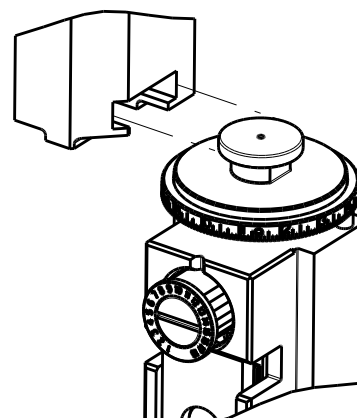


8		7		6		5		4		3		
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		28								
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION, ALL RIGHTS RESERVED.										
	ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
						SERVO LATCH PLATE	2119951-1	-	8-2266152-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2266152-4	-	-	-
						MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
						SERVO LATCH PLATE	2119951-1	-	8-2266152-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2266152-4	-	-	-
						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
						-	-	-	-	-	-	-
						-	-	-	-	-	-	-
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-	-	-	-	-	-	-	
					-							

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO QUADOCK SYSTEM			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.05-3.35 mm [.120-.132 IN]			Ø1.15-1.60 mm [.045-.063 IN]
TERMINAL APPLICATION SPECIFICATION	114-18021		
			

TERMINALS APPLIED			
GROUP 1 		GROUP 2 	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928999-1	5-928918-2	968220-1	1703296-1
928999-5	5-928918-1	968220-5	1703296-5
928999-6	6-928918-1	968220-6	1534116-1
5-928999-1	6-928918-2	5-968220-1	1534116-2
968893-1	6-928918-3	5-968220-5	5-1534116-1
928918-1	1394702-1	5-968220-6	5-1534116-2
928918-2	1394702-2		1241918-1
1-928918-1	5-1394702-1		
1-928918-2	5-1394702-2		
5-928999-5	5-928999-6		
6-928999-5			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.50mm2		0.86+/-0.03 [0.034+/- .001]		5.0
0.35mm2		0.76+/-0.03 [0.030+/- .001]		6.1
0.25mm2		0.72+/-0.03 [0.028+/- .001]		6.6

- 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 C ASSEMBLY. SEE BELOW FOR PART NUMBER:

MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION:	8-2
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION:	8-2
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST":	8-2
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST":	8-2

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 50
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 24
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS

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.

 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

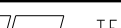
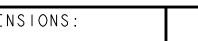
 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12 WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR
USE SHIM PACK 2119957-2 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 0.005 INCHES

△3 REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3
CONCERNING CRIMPING 0.50mm² WIRE.

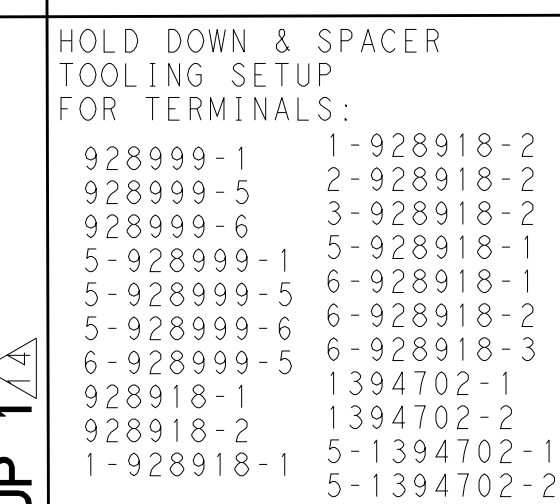
				2						I	
SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS							
P	LTR	DESCRIPTION					DATE	DWN	APV		
	B	ECR-14-D04853					04APR2014	RK	TE		
	C	ECR-14-018945					19DEC2014	KH	LG		
	C1	ECR-15-013464					14SEP2015	YY	UG		

	-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	23
	-	-	-	-	-	1	2063440-1	AIR FEED MODULE	23
	-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	21
	-	-	1	1	-	-	1901094-3	SPACER, FEEDER	19
	-	1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	17
	-	1	1	1	1	1	5-22280-0	SPRING, COMPRESSION	17
	-	1	1	1	1	1	1752353-3	GUIDE PIN, HOLDDOWN	17
	-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	17
	-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	17
	-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	16
	-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	16
	-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	16
	-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	13
	-	-	-	-	1	-	2119799-1	HOLDER, FEED FINGER, AF	13
	-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	13
	-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	13
	-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	11
	-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	11
	-	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
	-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
15, 14	-	1	1	1	1	1	1-240641-3	SPACER	81
	-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
	-	1	1	1	1	1	1633782-2	FENCE	78
	-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
	-	1	1	1	1	1	2119943-1	WASHER, SPACER	69
	-	1	-	-	-	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
6	-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	61
	-	2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	62
	-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
	-	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	-	-	-	1	1338685-1	PAWL, FEED	56
	-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
	-	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
	-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	51
6	-	1	1	1	1	1	1-1752354-7	STANDOFF, HOLD-DOWN	50
	-	-	-	-	-	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	-	-	-	-	1	2119653-1	FEED CAM, POST FEED	47
	-	1	1	1	1	1	2-2119656-1	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
	-	1	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
6	-	1	1	1	1	1	1-2119644-4	RAM WASHER, PRECISION	38
	-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
	-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
	-	1	1	1	1	1	1320908-6	SPACER, STRIP GUIDE	30
	-	1	1	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
	-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
	-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
15, 14	-	1	1	1	1	1	1803155-1	HOLD DOWN, TERMINAL	18
1	-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
	-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1	1-1338690-2	ANVIL, COMBINATION .055	8
15, 14	-	1	1	1	1	1	4-240641-2	SPACER	7
	-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
	-	1	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1	2119784-2	CRIMPER, INSULATION O PREMIUM	3
	-	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	1	1	1	1-562108-5	CRIMPER, WIRE, F	1
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM

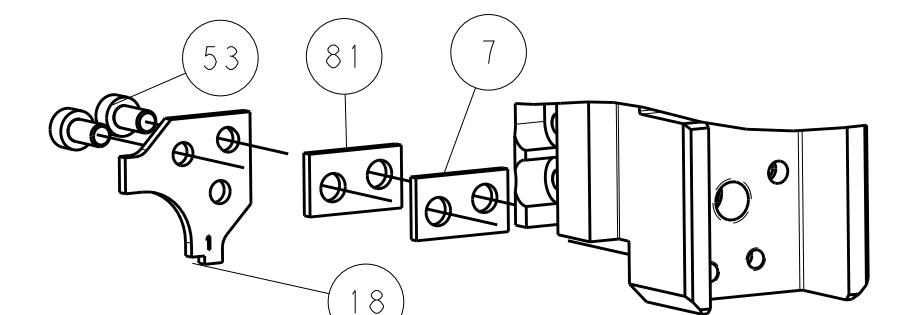
THIS DRAWING IS A COMPUTER GENERATED FILE. NO ELECTRONIC SIGNATURES OR COMMENTS ARE TO BE MADE ON THIS DRAWING. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN YIN 26DEC2013	 TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm		CHK G. BAILEY 26DEC2013	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC APD U GAO 26DEC2013	
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		APPLICATION SPEC	SIZE A
MATERIAL -	FINISH -	WEIGHT -	CASE CODE 00779
		DRAWING NO C-2266152	RESTRICTED -
		Customer Accessible Production Drawing	SCALE 1:2
		SHEET 1	OF 4
		REV C2	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

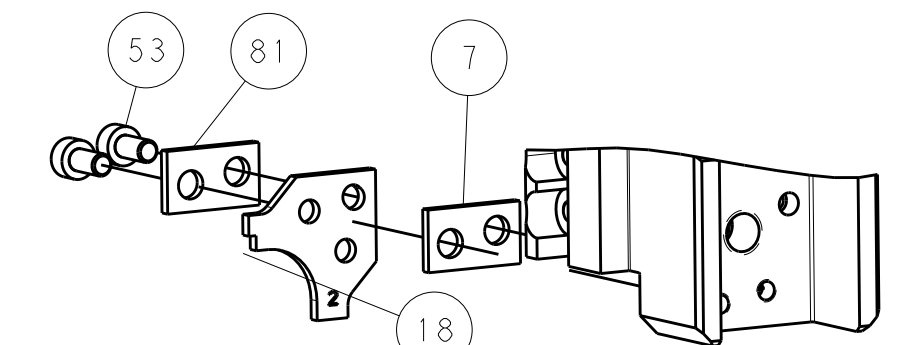
TERMINAL HOLD DOWN & SPACER SETUP CHART



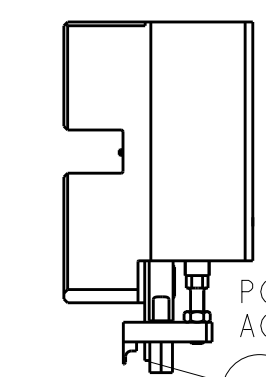
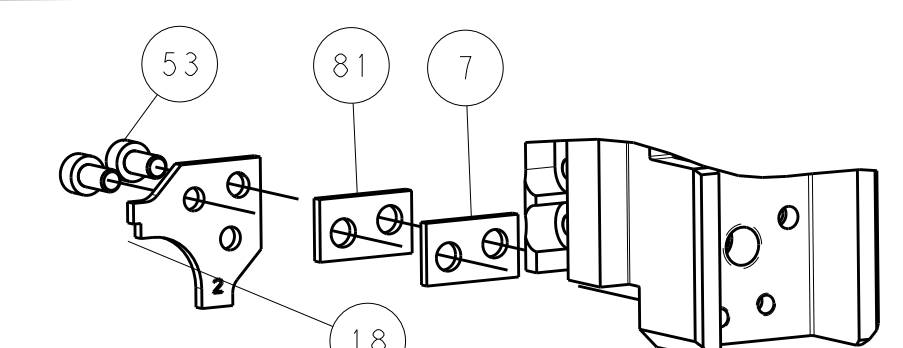
**HOLD DOWN & SPACER
TOOLING SETUP
FOR TERMINALS:**



	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:
--	---

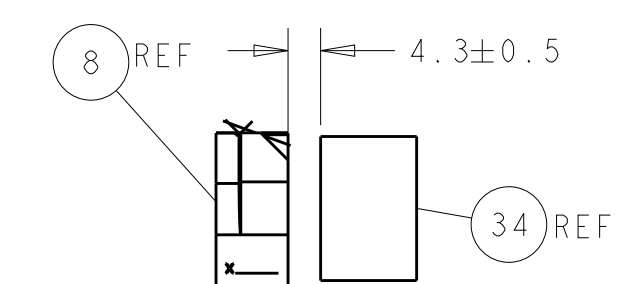


HOLD DOWN & SPACER
TOOLING SETUP
FOR TERMINALS:

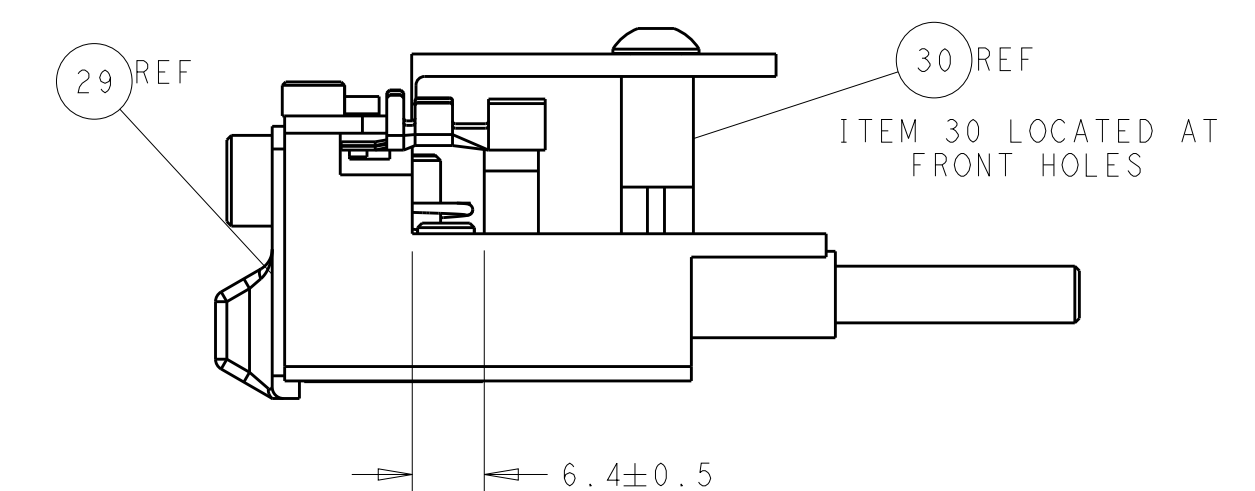


POSITION TOP EDGE OF HOLD DOWN
AGAINST BOTTOM SURFACE OF RAM

HOLD DOWN SETUP

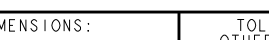


TERMINAL SUPPORT LOCATION

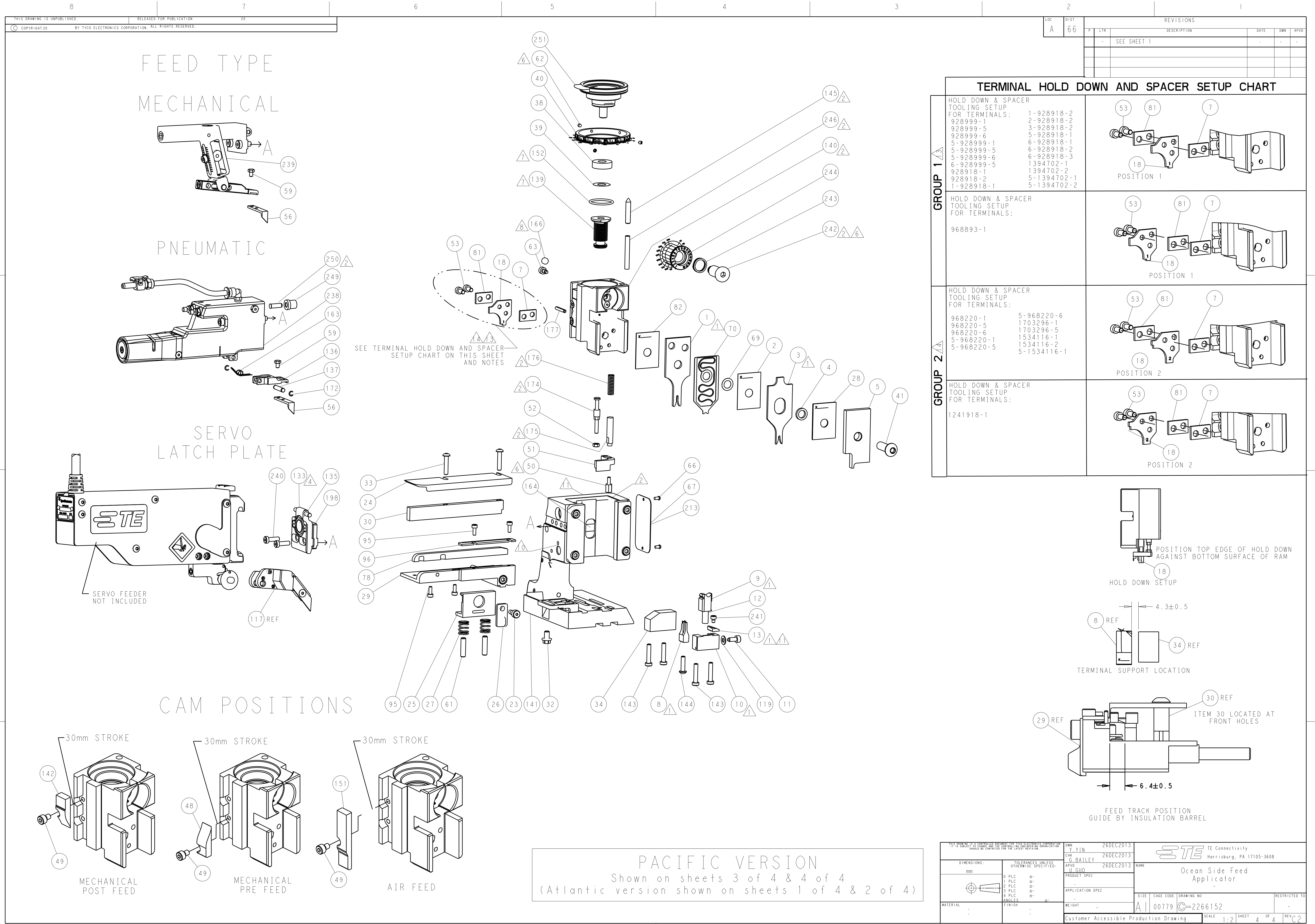


FEED TRACK POSITION
GUIDE BY INSULATION BARREL



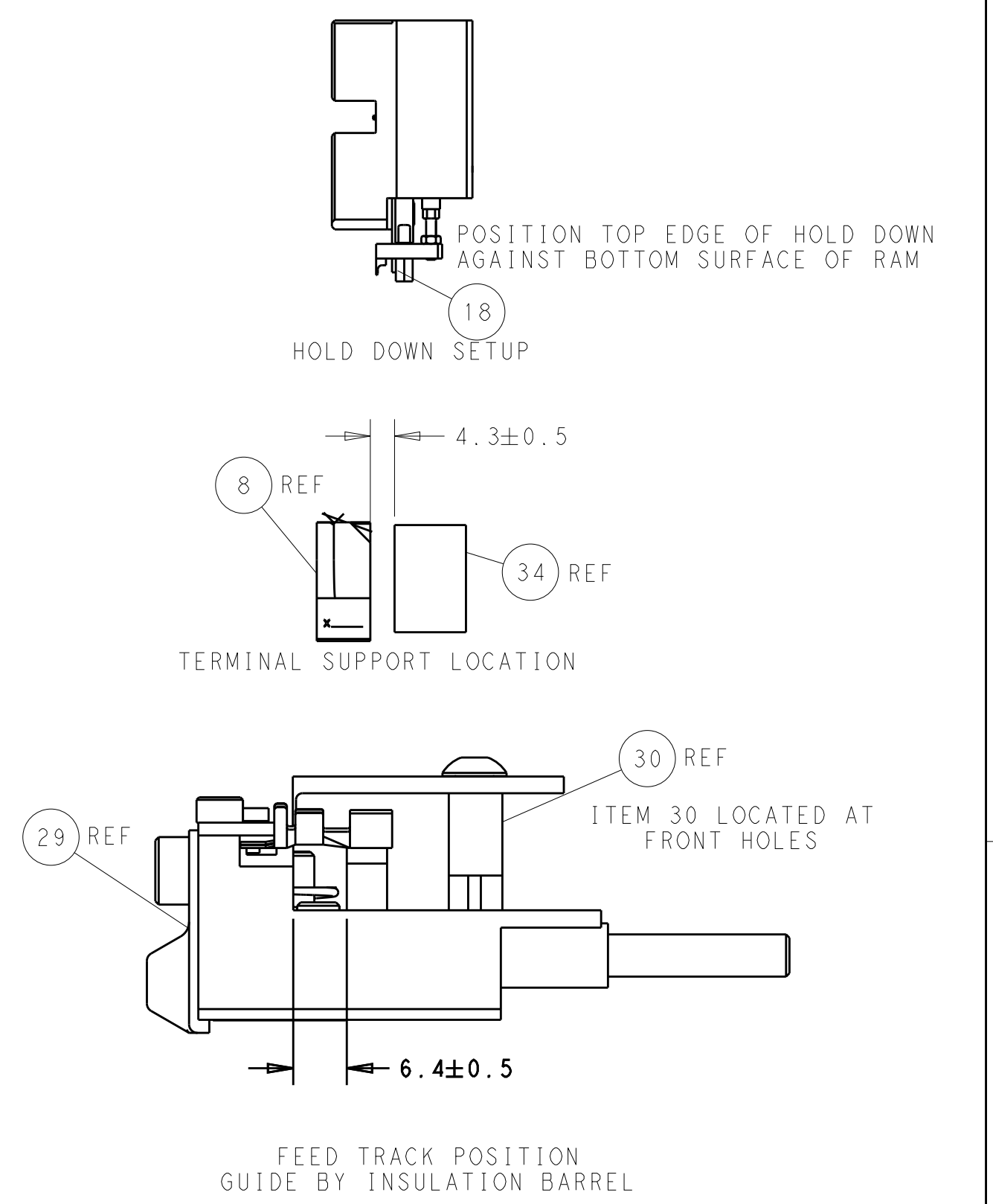
*THIS DRAWING IS A TECHNICAL DOCUMENT FOR YOUR BUSINESS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING/ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISIONS		DWN Y_YIN 26DEC2013 CHK G_BALEY 26DEC2013 U_GUO 26DEC2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±. FINISH -		NAME Ocean Side Feed Applicator PRODUCT SPEC - APPLICATION SPEC -	
		SIZE A 00779 C=2266152		DRAWING NO. RESTRICTED TO	
MATERIAL -		WEIGHT -		SCALE 1:2 SHEET 2 OF 4 REV C	
Customer Accessible Production Drawing					

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



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

TERMINAL HOLD DOWN AND SPACER SETUP CHART			
GROUP 1	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	1-928918-2 2-928918-2 3-928918-2 5-928918-1 6-928918-1 5-928918-2 6-928918-2 5-928918-3 1394702-1 1394702-2 5-1394702-1 5-1394702-2	 POSITION 1
	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	968893-1	 POSITION 1
GROUP 2	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	968220-1 968220-5 968220-6 5-968220-1 5-968220-5	5-968220-6 1703296-1 1703296-5 1534116-1 1534116-2 5-1534116-1
	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	1241918-1	 POSITION 2



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 UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY. THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION.		OWN Y. YIN 26DEC2013	NAME Ocean Side Feed Applicator
DIMENSIONS: mm		CHK G. BAILEY 26DEC2013	SIZE A1
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		PRODUCT SPEC APPLICATION SPEC WEIGHT	SCALE 1:2
MATERIAL		Customer Accessible Production Drawing	SHEET 4 OF 4 REV C2