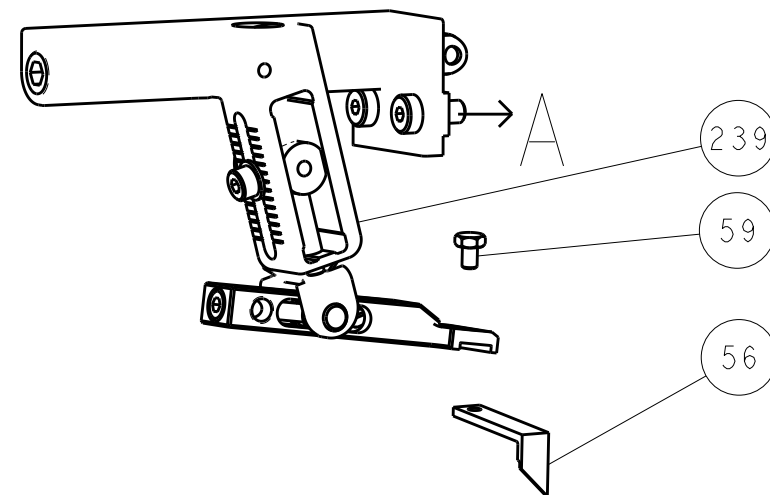
*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING
FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER
THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING.
REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

	-	1	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
	-	1	-	1	-	1803259-1	BUSHING, FLANGED	249
	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
	-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	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
	-	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	1	-	1	-	2063440-1	AIR FEED MODULE	238
	-	2	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	1	-	1	-	240638-1	SPRING, FEED FINGER	163
	-	1	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	1	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
5	-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	1	1	2844908-1	SCREW, LOCKING	99
	-	1	1	1	1	2844907-1	POST, LOCKING	98
	-	1	1	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	1803607-1	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
	-	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1	1338683-8	FEED PAWL	56
	-	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
	-	1	1	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	1	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
	-	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	1	1-1752356-3	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
	-	2	2	2	2	2-2844962-6	SPACER, CYLINDRICAL, STRIP GUIDE	30
	-	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-3	CRIMPER, CRIMPER	28
	-	1	1	1	1	1320928-6	STRIP GUIDE	24
	-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	2	2	2	2	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
3	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
	1	2	2	1	1	1-1333204-8	ANVIL, COMBINATION	8
	-	1	1	1	1	2-240641-5	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	2	2	1	1	1633965-3	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	455888-7	SPACER, CRIMPER	2
1	1	2	2	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1
	-77	-72	-71	-2	-1	PART NO	DESCRIPTION	ITEM NO

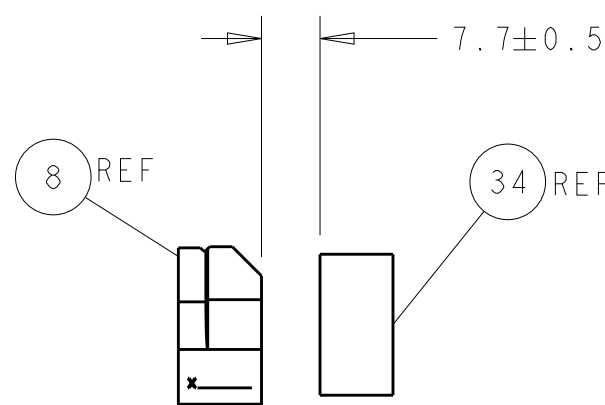
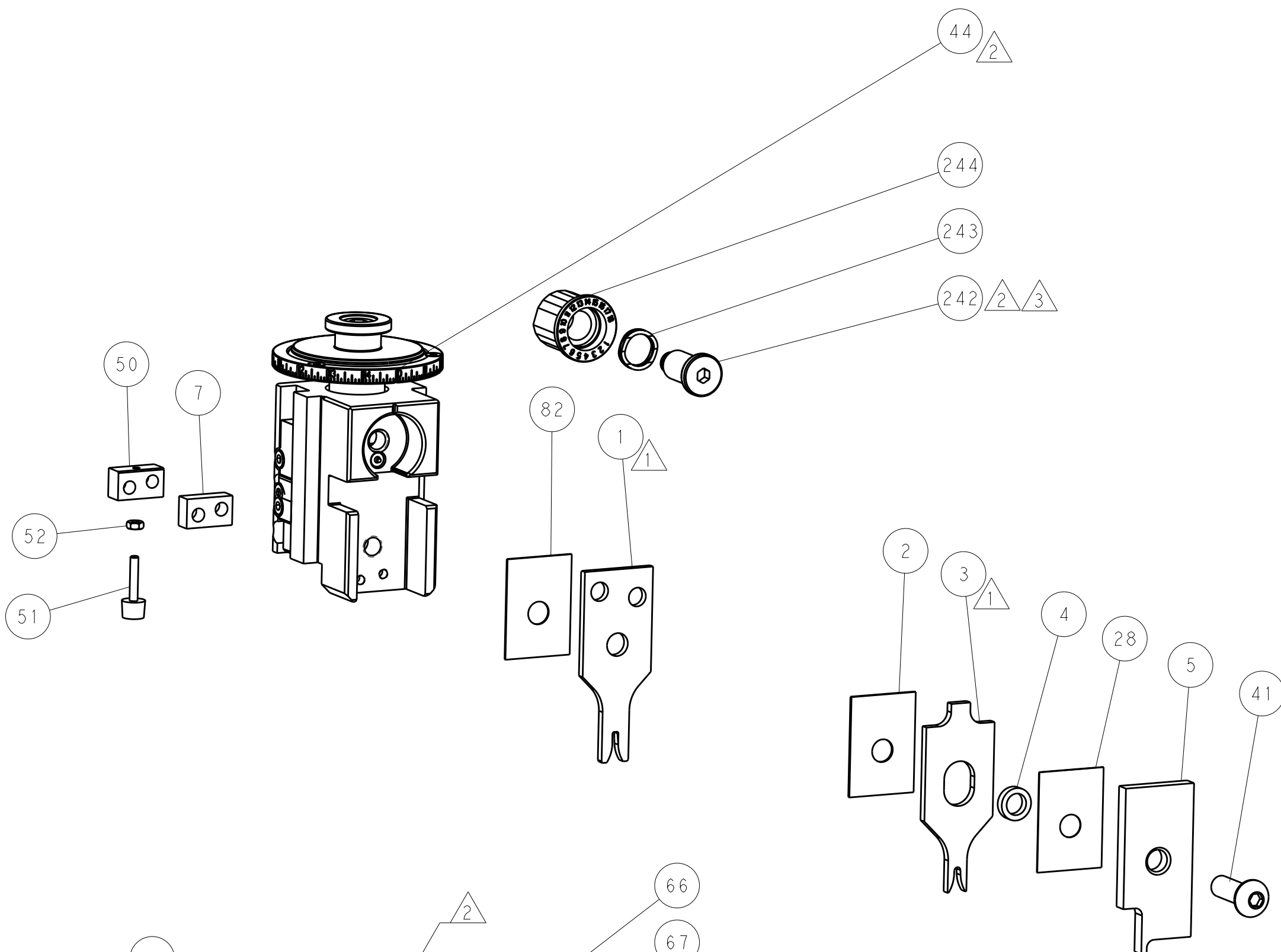
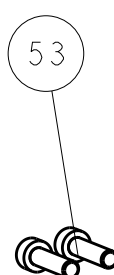
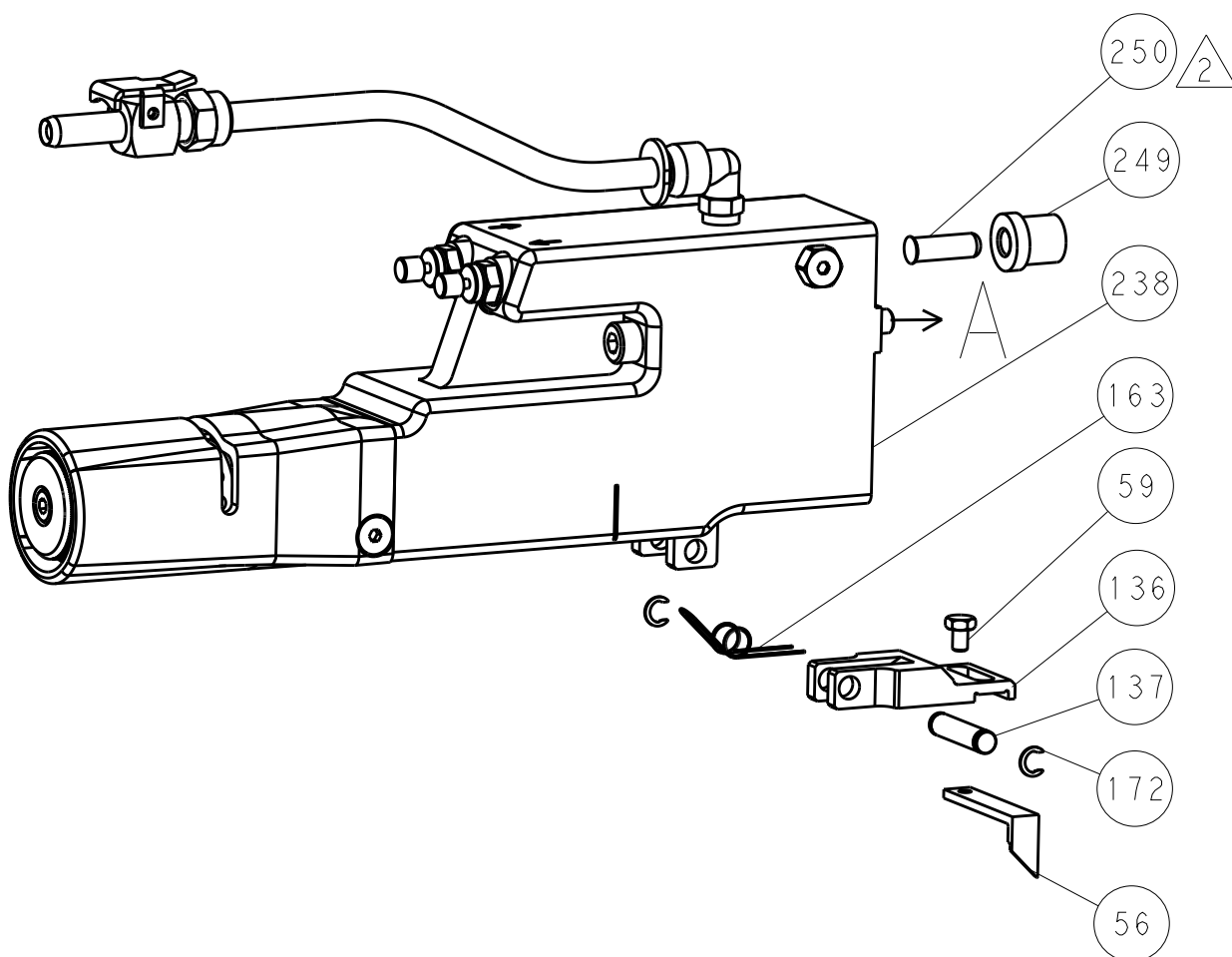
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LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
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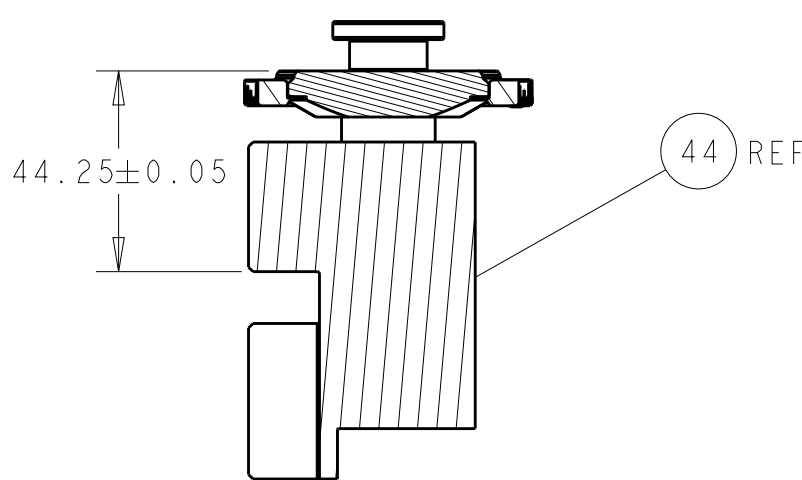
FEED TYPE
MECHANICAL



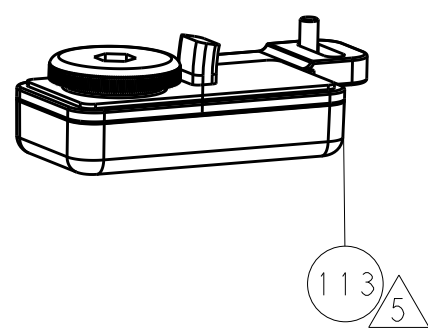
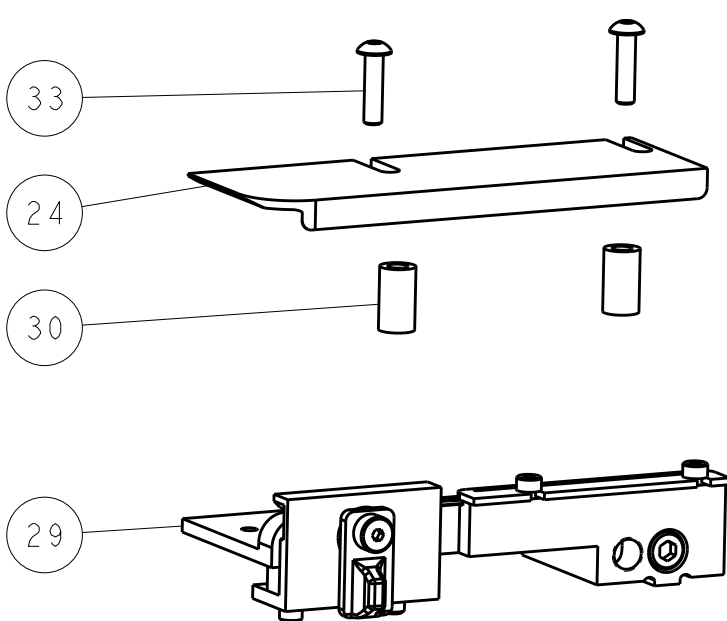
PNEUMATIC



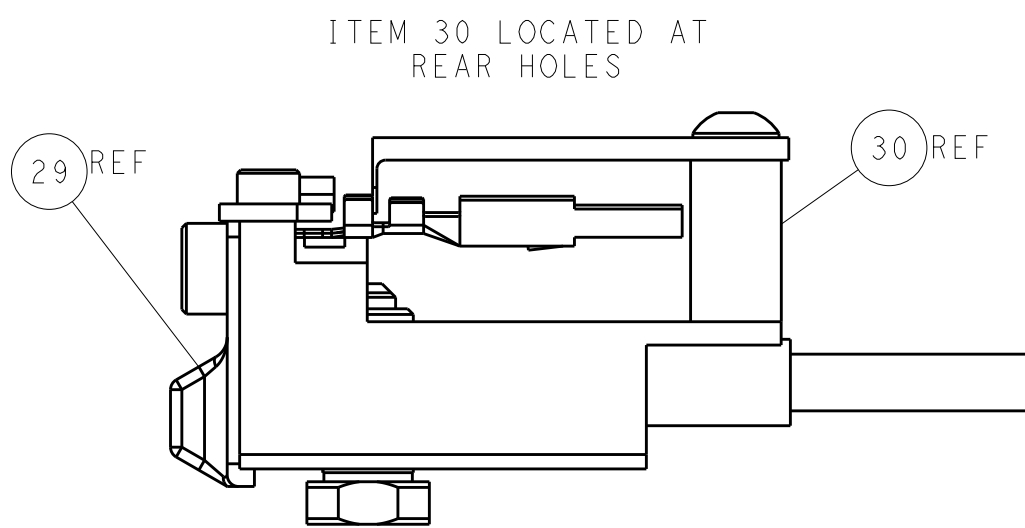
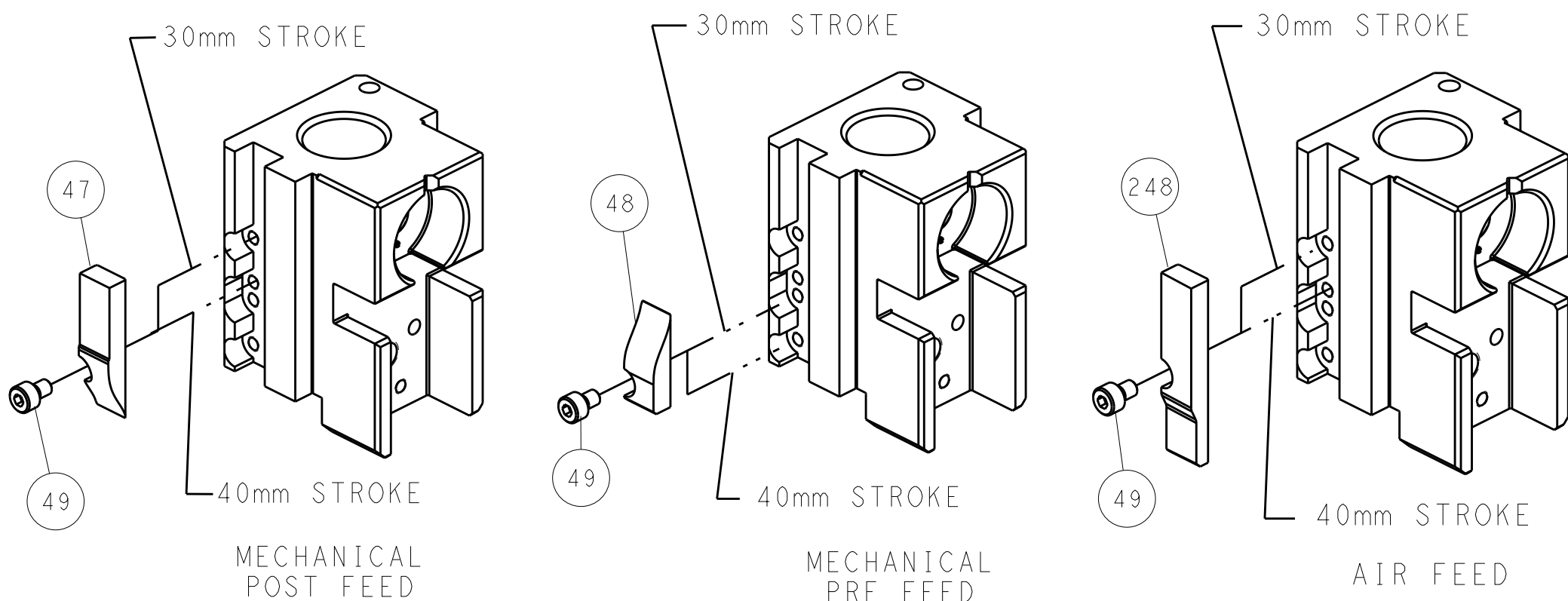
TERMINAL SUPPORT LOCATION



RAM SET-UP



CAM POSITIONS



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)

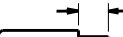
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		CHK	L. ZHANG	3APR2014		
		APVD	J. GUO	3APR2014	NAME	
		PRODUCT SPEC			Ocean Side Feed Applicator	
		APPLICATION SPEC			SIZE	
					CAGE CODE	
					DRAWING NO	
					RESTRICTED TO	
					A1 00779	
					C=2266254	
					Customer Accessible Production Drawing	
					SCALE	
					1:2	
					SHEET	
					2 of 4	
					REV	
					B	

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2266254-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2266254-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2266254-7	A	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.54 mm [.100]	O
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DIA 2.5MM CONTACT-PIN			
WIRE STRIP LENGTH 3.90-4.60 mm [.154-.181 IN]			INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]
TERMINAL APPLICATION SPECIFICATION		(B)114-18040	-
		(A)114-18020	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 929986-1	(A) 929970-1	(A) 929970-8	(A) 929963-8
(B) 929986-4	(A) 929970-7	(A) 929963-1	(A) 1-929963-0

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.45+/-0.05 [.057+/-0.002]	7.6
0.75mm2	1.36+/-0.05 [.054+/-0.002]	8.8
0.50mm2	1.27+/-0.05 [.050+/-0.002]	9.7



- 1 RECOMMENDED SPARE PARTS
- 2 REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- 3 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 4 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.
- 5 TERMINAL LUBRICANT IS RECOMMENDED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

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

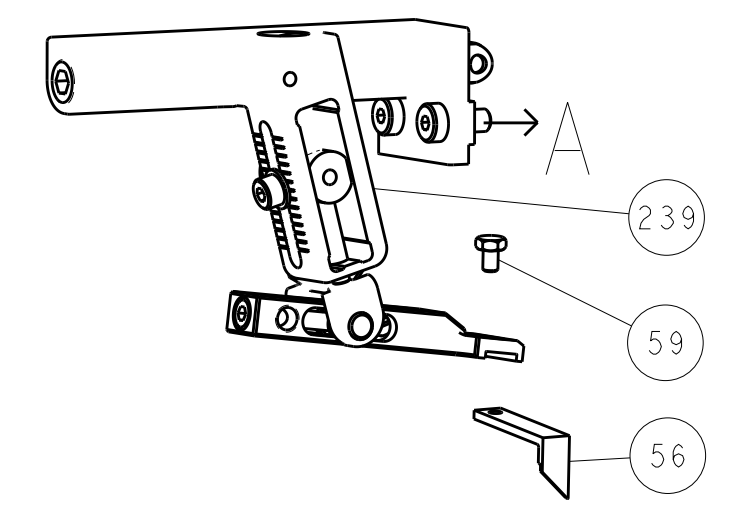
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

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-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
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-	1	1	2844907-1	POST, LOCKING	98
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-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-1	FLOATING SHEAR, FRONT -	9
1	1	1	1-1333204-8	ANVIL, COMBINATION	8
-	1	1	2-240641-5	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	455888-7	SPACER, CRIMPER	2
1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1
-77	-22	-21	PART NO	DESCRIPTION	ITEM NO

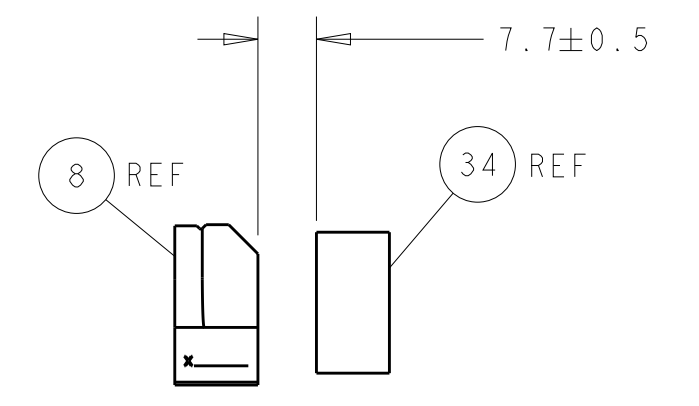
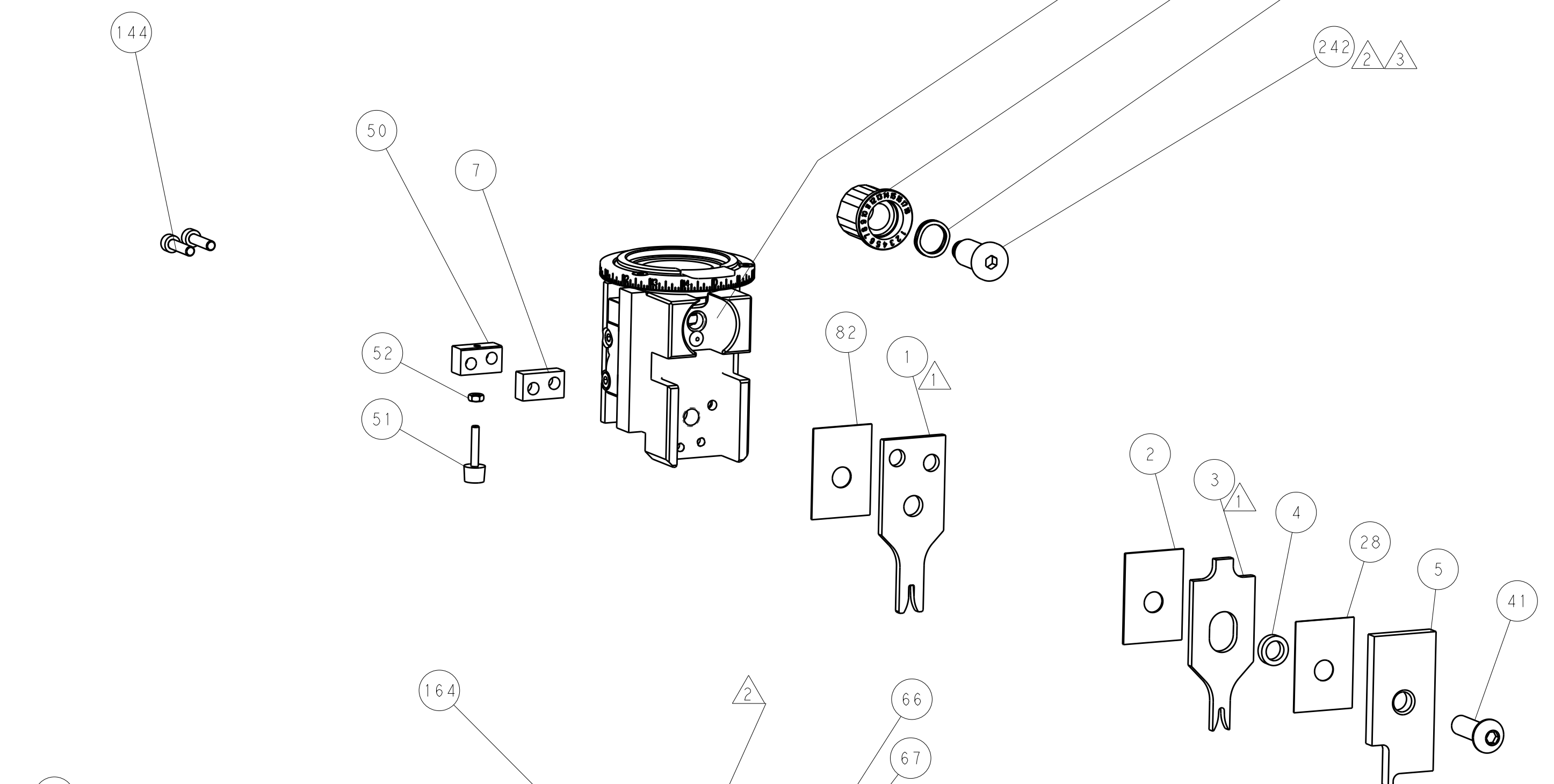
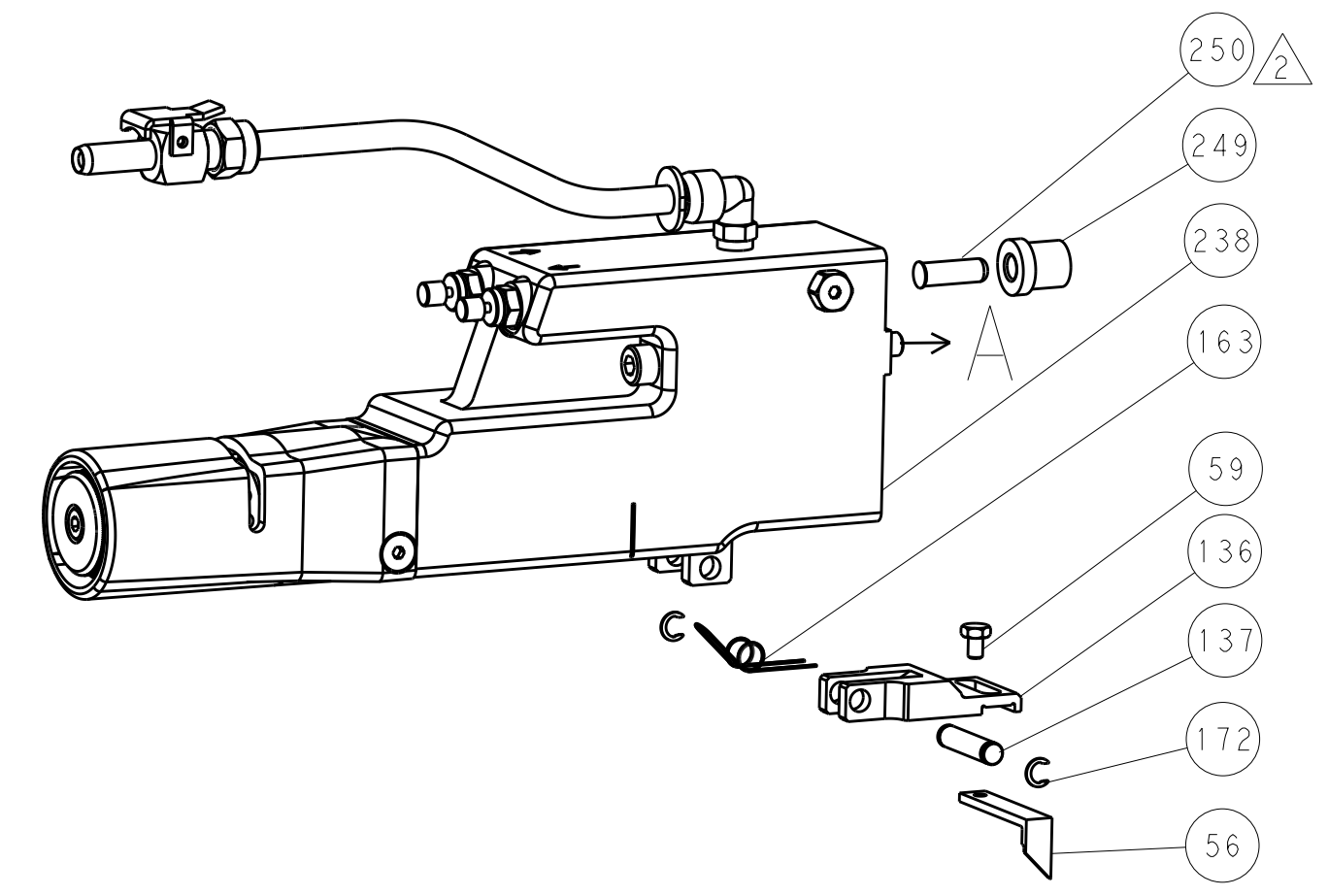
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				CHK L. ZHANG 3APR2014															
				APVD U. GUO 3APR2014															
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator -													
mm				PRODUCT SPEC															
		0 PLC ±		APPLICATION SPEC															
		1 PLC ±																	
		2 PLC ±																	
		3 PLC ±																	
		4 PLC ±																	
ANGLES		FINISH		SIZE				CAGE CODE		DRAWING NO		RESTRICTED TO							
MATERIAL		FINISH		WEIGHT				A1		00779		C=2266254		-					
Customer Accessible Production Drawing				SCALE				1:2		SHEET		3		OF		REV		B	

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

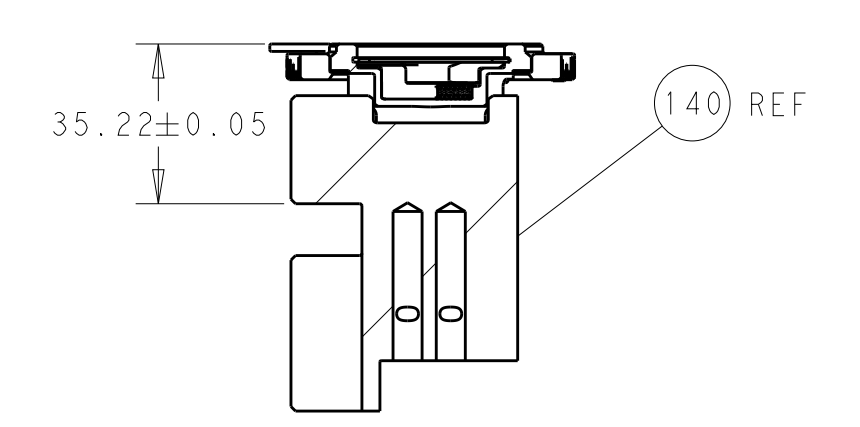
FEED TYPE
MECHANICAL



PNEUMATIC

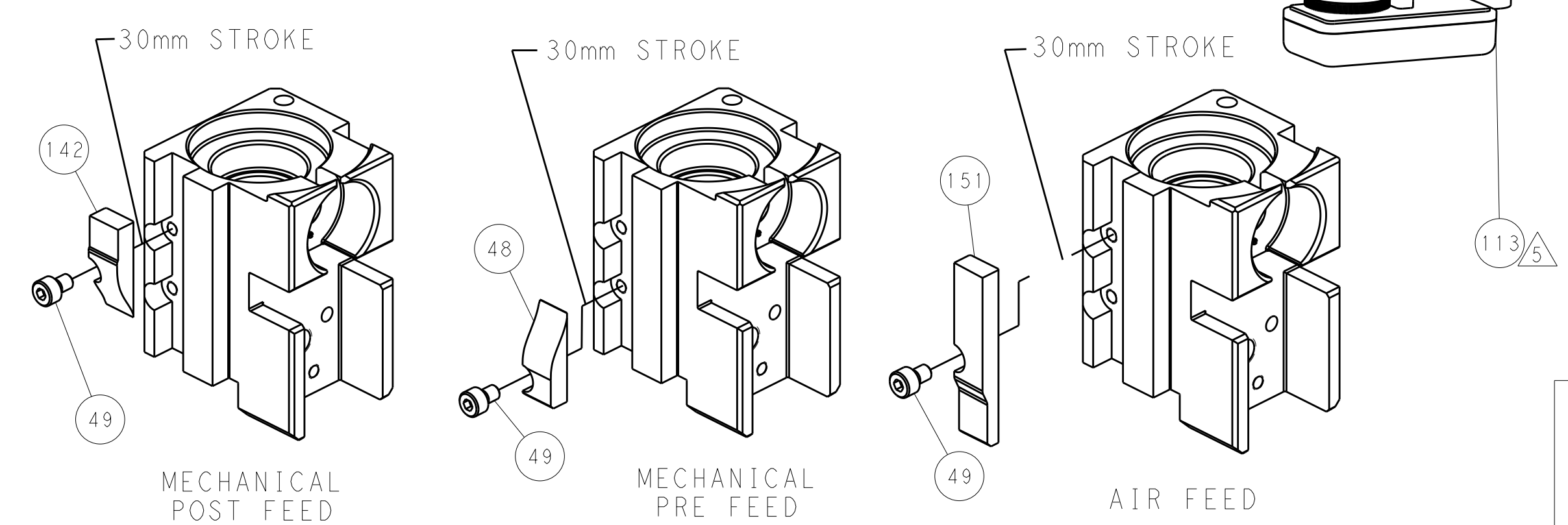


TERMINAL SUPPORT LOCATION



RAM SET-UP

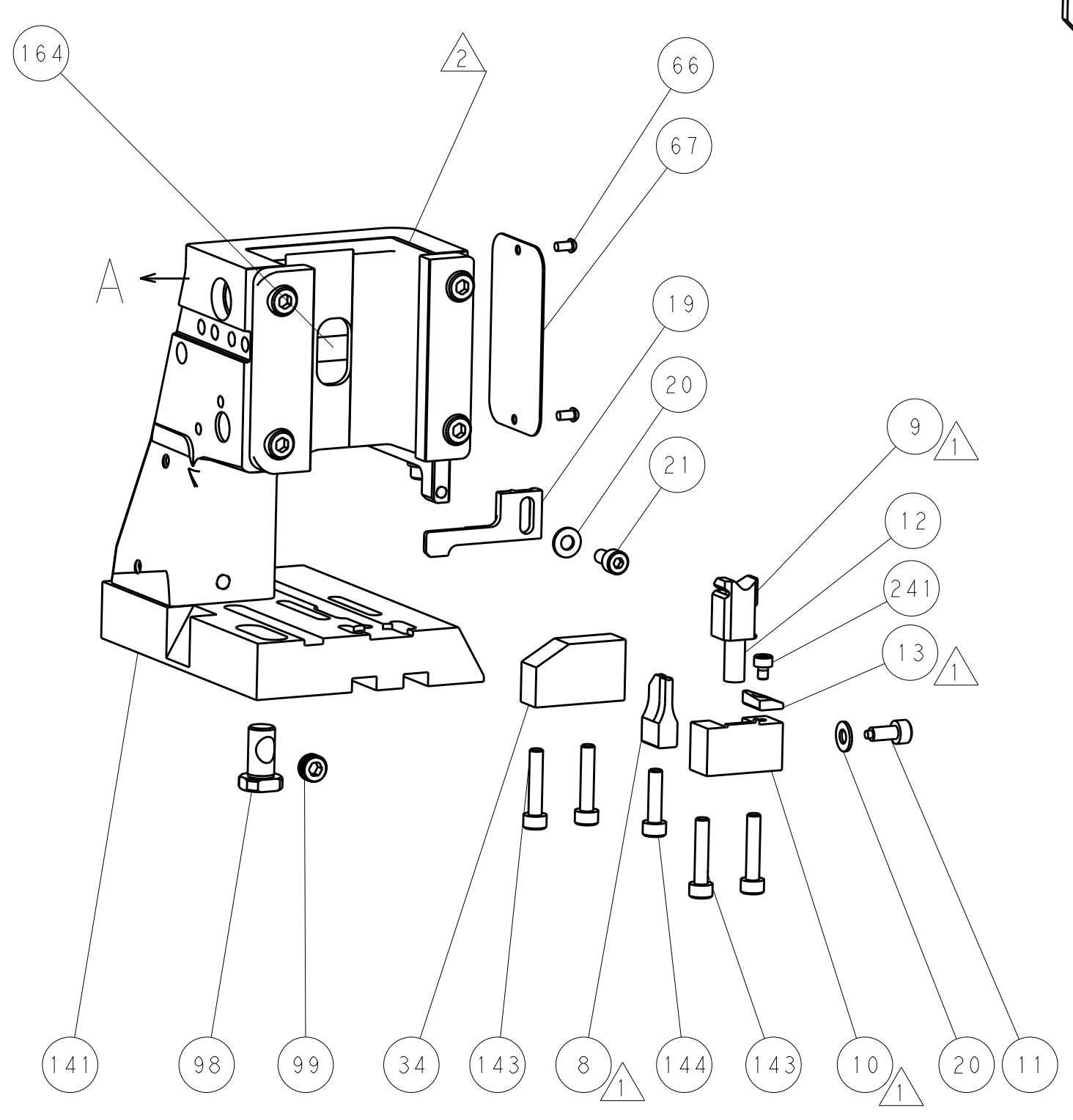
CAM POSITIONS



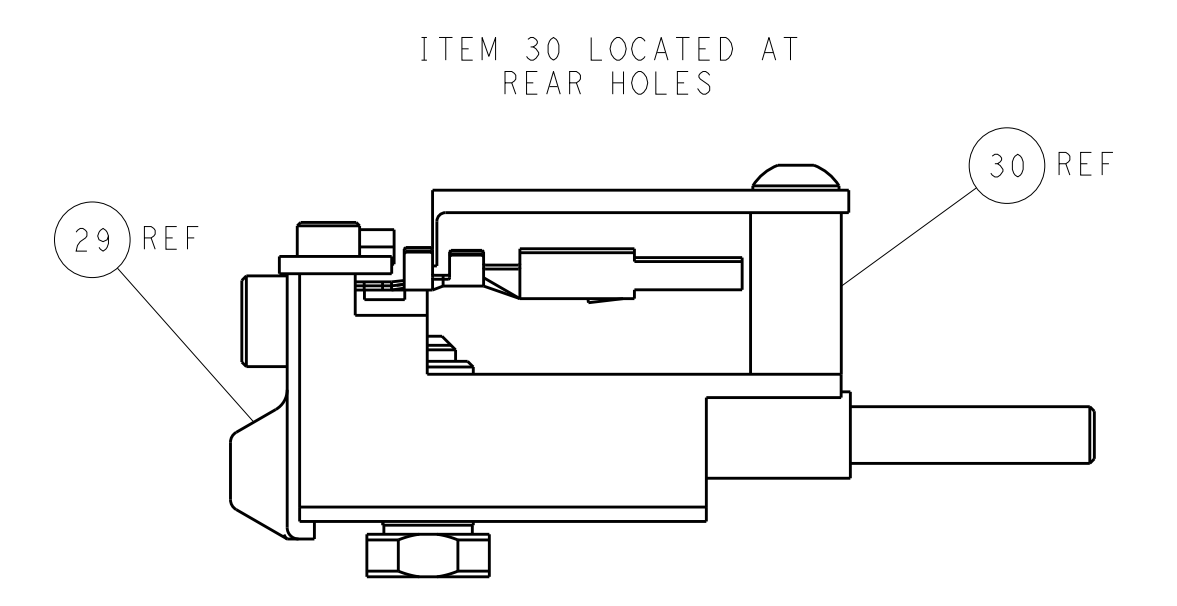
MECHANICAL
POST FEED

MECHANICAL
PRE FEED

AIR FEED



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



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J. HOU 3APR2014		CHK L. ZHANG 3APR2014		APVD H. GUO 3APR2014		NAME Ocean Side Feed Applicator	
0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		ANGLES ±	
FINISH		MATERIAL		WEIGHT		SIZE A1		CAGE CODE 00779		DRAWING NO C=2266254	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 4		OF 4		REV B		RESTRICTED TO	

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