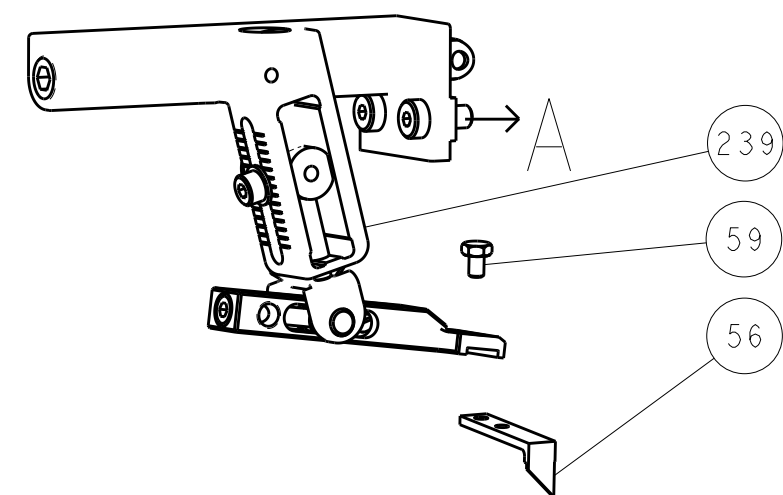
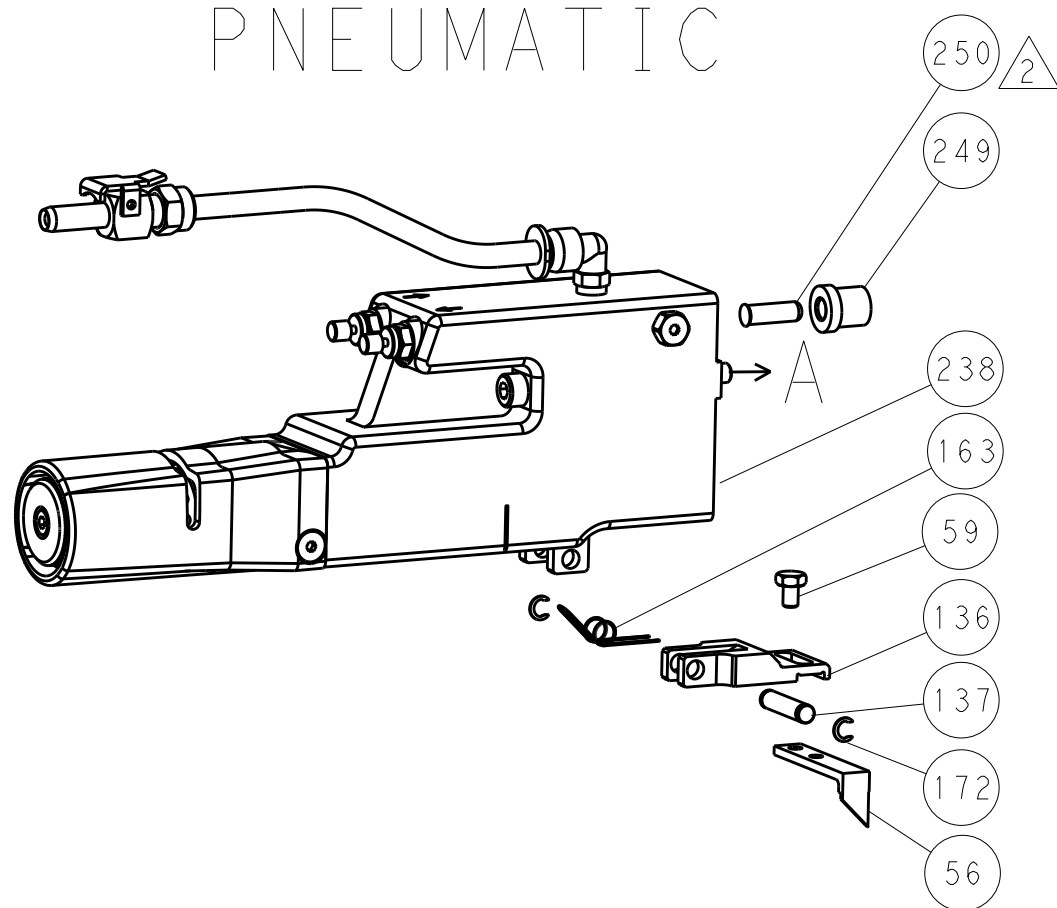


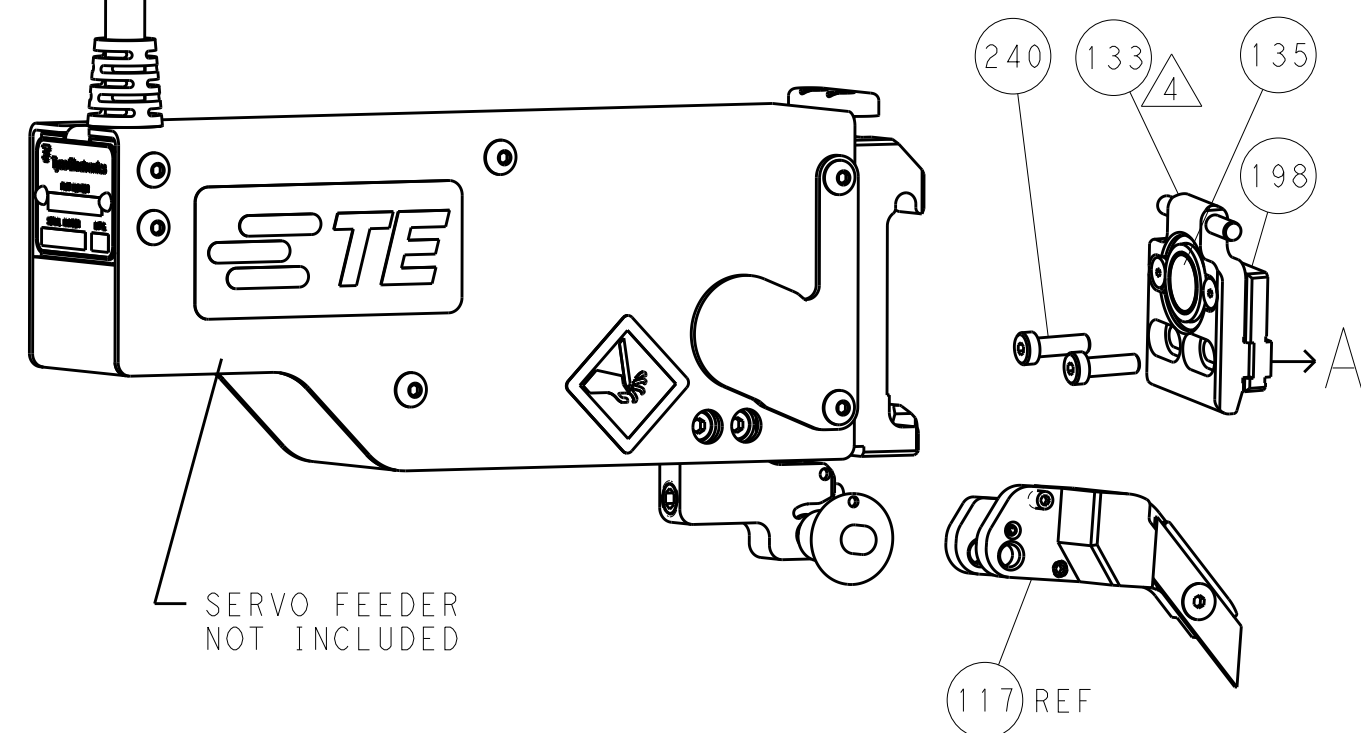
FEED TYPE MECHANICAL



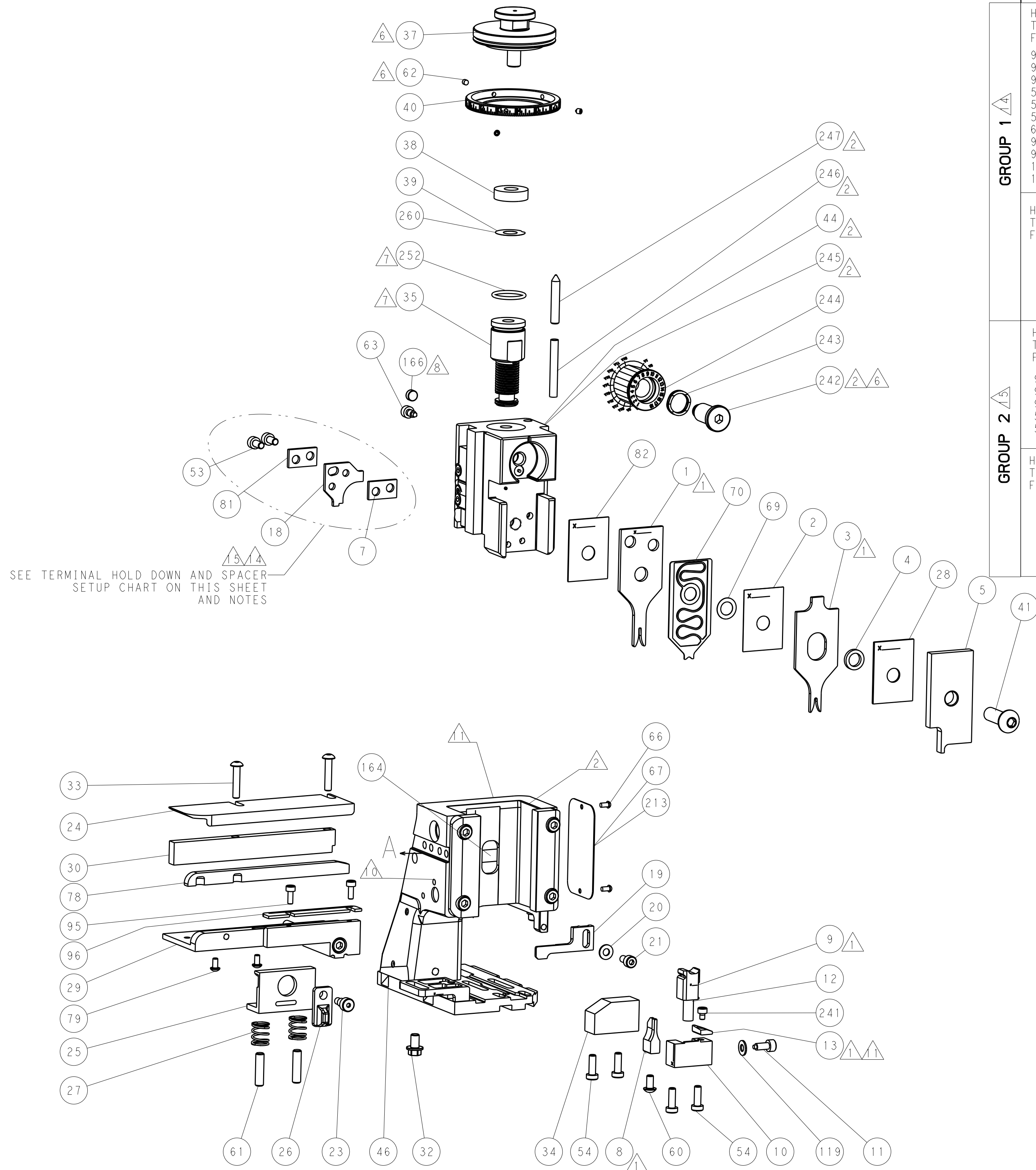
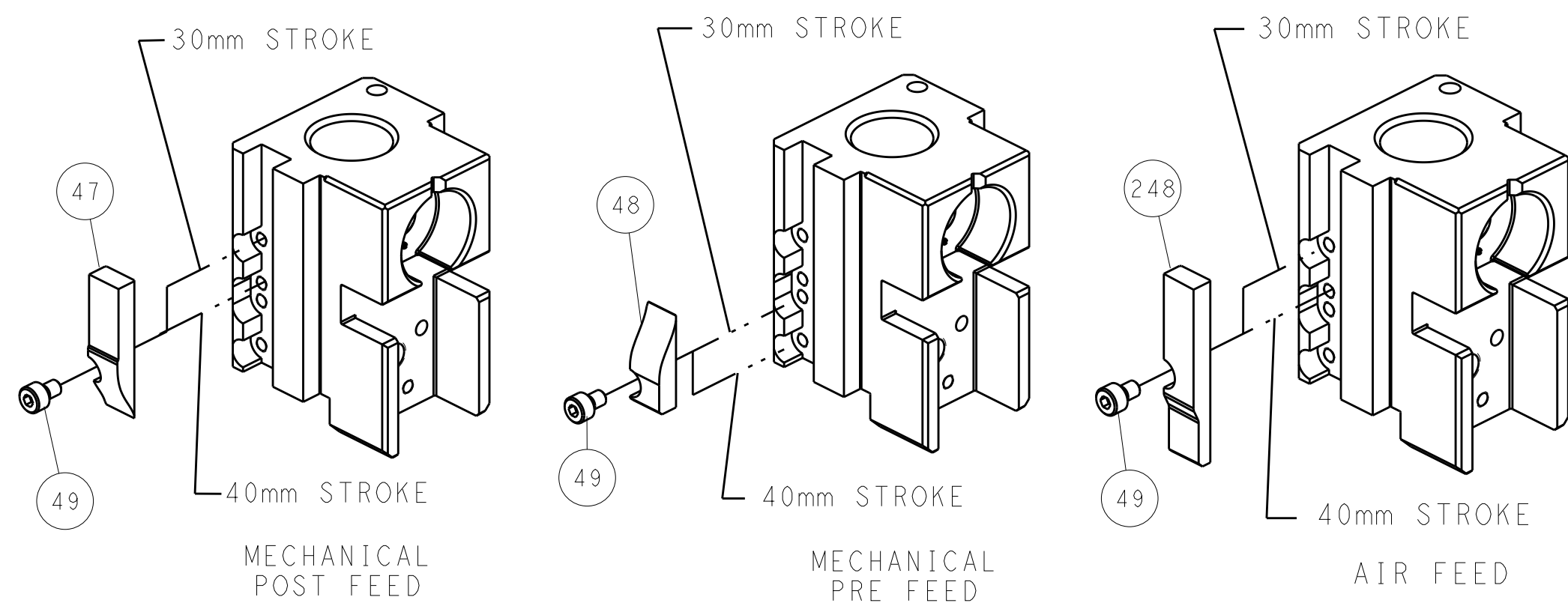
PNEUMATIC



SERVO LATCH PLATE



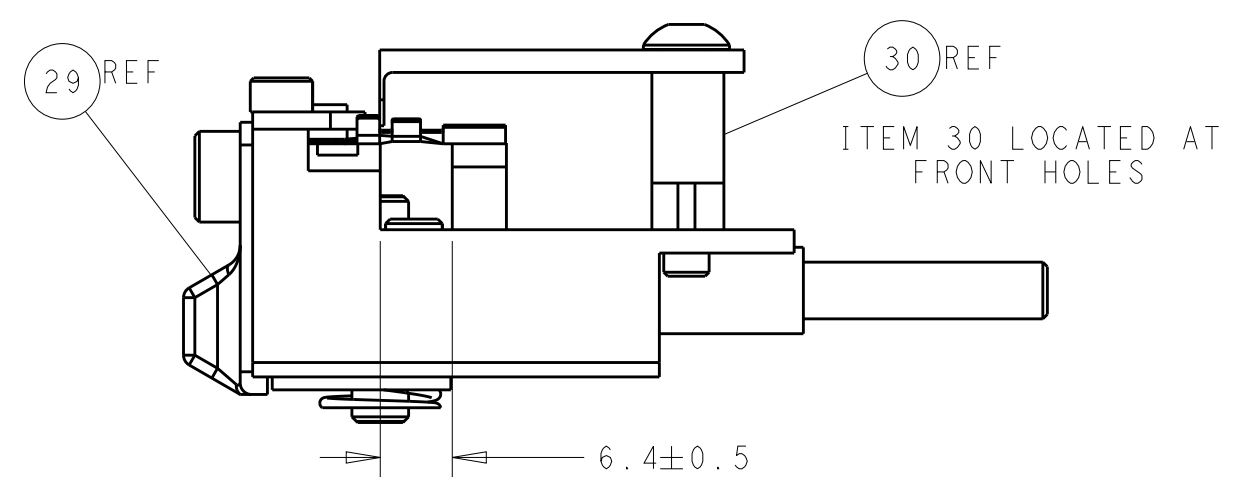
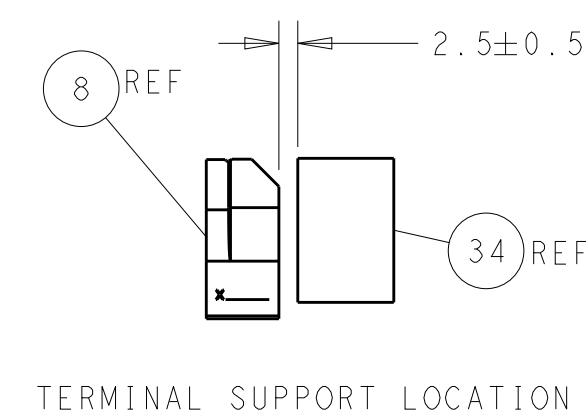
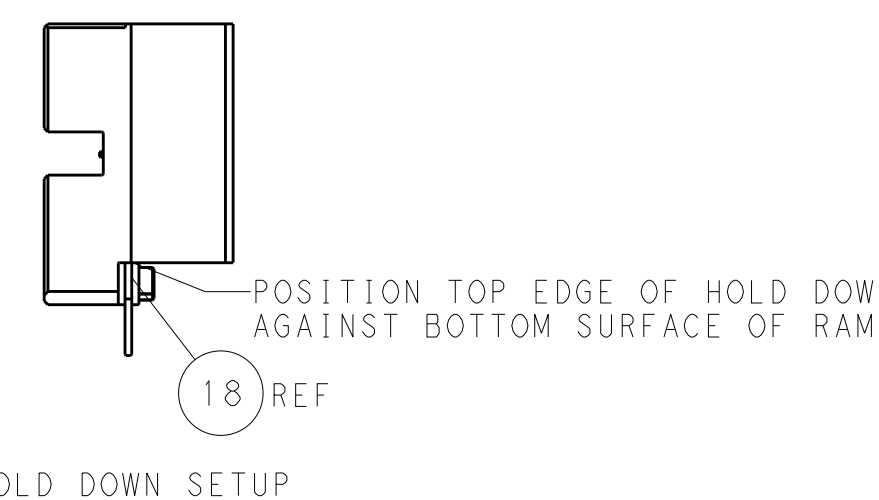
CAM POSITIONS



SEE TERMINAL HOLD DOWN AND SPACER
SETUP CHART ON THIS SHEET
AND NOTES

LOC		DIST		REV		DATE		BY		CHKD	
A		66		1		08DEC2011		T. ELBIN		T. ELBIN	

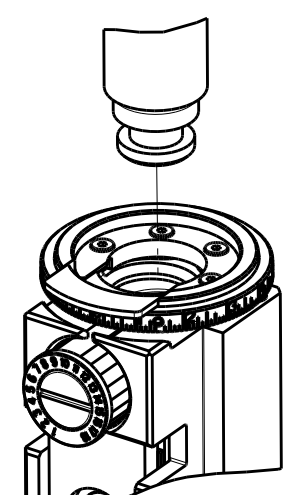
TERMINAL HOLD DOWN & SPACER SETUP CHART											
HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:				POSITION 1							
928999-1				2-928918-2							
928999-5				3-928918-2							
928999-6				5-928918-1							
5-928999-1				6-928918-1							
5-928999-5				6-928918-2							
5-928999-6				6-928918-3							
6-928999-5				1394702-1							
928918-1				1394702-2							
928918-2				5-1394702-1							
1-928918-1				5-1394702-2							
1-928918-2											
HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:				POSITION 1							
968893-1											
HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:				POSITION 2							
968220-1				5-968220-6							
968220-5				1703296-1							
968220-6				1703296-5							
5-968220-1				1534116-1							
5-968220-5				1534116-2							
				5-1534116-1							
HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:				POSITION 2							
1241918-1											



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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST VERSION.				OWN: HOFFNER 07DEC2001 CHK: T. ELBIN 08DEC2011 APVD: T. ELBIN 08DEC2011				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1				NAME: Ocean Side Feed Applicator			
MATERIAL: .				FINISH: .				SIZE: A1			
								CAGE CODE: 00779			
								DRAWING NO: C=2151541			
								SHEET 2 OF 4			
								REV D4			

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7		6		5		4		3		
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20								
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.										
	PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
						SERVO LATCH PLATE	2119951-1	-	8-2151541-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2151541-4	-	-	-
						MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
						SERVO LATCH PLATE	2119951-1	-	8-2151541-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2151541-4	-	-	-
						MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
						-	-	-	-	-	-	
						-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.83 mm [.072]	O
APPLICATOR INSTRUCTIONS 408-10389		
TERMINAL DATA: TE TERMINAL		TE SPECIFICATION
TERMINAL NAME: MICRO QUADLOK SYSTEM		
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE	
3.05-3.35 mm [.120-.132 IN]	Ø 1.15-1.60 mm [.045-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-18021	-
	(B)114-61024	-
TERMINALS APPLIED		
GROUP 1		GROUP 2
TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 928999-1	(A) 5-928918-2	(A) 968220-1
(A) 928999-5	(A) 5-928918-1	(A) 968220-5
(A) 928999-6	(A) 6-928918-1	(A) 968220-6
(A) 5-928999-1	(A) 6-928918-2	(A) 5-968220-1
(A) 5-928999-5	(A) 6-928918-3	(A) 5-968220-5
(A) 5-928999-6	(A) 1394702-1	(A) 5-968220-6
(A) 6-928999-5	(A) 1394702-2	(B) 2005119-1
(A) 928918-1	(A) 5-1394702-1	
(A) 928918-2	(A) 5-1394702-2	
(A) 1-928918-1	(A) 968893-1	
(A) 1-928918-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35mm2	0.82+/-0.03 [.032+/- .001]	9.3
0.25mm2	0.76+/-0.03 [.030+/- .001]	10.0
0.20mm2	0.72+/-0.03 [.028+/- .001]	10.4

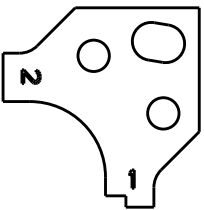
- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151541-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151541-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151541-5
- 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 ITEMS 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET 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.
- 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.
- REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3 CONCERNING CRIMPING 0.50mm² WIRE.

TERMINAL DATA: TE TERMINAL		TE SPECIFICATION	
TERMINAL NAME: MICRO QUADLOK SYSTEM			
WIRE STRIP LENGTH 3.05-3.35 mm [.120-.132 IN]		INSULATION DIAMETER RANGE Ø 1.15-1.60 mm [.045-.063 IN]	
TERMINAL APPLICATION SPECIFICATION			
(A)114-18021			
(B)114-61024			
TERMINALS APPLIED			
GROUP 1		GROUP 2	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 928999-1	(A) 5-928918-2	(A) 968220-1	(A) 1703296-1
(A) 928999-5	(A) 5-928918-1	(A) 968220-5	(A) 1703296-5
(A) 928999-6	(A) 6-928918-1	(A) 968220-6	(A) 1534116-1
(A) 5-928999-1	(A) 6-928918-2	(A) 5-968220-1	(A) 1534116-2
(A) 5-928999-5	(A) 6-928918-3	(A) 5-968220-5	(A) 5-1534116-1
(A) 5-928999-6	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 6-928999-5	(A) 1394702-2		(A) 1241918-1
(A) 928918-1	(A) 5-1394702-1		
(A) 928918-2	(A) 5-1394702-2		
(A) 1-928918-1	(A) 968893-1		
(A) 1-928918-2			

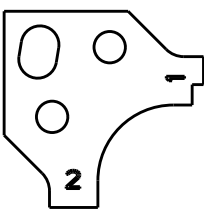
WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	0.92+/-0.03 [.036+/- .001]	8.3

*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.

POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS, REFER TO SHEET 2.



POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS, REFER TO SHEET 2.



-	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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	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
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

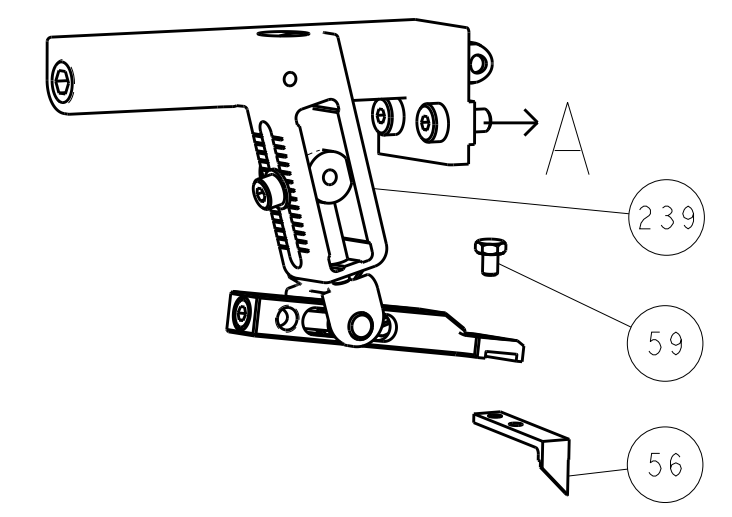
PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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

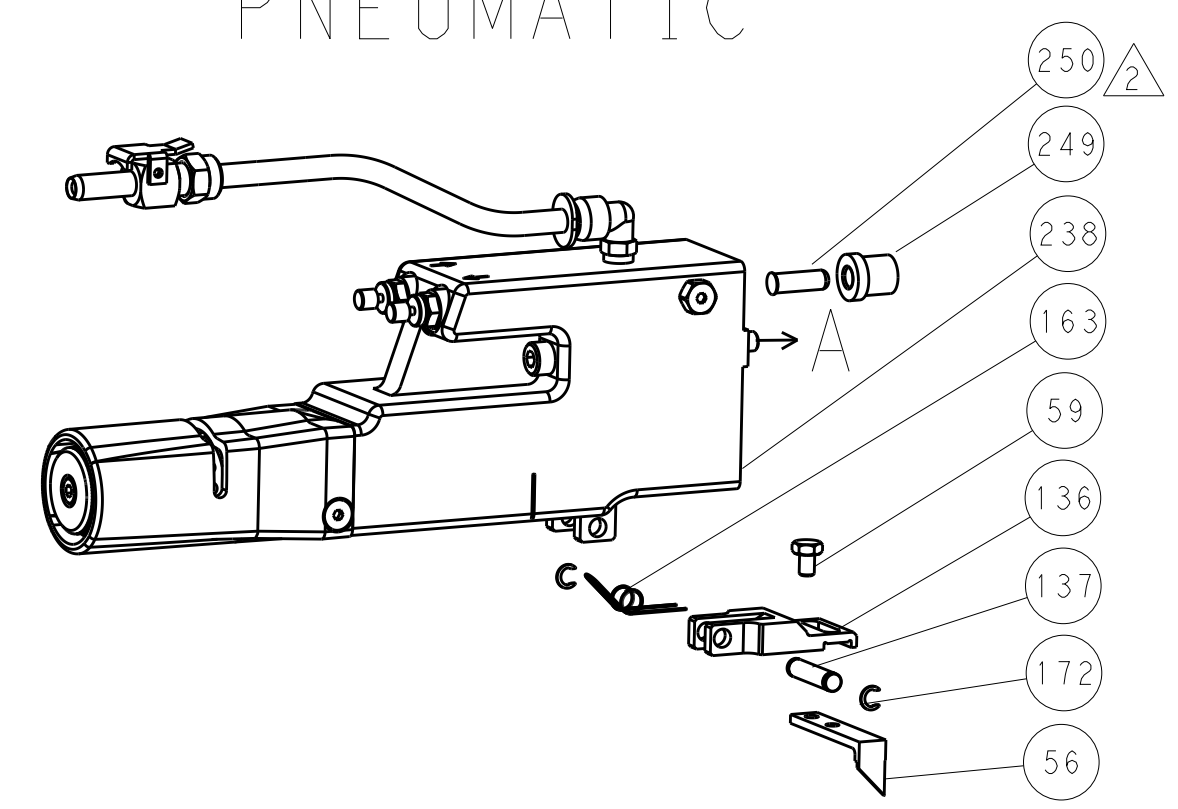
-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	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	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	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	1-18028-2	WASHER, FLAT, REG M4	119
-	-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1-240641-3	SPACER	81
-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	79
-	1	1	1	1	1633782-2	FENCE	78
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	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	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1752356-6	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	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	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	240792-1	DRAG, TERMINAL	25
-	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	2217529-1	TERMINAL HOLD DOWN	18
-	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	462006-6	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1333233-1	ANVIL, COMBINATION, SPECIAL	8
-	1	1	1	1	4-240641-2	SPACER	7
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	1	5-568176-3	CRIMPER, WIRE	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER OF THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.		DWN 07DEC2001	TE Connectivity	
CHK T. ELBIN		08DEC2011	Harrisburg, PA 17105-3608	
APVD T. ELBIN		08DEC2011	NAME	
DIMENSIONS: mm		PRODUCT SPEC	Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES FINISH ±.		APPLICATION SPEC	SIZE CASE CODE DRAWING NO	
MATERIAL		WEIGHT	A1 00779 ©=2151541	
CUSTOMER DRAWING		SCALE 1:1	SHEET 3 OF 4	
		REV D4		

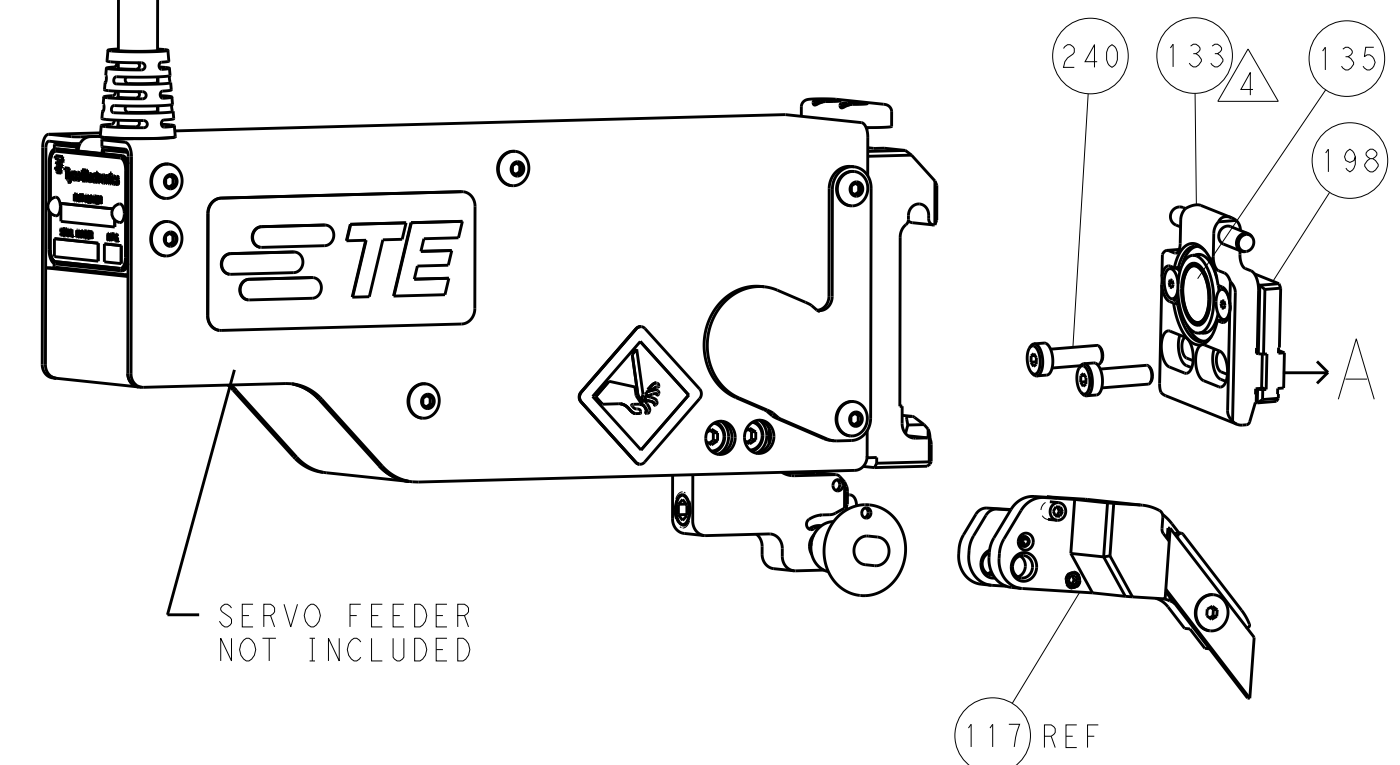
FEED TYPE MECHANICAL



PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS

