



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: 8-2151924-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151924-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151924-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151924-6
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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS
7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
8. MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
12. WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.74.
13. USE ITEM 34 WITH TERMINAL 2120770-1.
14. USE ITEM 272 WITH TERMINAL 2120686-1.
15. WIRE CRIMP INFORMATION OBTAINED FROM 114-18079.
 INSULATION CRIMP INFORMATION OBTAINED FROM 114-18050.

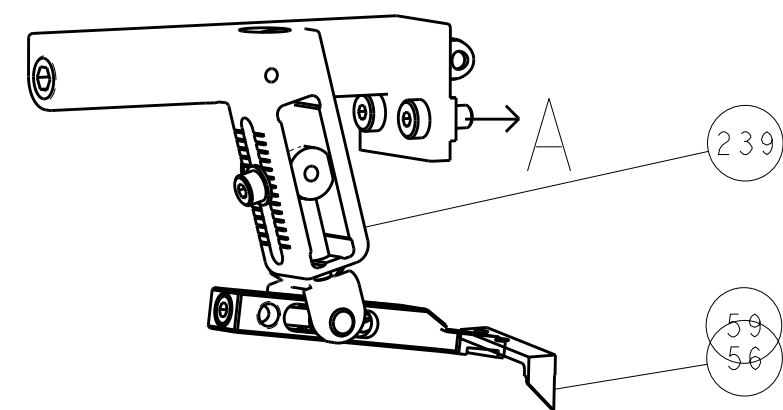
6		5		4		3	
FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
	CONVERT TO	PART NUMBERS REQUIRED					
MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	SERVO LATCH PLATE	2119951-1	-	8-2151924-5	1901094-3	2-1752354-0	2168400-6 (QUANTITY 2)
	SMART APPLICATOR	2161326-1	-	8-2151924-4	-	-	-
PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	SERVO LATCH PLATE	2119951-1	-	8-2151924-5	1901094-3	2-1752354-0	2168400-6 (QUANTITY 2)
	SMART APPLICATOR	2161326-1	-	8-2151924-4	-	-	-
SERVO LATCH PLATE  4	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
 SERVO LATCH PLATE  12	-	-	-	-	-	-	-
	-	-	-	-	-	-	-
NONE	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-

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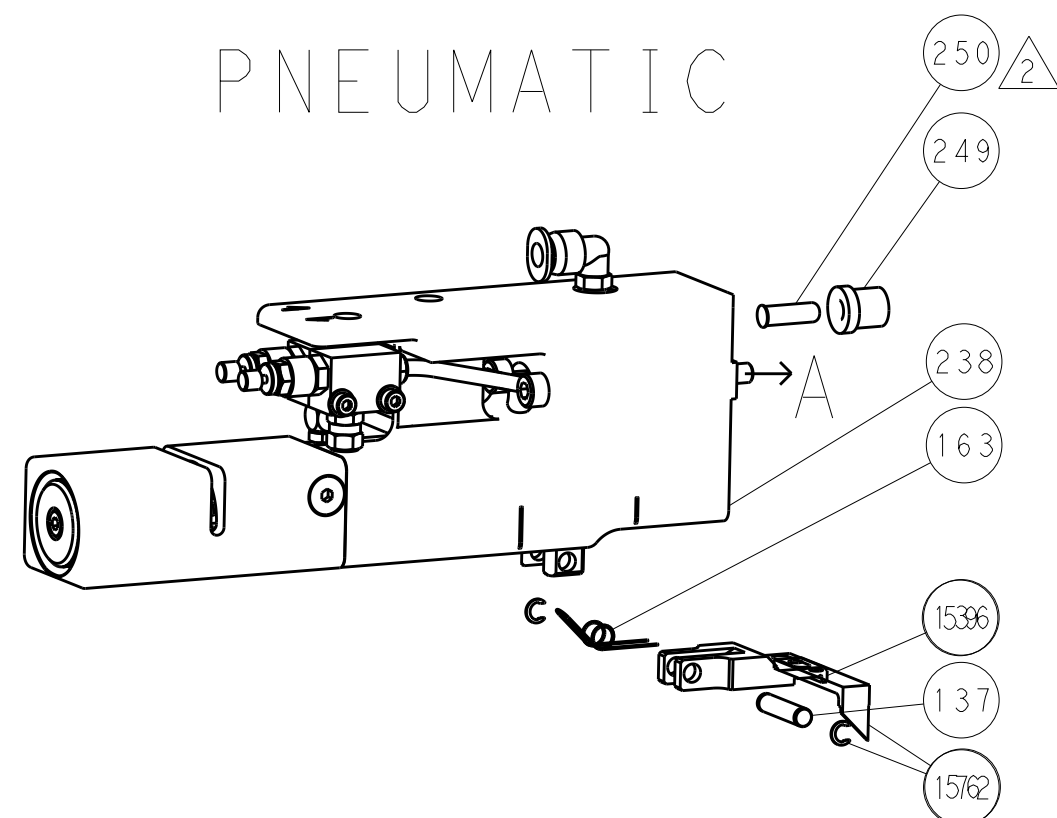
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LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

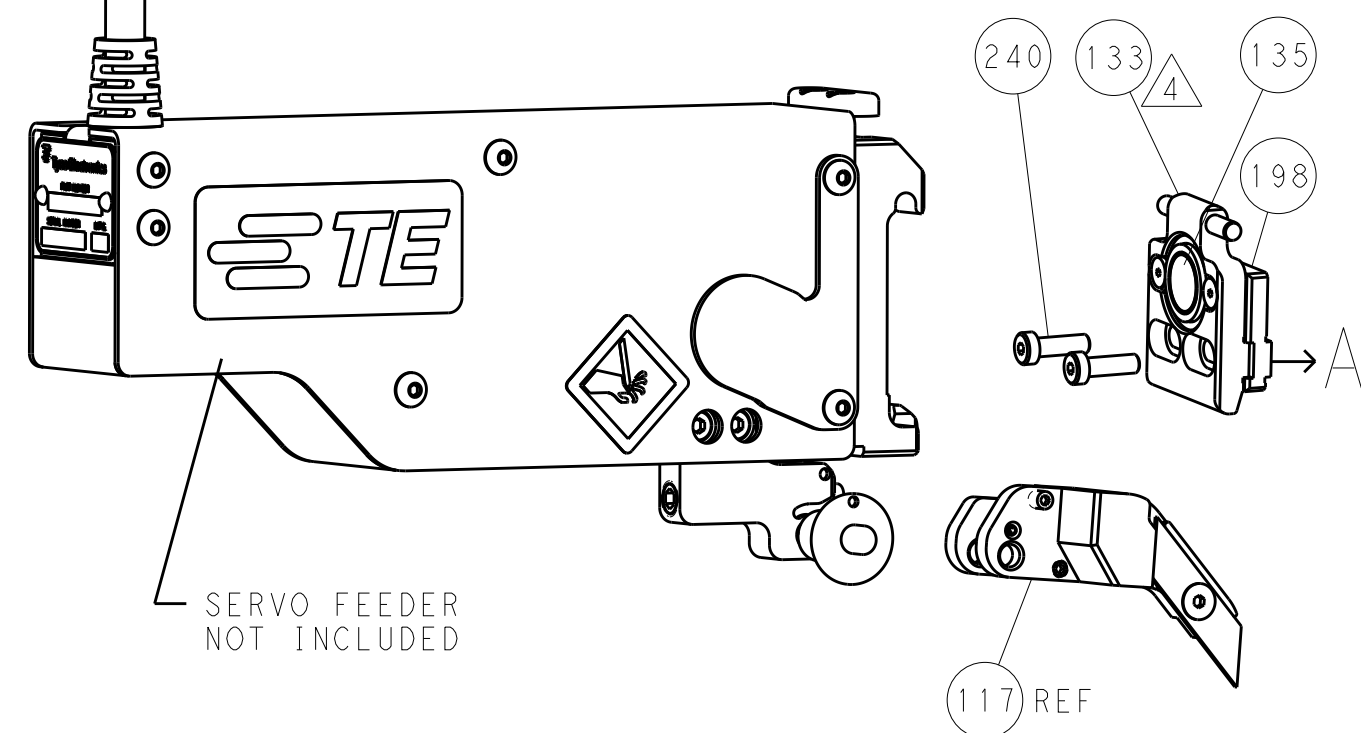
FEED TYPE
MECHANICAL



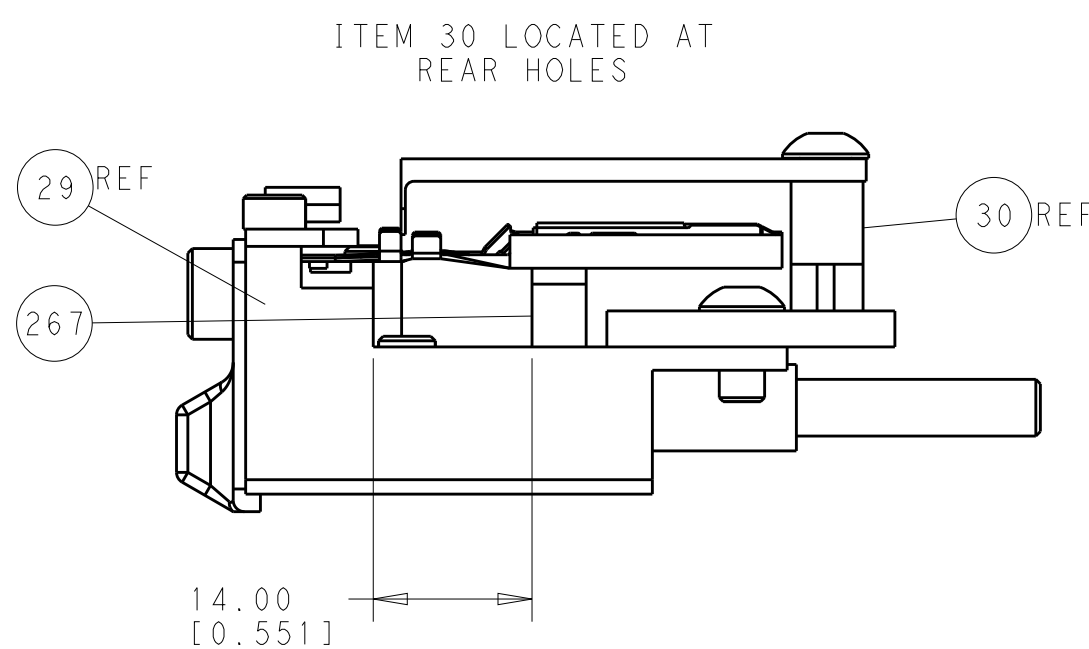
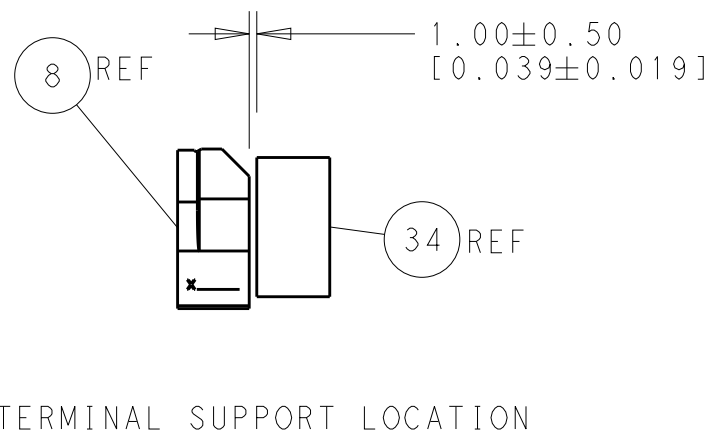
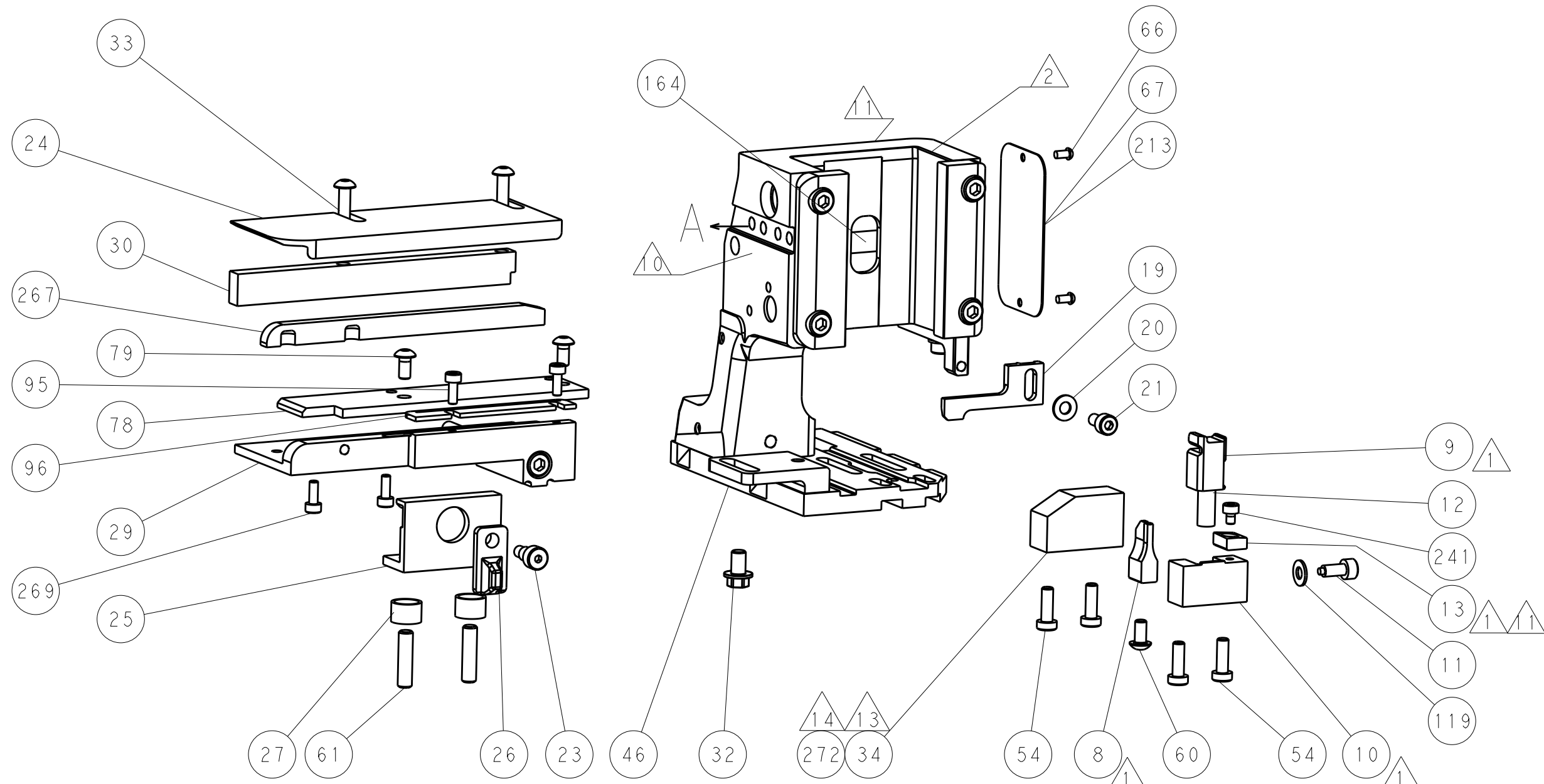
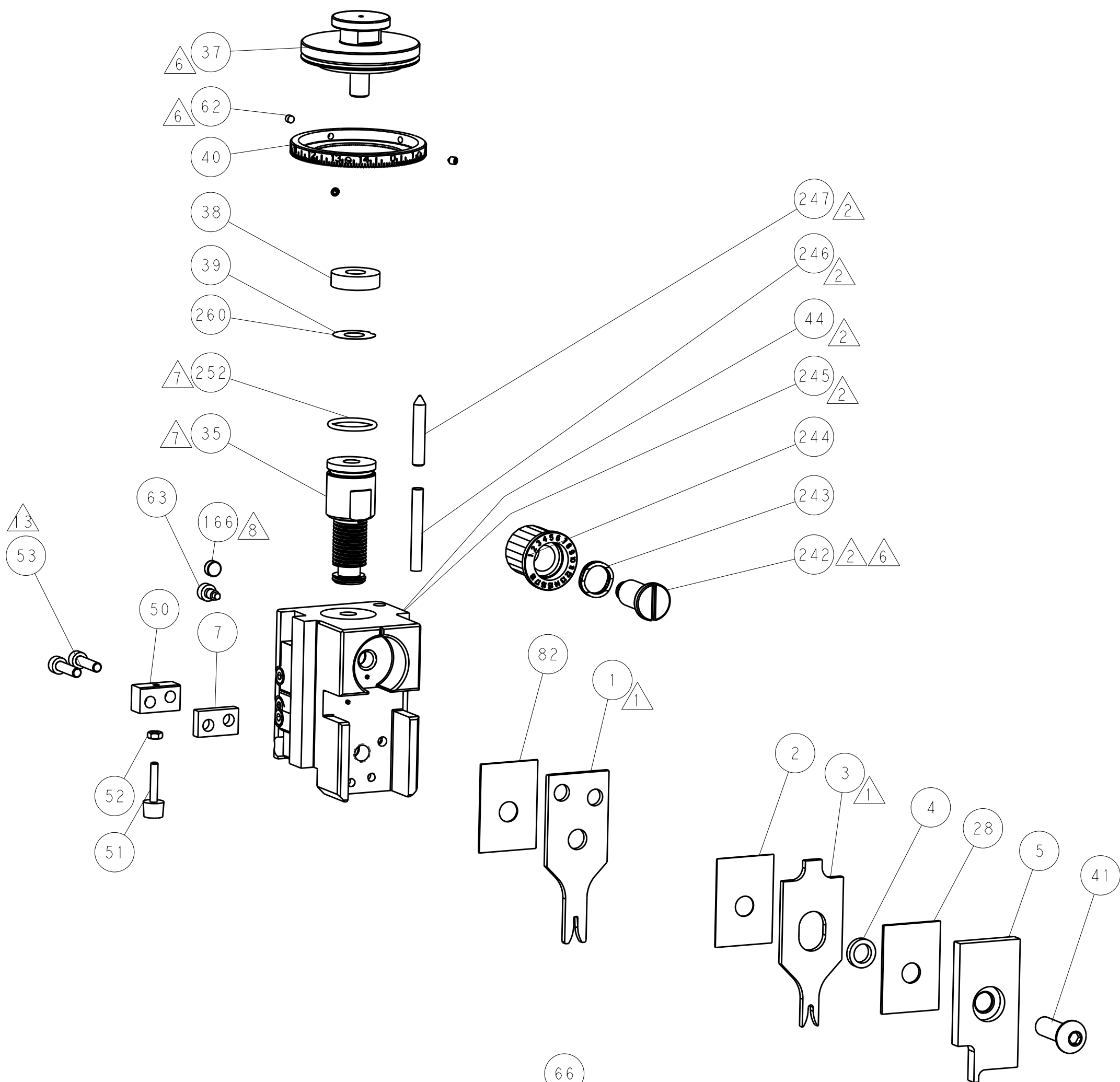
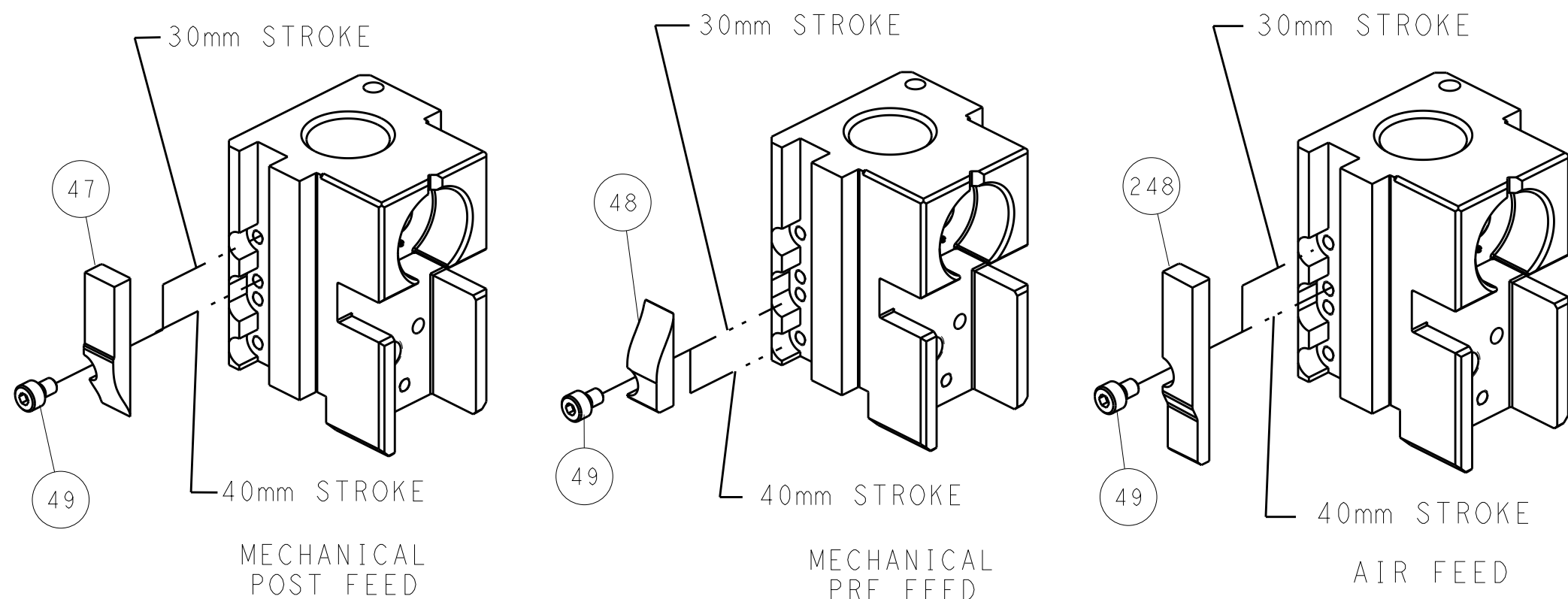
PNEUMATIC



SERVO
LATCH PLATE



CAM POSITIONS



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)

1. NOT DIMENSIONED TO CENTERLINE UNLESS OTHERWISE SPECIFIED DIMENSIONS OF CONTACTS FOR THE TOP LAYER POSITION		DWN 23APR2013 K. HUANG		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm				Ocean Side Feed Applicator	
		PRODUCT SPEC		-	
		APPLICATION SPEC		-	
				SIZE	CAGE CODE
				DRAWING NO	
MATERIAL		WEIGHT		RESTRICTED TO	
-		-		-	
				A1 00779 C=2151924	
		Customer Accessible Product Drawing		SCALE	SHEET
				1:2	2 of 4
					REV A

	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151924-1	A	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	-	8-2151924-5	1901094-3	2-1752354-0	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151924-4	-	-	-
	2-2151924-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151924-5	1901094-3	2-1752354-0	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151924-4	-	-	-
	2-2151924-5	A	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
	2-2151924-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2151924-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.58 mm [.062]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: EMAX SOCKET CONTACT F-CRIMP			
WIRE STRIP LENGTH 3.40-4.00 mm [.134-.157 IN]			INSULATION DIAMETER RANGE Ø1.00-1.60 mm [.039-.063 IN]
TERMINAL APPLICATION SPECIFICATION	114-18079	-	-
	114-18050	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2120770-1	2120686-1		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm2	1.06+/-0.05 [.042+/-0.002]	7.3
0.37mm2	0.99+/-0.05 [.039+/-0.002]	8.2
0.25mm2	0.93+/-0.05 [.037+/-0.002]	8.8
0.20mm2	0.91+/-0.05 [.036+/-0.002]	9.0



- 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: 8-2151924-4
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- 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.
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- USE ITEM 34 WITH TERMINAL 2120770-1.
- USE ITEM 272 WITH TERMINAL 2120686-1.
- WIRE CRIMP INFORMATION OBTAINED FROM 114-18079.
INSULATION CRIMP INFORMATION OBTAINED FROM 114-18050.

THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINAING UNIT.

	-	1	1	1	1	2-1752356-0	SUPPORT, TERMINAL	272
	-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
	-	1	1	1	1	1633782-2	FENCE	267
	-	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
	-	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
	-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)

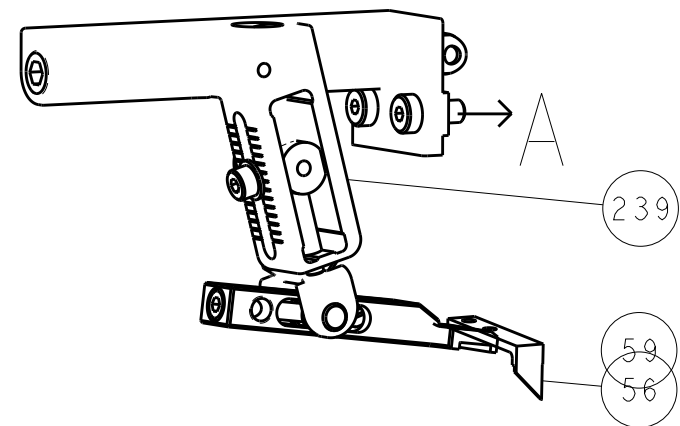
SET UP GAUGE 2119599-1	LOC A	DIS 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	-	-	-	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	2-2119656-2	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	1-690438-0	FRONT STRIP GUIDE	96	
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95	
-	1	1	1	1	455888-6	SPACER, CRIMPER	82	
-	2	2	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)	79	
-	1	1	1	1	1633470-3	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	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62	
-	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61	
					5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	-	1	1	1338685-1	PAWL, FEED	56	
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	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	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	2119644-1	RAM WASHER, PRECISION	38	
	-	1	1	1	1	1-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33	
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32	
-	1	1	1	1	1320908-9	SPACER, STRIP GUIDE	30	
-	1	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28	
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27	
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26	
-	1	1	1	1	240792-1	DRAG, TERMINAL	25	
-	1	1	1	1	1320928-4	STRIP GUIDE	24	
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
-	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	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	2119805-1	SHEAR HOLDER, FRONT	10	
	-	1	1	1	454276-5	FLOATING SHEAR, FRONT	9	
	1	1	1	1	1-1333202-0	ANVIL, COMBINATION	8	
-	1	1	1	1	240641-4	SPACER	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
	1	1	1	1	1633965-4	CRIMPER, INSULATION O PREMIUM	3	
-	1	1	1	1	455888-4	SPACER, CRIMPER	2	
	1	1	1	1	1-456403-3	CRIMPER, WIRE PREMIUM	1	
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO	

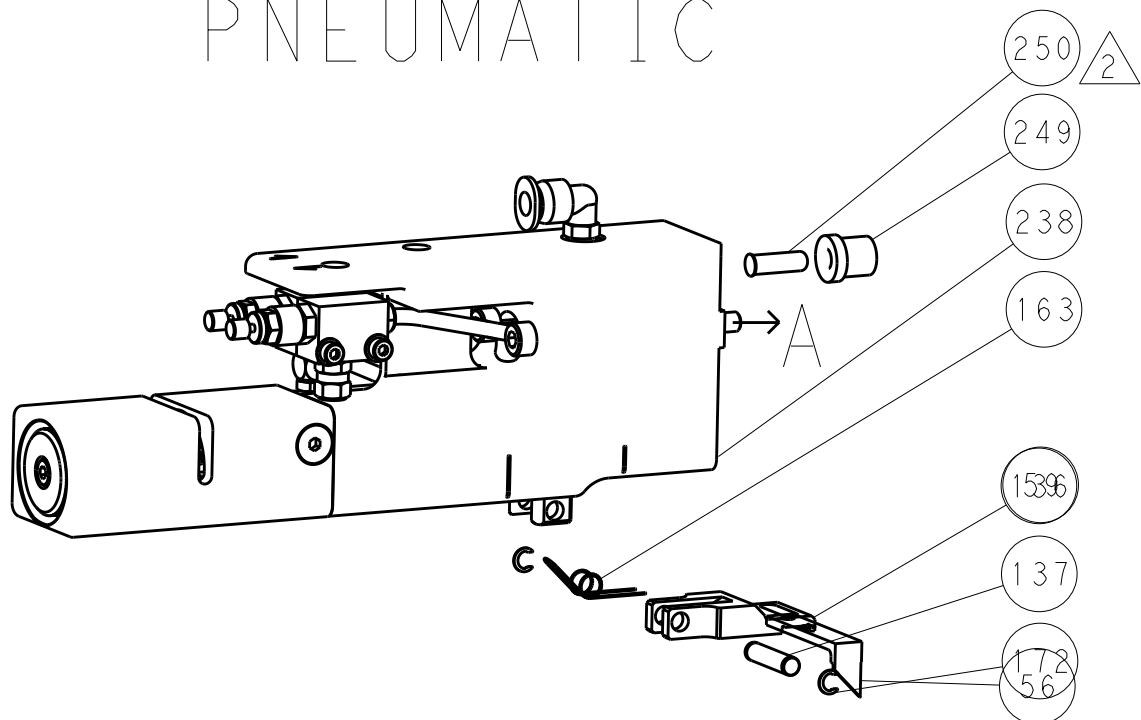
THIS DOCUMENT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION. SHOULD BE CONTACTED FOR THE LATEST EDITION.				OWN K. HUANG	23APR2013	TE Connectivity Harrisburg, PA 17105-3608		
				CHK L. ZHANG	23APR2013			
DIMENSIONS: mm				APVD J. GUO	23APR2013	NAME Ocean Side Feed Applicator		
				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±.5		PRODUCT SPEC		
						APPLICATION SPEC		
MATERIAL -				FINISH -		WEIGHT -		
						SIZE A1		
						CASE CODE 00779		
						DRAWING NO C=2151924		
						RESTRICTED TO -		
						Customer Accessible Production Drawing		
						SCALE 1:2		
						SHEET 3		
						OF 4		
						REV A1		

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

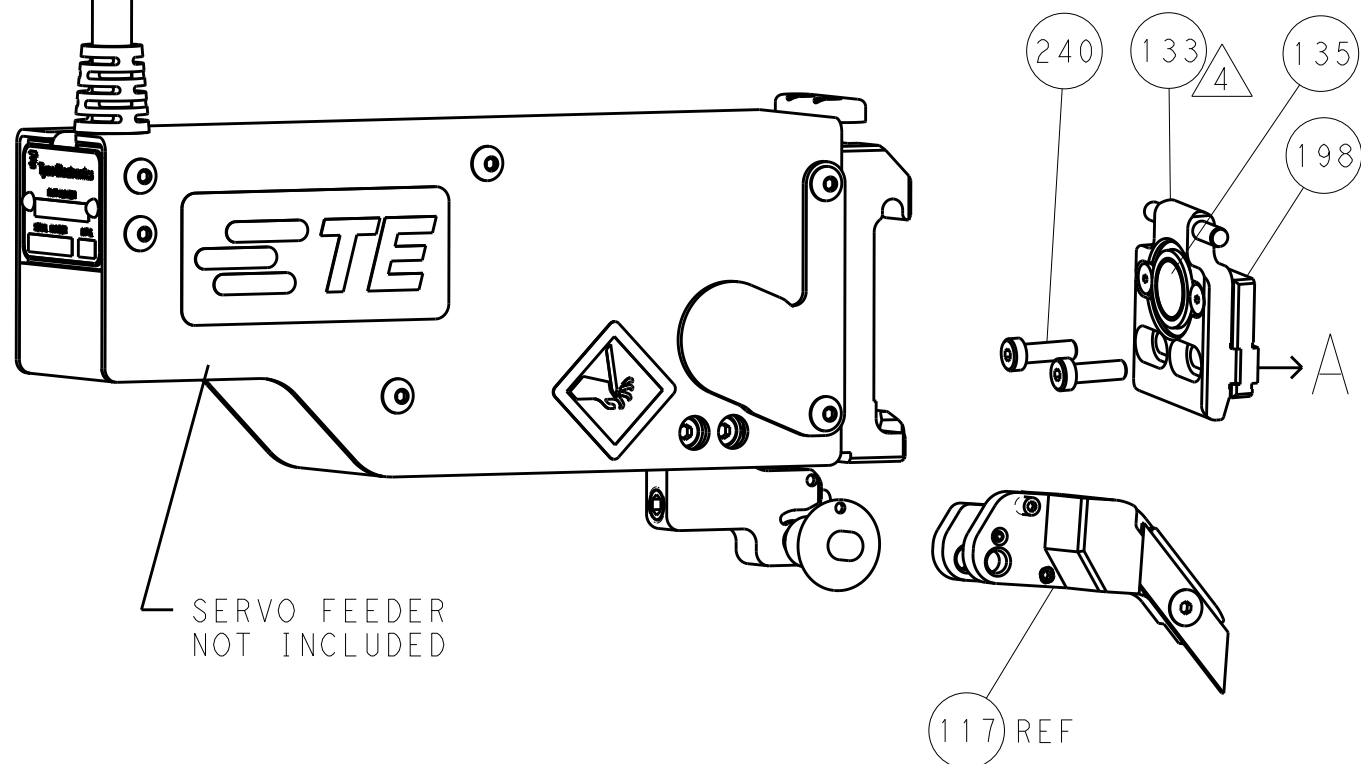
FEED TYPE MECHANICAL



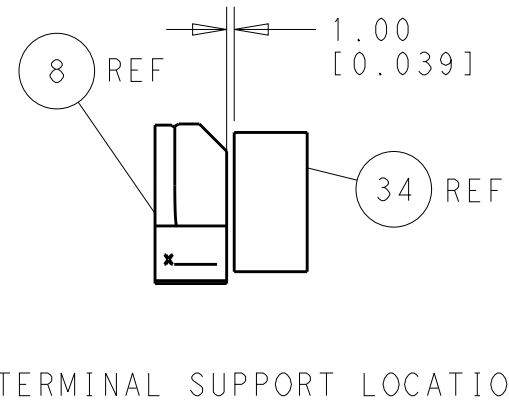
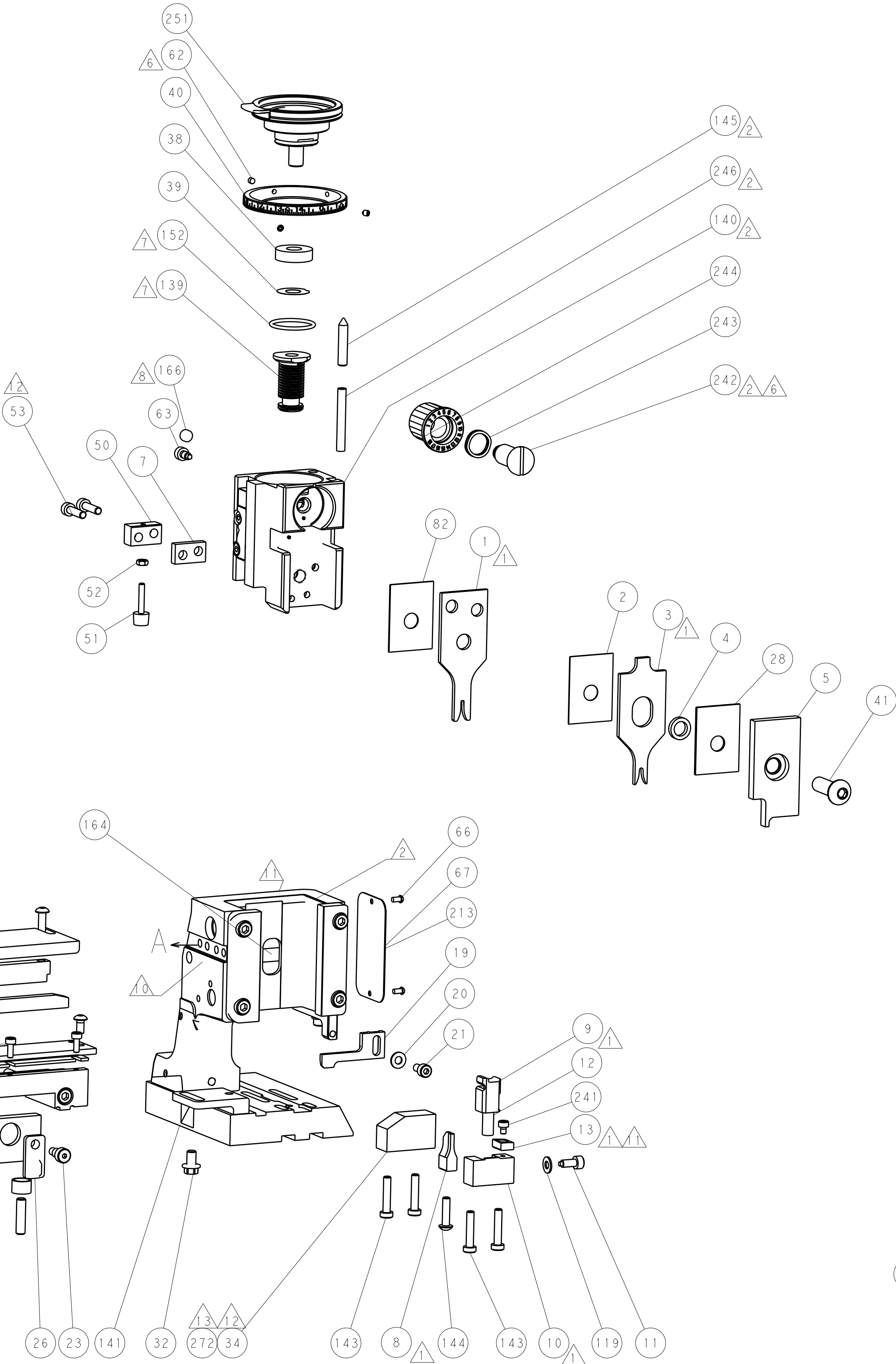
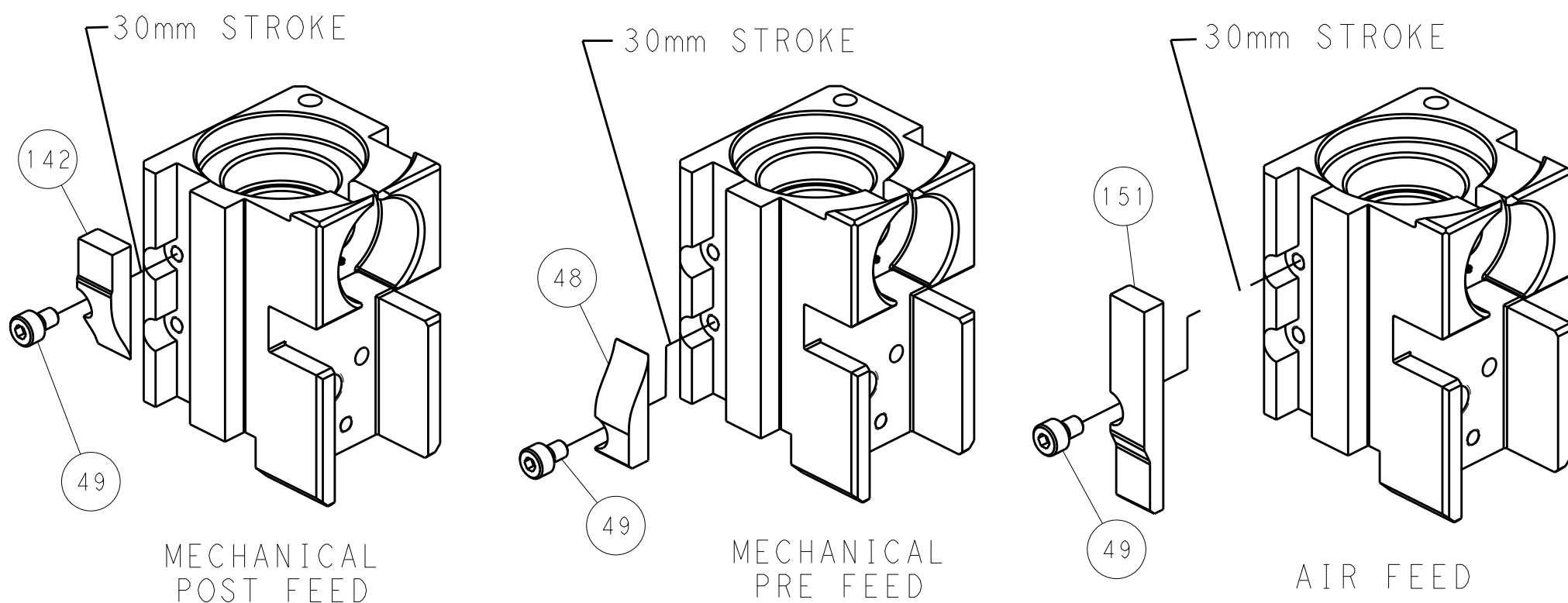
PNEUMATIC



SERVO LATCH PLATE

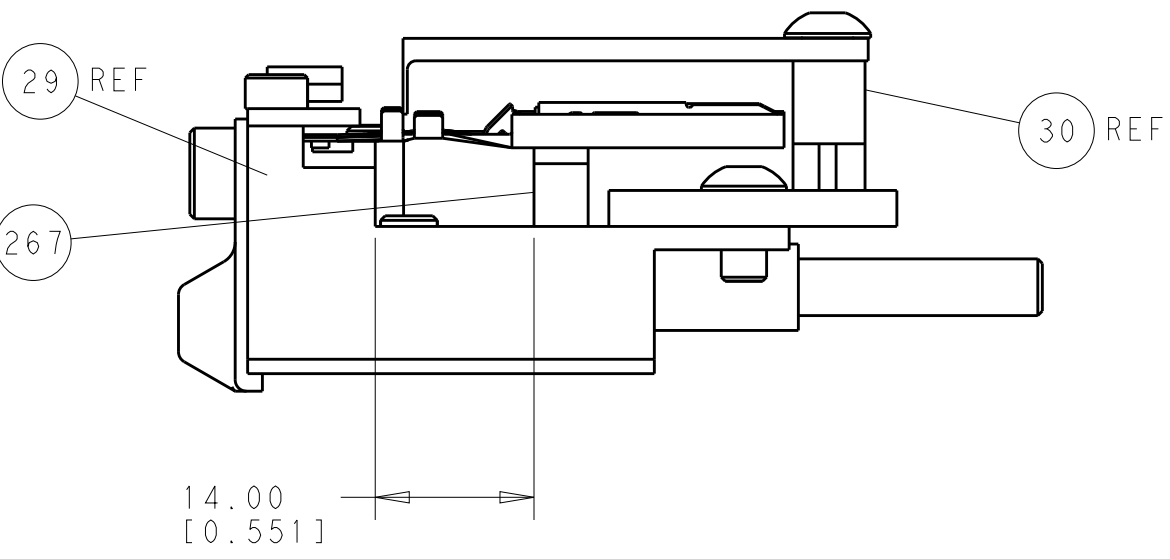


CAM POSITIONS



TERMINAL SUPPORT LOCATION

ITEM 30 LOCATED AT
REAR HOLES



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

FEED TRACK POSITION GUIDE BY INSULATION BARREL			
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
0 PLC ±.5		1 PLC ±0.13	
2 PLC ±0.13		3 PLC ±0.013	
4 PLC ±0.001		ANGLES FINISH	
MATERIAL		FINISH	
DWN: K. HUANG 23APR2013		CHK: L. ZHANG 23APR2013	
APVD: J. GUO 23APR2013		NAME: Ocean Side Feed Applicator	
PRODUCT SPEC		APPLICATION SPEC	
WEIGHT		SCALE 1:2	
Customer Accessible Production Drawing		SHEET 4 OF 4	
REV A1		REV A1	