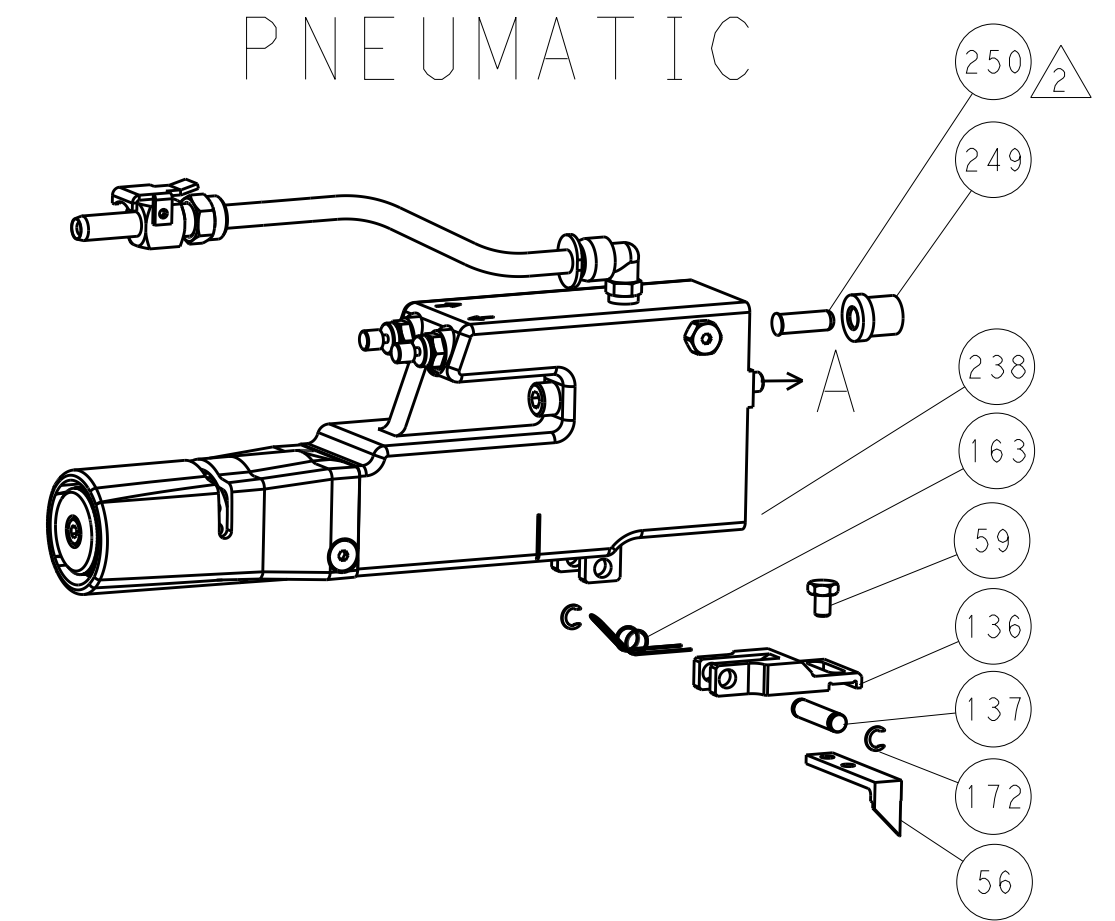


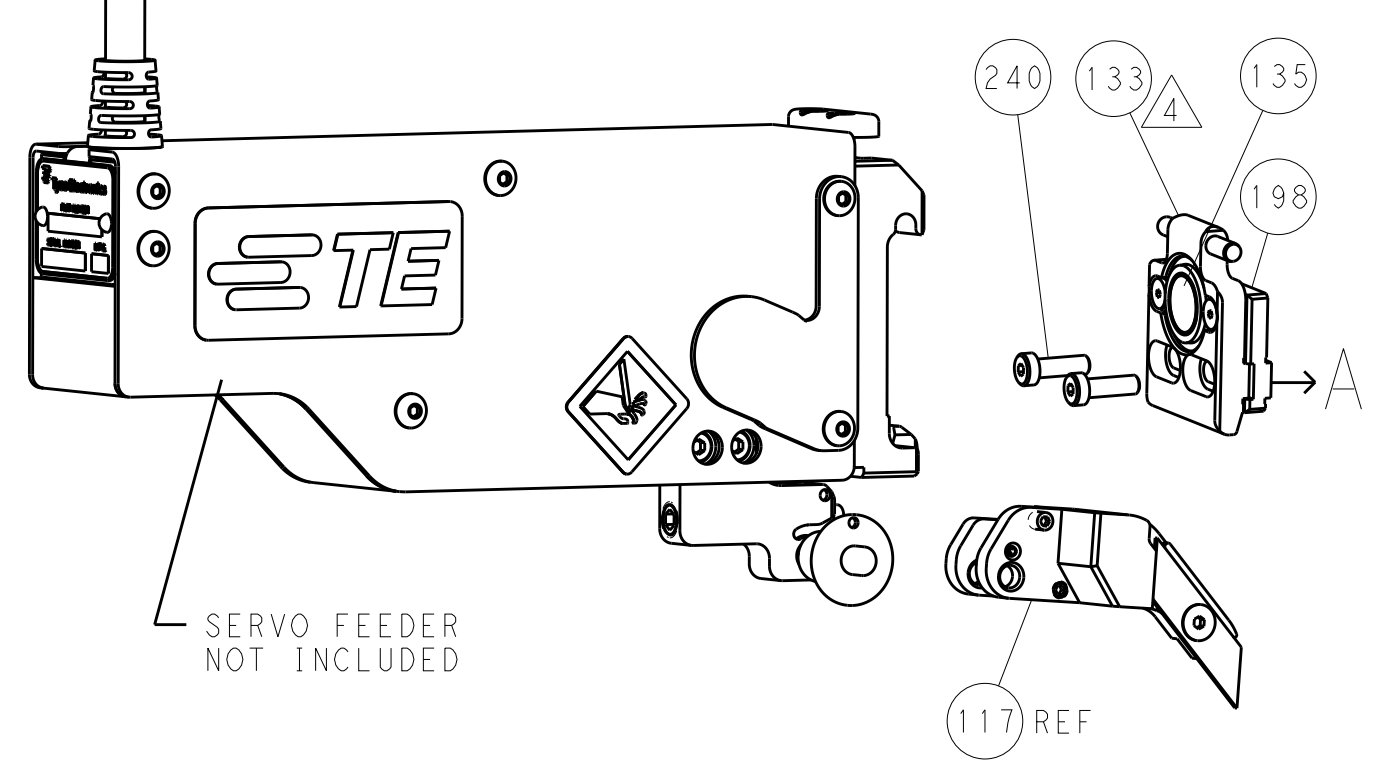
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

FEED TYPE

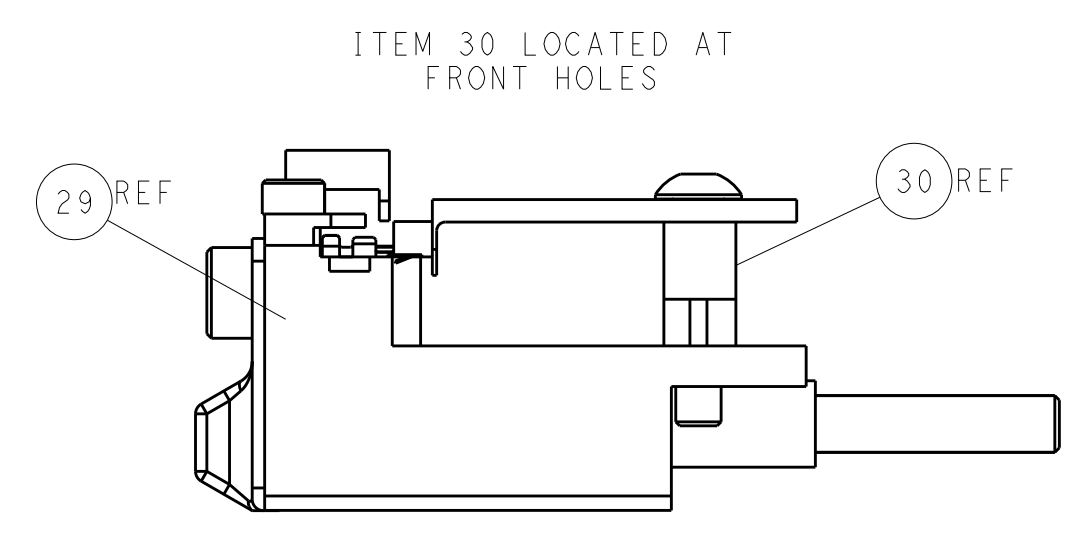
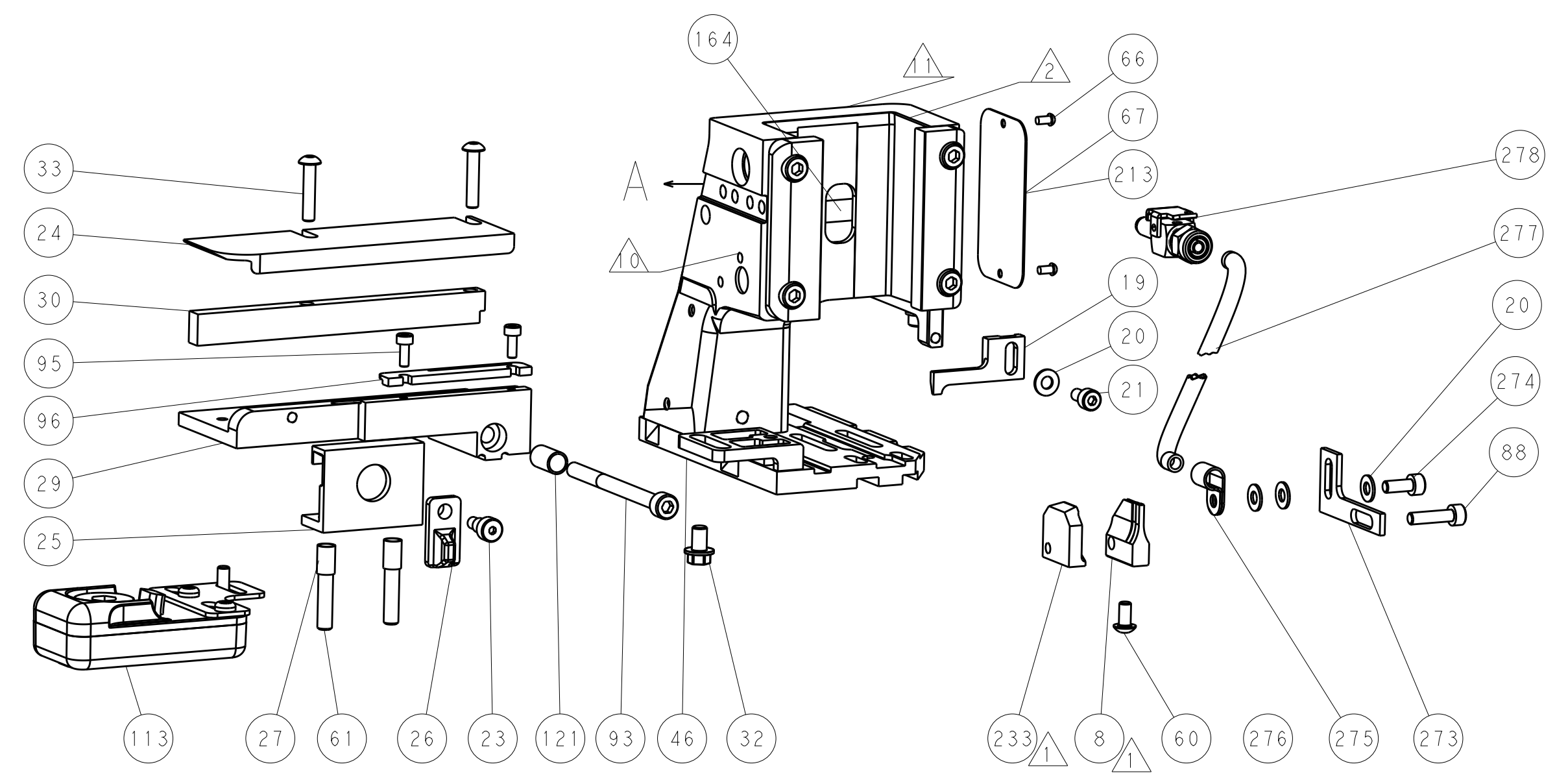
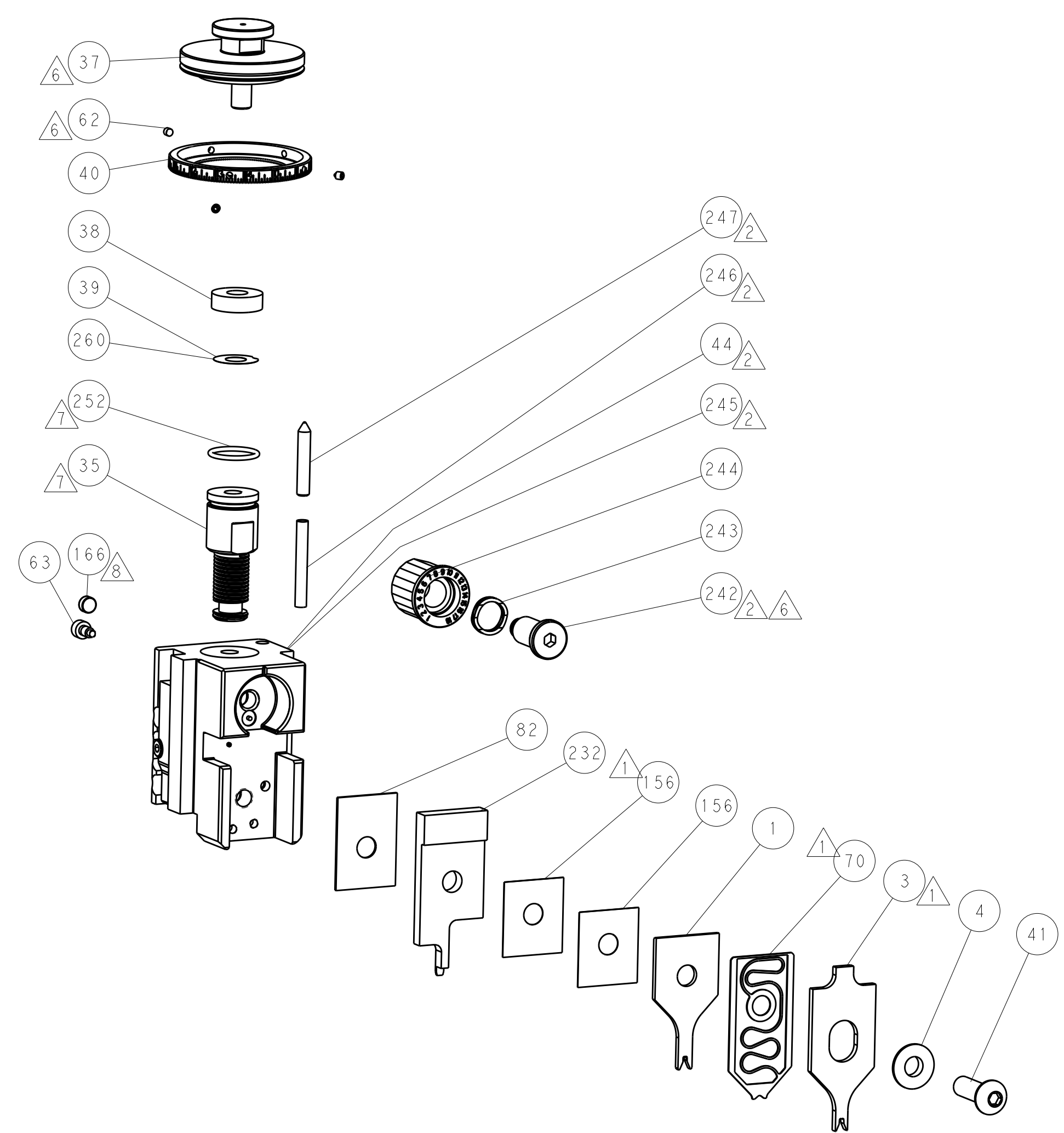
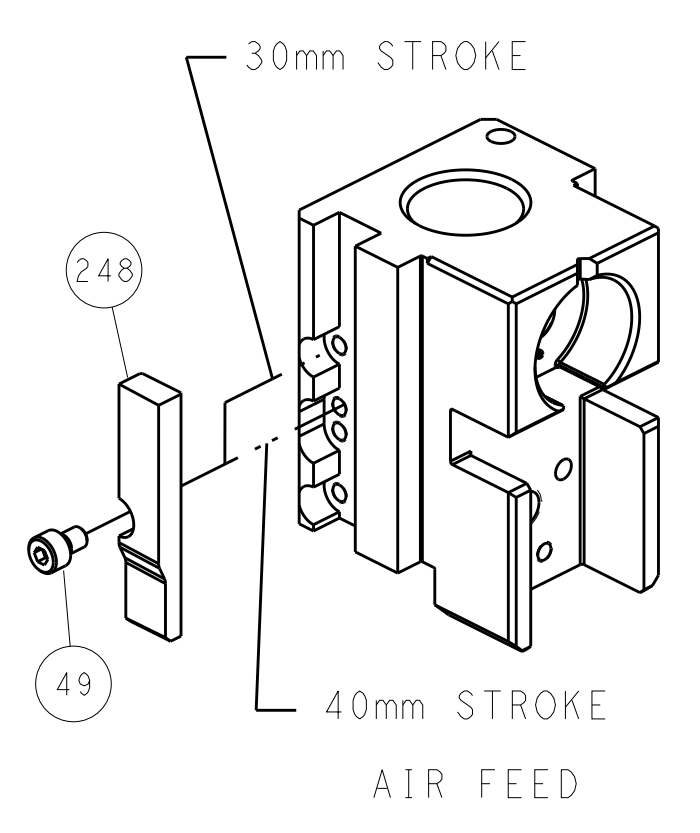
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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:		OWN	18DEC2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC	±		CHK	18DEC2012	
	1 PLC	±		APVD	18DEC2012	NAME
	2 PLC	±				Ocean Side Feed
	3 PLC	±				Applicator
	4 PLC	±				
	ANGLES	±				SIZE
MATERIAL	FINISH			WEIGHT		CAGE CODE
						00779
						©=2151434
Customer Accessible Production Drawing				SCALE	1:2	SHEET
						2
						OF 4
						REV
						C

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2151434-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2151434-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴
	2-2151434-7	C	FINE CRIMP HEIGHT ADJUST	NONE
	7-2151434-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.37 mm [.054]	F
INSUL	1.96 mm [.077]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: KK CRIMP TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.54-3.18 mm [1.00-.125 IN]		Ø1.09-1.57 mm [.043-.062 IN]	
TERMINAL APPLICATION SPECIFICATION	ATS-638882000 Rev E	-	-
TERMINALS APPLIED ¹⁰			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
286698-1	08-50-0113	286698-2	08-55-0101
286698-3	08-56-0109		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
22 AWG	0.815+/-0.025 [.032+/- .001]	6.2
24 AWG	0.760+/-0.030 [.030+/- .001]	6.4
26 AWG	0.735+/-0.025 [.029+/- .001]	6.6
28 AWG	0.705+/-0.025 [.028+/- .001]	6.8
30 AWG	0.685+/-0.025 [.027+/- .001]	7.0

- 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: 8-2151434-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151434-5
- 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. PLEASE REFER TO MOLEX APPLICATION TOOLING SPECIFICATION SHEET FOR COMPLETE TERMINAL LISTING.

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: KK CRIMP TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.54-3.18 mm [1.00-.125 IN]		Ø1.09-1.57 mm [.043-.062 IN]	
TERMINAL APPLICATION SPECIFICATION	ATS-638882000 Rev E	-	-
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
286698-4	08-52-0101	286698-5	08-65-0815
286698-6	08-65-0813	286698-7	97-00-0444
286698-8	08-55-0102	286698-9	08-70-0046
1-286698-0	08-52-0118	1-286698-1	08-52-0121
1-286698-2	08-50-0321	1-286698-3	08-65-0804
1-286698-4	08-65-0801	1-286698-5	08-65-0811
1-286698-6	08-65-0817	1-286698-7	40-07-0815
1-286698-8	97-00-0920		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹
22 AWG	0.815+/-0.025 [.032+/- .001]	6.2
24 AWG	0.765+/-0.025 [.030+/- .001]	6.4
26 AWG	0.710+/-0.030 [.028+/- .001]	6.6
28 AWG	0.685+/-0.025 [.027+/- .001]	6.8
30 AWG	0.645+/-0.015 [.0265+/- .0005]	7.0

***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
-	1	1	1	23238-1	INSERT, COUPLING	278
-	457	457	457	2030758-3	TUBING, POLYURETHANE	277
-	1	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	276
-	1	1	1	986220-3	CLAMP, CABLE, BLACK	275
-	1	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	274
-	1	1	1	2217068-1	BRACKET, AIR BLAST	273

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

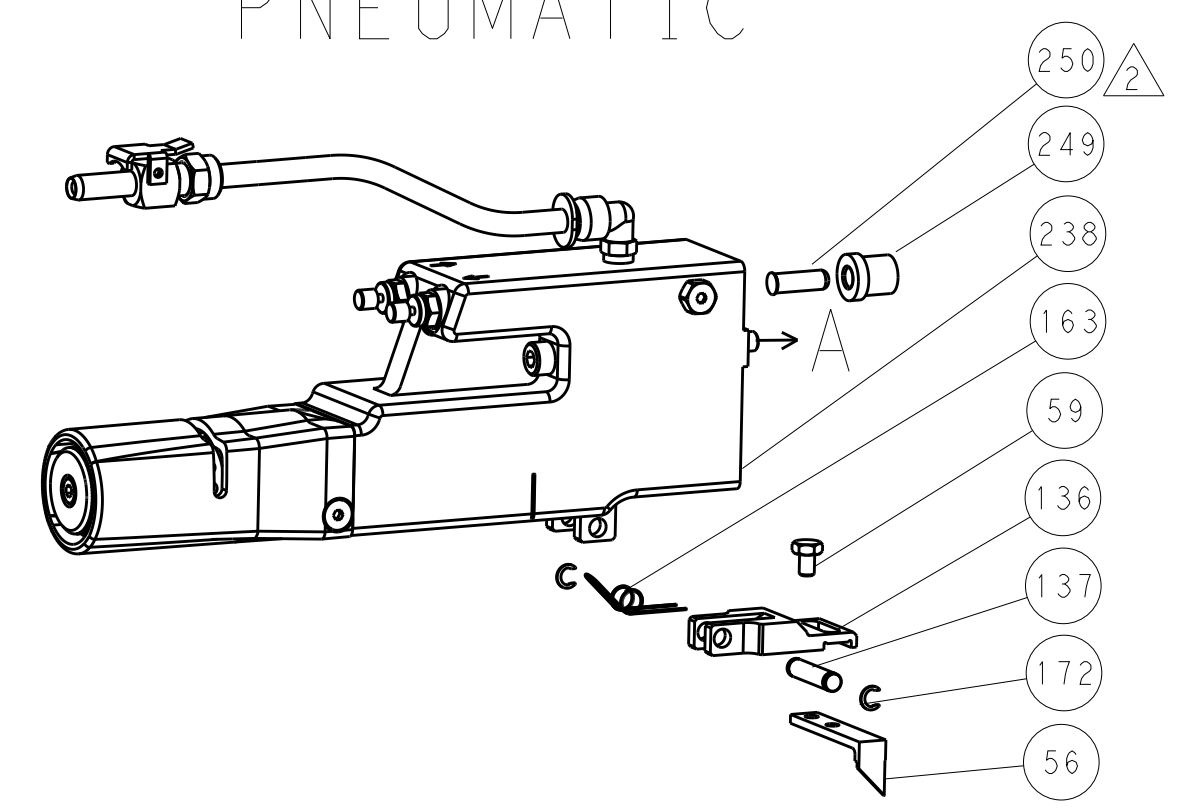
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	1	1	1	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	2119082-5	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	
-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240	
-	-	-	1	2063440-1	AIR FEED MODULE	238	
-	1	1	1	2063687-7	PLATE, REAR SHEAR	233	
-	1	1	1	1803174-3	BLADE, SLUG	232	
-	-	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	
-	2	2	2	2031943-1	SPACER, CRIMPER, SPECIAL	156	
-	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	
-	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1	1	2119650-1	RAM, 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	2-690487-2	GUIDE, FRONT STRIP	96	
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93	
-	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	88	
-	1	1	1	455888-7	SPACER, CRIMPER	82	
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	2119791-9	DEPRESSOR, WIRE	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	
-	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	
-	-	-	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	1-2119644-4	RAM WASHER, PRECISION	38	
-	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	1320908-5	SPACER, STRIP GUIDE	30	
-	1	1	1	2-1901086-9	PLATE, STRIP GUIDE	29	
-	2	2	2	22280-1	SPRING, COMPRESSION	27	
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	1-690754-5	DRAG, SPECIAL	25	
-	1	1	1	1320928-2	STRIP GUIDE	24	
-	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	
-	4	4	4	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1-2119533-1	STRIPPER, SIDE FEED	19	
-	-	-	-	-	-	10	
-	-	-	-	-	-	9	
-	1	1	1	1	2031312-3	ANVIL, SPECIAL	8
-	-	-	-	-	-	7	
-	-	-	-	-	-	6	
-	-	-	-	-	-	5	
-	1	1	1	1	3-238009-5	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	3-1803017-6	CRIMPER, INSULATION F	3
-	-	-	-	-	-	2	
-	1	1	1	1	1803173-1	CRIMPER, WIRE	1

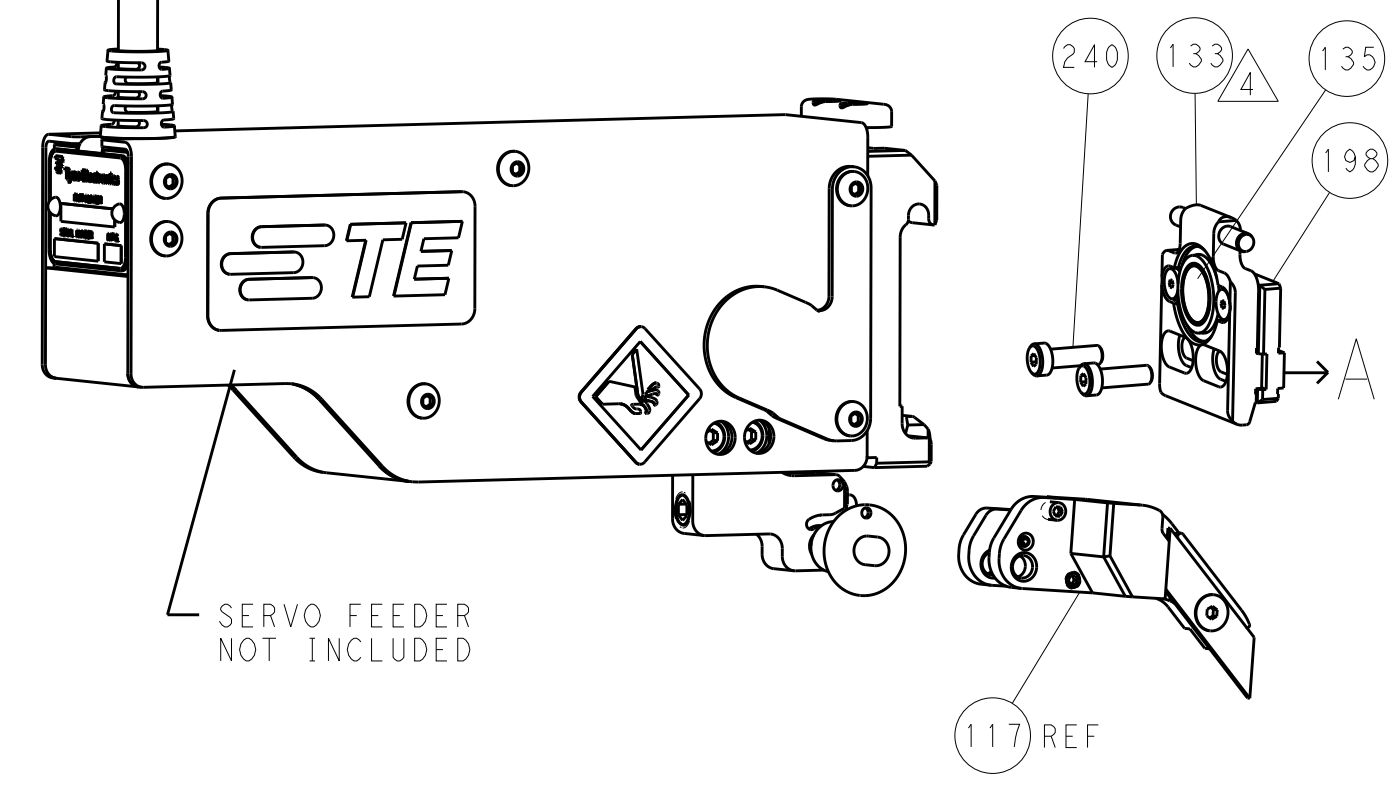
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MATERIAL				WEIGHT	SCALE	SHEET	REV
Customer Accessible Production Drawing				SCALE	1:2	SHEET 3 of 4	REV C

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

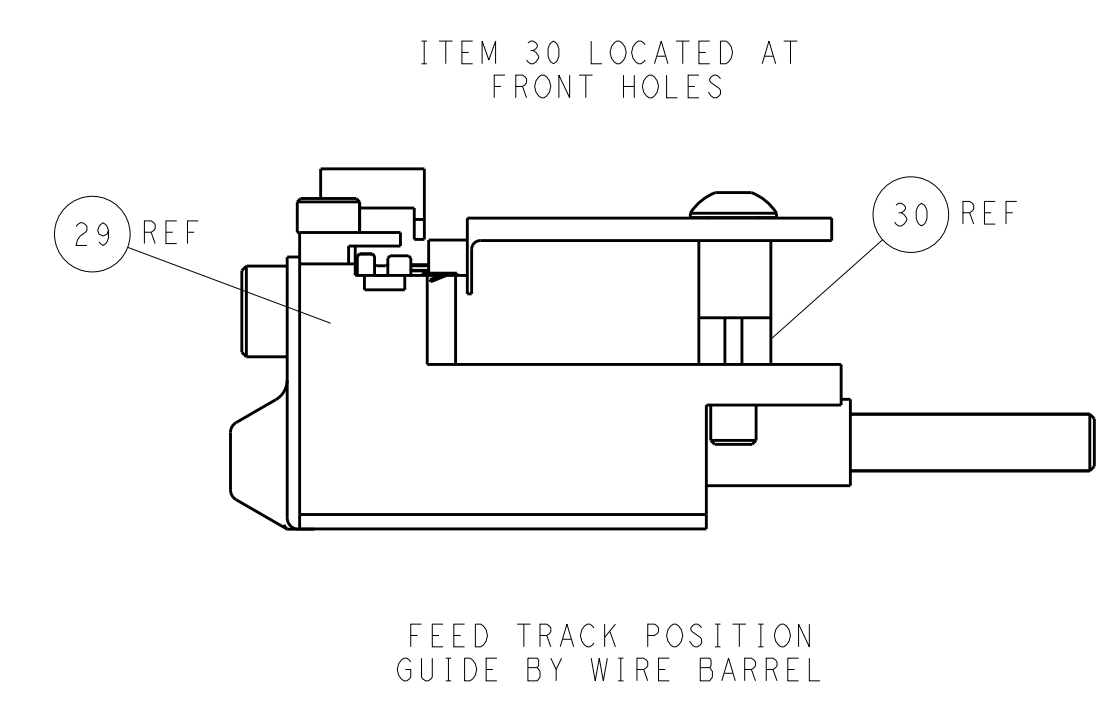
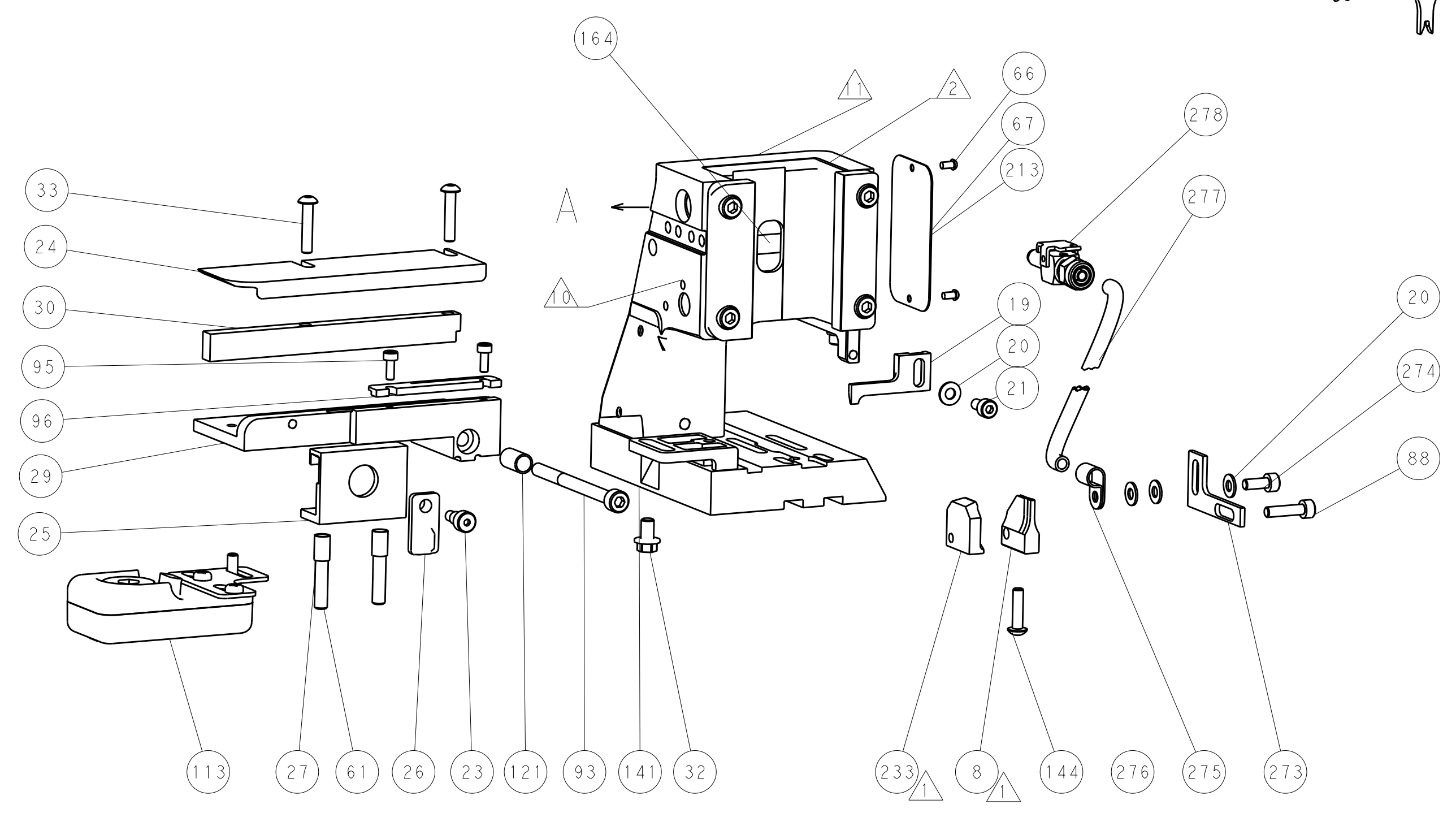
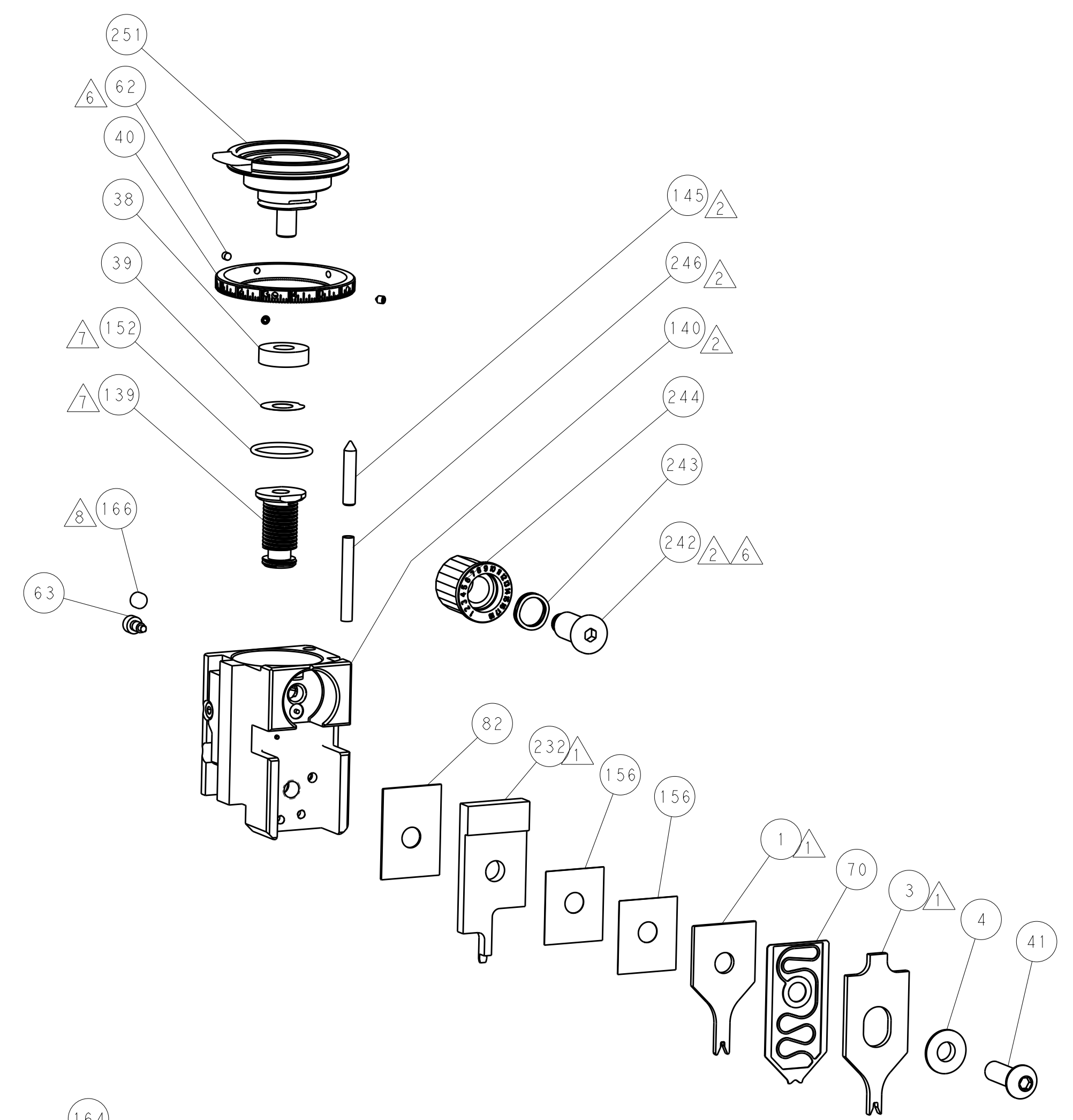
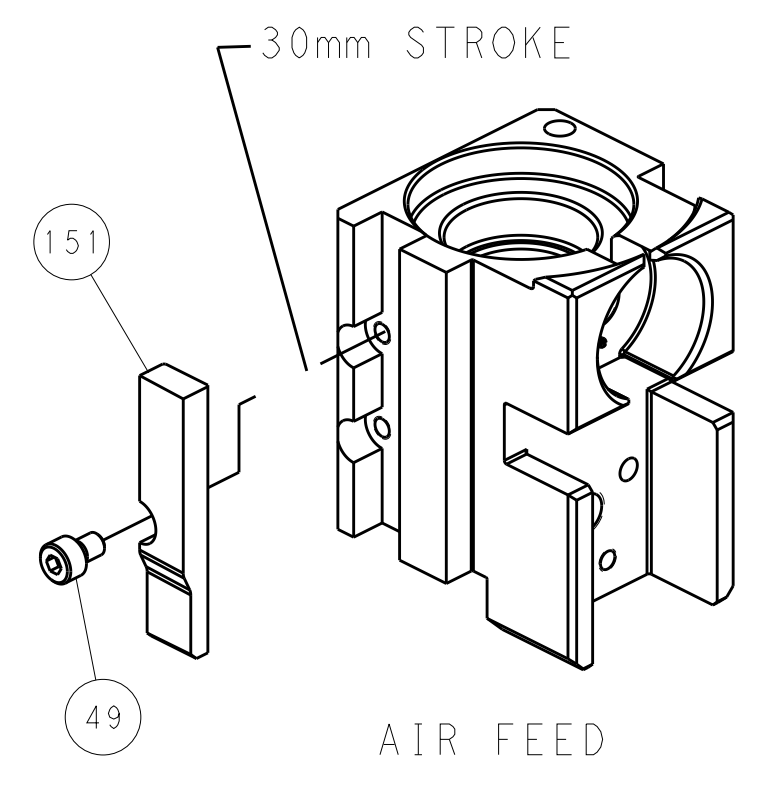
FEED TYPE PNEUMATIC



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN	18DEC2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC	±		CHK	18DEC2012	
	1 PLC	±		APVD	18DEC2012	NAME
	2 PLC	±				Ocean Side Feed
	3 PLC	±				Applicator
	4 PLC	±				
	ANGLES	±				
MATERIAL	FINISH			WEIGHT		SIZE
						CAGE CODE
						DRAWING NO
						RESTRICTED TO
						A 00779 ©=2151434
						Customer Accessible Production Drawing
						SCALE 1:2 SHEET 4 OF 4 REV C