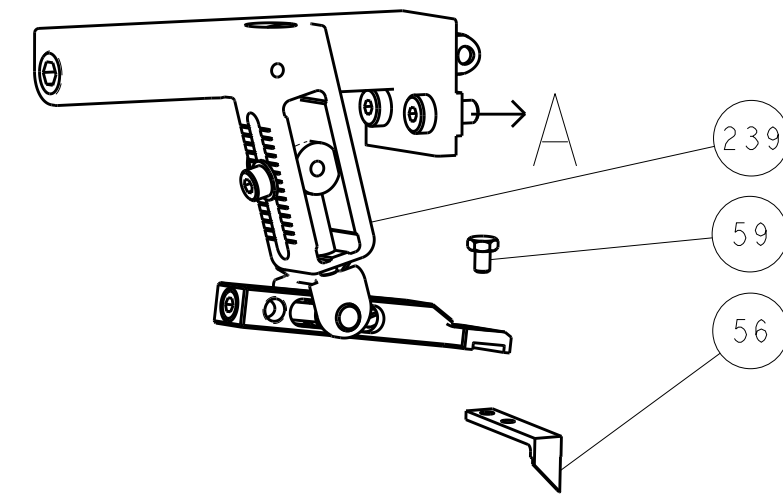
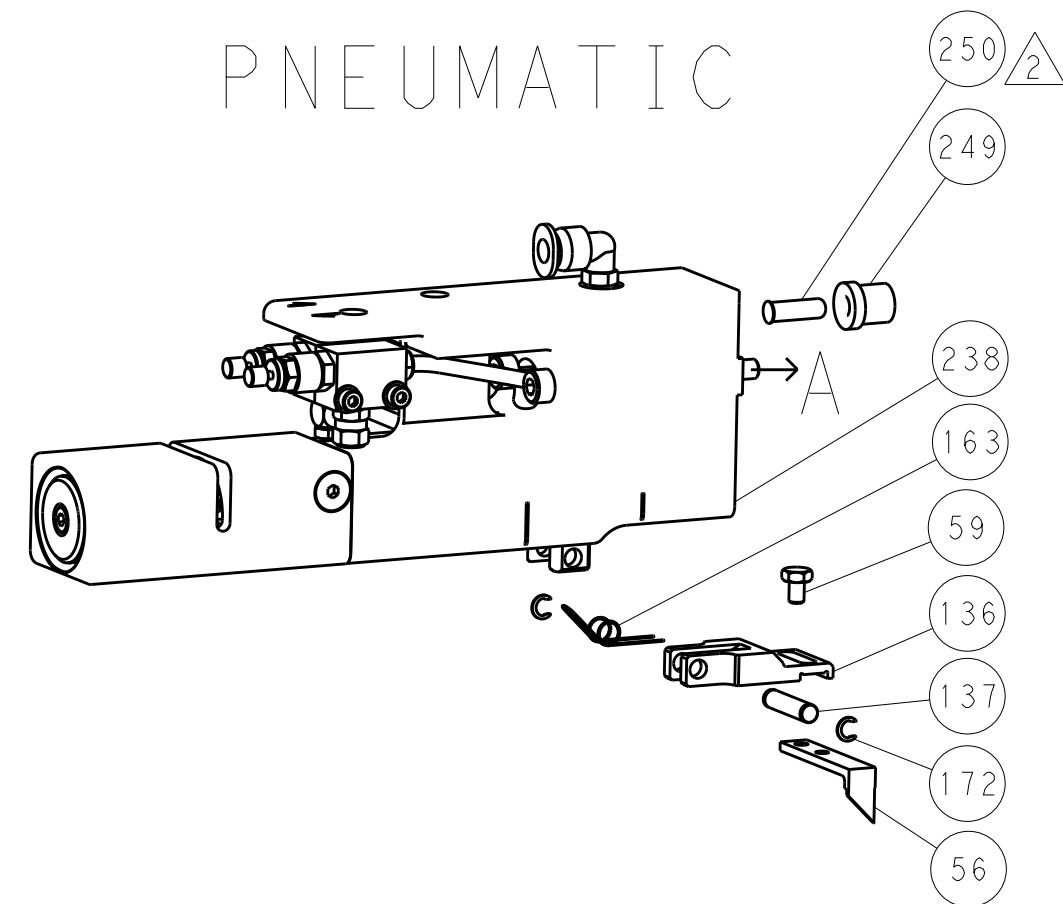
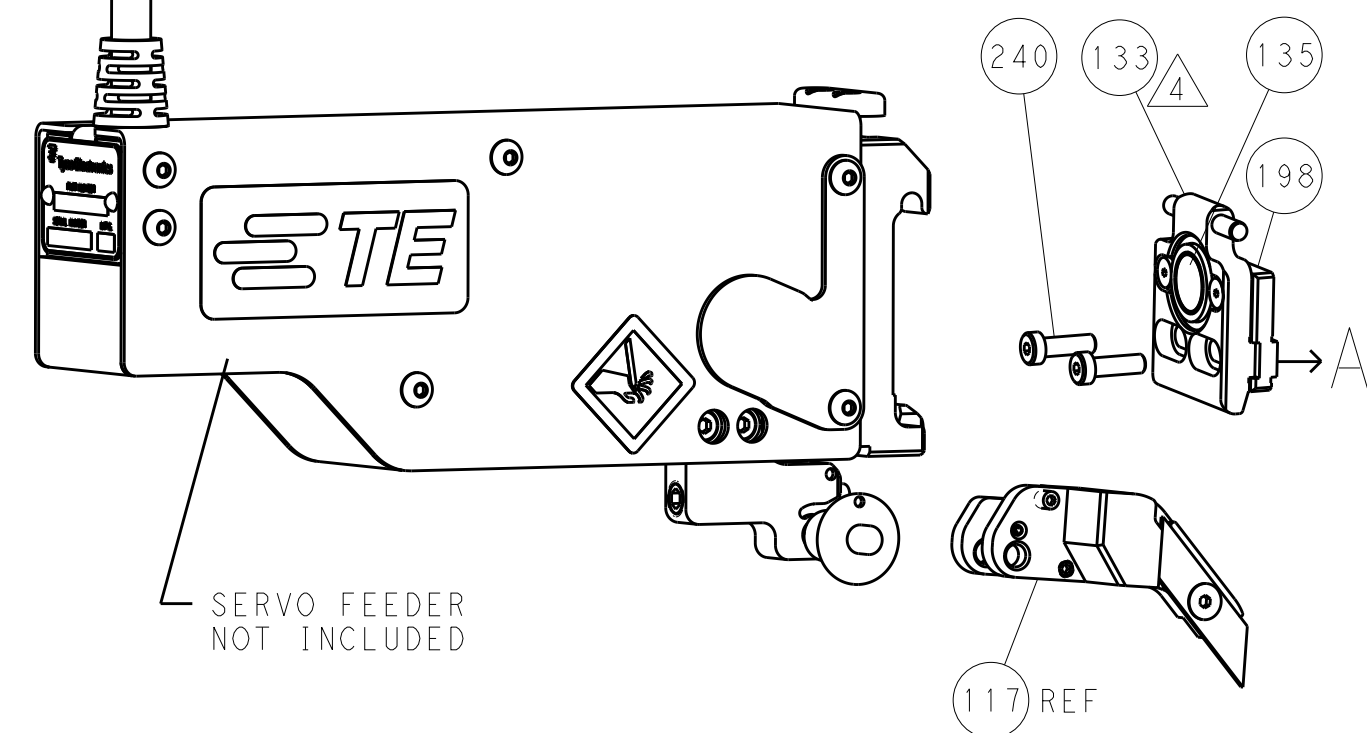


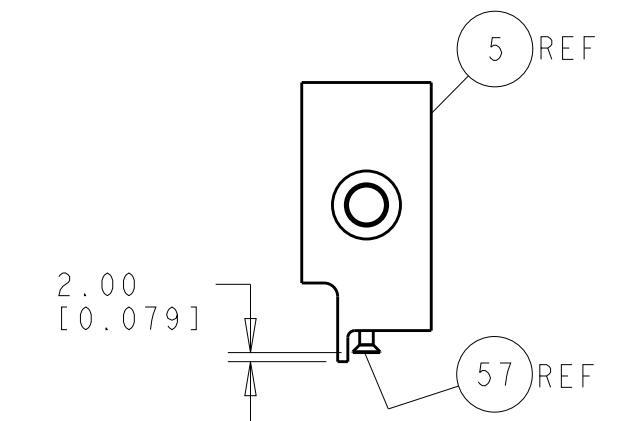
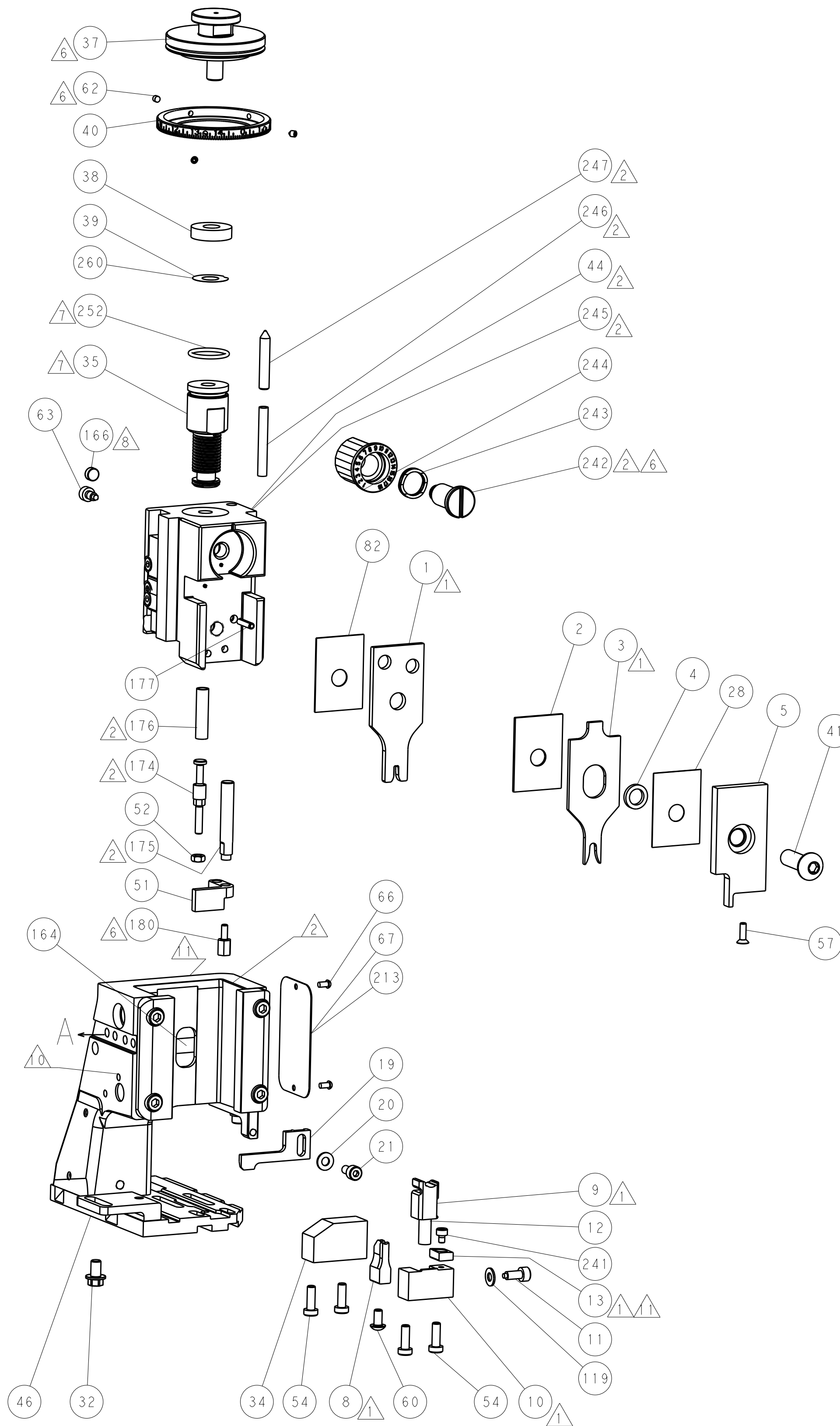
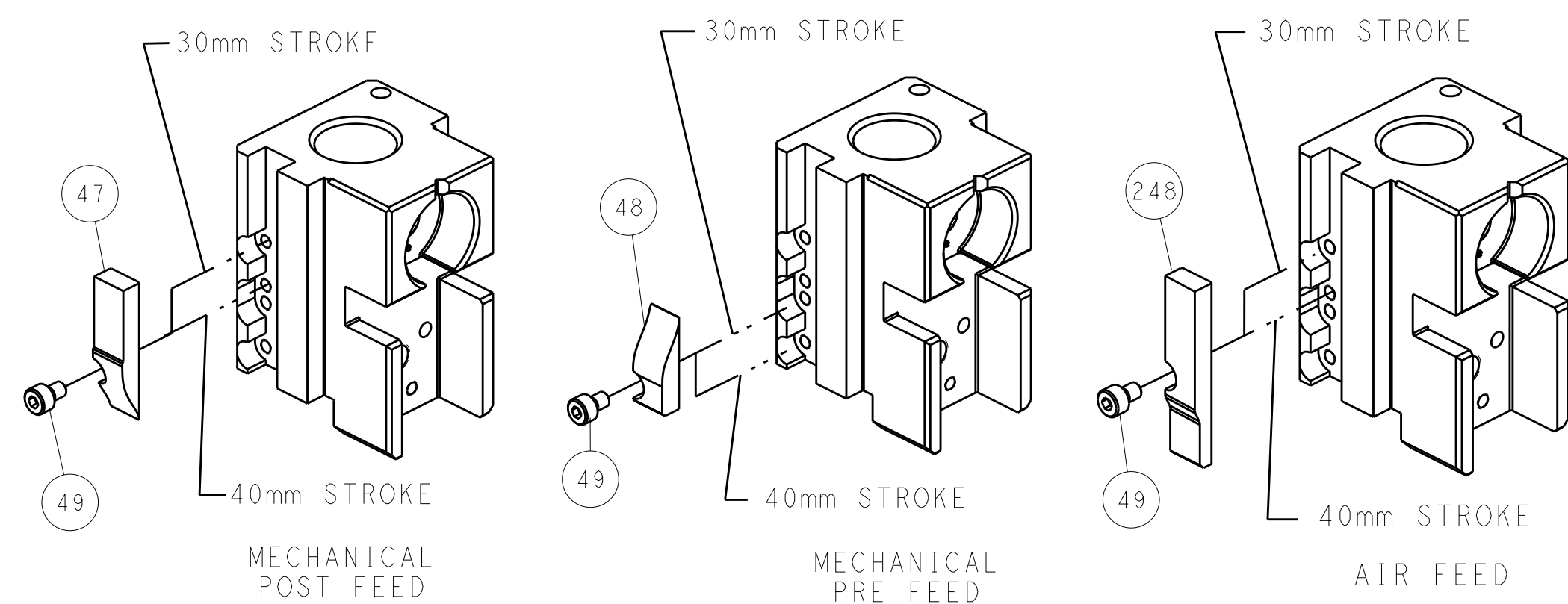
FEED TYPE
MECHANICAL



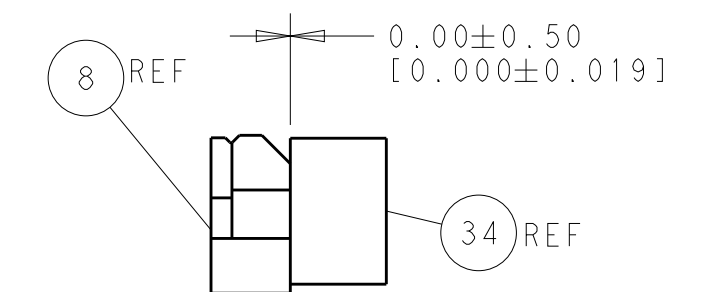
PNEUMATIC

SERVO
LATCH PLATE

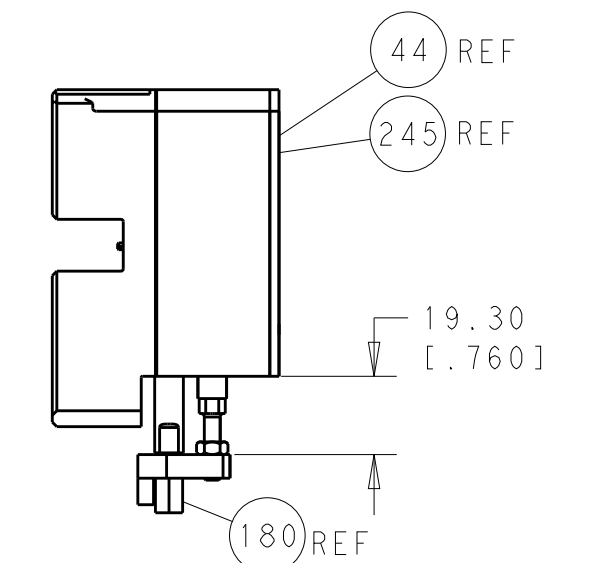
CAM POSITIONS



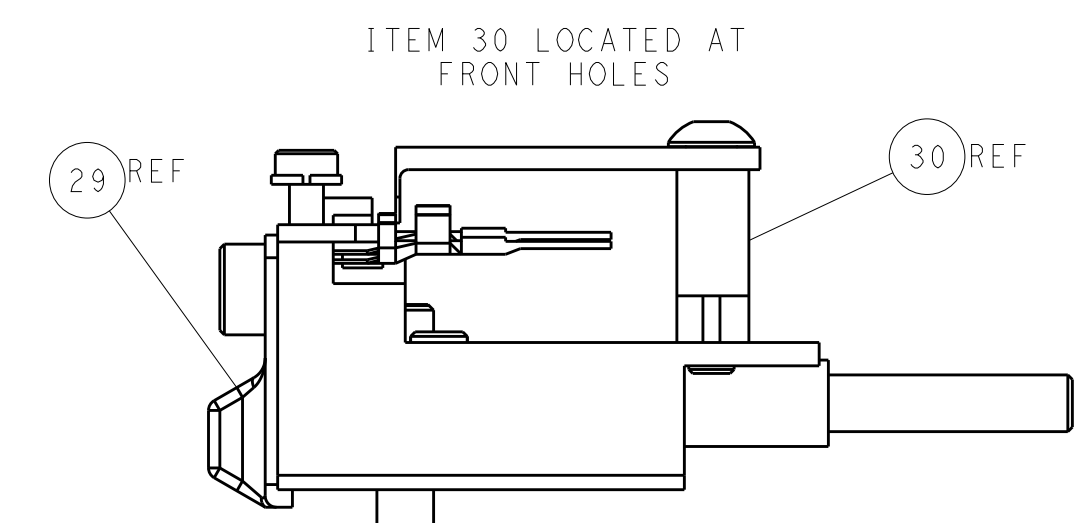
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



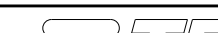
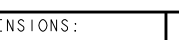
HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INS. BARREL

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 A CONTROLLING DOCUMENT FOR THE PRODUCING ORGANIZATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION MAY BE CONTACTED FOR THE LATEST REVISIONS		DWN Y YIN 24APR2013		 TE Connectivity Harrisburg, PA 17105-3608	
CHK G.BAILEY 24APR2013		APVD U GUO 24APR2013			
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±.		NAME Oen Air Feed Applicator -	
MATERIAL -		FINISH -		SIZE A1	
		WEIGHT -		GAGE CODE 00779	
				DRAWING NO C-2151938	
		Customer Accessible Production Drawing		SCALE 1:1 SHEET 2 OF 4 REV A	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8

7

6

5

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

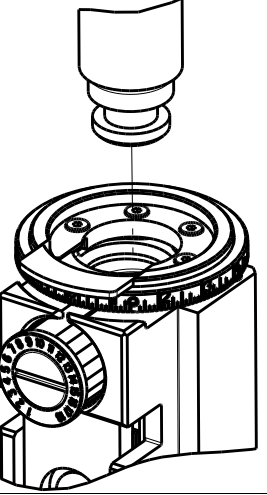
RELEASED FOR PUBLICATION

20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2151938-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

2-2151938-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

2-2151938-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2-2151938-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

2-2151938-7

A

FINE CRIMP HEIGHT ADJUST

NONE

7-2151938-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.68 mm [.145]	O

APPLICATOR INSTRUCTIONS
408-10389



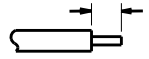
TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: .070 TAB ECONOSEAL 3

WIRE STRIP LENGTH

4.00-4.50 mm [.157-.177 IN]



INSULATION DIAMETER RANGE

Ø3.00 mm MAX [Ø.118 IN MAX]

TERMINAL APPLICATION SPECIFICATION

114-3040

-

-

-

-

-

-

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
345807-1		172888-2	172746-1

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING⁹

2.00mm2	1.75+/-0.05 [.069+/- .002]	4.0
1.50mm2	1.57+/-0.05 [.062+/- .002]	5.8
1.00mm2	1.37+/-0.05 [.054+/- .002]	8.0
0.75mm2	1.30+/-0.05 [.051+/- .002]	8.8



RECOMMENDED SPARE PARTS

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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151938-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151938-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151938-5

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 & 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. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION RANGE QUOTED IS THAT OF THE TERMINAL. THE SEAL INSULATION RANGE IS Ø1.85-2.70 [Ø.073-.106 IN].

13. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

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	-	8-2151938-5	1901094-3	1-1752354-5	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151938-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
SERVO LATCH PLATE	2119951-1	-	8-2151938-5	1901094-3	1-1752354-5	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151938-4	-	-	-
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
-	-	-	-	-	-	-
-	-	-	-	-	-	-

SET UP GAUGE

2119599-1

LOC

A

DIST

66

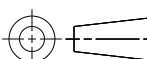
REVISONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
-	-	SEE SHEET 1	-	-	-

-	1	1	1	1	2119082-8	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
-	-	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
-	1	1	1	1	1-1752354-5	STANDOFF,HOLD-DOWN	180
-	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	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
-	-	-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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
-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	51
-	-	-	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	1-2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	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	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	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	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	2-1633132-3	ANVIL, COMBINATION .090	8
	-	-	-	-	-	-	7
	-	-	-	-	-	-	6
	-	1	1	1	2119781-5	DEPRESSOR, SHEAR	5
	-	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	3-2119784-8	CRIMPER, INSULATION O PREMIUM	3
1	-	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	1	1	4-456406-7	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND THE USER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.

DIMENSIONS:
mm



MATERIAL: -

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±.1
1 PLC ±0.1
3 PLC ±0.02
5 PLC ±0.005
4 PLC ±0.0005 ANGLES ±.1

FINISH: -

DWN: Y. YIN 24APR2013
CHK: G. BAILEY 24APR2013
APVD: H. GUO 24APR2013

PRODUCT SPEC: -
APPLICATION SPEC: -

WEIGHT: -

Customer Accessible Production Drawing

NAME: Ocean Side Feed Applicator

SIZE: A | CASE CODE: 00779 ©=2151938
DRAWING NO: 00779

RESTRICTED TO: -

SCALE: 1:1 SHEET 3 OF 4 REV A

PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4

(Atlantic version shown on sheets 1 of 4 & 2 of 4)

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
-	-	SEE SHEET 1	-	-	-

-	1	1	1	1	2119082-8	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
-	-	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
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-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
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-	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
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-	-	-	1	1	1338685-1	PAWL, FEED	56
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	51
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-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPAC	

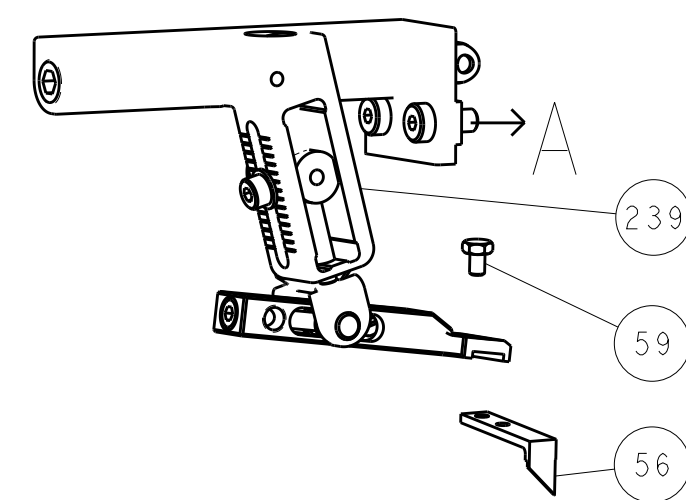
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

C

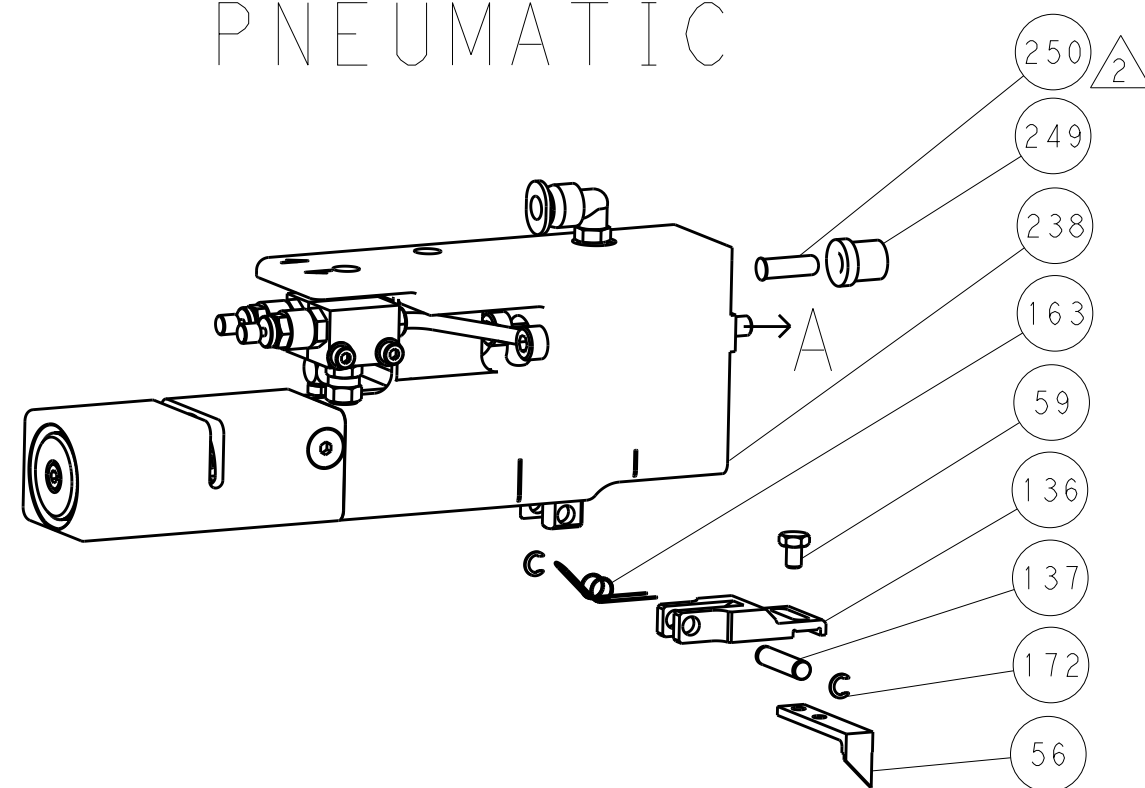
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A

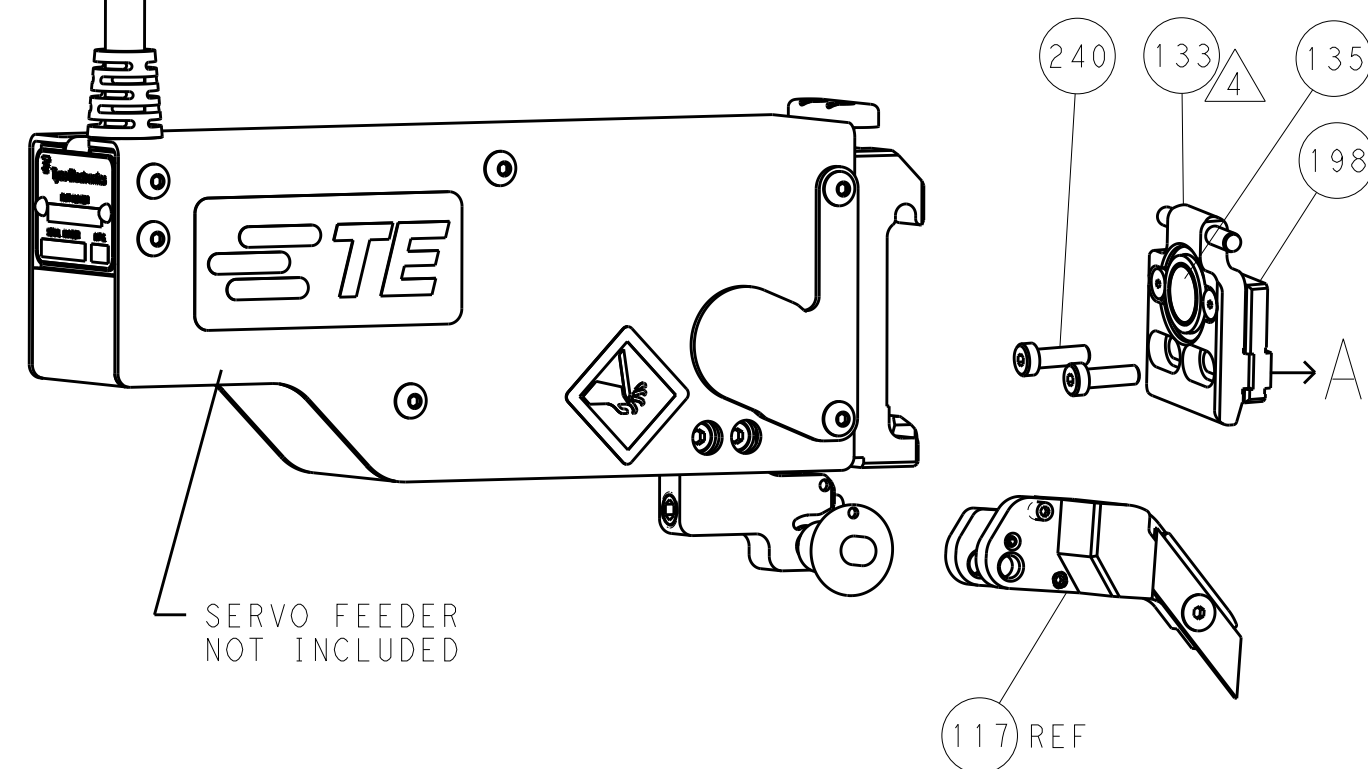
FEED TYPE MECHANICAL



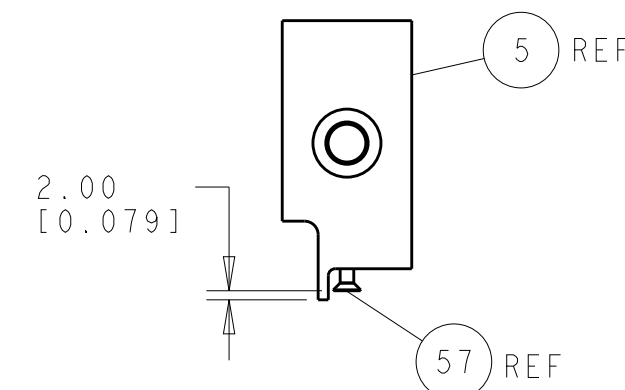
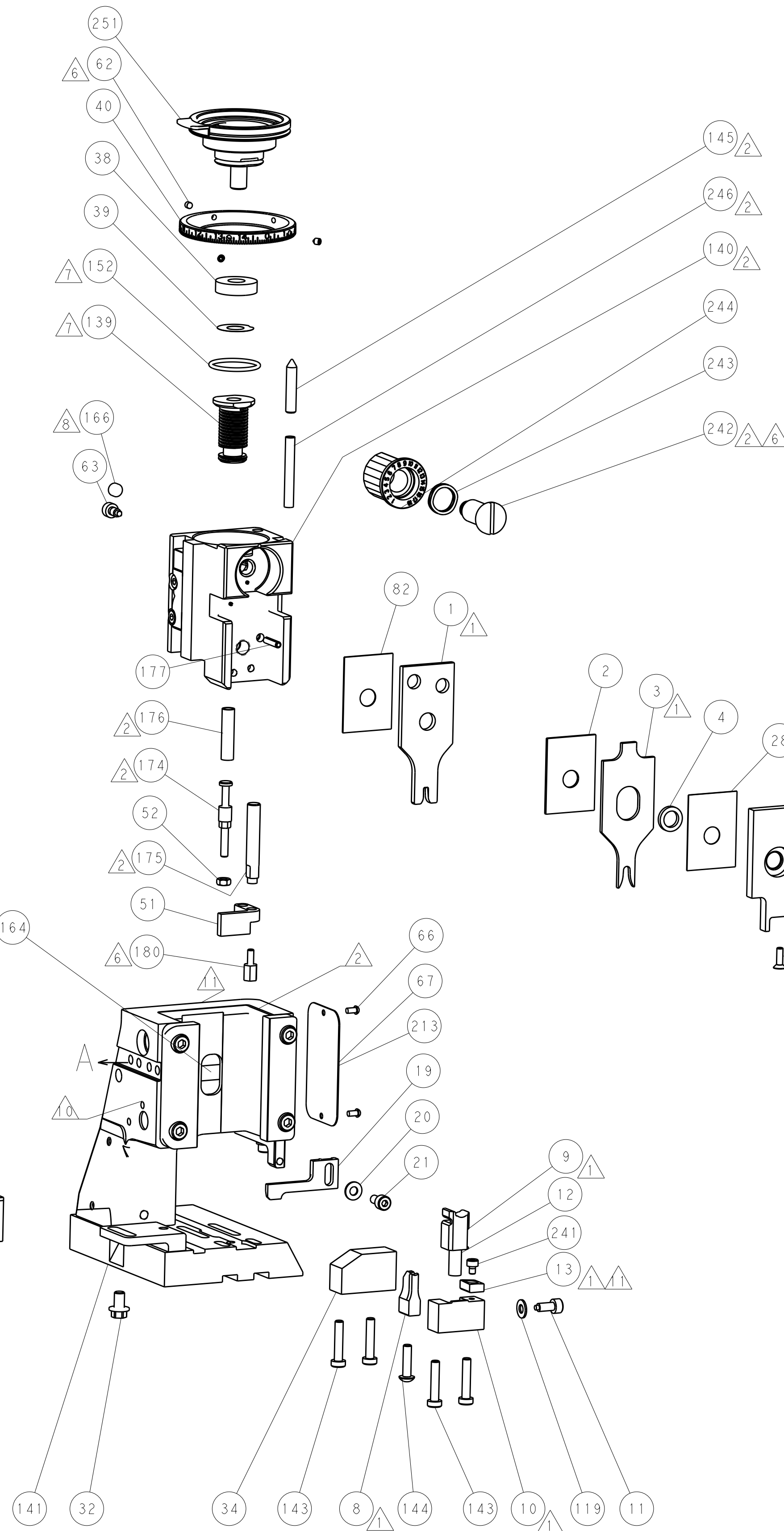
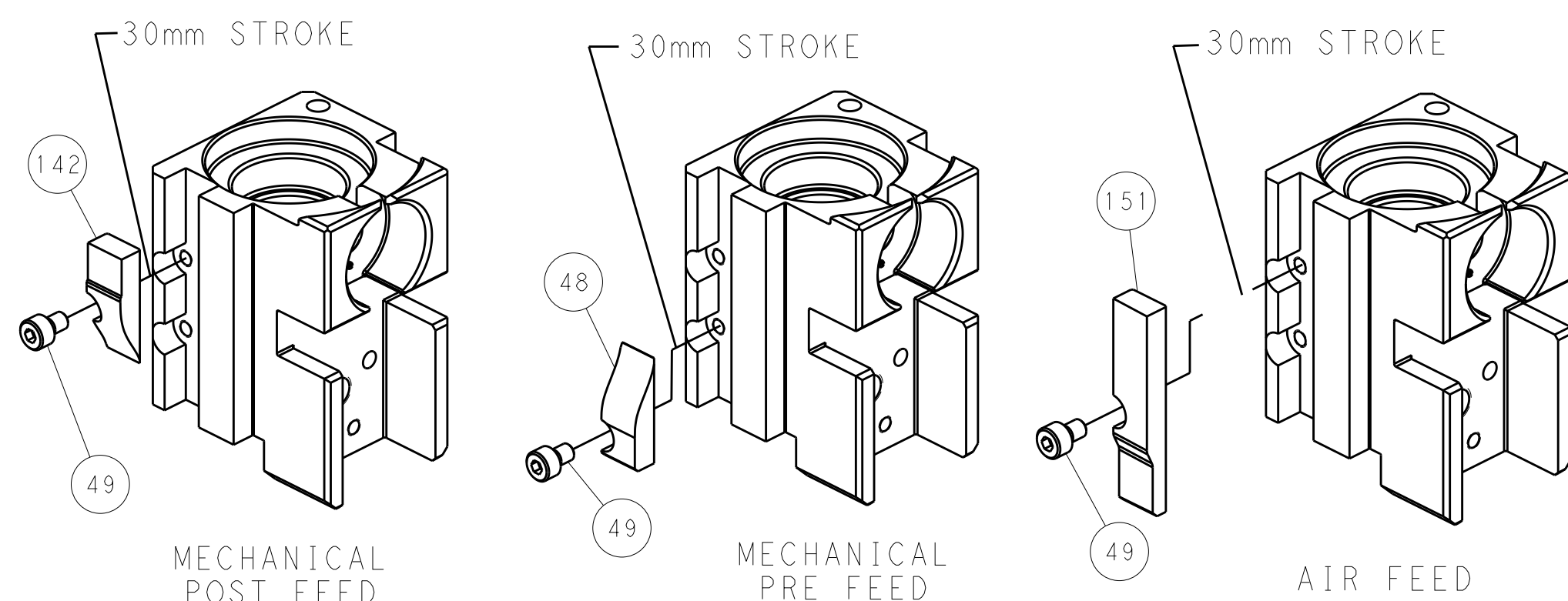
PNEUMATIC



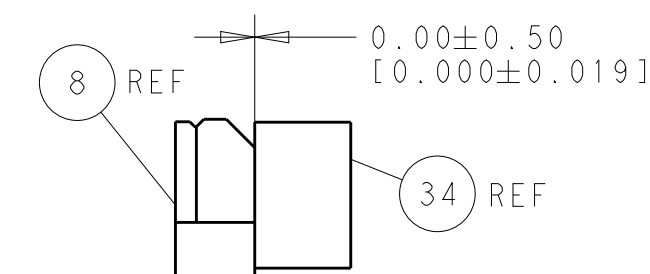
SERVO LATCH PLATE



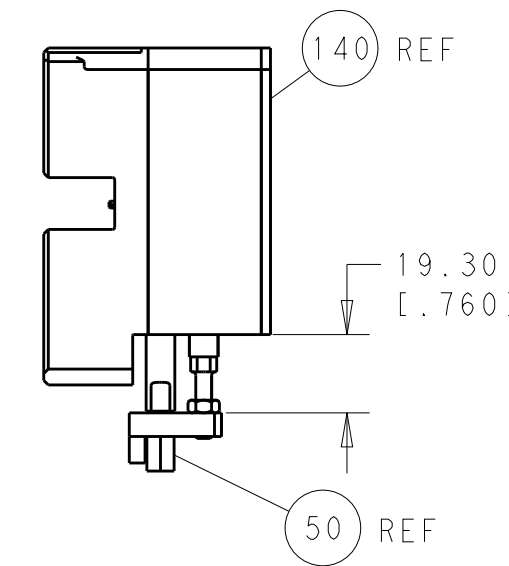
CAM POSITIONS



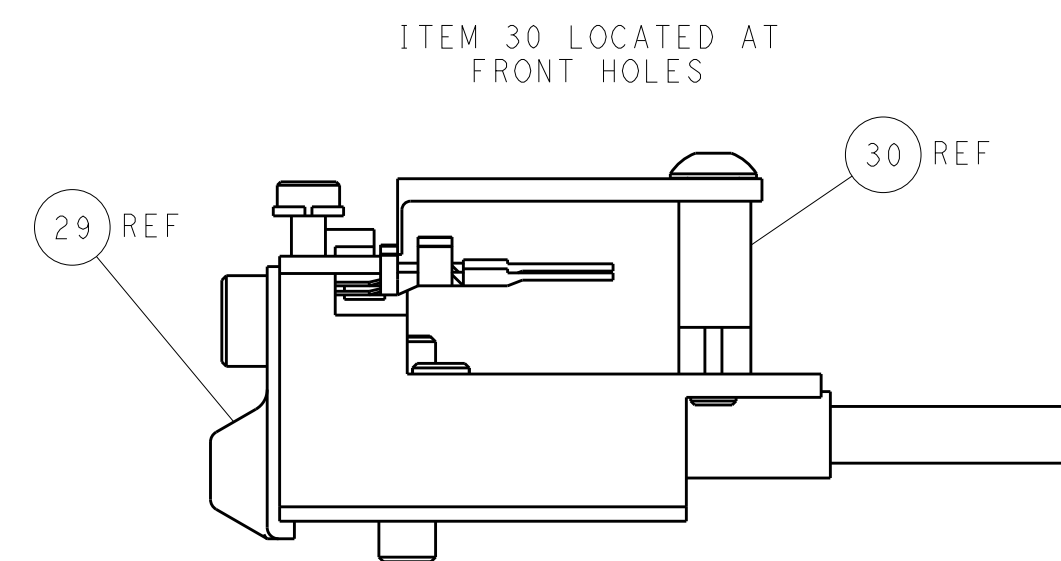
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INS. BARREL

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

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN Y. YIN 24APR2013	CHK G. BAILEY 24APR2013	APVD J. GUO 24APR2013	NAME Ocean Side Feed Applicator	SIZE A1	CAGE CODE 00779	DRAWING NO. C=2151938	RESTRICTED TO -
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		APPLICATION SPEC		WEIGHT	
0 PLC ±.1		1 PLC ±.02		2 PLC ±.02		3 PLC ±.005		4 PLC ±.0005	
ANGLES		FINISH		MATERIAL		Customer Accessible Production Drawing		SCALE 1:1	
						SHEET 4 OF 4		REV A	