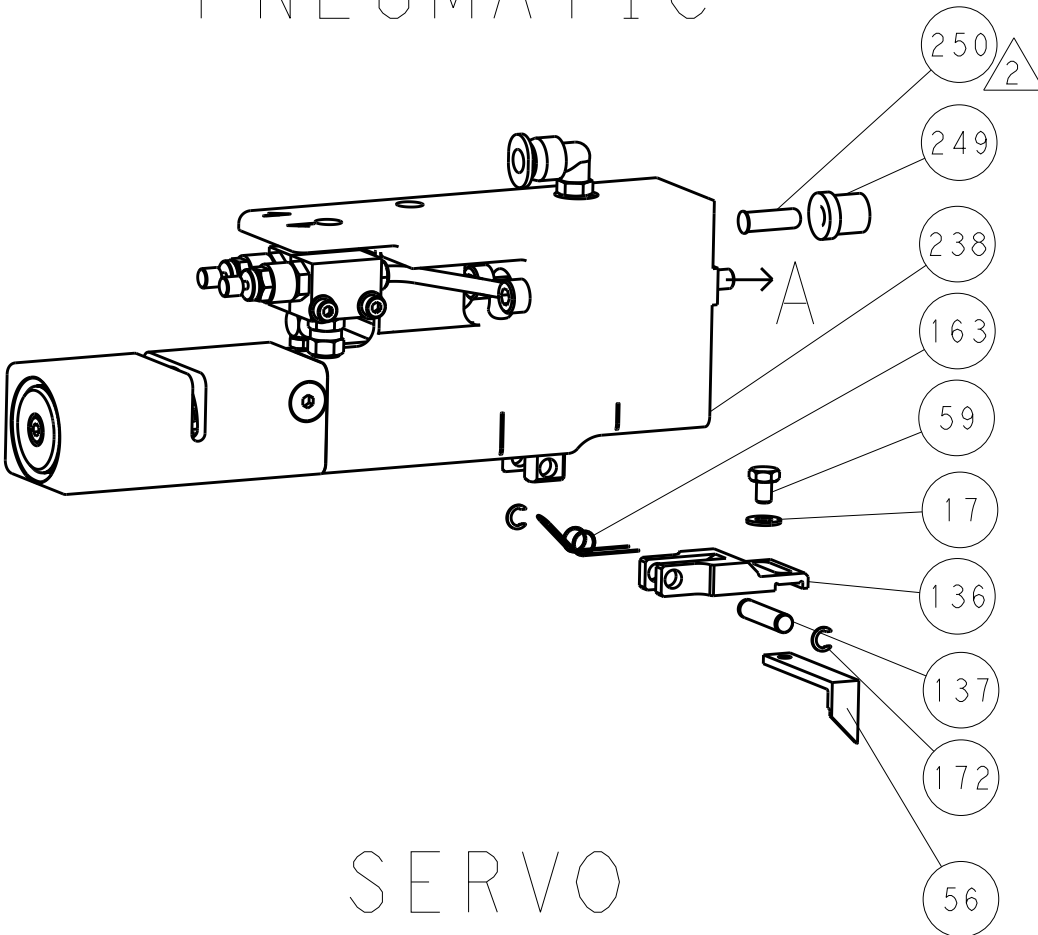


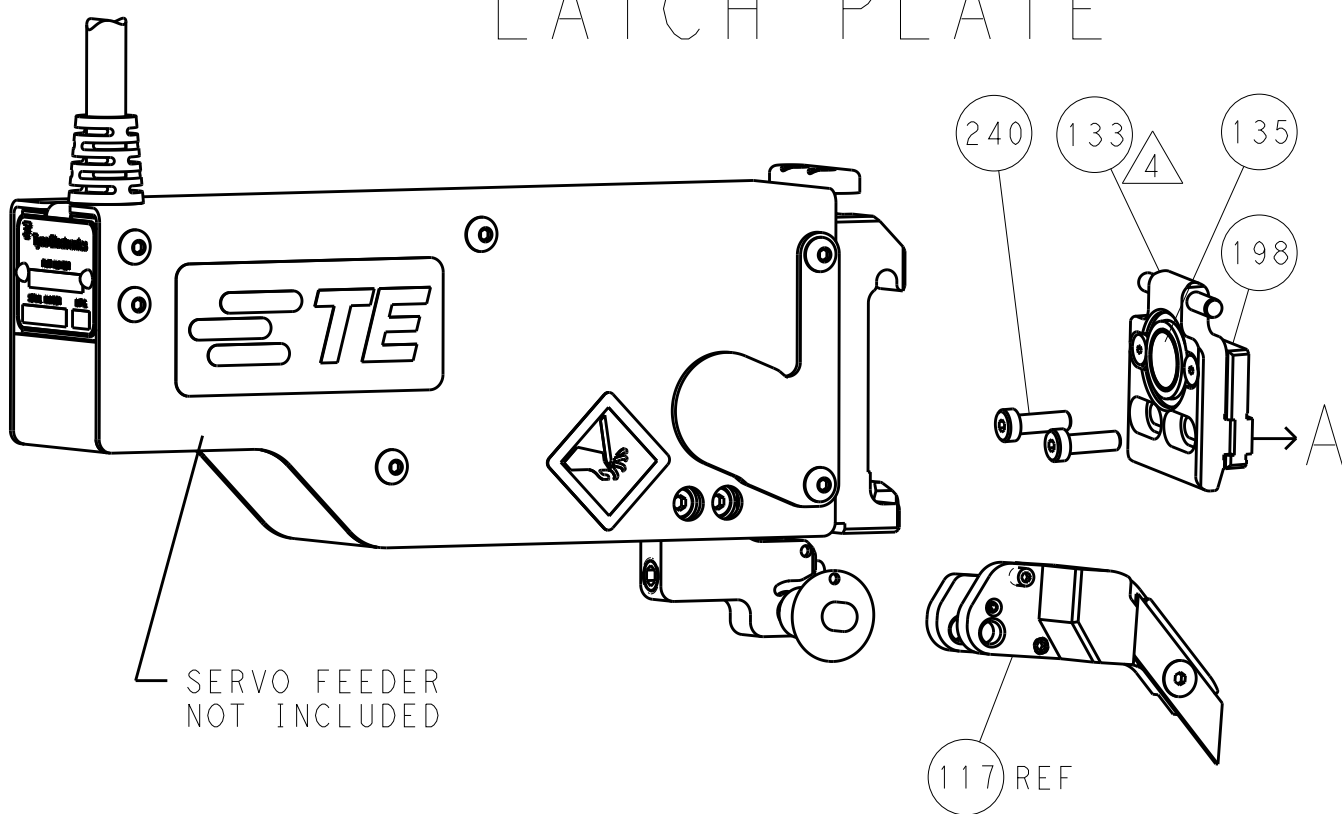
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

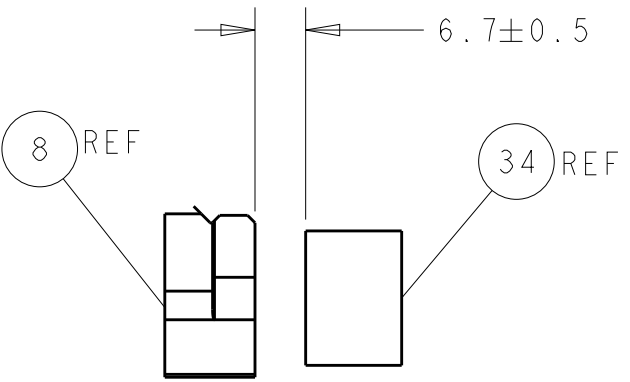
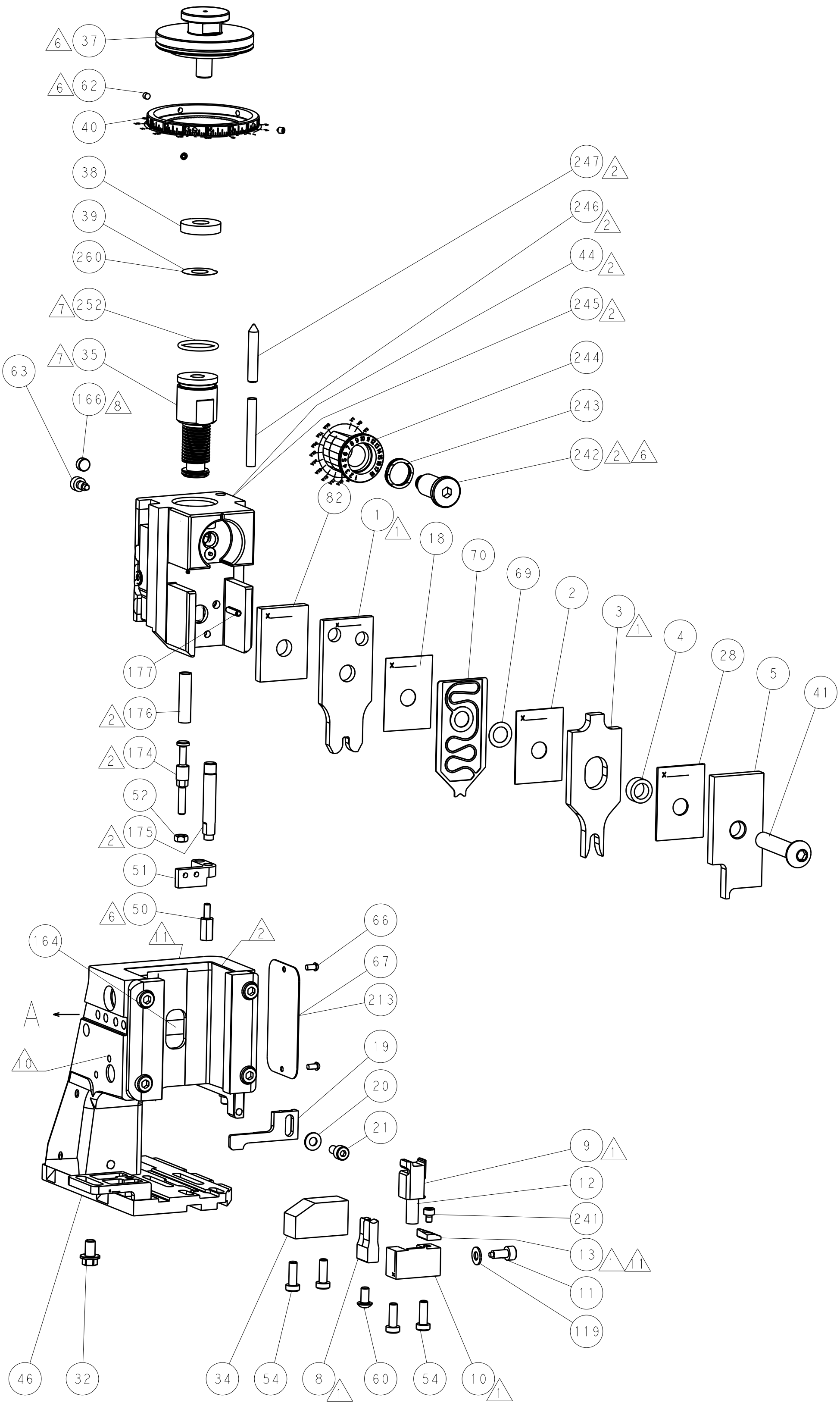
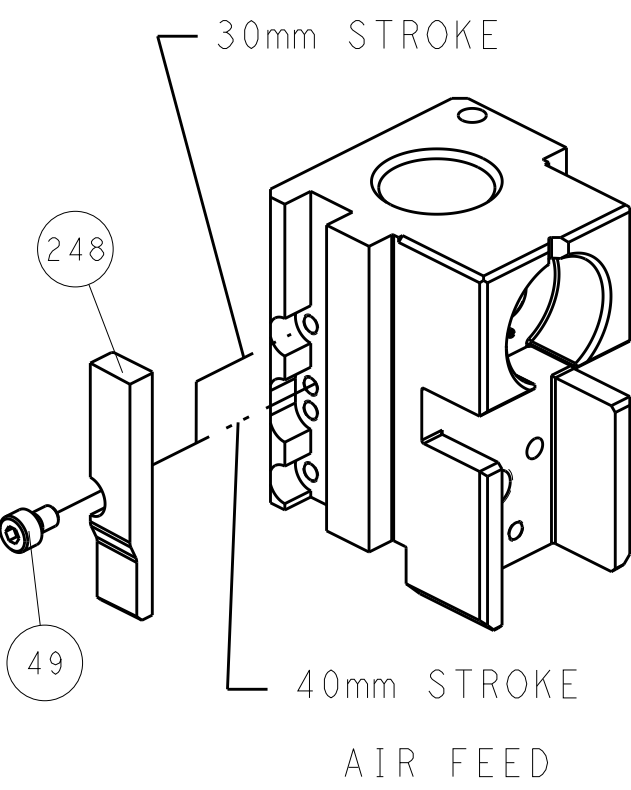
PNEUMATIC



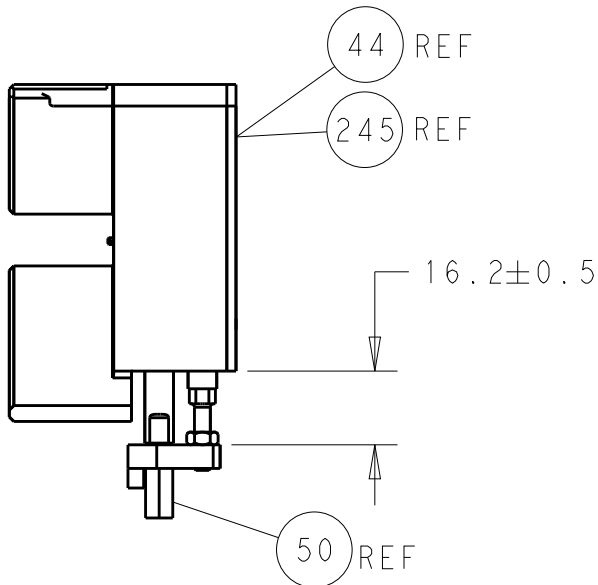
SERVO
LATCH PLATE



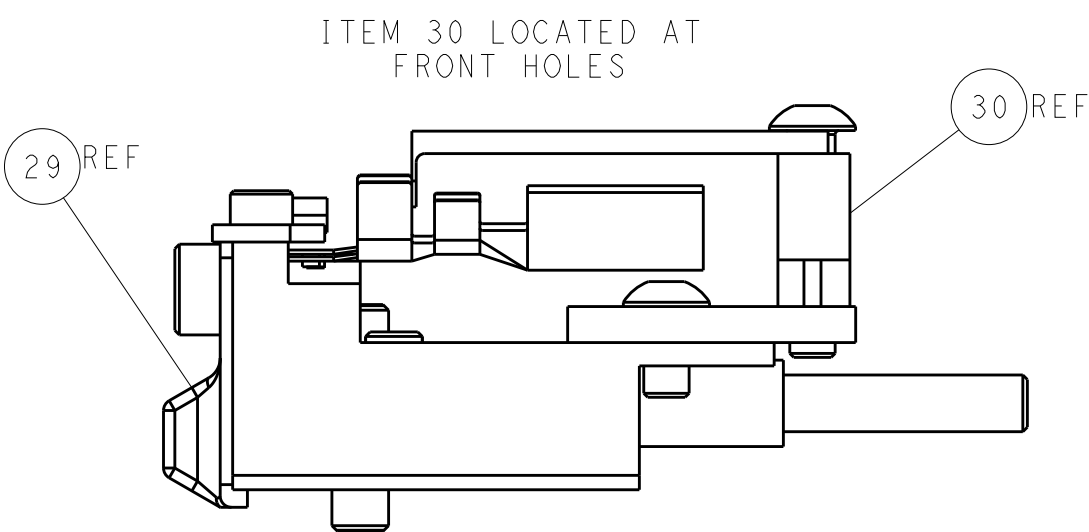
CAM POSITION



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP

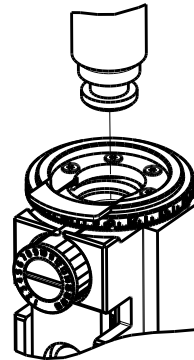


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

1ST PUBLISHED BY: COMPANY LOGO FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN L. ZHANG 16JUL2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 16JUL2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S. XI 16JUL2012	SIZE 00779	
0 PLC ±		PRODUCT SPEC	CAGE CODE 00779	
1 PLC ±		APPLICATION SPEC	DRAWING NO. 2151686	
2 PLC ±		WEIGHT	RESTRICTED TO	
3 PLC ±		Customer Accessible Production Drawing	SCALE 1:2	
4 PLC ±		Customer Accessible Production Drawing	SHEET 2 OF 4	
ANGLES		Customer Accessible Production Drawing	REV B	
FINISH		Customer Accessible Production Drawing	REV B	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151686-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC							
					SERVO LATCH PLATE SMART APPLICATOR	2119951-1 2161326-1	- -	8-2151686-5 8-2151686-4	1901094-3 -	- -	2168400-6 (QUANTITY 2) -
	2-2151686-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 							
					PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2151686-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2151686-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	5.10 mm [.201]	O
APPLICATOR INSTRUCTIONS 408-10389 		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 5.8X0.8			
WIRE STRIP LENGTH 5.20-5.80 mm [.205-.228 IN]			INSULATION DIAMETER RANGE Ø3.30-4.50 mm [.130-.177 IN]
TERMINAL APPLICATION SPECIFICATION 	114-18052	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1-962846-1	1-962846-2	2-962846-1	2-962846-2

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
4.00mm2		2.33+/-0.05 [.092+/- .002]		8.7



-  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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151686-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151686-5
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 50, 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.
-  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
-  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.

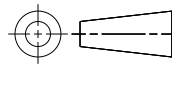
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-77	-27	-25	-22	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)

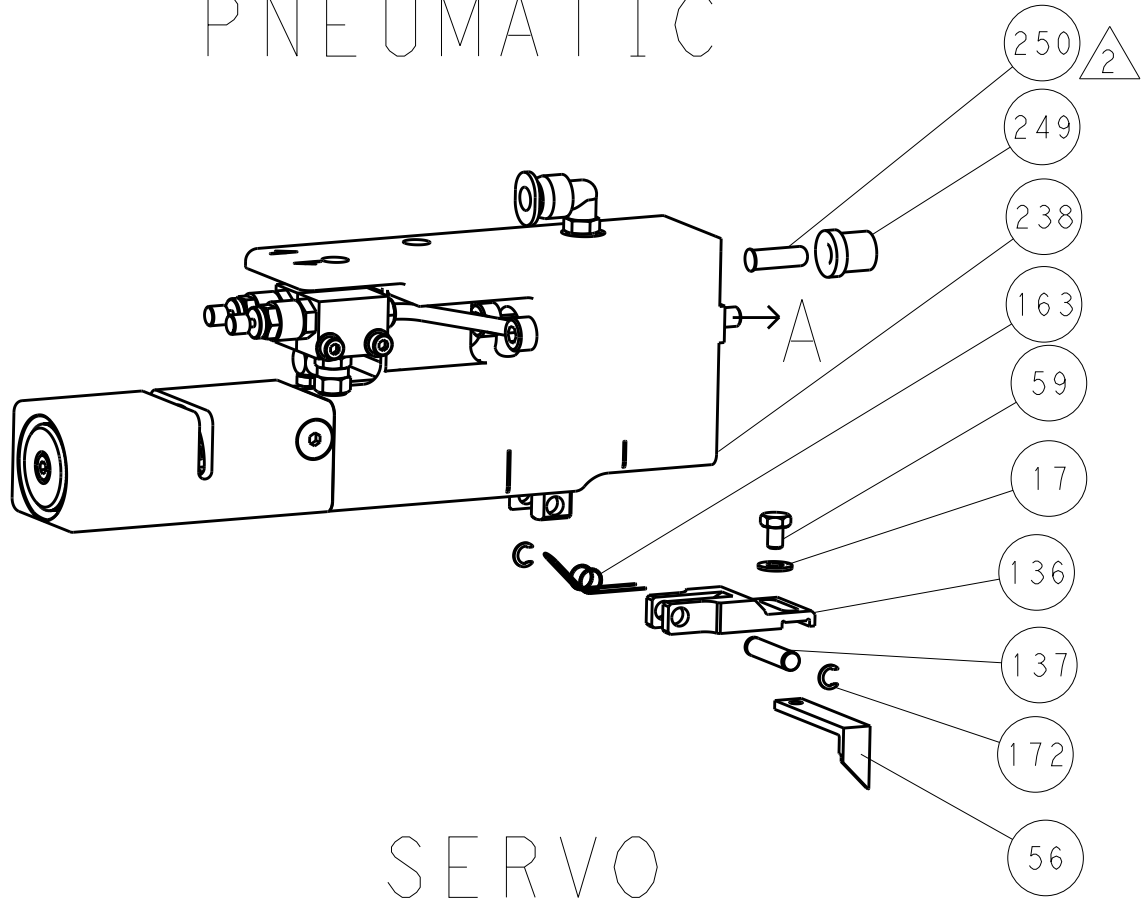
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
			-	-	SEE SHEET 1	-

	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	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	2063440-1	AIR FEED MODULE	238
	-	-	1	-	2119740-2	TAG, IDENTIFICATION	213
	-	-	1	-	1901094-3	SPACER, FEEDER	198
	-	1	1	1	993111-8	PIN, SLOTTED SPRING 3.0 X 12.0	177
	-	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
	-	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
	-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	-	1	240638-1	SPRING, FEED FINGER	163
	-	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	2119798-2	DETENT PIN	145
	-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
	-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
	-	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1	2161312-1	RAM, STEPPED, ASIAN STYLE, SIDE FEED	140
	-	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	1-18028-2	WASHER, FLAT, REG M4	119
	-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
	-	1	1	1	2-455888-9	SPACER, CRIMPER	82
	-	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
	-	1	1	1	1633470-2	EXTENSION PLATE	78
	-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	1	1	2119943-1	WASHER, SPACER	69
	-	1	-	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	-	1	1338683-8	FEED PAWL	56
	-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1	1-1901681-0	HOLDDOWN, TERMINAL	51
	-	1	1	1	2-1752354-8	STANDOFF, HOLD-DOWN	50
	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	41
	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1	2119644-3	RAM WASHER, PRECISION	38
	-	1	1	1	1-1752356-5	SUPPORT, TERMINAL	34
	-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
	-	1	1	1	1320908-2	SPACER, STRIP GUIDE	30
	-	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1-455888-0	SPACER, CRIMPER	28
	-	1	1	1	1320928-6	STRIP GUIDE	24
	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
	-	1	1	1	455888-2	SPACER, CRIMPER	18
	-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	17
	-	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
	1	1	1	1	1633925-2	ANVIL, COMBINATION	8
	-	-	-	-	-	-	7
	-	-	-	-	-	-	6
	-	1	1	1	1-2119757-3	DEPRESSOR, SHEAR	5
	-	1	1	1	4-238011-6	BLOCK, CRIMPER SPACER	4
	1	1	1	1	3-1633965-9	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	455888-5	SPACER, CRIMPER	2
	1	1	1	1	456410-4	CRIMPER, WIRE PREMIUM	1
	-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

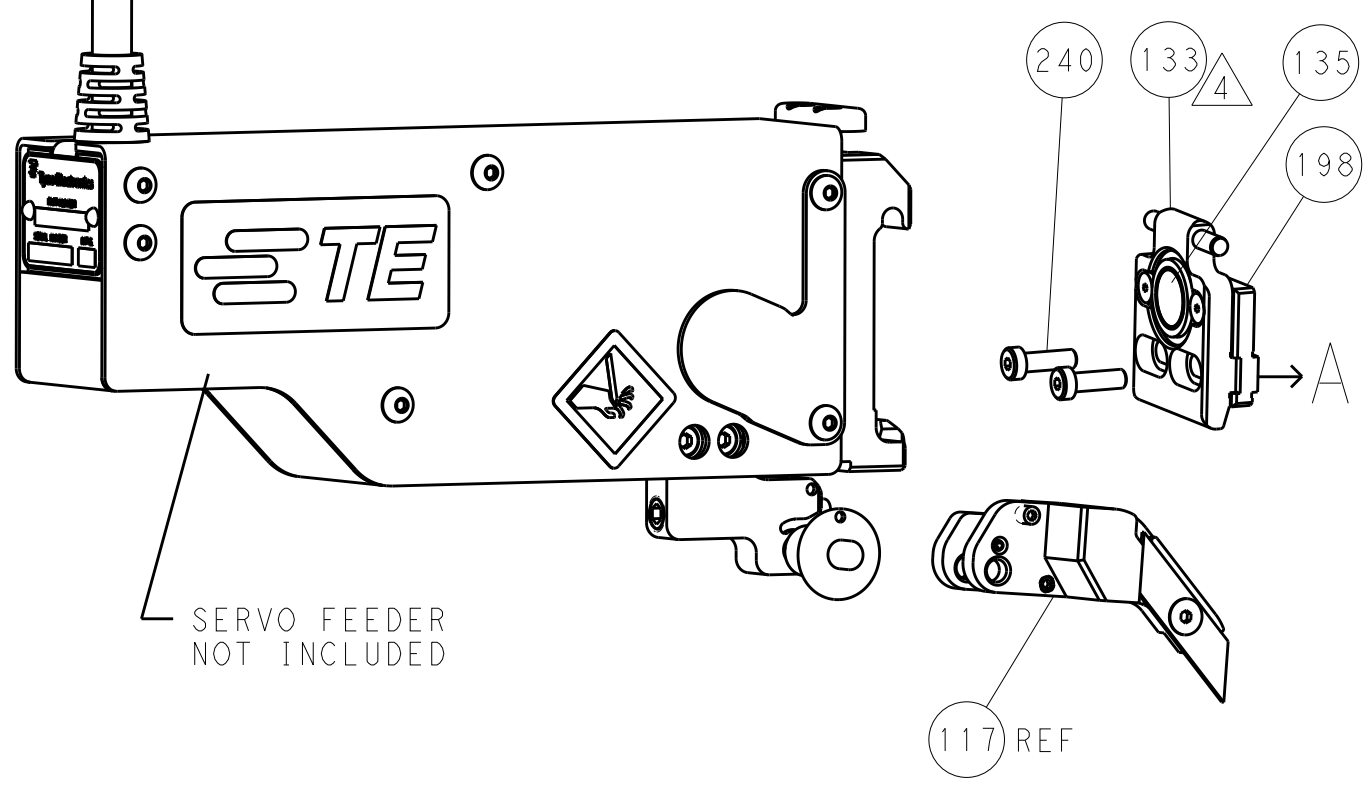
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND WITHOUT NOTICE, THE MANUFACTURING ORGANIZATION SHALL BE CONTACTED FOR THE LATEST EDITION.		OWN L. ZHANG CHK L. ZHANG APVD S. XI	16JUL2012 16JUL2012 16JUL2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC APPLICATION SPEC		SIZE A1	
MATERIAL -		FINISH -		CAGE CODE 00779	
		WEIGHT -		DRAWING NO C=2151686	
		Customer Accessible Production Drawing		RESTRICTED TO -	
		SCALE 1:2		SHEET 3 OF 4	
				REV B	

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

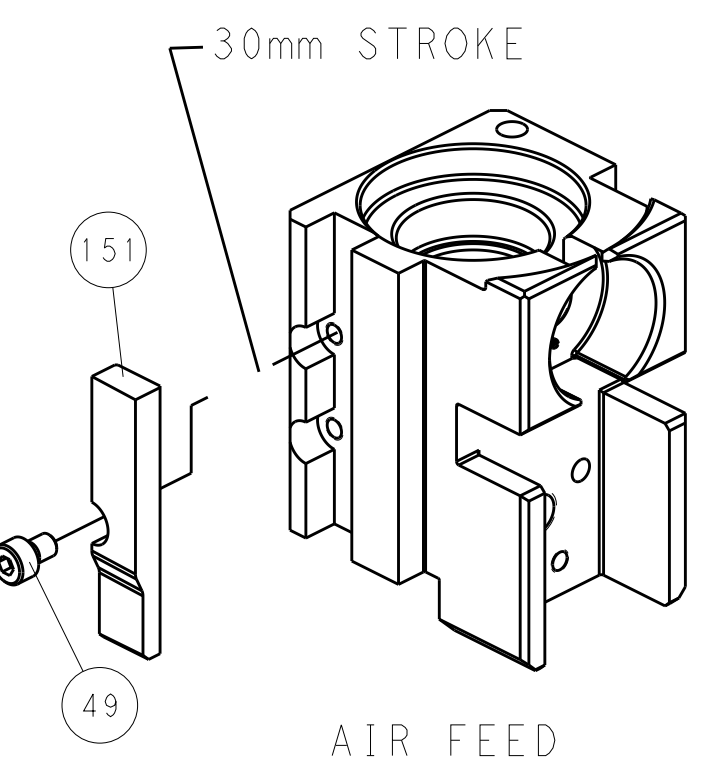
FEED TYPE
PNEUMATIC



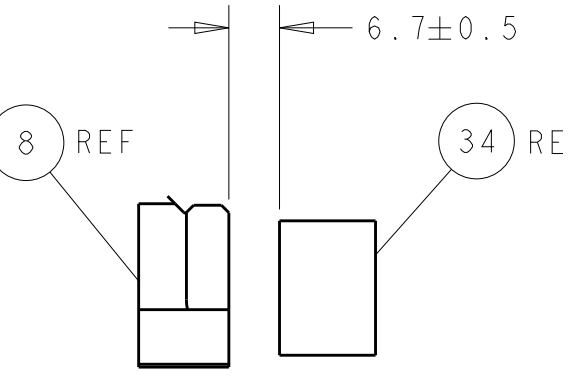
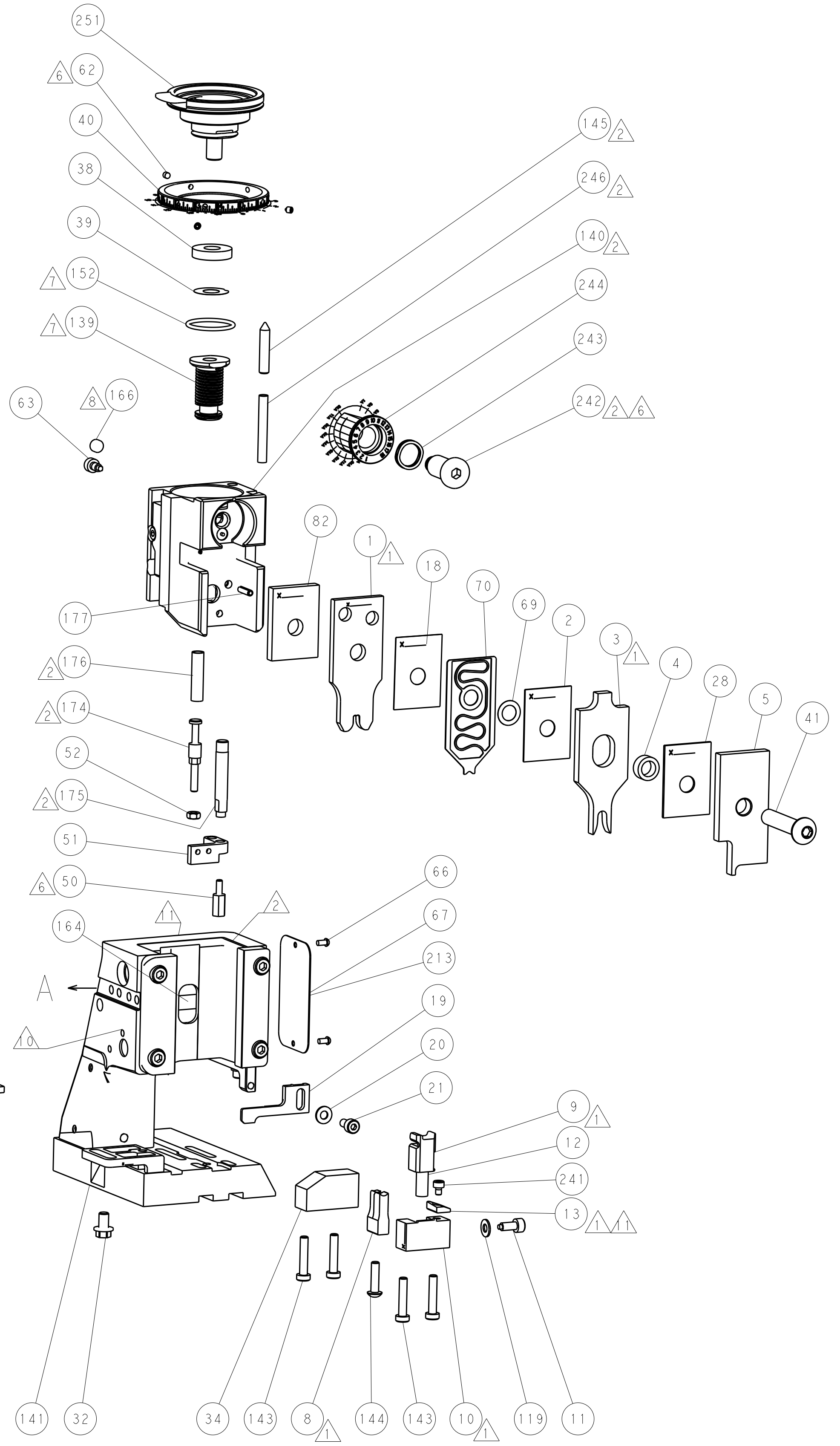
SERVO
LATCH PLATE



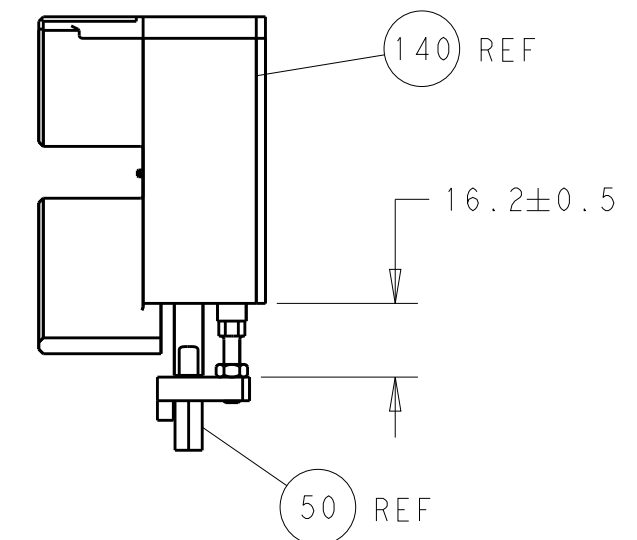
CAM POSITION



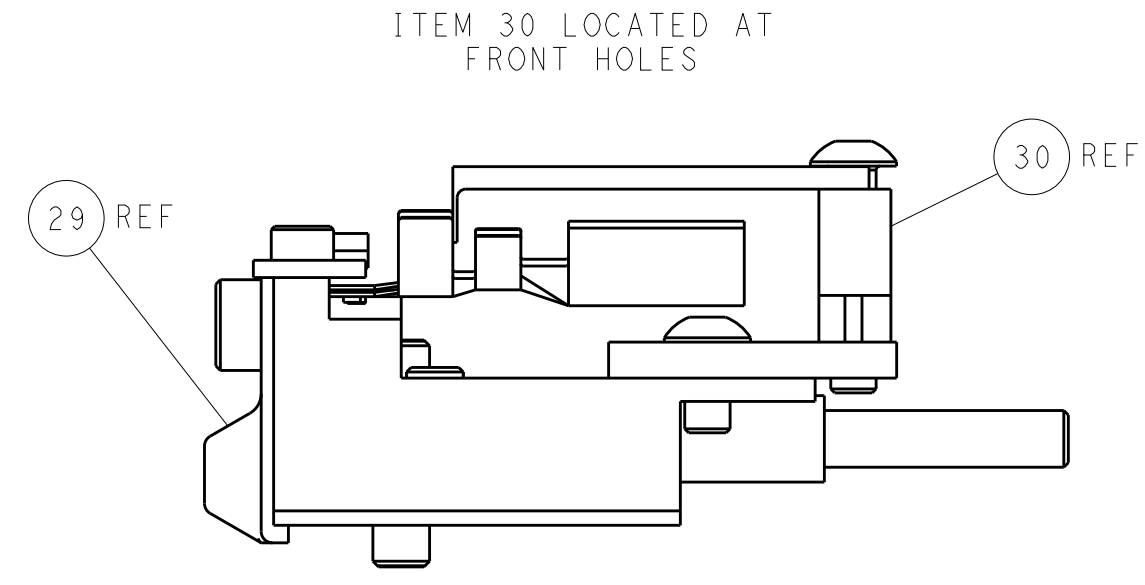
AIR FEED



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		16JUL2012		STE		TE Connectivity	
mm		0 PLC ±		CHK		16JUL2012		Harrisburg, PA 17105-3608			
		1 PLC ±		APVD		16JUL2012		NAME		Ocean Side Feed	
		2 PLC ±		S		X1		PRODUCT SPEC		Applicator	
		3 PLC ±		APVD		16JUL2012		APPLICATION SPEC			
		4 PLC ±		S		X1		WEIGHT		-	
		ANGLES		FINISH		-		SIZE		CAGE CODE	
								00779		DRAWING NO	
								Customer Accessible Production Drawing		SCALE	
								1:2		SHEET	
								4		OF	
								4		REV	
								B			