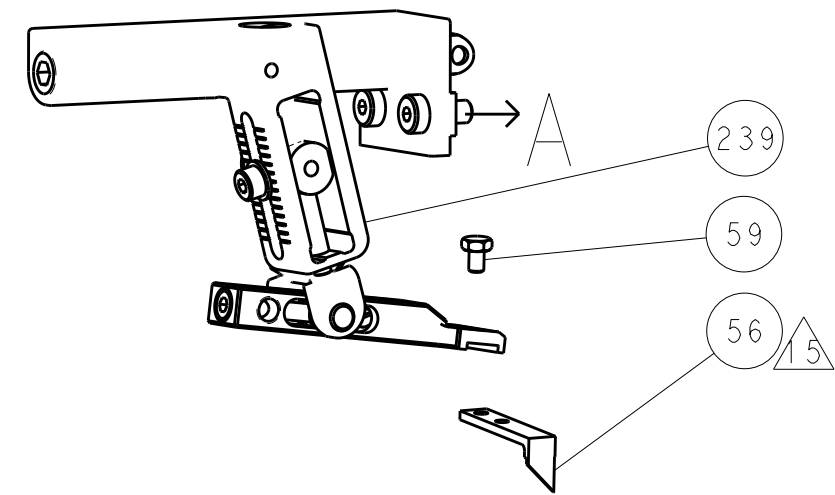
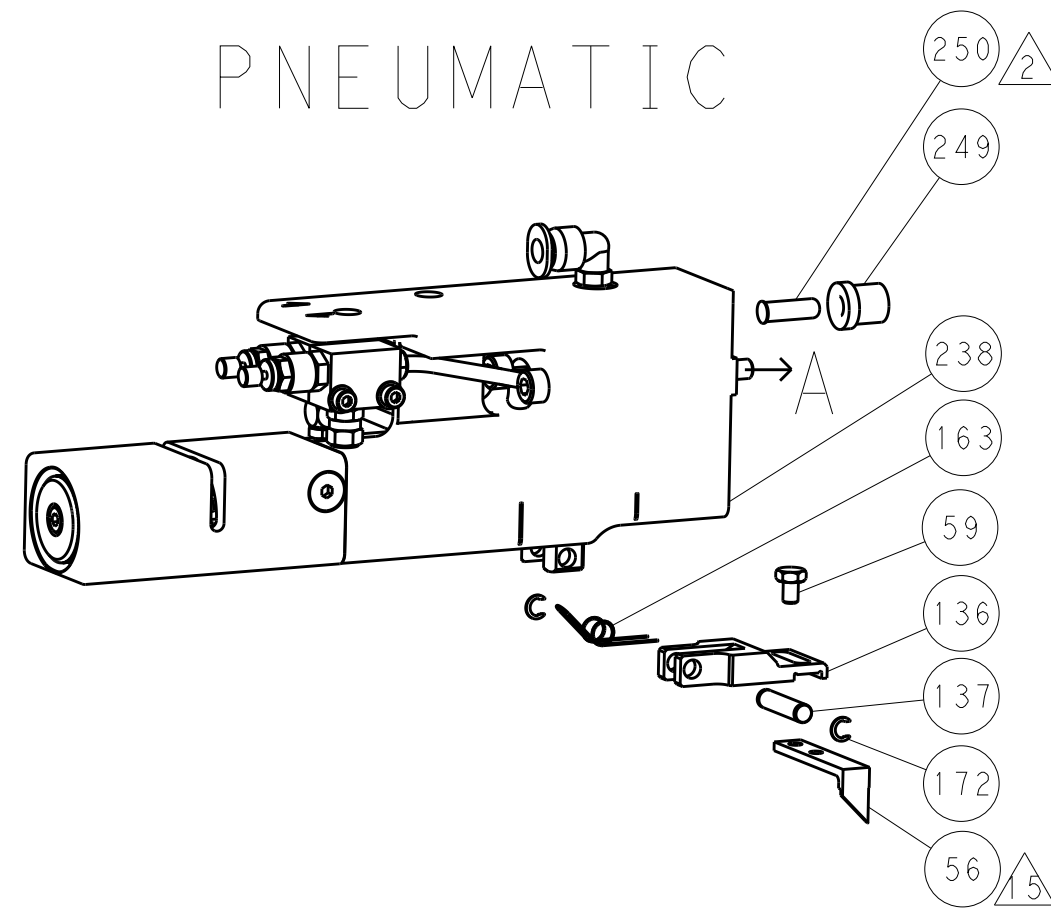


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		P	LTR	DESCRIPTION	DATE	DWN
A	66	-	-	SEE SHEET 1	-	-

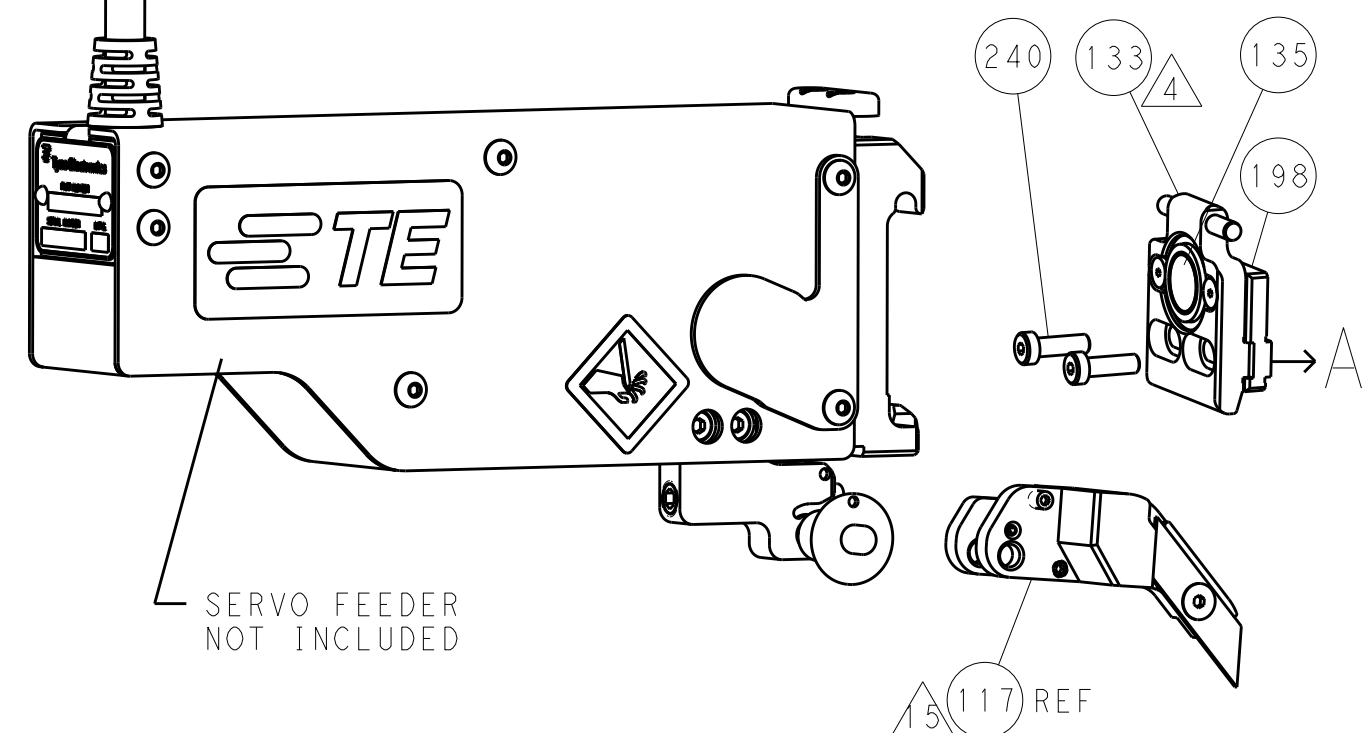
FEED TYPE
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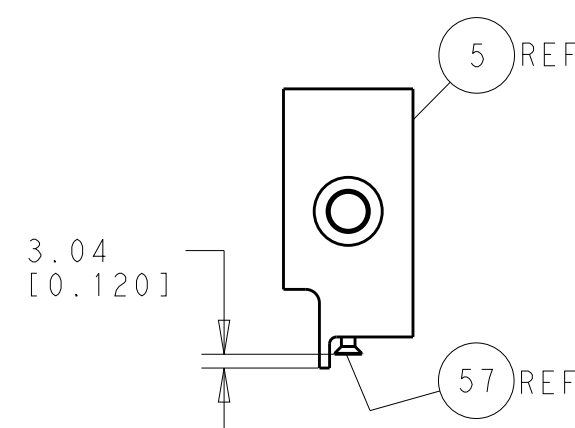
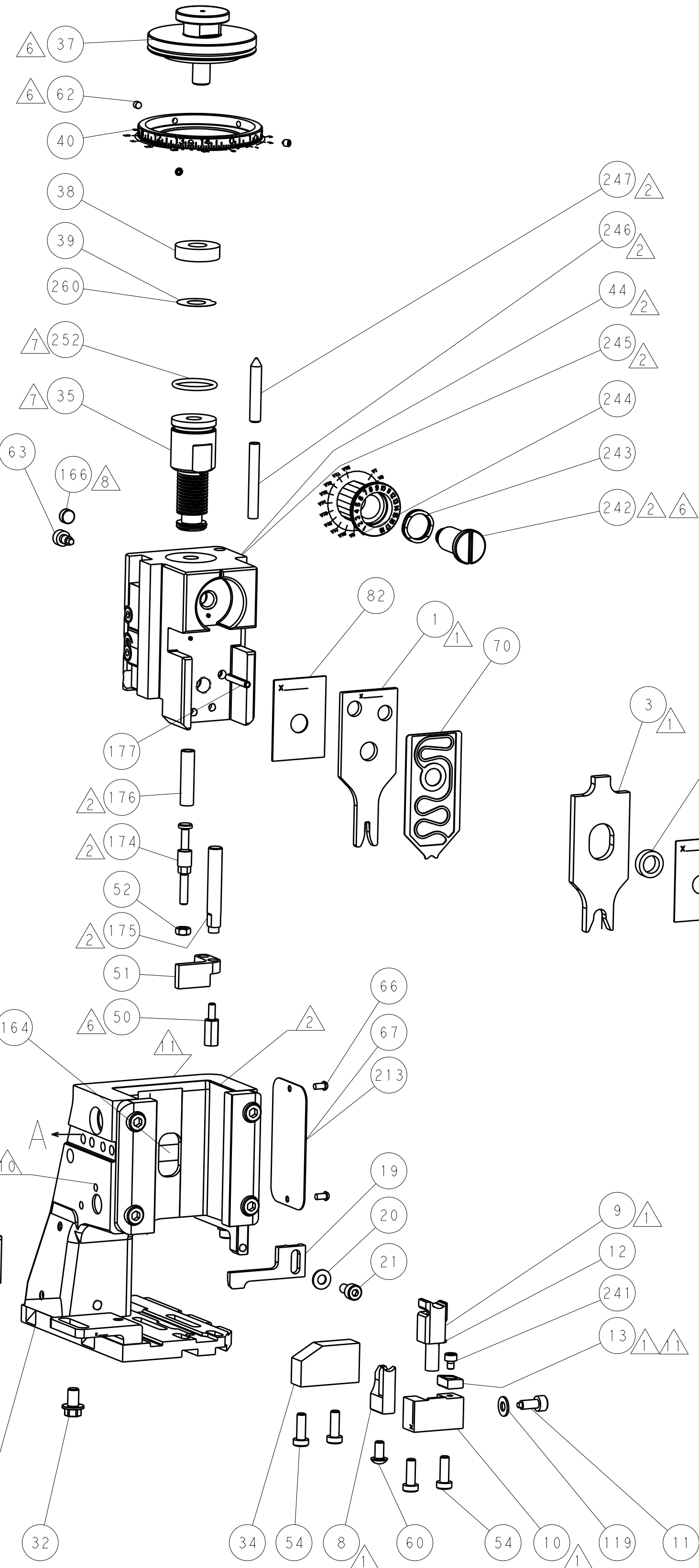
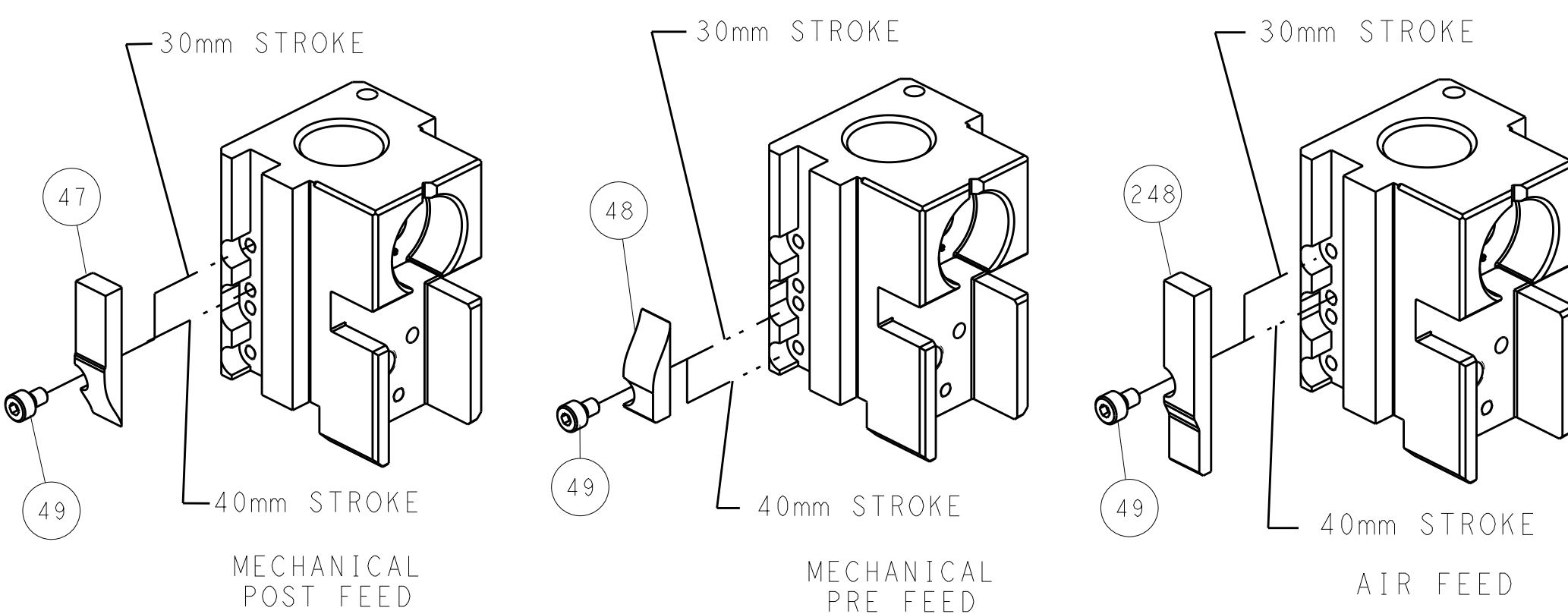
PNEUMATIC



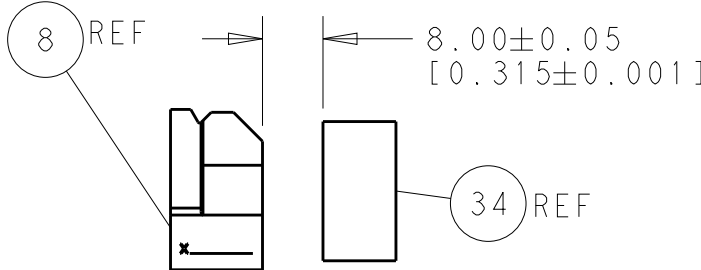
SERVO
LATCH PLATE



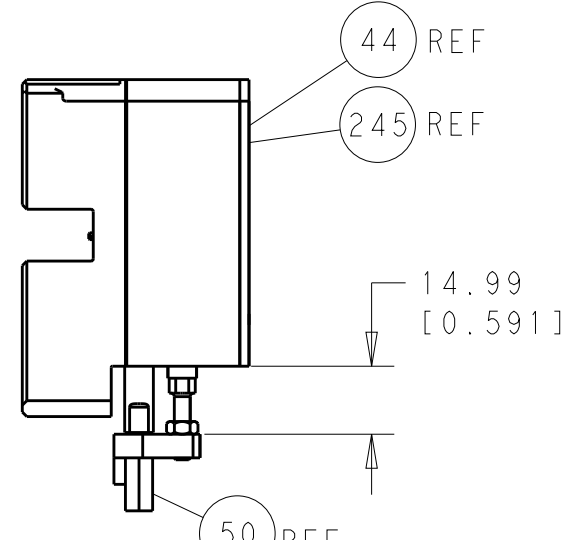
CAM POSITIONS



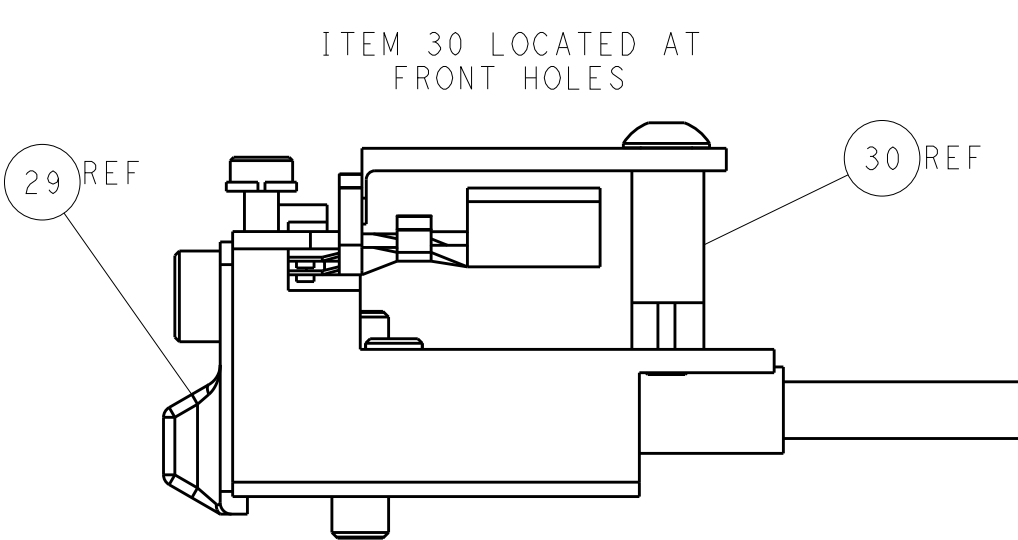
SHEAR DEPRESSOR DETAIL



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 090CE2011		TE Connectivity	
mm		0 PLC ±0.5		CHK G. BAILEY 090CE2011		Harrisburg, PA 17105-3608	
		1 PLC ±0.13		APVD S. XI 090CE2011		NAME Ocean Side Feed	
		2 PLC ±0.13		PRODUCT SPEC		Applicator	
		3 PLC ±0.13		APPLICATION SPEC		SIZE CAGE CODE DRAWING NO	
		4 PLC ±0.0001		WEIGHT		A1 00779 ©=2151323	
MATERIAL		FINISH		Customer Accessible Production Drawing		RESTRICTED TO	
				SCALE 1:2		SHEET 2 OF 4	
						REV B	

	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151323-1	B	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	-	8-2151323-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151323-4	-	-	-
	2-2151323-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC 	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151323-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151323-4	-	-	-
	2-2151323-5	B	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
2-2151323-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151323-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	6.35 mm [.250]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: DIA .4MM SOCKET CONTACT			
WIRE STRIP LENGTH 4.55-5.31 mm [.179-.209 IN]			INSULATION DIAMETER RANGE Ø 6.00mm MAX [.236 IN MAX]
TERMINAL APPLICATION SPECIFICATION 	114-18118 	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
962952-1	962952-2	963243-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.00mm2		1.43+/-0.05 [.056+/-0.002]		4.3
0.75mm2		1.34+/-0.05 [.053+/-0.002]		5.0
0.50mm2		1.26+/-0.05 [.050+/-0.002]		5.8



- 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: 8-2151323-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151323-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151323-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151323-6
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 & 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.
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.THE INSULATION RANGE LISTED IS FOR THE TERMINAL.THE INSULATION RANGE FOR THE SEAL IS Ø1.40-2.00mm.
- 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.
- MUST BE FED OFF OF SLOT ON CARRIOR STRIP

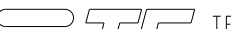
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-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)

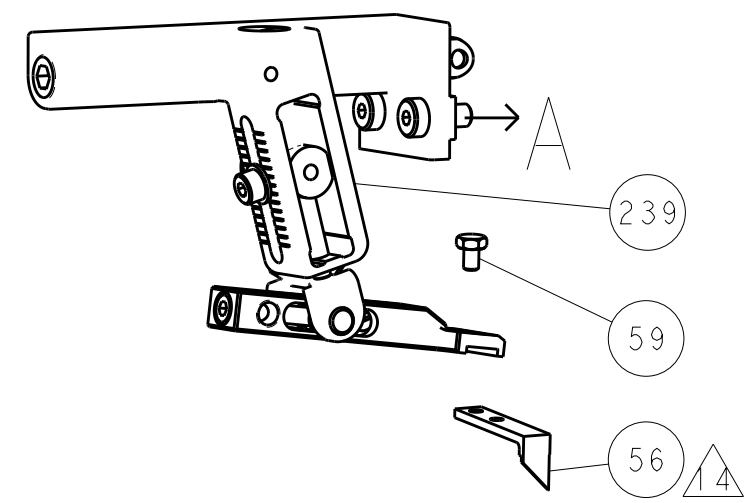
SET UP GAUGE 2119599-1	LOC A	DIS 66	REVISIONS						
			P	LTR	DESCRIPTION	DATE	OWN	APVD	
			-	-	SEE SHEET 1	-	-	-	

-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	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
-	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	1-2119791-0	DEPRESSOR, WIRE	70
-	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	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	2	2	2	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	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
	-	-	-	1	1338685-1	PAWL, FEED	56
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
	-	1	1	1	3-1752354-1	STANDOFF,HOLD-DOWN	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	2079383-5	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	1320908-7	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-2	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	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	3-22280-3	SPRING, COMPRESSION	12
	-	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	9-1333204-4	ANVIL, COMBINATION	8
-	1	1	1	1	2119781-5	DEPRESSOR, SHEAR	5
	-	1	1	1	238011-1	BLOCK, CRIMPER SPACER	4
	1	1	1	1	2-1803019-2	CRIMPER, INSULATION O	3
	1	1	1	1	2-456405-8	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

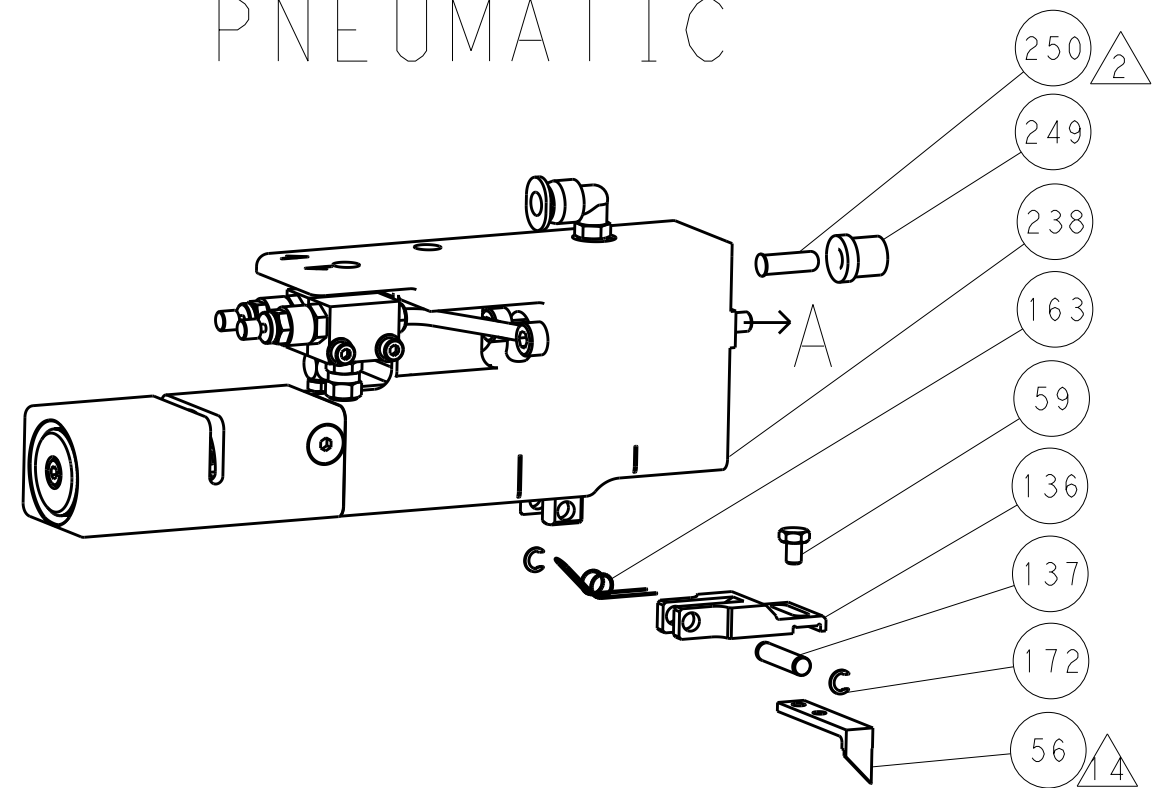
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE ISSUING ORGANIZATION. NO OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.				DRAWN T.YIN 090CE2011		 TE Connectivity Harrisburg, PA 17105-3608			
				CHECKED G.BAILEY 090CE2011					
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPROVED S.XI 090CE2011		NAME			
mm		0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001		PRODUCT SPEC		Ocean Side Feed Applicator			
		FINISH		APPLICATION SPEC					
MATERIAL		FINISH		WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
-		-		-		A1	00779	C=2151323	-
Customer Accessible Production Drawing						SCALE	1:2	SHEET 3 OF 4	REV B

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

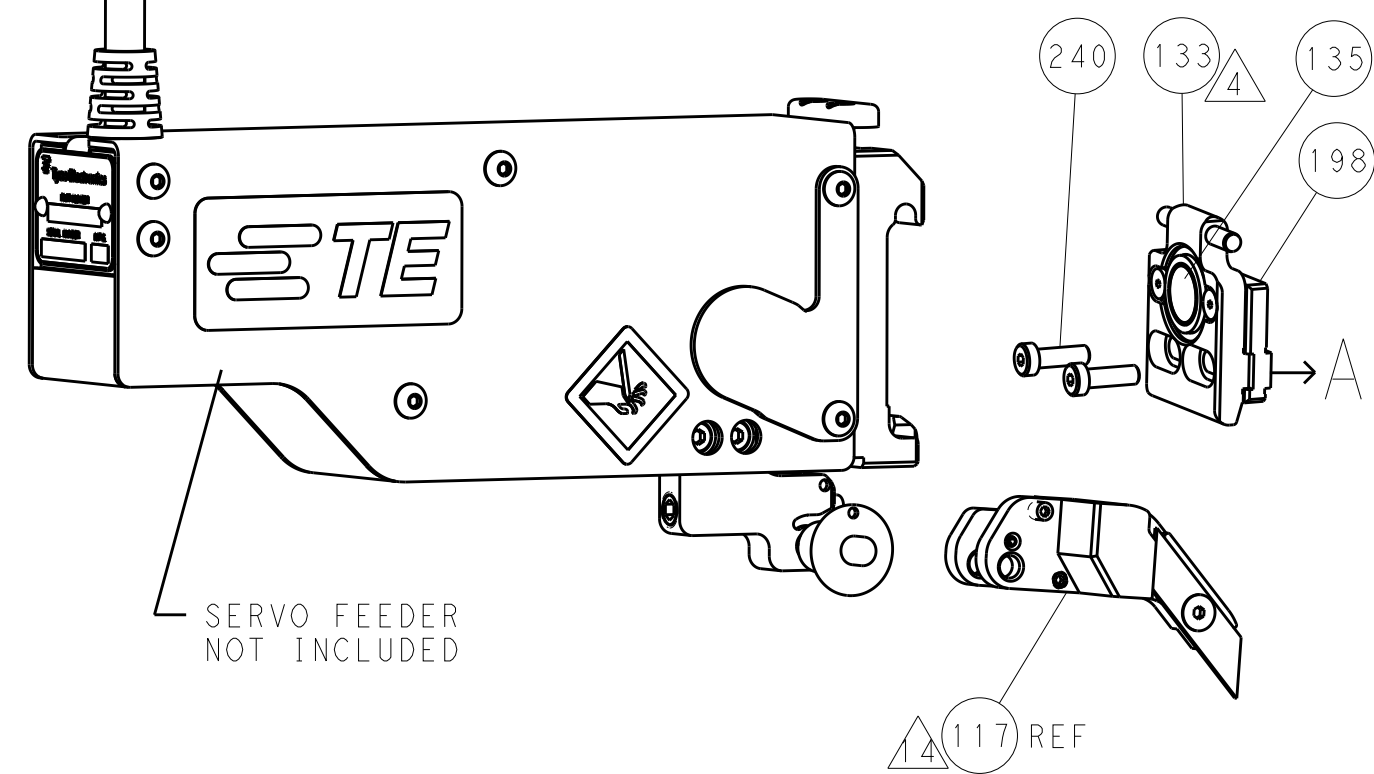
FEED TYPE MECHANICAL



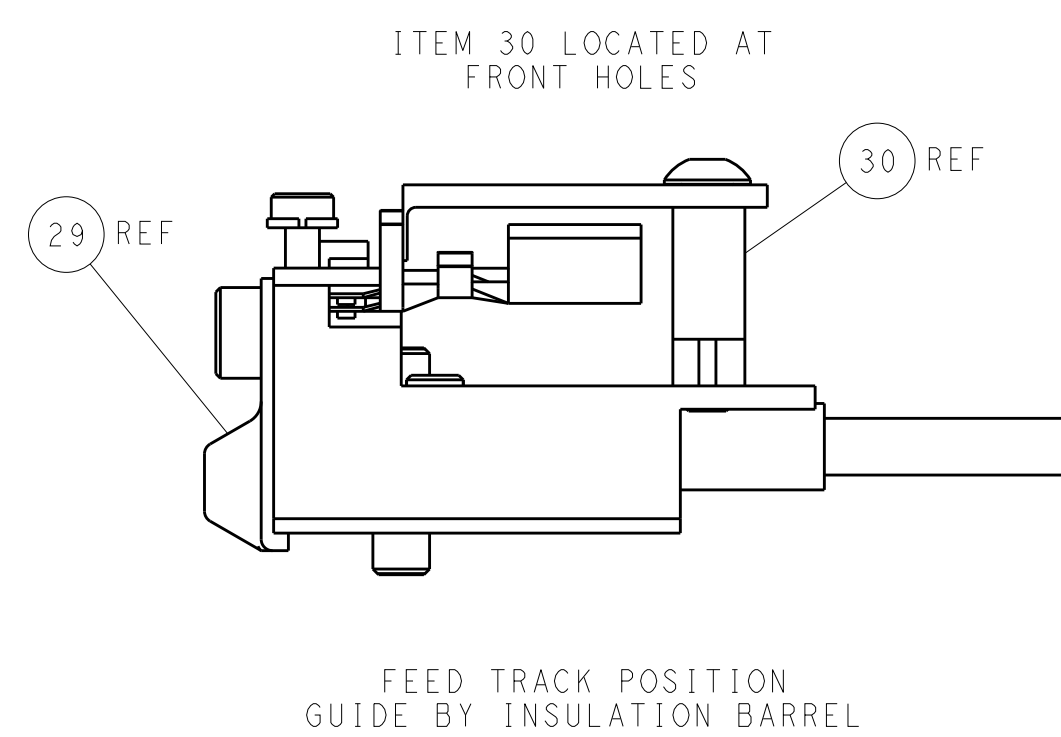
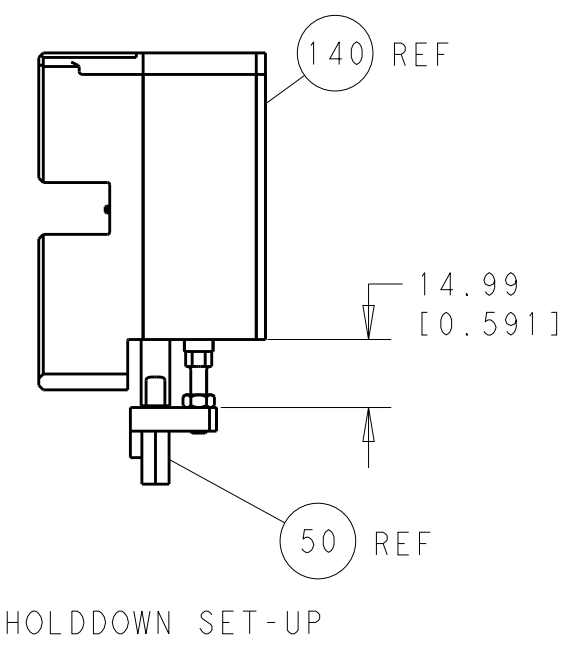
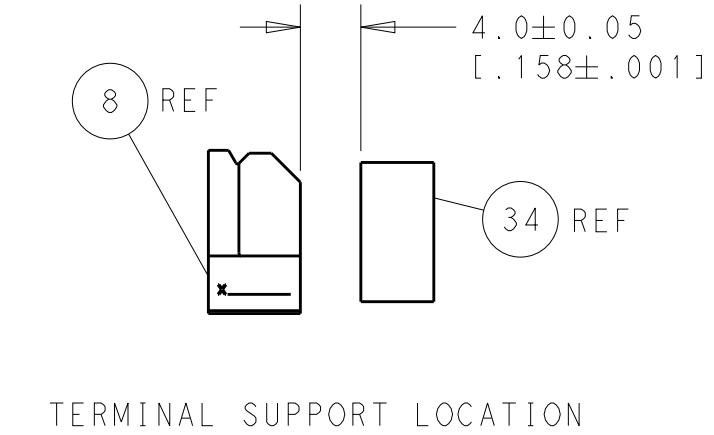
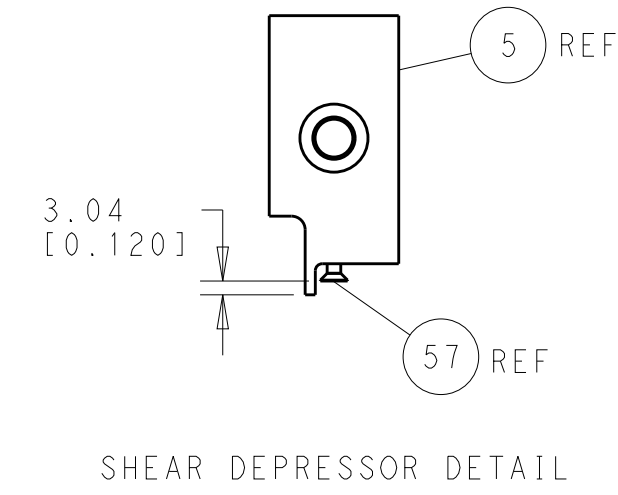
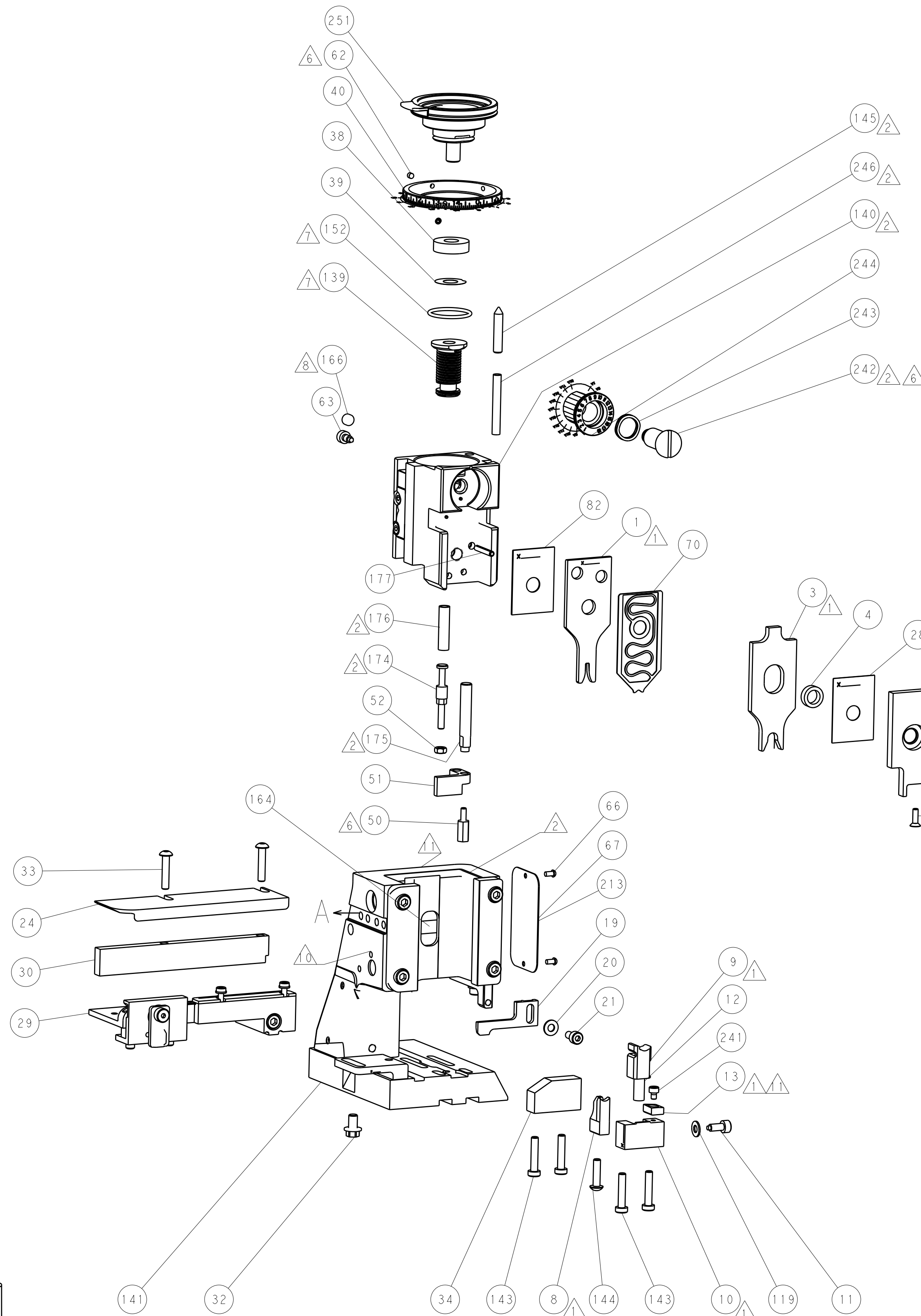
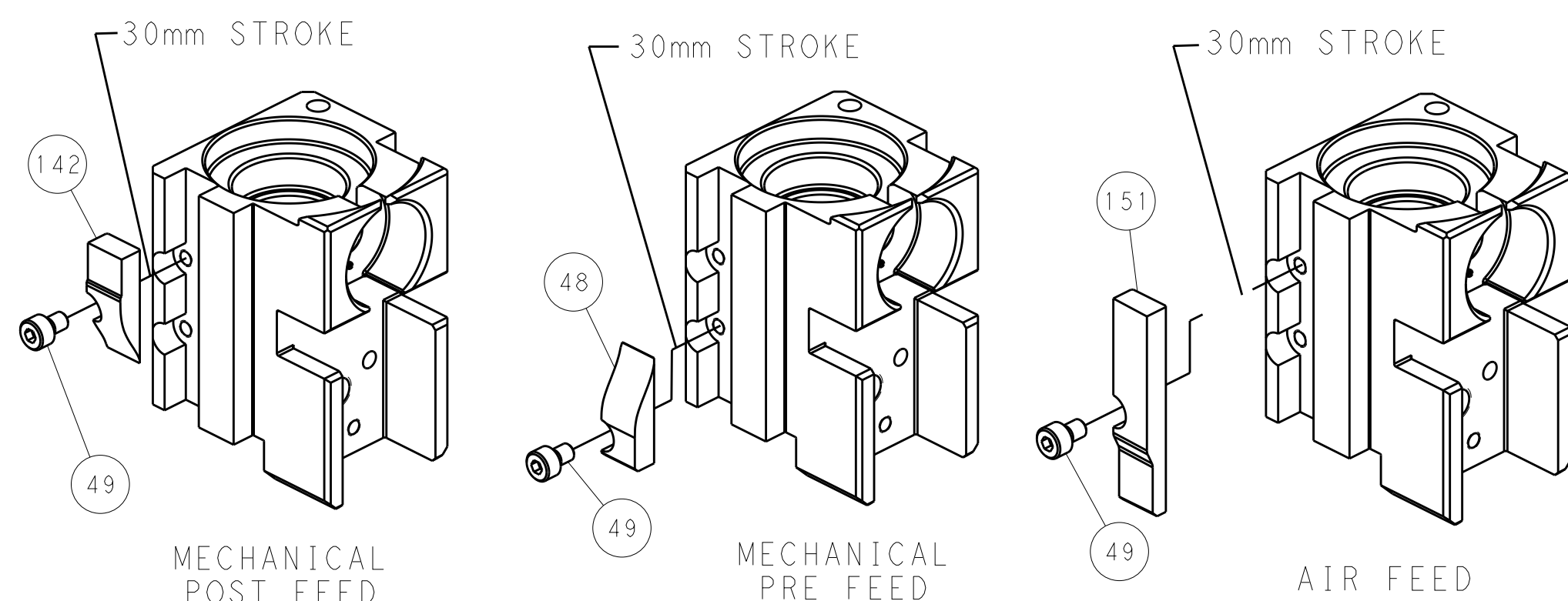
PNEUMATIC



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)

FIRST PUBLISHED BY: 090CE2011 THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.				OWN Y. YIN 090CE2011 CHK G. BAILEY 090CE2011 APVD S. XI 090CE2011		 TE Connectivity Harrisburg, PA 17105-3608									
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME Ocean Side Feed Applicator		SIZE -		CAGE CODE -		DRAWING NO -		RESTRICTED TO -	
mm		0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001		APPLICATION SPEC											
		FINISH		WEIGHT		A1 00779 C=2151323		SCALE		1:2		SHEET 4 OF 4		REV B	
MATERIAL		-		-		-		-		-		-		-	