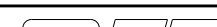
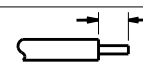


THIS DRAWING IS A CONTROLLED DOCUMENT FOR TONY IT IS SUBJECT TO CHANGE AND THE CONTROL PLAN ENGINEERING ORGANIZATION SHOULD BE CONSULTED FOR THE LATEST REVISION		DWN Z HANG 16JAN2013	 TE Connectivity Harrisburg, PA 17105-3608	
		CHK Z HANG 16JAN2013		
		APVD S.XI 16JAN2013		
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator -
mm		0. PLC ±.1 1. PLC ±.1 2. PLC ±.1 3. PLC ±.1 4. PLC ±.1		
		PRODUCT SPEC -		
		APPLICATION SPEC -		
MATERIAL -		WEIGHT -		
FINISH -		SIZE A1		CASE CODE 00779
		DRAWING NO C-2151856		RESTRICTED TO -
Customer Accessible Production Drawing				
		SCALE 1:2		SHEET 2 OF 4
		REV C		

	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151856-1	C	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	-	8-2151856-5	1901094-3	1-1752354-9	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151856-4	-	-	-
	2-2151856-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151856-5	1901094-3	1-1752354-9	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151856-4	-	-	-
	2-2151856-5	C	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
	2-2151856-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2151856-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.28 mm [.090]	F
INSUL	4.19 mm [.165]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI MIC REC, CTC			
WIRE STRIP LENGTH 3.50-4.00 mm [.138-.157 IN]			INSULATION DIAMETER RANGE Ø 3.40 mm [.134 IN] MAX 
TERMINAL APPLICATION SPECIFICATION 		114-20045	-
-		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
282466-1		281934-2	281934-3

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ^{△9}
2.50mm2		1.98+/-0.05 [.078+/- .002]		5.3
1.50mm2		1.72+/-0.05 [.068+/- .002]		7.5



^{△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: 8-2151856-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151856-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151856-5

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
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.

^{△0} 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 RANGLE QUOTED IS THAT OF THE TERMINAL.
THE SEAL 281934-2 INSULATION RANGE IS 1.7-2.4mm [.067-.094 IN]
THE SEAL 281934-3 INSULATION RANGE IS 2.5-3.3mm [.098-.130 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.

*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	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	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-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	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

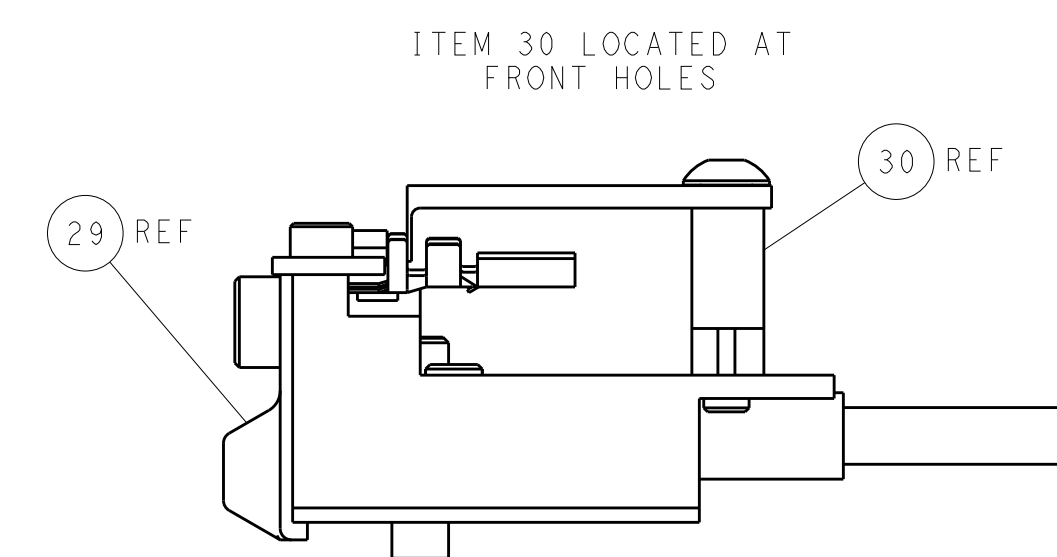
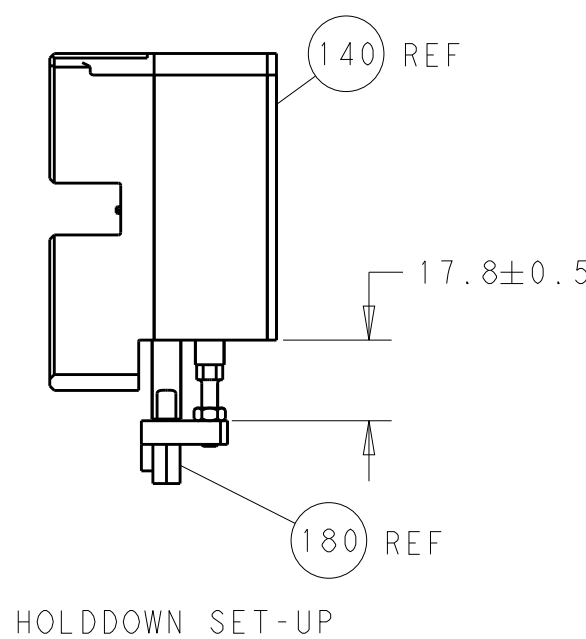
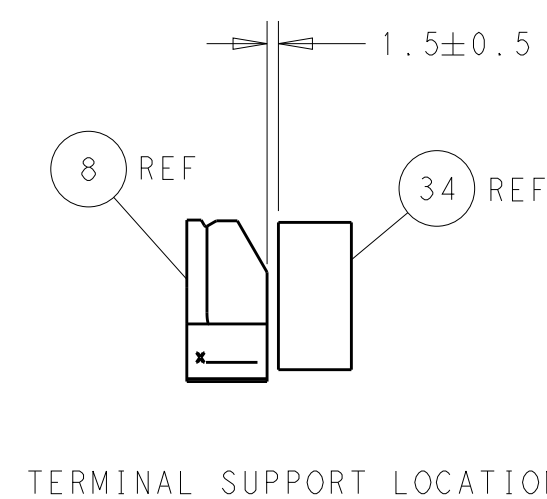
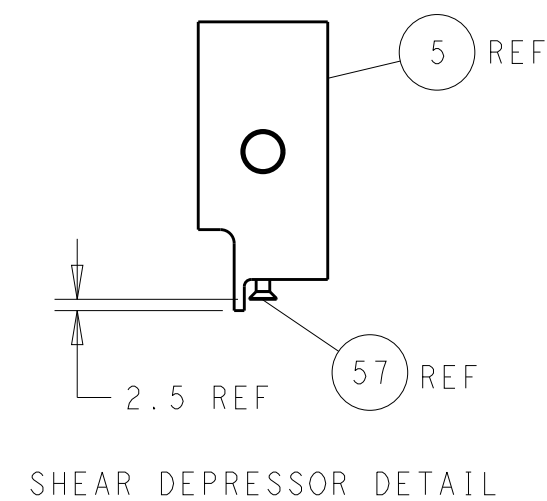
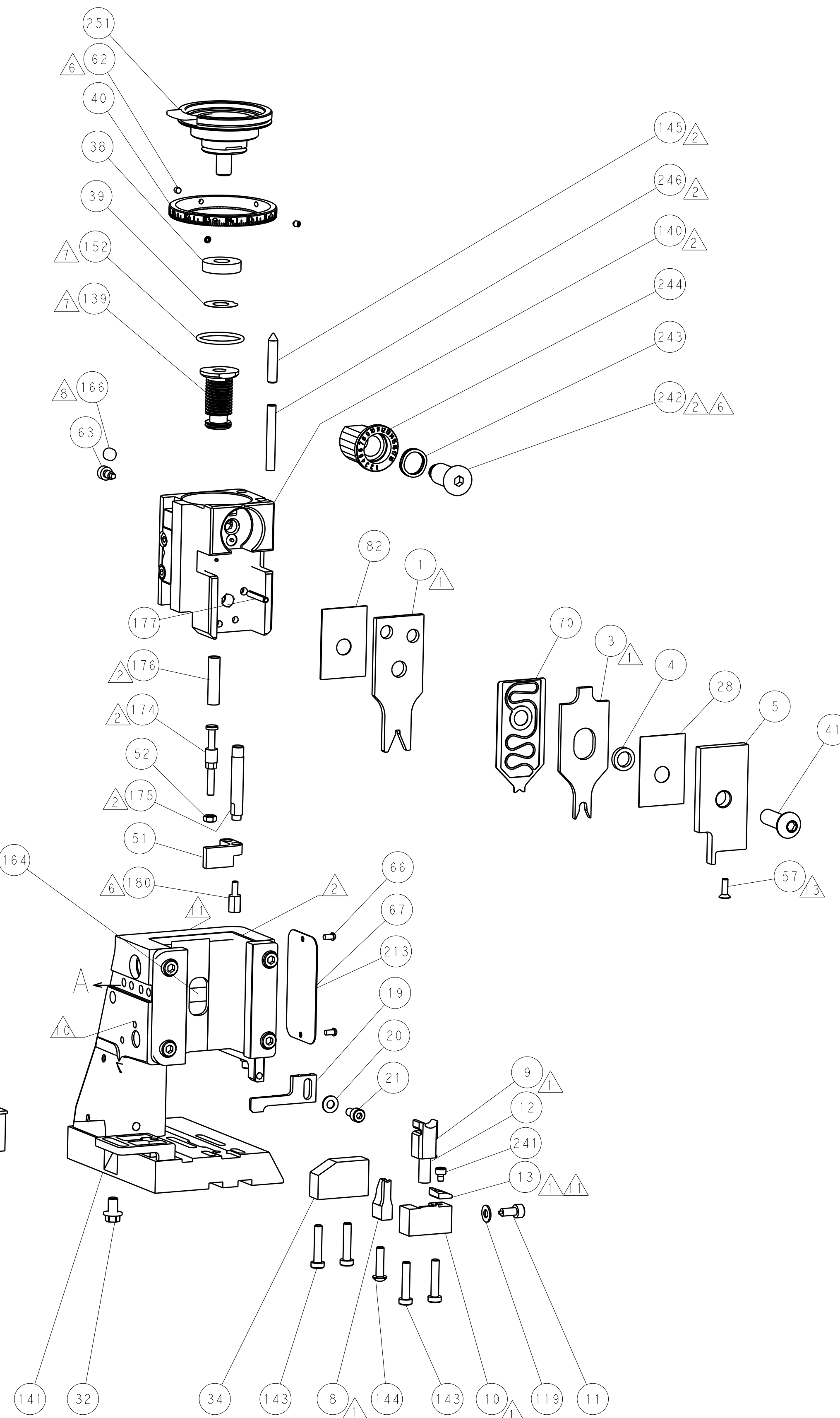
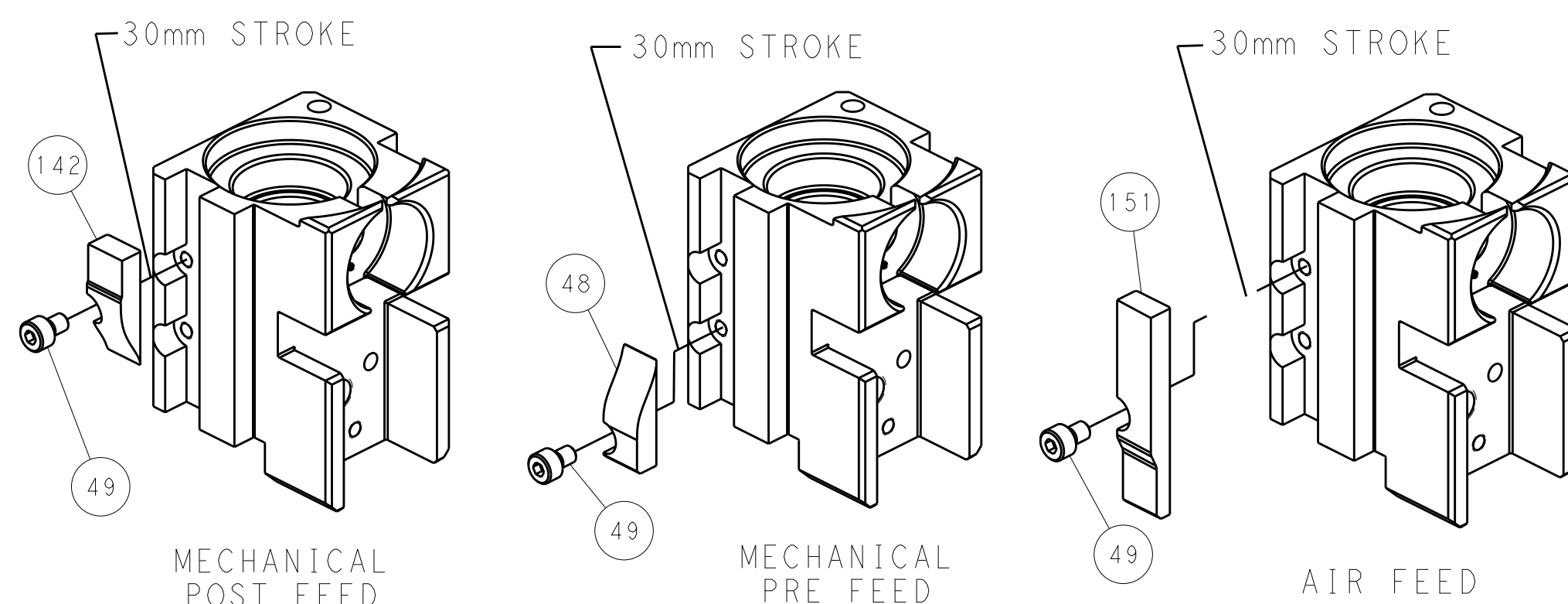
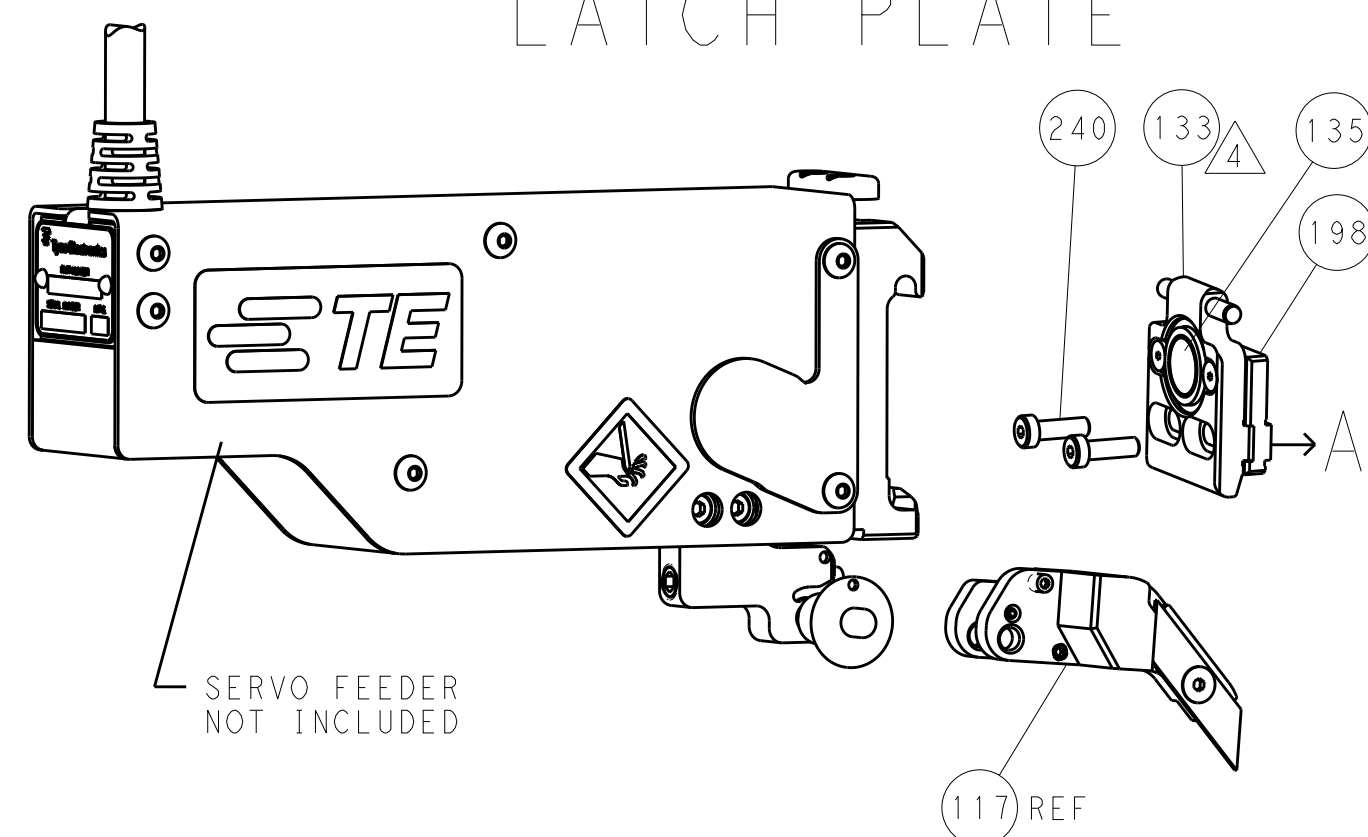
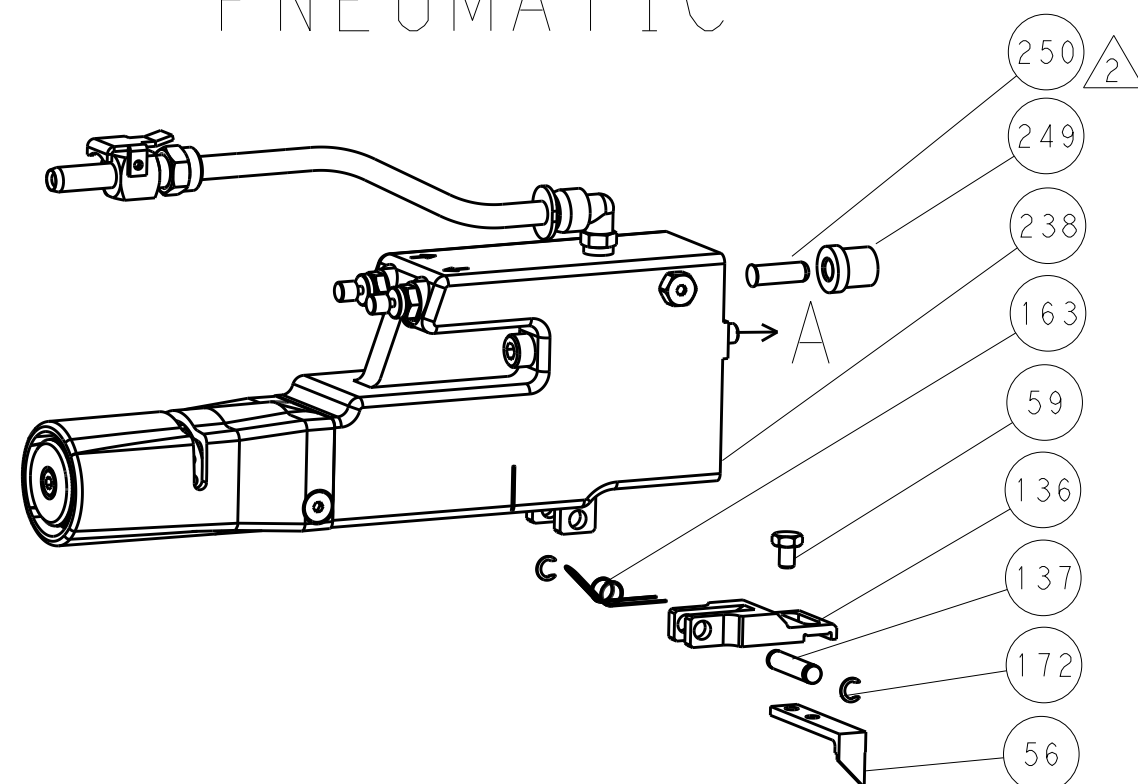
^{△6}	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
	-	-	1	-	-	2119740-2	TAG,IDENTIFICATION	213
^{△6}	-	-	1	-	-	1901094-3	SPACER, FEEDER	198
	-	1	1	1	1	1-1752354-9	STANDOFF,HOLD-DOWN	180
	-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	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	455888-6	SPACER, CRIMPER	82
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	-	1	1	2119740-1	TAG,IDENTIFICATION	67
^{△6}	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
^{△13}	-	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	1901681-1	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	2119644-2	RAM WASHER, PRECISION	38
	-	1	1	1	1	1752356-1	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	1-1320908-0	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	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
^{△1}	-	1	1	1	1	1-356885-3	STOP, SHEAR	11
	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
^{△1}	-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
	1	1	1	1	1	4-1333205-0	ANVIL, COMBINATION	8
	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	1-2119781-0	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
^{△1}	1	1	1	1	1	1-1633966-7	CRIMPER, INSULATION O	3
	-	-	-	-	-	-	-	2
^{△1}	1	1	1	1	1	3-1633730-0	CRIMPER, WIRE	1
	-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION.				OWN	16JAN2013	 TE Connectivity Harrisburg, PA 17105-3608			
				CHK	16JAN2013				
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	16JAN2013	NAME		Ocean Side Feed Applicator	
		0 PLC ±.01		PRODUCT SPEC		SIZE			
		1 PLC ±.01		APPLICATION SPEC					
MATERIAL		FINISH		WEIGHT		CASE CODE		DRAWING NO	
-		-		-		A1		00779 C-2151856	
Customer Accessible Production Drawing						SCALE		SHEET	
						1:2		3 of 4	
						REV		C	

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)

THIS DRAWING IS A FURNISHED DOCUMENT FOR THE ENGINEERING CORPORATION IT IS SUBJECT TO CHANGES AND THE CONTROLLING ENGINEERING CORPORATION IT SHOULD BE CONTROLLED FOR THE SAME REASON AS THE PREVIOUS EDITION		DWN L ZHANG 16 JAN 2013	 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:		CHK L ZHANG 16 JAN 2013			NAME	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S X J 16 JAN 2013			Ocean Side Feed Applicator -	
mm	0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1	PRODUCT SPEC -	SIZE A	CAGE CODE 00779	DRAWING NO C=2151856	RESTRICTED TO -
MATERIAL -	FINISH -	WEIGHT -	Customer Accessible Production Drawing			
		SCALE 1:1		SHEET A	OF A	REV C