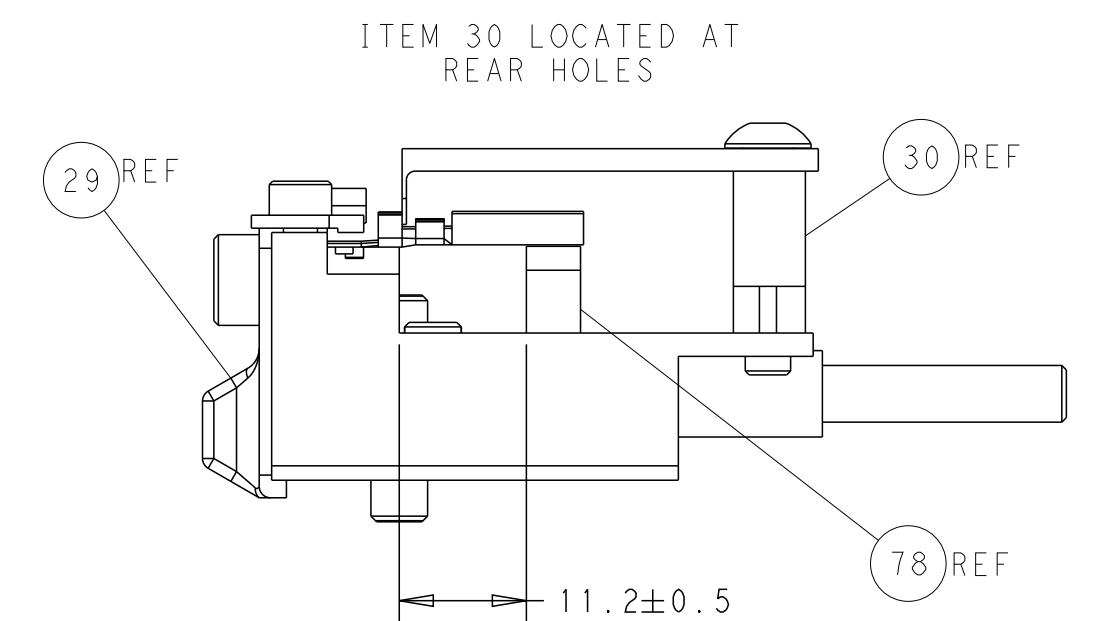
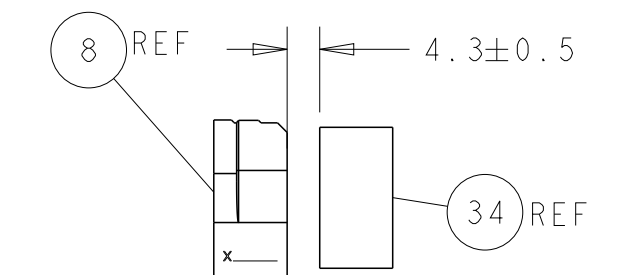
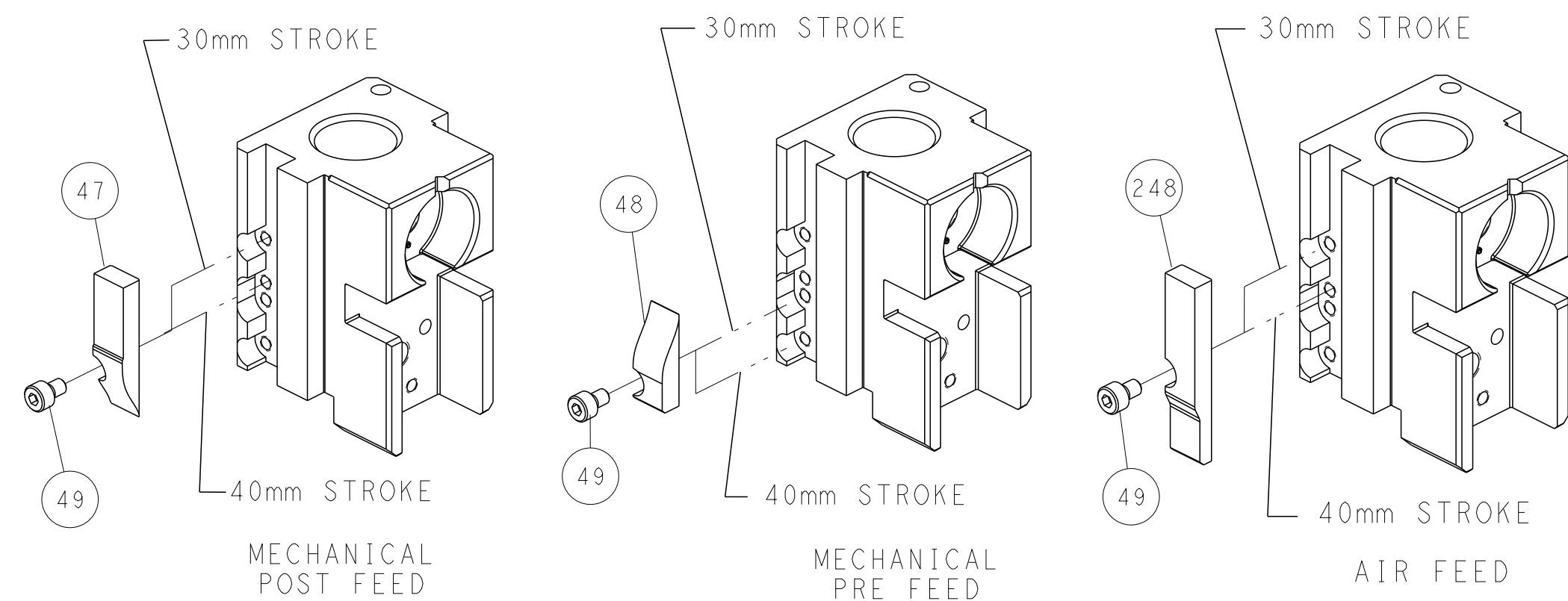
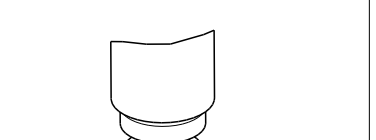




THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN Y.YIN 23SEP2011 CHK G.BAILEY 23SEP2011 APVD S.XI 23SEP2011		 TE Connectivity	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC APPLICATION SPEC		SIZE -	
MATERIAL -		FINISH -		CAGE CODE -	
WEIGHT -		DRAWING NO C=2151045		RESTRICTED TO -	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE 1:2	SHEET 2 OF 4
				REV F	

8		7	
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2016		2016	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151045-1	E	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	-	8-2151045-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151045-4	-	-	-
	2-2151045-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151045-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151045-4	-	-	-
	2-2151045-5	E	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	2063440-1
	2-2151045-7	E	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151045-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	2.29 mm [.090]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO POWER		QUADLOK SOCKET CONTACT	
WIRE STRIP LENGTH 3.20-3.80 mm [1.26-.150 IN]		INSULATION DIAMETER RANGE Ø1.20-1.60 mm [0.047-.063 IN]	
TERMINAL APPLICATION 	114-18141	-	-
SPECIFICATION	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
968678-2	968679-5	1-968679-5	
968679-2	968679-6	2-968679-5	

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.50mm2			1.15+/-0.03 [0.045+/-0.001]		5.6
0.35mm2			1.08+/-0.03 [0.043+/-0.001]		6.3



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: 8-2151045-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151045-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151045-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151045-6
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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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. WHEN RUNNING TERMINAL 968678 MOVE ITEM 7 BETWEEN ITEM 44 OR ITEM 245 AND ITEM 18.
13. WHEN RUNNING TERMINAL 968679 MOVE ITEM 261 BETWEEN ITEM 44 OR ITEM 245 AND ITEM 18.

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

2		1				
SET UP GAUGE 2119599-1		REVISIONS				
P	LTR	DESCRIPTION		DATE	DWN	APVD
	-	SEE SHEET 1		-	-	-

43	-	1	1	1	1	6-240641-5	SPACER	261	
	-	1	1	1	1	2119782-1	LINE ADJUST HEAD ASM, PACIFIC STYLE	251	
6	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250	
	-	-	-	1	-	1803259-1	BUSHING, FLANGED	249	
	-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246	
	-	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	19	
	-	-	-	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	
	7	-	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152
-		-	-	1	-	2119641-2	FEED CAM, AIR FEED	151	
7	-	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	455888-3	SPACER, CRIMPER	82	
	-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	79	
	-	1	1	1	1	1633782-2	FENCE	78	
	6	-	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	2-2168083-6	SCR, SKT HD CAP, RoHS, M4 X 18	53	
-		-	-	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	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	
6	-	1	1	1	1	1320908-3	SPACER, STRIP GUIDE	30	
	-	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29	
	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28	
	-	1	1	1	1	1320928-6	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	879657-2	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	1-356885-4	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	5-1333202-3	ANVIL, COMBINATION	8	
	12	-	1	1	1	1	2-240641-5	SPACER	7
	-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
	1	-	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
1		1	1	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3	
1	-	1	1	1	1	455888-5	SPACER, CRIMPER	2	
	1	1	1	1	1	9-657555-1	CRIMPER, WIRE PREMIUM	1	
	-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO	

THIS DRAWING IS A CONTROLLED DOCUMENT.										DWG T.YIN 23SEP2011				TE Connectivity							
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:						CHK C.GAILEY 23SEP2011		NAME Ocean Side Feed Applicator									
mm				APPROVED S.XI 23SEP2011																	
				PRODUCT SPEC -																	
				APPLICATION SPEC -																	
MATERIAL				FINISH		ANGLES ± .1		WEIGHT -		SIZE A1		CAGE CODE -		DRAWING NO C=2151045		RESTRICTED TO -					
										CUSTOMER ACCESSIBLE PRODUCTION DRAWING						SCALE 1:2		SHEET 3 OF 4		REV E	

REVISIONS				
P	LTR	DESCRIPTION	DATE	OWN APVD
-	-	SEE SHEET 1	-	-

D

C

B

A

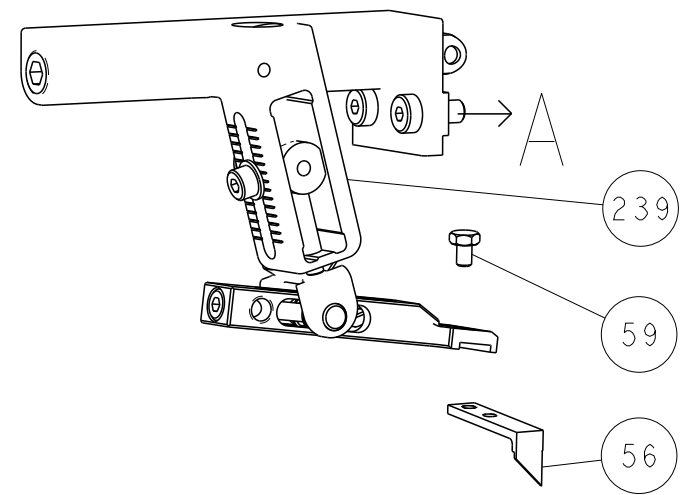
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C

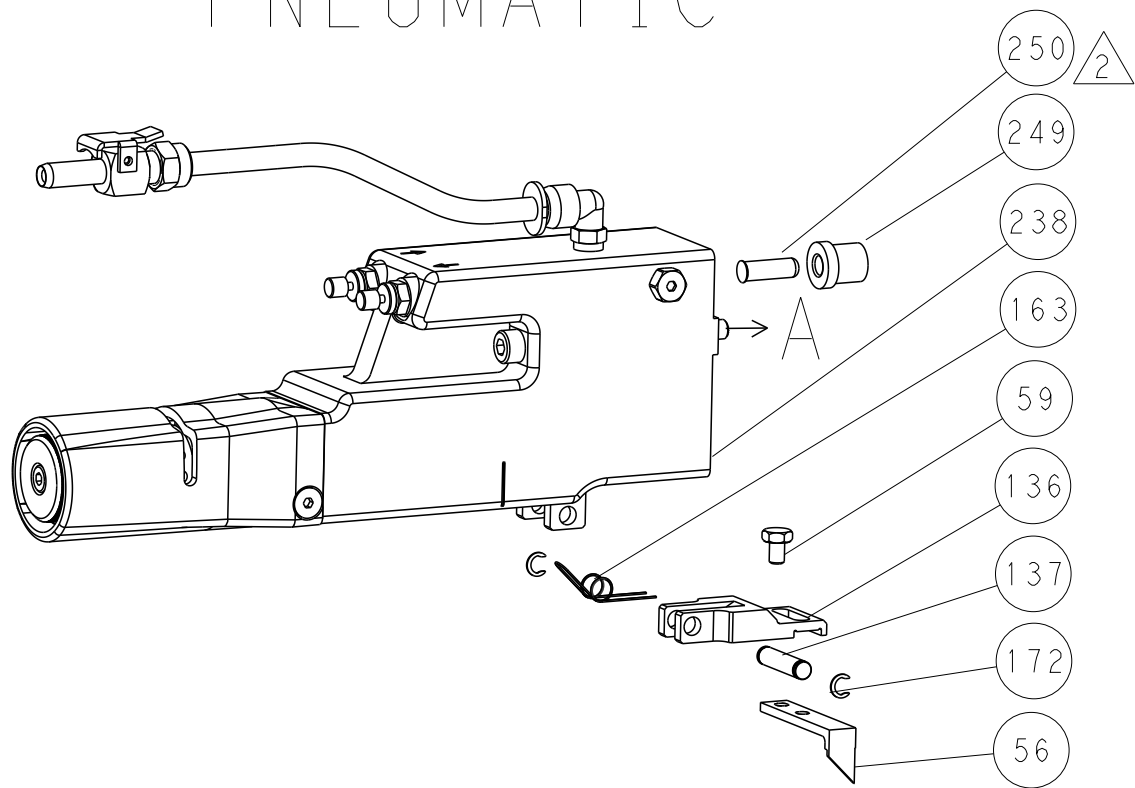
B

A

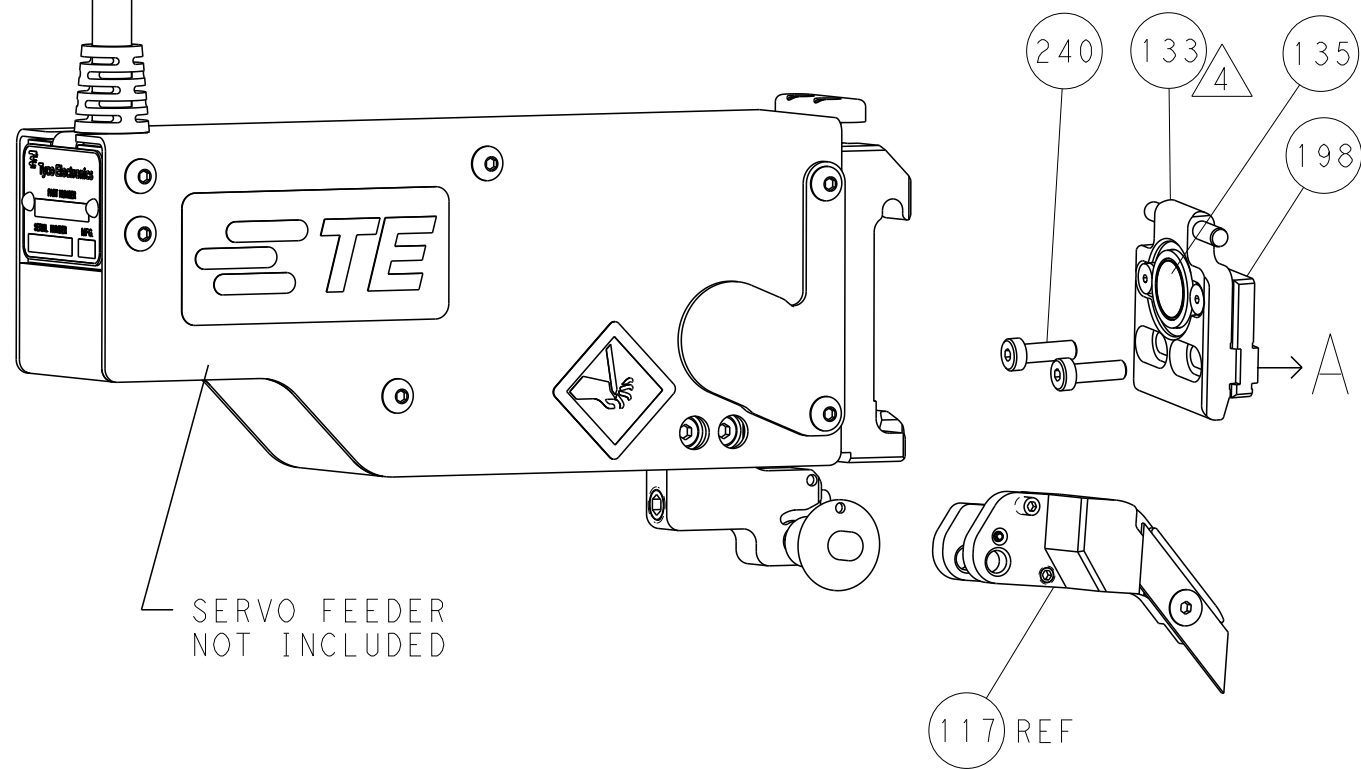
FEED TYPE MECHANICAL



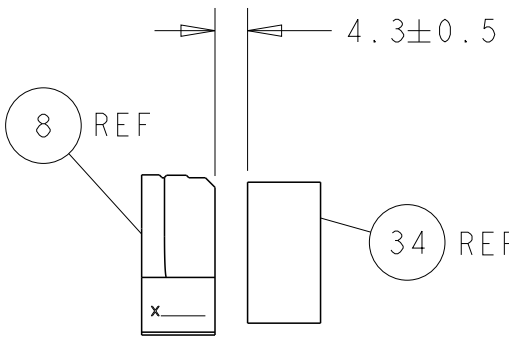
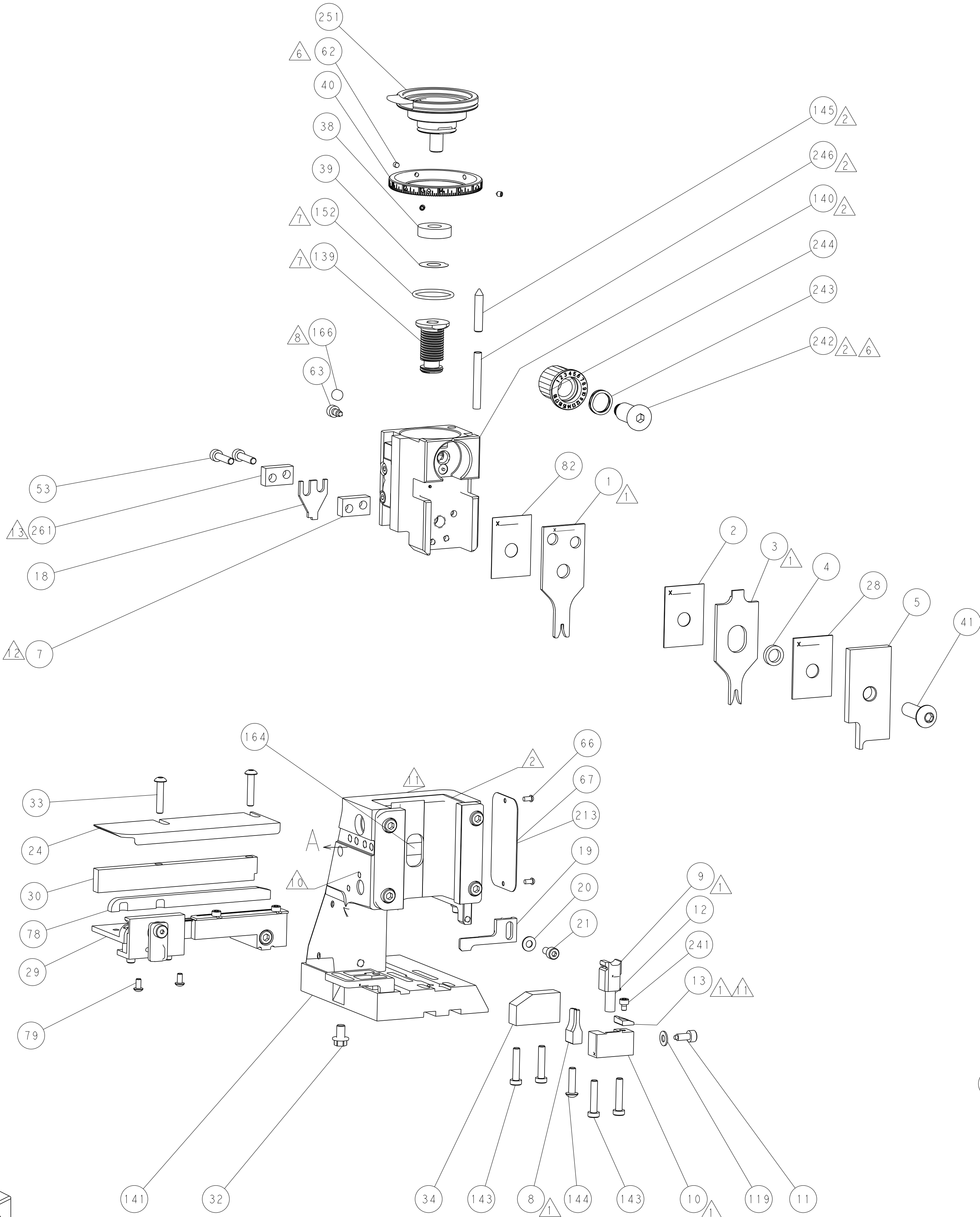
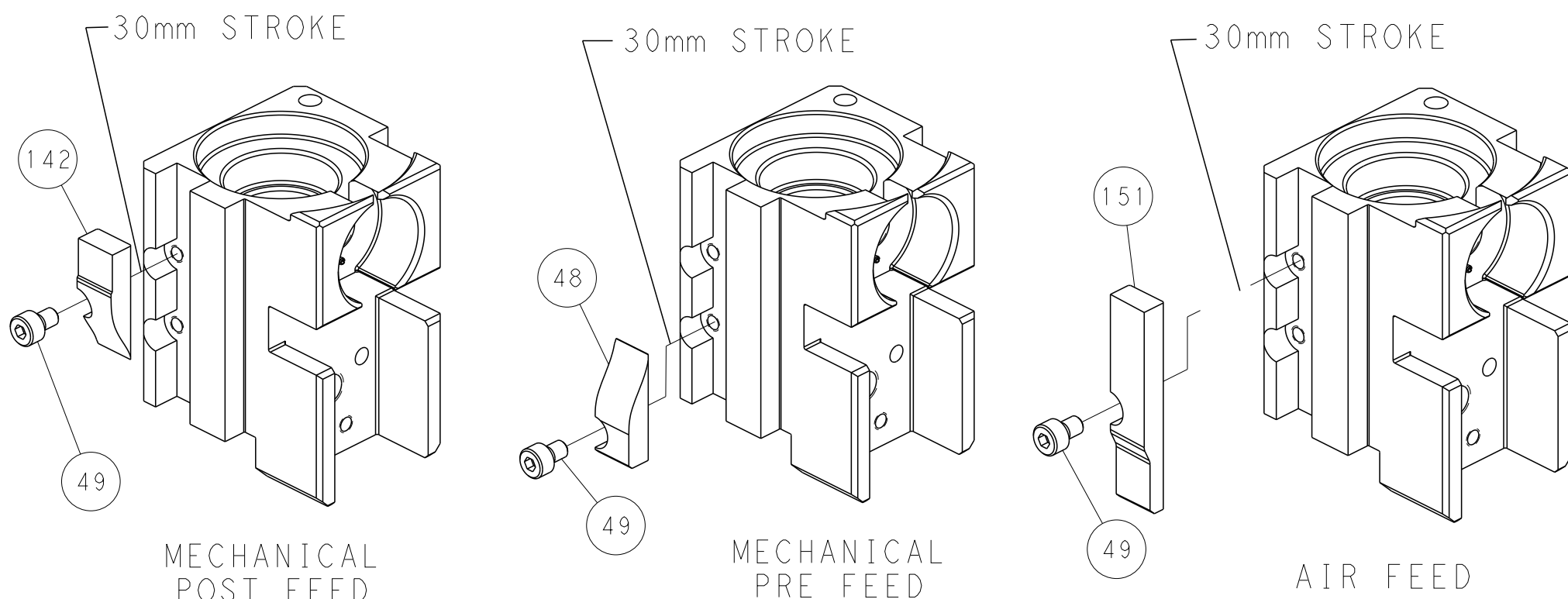
PNEUMATIC



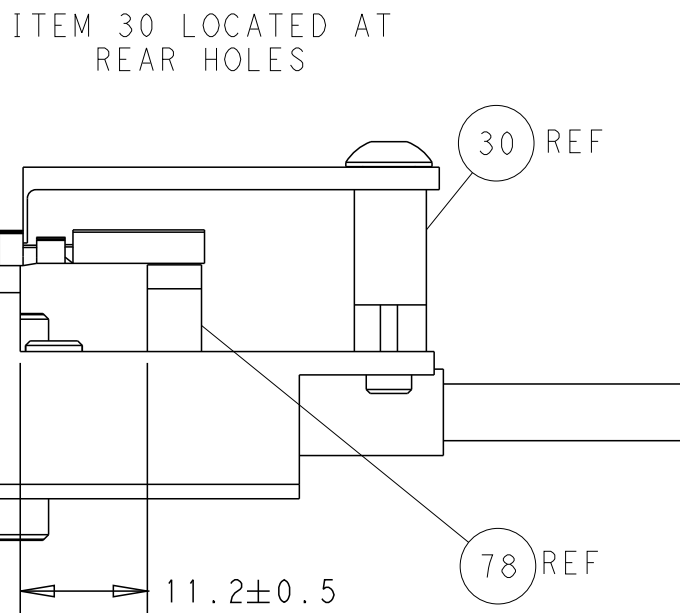
SERVO LATCH PLATE



CAM POSITIONS

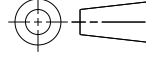


TERMINAL SUPPORT LOCATION



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.		OWN Y. YIN	23SEP2011	 TE Connectivity	
DIMENSIONS:		CHK G. BAILEY			
mm		APVD		NAME Ocean Side Feed Applicator	
		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	
		0 PLC ±		APPLICATION SPEC	
MATERIAL		WEIGHT		SIZE A1	
		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2	
				SHEET 4 OF 4	
				REV E	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION