

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

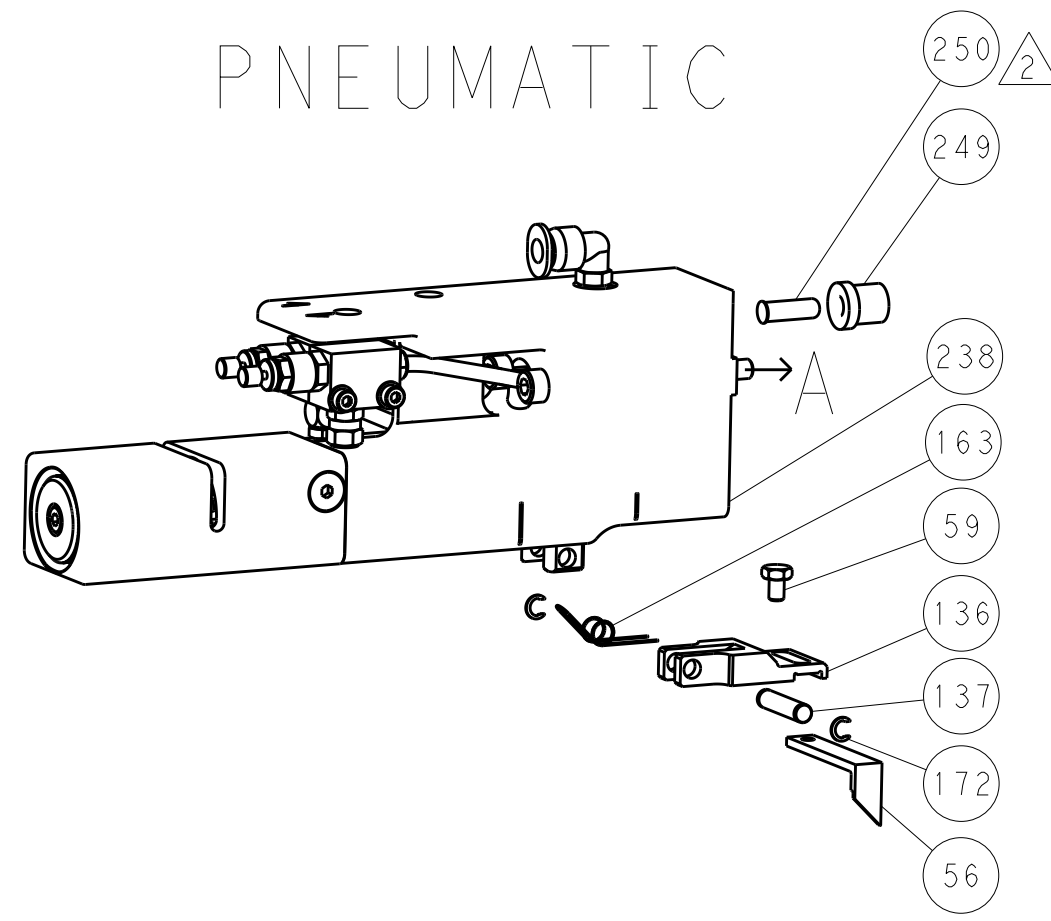
C

B

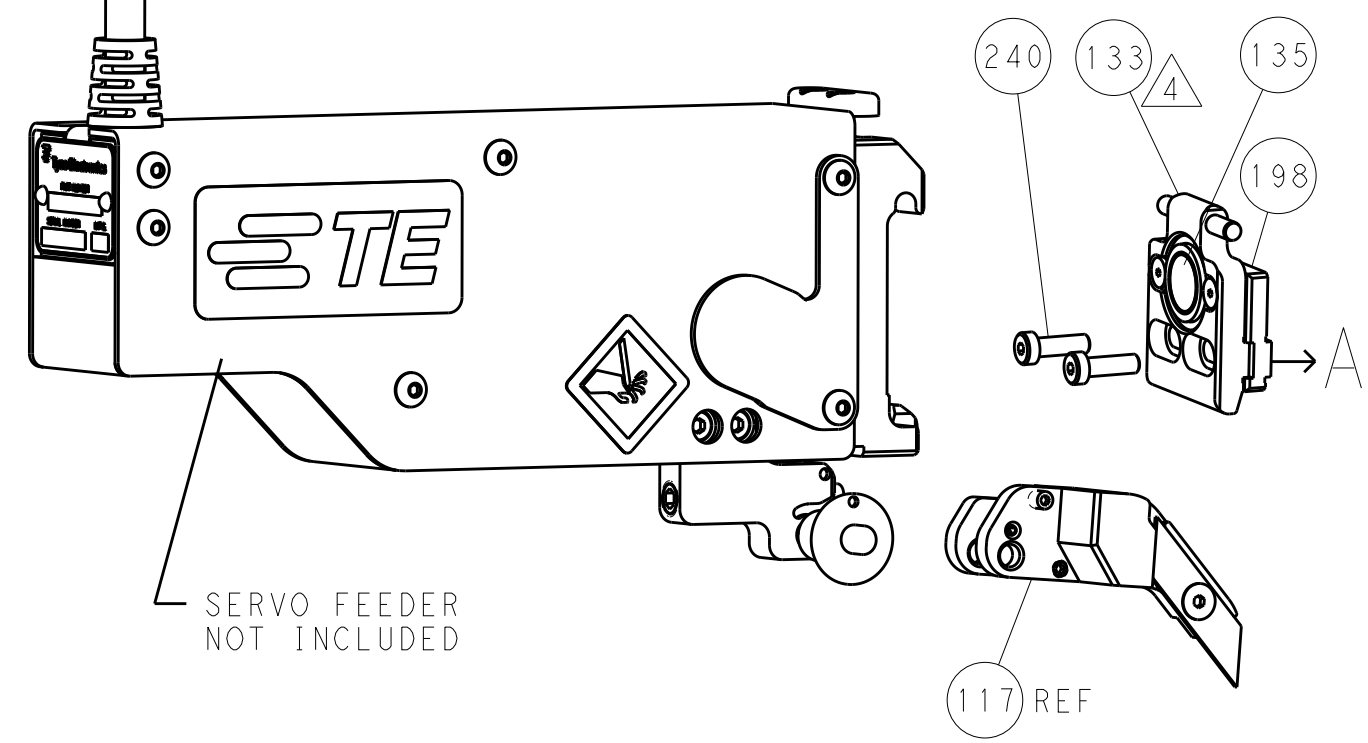
A

FEED TYPE

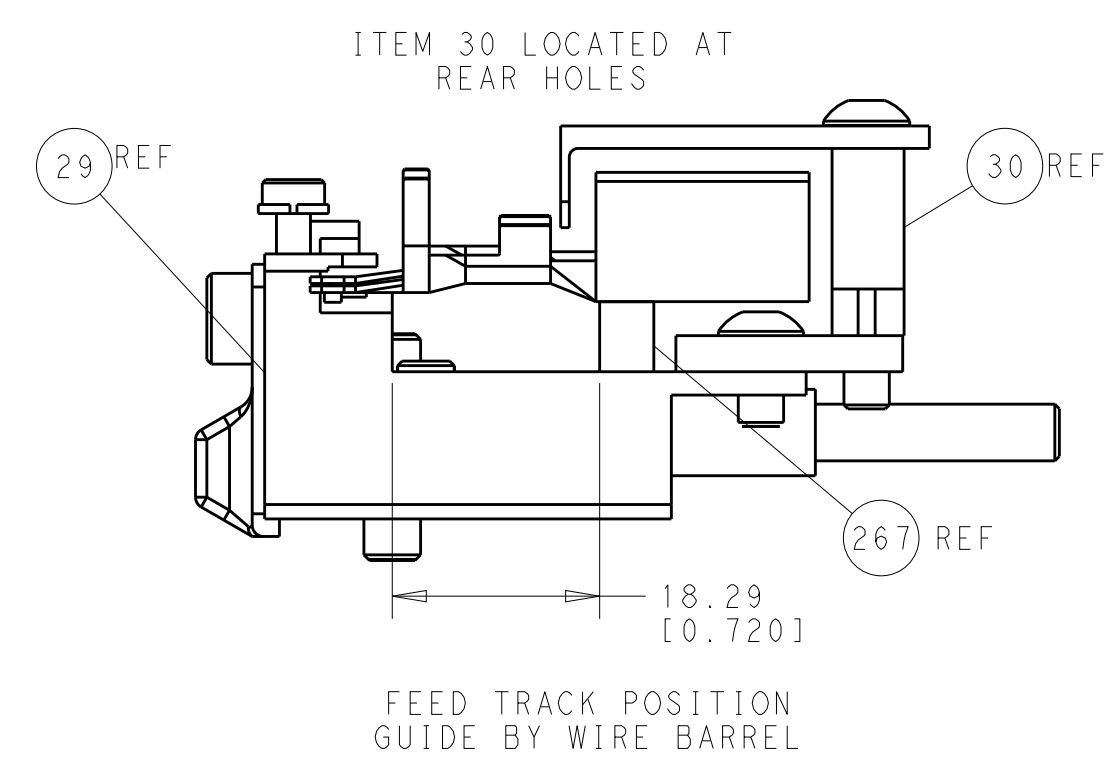
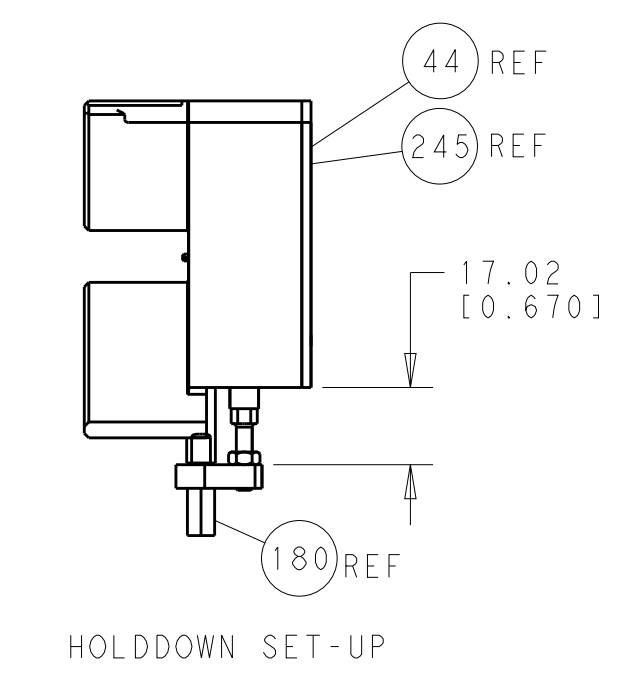
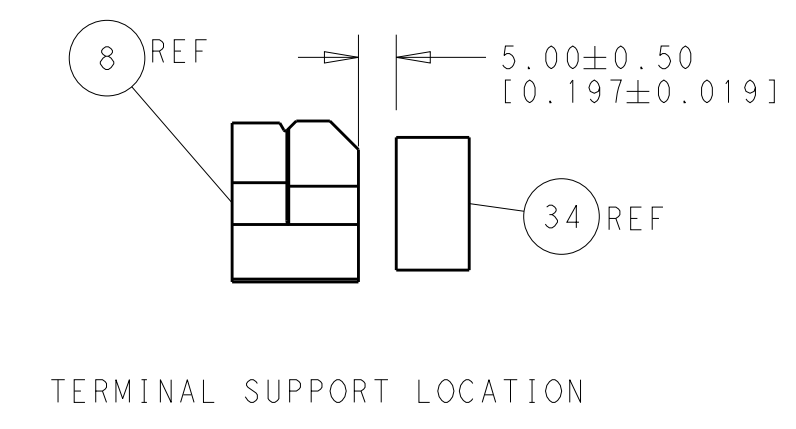
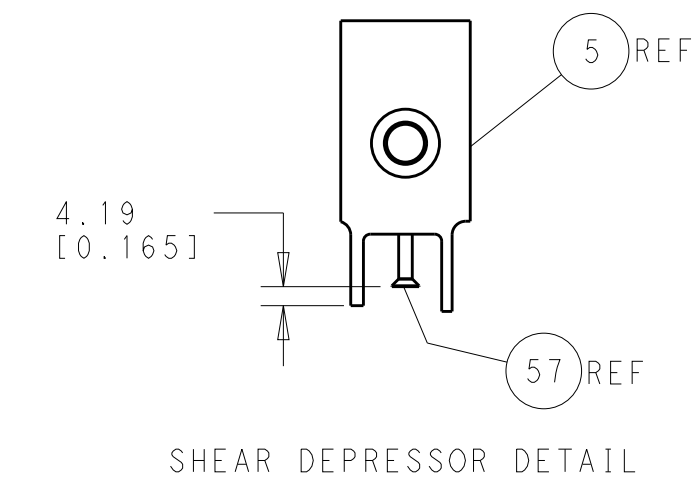
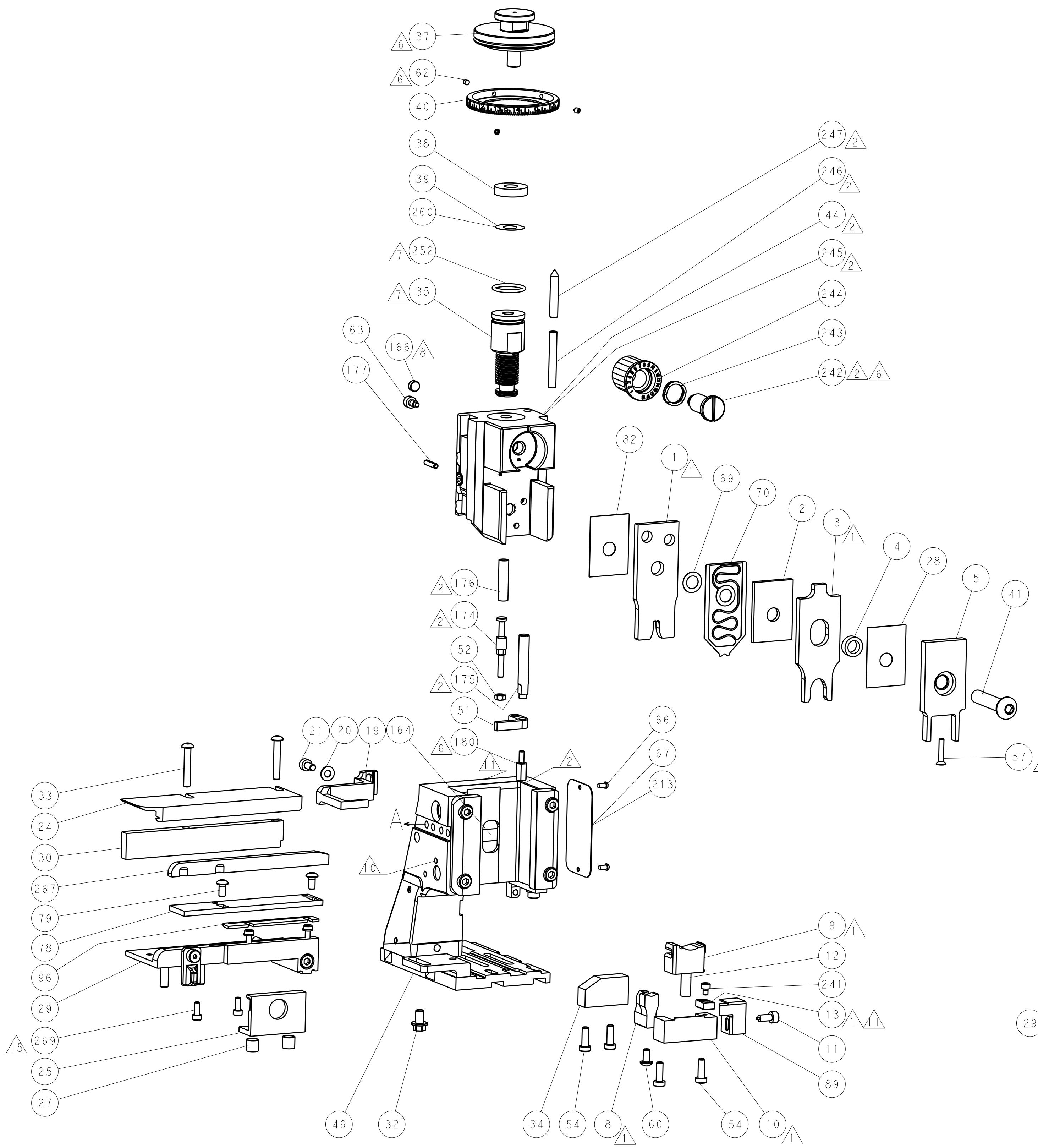
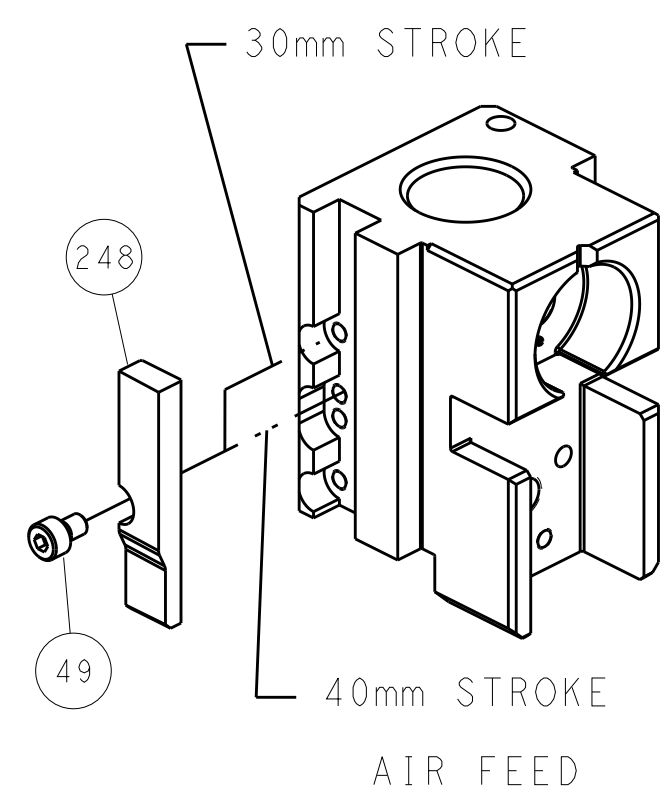
PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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

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

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20				DWN 01JAN2012				TE Connectivity			
COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.				CHK 01JAN2012				Harrisburg, PA 17105-3608			
				APVD 01JAN2012				NAME			
								Ocean Side Feed			
								Applicator			
								SIZE CAGE CODE DRAWING NO			
								A1 00779 C-2151723			
								RESTRICTED TO			
								Customer Accessible Production Drawing			
								SCALE 1:1 SHEET 2 OF 4 REV A			



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.89 mm [.153]	F
INSUL	9.53 mm [.375]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: G&H TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MAK 8.0x0.8/9.5x1.2 Terminal			
WIRE STRIP LENGTH 7.40-7.70 mm [.291-.303 IN]			INSULATION DIAMETER RANGE Ø4.00-4.40 mm [.157-.173 IN]
TERMINAL APPLICATION SPECIFICATION	NONE	-	-
	-	-	-
TERMINALS APPLIED  			
TE TERMINAL	G&H TERMINAL	TE SEAL	G&H SEAL
1572996-1	28469.306.189	2113288-1	0211626A

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
4.00mm ²			2.50+/-0.05 [0.098+/-0.002]		6.8

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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151723-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151723-5
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, 180 & 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
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. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
13. 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.
14. CUT TO LENGTH AT ASSEMBLY.

6		5			4		3	
FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
	CONVERT TO	PART NUMBERS REQUIRED						
PNEUMATIC	-	-	-	-	-	-	-	
	SERVO LATCH PLATE	2119951-1	-	8-2151723-5	1901094-1	2-1752354-6	8-18023-4 (QUANTITY 2)	
	SMART APPLICATOR	2161326-1	-	8-2151723-4	-	-	-	
SERVO LATCH PLATE 	-	-	-	-	-	-	-	
	PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-2	2119799-1	2063440-3	
NONE	-	-	-	-	-	-	-	
-	-	-	-	-	-	-	-	

*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.

A	-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	269
	-	1	1	1	1633782-3	FENCE	267
	-	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	1-22279-3	SPRING, COMPRESSION	246
	-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6	-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
	-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)

		2							
SET UP GAUGE 2119599-1				LOC A	DIST 66	REVISIONS			
		P	LTR	DESCRIPTION		DATE	DWN	APVD	
			-	SEE SHEET 1					
6	-	-	2	-	8-18023-4	SCR, SKT HD CAP M5 X 35.0		240	
	-	-	-	1	2063440-3	AIR FEED MODULE		238	
	-	-	1	-	2119740-2	TAG, IDENTIFICATION		213	
	-	-	1	-	1901094-1	SPACER, FEEDER		198	
	-	1	1	1	2-1752354-6	STANDOFF, HOLD-DOWN		180	
	-	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0		177	
	-	1	1	1	8-22280-7	SPRING, COMPRESSION		176	
	-	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN		175	
	-	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN		174	
	-	-	-	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		
-	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		
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF		117		
-	1	1	1	2-690438-2	FRONT STRIP GUIDE		96		
-	1	1	1	318563-1	GUARD, FRONT CHIP		89		
-	1	1	1	455888-4	SPACER, CRIMPER		82		
-	2	2	2	18024-6	SCR, BTN SKT HD CAP (M4 X 8.0)		79		
-	1	1	1	1803096-1	EXTENSION PLATE		78		
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE		71		
-	1	1	1	2119791-9	DEPRESSOR, WIRE		70		
-	1	1	1	2119943-1	WASHER, SPACER		69		
-	1	-	1	2119740-1	TAG, IDENTIFICATION		67		
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS		66		
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT		63		
6	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0		62	
3	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59	
1	-	1	1	1	985575-5	SCR, FLT SKT HD CAP M3 X 16.0		57	
-	-	-	-	1	1338683-8	FEED PAWL		56	
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5		52	
-	1	1	1	1	1901681-2	HOLDDOWN, TERMINAL		51	
-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49	
-	1	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)		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	1-2119644-3	RAM WASHER, PRECISION		38	
-	1	1	1	1	1-1752356-1	SUPPORT, TERMINAL		34	
-	2	2	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)		33	
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG		32	
-	1	1	1	1	1-1320908-8	SPACER, STRIP GUIDE		30	
-	1	1	1	1	2119959-5	ASSEMBLY, STRIP GUIDE		29	
-	1	1	1	1	455888-3	SPACER, CRIMPER		28	
-	2	2	2	2	22281-8	SPRING, COMPRESSION		27	
-	1	1	1	1	240792-1	DRAG, TERMINAL		25	
-	1	1	1	1	1320928-8	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	1803013-1	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	1-356885-3	STOP, SHEAR		11	
1	-	1	1	1	1-2119805-0	SHEAR HOLDER, FRONT		10	
1	-	1	1	1	1-318059-0	FLOATING SHEAR, FRONT		9	
1	1	1	1	1	1633930-9	ANVIL, COMBINATION		8	
-	-	-	-	-	-	-		7	
-	-	-	-	-	-	-		6	
-	1	1	1	1	1803080-1	DEPRESSOR, SHEAR		5	
-	1	1	1	1	2-238011-7	BLOCK, CRIMPER SPACER		4	
1	1	1	1	1	2-1633996-9	CRIMPER, INSULATION SPECIAL		3	
-	1	1	1	1	2-455888-5	SPACER, CRIMPER		2	
1	1	1	1	1	7-1633609-2	CRIMPER, WIRE		1	
-77	-27	-25	-22	PART NO		DESCRIPTION		ITEM NO	
PLOT DRAWING IS A CONTROLLED DOCUMENT FOR THE TELEPHONY ORGANIZATION IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR THE LATEST REVISION DOWNSIDE OF CONTROLLED DOCUMENT FOR THE LATEST REVISION				DWN	01JAN2012				
				CHK	01JAN2012				
				APVD	01JAN2012				
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME			
mm						Ocean Side Feed Applicator			
				0 PLC ±.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES .2		SIZE			
MATERIAL				FINISH		DRAWING NO			
						RESTRICTED TO			
				WEIGHT		A 00779 C-2151723			
				Customer Accessible Production Drawing		SCALE 1:1 SHEET 3 OF 4 REV A			

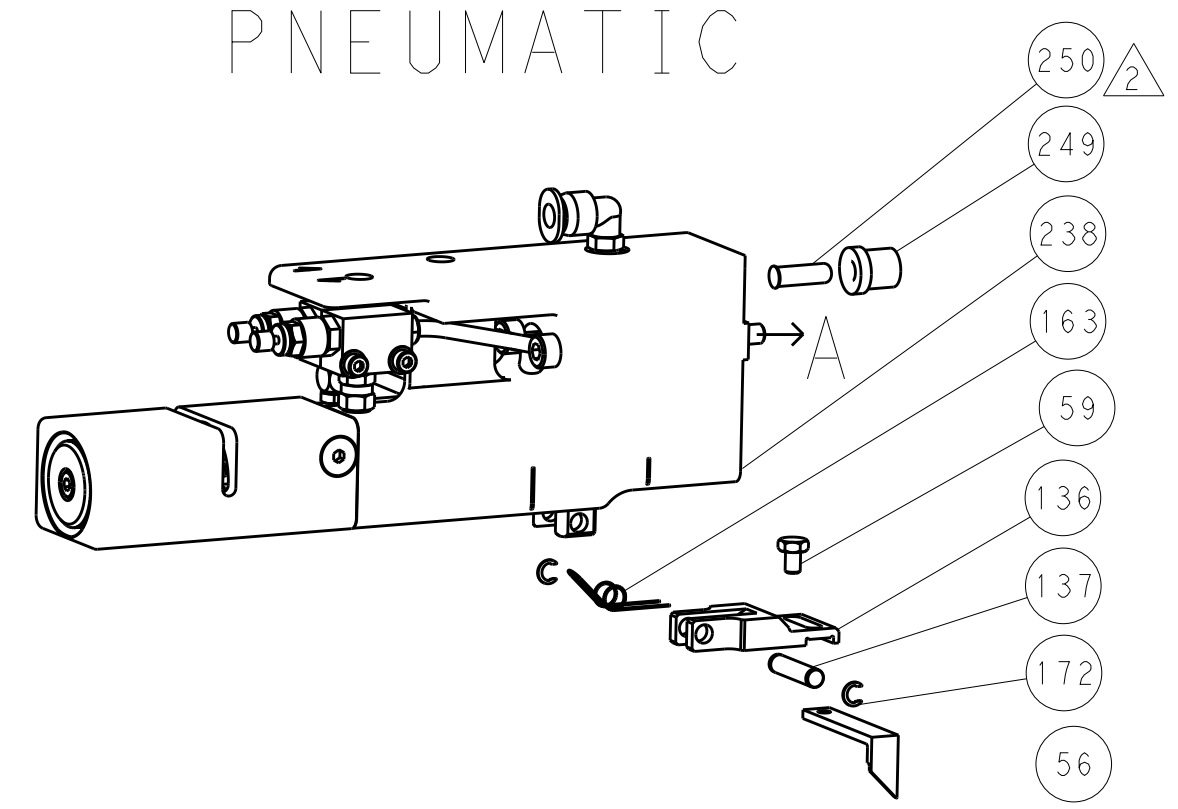
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

C

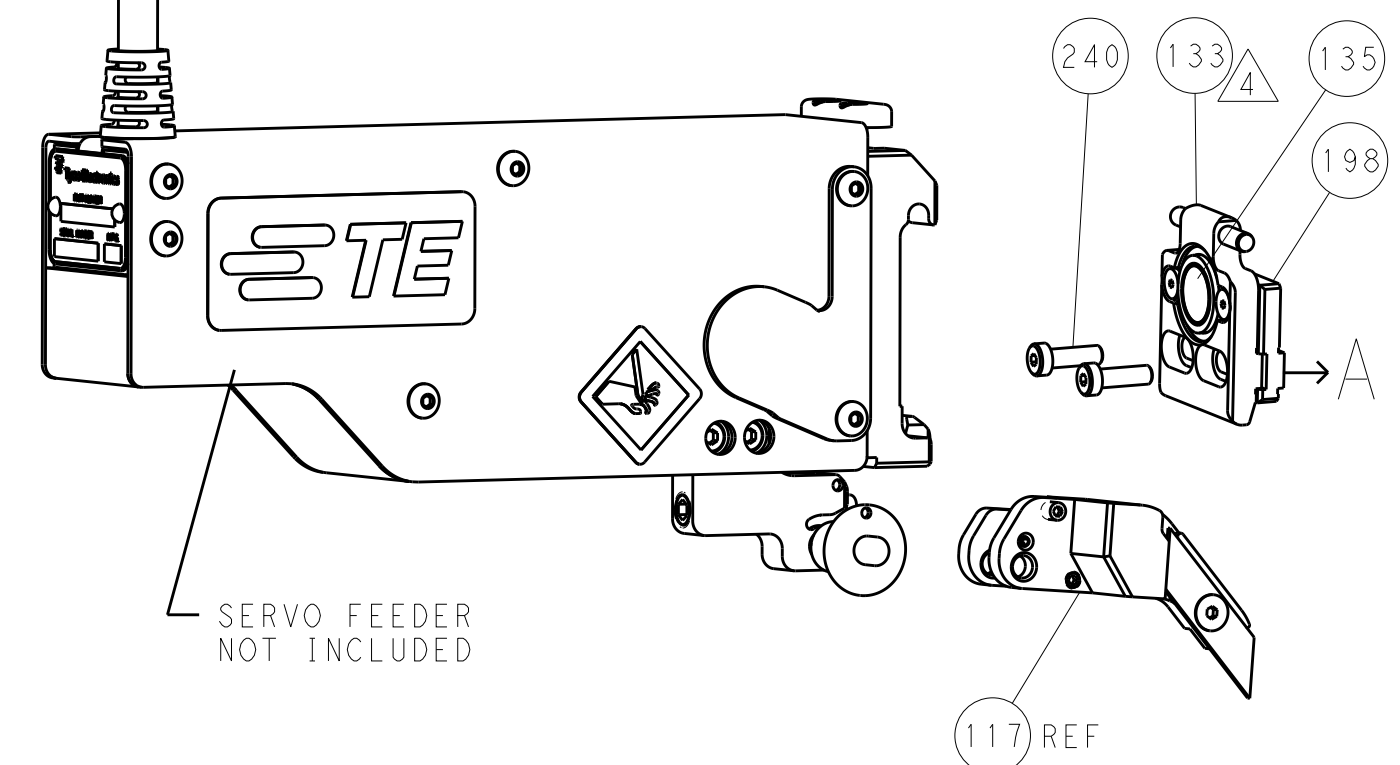
B

A

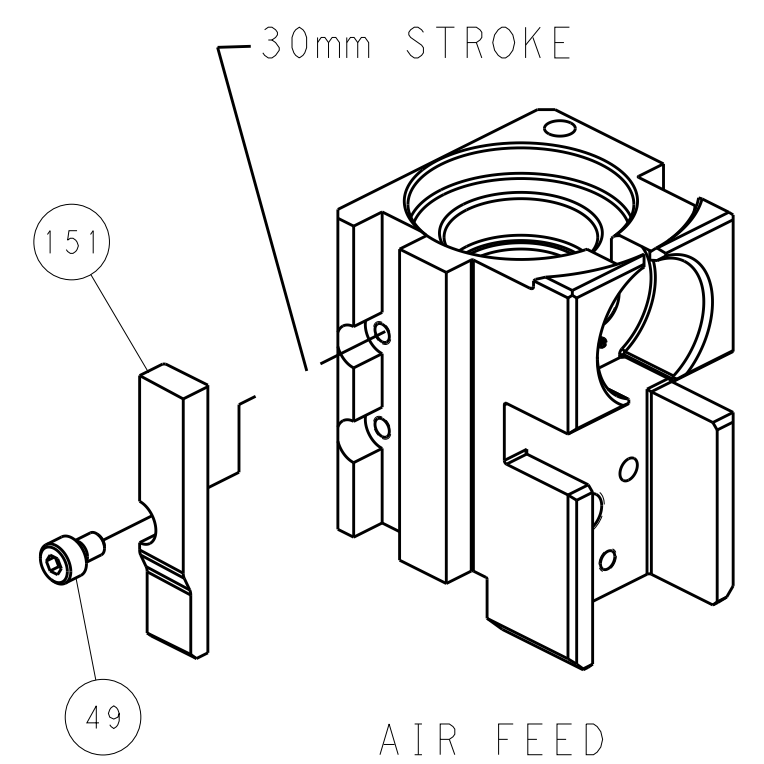
FEED TYPE PNEUMATIC



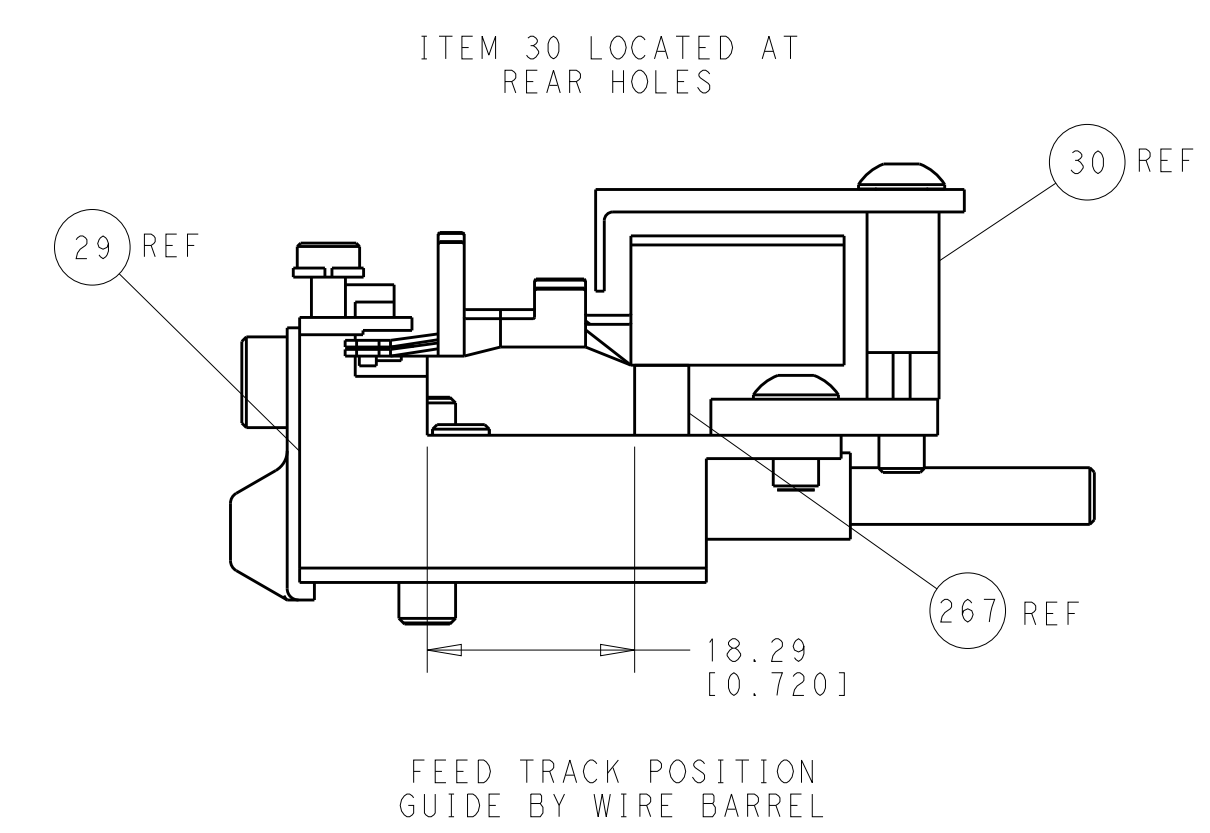
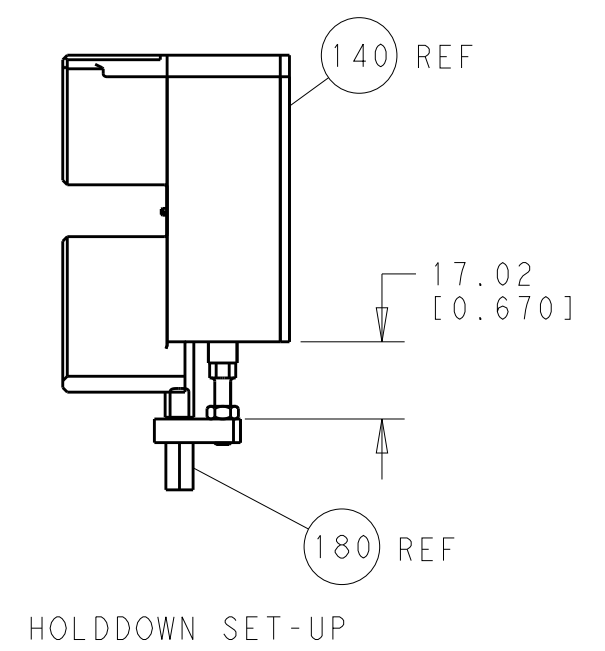
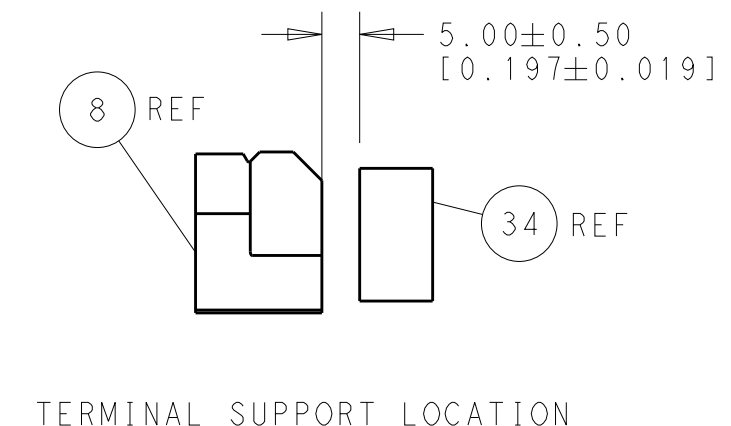
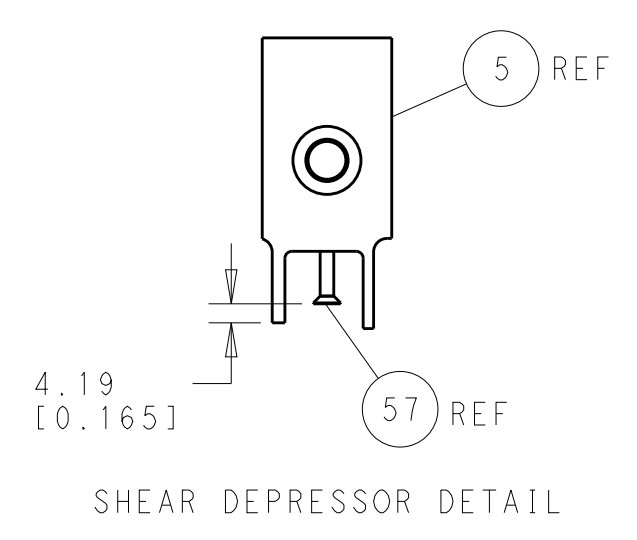
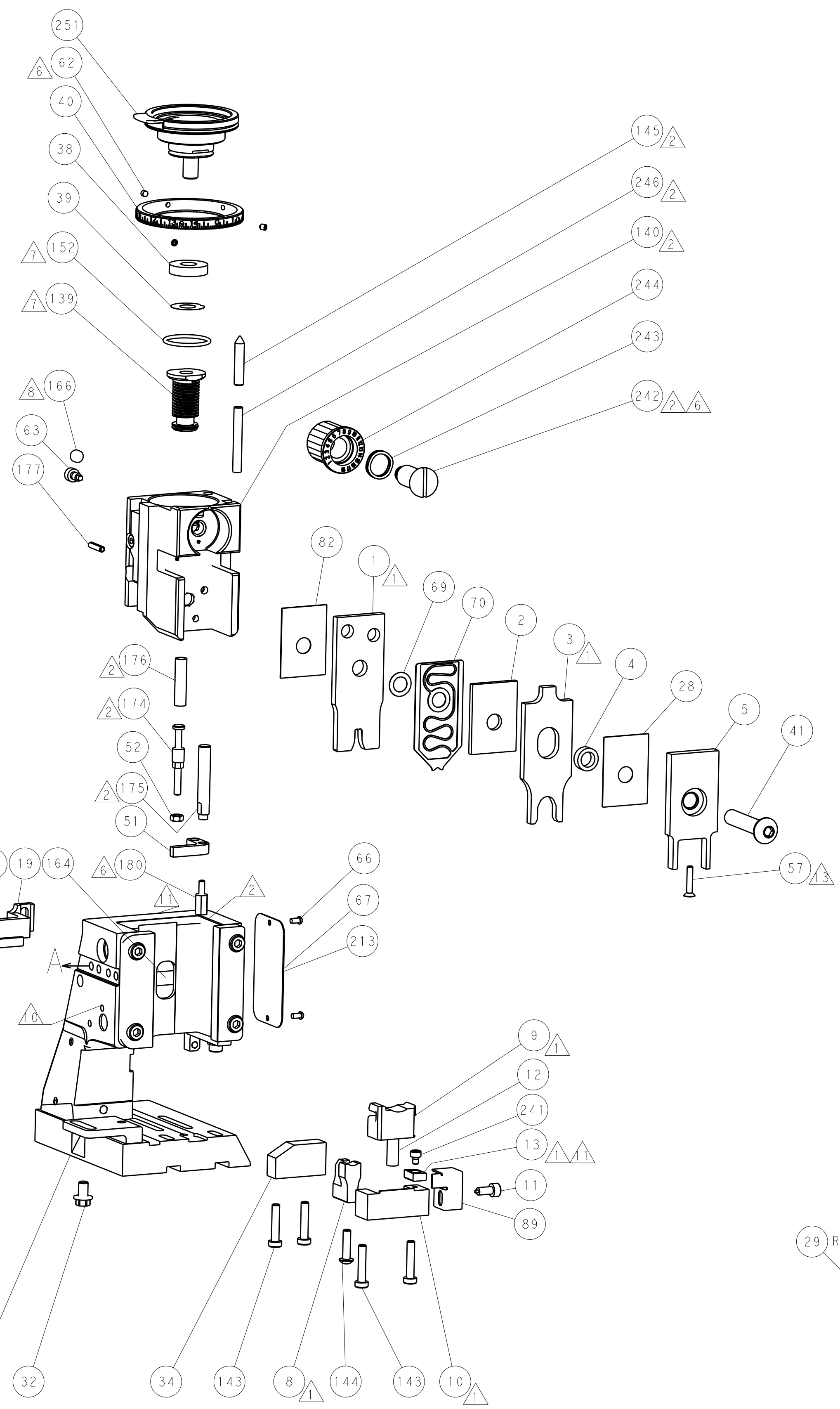
SERVO LATCH PLATE



CAM POSITION



AIR FEED



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. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN	01JAN2012	STE TE Connectivity Harrisburg, PA 17105-3608	
		CHK	01JAN2012		
		APVD	01JAN2012	NAME	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	
mm		0 PLC ±.1		APPLICATION SPEC	
		1 PLC ±0.1		WEIGHT	
		2 PLC ±0.02		SCALE	
		3 PLC ±0.005		SHEET	
		4 PLC ±0.0005		OF	
MATERIAL		FINISH		REV	
				A	
				Customer Accessible Production Drawing	