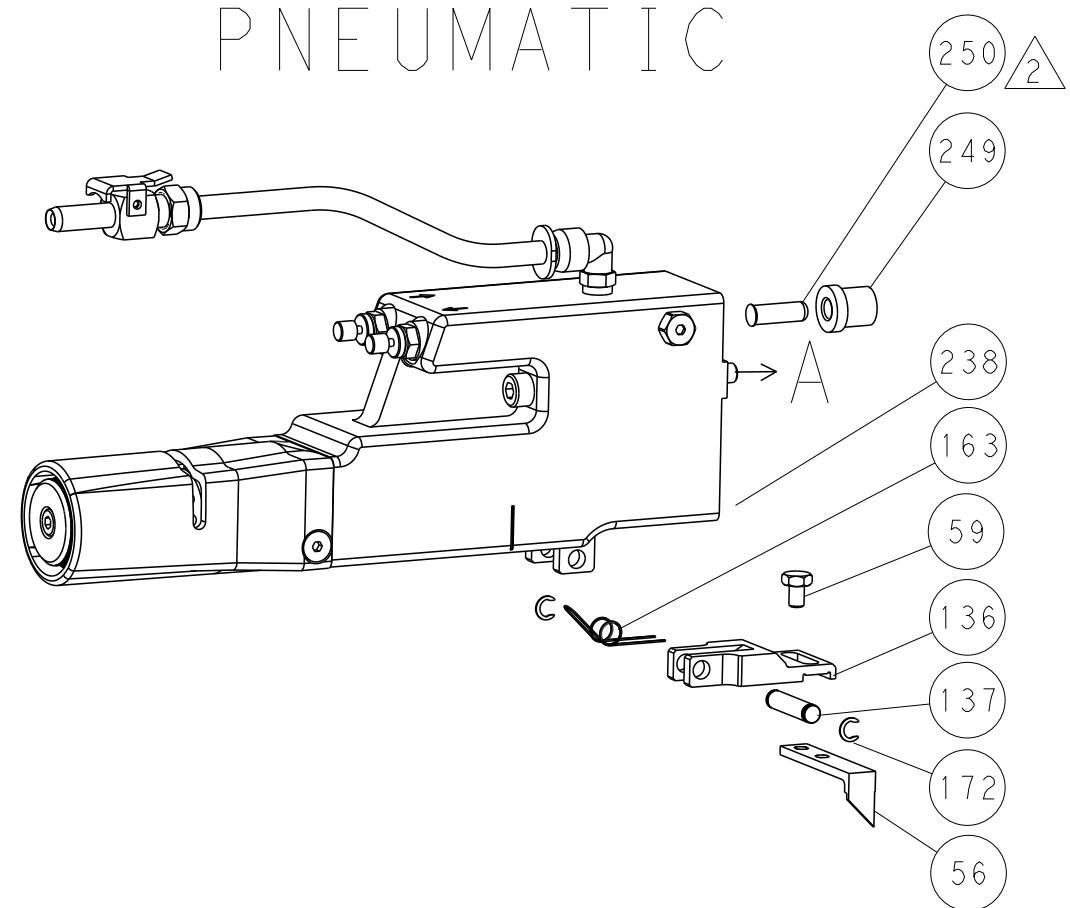
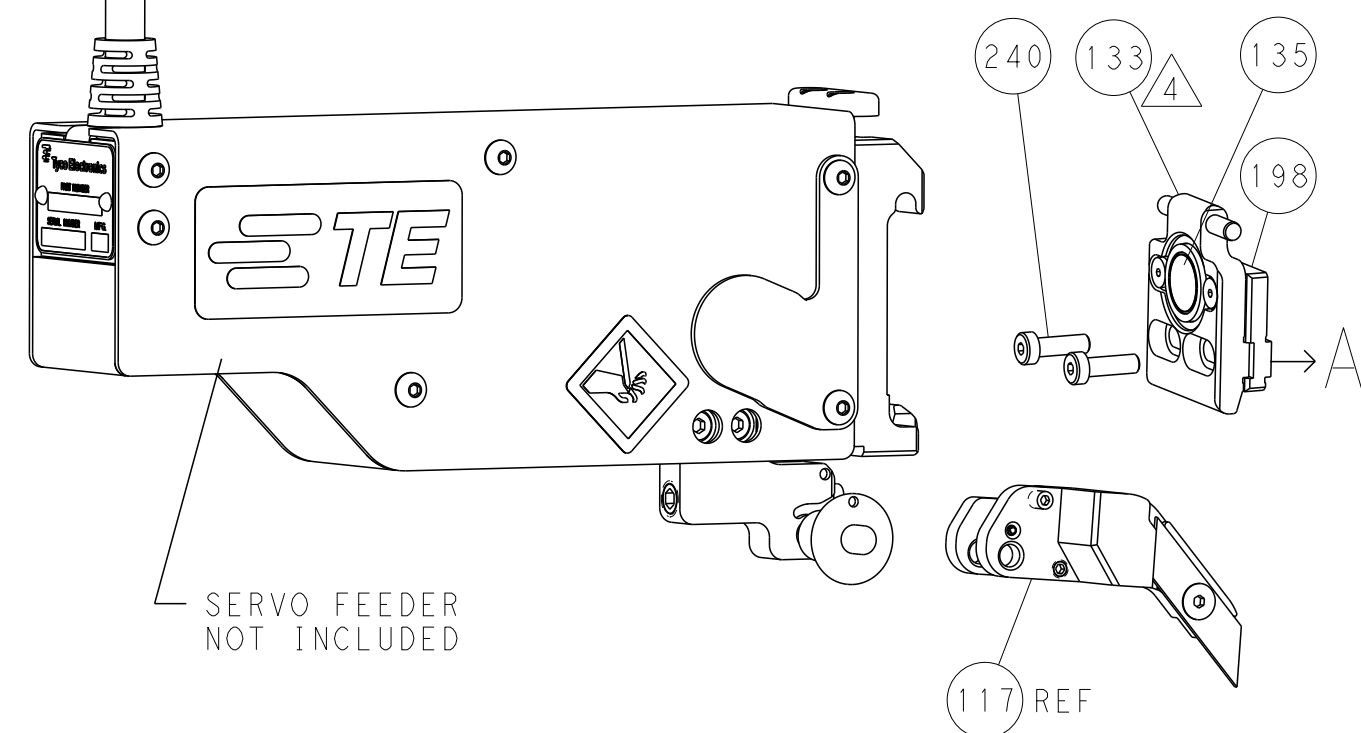
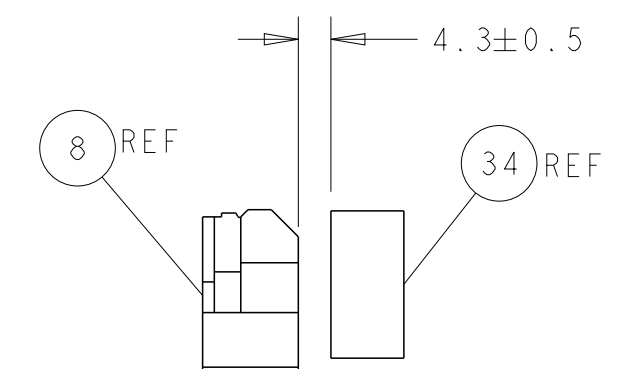
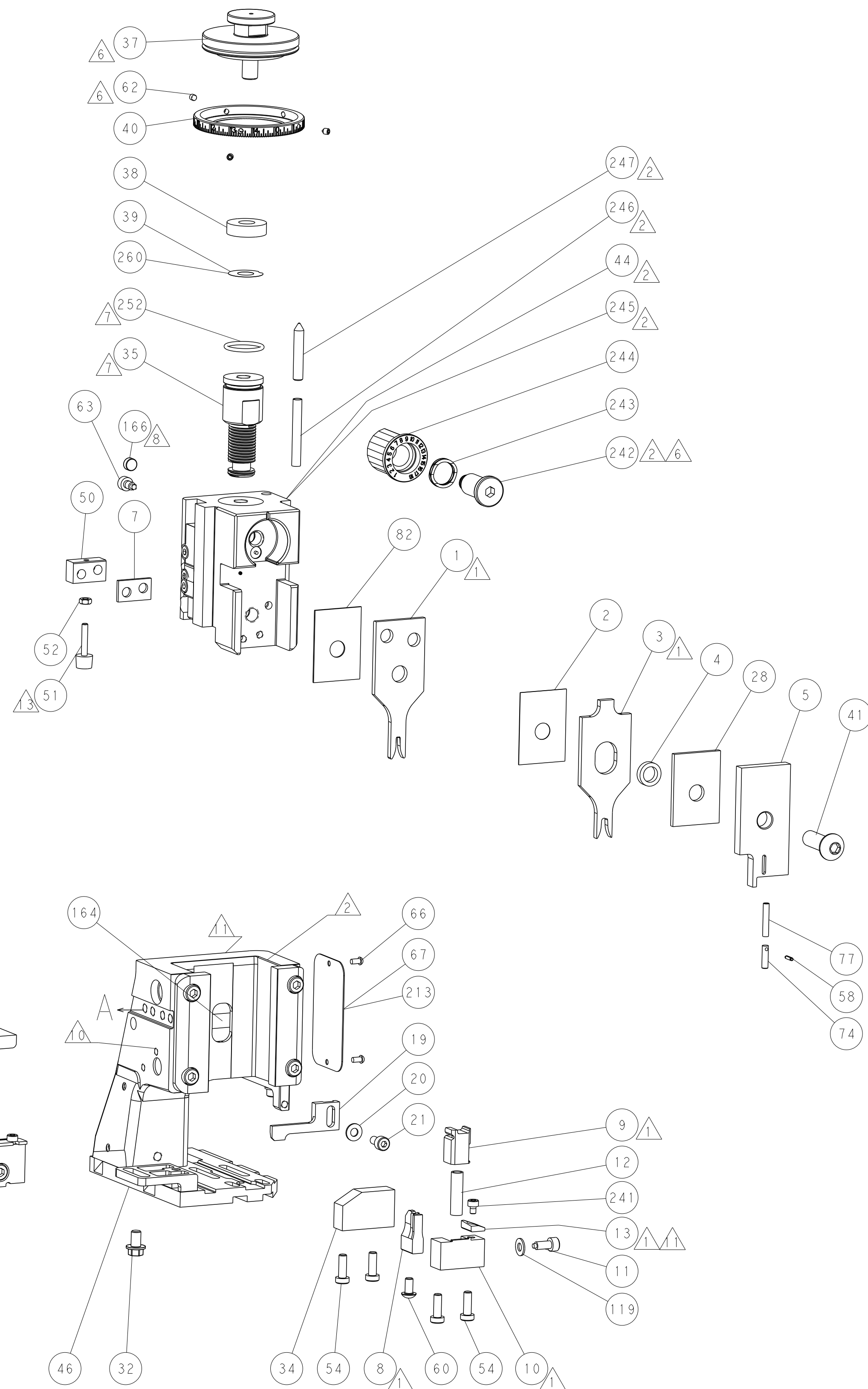


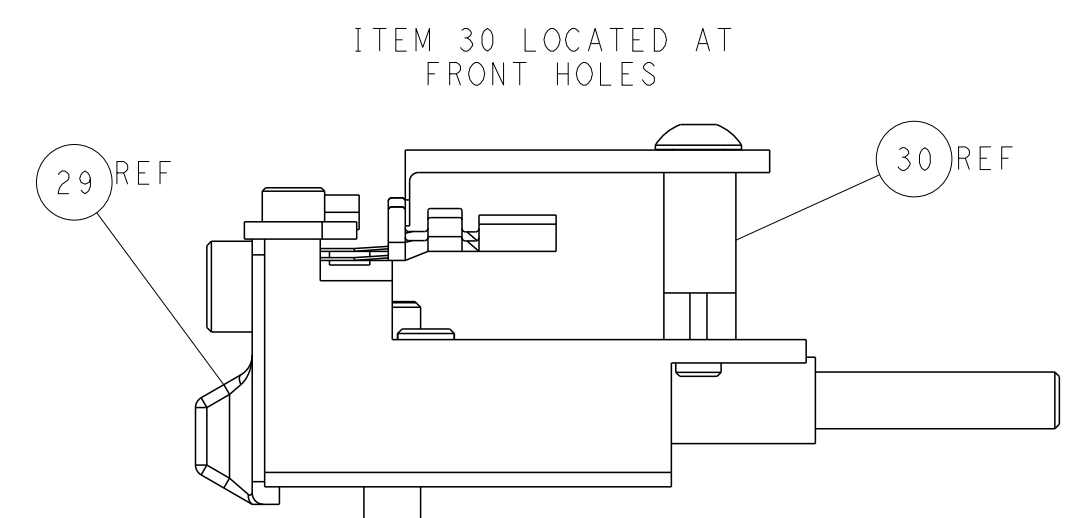
PNEUMATIC

SERVO
LATCH PLATE

CAM POSITIONS



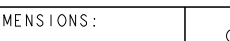
TERMINAL SUPPORT LOCATION

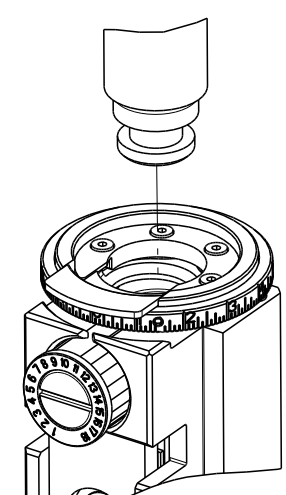


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

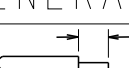
ATLANTIC VERSION

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TWO ELECTRONICS CORPORATION IT IS OBSOLETE TO THE EXTENT IT DOES NOT CONFORM TO THE LATEST REVISION. IT SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN 03SEP2012 CHK 03SEP2012 APVD 03SEP2012 S.XI		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		Ocean Side Feed Applicator	
		FINISH		SIZE CAGE CODE DRAWING NO	
MATERIAL		WEIGHT		RESTRICTED TO	
-		-		A1 00779 C-2151743	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 OF 4 REV D1	

	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151743-1	D	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	-	8-2151743-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151743-4	-	-	-
	2-2151743-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151743-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151743-4	-	-	-
	2-2151743-5	D	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
	2-2151743-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2151743-7	B	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	OV
APPLICATOR INSTRUCTIONS 408-10389 		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: NEXT GENERATION SOFT SHELL CONTACT			
WIRE STRIP LENGTH 		INSULATION DIAMETER RANGE	
4.20-4.80 mm [.165-.189 IN]		Ø2.00-3.30 mm [.079-.130 IN]	
TERMINAL APPLICATION SPECIFICATION 	(A)114-106118	-	-
	(B)114-106147	-	-
TERMINALS APPLIED ¹²			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1971783-1	(A) 1971783-2	(A) 1971784-1	(A) 1971784-2
(B) 2232723-1	(B) 2232723-2	(B) 2232724-1	(B) 2232724-2

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING ⁹ 
16 AWG OR 1.27mm2	1.37+/-0.04 [.054+/- .002]	2.6
18 AWG OR 0.80mm2	1.21+/-0.04 [.048+/- .002]	4.4
19 AWG OR 0.70mm2	1.08+/-0.04 [.043+/- .002]	5.7
(2) 22 AWG	1.07+/-0.04 [.042+/- .002]	5.8 ¹³



- 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: 8-2151743-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151743-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151743-5
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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- ⁸ MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- ¹² ADJUST ITEM 51 WHEN SWITCHING TERMINALS.
- ¹³ FOR (2) 22 AWG WIRE, MAXIMUM INSULATION DIAMETER PER WIRE IS Ø 2.03mm.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: NEXT GENERATION SOFT SHELL CONTACT			
WIRE STRIP LENGTH 		INSULATION DIAMETER RANGE	
4.20-4.80 mm [.165-.189 IN]		Ø2.00-3.30 mm [.079-.130 IN]	
TERMINAL APPLICATION SPECIFICATION 	(A)114-106118	-	-
	-	-	-
TERMINALS APPLIED ¹²			
(A)2238066-1	(A)2238066-2	(A)2238067-1	(A)2238067-2

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING ⁹ 
18 AWG OR 0.80mm2	0.99+/-0.03 [.069+/- .001]	6.4

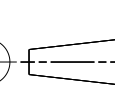
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	1803259-1	BUSHING, FLANGED	249
-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	DIST 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	DWN	APVD
			-		SEE SHEET 1	-	-	-

6	-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
	-	1	1	1	1	2119082-8	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
	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
8	-	-	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
7	-	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
6	-	-	-	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	22278-8	SPRING, COMPRESSION	77
	-	1	1	1	1	854769-4	HOLDER, INS	74
6	-	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	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	-	-	1	1	1338685-1	PAWL, FEED	56
2	-	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	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	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
	-	1	1	1	1	1752356-1	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	1-1320908-0	SPACER, STRIP GUIDE	30
	-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	2-455888-2	SPACER, CRIMPER	28
1	-	1	1	1	1	1320928-2	STRIP GUIDE	24
	-	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	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	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
	1	1	1	1	1	1-1803079-3	ANVIL, WITH STABILIZER	8
1	-	1	1	1	1	4-240641-2	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
	-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
	1	1	1	1	1	2-2119785-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	1	1	1	455888-2	SPACER, CRIMPER	2
	1	1	1	1	1	5-456405-6	CRIMPER, WIRE PREMIUM	1

-77-27-25-22-21			PART NO		DESCRIPTION				ITEM NO				
THIS DRAWING IS TO REMAIN UNPUBLISHED. IT IS THE PROPERTY OF THE COMPANY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. PERMISSION TO REPRODUCE THIS DRAWING IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, MUST BE OBTAINED FROM THE COMPANY.					OWN	03SEP2012	 TE Connectivity Harrisburg, PA 17105-3608			NAME			
					CHK	03SEP2012							
					APVD	03SEP2012							
DIMENSIONS:					TOLERANCES UNLESS OTHERWISE SPECIFIED:	PRODUCT SPEC	Ocean Side Feed				RESTRICTED TO		
					0 PLC ±	-	-						
					1 PLC ±	-	-						
					2 PLC ±	-	-						
					3 PLC ±	-	-						
					4 PLC ±	-	-			SIZE			
					ANGLES	±	-				CASE CODE		
					FINISH	-	-					DRAWING NO	
						-	-						©=2151743
						-	-						
					WEIGHT	-	-			SCALE			
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LOC		DIST	REVISIONS			
A	66		P	LTR	DESCRIPTION	DATE
			-		SEE SHEET 1	-

D

C

B

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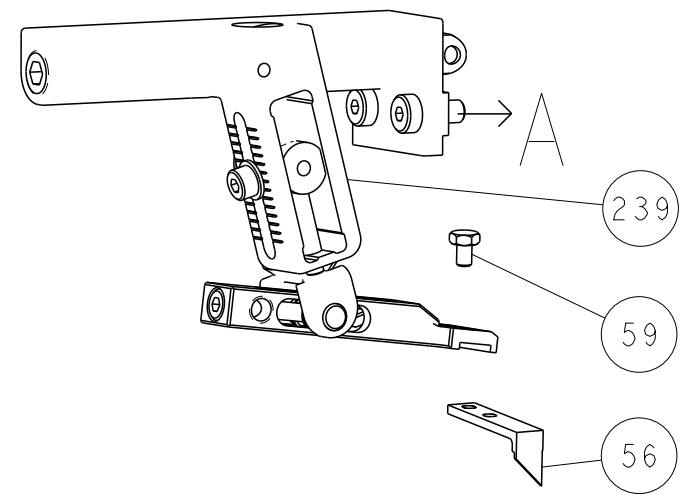
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C

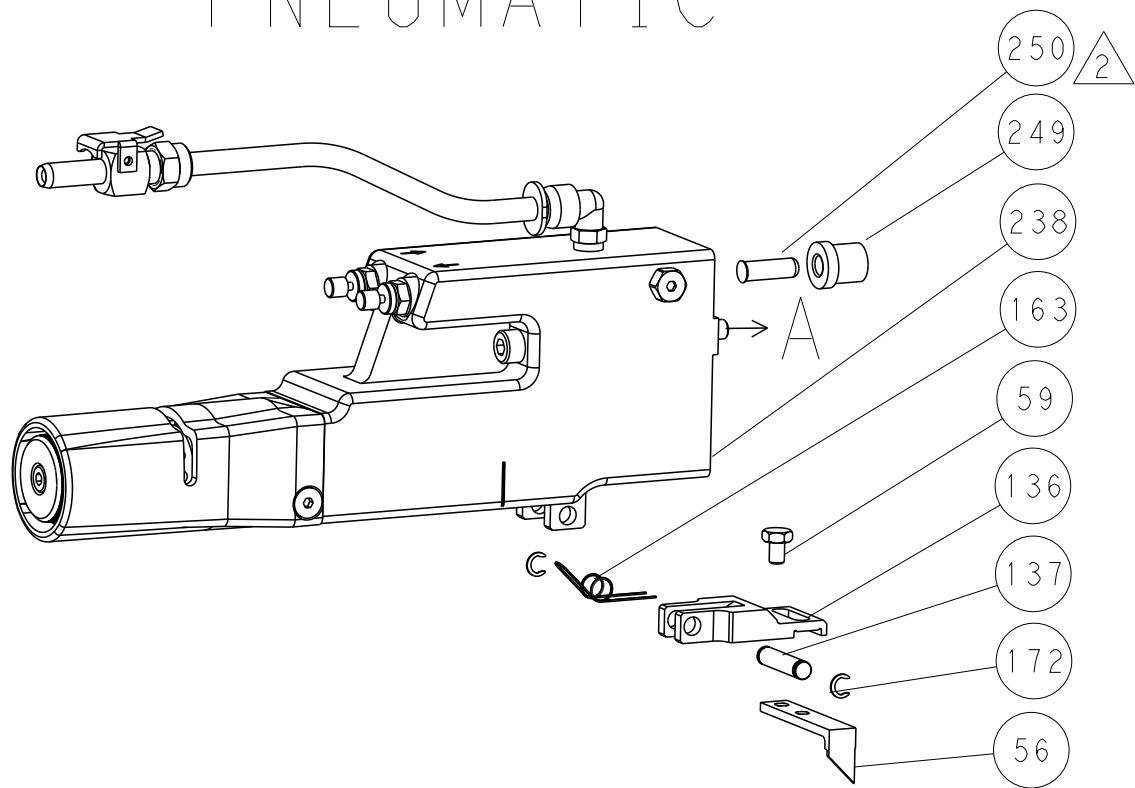
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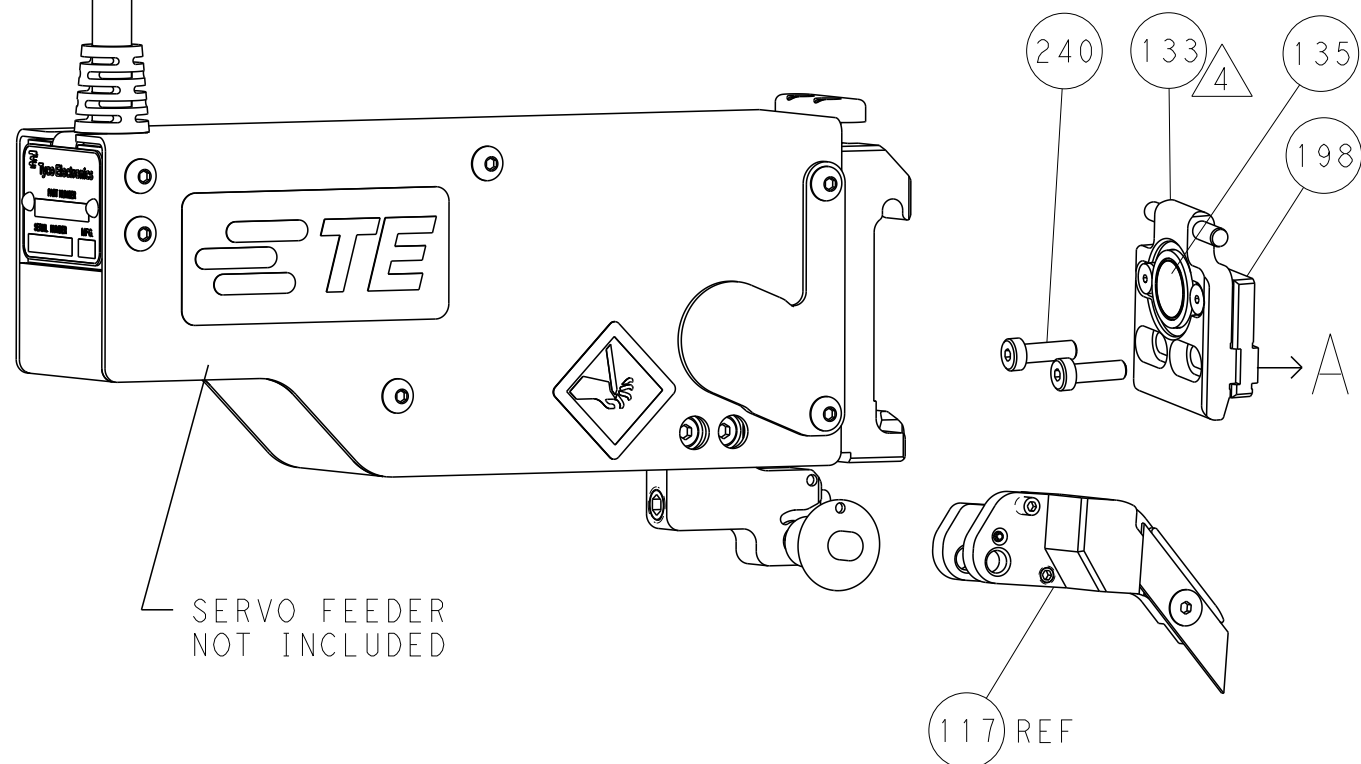
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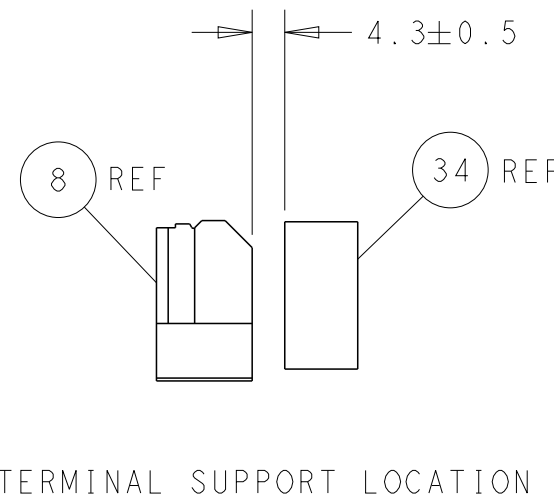
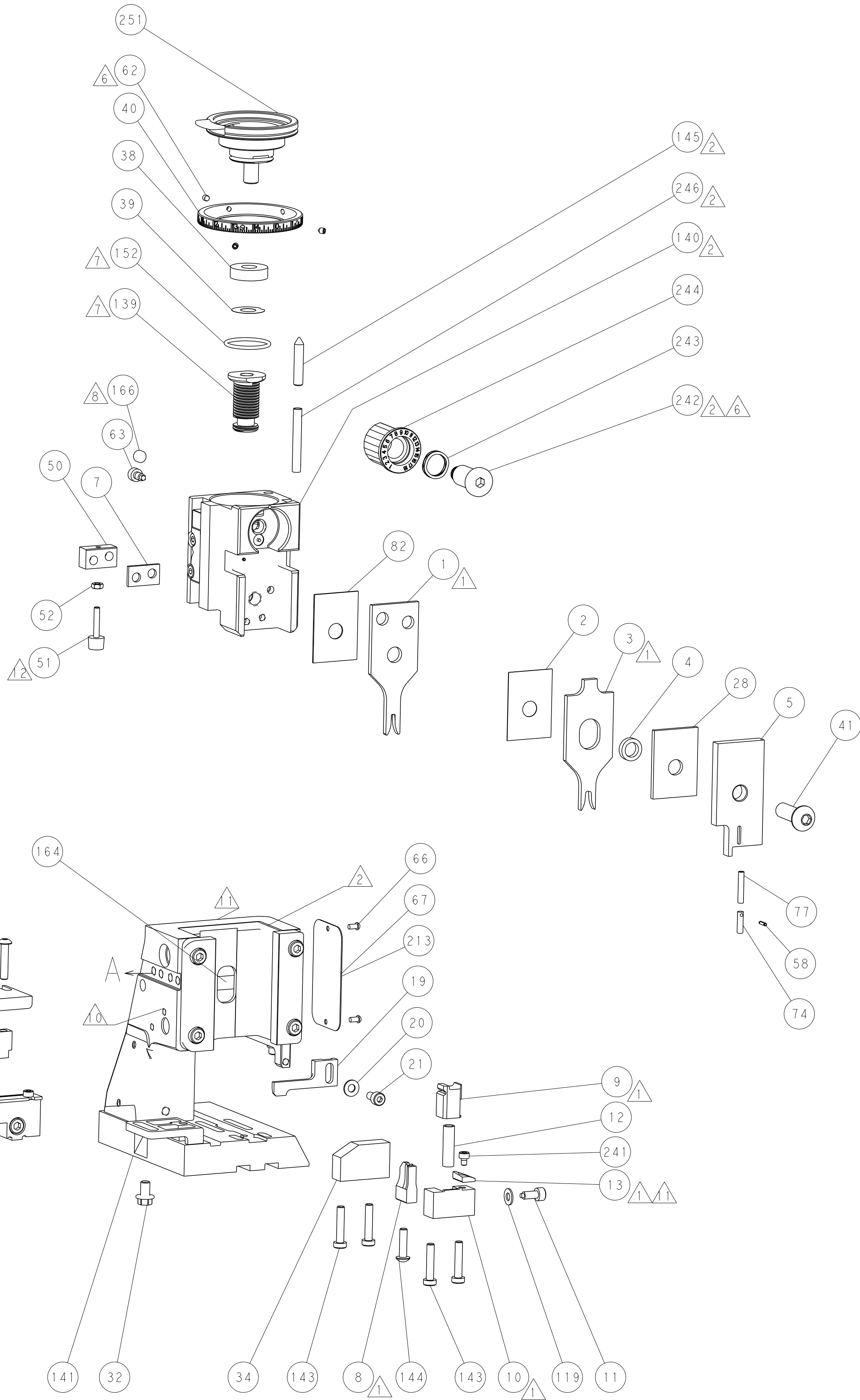
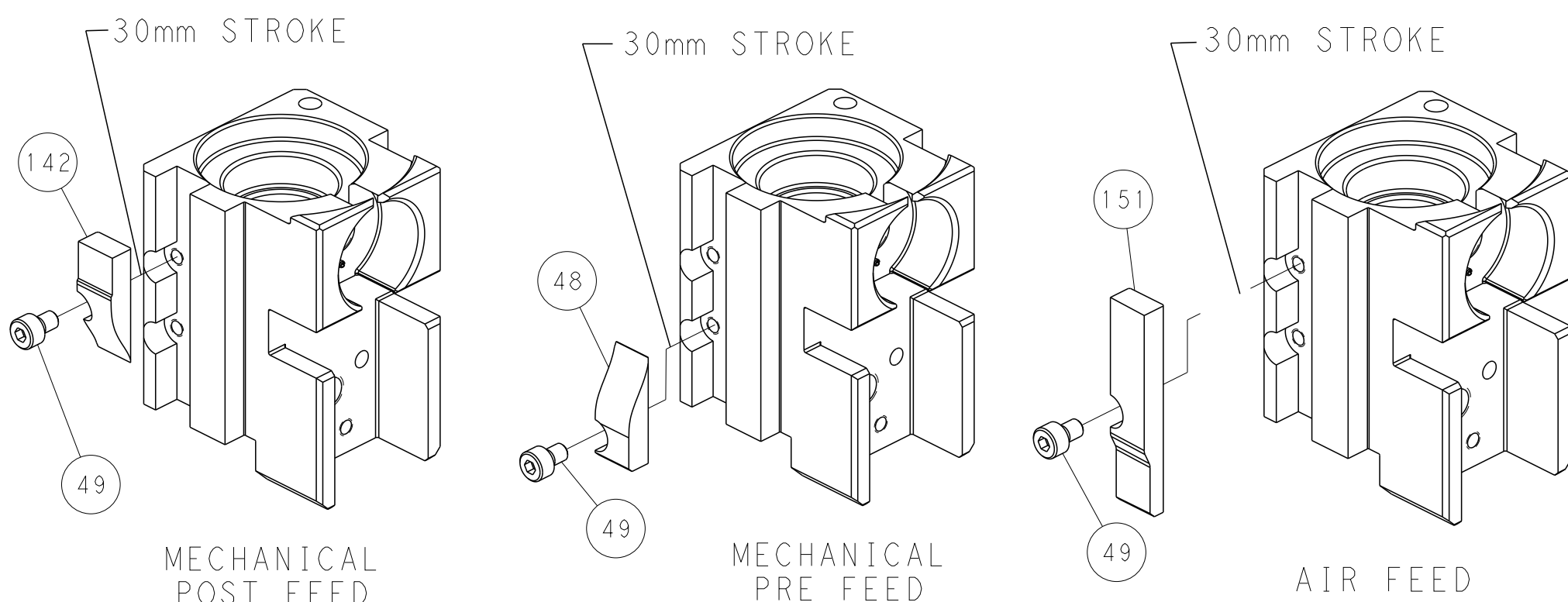
PNEUMATIC



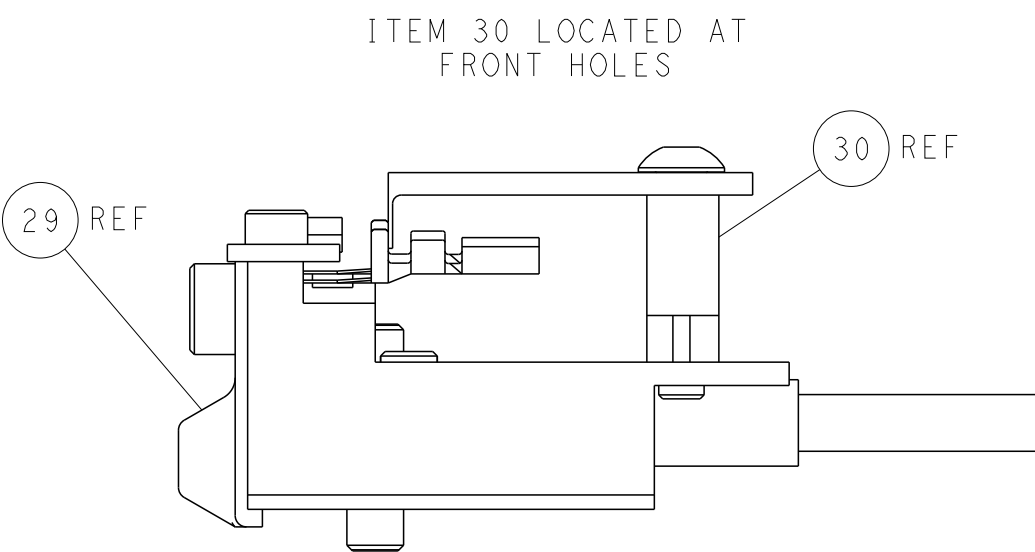
SERVO LATCH PLATE



CAM POSITIONS



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)

1. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.		DWN	L. ZHANG	03SEP2012	TE Connectivity		
		CHK	L. ZHANG	03SEP2012	Harrisburg, PA 17105-3608		
		APVD	S. X1	03SEP2012	NAME Ocean Side Feed Applicator		
		PRODUCT SPEC					
		APPLICATION SPEC					
		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
		A1	00779	C=2151743			
		Customer Accessible Production Drawing		SCALE	1:2	SHEET 4 of 4	
				REV	D1		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION