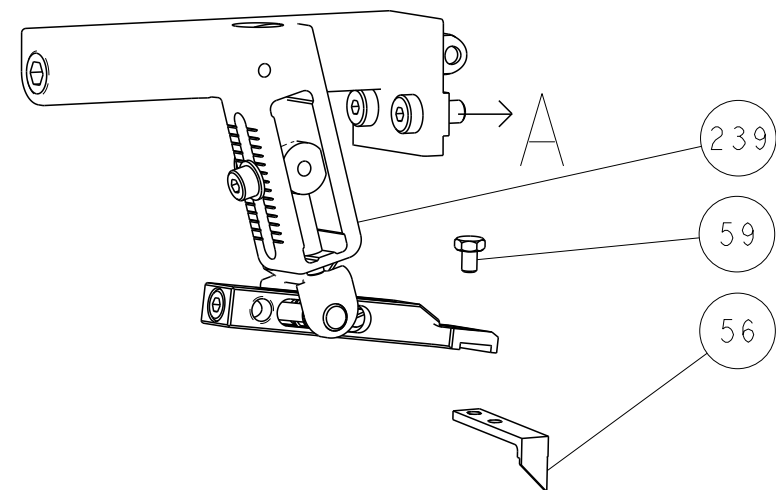
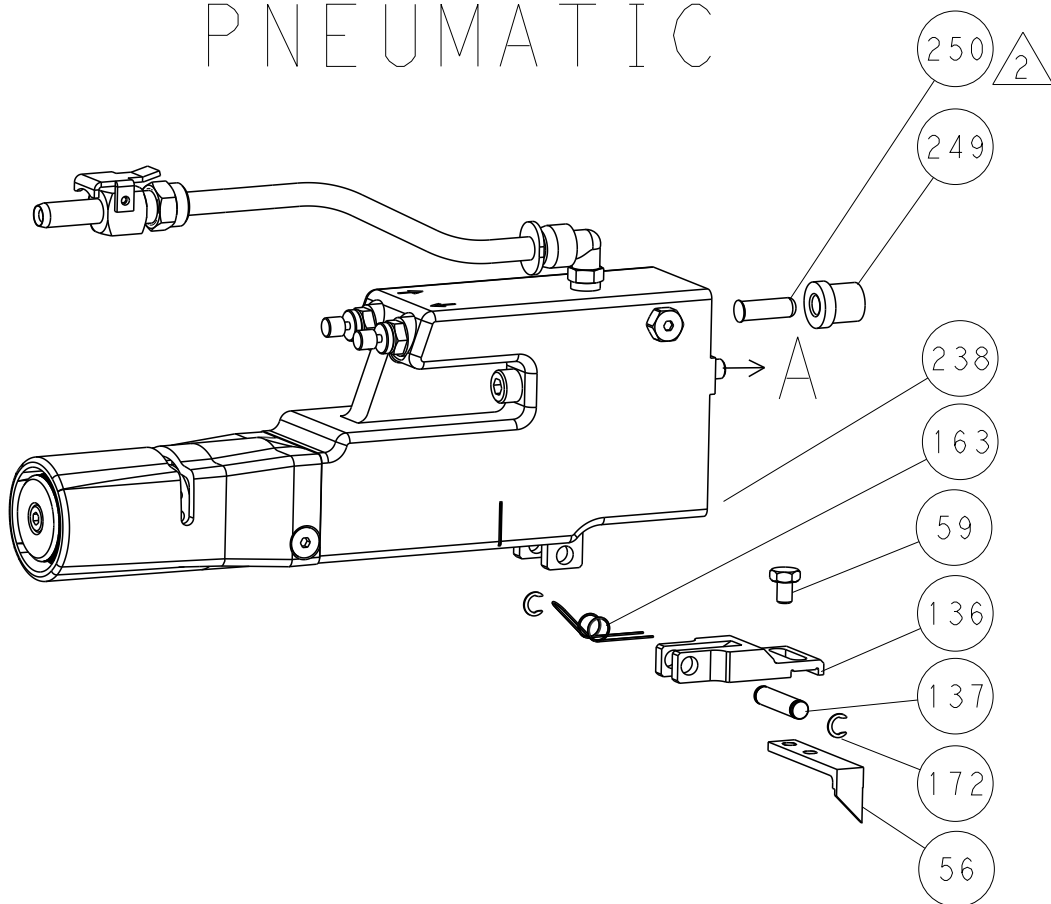


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A	66	P	LTR	DESCRIPTION		DATE	DWN	APVD
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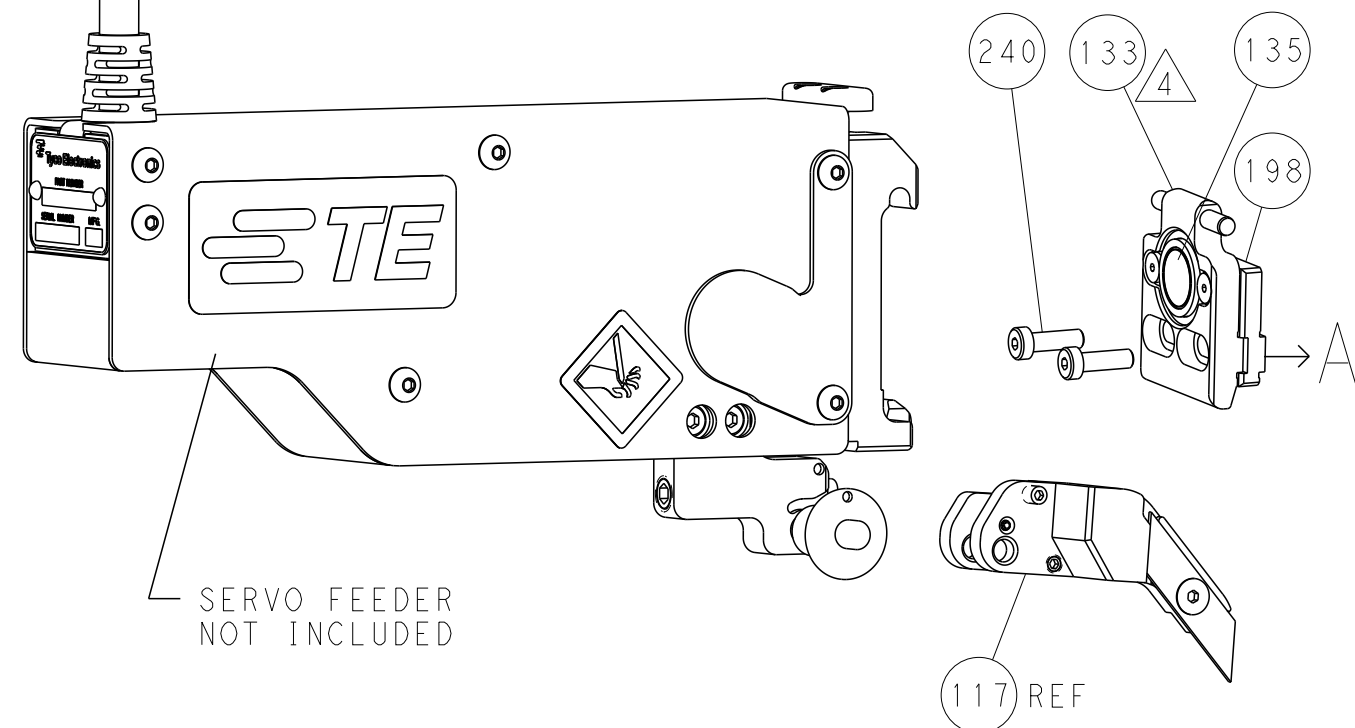
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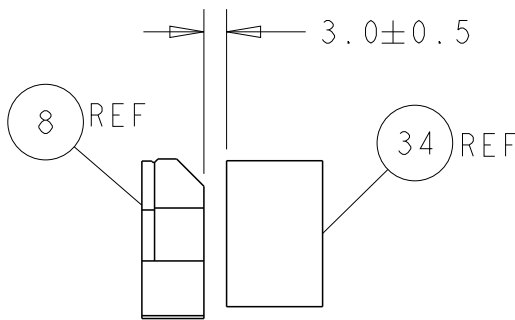
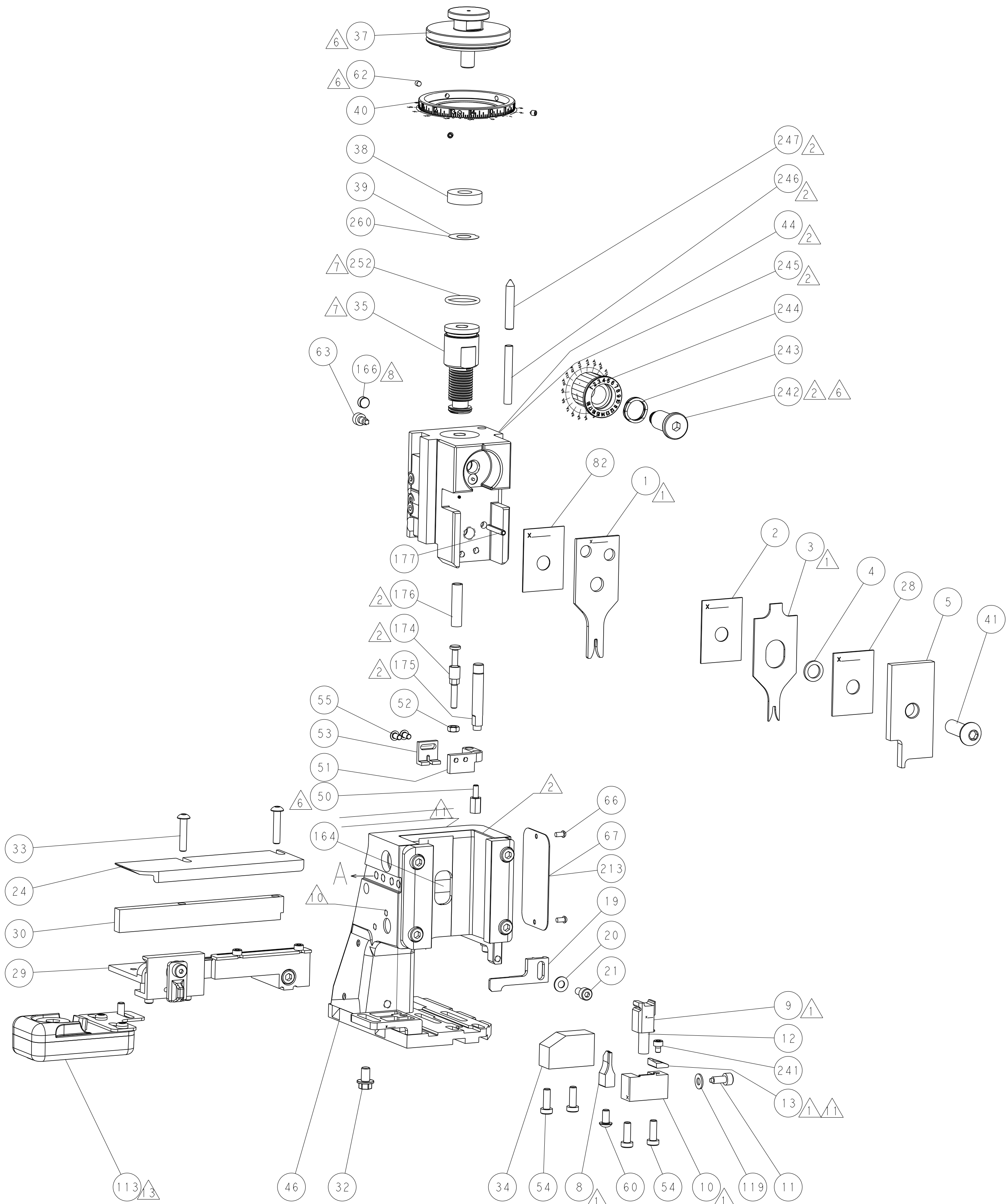
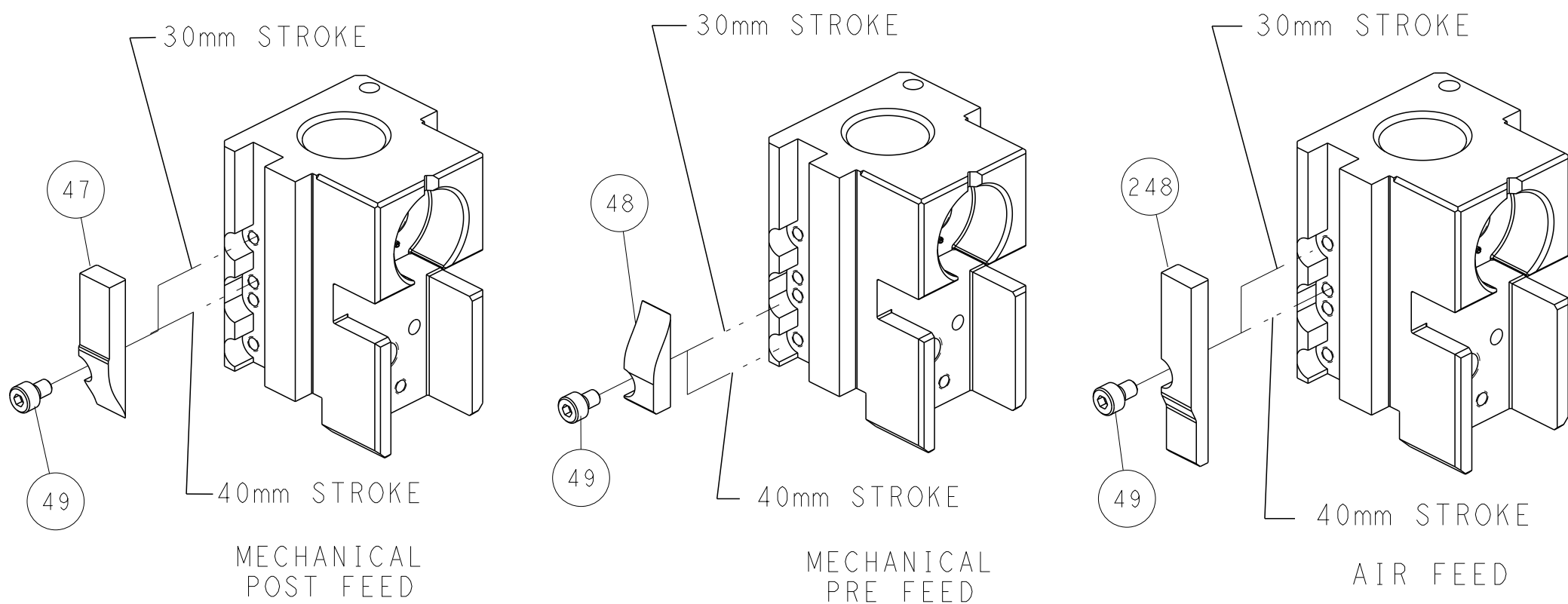
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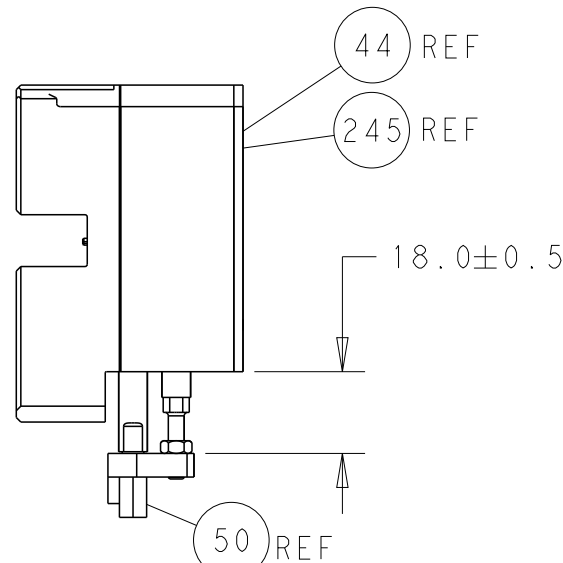
SERVO
LATCH PLATE



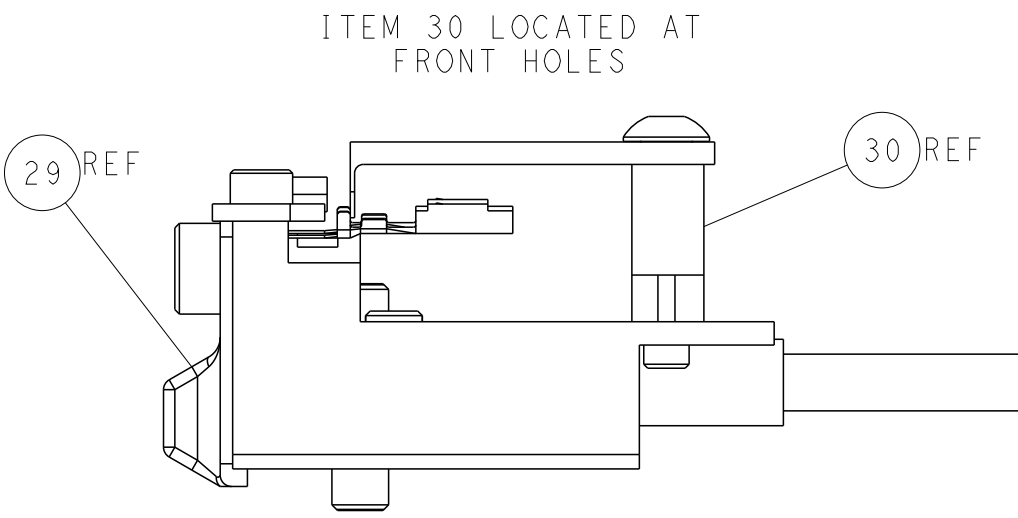
CAM POSITIONS



TERMINAL SUPPORT LOCATION

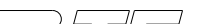


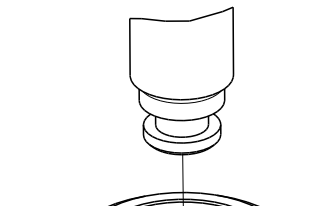
HOLDDOWN SET-UP



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THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE USER TO VERIFY THE LATEST VERSION OF THE DRAWING.				DWN	L. ZHANG	13OCT2011	 TE Connectivity						
				CHK	L. ZHANG	13OCT2011	Harrisburg, PA 17105-3608						
				APVD	S. XI	13OCT2011	NAME Ocean Side Feed Applicator -						
				PRODUCT SPEC									
				APPLICATION SPEC									
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO						
				A1	00779	C=2151240							
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE	1:2	SHEET	2	OF	4	REV	C

	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151240-1	C	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	-	8-2151240-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151240-4	-	-	-
	2-2151240-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151240-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151240-4	-	-	-
	2-2151240-5	C	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
	2-2151240-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2151240-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.90 mm [.075]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: DYNAMIC 2000 SERIES REC CONTACT "S" SIZE							
WIRE STRIP LENGTH 2.90-3.90 mm [.114-.154 IN]		 INSULATION DIAMETER RANGE Ø0.88-1.50 mm [.035-.059 IN]					
TERMINAL APPLICATION SPECIFICATION	114-5258	-	-	-	-	-	-
TERMINALS APPLIED							
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1318106-1							

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
24 AWG OR 0.20mm2		0.71+/-0.03 [.028+/- .001]		10.3
26 AWG OR 0.12mm2		0.67+/-0.03 [.026+/- .001]		10.7
28 AWG OR 0.09mm2		0.64+/-0.03 [.025+/- .001]		11.2



- 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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151240-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151240-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151240-5
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 50 & 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.
- 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 LUBRICANT IS RECOMMENDED.

TERMINAL DATA: TE TERMINAL				TE CRIMP SPECIFICATION			
TERMINAL NAME: D-2 TAB CONTACT "S" SIZE							
WIRE STRIP LENGTH 2.90-3.90 mm [.114-.154 IN]		 INSULATION DIAMETER RANGE Ø0.88-1.50 mm [.035-.059 IN]					
TERMINAL APPLICATION SPECIFICATION	114-5258	-	-	-	-	-	-
TERMINALS APPLIED							
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1318110-1							

*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
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-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)

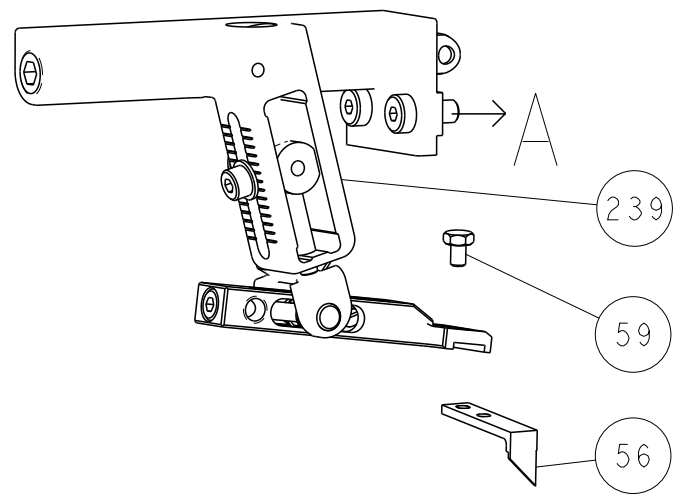
SET UP GAUGE 2119599-1	LOC A	DIS 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	DWN	APVD
			-		SEE SHEET 1	-	-	-

	-	1	1	1	1	2119082-9	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
	-	-	1	-	-	2119740-2	TAG,IDENTIFICATION	213
	-	-	1	-	-	1901094-3	SPACER, FEEDER	198
	-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
	-	-	-	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	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
	-	1	1	1	1	455888-5	SPACER, CRIMPER	82
	-	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	1338685-1	PAWL, FEED	56
	-	2	2	2	2	1655785-9	SCR, BTN SKT HD CAP (M3 X 6)	55
	-	1	1	1	1	2-1976053-7	LOCATER BLOCK,TERMINAL	53
	-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1	1	1901681-4	HOLDDOWN, TERMINAL	51
	-	1	1	1	1	2-1752354-0	STANDOFF,HOLD-DOWN	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	2119644-1	RAM WASHER, PRECISION	38
	-	1	1	1	1	1752356-3	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	1320908-6	SPACER, STRIP GUIDE	30
	-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
	-	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	462006-6	FLOATING SHEAR, FRONT	9
	1	1	1	1	1	2-1633128-5	ANVIL, COMBINATION .055	8
	-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	-	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
	1	1	1	1	1	2119582-8	CRIMPER, INSULATION F PREMIUM	3
	-	1	1	1	1	455888-6	SPACER, CRIMPER	2
	1	1	1	1	1	2-456402-4	CRIMPER, WIRE PREMIUM	1
	-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

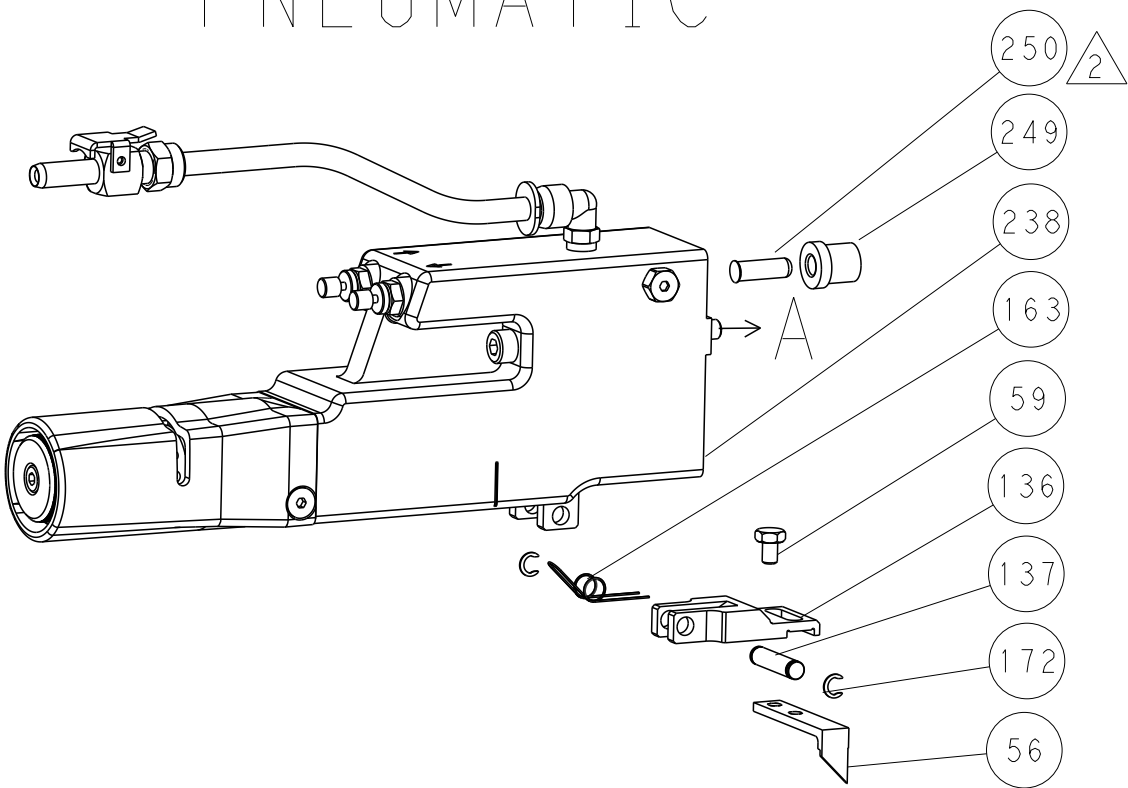
THIS DOCUMENT IS CONTROLLED DOCUMENT AND IT IS SUBJECT TO COMPANY POLICY AND IT IS THE RESPONSIBILITY OF THE USER TO CONTACT THE COMPANY FOR THE LATEST EDITION.				DWN	L. ZHANG	13OCT2011	 TE Connectivity Harrisburg, PA 17105-3608								
				CHK	L. ZHANG	13OCT2011									
DIMENSIONS:				APVD	S. XI	13OCT2011									
				TOLERANCES UNLESS OTHERWISE SPECIFIED:											
mm		0 PLC		±				NAME Ocean Side Feed Applicator - SIZE A1		CAGE CODE 00779		DRAWING NO C-2151240		RESTRICTED TO -	
		1 PLC		±											
		2 PLC		±											
		3 PLC		±											
		4 PLC		±											
ANGLES				±											
FINISH															
MATERIAL				-				PRODUCT SPEC							
				-				APPLICATION SPEC							
				-				WEIGHT							
				-				CUSTOMER ACCESSIBLE PRODUCTION DRAWING							
				-				SCALE		1:2		SHEET		3 OF 4	
				-								REV		C	

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

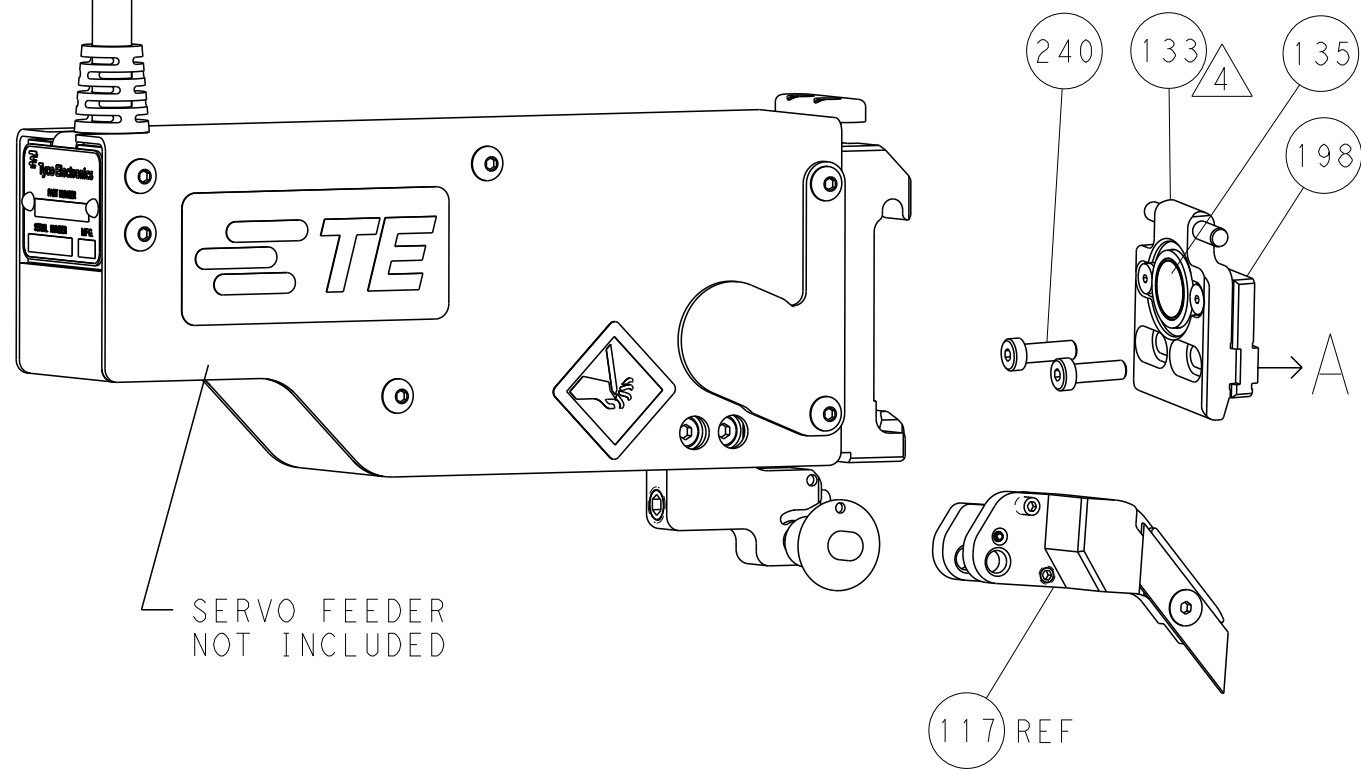
FEED TYPE
MECHANICAL



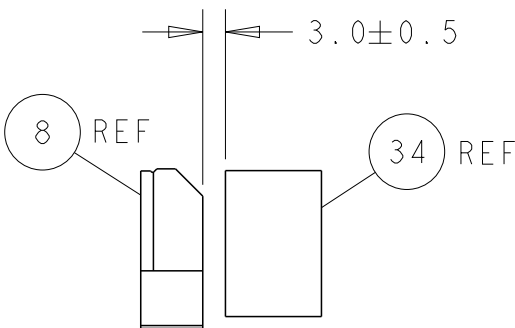
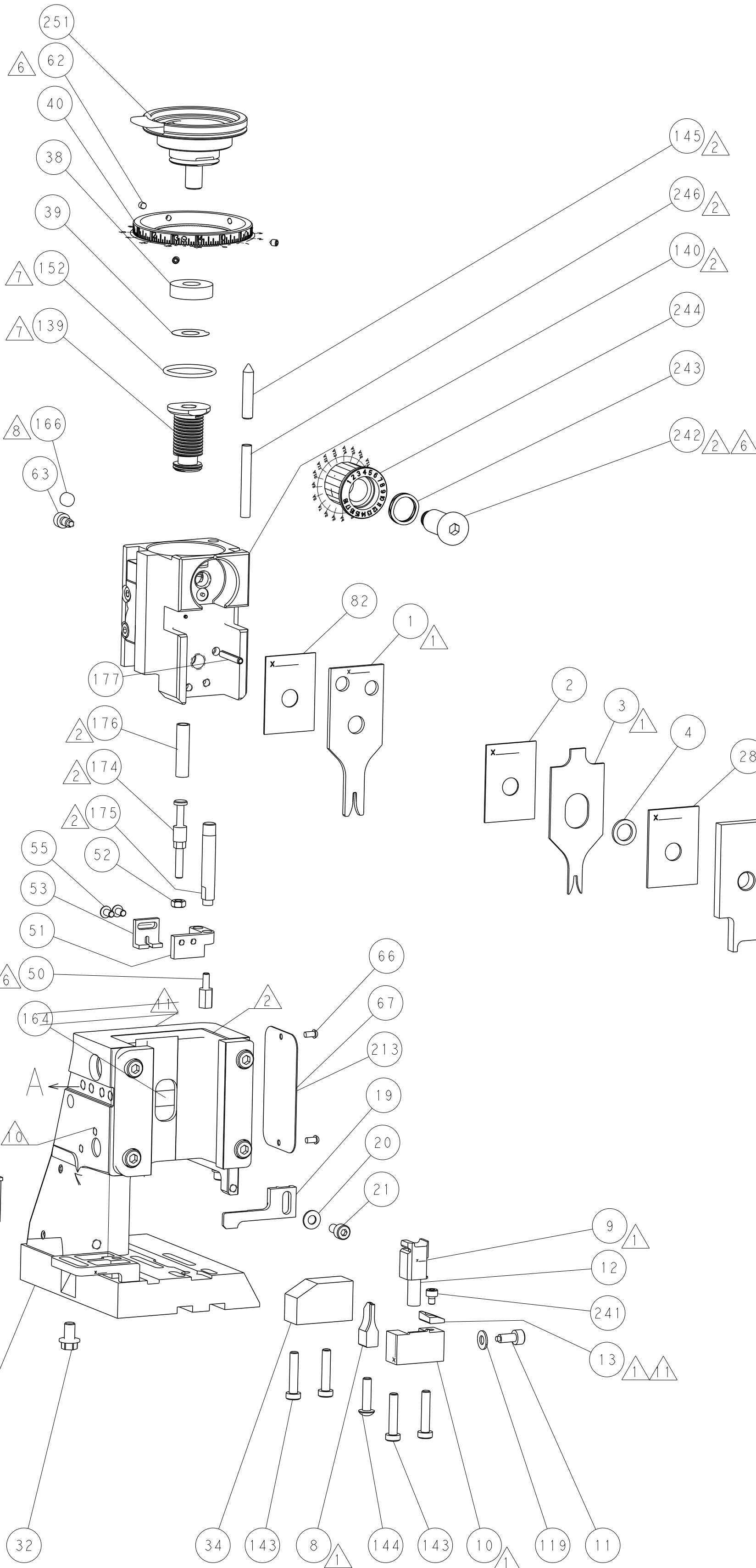
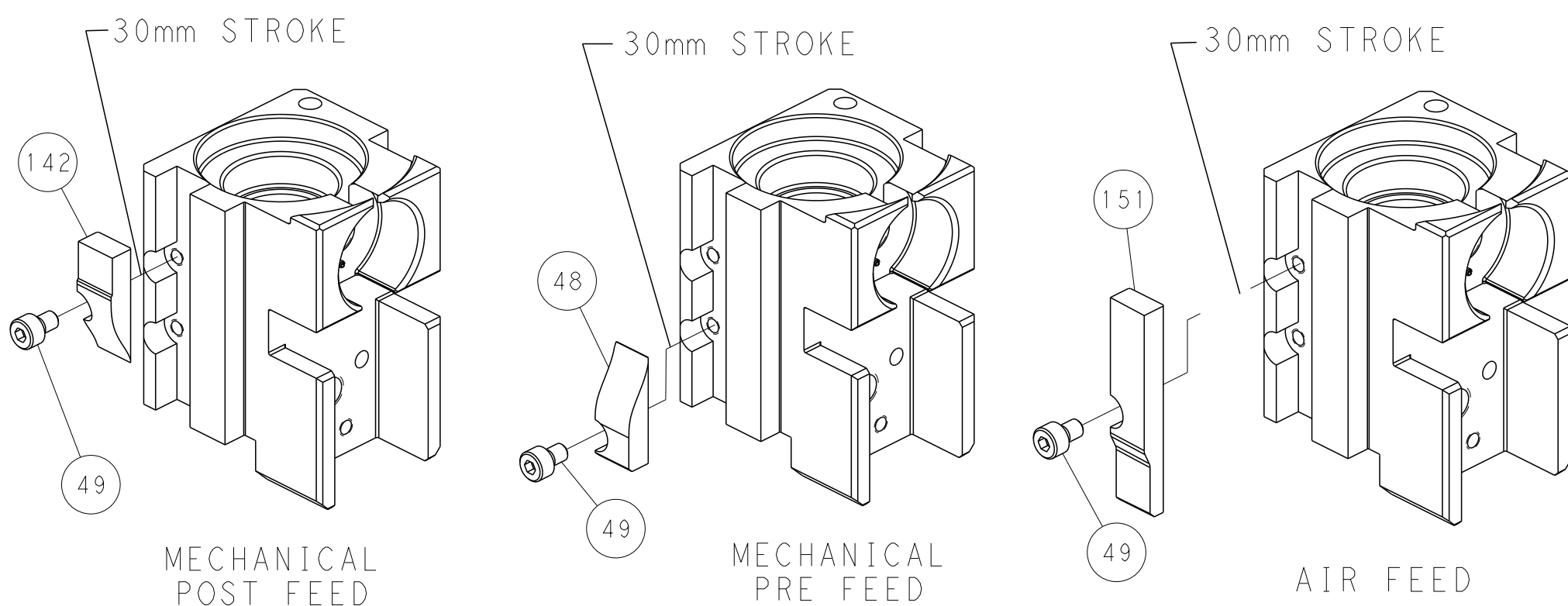
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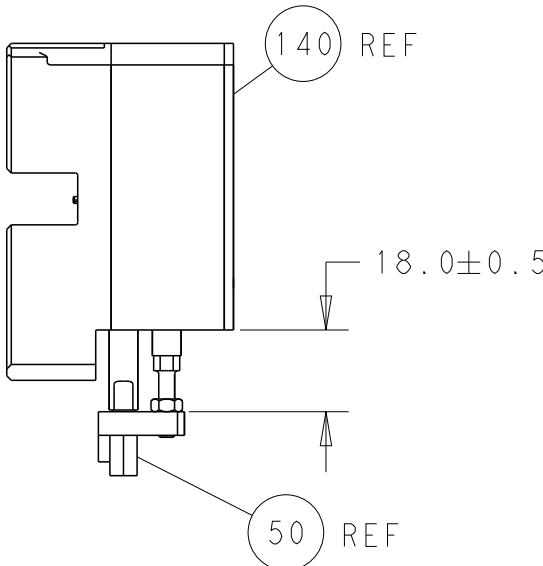
SERVO
LATCH PLATE



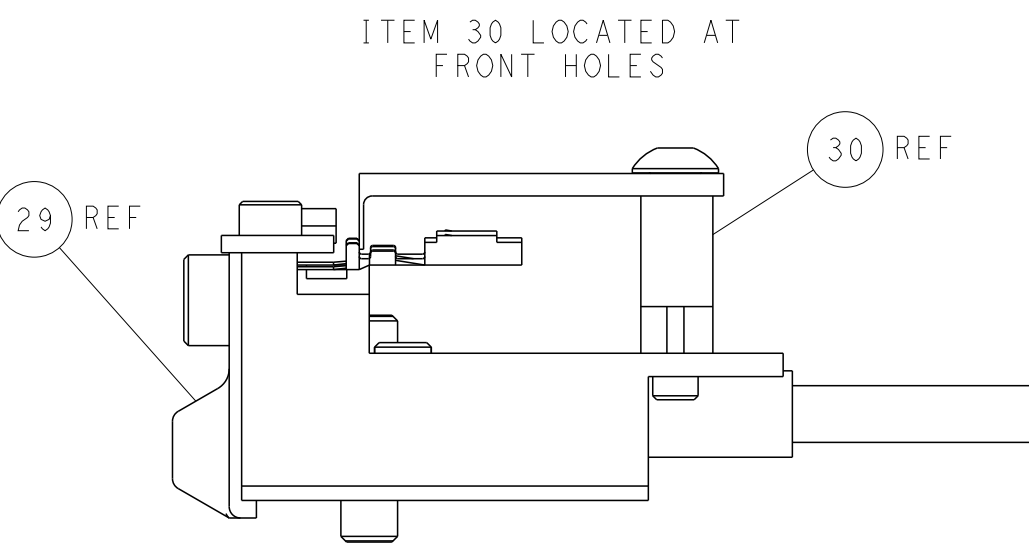
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLD-DOWN SET-UP



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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CHK L. ZHANG 13OCT2011				NAME				Harrisburg, PA 17105-3608			
S. XI 13OCT2011				PRODUCT SPEC				Ocean Side Feed			
APVD				APPLICATION SPEC				Applicator			
MATERIAL				WEIGHT				RESTRICTED TO			
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE 1:2				SHEET 4 OF 4			
				REV C							