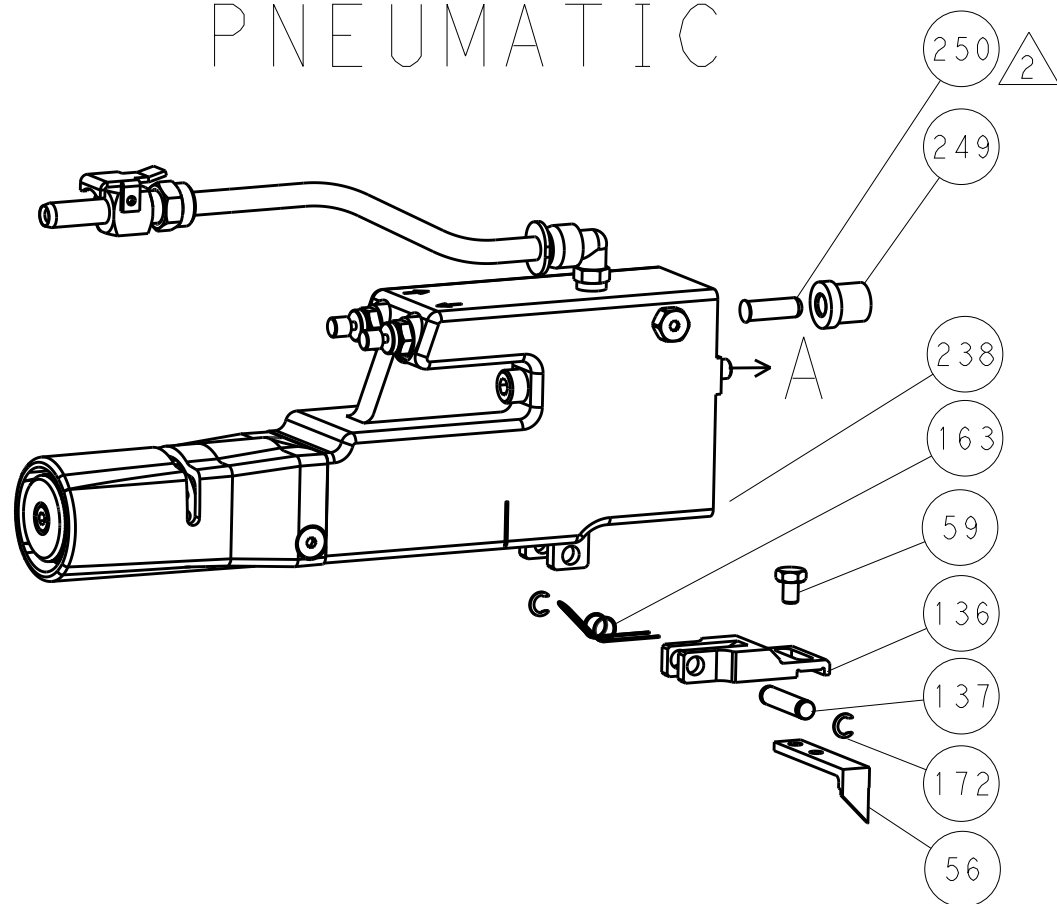


LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE
MECHANICAL



PNEUMATIC



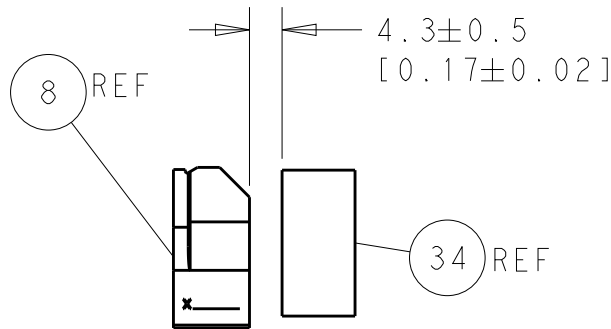
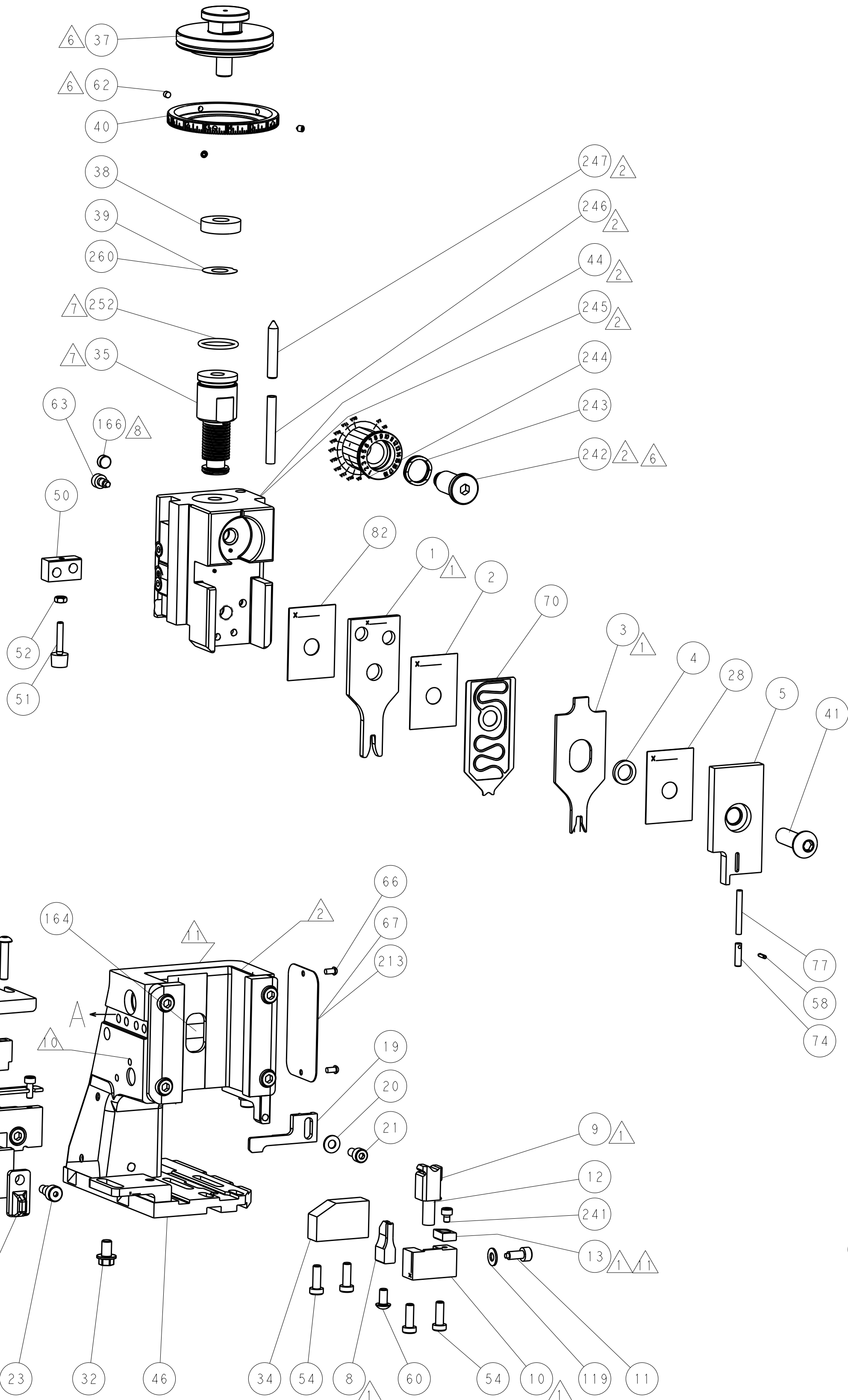
SERVO
LATCH PLATE



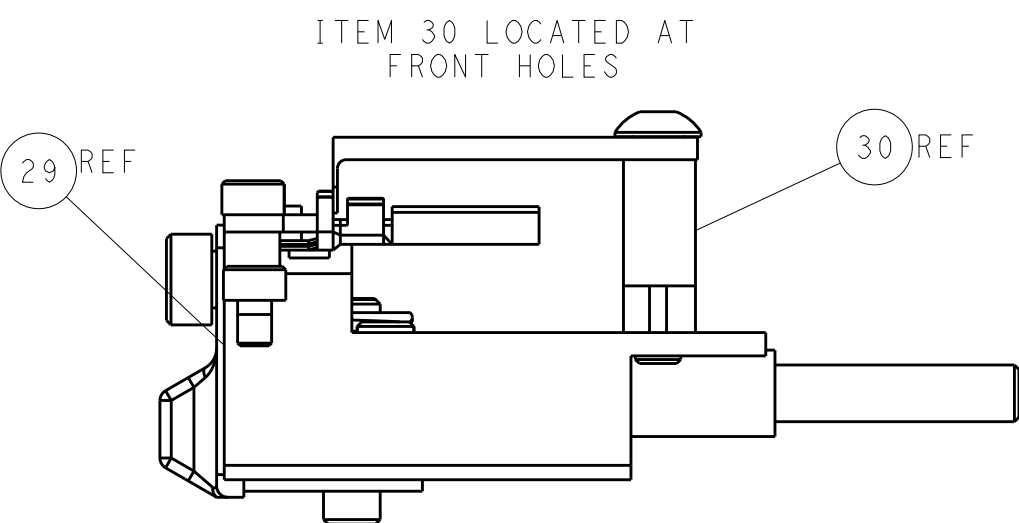
CAM POSITIONS



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



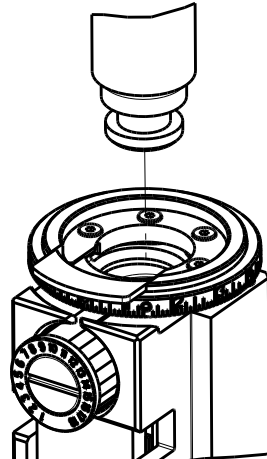
TERMINAL SUPPORT LOCATION



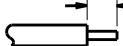
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

1. THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN: HOFFNER 28OCT2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK: T.ELBIN 31OCT2011		
mm	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD: T.ELBIN 31OCT2011	NAME: Ocean Side Feed Applicator	
	0 PLC ±.5	PRODUCT SPEC	SIZE: CAGE CODE: DRAWING NO: A1 00779 ©=2151500	
	1 PLC ±0.13	APPLICATION SPEC	RESTRICTED TO	
	2 PLC ±0.13			
	3 PLC ±0.013			
	4 PLC ±0.0001			
	ANGLES ±.0001			
MATERIAL:	FINISH:	WEIGHT:	Customer Accessible Production Drawing	
			SCALE: 1:2 SHEET 2 OF 4 REV E1	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

8		7		6		5		4		3	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		28							
© COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.									
PACIFIC 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	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151500-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151500-4	-	-	-
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151500-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151500-4	-	-	-
					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
				-	-	-	-	-	-	-	
				-	-	-	-	-	-	-	

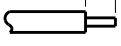
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL MNL		SOCKET 0.5-2.0 mm2	
WIRE STRIP LENGTH 157-187 IN [3.99-4.75 mm]		INSULATION DIAMETER RANGE Ø .060-.130 IN [1.52-3.30 mm]	
TERMINAL APPLICATION 	(A)114-1010	(C)114-1012	-
SPECIFICATION 	(B)114-1011	(D)114-5214	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 350536-1	(A) 350536-2	(A) 350536-3	(A) 350536-6
(A) 350536-7	(A) 350654-1	(A) 350654-2	(A) 350654-7
(A) 350687-1	(A) 350687-2	(A) 350687-4	(A) 350687-7
(A) 350687-8	(B) 350217-1	(B) 350218-1	(B) 350218-2
(B) 350218-3	(C) 61117-1	(C) 61117-2	(C) 61117-4
(C) 61117-5	(C) 61117-6	(C) 61117-7	(C) 61118-1
(C) 61118-2	(C) 61118-4	(C) 61118-5	(D) 170120-1
(D) 170120-4	(D) 917636-1		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
14 AWG		1.75+/-0.05 [0.069+/- .002]		4.6
2.00mm ²		1.70+/-0.05 [0.067+/- .002]		5.0
1.50mm ²		1.57+/-0.05 [0.062+/- .002]		6.5
16 AWG		1.50+/-0.05 [0.059+/- .002]		7.2
1.25mm ²		1.45+/-0.05 [0.057+/- .002]		7.7
1.00mm ²		1.40+/-0.05 [0.055+/- .002]		8.2
18 AWG		1.32+/-0.05 [0.052+/- .002]		9.2
0.75mm ²		1.30+/-0.05 [0.051+/- .002]		9.4
0.50mm ²		1.22+/-0.05 [0.048+/- .002]		10.2
20 AWG		1.19+/-0.05 [0.047+/- .002]		10.6



- 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 CASSSETTE 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
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 61 & 62
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 24 & 25
- 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.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL MNL		SOCKET 0.5-2.0 mm2	
WIRE STRIP LENGTH 157-187 IN [3.99-4.75 mm]		INSULATION DIAMETER RANGE Ø.079-0.130 IN [2.01-3.30 mm]	
TERMINAL APPLICATION SPECIFICATION 	(D)114-18011	-	-
TERMINALS APPLIED			
TE TERMINAL (D) 926882-1	TE TERMINAL (D) 926882-2	TE TERMINAL (D) 926882-3	TE TERMINAL (D) 926882-4
(D) 926882-7	(D) 926883-1	(D) 926883-3	(D) 926883-4
(D) 926883-5	(D) 926883-6	(D) 926883-7	(D) 926883-8
(D) 926887-1	(D) 926887-3	(D) 926887-4	(D) 926887-6
(D) 926887-7	(D) 927965-1	(D) 927965-3	

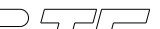
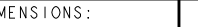
WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING	
14 AWG		1.73+/-0.05	[.068+/- .002]	4.6	
2.00mm2		1.70+/-0.05	[.067+/- .002]	5.0	
1.50mm2		1.53+/-0.05	[.060+/- .002]	6.5	
16 AWG		1.47+/-0.05	[.058+/- .002]	7.2	
1.25mm2		1.45+/-0.05	[.057+/- .002]	7.7	
1.00mm2		1.37+/-0.05	[.054+/- .002]	8.2	
18 AWG		1.30+/-0.05	[.051+/- .002]	9.2	
0.75mm2		1.30+/-0.05	[.051+/- .002]	9.4	
0.50mm2		1.21+/-0.05	[.048+/- .002]	10.2	
20 AWG		1.21+/-0.05	[.048+/- .002]	10.6	

```
*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.
```

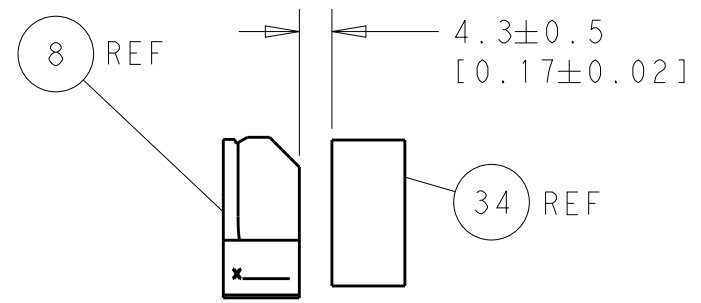
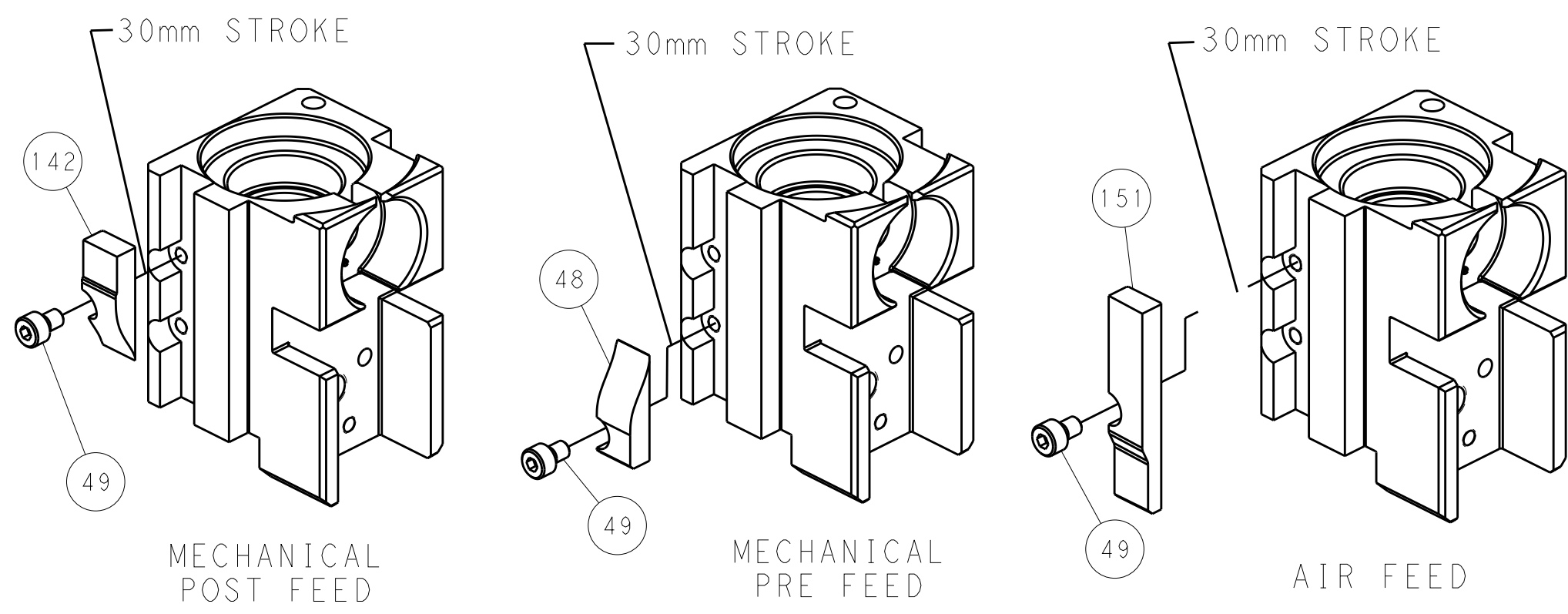
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	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
-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)

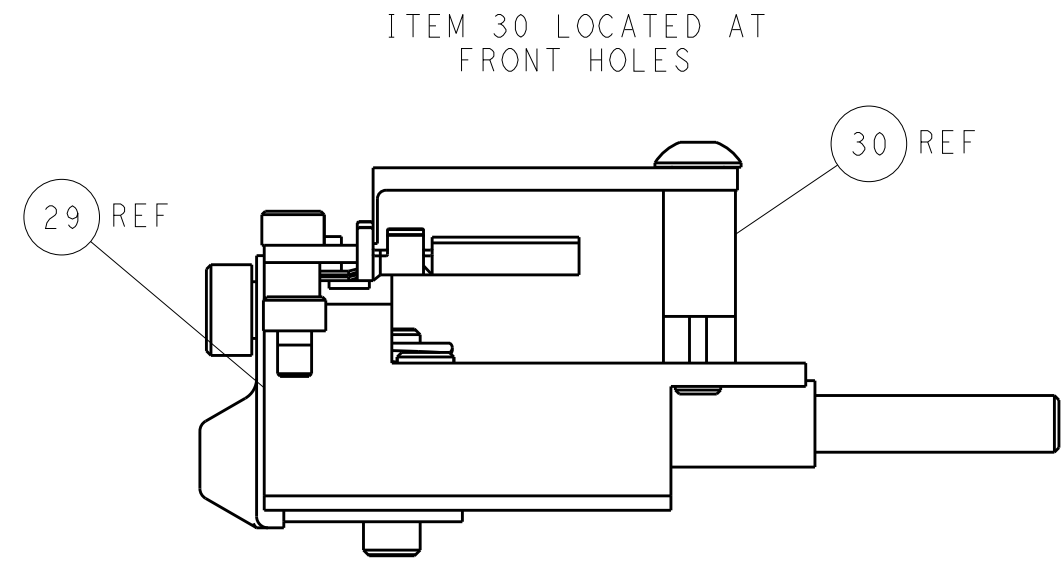
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SET UP GAUGE		LOC	DIST	REVISIONS					
2119599-1		A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
				-		SEE SHEET 1	-	-	-
-	1	-	-	2119740-2	TAG, IDENTIFICATION				213
-	1	-	-	1901094-3	SPACER, FEEDER				198
-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT				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	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
2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0				96
1	1	1	1	690438-1	FRONT STRIP GUIDE				95
1	1	1	1	455888-5	SPACER, CRIMPER				82
1	1	1	1	5-547505-2	SPRING, COMPRESSION				77
1	1	1	1	854769-4	HOLDER, INS				74
1	1	1	1	2119956-1	DOCUMENTATION PACKAGE				71
1	1	1	1	2119791-5	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	1	2119793-1	LIMITER, ADJUSTMENT BOLT				63
3	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
-	-	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	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10				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	1-2119644-2	RAM WASHER, PRECISION				38
1	1	1	1	3-1752356-4	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	1-1320908-2	SPACER, STRIP GUIDE				30
1	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE				29
1	1	1	1	455888-3	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	240792-5	DRAG, TERMINAL				25
1	1	1	1	1320928-2	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	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	1803095-1	FLOATING SHEAR, FRONT				9
1	1	1	1	8-1333205-1	ANVIL, COMBINATION				8
-	-	-	-	-	-				7
-	-	-	-	-	-				6
1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR				5
1	1	1	1	238011-7	BLOCK, CRIMPER SPACER				4
1	1	1	1	1633962-3	CRIMPER, INSULATION F PREMIUM				3
1	1	1	1	455888-1	SPACER, CRIMPER				2
1	1	1	1	3-456406-3	CRIMPER, WIRE PREMIUM				1
-27	-25	-22	-21	PART NO	DESCRIPTION				ITEM NO

THIS DRAWING IS THE PROPERTY OF THE COMPANY. IT IS TO BE USED FOR THE SPECIFIC PURPOSE AND SHOULD BE CONTROLLED FOR THE LATEST VERSION.		DWN 280CT2011 OFFNER CIP 310CT2011 T.F.LBIN AND 310CT2011 T.F.LBIN		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC		SIZE	
MATERIAL		APPLICATION SPEC		CASE CODE DRAWING NO	
FINISH		WEIGHT		RESTRICTED TO	
-		-		A1 00779 C=2151500	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 3 OF 4 REV 1	

CAM POSITIONS

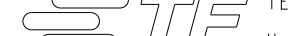


TERMINAL SUPPORT LOCATION



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TFC ELECTRONICS CORPORATION IT IS SUBJECT TO THE TERMS AND CONDITIONS OF THE PURCHASE ORDER AND SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN 280C12011 CWR HOFFNER 310CT2011 TFLBIN 310CT2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±		NAME Ocean Side Feed Applicator -	
		PRODUCT SPEC APPLICATION SPEC -		SIZE CASE CODE DRAWING NO A1 00779 C=2151500	
MATERIAL FINISH -		WEIGHT -		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 4 OF 4 REV E1	