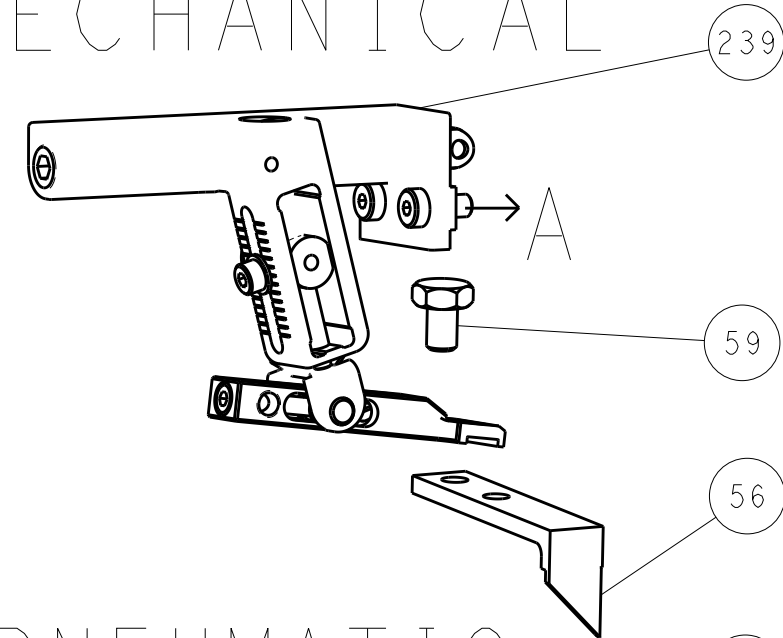
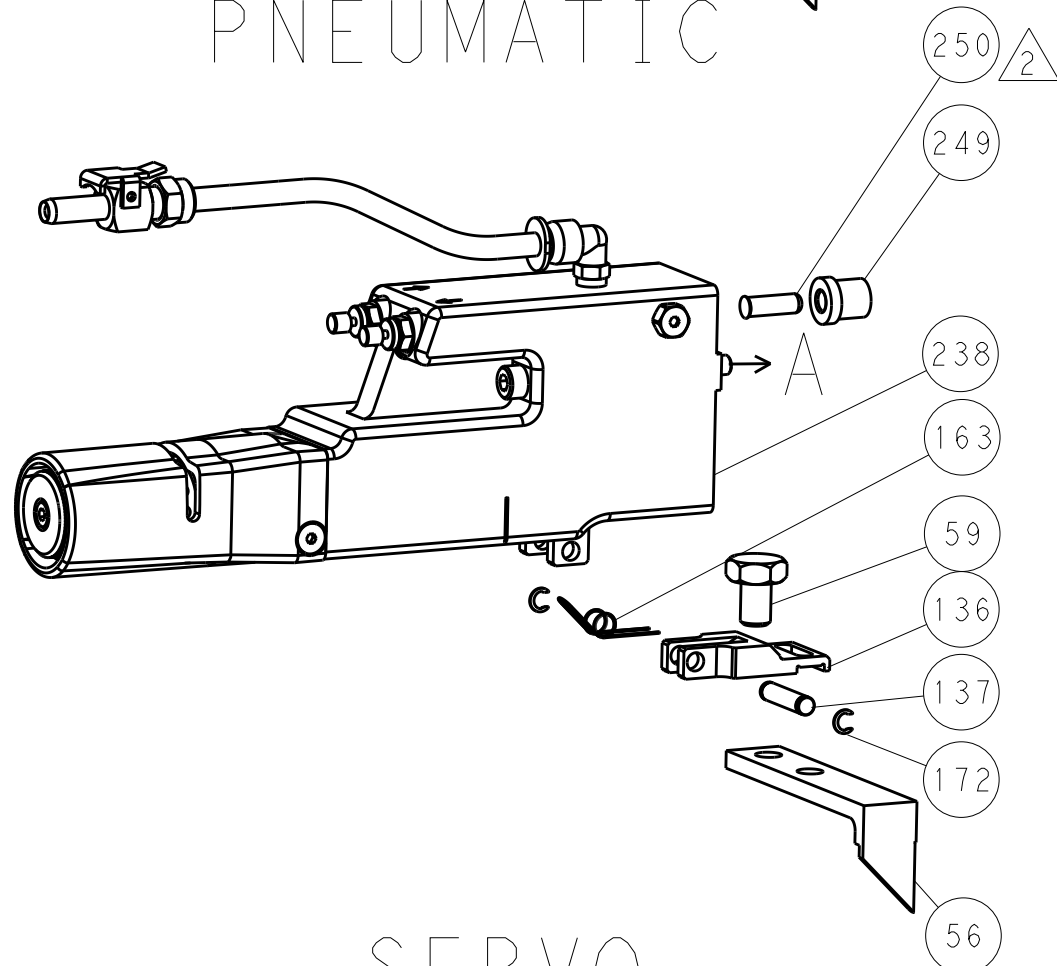


LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

FEED TYPE
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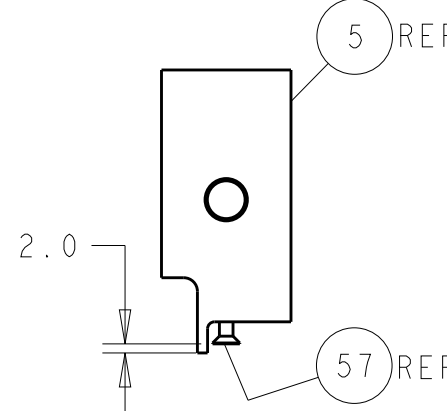
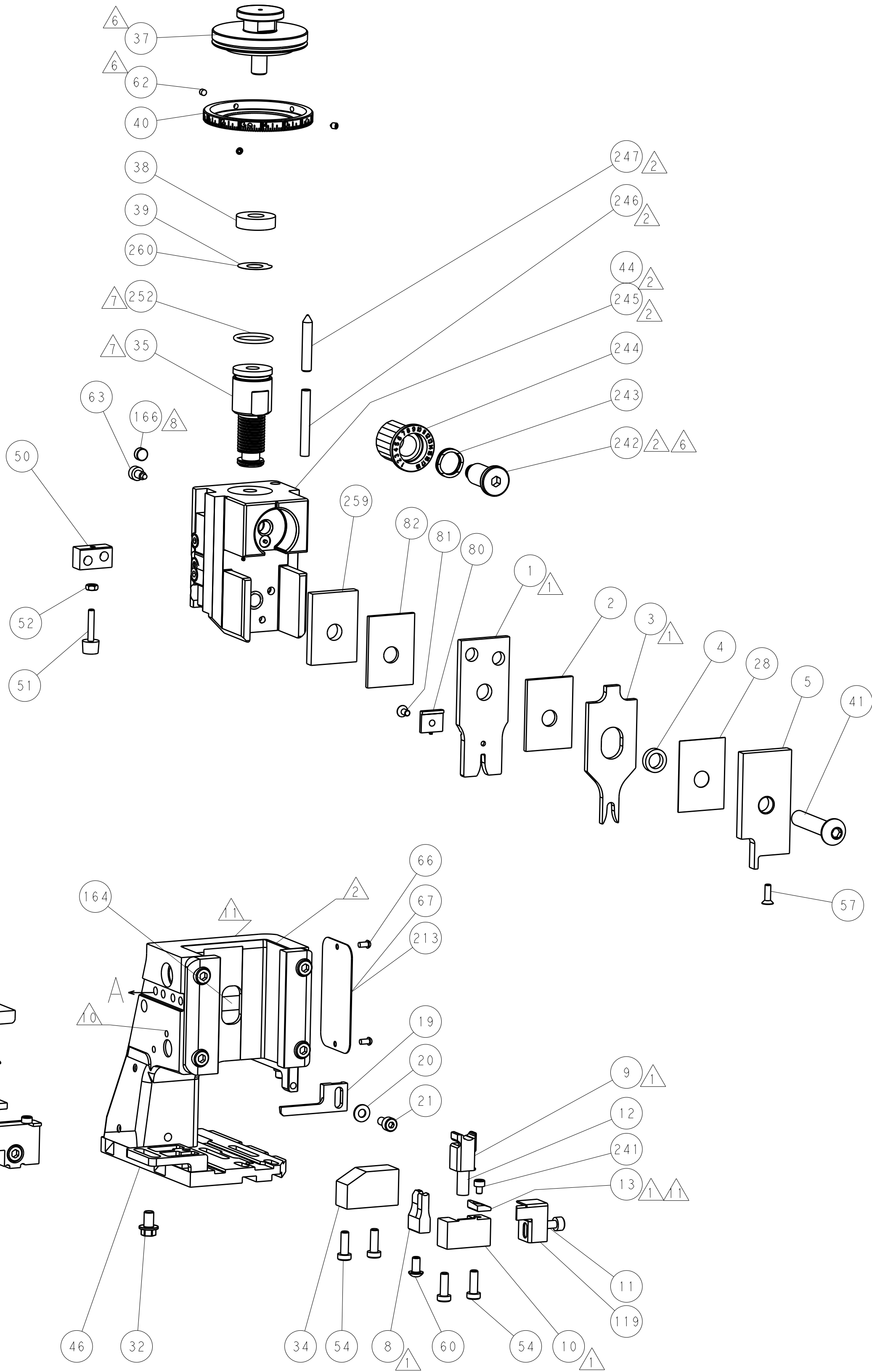
PNEUMATIC



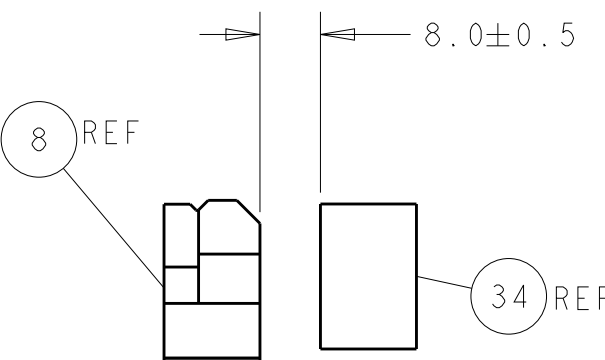
SERVO
LATCH PLATE



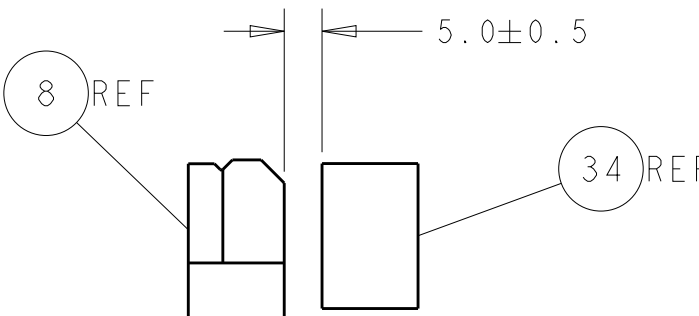
CAM POSITIONS



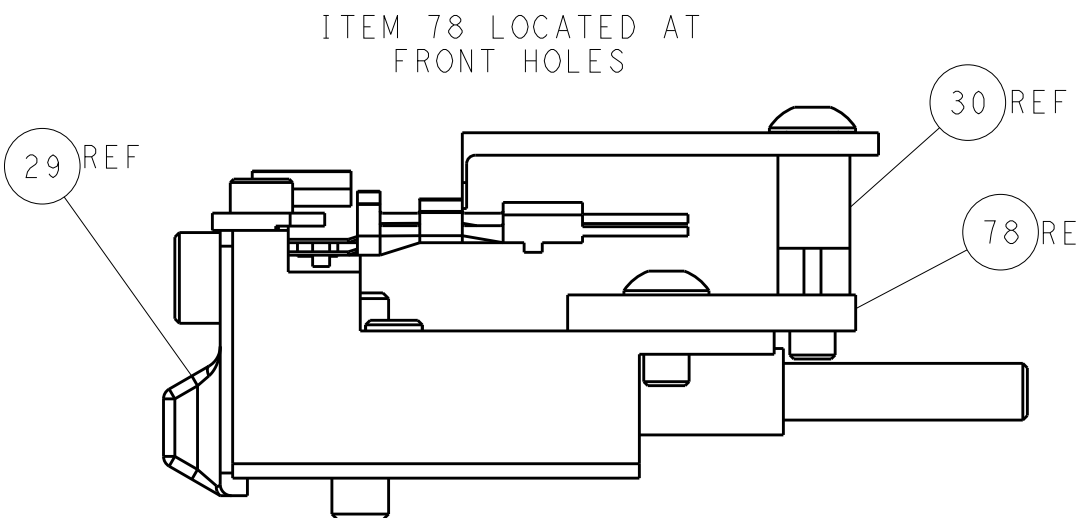
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION FOR
BLADE TERMINAL P/N 1326031-8



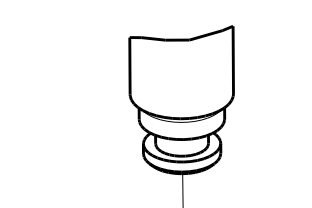
TERMINAL SUPPORT LOCATION FOR
RECEPTACLE TERMINAL P/N 1326032-9



FEED TRACK POSITION
GUIDE BY WIRE 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THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE CONTACTED FOR THE LATEST REVISION.		DWN	YIN	25JUL2012	TE Connectivity		
		CHK	G. BAILEY	25JUL2012	Harrisburg, PA 17105-3608		
		APVD	S. XI	25JUL2012	NAME Ocean Side Feed Applicator -		
		PRODUCT SPEC					
		APPLICATION SPEC					
		WEIGHT		SIZE			
				A1 00779 ©=2151730			
		Customer Accessible Production Drawing		SCALE			
				1:1 SHEET 2 OF 4 REV D			

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151730-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151730-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151730-4	-	-	-
	2-2151730-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151730-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151730-4	-	-	-
	2-2151730-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 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
					-	-	-	-	-	-	-
	2-2151730-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2151730-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.25 mm [.167]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8mm BLADE, SEALED			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
5.50-5.51 mm [.217-.217 IN]			Ø1.20-2.70 mm [.047-.106 IN]
TERMINAL APPLICATION SPECIFICATION		114-13013	-
		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL PN	YAZAKI PN
1326031-8	1326032-9	1949064-1	7158-3113-40
		1949064-2	7158-3112-70

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁴
18 AWG		1.37+/-0.05 [.054+/- .002]		4.1
1.00mm2		1.30+/-0.05 [.051+/- .002]		4.9
0.75mm2		1.22+/-0.05 [.048+/- .002]		6.0



- 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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151730-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151730-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151730-5
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 ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.
- 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.

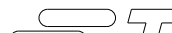
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	1	2-455888-9	SPACER, CRIMPER	259
-	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	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-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	DIS 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	DWN	APVD
				-	SEE SHEET 1	-	-	-

⁶	-	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
	-	-	-	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	2161312-1	RAM, STEPPED, 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	318563-1	GUARD, FRONT CHIP	119
	-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
	-	1	1	1	1	1-455888-7	SPACER, CRIMPER	82
	-	1	1	1	1	985575-1	SCR, FLT SKT HD CAP M3 X 6.0	81
	-	1	1	1	1	224405-2	DEPRESSOR, WIRE	80
	-	2	2	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79
	-	1	1	1	1	1633470-2	EXTENSION PLATE	78
	-	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
	-	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
	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	1	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	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	2-1752356-0	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	1-1320908-5	SPACER, STRIP GUIDE	30
	-	1	1	1	1	2119959-4	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-3	SPACER, CRIMPER	28
	-	1	1	1	1	240792-2	DRAG, TERMINAL	25
	-	1	1	1	1	1320928-6	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	2119533-2	STRIPPER, SIDE FEED	19
¹	-	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	1-1633927-6	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
	-	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
¹	1	1	1	1	1	6-2119784-2	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	1-455888-9	SPACER, CRIMPER	2
	¹	1	1	1	1	1-856313-7	CRIMPER, WIRE	1
	-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ELECTRONIC CORPORATION IT IS SUBJECT TO CHANGE AND TO THE TERMS AND CONDITIONS OF THE DRAWING. NO PART OF THIS DRAWING SHOULD BE COPIED FOR THE LATEST EDITION.				DWN T.YIN	25JUL2012	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK G.BAILEY	25JUL2012				
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S.XI	25JUL2012	NAME		Ocean Side Feed Applicator	
		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		PRODUCT SPEC -		SIZE		CASE CODE	
MATERIAL -		FINISH -		APPLICATION SPEC -		DRAWING NO		RESTRICTED TO	
				WEIGHT -		A1 00779 C=2151730		-	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 3 OF 4		REV D	

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

D

C

B

A

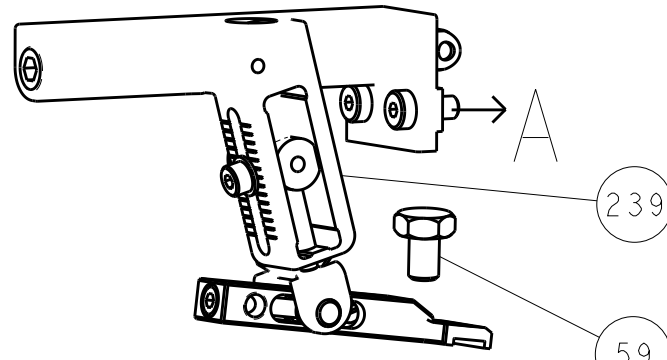
D

C

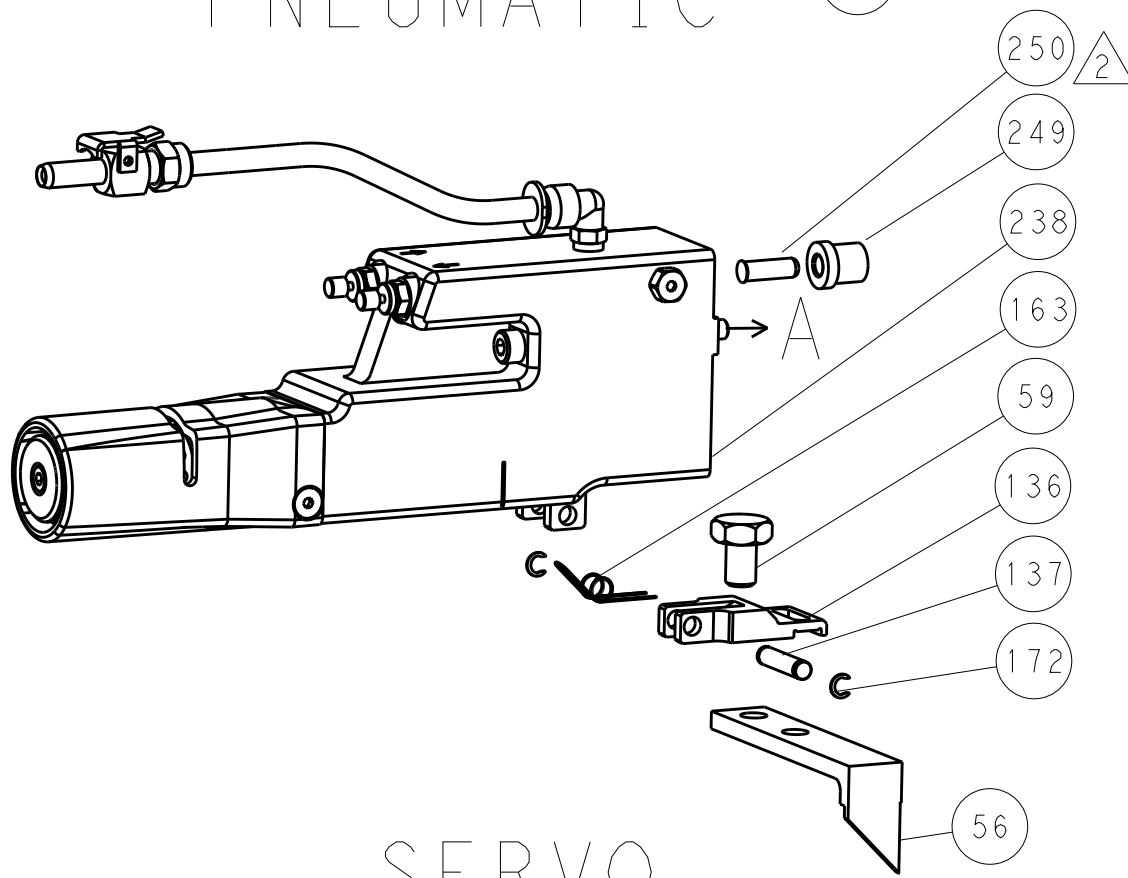
B

A

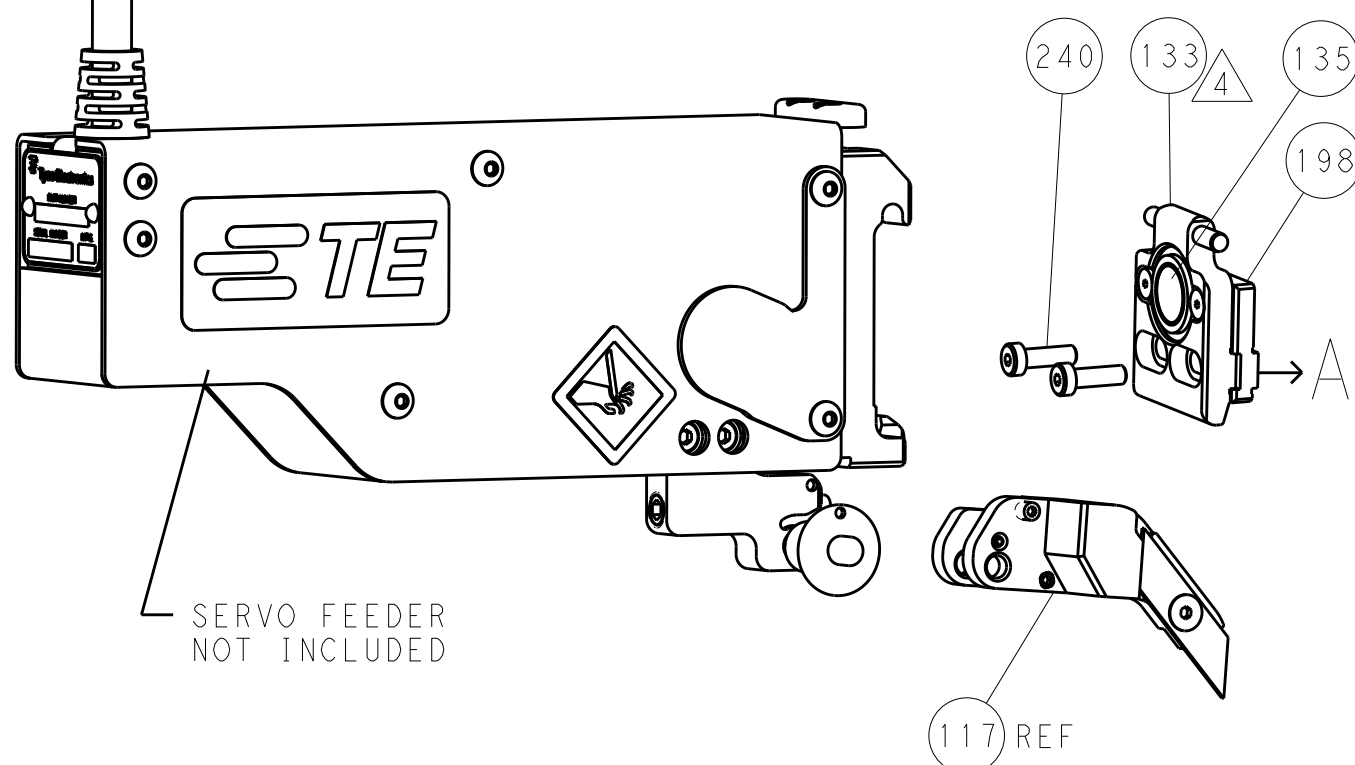
FEED TYPE MECHANICAL



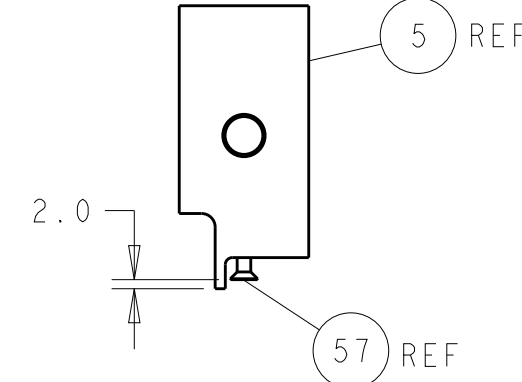
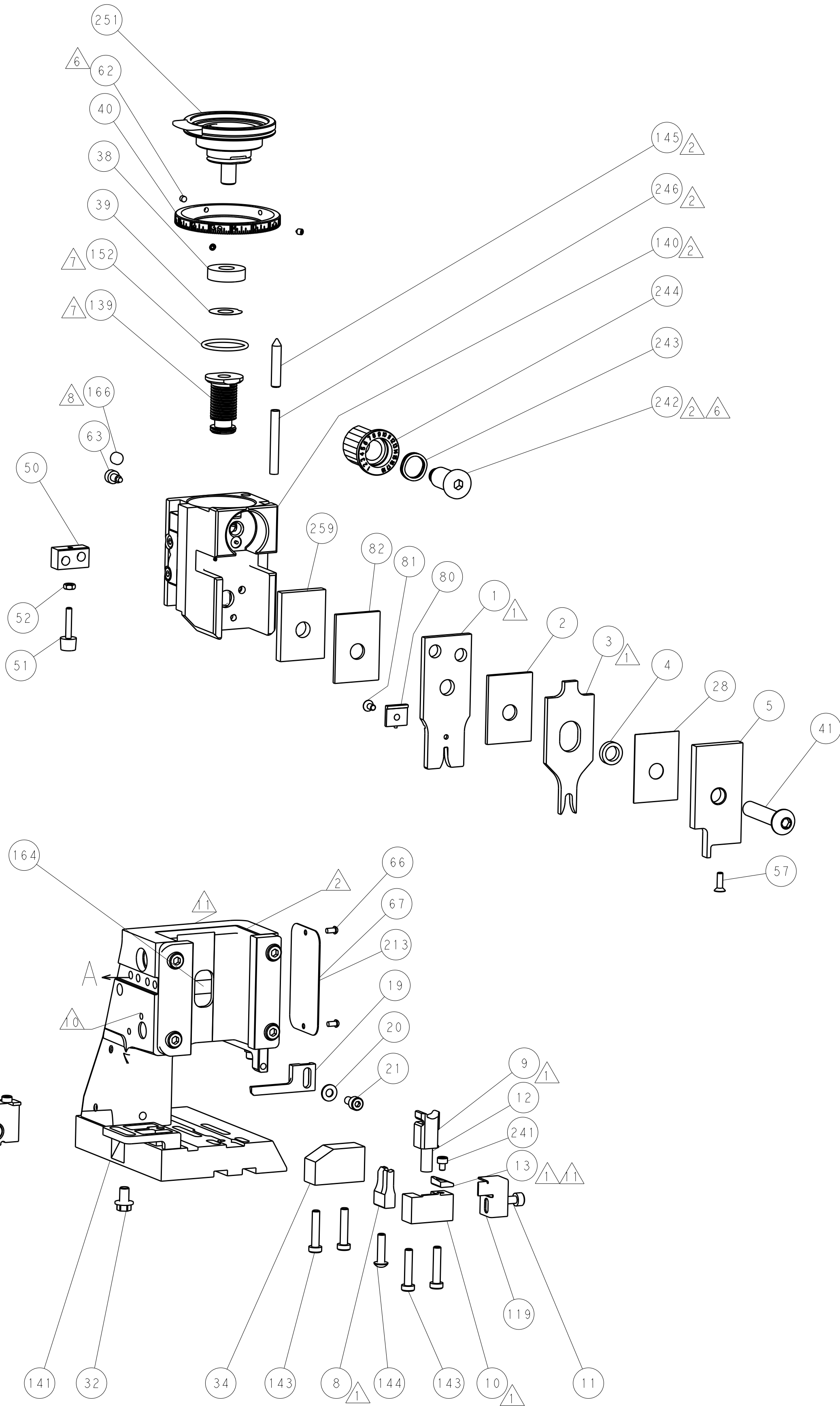
PNEUMATIC



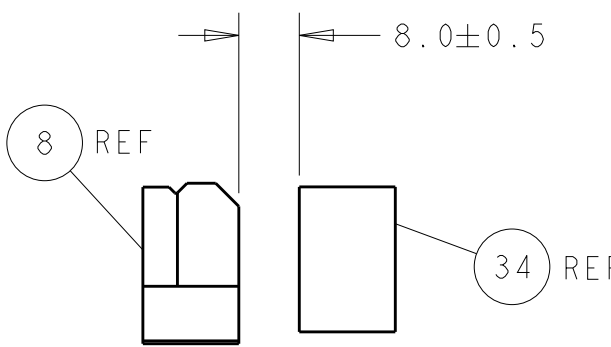
SERVO LATCH PLATE



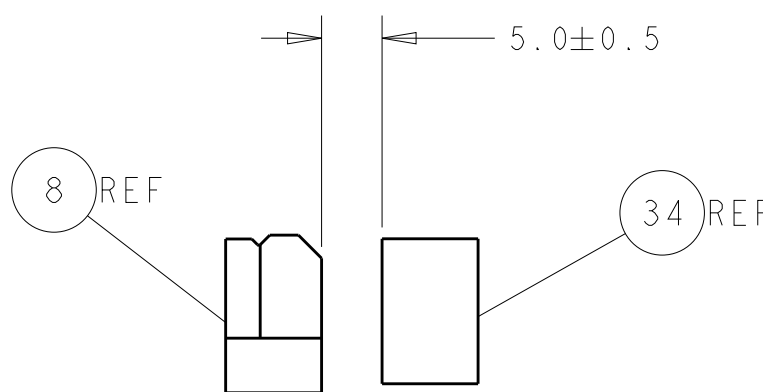
CAM POSITIONS



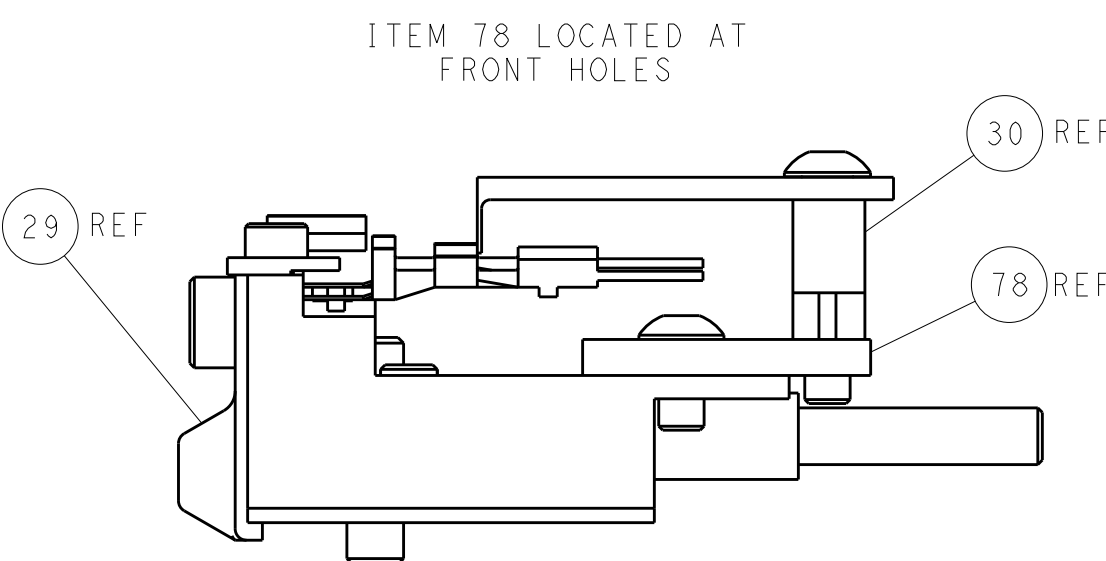
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION FOR
BLADE TERMINAL P/N 1326031-8



TERMINAL SUPPORT LOCATION FOR
RECEPTACLE TERMINAL P/N 1326032-9



FEED TRACK POSITION
GUIDE BY WIRE BARREL

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 Y. YIN 25JUL2012		CHK G. BAILEY 25JUL2012		APVD S. XI 25JUL2012		NAME	
mm		0 PLC ±		PRODUCT SPEC		APPLICATION SPEC		SIZE		CAGE CODE	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE		SHEET	
								1:1		4 OF 4	
										REV	