

THIS DRAWING IS A CONTROLLED DOCUMENT FOR VETO ENGINEERING CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION MAY BE DIFFERENT FROM THE ONE IN YOUR POSSESSION		DWN 040C2011 CHK HOFFNER EFLBIN 050C2011 AVD EFLBIN 050C2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ±.01 1 PLC ±.01 2 PLC ±.01 3 PLC ±.01 4 PLC ±.01 ANGLES ±.1°		Ocean Side Feed Applicator	
		PRODUCT SPEC		SIZE	
		APPLICATION SPEC		CAGE CODE	
MATERIAL		FINISH		DRAWING NO	
-		-		A1 00779 C=2151018	
		WEIGHT		RESTRICTED TO	
		-		-	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 OF 4 REV H	

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1

THIS DRAWING IS UNPUBLISHED.

RELEASED FOR PUBLICATION

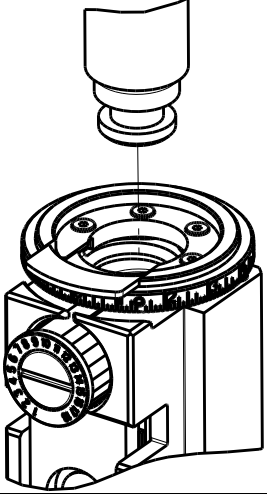
20

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2151018-1

REVISION

H

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

SERVO LATCH PLATE

2119951-1

-

8-2151018-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151018-4

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2151018-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151018-4

-

-

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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2-2151018-2

H

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-2

-

-

SERVO LATCH PLATE

2119951-1

-

8-2151018-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

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8-2151018-4

-

-

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5-18022-5

2119653-2

-

-

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-2

2119799-1

2063440-1

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2-2151018-5

H

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE

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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2-2151018-7

H

FINE CRIMP HEIGHT ADJUST

NONE

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7-2151018-7

B

CRIMP TOOLING KIT

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.29 mm [.090]

F

INSUL

2.79 mm [.110]

F

APPLICATOR INSTRUCTIONS

408-10389



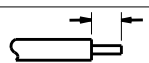
TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: "L" SIZE DYNAMIC D-3 TAB CONTACT

WIRE STRIP LENGTH

3.80-4.80 mm [.150-.189 IN]



INSULATION DIAMETER RANGE

Ø1.80-2.80 mm [.071-.110 IN]

TERMINAL APPLICATION SPECIFICATION

114-5148

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TERMINALS APPLIED



TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

175286-2

5-175286-5

1-175196-3

5-175196-3

175286-3

6-175286-2

1-175196-4

6-175196-2

175286-5

6-175286-3

1-175196-5

6-175196-3

1-175286-2

175196-2

2-175196-4

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1-175286-3

175196-3

2-175196-5

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5-175286-2

175196-4

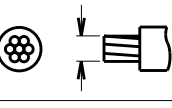
3-175196-4

5-175286-3

1-175196-2

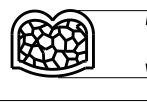
5-175196-2

WIRE SIZE



CRIMP HEIGHT

mm [INCH]



CRIMP HEIGHT

REFERENCE SETTING



16 AWG

1.46+/-0.05 [.057+/- .002]

6.0

18 AWG

1.30+/-0.05 [.051+/- .002]

7.7

20 AWG

1.18+/-0.05 [.046+/- .002]

8.8



 RECOMMENDED SPARE PARTS

 GREASE BEARING SURFACES LIGHTLY

3. 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: 8-2151018-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151018-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151018-5

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.

 TERMINAL LUBRICANT IS RECOMMENDED.

-

1

1

1

1

2119782-1

FINE ADJUST HEAD ASM, PACIFIC STYLE

251

-

-

-

1

-

2119640-1

PUSH ROD, AIR FEED

250

-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

OWN

APVD

-

-

SEE SHEET 1

-

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2079988-1

BUSHING, LCH5-12, MISUMI

249

-

1

1

1

1

1-22279-3

SPRING, COMPRESSION

246

-

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

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1

1

1

1

7-18023-7

SCR, SKT HD CAP M3 X 4.0

241

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-

2

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-

2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

-

-

-

-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

-

-

-

1

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2063440-1

AIR FEED MODULE

238

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1

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2119740-2

TAG,IDENTIFICATION

213

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1901094-3

SPACER, FEEDER

198

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2

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21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

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1

1

1

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

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1

-

240638-1

SPRING, FEED FINGER

163

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1

1

1

1

8-21084-1

O-RING, .801 ID, .070 DIA. MAT.

152

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1

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2119641-2

FEED CAM, AIR FEED

151

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2119798-2

DETENT PIN

145

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1

2079383-8

SCR, BHSC, RoHS (M4 X 16)

144

-

4

4

4

4

2168400-5

SHCS, LOW HEAD, RoHS, M4 X 20

143

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-

1

2119653-2

FEED CAM, POST FEED

142

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1

1

1

1

1-2119656-0

APPLICATOR BASIC ASSEMBLY, SF

141

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1

1

1

1

2119650-1

RAM, ASIAN STYLE, SIDE FEED

140

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1

1

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1

2119092-2

BOLT, ADJUSTMENT

139

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1

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3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

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1

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2119799-1

HOLDER,FEED FINGER, AF

136

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REF

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SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

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1

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1633743-1

SERVO FEED LATCH ASM

133

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1

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1

1

1-18028-2

WASHER, FLAT, REG M4

119

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REF

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2119944-1

FEED FINGER ASSEMBLY,SF

117

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1

1

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2119955-1

ASSY, LUBRICATOR, SIDE FEED

113

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1

1

1

1

455888-6

SPACER, CRIMPER

82

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1

1

1

1

5-547505-2

SPRING, COMPRESSION

77

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1

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1

854769-4

HOLDER, INS

74

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2119956-1

DOCUMENTATION PACKAGE

71

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1

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1

1

2119740-1

TAG,IDENTIFICATION

67

-

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

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1

1

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

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3

3

3

3

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

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1

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

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21028-2

PIN, SLOTTED SPRING .062 X .250

58

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1

1

1338685-1

PAWL, FEED

56

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2

2

2

2

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

53

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5018030-1

NUT, HEX, REG, RoHS, M3

52

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1

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811242-5

BUMPER, HOLD DOWN

51

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1

1

1

1

690753-2

SPACER, TONKER

50

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-

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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

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1

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2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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1

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2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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2119957-1

APPLICATOR SHIM PACK

39

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1-2119644-2

RAM WASHER, PRECISION

38

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1

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1

1752356-1

SUPPORT, TERMINAL

34

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2

2

2

2

2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

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1

1

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2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

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1

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1

1

1-1320908-0

SPACER, STRIP GUIDE

30

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1

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2119959-1

ASSEMBLY, STRIP GUIDE

29

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455888-3

SPACER, CRIMPER

28

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1

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

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1

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2119806-1

INSERT, SHEAR

13

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1

1

1

1

3-22280-3

SPRING, COMPRESSION

12

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1

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1-356885-5

STOP, SHEAR

11

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1

1

1

1

2119805-1

SHEAR HOLDER, FRONT

10

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1

1

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1

1803095-1

FLOATING SHEAR, FRONT

9

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1

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4-1333205-8

ANVIL, COMBINATION

8

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1-2119780-3

DEPRESSOR, SHEAR

5

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238011-4

BLOCK, CRIMPER SPACER

4

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2119582-2

CRIMPER, INSULATION F PREMIUM

3

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455888-1

SPACER, CRIMPER

2

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1

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1

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1

5-456406-6

CRIMPER, WIRE PREMIUM

1

-77

-27

-25

-22

-21

PART NO

DESCRIPTION

ITEM NO

THE DIMENSIONS TO BE COMPLETED BY THE USER SHALL BE THE DIMENSIONS OF THE PARTS TO BE USED IN THE ASSEMBLY. IT IS THE USER'S RESPONSIBILITY TO OBTAIN THE DIMENSIONS OF THE PARTS TO BE USED IN THE ASSEMBLY. IT IS THE USER'S RESPONSIBILITY TO OBTAIN THE DIMENSIONS OF THE PARTS TO BE USED IN THE ASSEMBLY.

OWN

04OCT2011

CHK

05OCT2011

T.ELBIN

05OCT2011

APVD

05OCT2011

T.ELBIN

05OCT2011

NAME

Ocean Side Feed

Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2151018

-

Customer Accessible Production Drawing

SCALE

1:2

SHEET

3

OF

4

REV

H

8

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4

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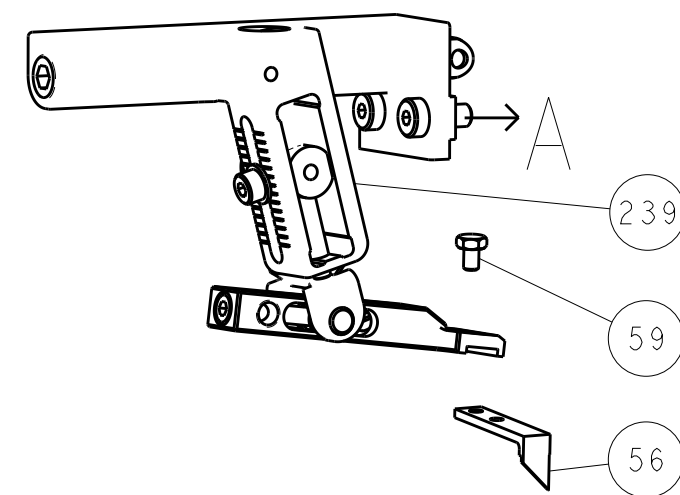
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AMP 4805 REV 31MAR2000

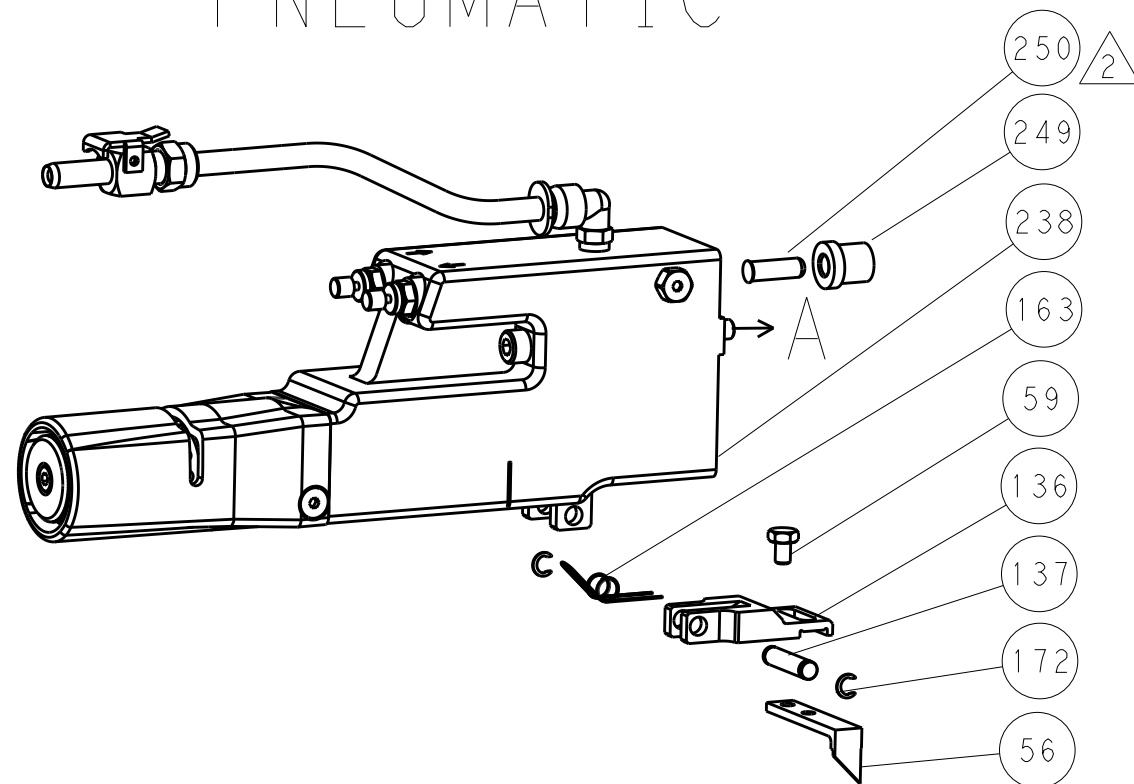
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

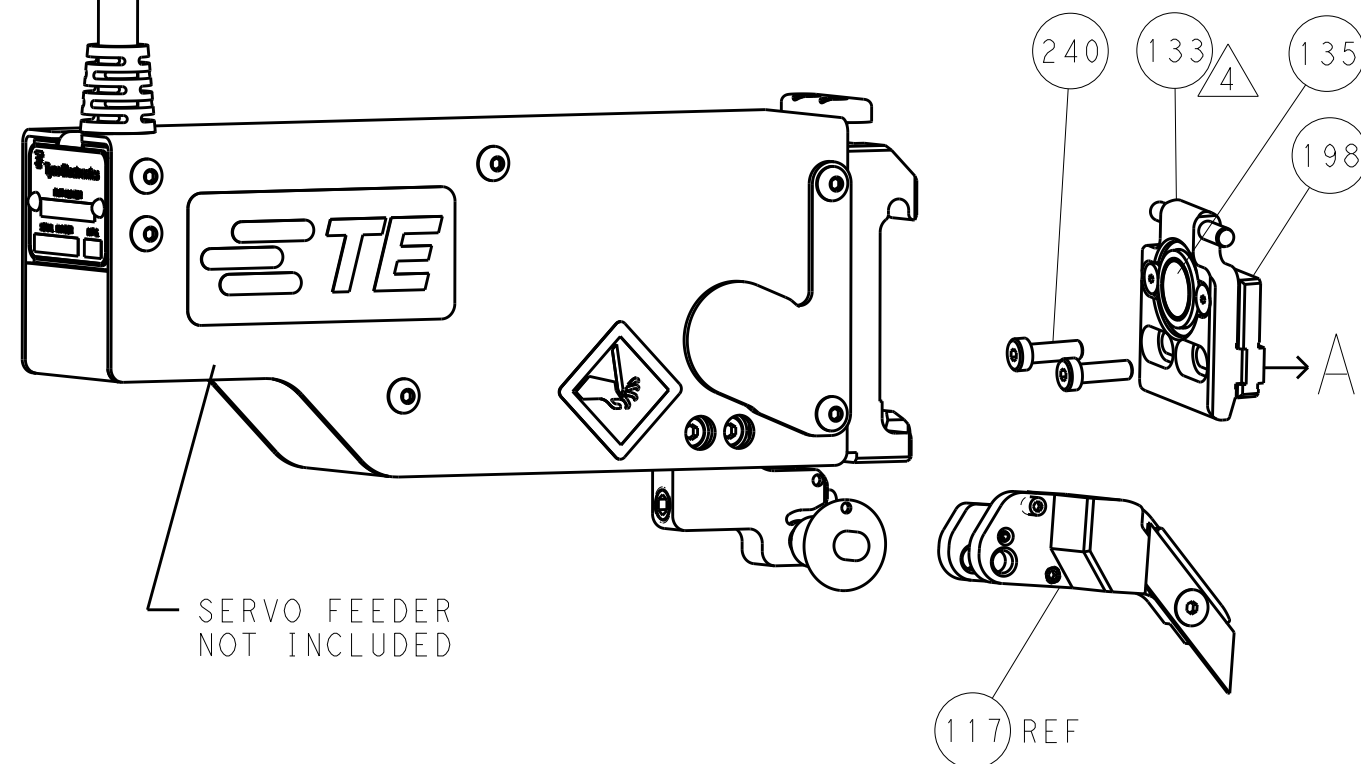
FEED TYPE
MECHANICAL



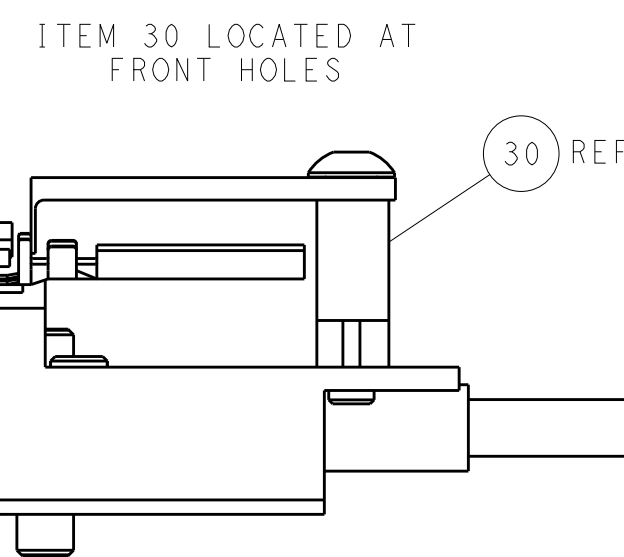
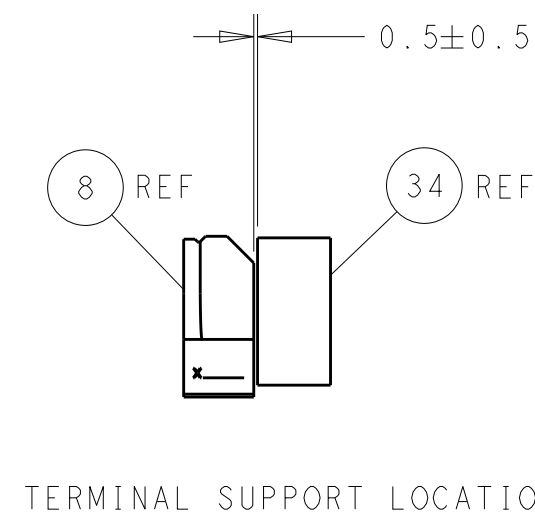
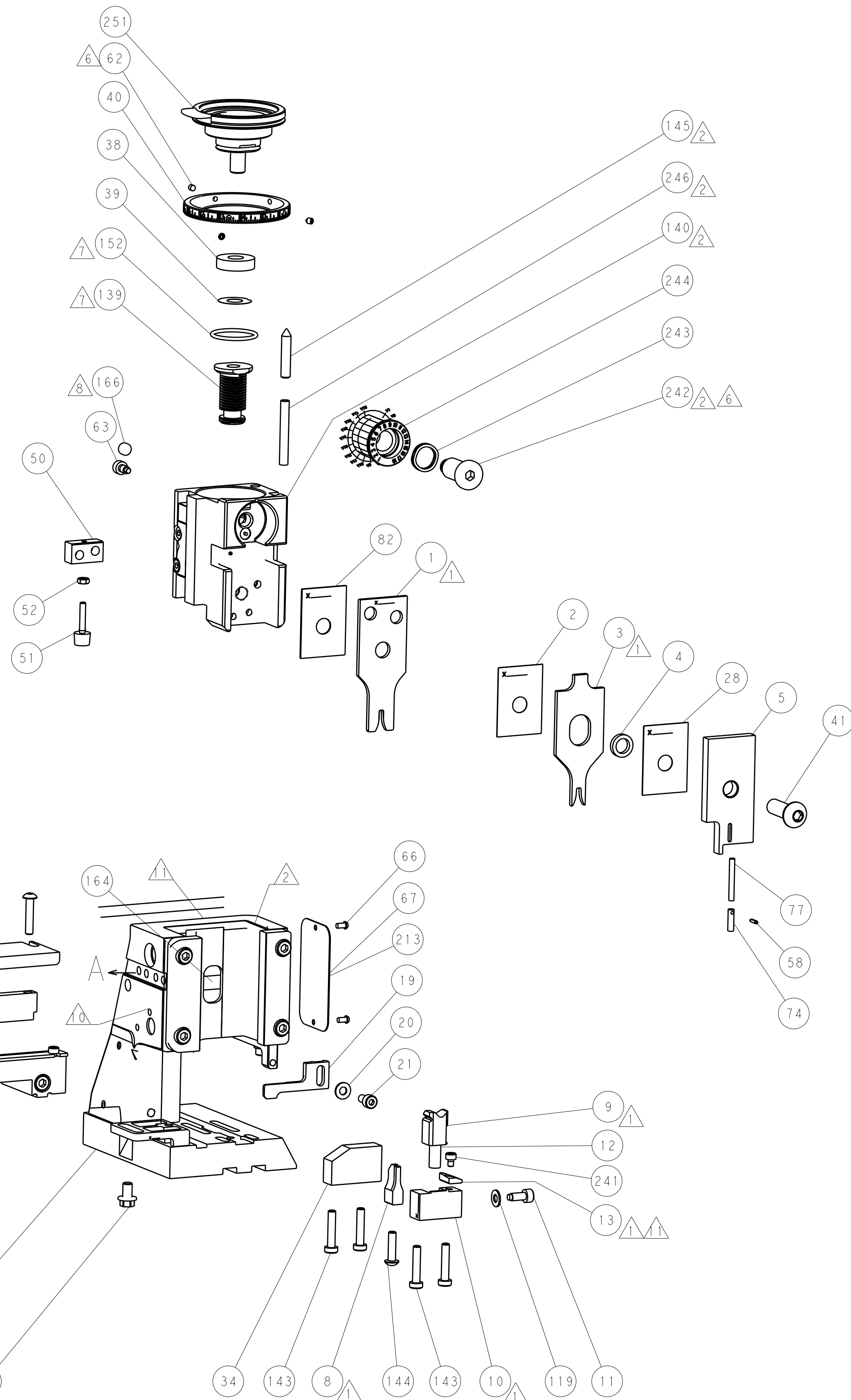
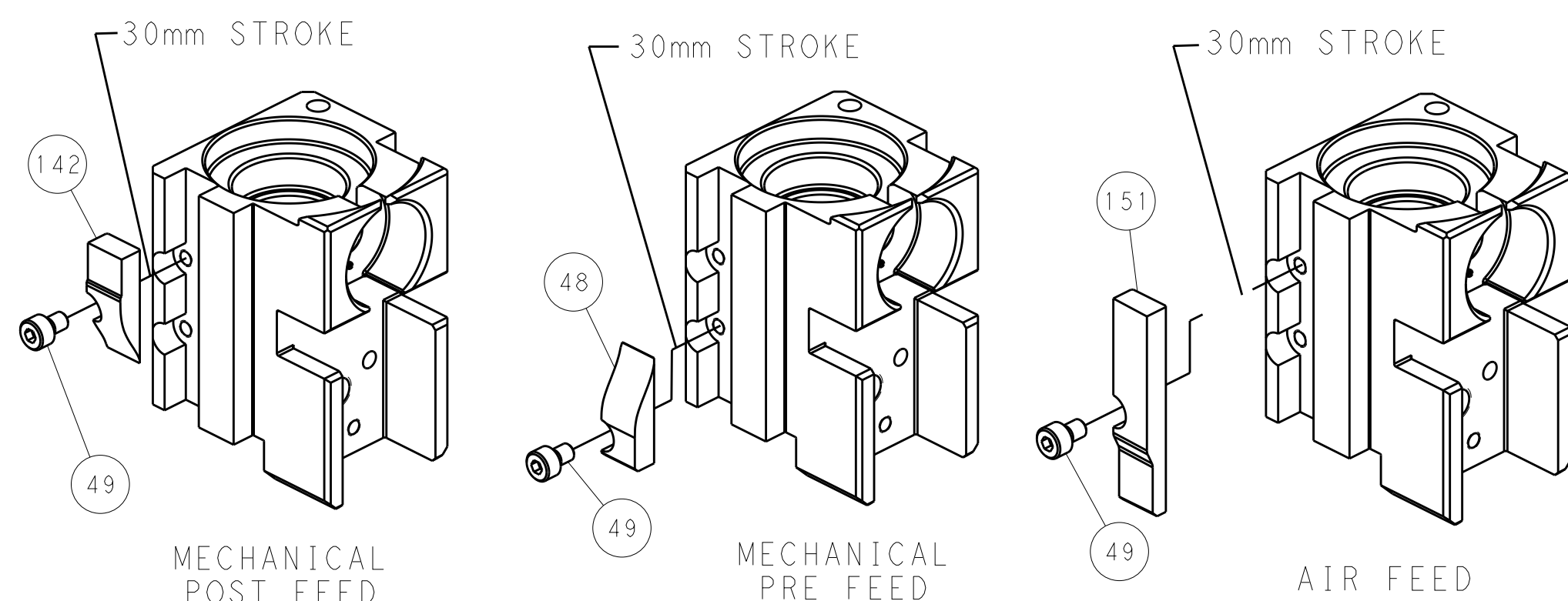
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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:		OWN: HOFFNER 04OCT2011		CHK: T.ELBIN 05OCT2011		APVD: T.ELBIN 05OCT2011		NAME: Ocean Side Feed Applicator	
mm		0 PLC ±.1		1 PLC ±.1		2 PLC ±.1		3 PLC ±.1		4 PLC ±.1	
ANGLES		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE 1:2		SHEET 4 OF 4	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE 1:2		SHEET 4 OF 4	