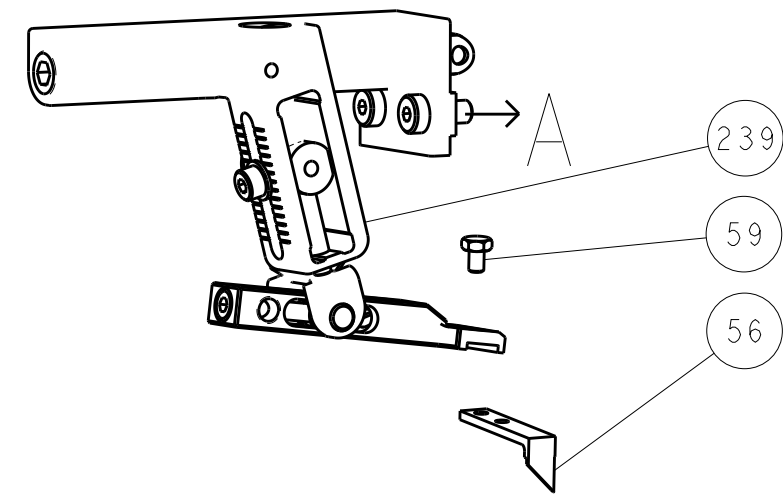
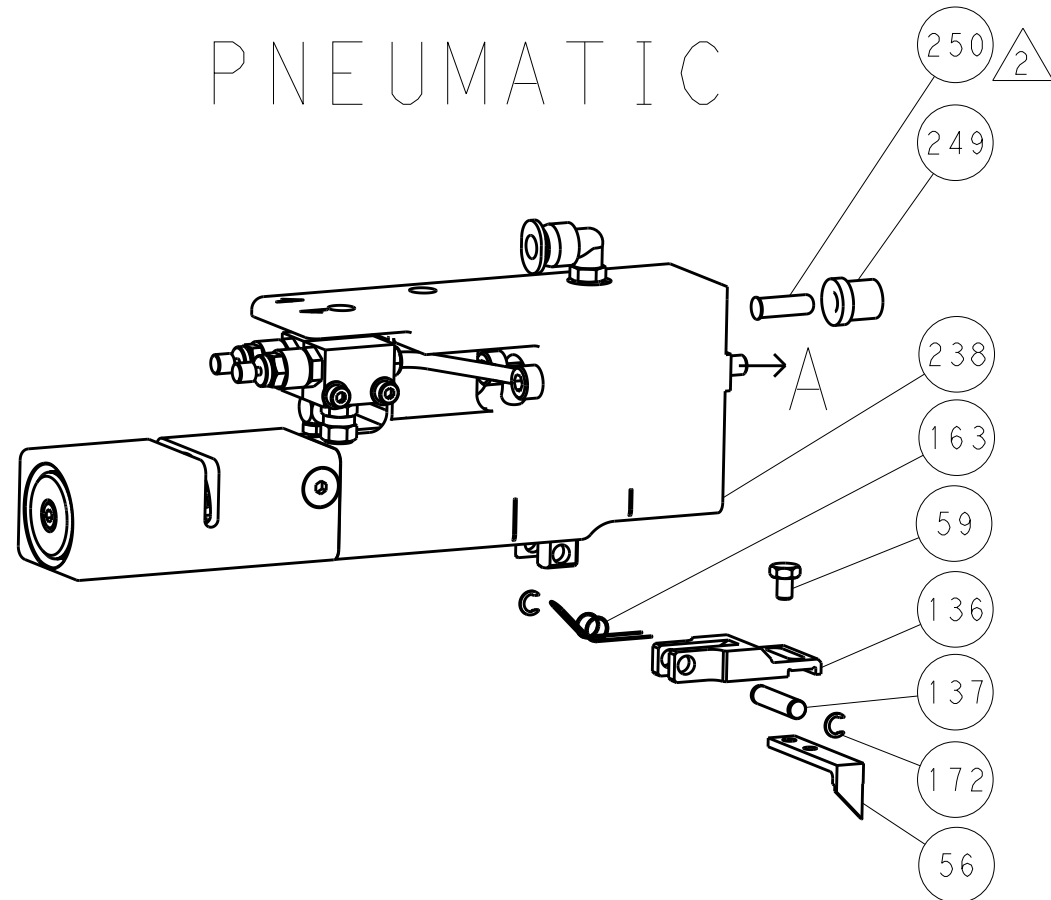


LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

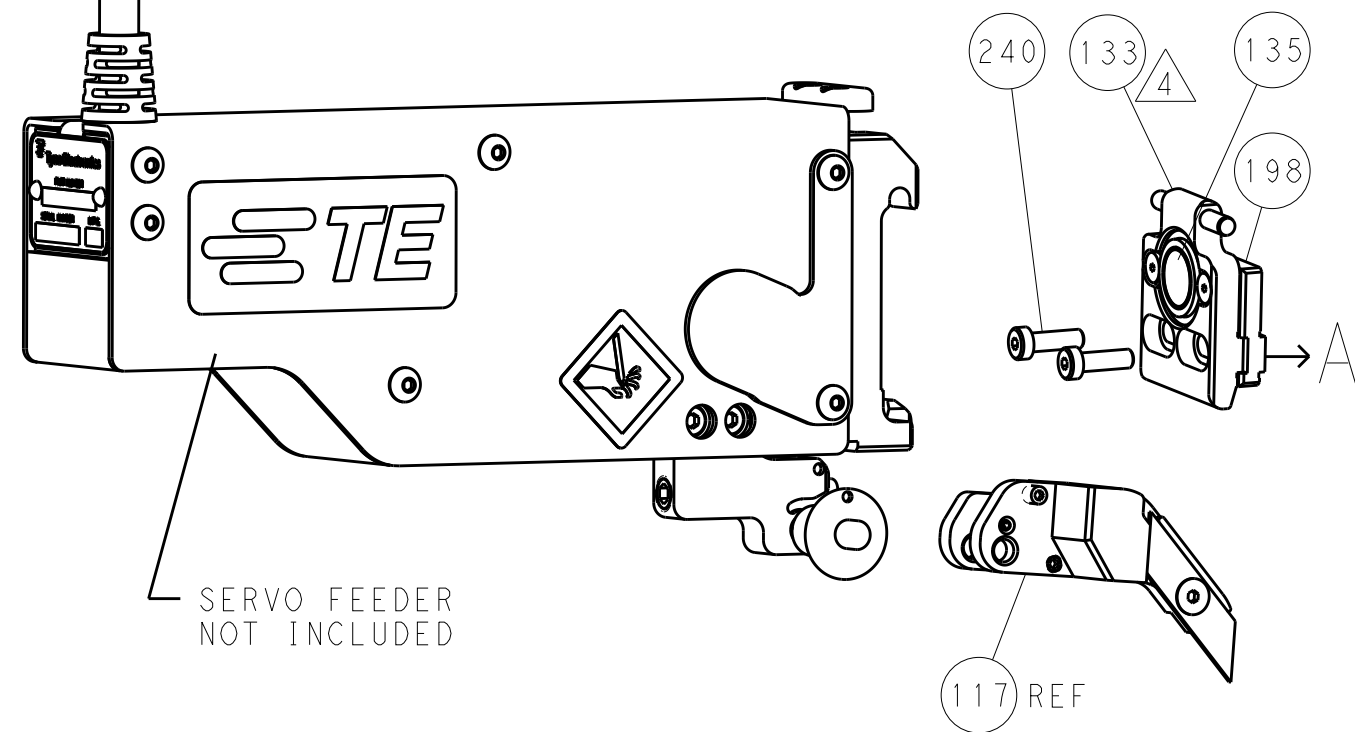
FEED TYPE
MECHANICAL



PNEUMATIC



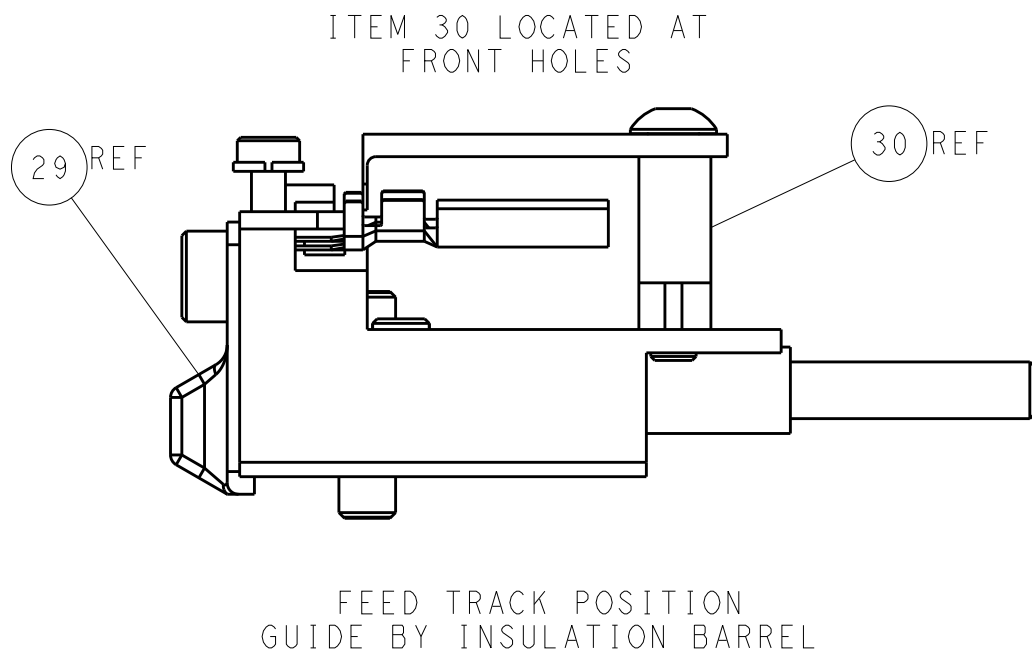
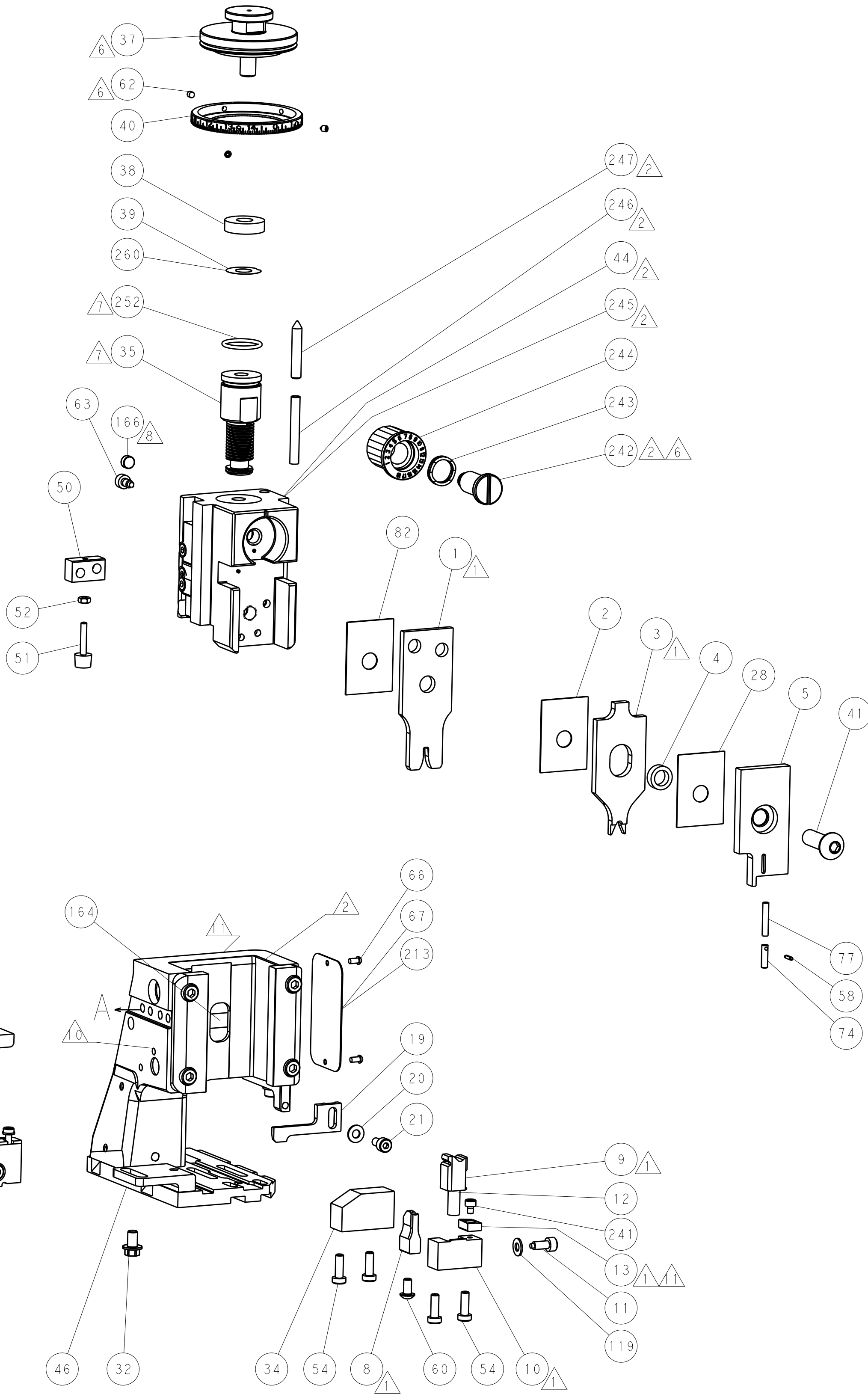
SERVO
LATCH PLATE



CAM POSITIONS



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THIS DRAWING IS UNPUBLISHED.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.				DWN: L. ZHANG 23NOV2012				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:				CHK: L. ZHANG 23NOV2012				NAME: Ocean Side Feed Applicator			
mm				APVD: S. XI 23NOV2012				SIZE: A1			
TOLERANCES UNLESS OTHERWISE SPECIFIED:				PRODUCT SPEC				CAGE CODE: 00779			
0 PLC ±0.1				APPLICATION SPEC				DRAWING NO: 2151731			
1 PLC ±0.1				WEIGHT				SCALE: 1:1			
2 PLC ±0.02				CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SHEET 2 OF 4			
3 PLC ±0.005				RESTRICTED TO				REV B			
4 PLC ±0.0005											
ANGLES ±0.0005											
FINISH											

8

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THIS DRAWING IS UNPUBLISHED.

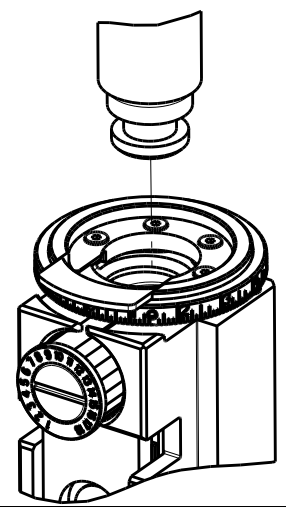
RELEASED FOR PUBLICATION

20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2151731-1

REVISION

B

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2119951-1

-

8-2151731-5

1901094-3

-

2168400-6 (QUANTITY 2)

2161326-1

-

8-2151731-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2151731-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151731-4

-

-

-

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

-

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-

-

-

-

2-2151731-2

B

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

2168400-6 (QUANTITY 2)

2-2151731-5

B

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

-

2-2151731-7

B

FINE CRIMP HEIGHT ADJUST

NONE

-

-

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-

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-

-

7-2151731-7

A

CRIMP TOOLING KIT

-

-

-

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-

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-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.54 mm [.100]

F

INSUL

3.30 mm [.130]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: SOCKET/PIN CONTACT

WIRE STRIP LENGTH

4.7-5.5mm [.185-.216 IN]

INSULATION DIAMETER RANGE

Ø.089-.131 IN [2.26-3.33 mm]

TERMINAL APPLICATION SPECIFICATION

114-13045

-

-

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

776492-1

776492-2

638078-1

638078-3

WIRE SIZE

14 AWG

1.63+/-0.05 [.064+/-0.002]

5.5

16 AWG

1.55+/-0.05 [.061+/-0.002]

6.9

18 AWG

1.37+/-0.05 [.054+/-0.002]

8.4

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: SOCKET/PIN CONTACT

WIRE STRIP LENGTH

4.7-5.5mm [.185-.216 IN]

INSULATION DIAMETER RANGE

Ø.089-.131 IN [2.26-3.33 mm]

TERMINAL APPLICATION SPECIFICATION

114-13045

-

-

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

776493-1

776493-2

776349-1

776349-3

WIRE SIZE

18 AWG

1.32+/-0.000 [.052+/-0.000]

9.0

20 AWG

1.22+/-0.000 [.048+/-0.000]

10.0

1

2

3

4

5

6

7

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100

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: 8-2151731-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151731-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151731-5

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 & 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.

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

-

8-2151731-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151731-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2151731-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151731-4

-

-

-

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

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-

SET UP GAUGE

2119599-1

LOC

A

DIST

66

REVISIONS

REV

LYR

DESCRIPTION

DATE

OWN

APVD

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1

1

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1

1-22279-3

SPRING, COMPRESSION

246

-

1

1

1

1

2119082-9

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

-

-

-

-

-

2119580-1

MECHANICAL FEED ASSEMBLY

239

-

-

-

1

-

2063440-1

AIR FEED MODULE

238

-

-

1

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-

2119740-2

TAG, IDENTIFICATION

213

-

-

1

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-

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

-

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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

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-

2119944-1

FEED FINGER ASSEMBLY, SF

117

-

1

1

1

1

455888-5

SPACER, CRIMPER

82

-

1

1

1

1

22278-8

SPRING, COMPRESSION

77

-

1

1

1

1

854769-4

HOLDER, INS

74

-

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

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

21028-2

PIN, SLOTTED SPRING .062 X .250

58

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-

-

1

1

1338685-1

PAWL, FEED

56

-

2

2

2

2

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

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

18023-9

SCR, SKT HD CAP M4 X 6.0

49

-

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1

2119652-1

FEED CAM, PRE FEED

48

-

1

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2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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1

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1

1

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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1

2119957-1

APPLICATOR SHIM PACK

39

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1-2119644-2

RAM WASHER, PRECISION

38

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1

1

1

1

1752356-6

SUPPORT, TERMINAL

34

-

2

2

2

2

2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

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1

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1

1

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

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1

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1

1

1-1320908-2

SPACER, STRIP GUIDE

30

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2119959-1

ASSEMBLY, STRIP GUIDE

29

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455888-4

SPACER, CRIMPER

28

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1320928-2

STRIP GUIDE

24

-

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2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

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1-18028-2

WASHER, FLAT, REG M4

20

-

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2119533-1

STRIPPER, SIDE FEED

19

-

1

1

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1

2119806-1

INSERT, SHEAR

13

-

1

1

1

1

3-22280-3

SPRING, COMPRESSION

12

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1

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1

1-356885-4

STOP, SHEAR

11

-

1

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1

2119805-1

SHEAR HOLDER, FRONT

10

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1

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1

1803095-1

FLOATING SHEAR, FRONT

9

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1633133-8

ANVIL, COMBINATION .100

8

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1-2119780-1

DEPRESSOR, SHEAR

5

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4-238011-1

BLOCK, CRIMPER SPACER

4

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1-1803019-9

CRIMPER, INSULATION O

3

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455888-5

SPACER, CRIMPER

2

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2-456407-0

CRIMPER, WIRE PREMIUM

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100

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: 8-2151731-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151731-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151731-5

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 & 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.

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

-

8-2151731-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151731-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2151731-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151731-4

-

-

-

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

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SET UP GAUGE

2119599-1

LOC

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DIST

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REVISIONS

REV

LYR

DESCRIPTION

DATE

OWN

APVD

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1

1-22279-3

SPRING, COMPRESSION

246

-

1

1

1

1

2119082-9

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

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1

7-18023-7

SCR, SKT HD CAP M3 X 4.0

241

-

-

2

-

-

2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

-

-

-

-

-

2119580-1

MECHANICAL FEED ASSEMBLY

239

-

-

-

1

-

2063440-1

AIR FEED MODULE

238

-

-

1

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-

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

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-

-

1

-

2119641-2

FEED CAM, AIR FEED

151

-

1

1

1

1</

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

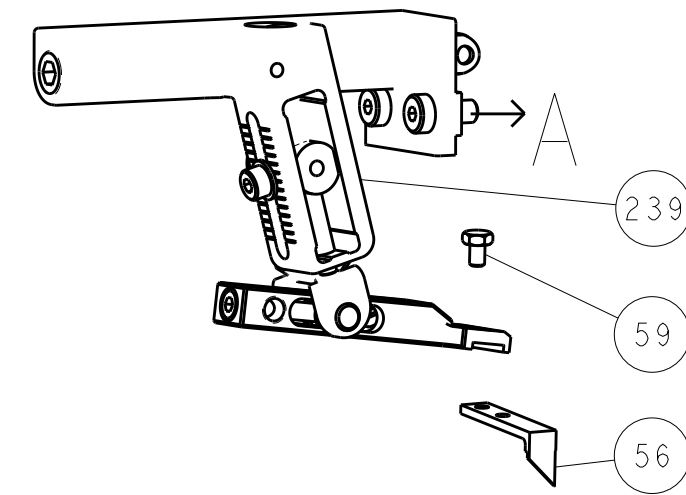
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

C

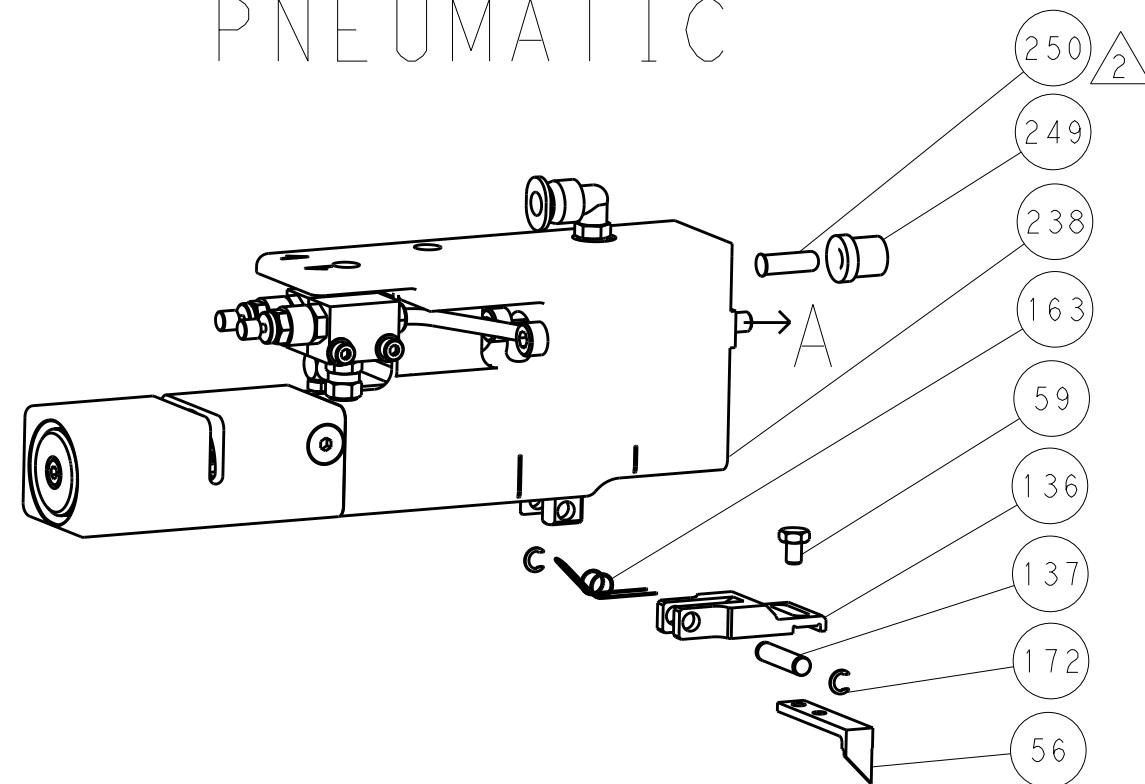
B

A

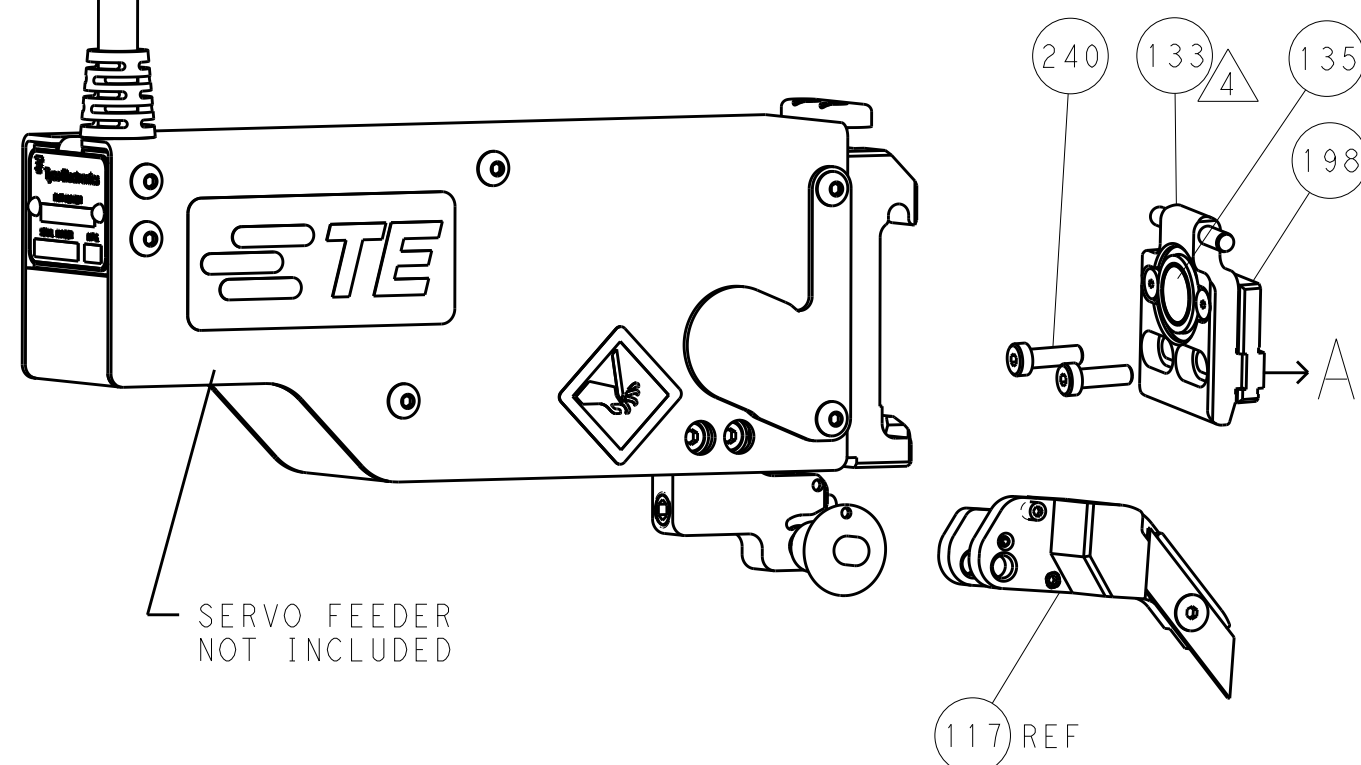
FEED TYPE MECHANICAL



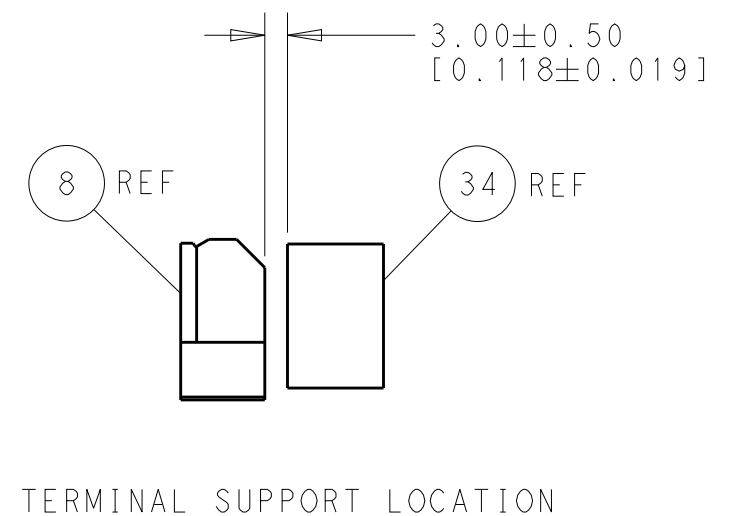
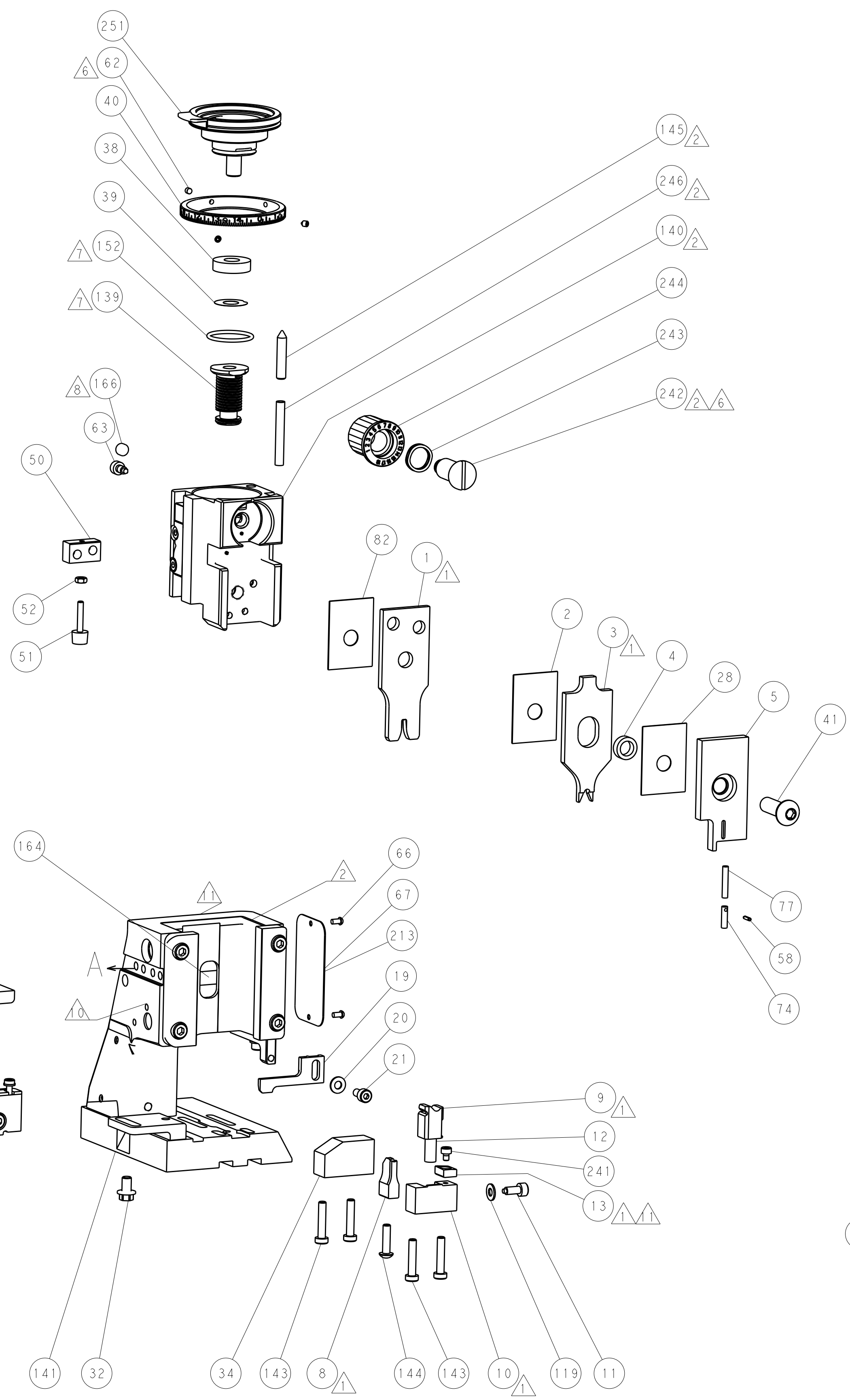
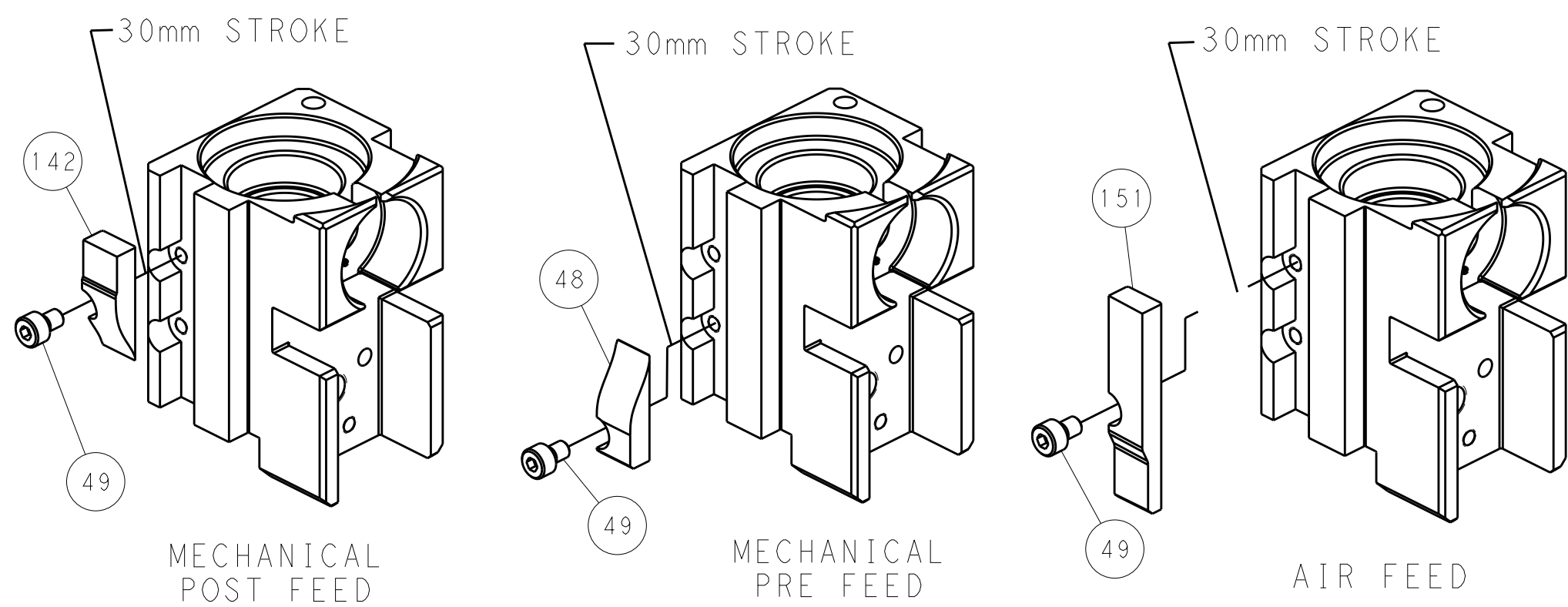
PNEUMATIC



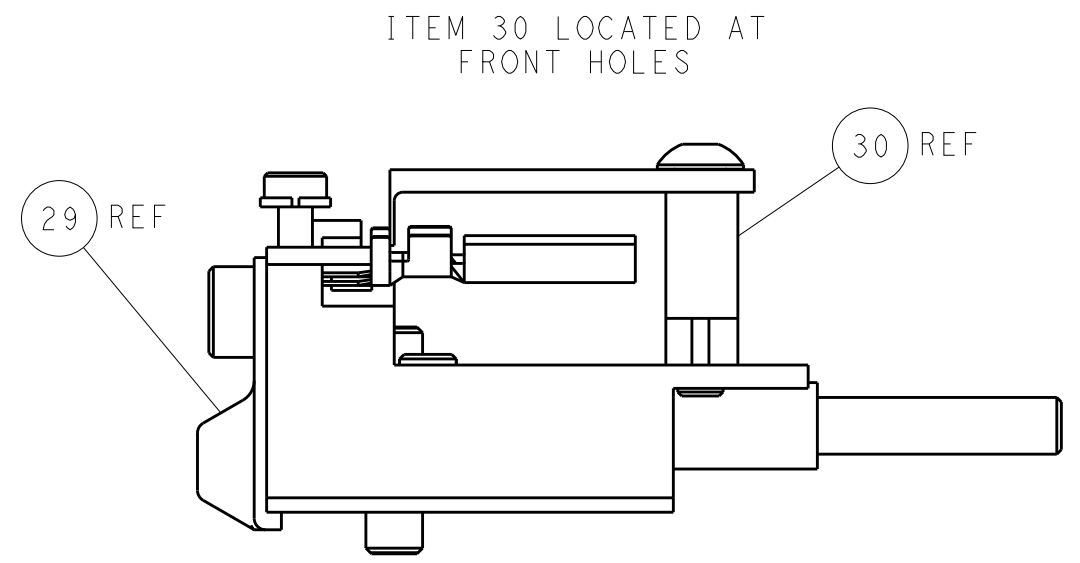
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN L. ZHANG 23NOV2012		CHK L. ZHANG 23NOV2012		NAME Ocean Side Feed Applicator	
0 PLC ±0.1		1 PLC ±0.1		2 PLC ±0.02		3 PLC ±0.005		4 PLC ±0.0005	
MATERIAL		FINISH		WEIGHT		SIZE A1		CAGE CODE 00779	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:1		SHEET 4		OF 4		REV B	