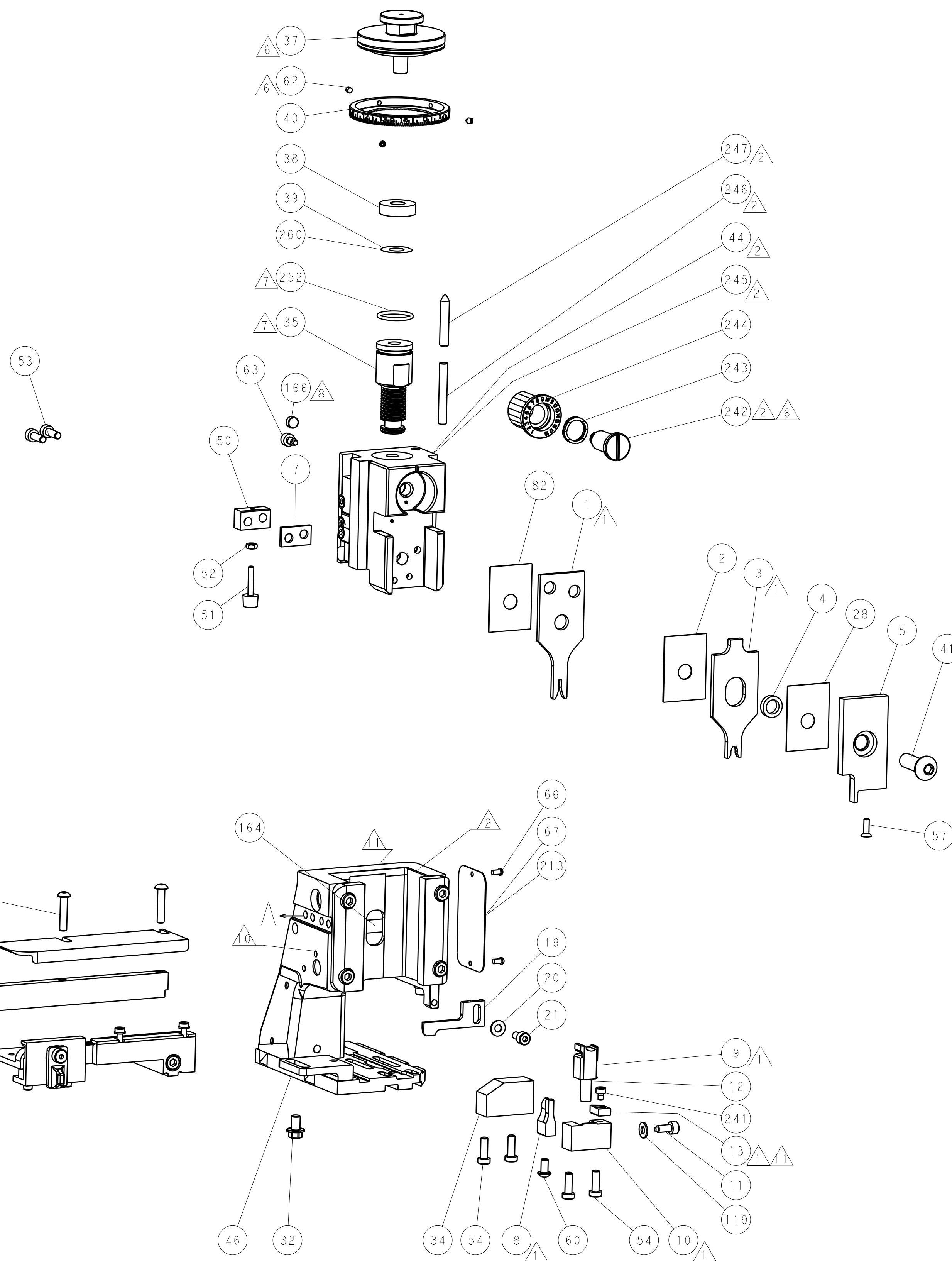
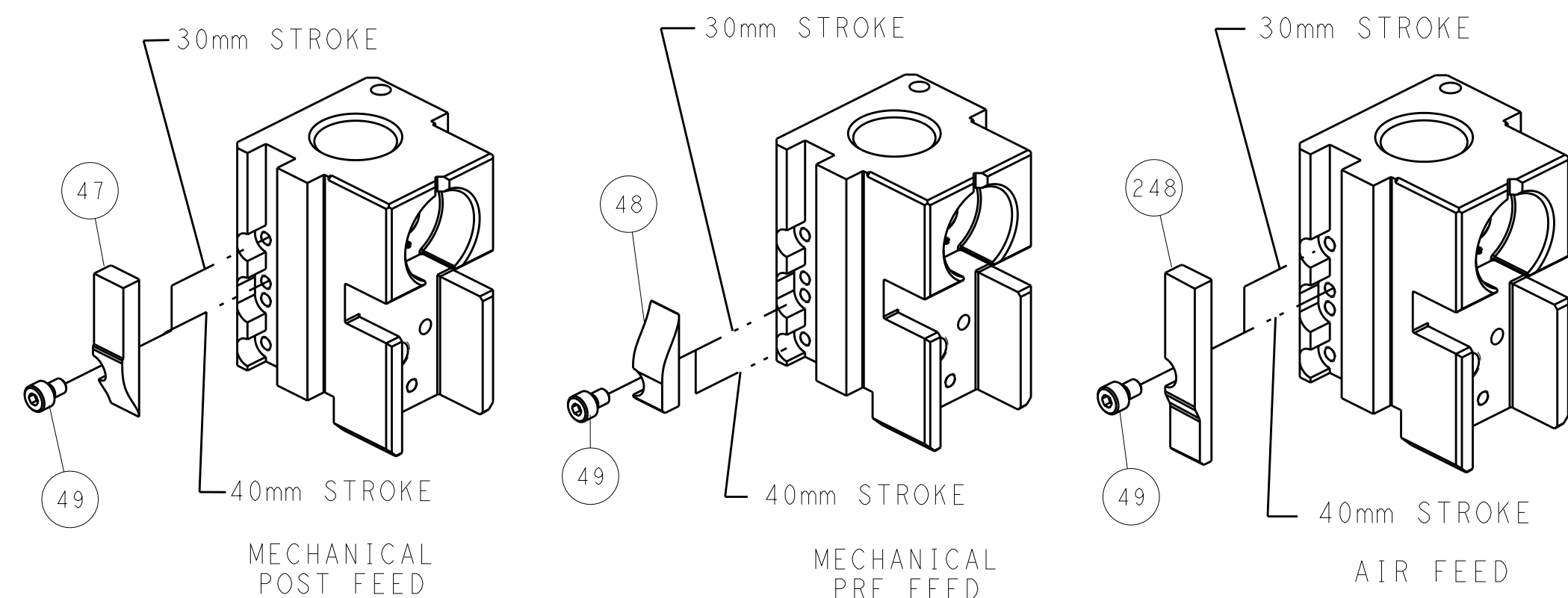


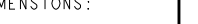
PNEUMATIC

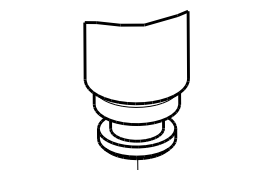
SERVO
LATCH PLATE

CAM POSITIONS



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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ENGINEERING CORPORATION IT IS SUBJECT TO CHANGES AND THE CONTROLING ENGINEERING CORPORATION MAY BE REVISED OR CONTROLLED FOR THE PURPOSE OF PREVENTION		DWN K HUANG 17APR2013		 TE Connectivity Harrisburg, PA 17105-3608	
		CHK L ZHANG 17APR2013			
		APP'D U GUO 17APR2013			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ± 1 PLC ±0.1 2 PLC ±0.02 4 PLC ±0.005 4 PLC ±0.0005		Ocean Side Feed Applicator	
		APPLICATION SPEC - WEIGHT -		SIZE A1	
MATERIAL		FINISH		CAGE CODE DRAWING NO	
-		-		00779 C=2151928	
				RESTRICTED TO	
				-	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 2 OF 4 REV A	

	8	7	6	5	4	3					
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151928-1	A	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	-	8-2151928-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151928-4	-	-	-
	2-2151928-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151928-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151928-4	-	-	-
	2-2151928-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
	2-2151928-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	7-2151928-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.43 mm [.135]	O

APPLICATOR INSTRUCTIONS
408-10389



TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MQS 1mm SOCKET CONTACT, SWS			
WIRE STRIP LENGTH 3.45-3.75 mm [.136-.148 IN]		INSULATION DIAMETER RANGE Ø 2.40-2.60mm [.094-.102 IN] 	
TERMINAL APPLICATION  114-18231		-	
SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
167048-2		967067-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.50mm2		1.01+/-0.03 [0.40+/- .001]		7.5
0.35mm2		0.92+/-0.03 [0.36+/- .001]		8.4



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: 8-2151928-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151928-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151928-5
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. 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. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION RANGE QUOTED IS THAT OF THE TERMINAL. THE SEAL INSULATION RANGE IS 1.4- 2.1mm [.055 - .083 IN.]
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. INSULATION CRIMP HEIGHT 2.8mm MAX, CRIMP WIDTH 3.6mm MAX.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-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	LTB	DESCRIPTION			DATE	OWN	APVD	
	-	SEE SHEET 1			-	-	-	
-	-	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	2119082-7	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		24	
1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		24	
-	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	
-	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	
1	1	1	1	455888-5	SPACER, CRIMPER		82	
1	1	1	1	2119956-1	DOCUMENTATION PACKAGE		7	
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	985575-3	SCR, FLT SKT HD CAP M3 X 10.0		57	
-	-	1	1	1338685-1	PAWL, FEED		56	
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	2119957-1	APPLICATOR SHIM PACK		3	

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DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC $\pm$ 1 PLC ± 0.1 2 PLC ± 0.02 3 PLC ± 0.05 4 PLCS ± 0.0005 ANGLES $\pm$		17APR2013	
		PRODUCT SPEC		Ocean Side Feed Applicator	
MATERIAL		APPLICATION SPEC		-	
FINISH		WEIGHT		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
-		-		A 00779 C=2151928 -	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 3 OF 4 REV A	

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

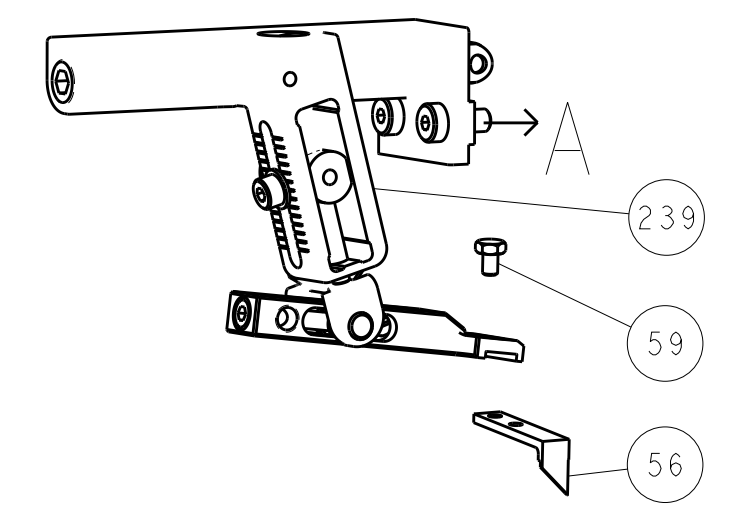
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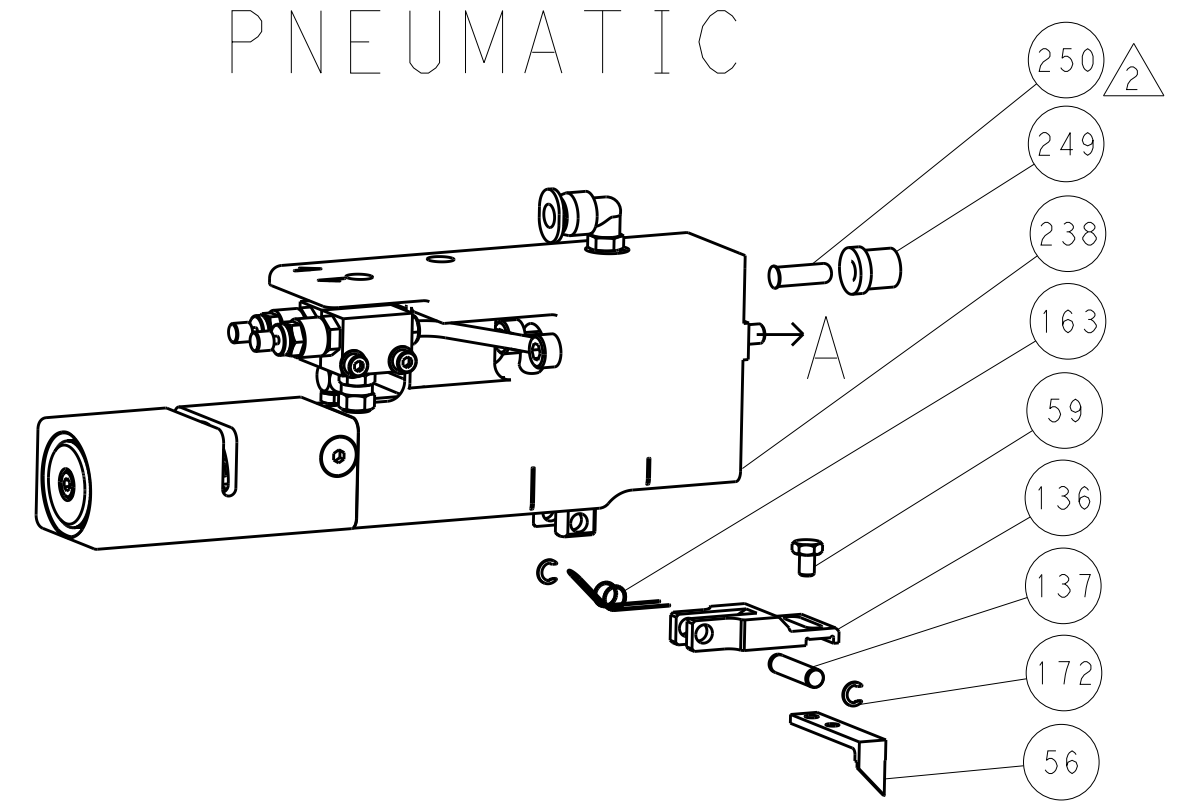
C

D

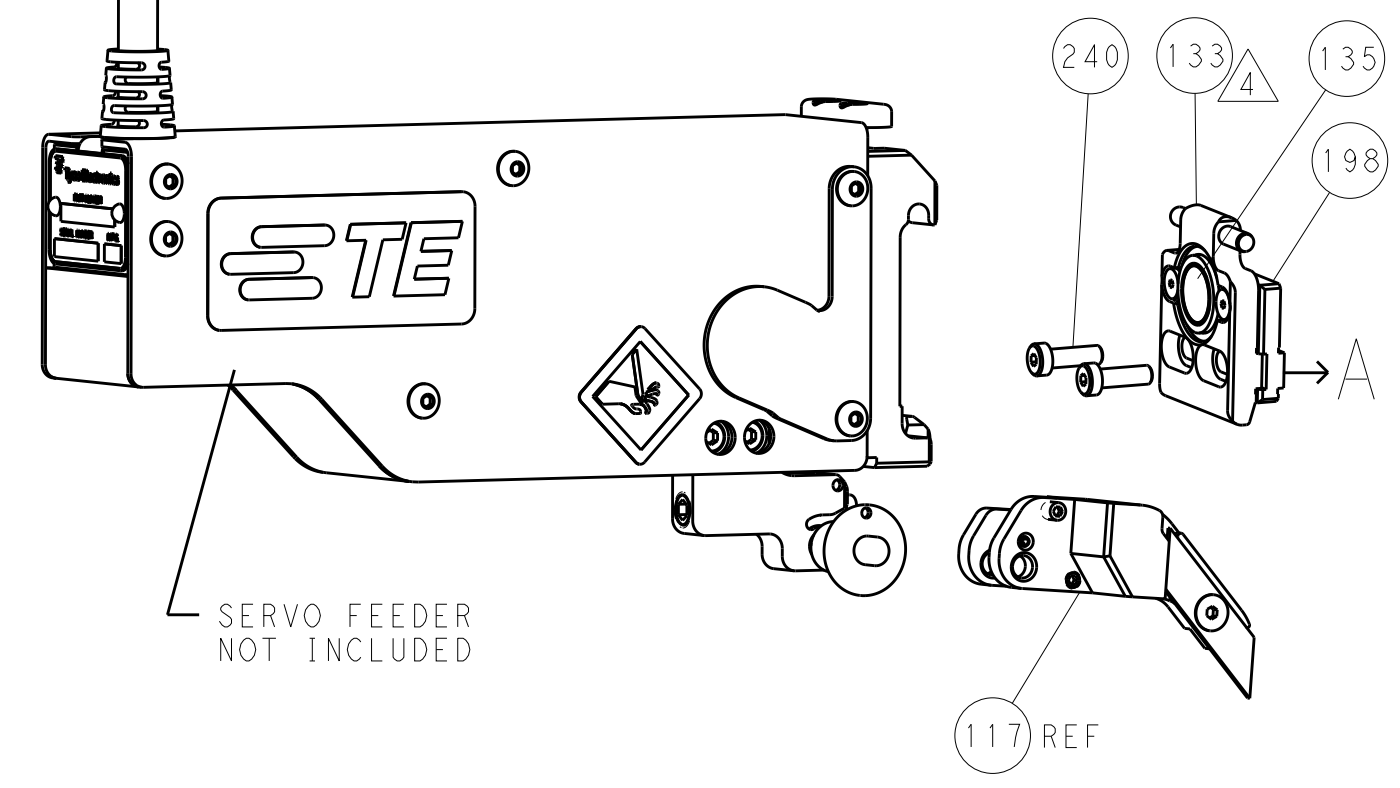
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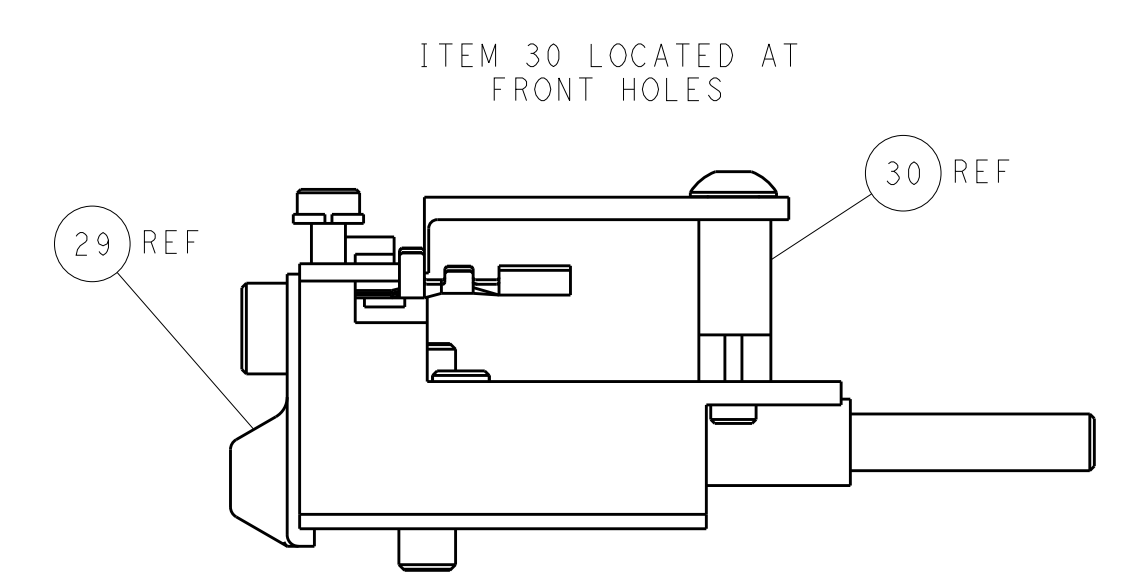
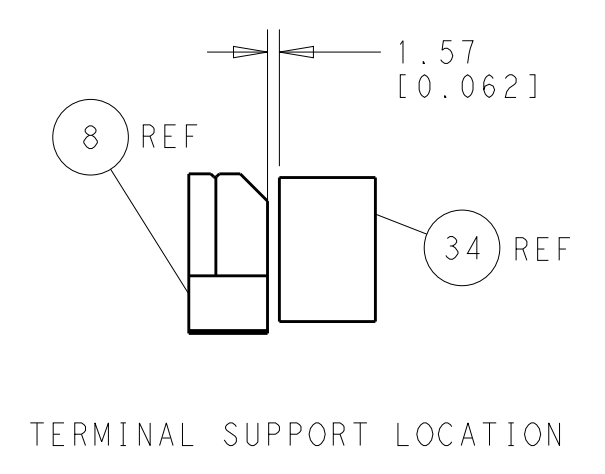
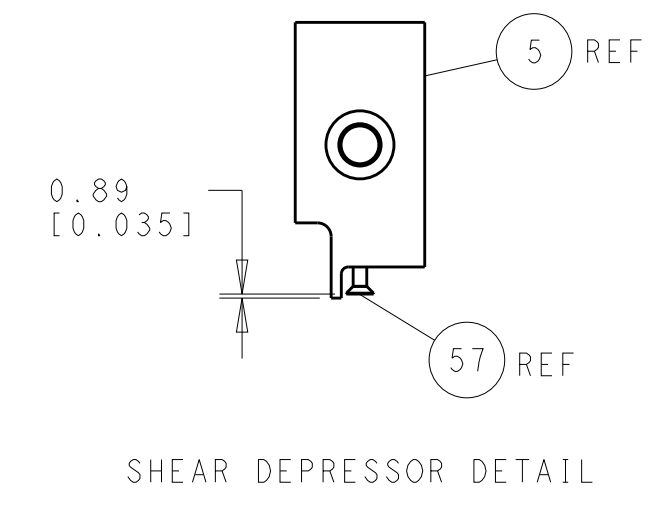
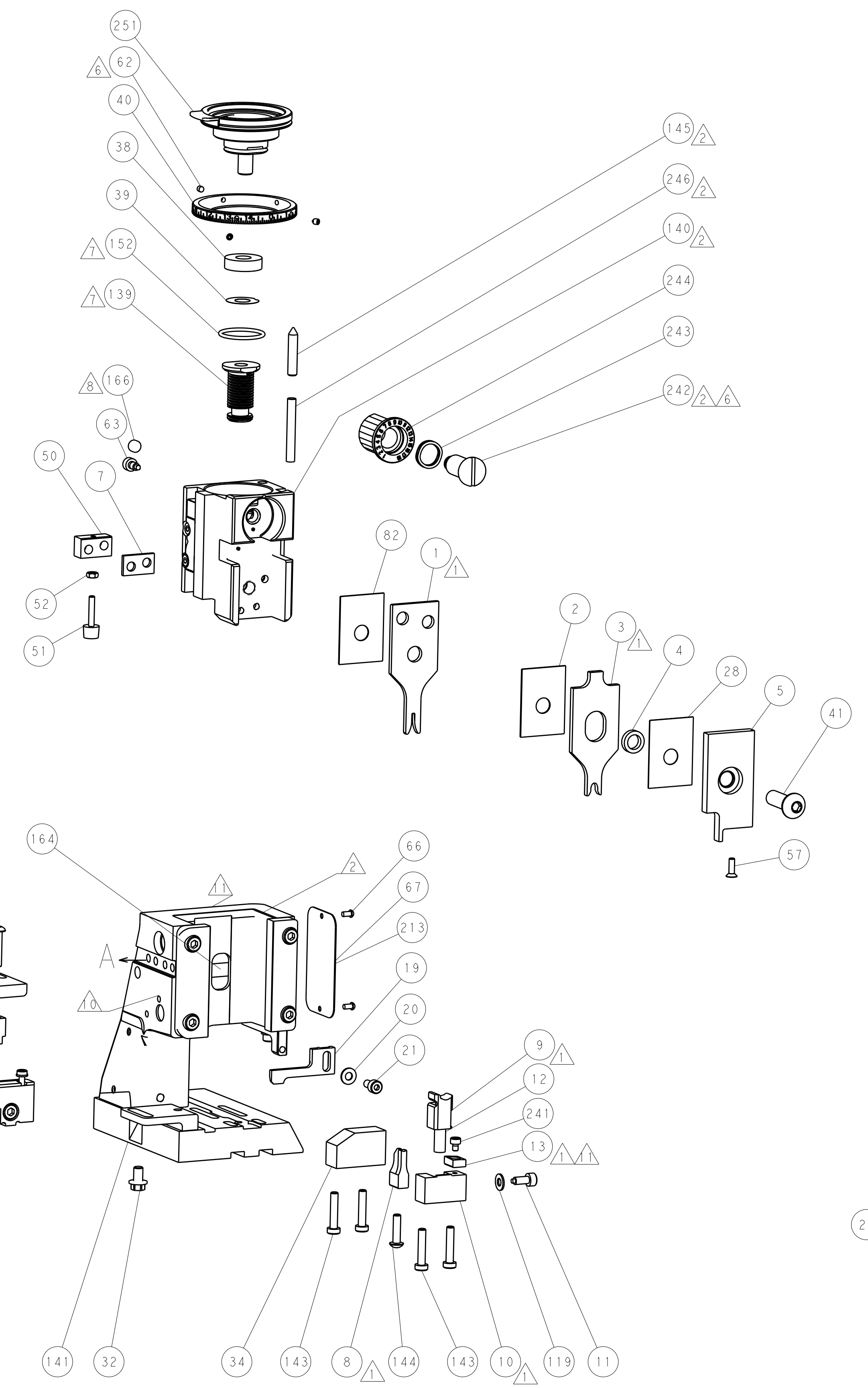
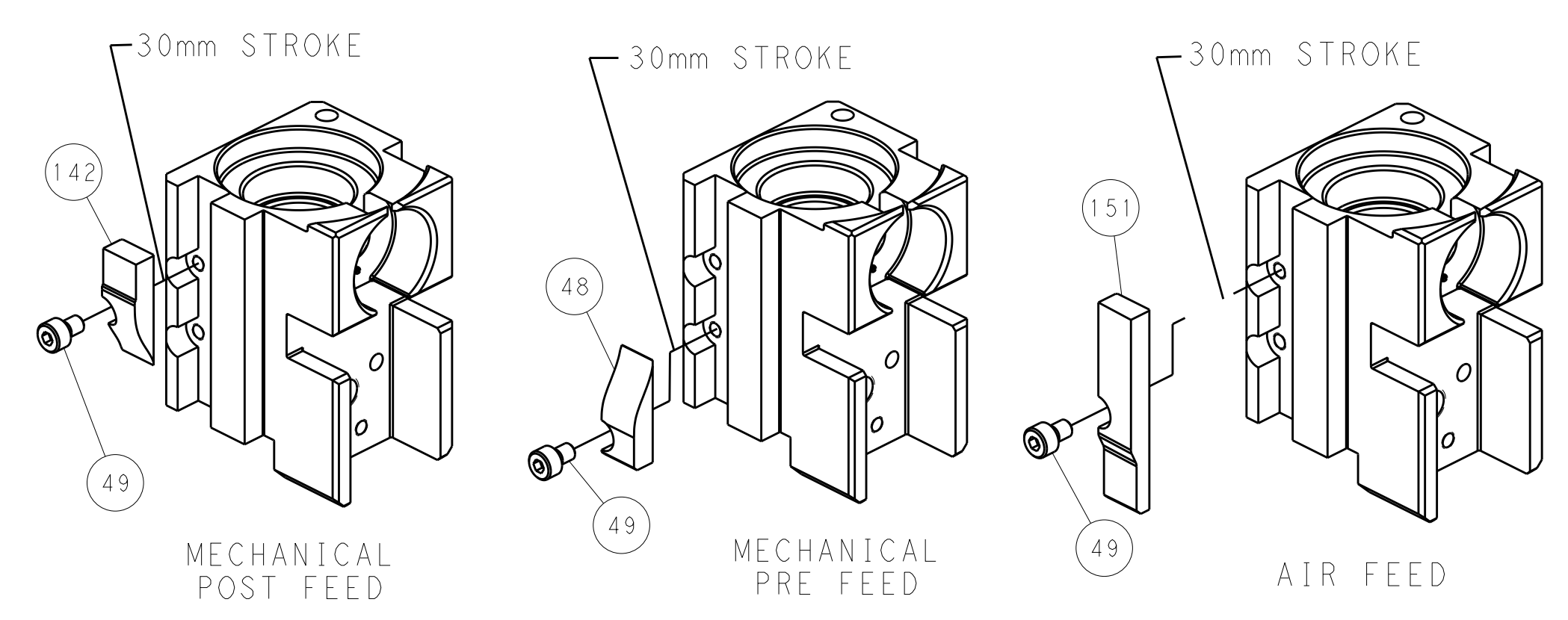
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±.1		PRODUCT SPEC -	SIZE A1
MATERIAL -		WEIGHT -		APPLICATION SPEC -	CAGE CODE 00779
Customer Accessible Production Drawing		SCALE 1:1		SHEET 4	OF 4
				REV A	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION