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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

4.20 mm [.165]

F

INSUL

6.20 mm [.244]

OV

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: 8mm NGI TAB

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

6.50-7.50 mm [.256-.295 IN]

Ø3.35-4.30 mm [.132-.169 IN]

TERMINAL APPLICATION SPECIFICATION

114-15112

-

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE SEAL

TE SEAL

1544332-1

1544316-1

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

6.00mm2

2.95+/-0.05 [.116+/- .002]

5.3

5.00mm2

2.80+/-0.05 [.110+/- .002]

7.2

4.00mm2

2.65+/-0.05 [.104+/- .002]

8.6

3.00mm2

2.50+/-0.05 [.098+/- .002]

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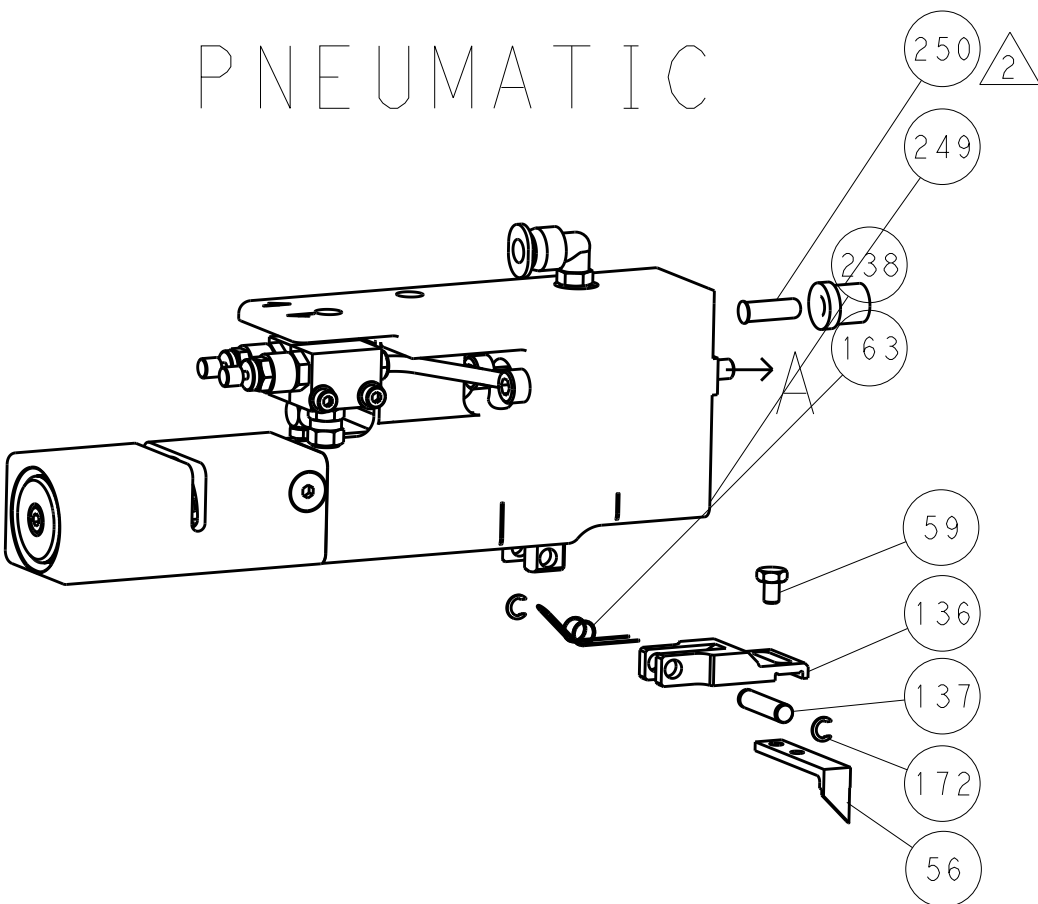
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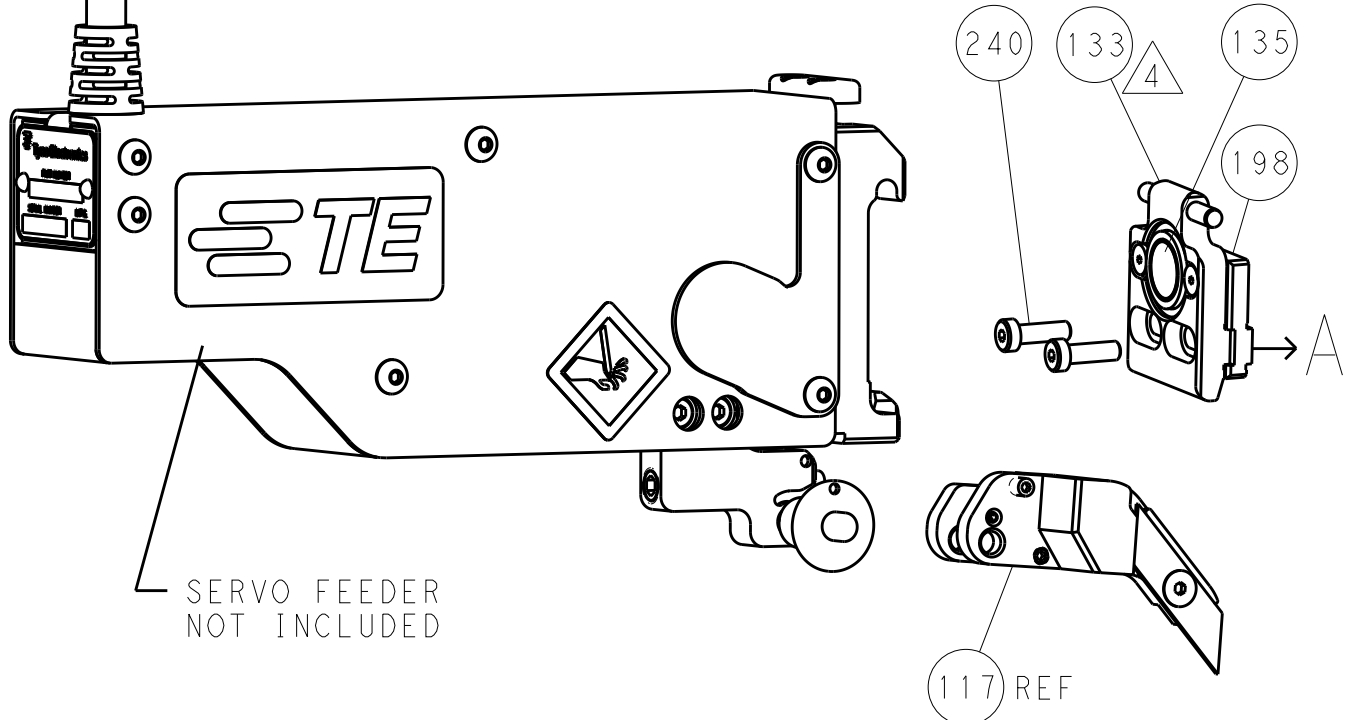
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

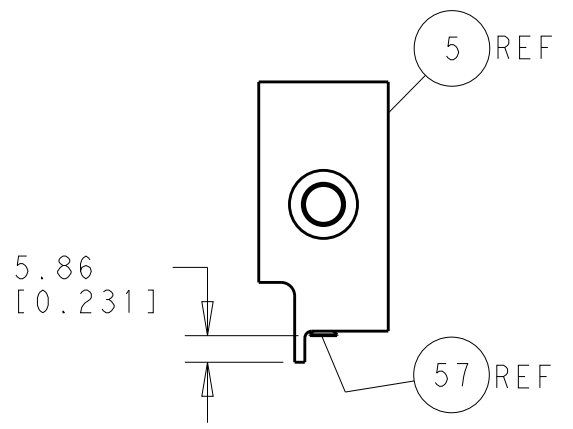
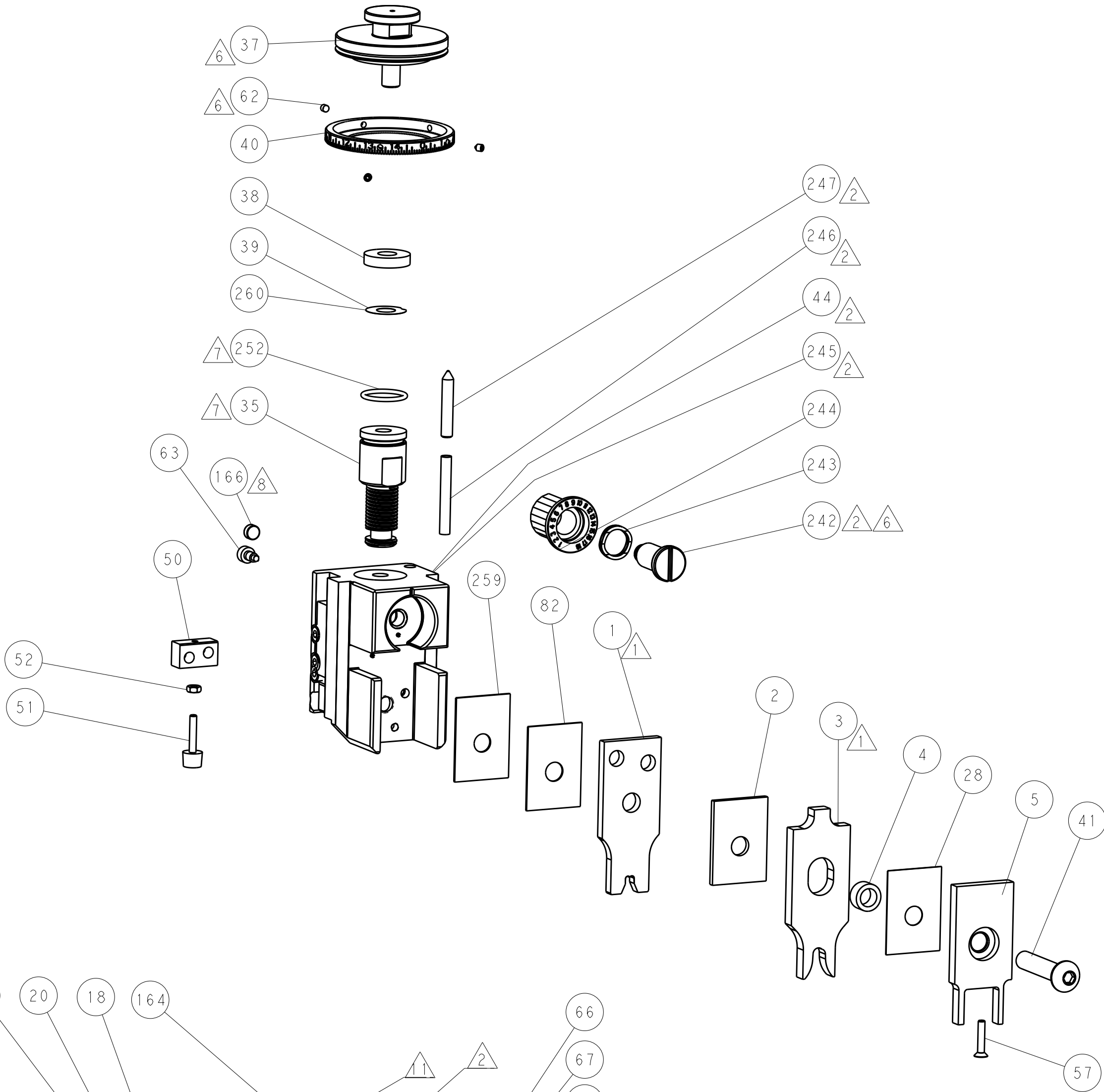
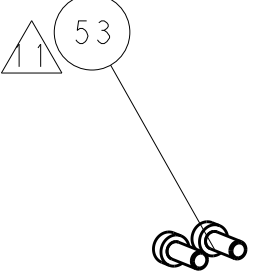
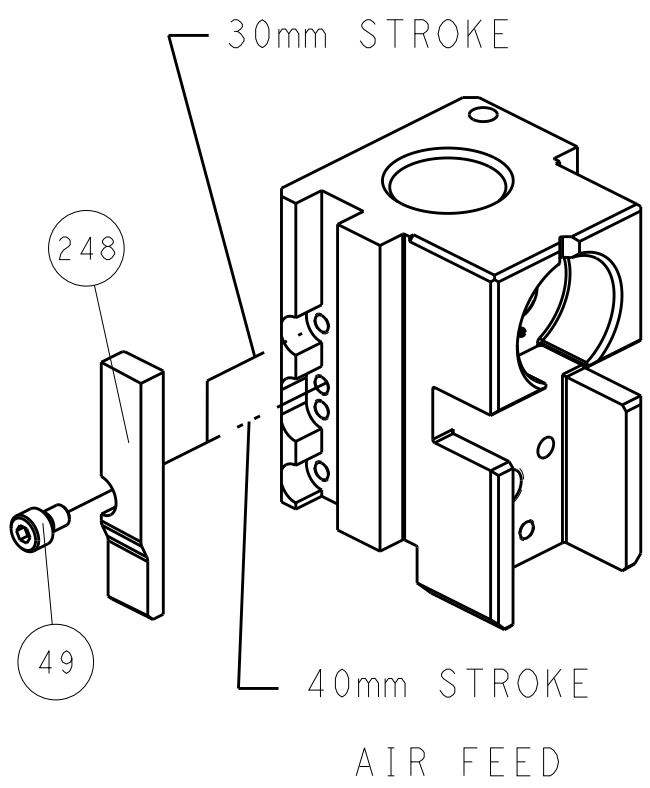
PNEUMATIC



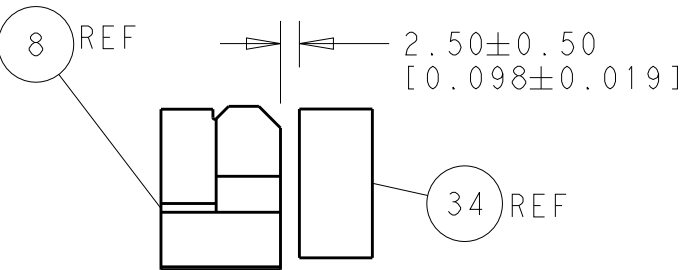
SERVO LATCH PLATE



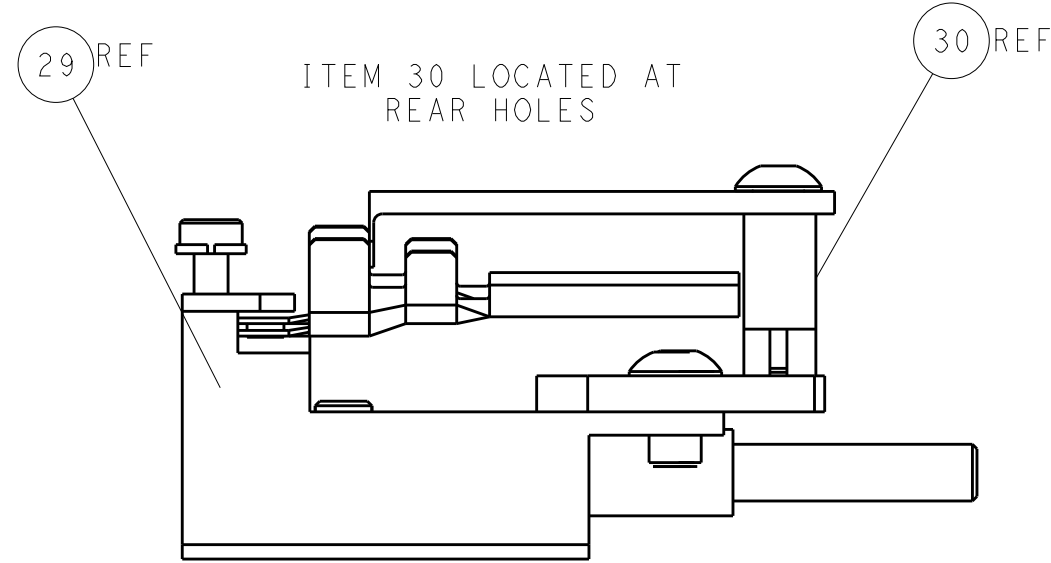
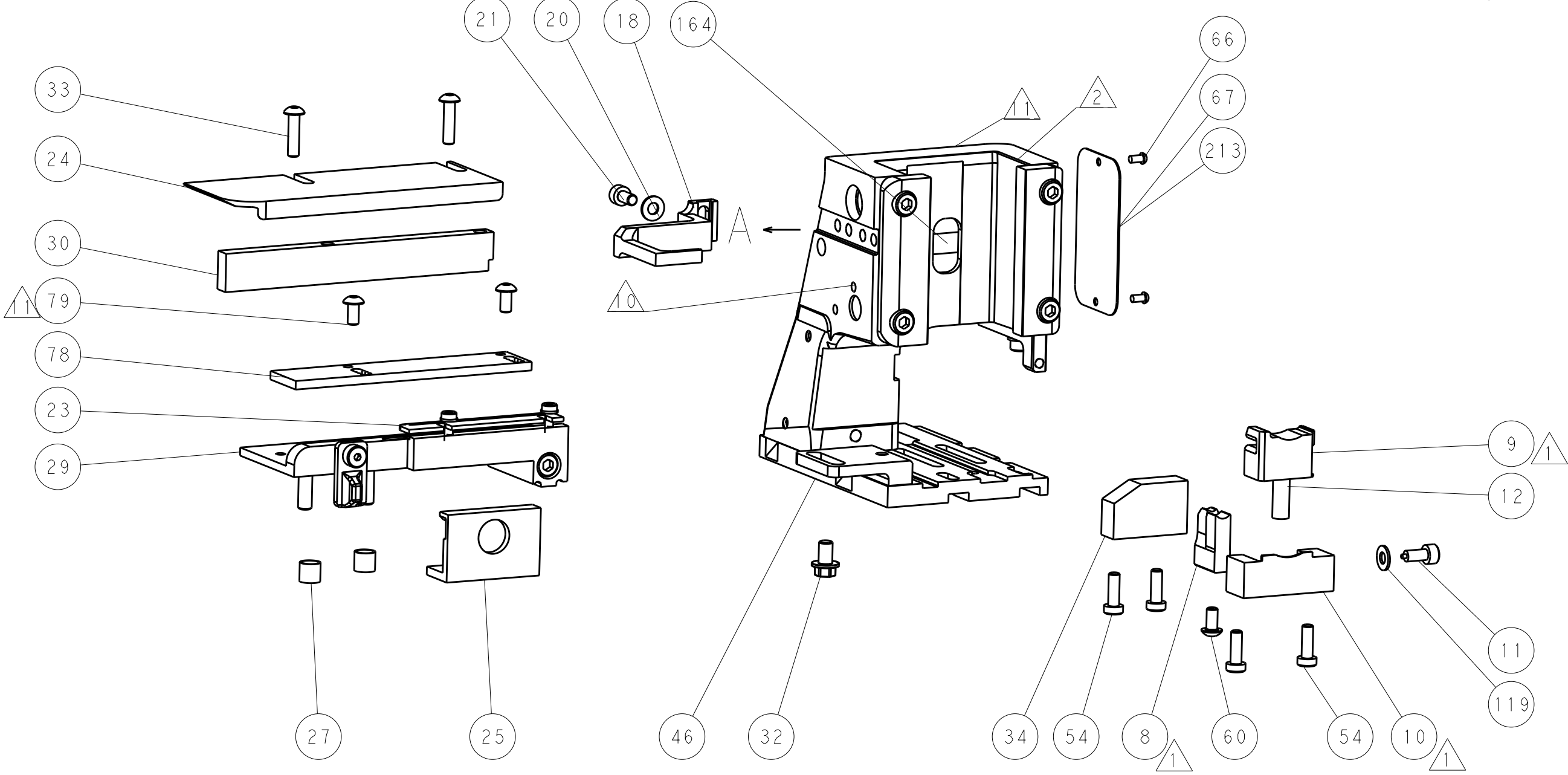
CAM POSITION



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



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 FORMED BY: COMPANY/REVISION/DATE FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE/REVISION/DATE FOR TYCO ELECTRONICS CORPORATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN: BOB HIGMAN 13JUN2013	TE Connectivity Harrisburg, PA 17105-3608	
CHK: T. ELBIN 13JUN2013		NAME: M. CLIFFORD	Ocean Side Feed Applicator	
APVD: 13JUN2013		PRODUCT SPEC: -	SIZE: A1	
APPLICATION SPEC: -		WEIGHT: -	CAGE CODE: 00779	
MATERIAL: -		FINISH: -	DRAWING NO: 2151927	
Customer Accessible Production Drawing		SCALE: 1:2	SHEET: 2 of 4	REV: A

	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151927-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151927-5	1901094-3	2-1752354-1	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151927-4	-	-	-
	2-2151927-5	A	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	2063440-3
	2-2151927-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2151927-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.20 mm [.165]	F
INSUL	6.20 mm [.244]	OV
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 8mm NGI TAB			
WIRE STRIP LENGTH 6.50-7.50 mm [.256-.295 IN]			INSULATION DIAMETER RANGE Ø3.35-4.30 mm [.132-.169 IN]
TERMINAL APPLICATION SPECIFICATION 	114-15112	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1544332-1		1544316-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
6.00mm2		2.95+/-0.05 [.116+/- .002]		5.3
5.00mm2		2.80+/-0.05 [.110+/- .002]		7.2
4.00mm2		2.65+/-0.05 [.104+/- .002]		8.6
3.00mm2		2.50+/-0.05 [.098+/- .002]		10.2



- 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: 8-2151927-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151927-5
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 62, 180 & 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.
- CUT TO LENGTH AT ASSEMBLY.
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

*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	1803078-1	SPACER, PRECISION	259
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-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	DWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	1	2063440-3	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	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
-	-	-	-	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1-2119656-8	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	455888-6	SPACER, CRIMPER	82
-	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	79
-	1	1	1	1803096-1	EXTENSION PLATE	78
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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	1	1	985575-5	SCR, FLT SKT HD CAP M3 X 16.0	57
-	-	-	1	1-1338683-1	FEED PAWL	56
-	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	690753-2	SPACER, TONKER	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	1-1752356-9	SUPPORT, TERMINAL	34
-	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1320908-3	SPACER, STRIP GUIDE	30
-	1	1	1	2119959-5	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	455888-3	SPACER, CRIMPER	28
-	2	2	2	22281-8	SPRING, COMPRESSION	27
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1320928-4	STRIP GUIDE	24
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	23
-	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	1803013-1	STRIPPER, SIDE FEED	18
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	1	1-2119805-2	SHEAR HOLDER, FRONT	10
-	1	1	1	1-318059-0	FLOATING SHEAR, FRONT	9
-	1	1	1	4-1633927-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	7
-	-	-	-	-	-	6
-	1	1	1	1803080-1	DEPRESSOR, SHEAR	5
-	1	1	1	4-238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	1	1803111-1	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	2-455888-2	SPACER, CRIMPER	2
-	1	1	1	4-1633730-8	CRIMPER, WIRE	1
-77-27-25-22	PART NO	DESCRIPTION				ITEM NO

THIS DOCUMENT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OF ANY KIND. THE USER SHALL BE CONTACTED FOR THE LATEST REVISION.		DWN BOB HIGMAN 13JUN2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK T.ELBIN 13JUN2013	NAME Ocean Side Feed Applicator	
		APVD M. CLIFFORD 13JUN2013	SIZE A1	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5		PRODUCT SPEC -	CAGE CODE 00779	
MATERIAL -		FINISH -	DRAWING NO C=2151927	
		WEIGHT -	RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:2
		SHEET 3		OF 4
		REV A		

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

D

C

B

A

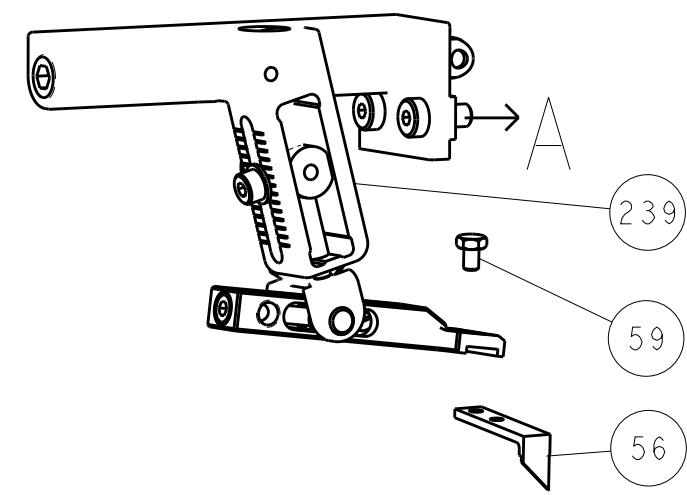
D

C

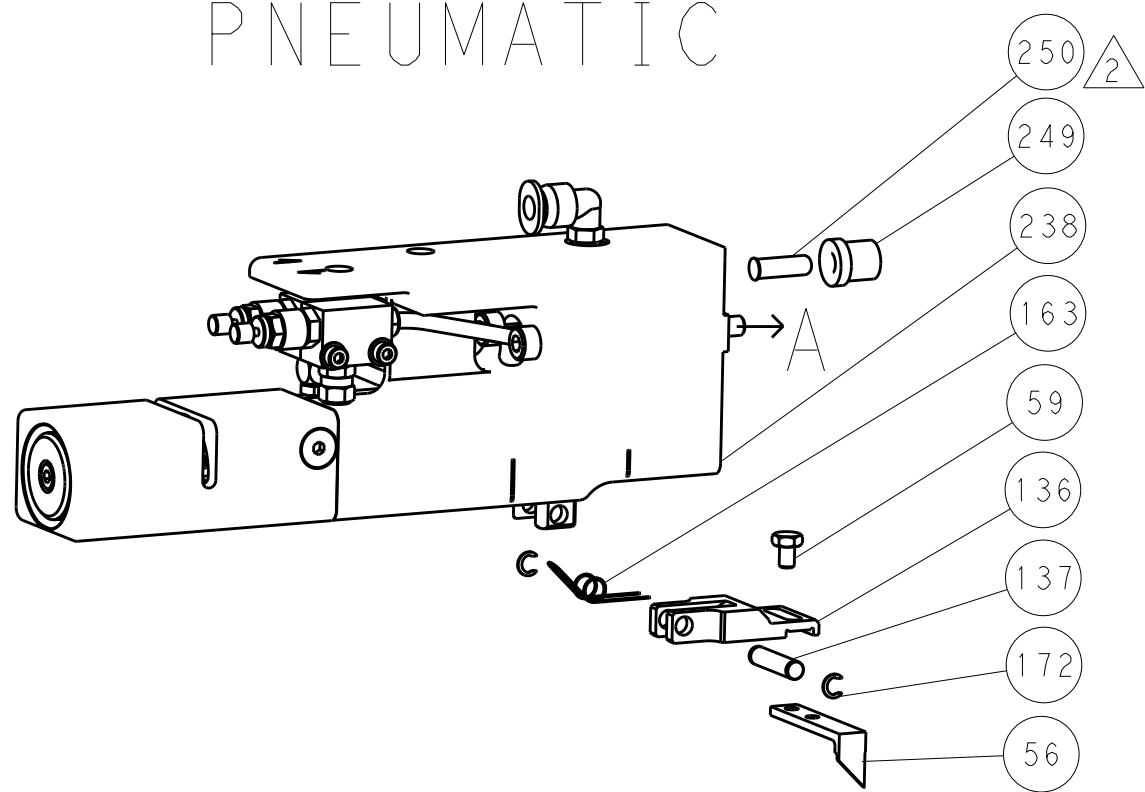
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A

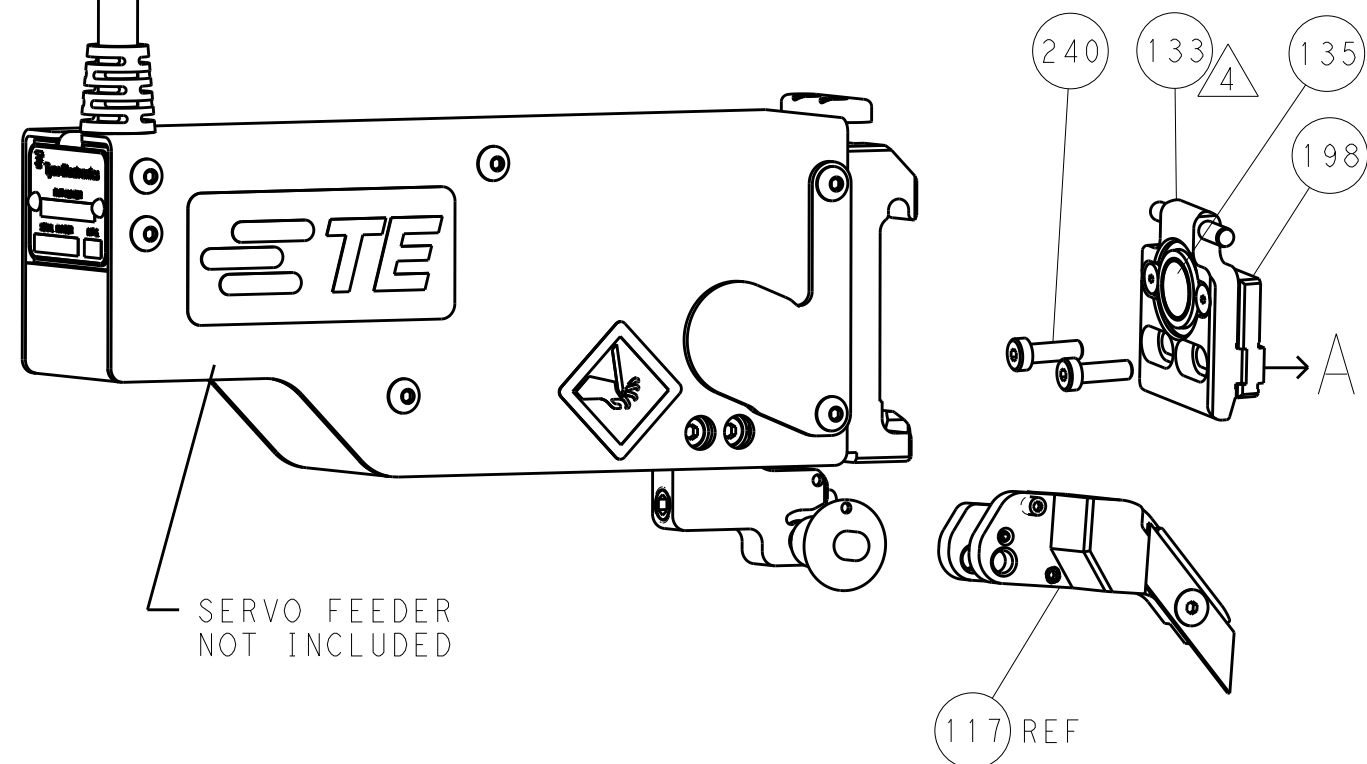
FEED TYPE MECHANICAL



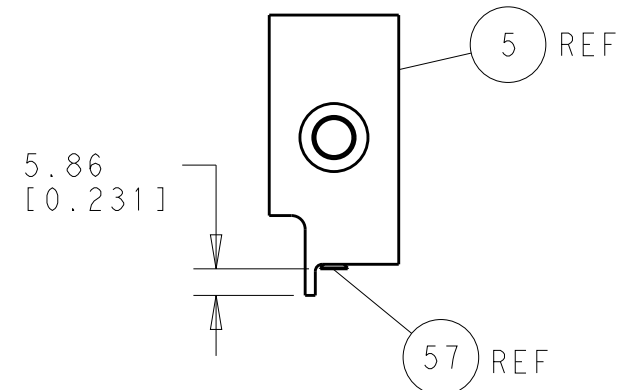
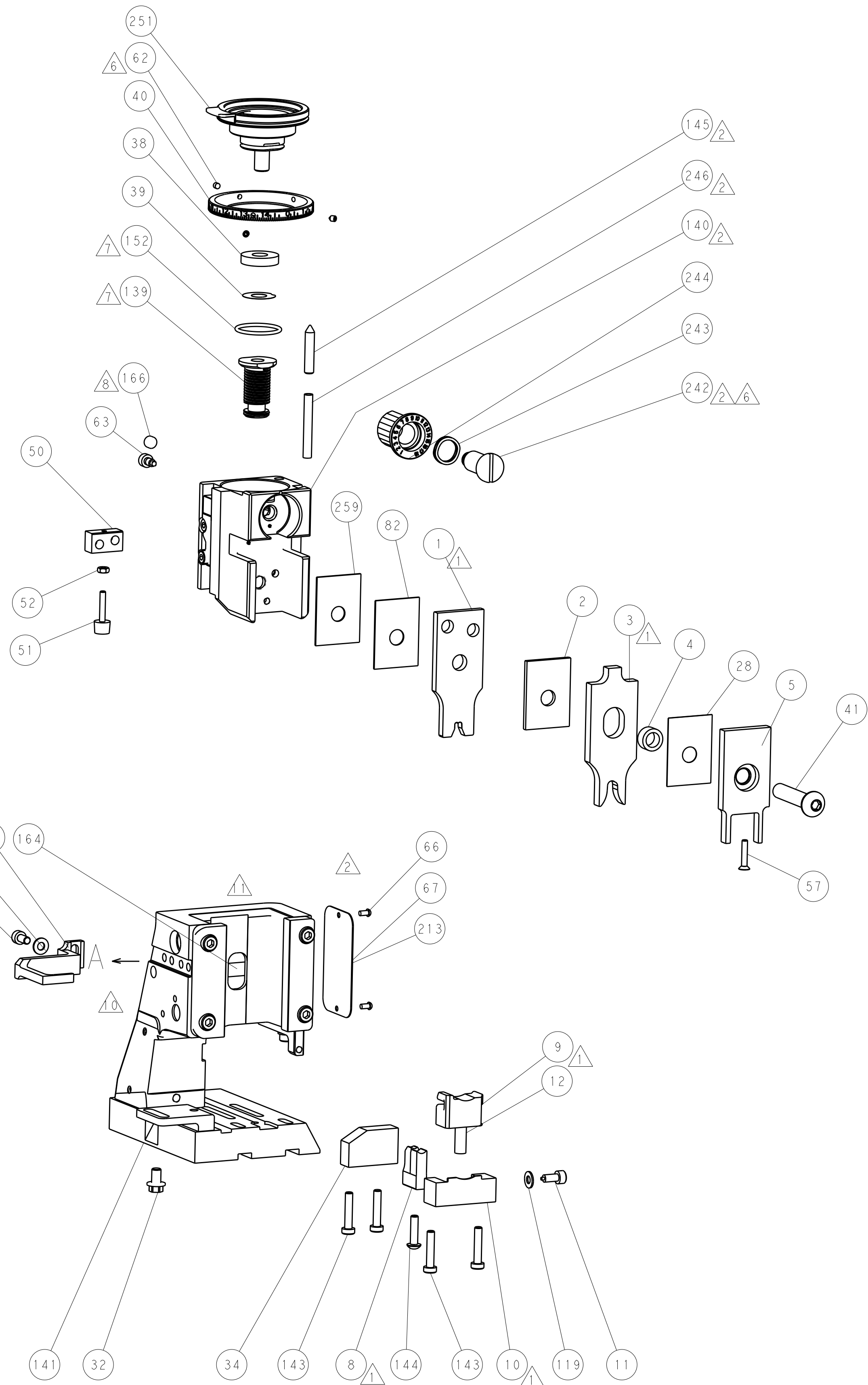
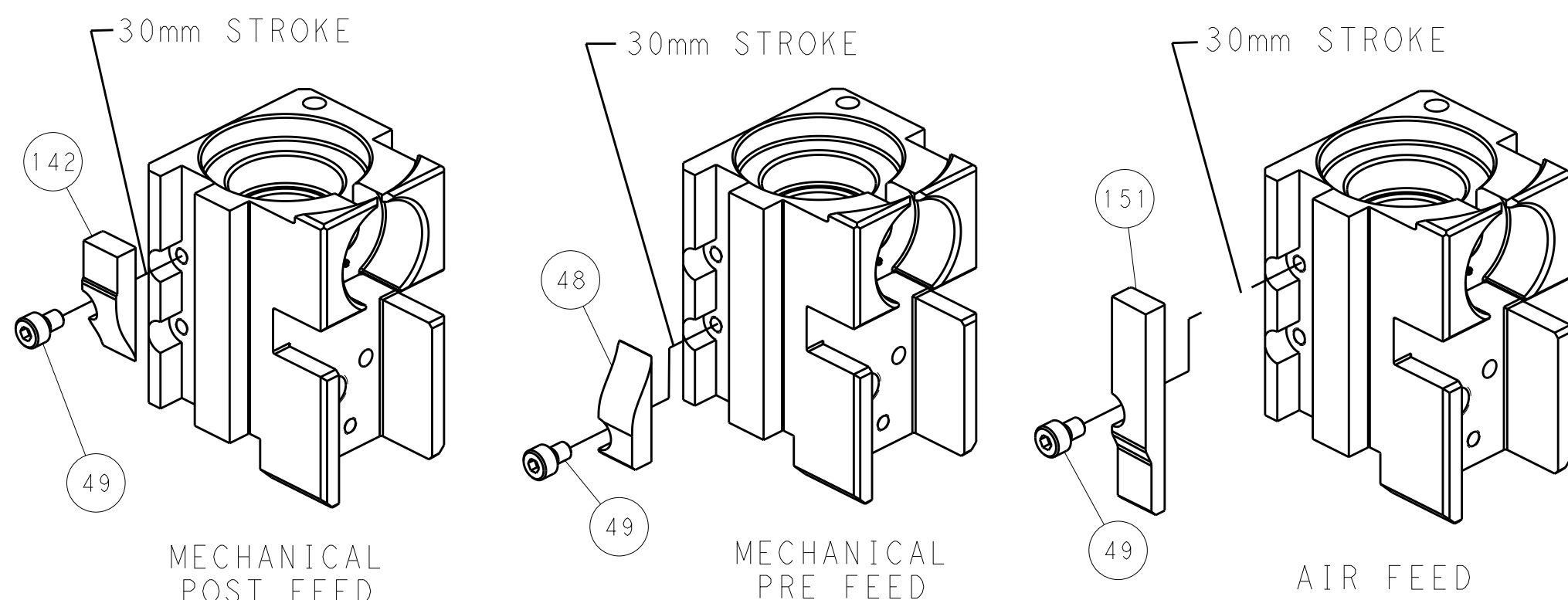
PNEUMATIC



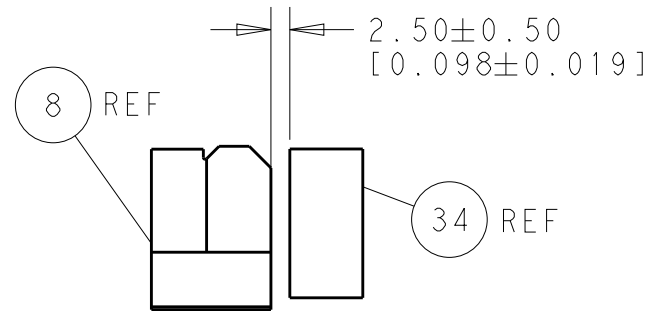
SERVO LATCH PLATE



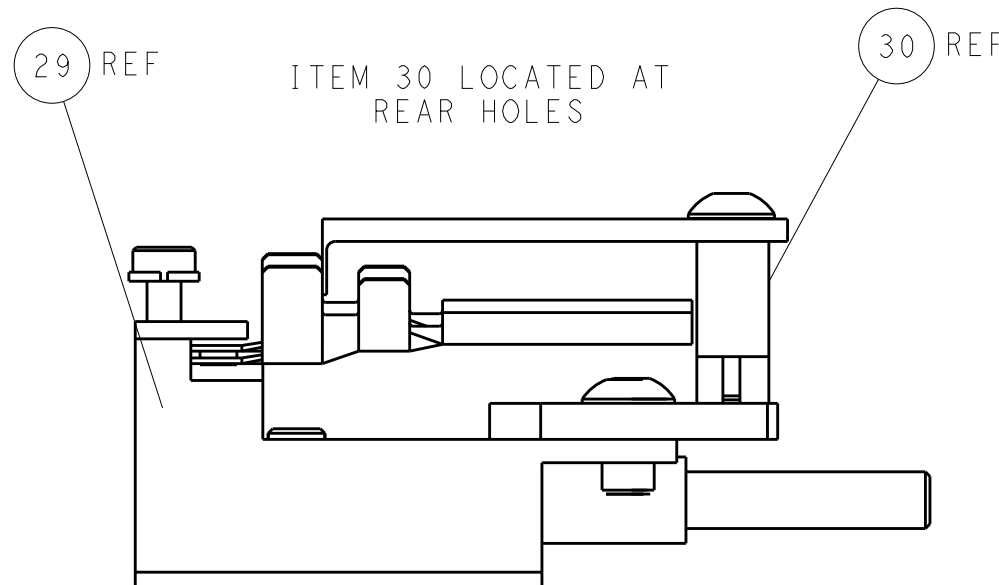
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



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)

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DIMENSIONS:		CHK	13JUN2013	Harrisburg, PA 17105-3608	
mm		APVD	13JUN2013	NAME	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		Ocean Side Feed Applicator	
0 PLC ±0.5		APPLICATION SPEC		-	
1 PLC ±0.13		WEIGHT		-	
2 PLC ±0.13		Customer Accessible Production Drawing		SCALE	
3 PLC ±0.013		1:2		SHEET	
4 PLC ±0.001		4		OF	
ANGLES FINISH		REV		A	
-		-		-	