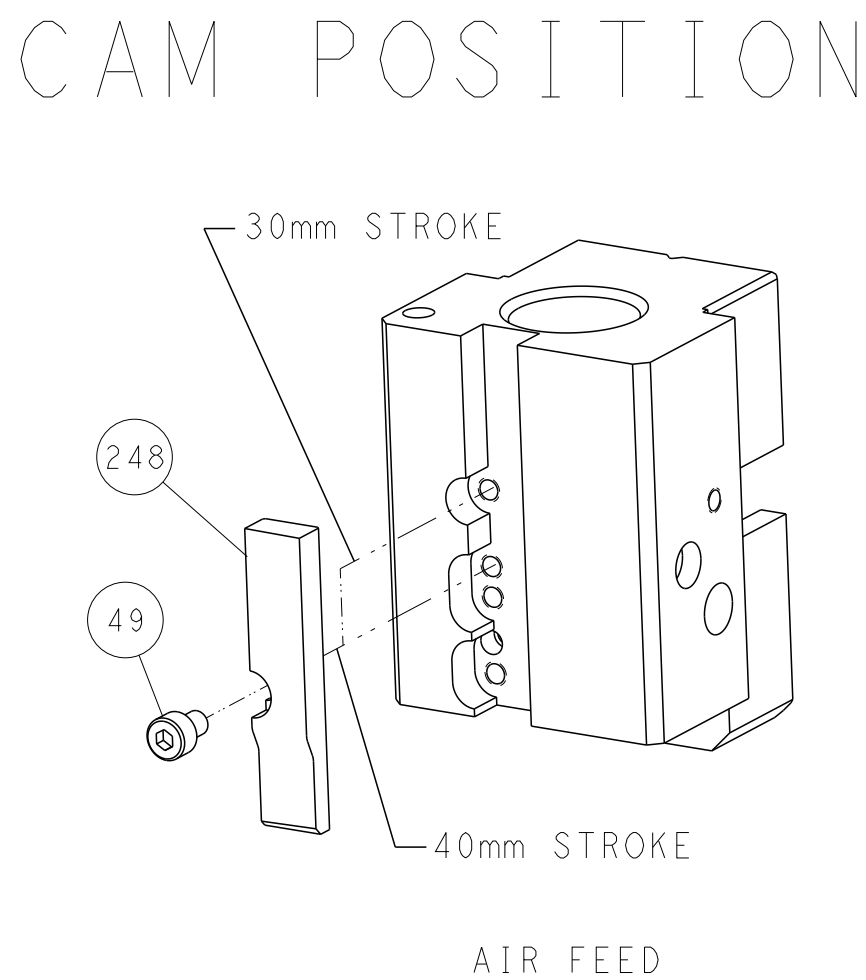
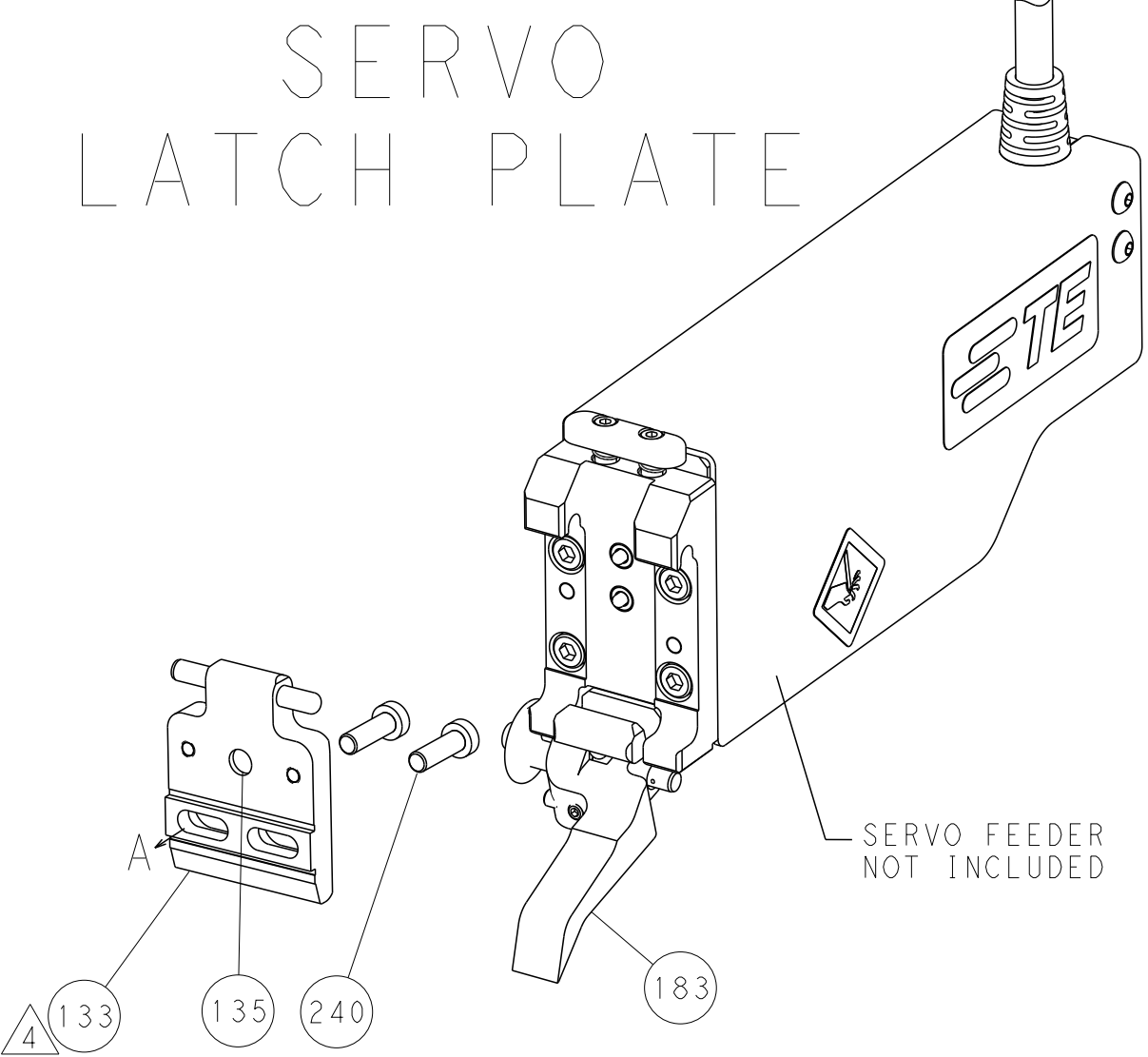
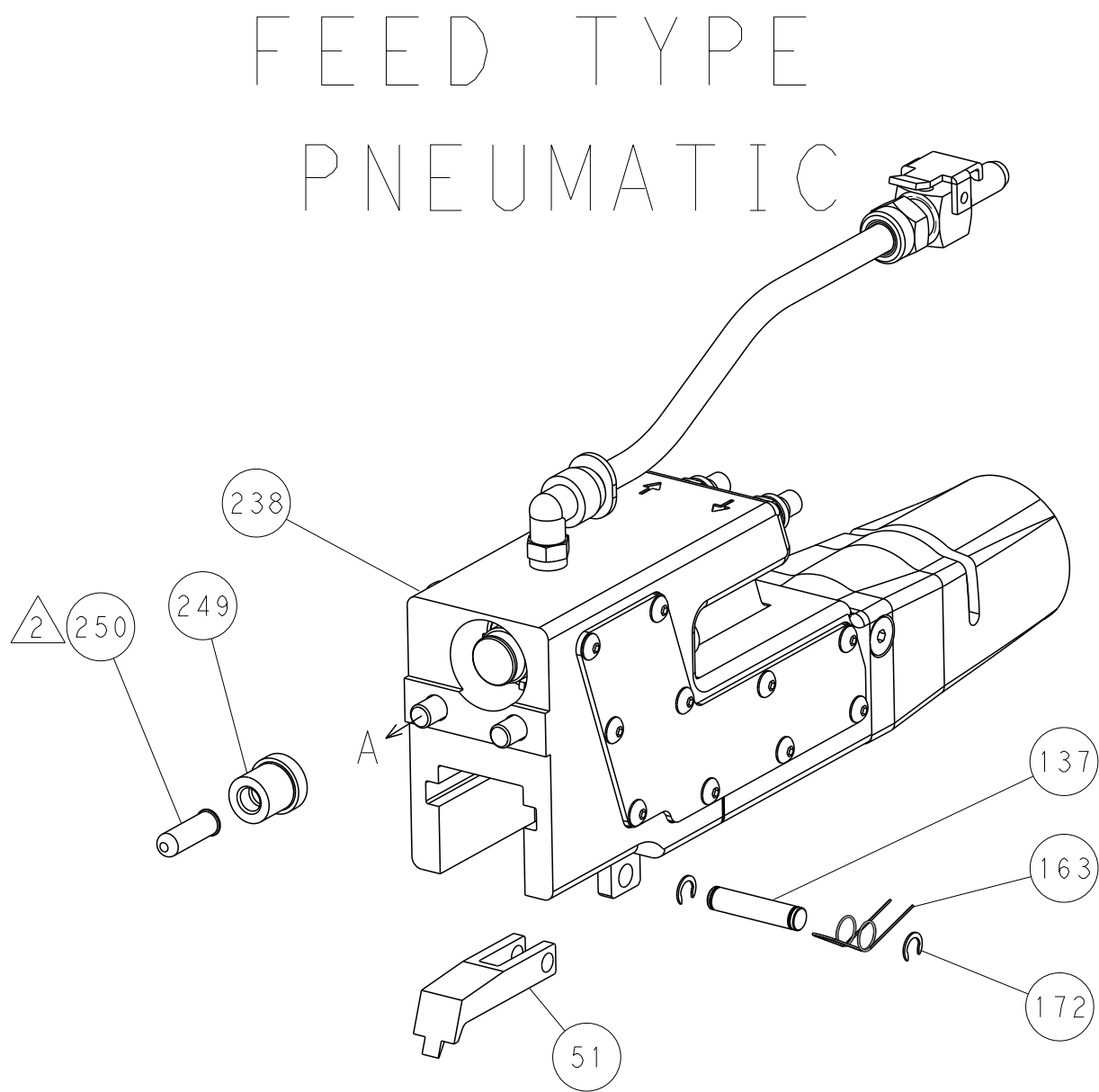
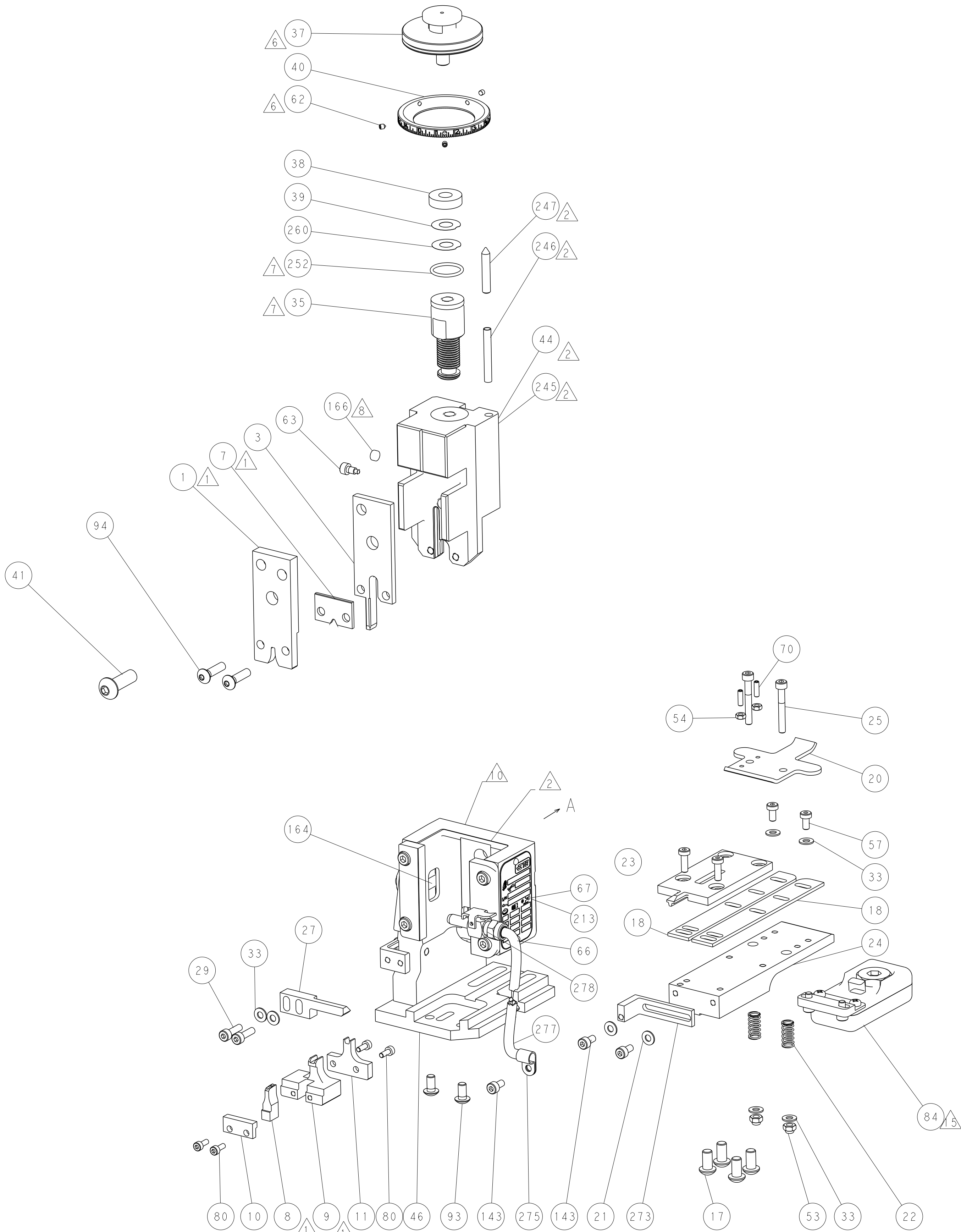


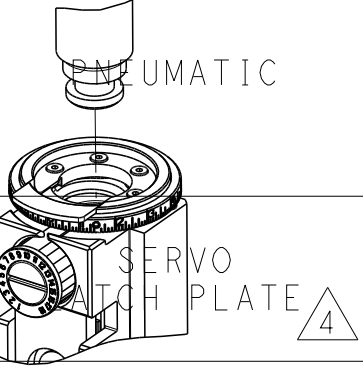
LOC	DIST	REVISIONS						
		P	LTR	DESCRIPTION	DATE	DWN	APVD	
A	66	-		SEE SHEET 1		-	-	-



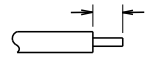
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

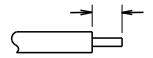
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DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.0005 1 PLC ±.0005 2 PLC ±.0005 3 PLC ±.0005 4 PLC ±.0005 ANGLES ±.0005 FINISH -				NAME Ocean End Feed Applicator			
MATERIAL -				PRODUCT SPEC APPLICATION SPEC WEIGHT -				SIZE CAGE CODE DRAWING NO 00779 C=2150117			
Customer Accessible Production Drawing				SCALE 1:1				SHEET 2 OF 4			
								REV B			

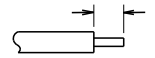
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART					
					CONVERT TO	PART NUMBERS REQUIRED				
	2-2150117-2	B	FINE CRIMP HEIGHT ADJUST		-	-	-	-	-	-
					SERVO LATCH PLATE	2119951-1	1901697-2	8-2150117-5	-	2168400-7 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2150117-4	-	-
	2-2150117-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	-	-	-	-	-	-
	2-2150117-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-
	7-2150117-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.79 mm [.110]	F
APPL INSTRUCTIONS 408-10390		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH 		INSULATION DIAMETER RANGE	
6.86-7.88 mm [.270-.310 IN]		Ø -	
TERMINAL APPLICATION SPECIFICATION 	114-2003	-	-
-	-	-	-
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62304-1	62304-2	9-62304-1	

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH 		INSULATION DIAMETER RANGE	
6.86-7.88 mm [.270-.310 IN]		Ø2.20-3.00 mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION 	114-2003	-	-
-	-	-	-
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62305-1	62305-2	62305-3	62305-4

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: SPLICE (AMPLIVAR)			
WIRE STRIP LENGTH 		INSULATION DIAMETER RANGE	
6.86-7.88 mm [.270-.310 IN]		Ø2.20-3.00 mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION 	114-2003	-	-
-	-	-	-
TERMINALS APPLIED  			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
62306-1	62306-2	62306-3	9-62306-1

WIRE SIZE		CRIMP HEIGHT mm [INCH]  	CRIMP HEIGHT REFERENCE SETTING 	WIRE SIZE		CRIMP HEIGHT mm [INCH]  	CRIMP HEIGHT REFERENCE SETTING 	WIRE SIZE		CRIMP HEIGHT mm [INCH]  	CRIMP HEIGHT REFERENCE SETTING 
3000 CMA 19+18Ø MAG(2951)		1.64+/-0.05 [.065+/- .002]	7.6	3000 CMA 19+18Ø MAG(2951)		1.45+/-0.05 [.057+/- .002]	9.6	5000 CMA 16+17 MAG(4936)		2.06+/-0.05 [.081+/- .002]	9.6
600 CMA 22Ø MAG(635)		1.33+/-0.05 [.052+/- .002]	10.8	600 CMA 22Ø MAG(635)		1.12+/-0.05 [.044+/- .002]	12.8	1500 CMA 21Ø+22 MAG(1503)		1.60+/-0.05 [.063+/- .002]	12.8



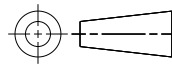
-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150117-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2150117-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2150117-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
-  APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.
-  GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 153.
-  MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
-  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.
-  SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
-  THE RECOMMENDED SET-UP FOR END FEED APPLICATORS IS POST-FEED WITH ITEM 2119653-1. THE APPLICATOR CAN BE CONFIGURED FOR PRE-FEED WITH ITEM 2119652-1 BUT MAY ENCOUNTER PROBLEMS WITH SOME APPLICATIONS. FEED ISSUES OR TERMINAL JAMMING MAY OCCUR IN THE PRE-FEED CONFIGURATION.
-  REFER TO TERMINAL CUSTOMER DRAWING FOR CRIMP HEIGHT FORMULA TO CALCULATE SPECIFIC CRIMP HEIGHTS.
-  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
-  TERMINAL LUBRICANT 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.

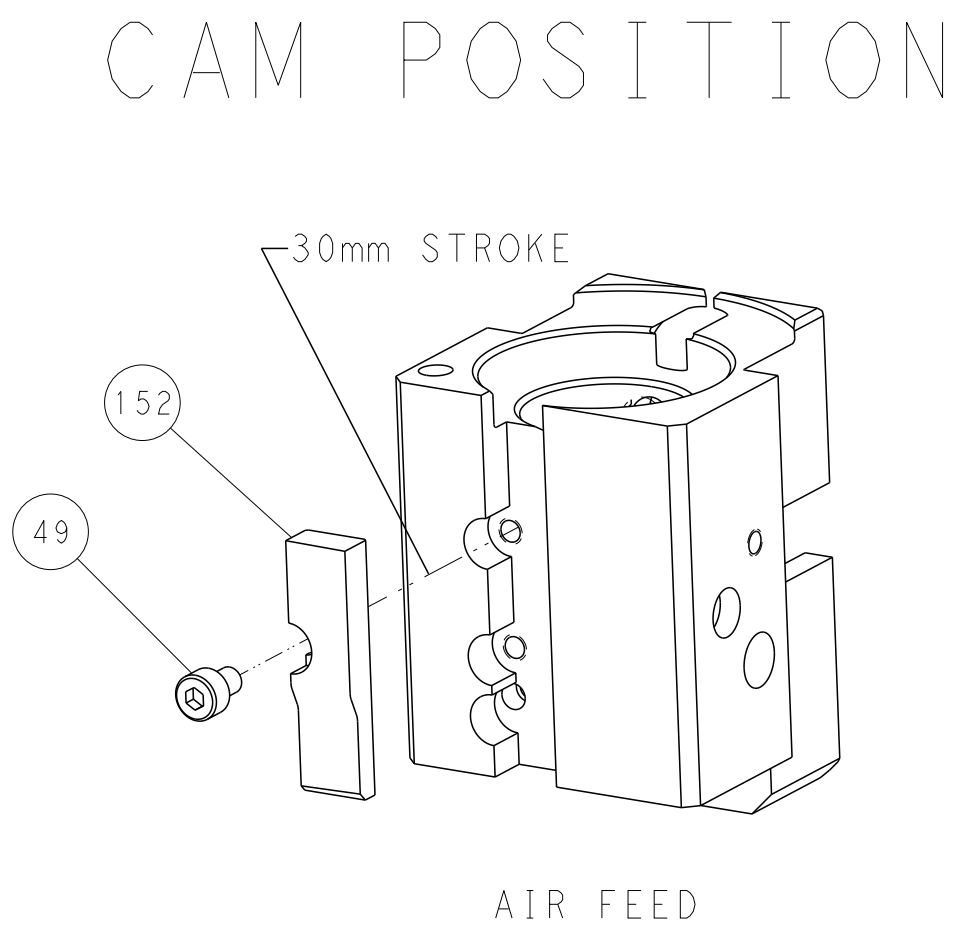
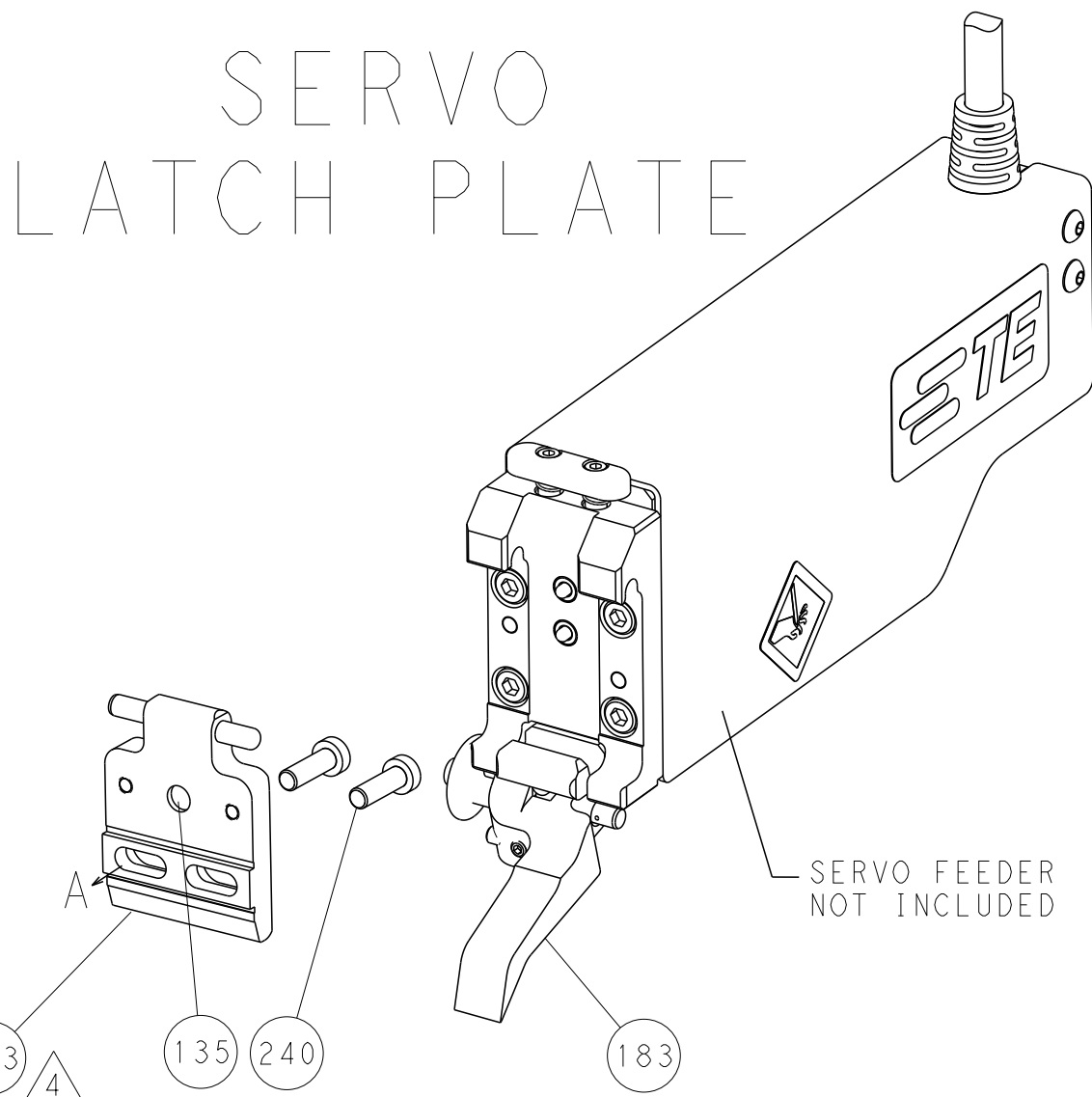
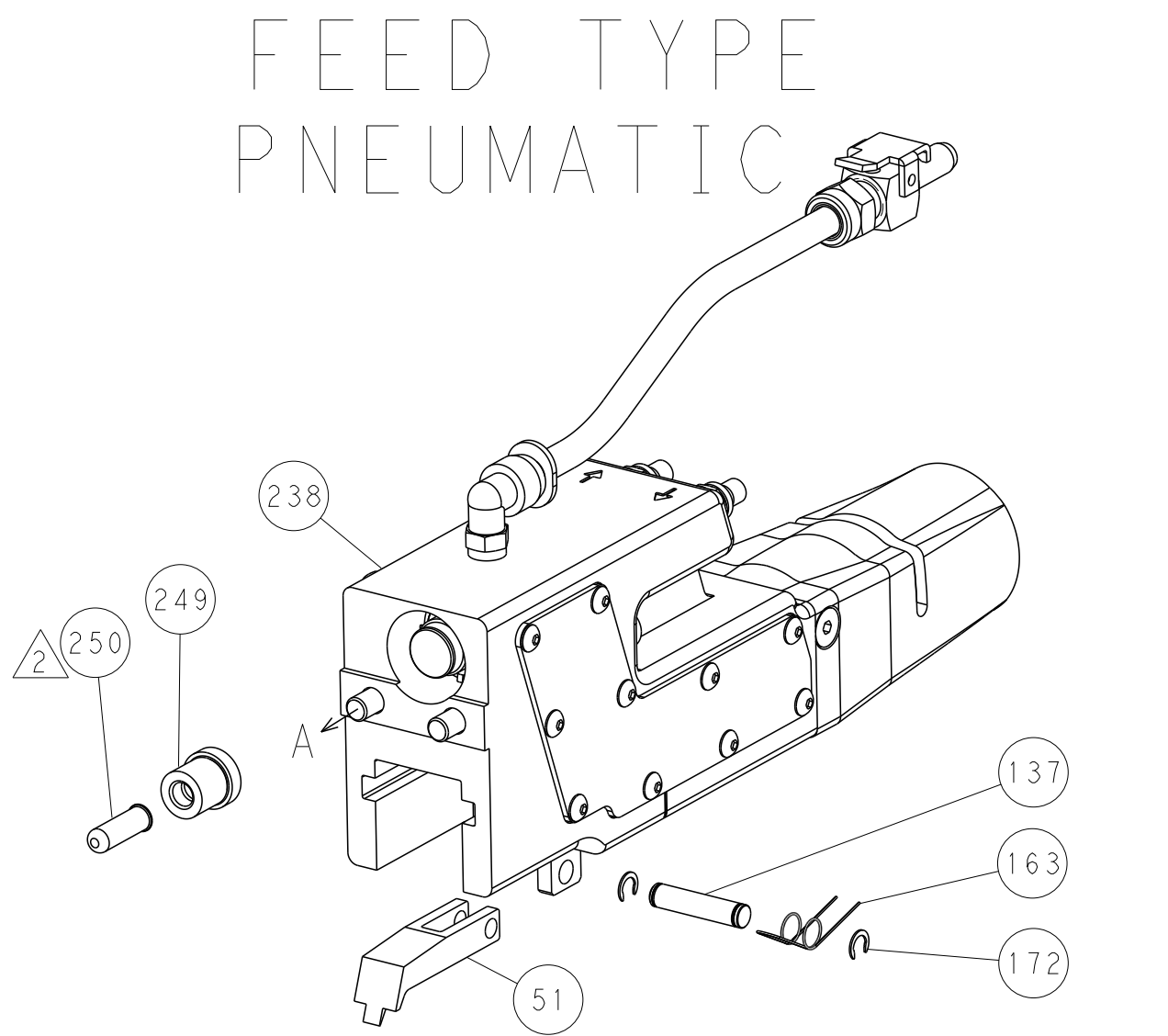
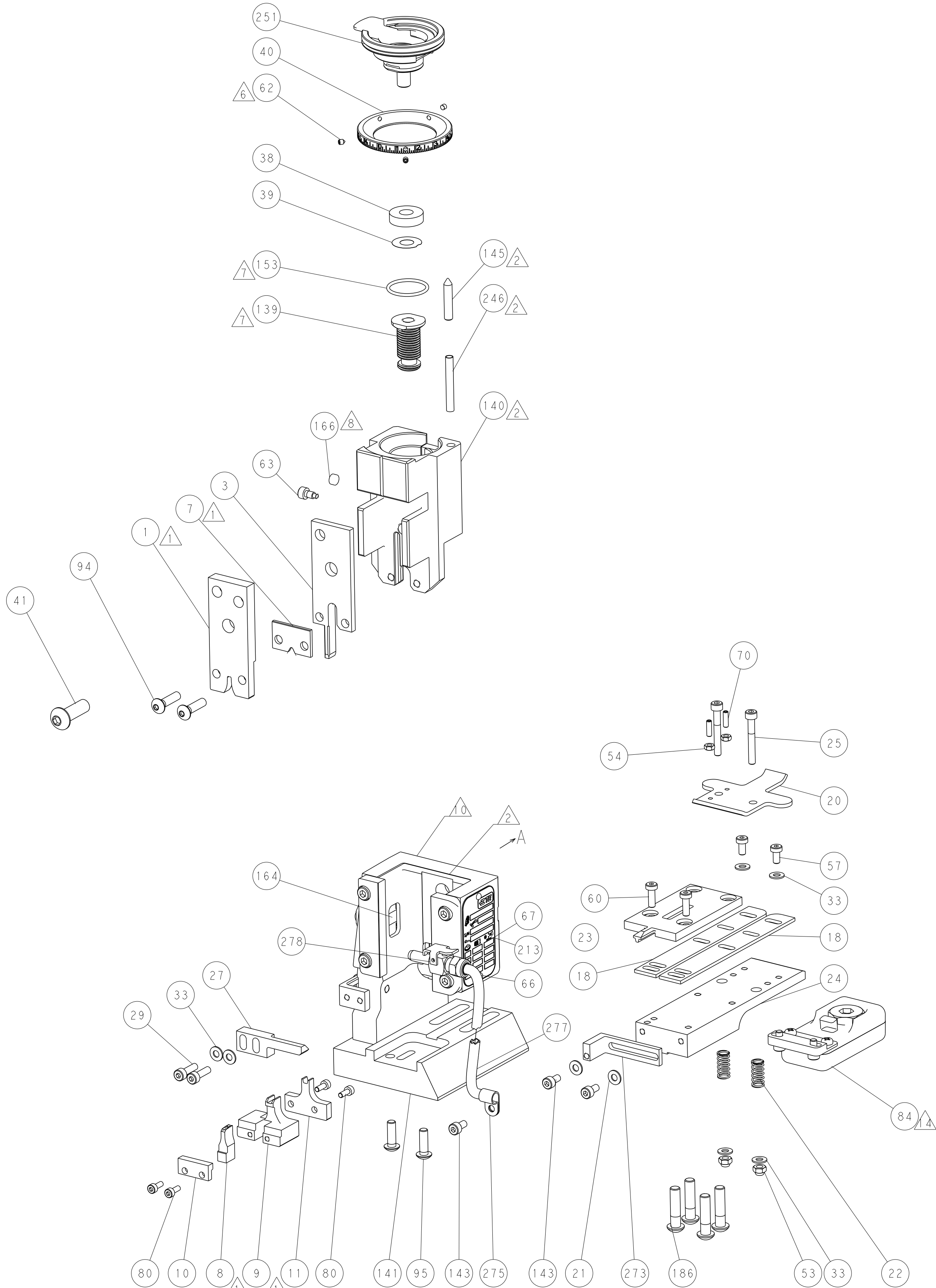
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE 2119599-2		LOC A	DIST 66	REVISIONS			
P	LTR	DESCRIPTION		DATE	DWN	APVD	
	-	SEE SHEET 1		-	-	-	

	-	1	1	1	23238-1	INSERT, COUPLING	278
	-	24	24	24	2030758-3	TUBING, POLYURETHANE	277
	-	1	1	1	986220-3	CLAMP, CABLE, BLACK	275
	-	1	1	1	2844280-1	MOUNT, AIR BLAST	273
	-	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
	-	-	2	-	2168400-7	SHCS, LOW HEAD, RoHS, M5 X 10	240
	-	-	-	1	2063440-1	AIR FEED MODULE	238
	-	-	1	-	2119740-2	TAG, IDENTIFICATION	213
	-	4	4	4	2-18024-1	SCR, BTN SKT HD CAP (M6 X 25.0)	186
	-	-	1	-	1901697-2	FEED FINGER ASSEMBLY,EF	183
	-	-	-	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.	153
	-	-	-	1	2119641-2	FEED CAM, AIR FEED	152
	-	1	1	1	2119798-2	DETENT PIN	145
	-	3	3	3	1-18023-0	SCR, SKT HD CAP M4 X 8.0	143
	-	1	1	1	2-2119655-2	APPLICATOR BASIC ASSEMBLY, EF	141
	-	1	1	1	2844275-1	RAM, ASIAN STYLE, END FEED	140
7	-	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
	-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	-	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
	-	-	1	-	1633743-1	SERVO FEED LATCH ASM	133
	-	2	2	2	1-18024-3	SCR, BTN SKT HD CAP (M5 X 16.0)	95
4	-	2	2	2	1-18024-4	SCR, BTN SKT HD CAP (M5 X 20.0)	94
	-	1	1	1	2119955-2	ASSY, LUBRICATOR, END FEED	84
	-	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	80
	-	1	1	1	2119956-2	DOCUMENTATION PACKAGE	71
	-	2	2	2	2-18032-2	SCR, SET, FLT POINT M3 X 10.0	70
	-	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
	-	2	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	60
	-	2	2	2	2168400-4	SHCS, LOW HEAD, RoHS, M4 X 8	57
	-	2	2	2	5018030-1	NUT, HEX, REG, RoHS, M3	54
	-	2	2	2	986965-8	NUT, LOCK, HEX, TORQUE (M4)	53
	-	-	-	1	2119792-9	PAWL, EF, AIR	51
	-	-	-	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	1-2119644-2	RAM WASHER, PRECISION	38
	-	8	8	8	1-18028-2	WASHER, FLAT, REG M4	33
	-	2	2	2	2-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 14	29
	-	1	1	1	460276-2	STRIPPER, SPECIAL	27
	-	2	2	2	1-2168083-5	SCR, SKT HD CAP, RoHS, M4 X 30	25
1	-	1	1	1	3-1752371-0	PLATE, STRIP GUIDE	24
	-	1	1	1	1-462932-0	PLATE, STRIP COVER	23
	-	2	2	2	2-22281-3	SPRING, COMPRESSION	22
	-	2	2	2	18027-2	WASHER, FLAT, REG M4	21
	-	1	1	1	1803292-1	DRAG	20
	-	2	2	2	1901259-4	GUIDE, LOWER STRIP	18
	-	1	1	1	459684-3	PLATE GUIDE, RETAINING	11
	-	1	1	1	459580-1	PLATE, RETAINING	10
1	-	1	1	1	2-459583-1	BODY, ANVIL	9
1	1	1	1	1	459582-4	ANVIL, AMPLIVAR SPLICE	8
1	-	1	1	1	459581-1	BLADE, SLUG	7
	-	-	-	-	-	-	6
	-	-	-	-	-	-	5
	-	-	-	-	-	-	4
1	1	1	1	1	459587-1	GUIDE, CRIMPER	3
	-	-	-	-	-	-	2
1	1	1	1	1	459585-1	CRIMPER, BLUNT F	1
	-77-27-25-22				PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.01 FINISH		NAME Ocean End Feed Applicator		SIZE A1	CAGE CODE 00779
		APPLICATION SPEC		DRAWING NO ©=2150117		RESTRICTED TO -	
MATERIAL -		WEIGHT -		Customer Accessible Production Drawing		SCALE 1:1	SHEET 3 OF 4
						REV B	

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



PACIFIC VERSION
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DIMENSIONS: mm		CHK G. BAILEY 16FEB2016	NAME Ocean End Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		APVD G. BAILEY 16FEB2016	SIZE A1 00779 C=2150117	
MATERIAL -		PRODUCT SPEC APPLICATION SPEC WEIGHT -	RESTRICTED TO -	
Customer Accessible Production Drawing		SCALE 1:1	SHEET 4	REV B

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