

Table with columns: ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER, PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

APPLICATOR DATA table with columns: CRIMP SIZE, WIRE, INSUL, TYPE.

TERMINAL DATA: TE TERMINAL, TE CRIMP SPECIFICATION, WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION.

TERMINALS APPLIED table with columns: TE TERMINAL, TE TERMINAL, TE TERMINAL, TE TERMINAL.

WIRE SIZE, CRIMP HEIGHT, CRIMP HEIGHT REFERENCE SETTING table.



- 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.
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 ITEM 62.
7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
8 MAGNET, ITEM 166 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.
10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE...

*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.

Table with columns: PART NO, DESCRIPTION, ITEM NO.

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

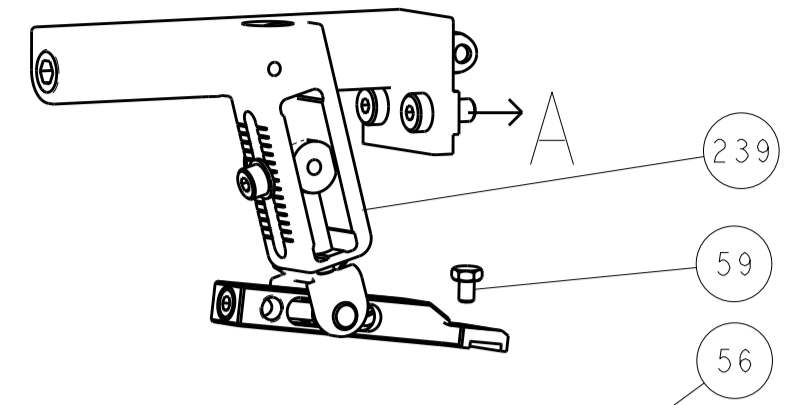
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Main parts list table with columns: REV, LTR, DESCRIPTION, DATE, DWN, APVD.

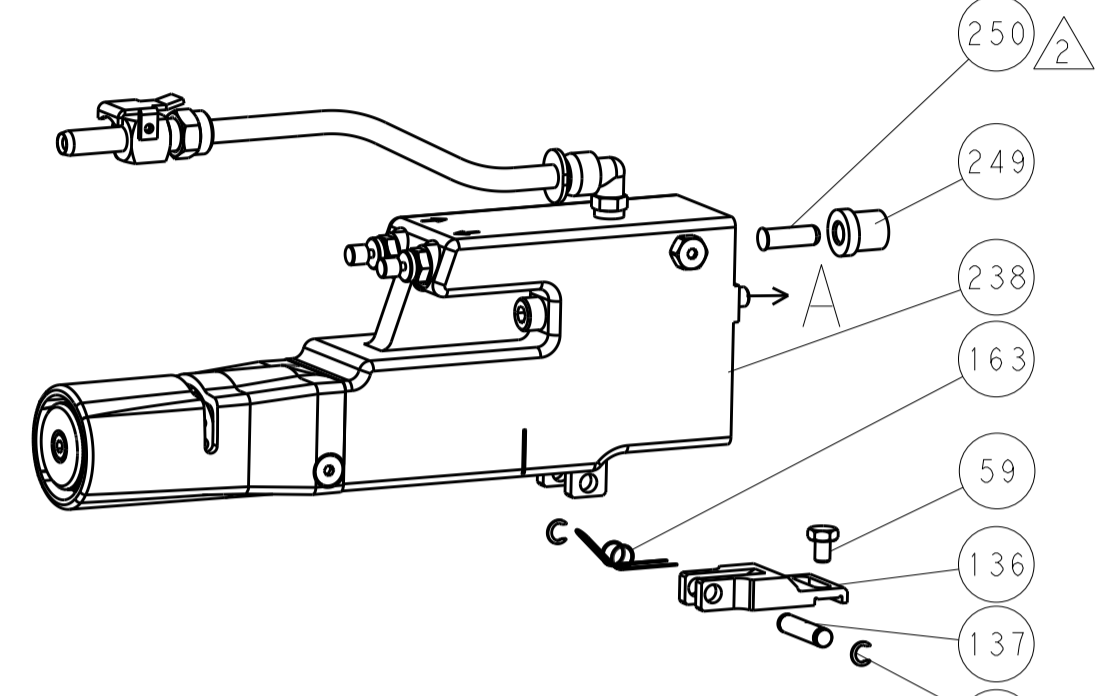
Header information table including: DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, CUSTOMER DRAWING, SCALE, SHEET 1 OF 4.

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1			

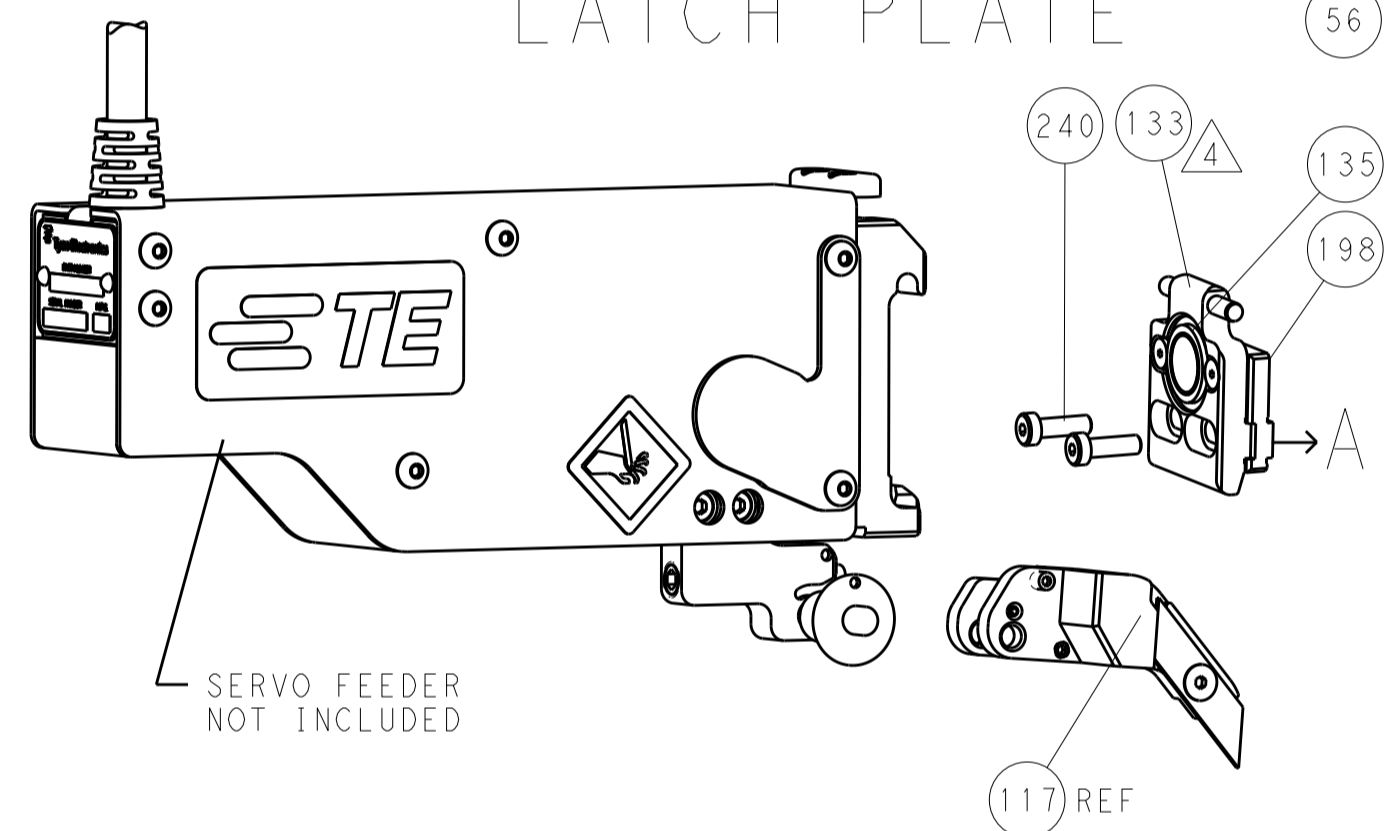
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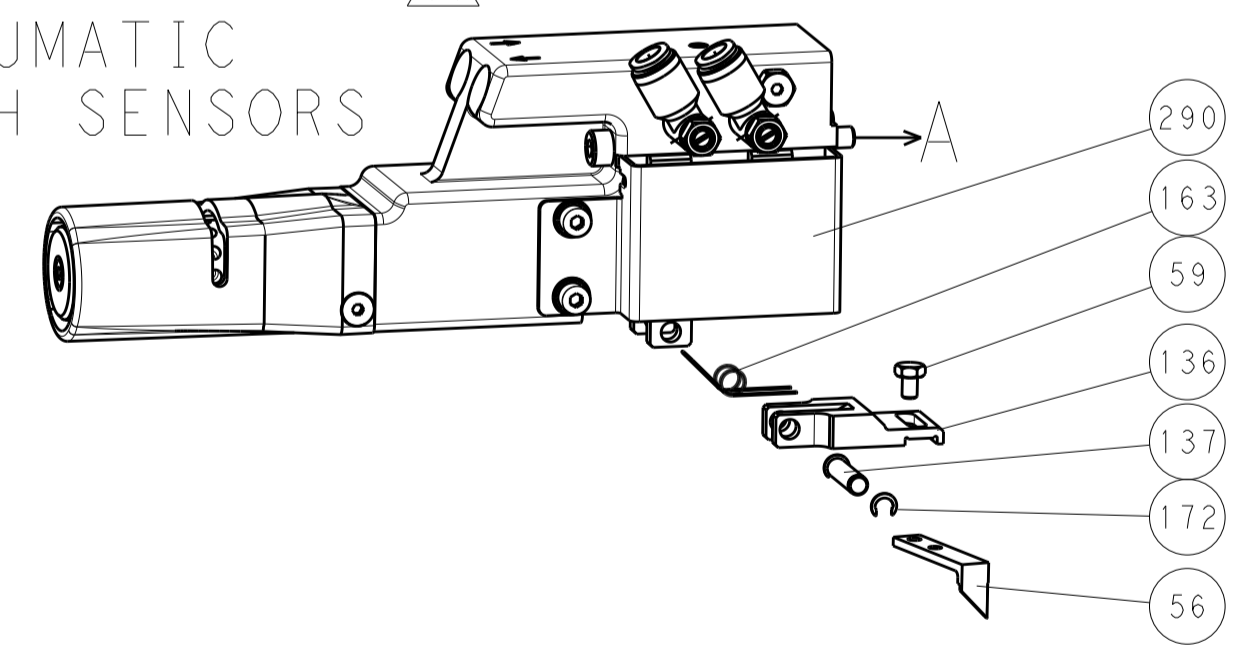
PNEUMATIC



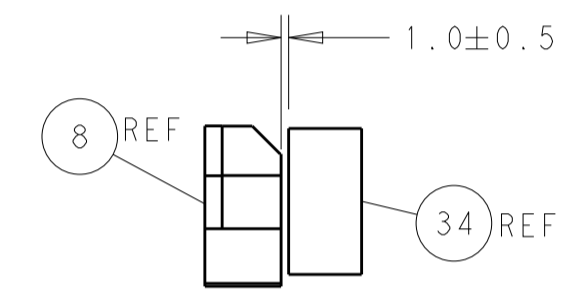
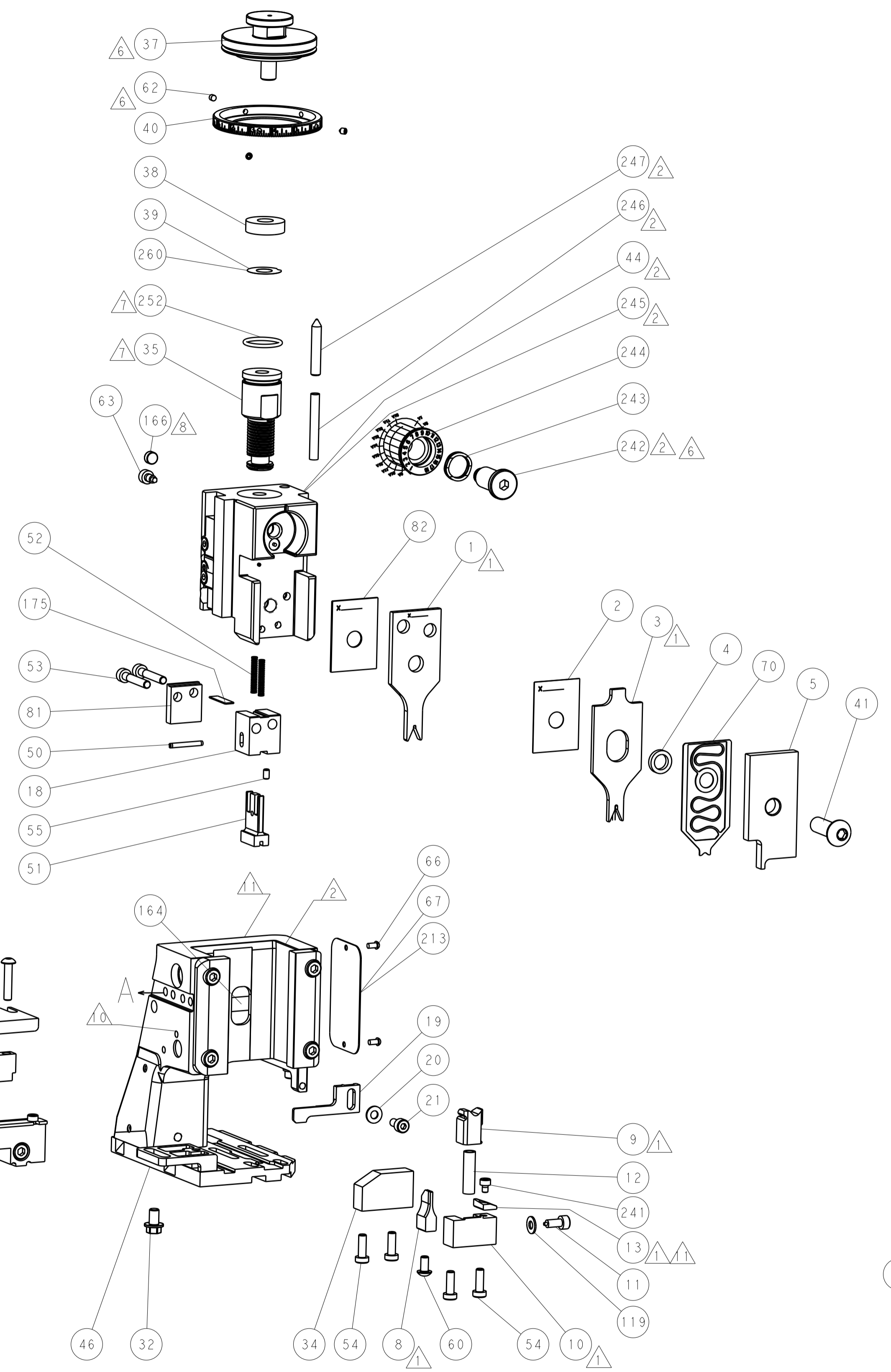
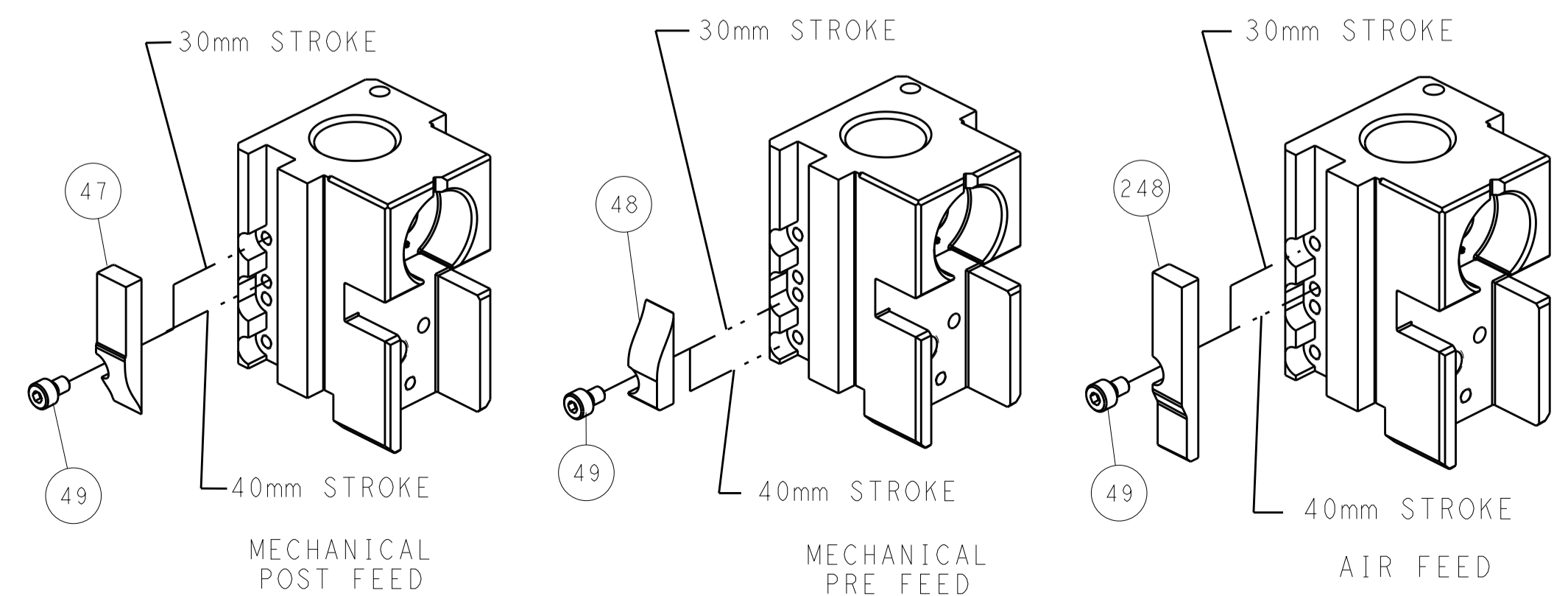
SERVO LATCH PLATE



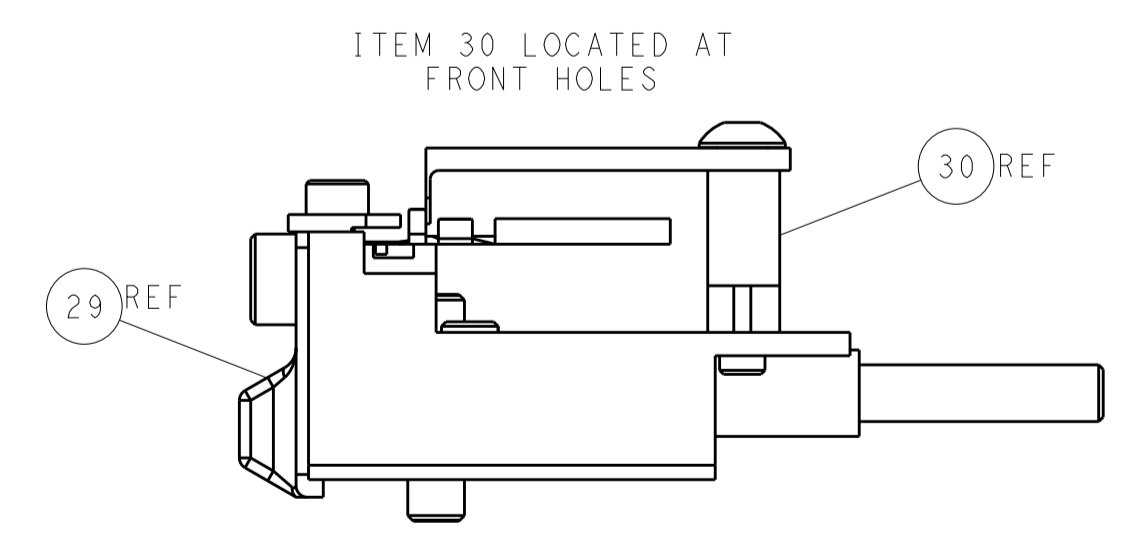
DOUBLE ACTING PNEUMATIC WITH SENSORS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: C. MOYER 31JUL2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD: T. ELBIN 31JUL2012		NAME: Ocean Side Feed Applicator	
CUSTOMER DRAWING		SCALE: 1:2		SHEET 2 OF 4		REV L	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151725-1	L	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	1722362-1
					SERVO LATCH PLATE	2119951-1	-	8-2151725-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151725-4	-	-	-
					DOUBLE ACTING	2119950-2	1338685-1	5-18022-5	-	2119799-1	1803430-1
	2-2151725-2	L	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151725-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151725-4	-	-	-
					DOUBLE ACTING	2119950-2	1338685-1	5-18022-5	-	2119799-1	1803430-1
	2-2151725-5	L	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	1722362-1
2-2151725-7	L	FINE CRIMP HEIGHT ADJUST	NONE	DOUBLE ACTING	2119950-2	1338685-1	5-18022-5	-	2119799-1	1803430-1	
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	2168400-6 (QUANTITY 2)	
4-2151725-2	L	FINE CRIMP HEIGHT ADJUST	DOUBLE ACTING PNEUMATIC WITH SENSORS	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	1722362-1	
				SERVO LATCH PLATE	2119951-1	-	8-2151725-5	1901094-3	-	2168400-6 (QUANTITY 2)	
				SMART APPLICATOR	2161326-1	-	8-2151725-4	-	-	2168400-6 (QUANTITY 2)	
7-2151725-7	L	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.35 mm [.053]	F
INSUL	1.55 mm [.061]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION
 TERMINAL NAME: GENERATION Y, 0.64 STYLE TERMINAL

WIRE STRIP LENGTH 4.00-4.50 mm [1.57-.177 IN]	INSULATION DIAMETER RANGE Ø 1.50-1.85 mm [0.059-.073 IN]
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TERMINAL APPLICATION SPECIFICATION 114-13183

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1438616-3	1642772-1	1924968-3	2098165-1
1438616-7	1642948-1	1949674-1	2098753-1
1456574-3	1924275-3	2035124-1	2098762-1
1456841-3	1924727-1	2035170-1	2138699-1
1456968-3	1-1924727-1	1-2035170-1	1-2138699-1
	1924955-3	2035334-3	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG OR 0.50mm2	0.95+/-0.05 [.037+/-0.002]	7.7
22 AWG OR 0.35mm2	0.90+/-0.05 [.035+/-0.002]	8.3

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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: 8-2151725-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151725-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151725-5
- 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 ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.
- TE TERMINAL YAZAKI TERMINAL
 1642772-1 7114-4618-02
 1642948-1 7116-4618-02
 1949674-1 7116-5231-08

THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.

***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.

ITEM NO	DESCRIPTION	ITEM NO	
-77	1803430-1	AIR FEED MODULE	290
-42	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-27	2119640-1	PUSH ROD, AIR FEED	250
-25	2079988-1	BUSHING, LCH5-12, MISUMI	249
-22	1-22279-3	SPRING, COMPRESSION	246
-21	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
	PART NO	DESCRIPTION	ITEM NO

PACIFIC VERSION
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 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE 2119599-1 LOC A DIST 66

REV	DATE	BY	APPV	DESCRIPTION
1				SEE SHEET 1

REV	DATE	BY	APPV	DESCRIPTION				
-	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	1722362-1	AIR FEED MODULE	238	
-	-	-	1	-	2119740-2	TAG IDENTIFICATION	213	
-	-	-	1	-	1901094-3	SPACER, FEEDER	198	
-	1	1	1	1	1803129-1	PLATE, RETAINER	175	
-	-	-	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	-	-	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	-	-	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	455888-8	SPACER, CRIMPER	82	
-	1	1	1	1	455053-2	PLATE, RETAINING	81	
-	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	
-	1	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	-	-	1	1338685-1	PAWL, FEED	56	
-	1	1	1	1	18031-1	SCR, SET, CUP POINT M3 X 5.0	55	
-	2	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25	53	
-	2	2	2	2	22278-9	SPRING, COMPRESSION	52	
-	1	1	1	1	9-1338389-4	HOLD DOWN, TERMINAL	51	
-	1	1	1	1	4-21028-0	PIN, SLOTTED SPRING .094 X .750	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	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	1320908-3	SPACER, STRIP GUIDE	30	
-	1	1	1	1	2119959-4	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	240792-1	DRAG, TERMINAL	25	
-	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	455052-3	CARRIER, HOLD DOWN	18	
-	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	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9	
-	1	1	1	1	4-1633621-9	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119757-3	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4	
-	1	1	1	1	7-1803019-9	CRIMPER, INSULATION O	3	
-	1	1	1	1	455888-2	SPACER, CRIMPER	2	
-	1	1	1	1	1803364-3	CRIMPER, WIRE PREMIUM	1	
-77	-42	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE: 31 JUL 2012	BY: T. MOYER	APPV: T. ELBIN
0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
5 PLC ±	6 PLC ±	ANGLES ±	FINISH ±	WTG ±
MATERIAL:		PRODUCT SPEC:	APPLICATION SPEC:	WEIGHT:
		APPLICATOR SPEC:	CUSTOMER DRAWING:	SCALE: 1:2 SHEET 3 of 4

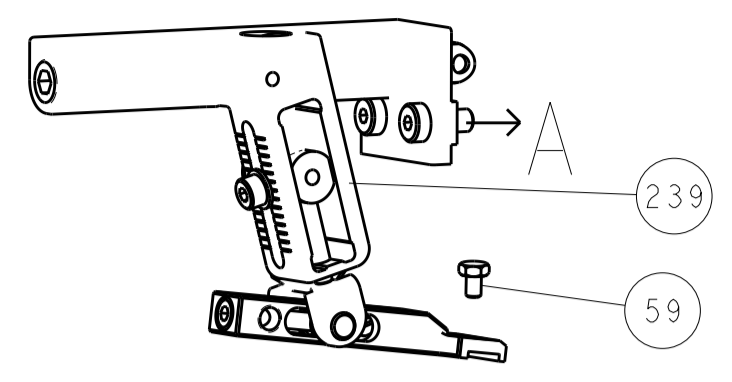
TE Connectivity
Harrisburg, PA 17105-3608

Ocean Side Feed
Applicator

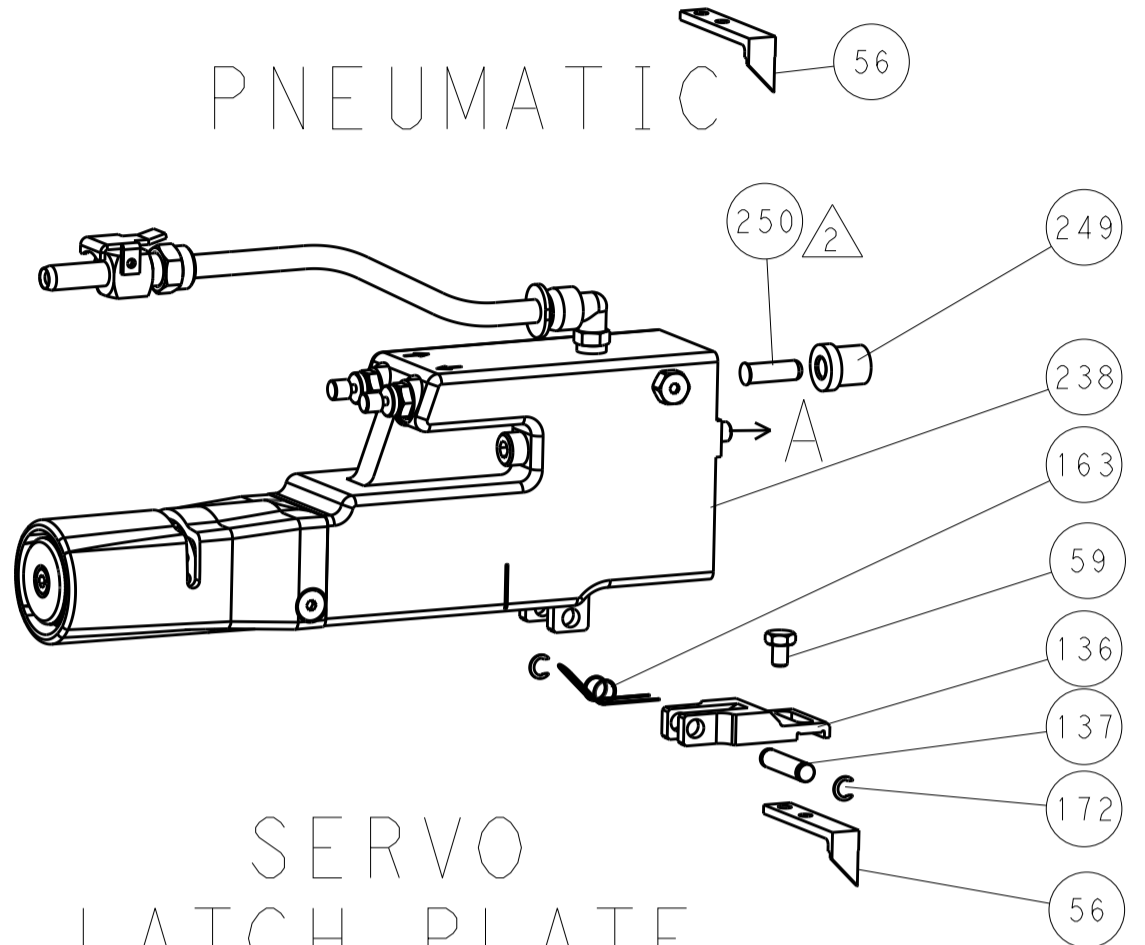
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REVISONS		DATE	OWN	APVD
LOC	DIST			
A	66			
P	LTM	DESCRIPTION		
		SEE SHEET 1		

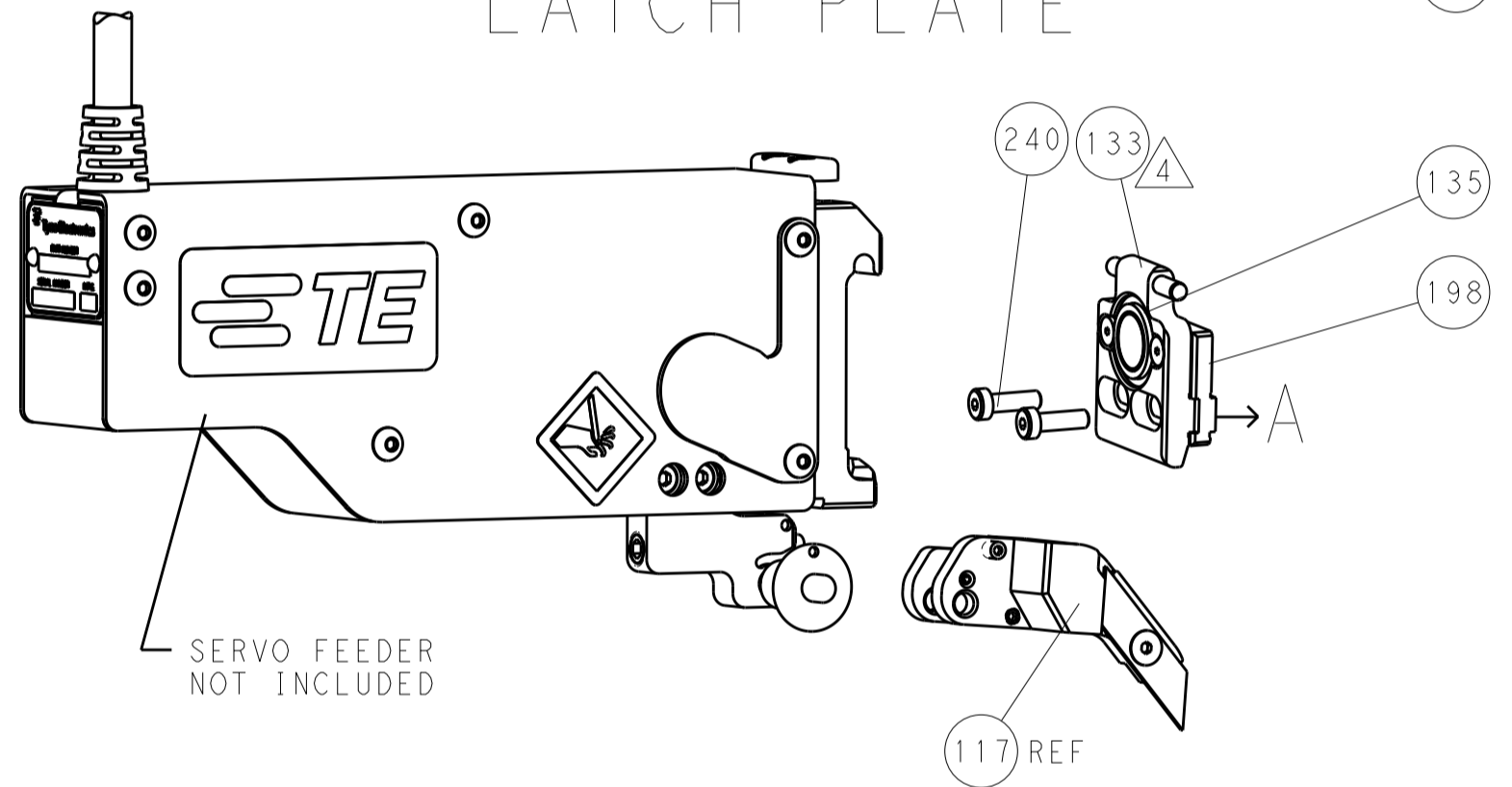
FEED TYPE MECHANICAL



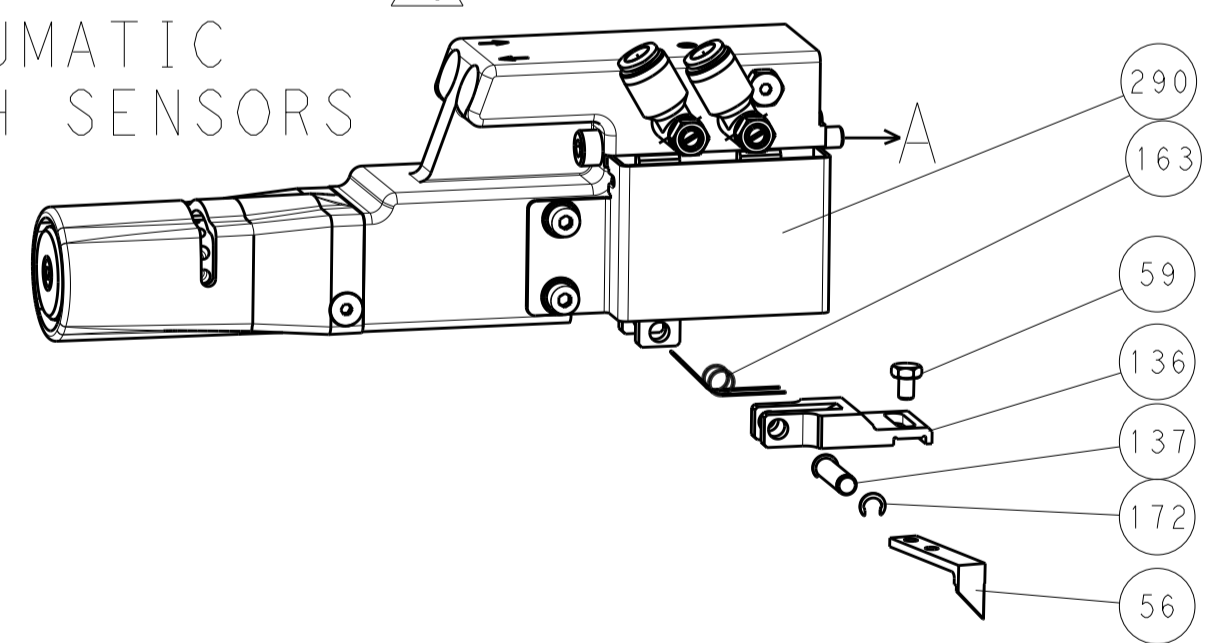
PNEUMATIC



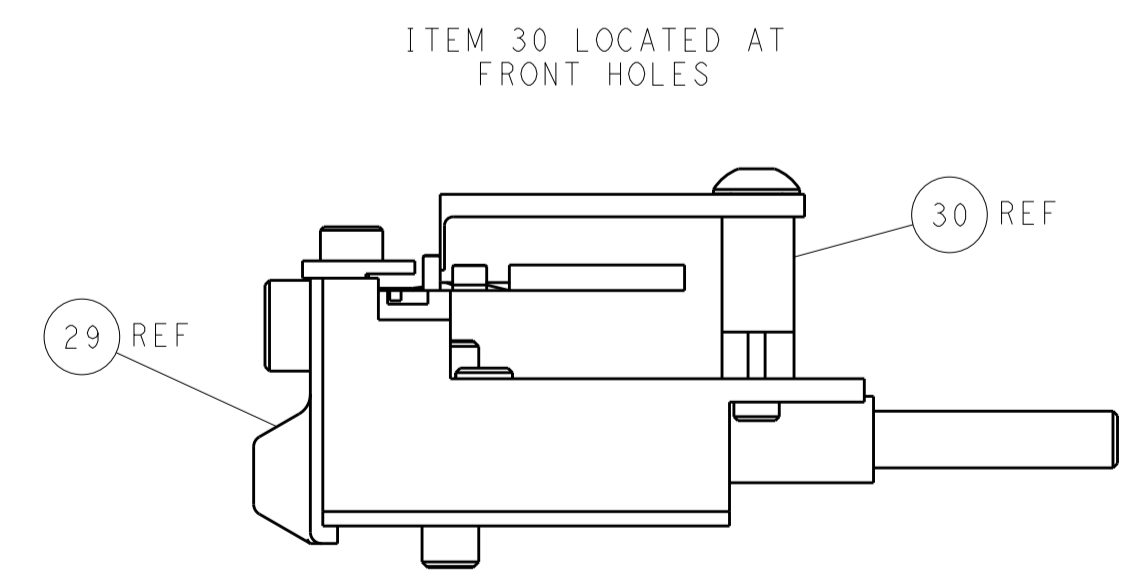
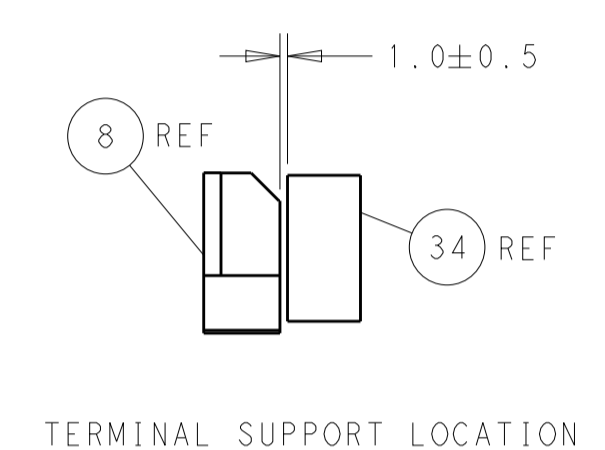
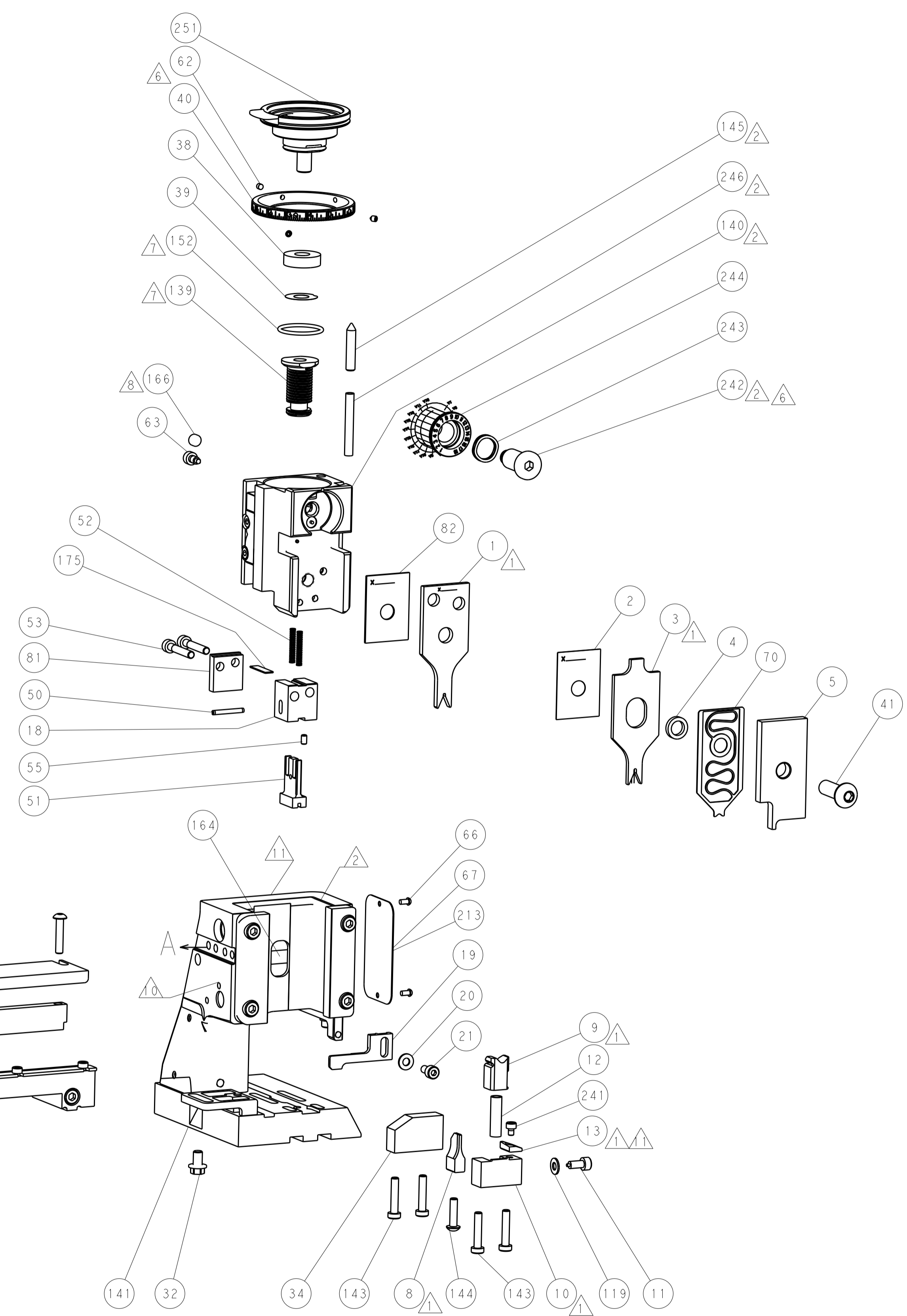
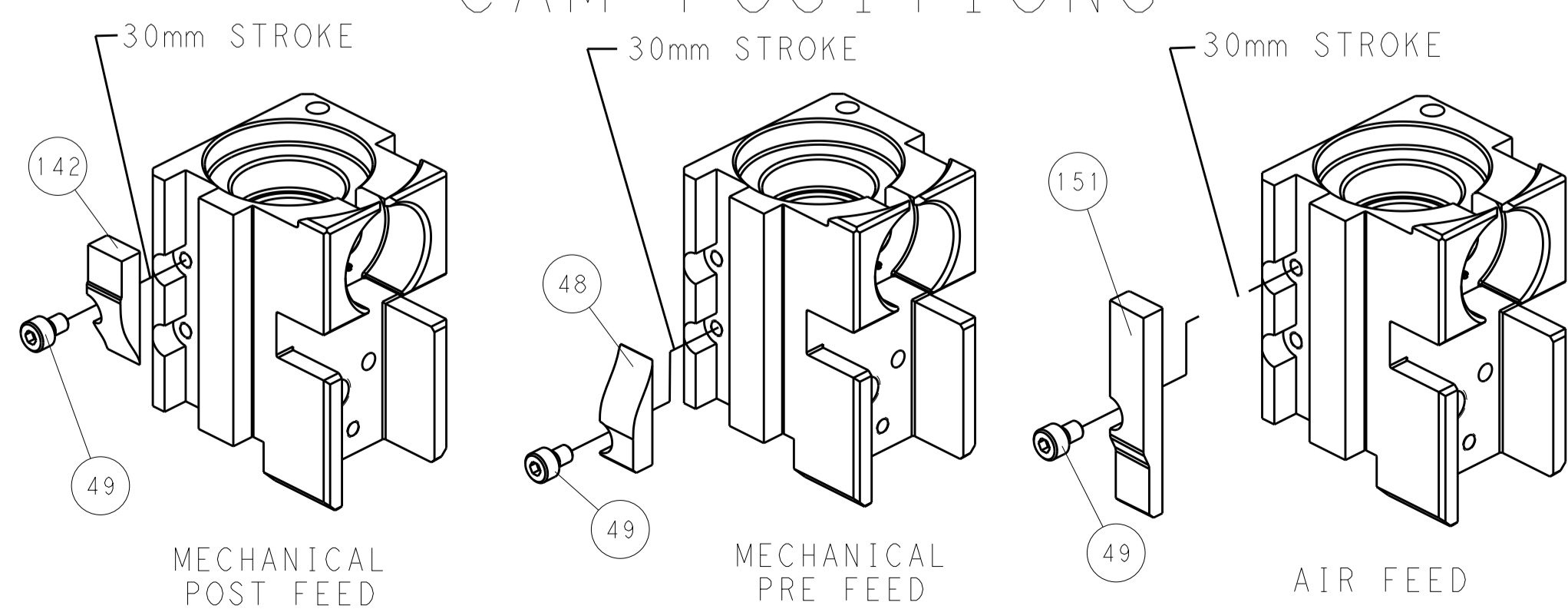
SERVO LATCH PLATE



DOUBLE ACTING PNEUMATIC WITH SENSORS



CAM POSITIONS



PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: C. MOYER 31 JUL 2012		STE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	5 PLC ±	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	APVD: T. ELBIN 31 JUL 2012	NAME:	RESTRICTED TO:	
			1:2	PRODUCT SPEC:	Ocean Side Feed Applicator		
				APPLICATION SPEC:			
				ANGLES:			
				CUSTOMER DRAWING:	A11 00779 ©=2151725		