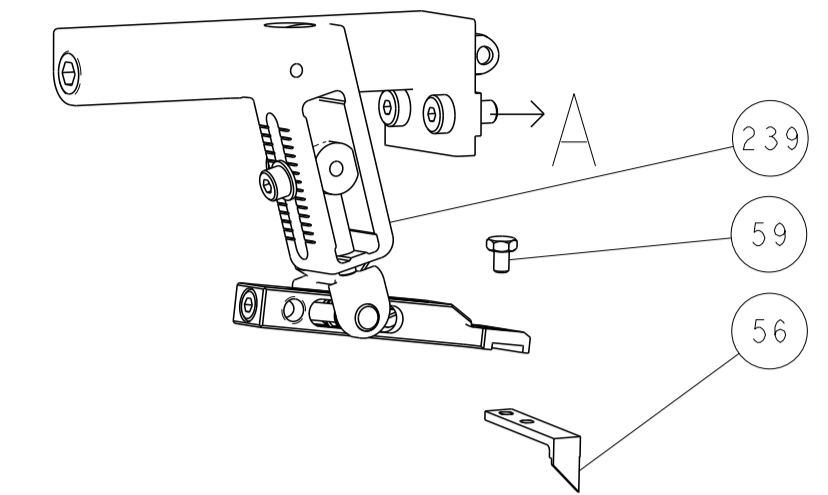
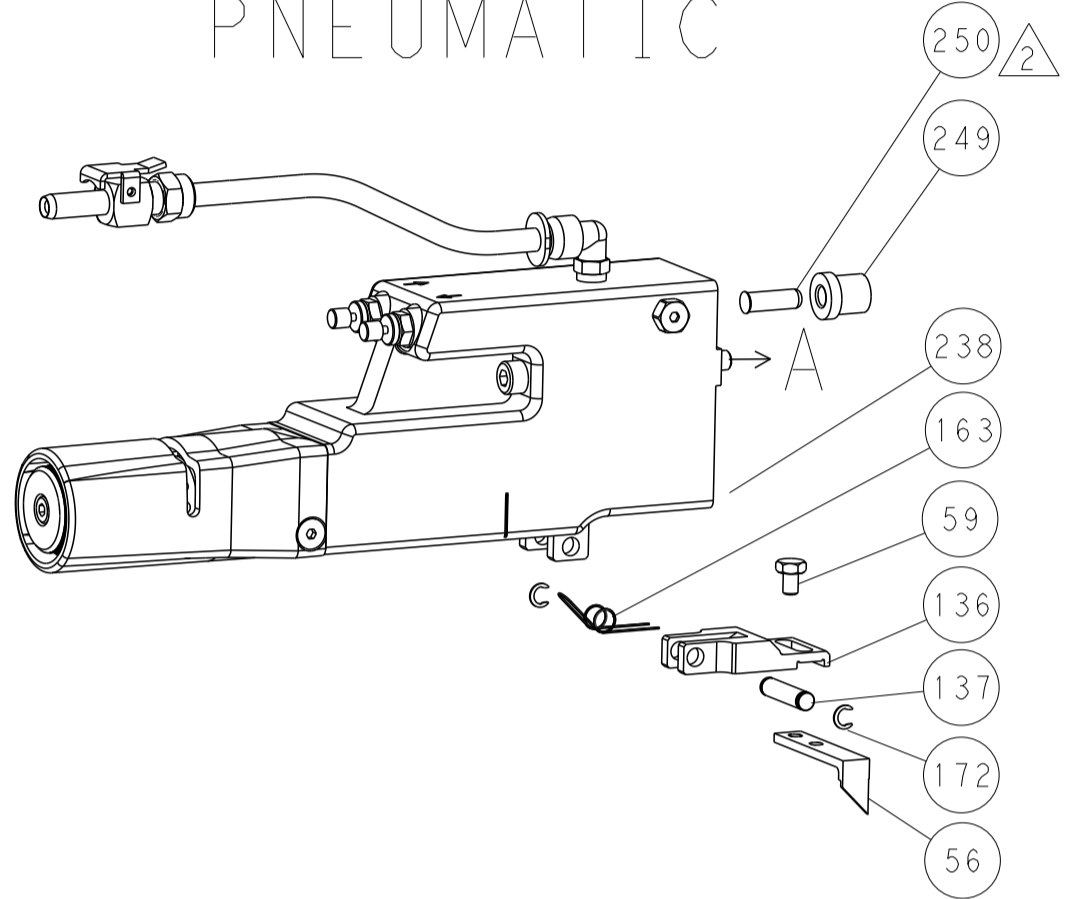


LOC		DIST		REVISIONS			
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

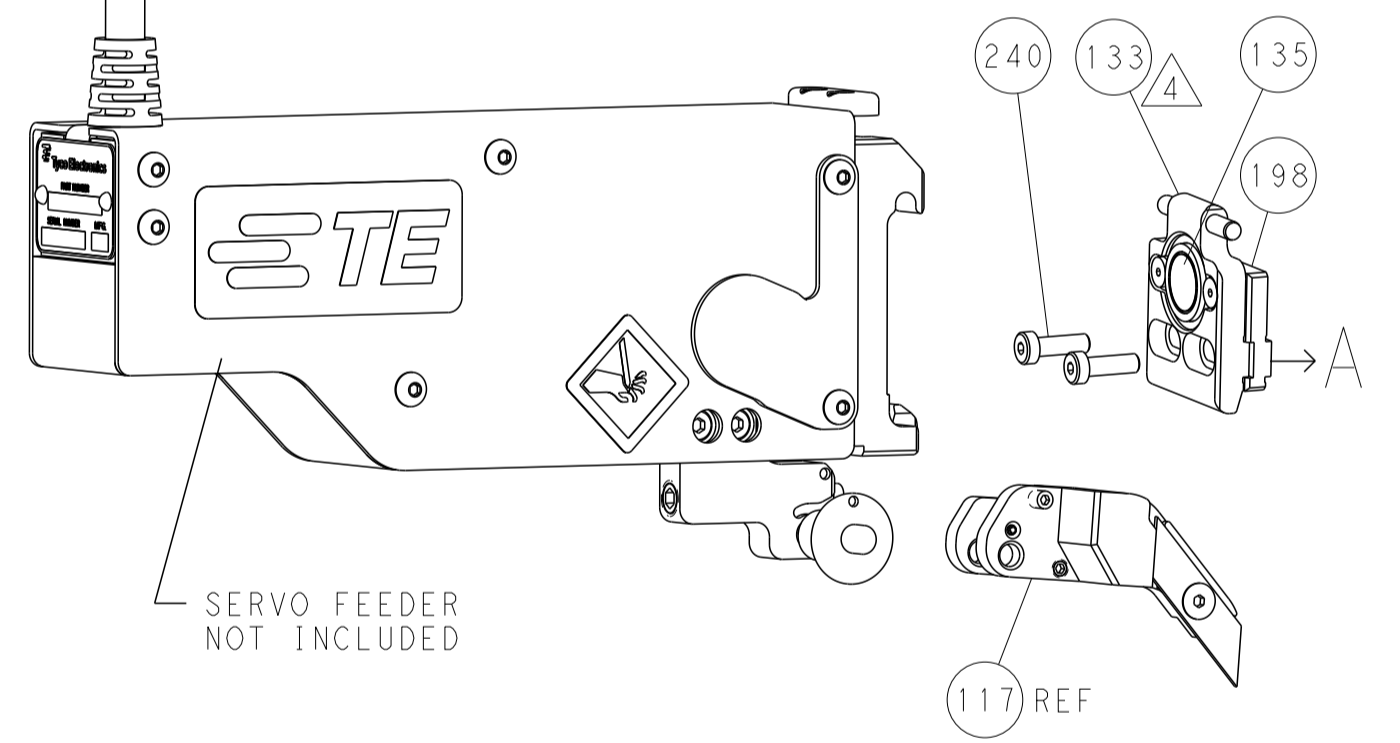
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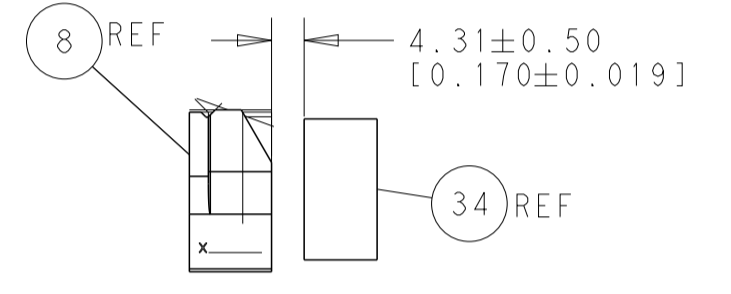
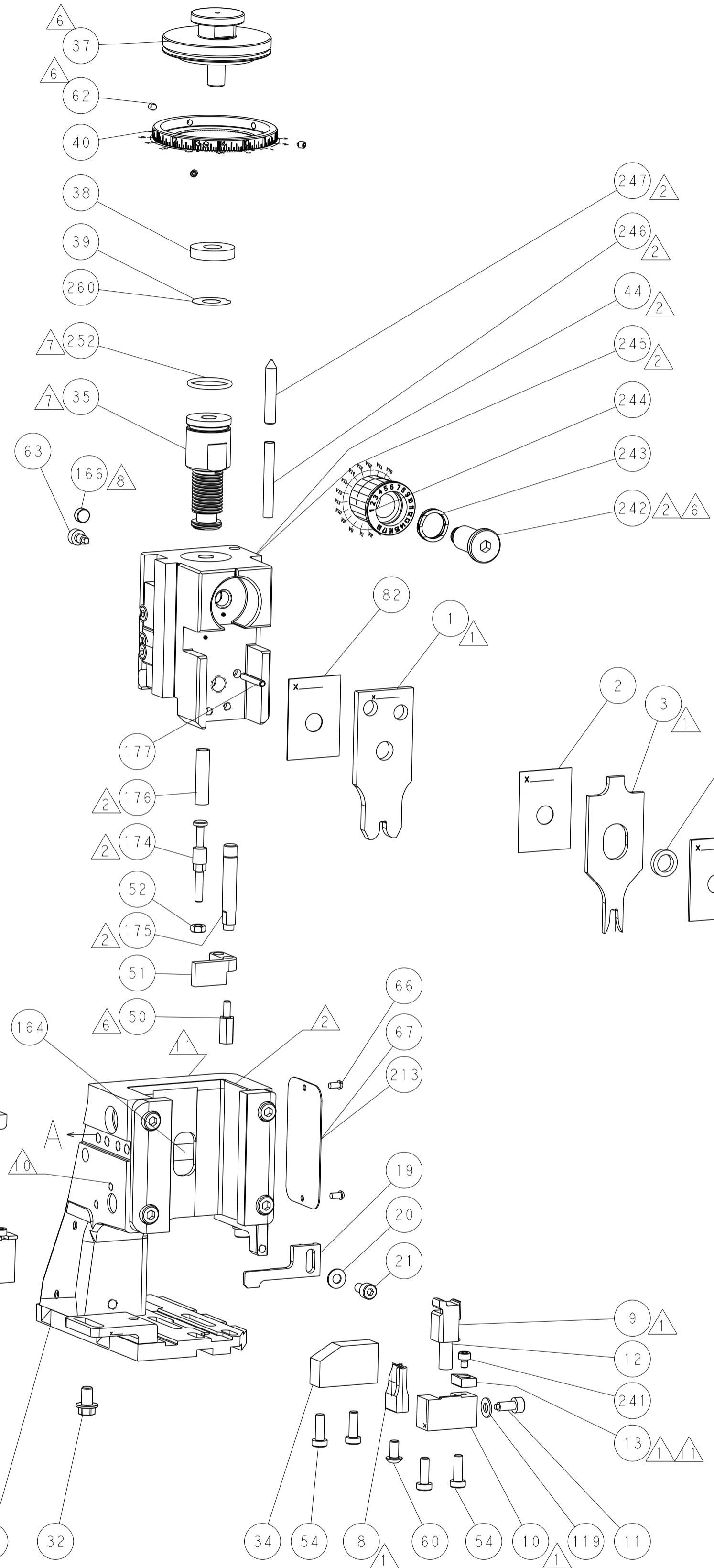
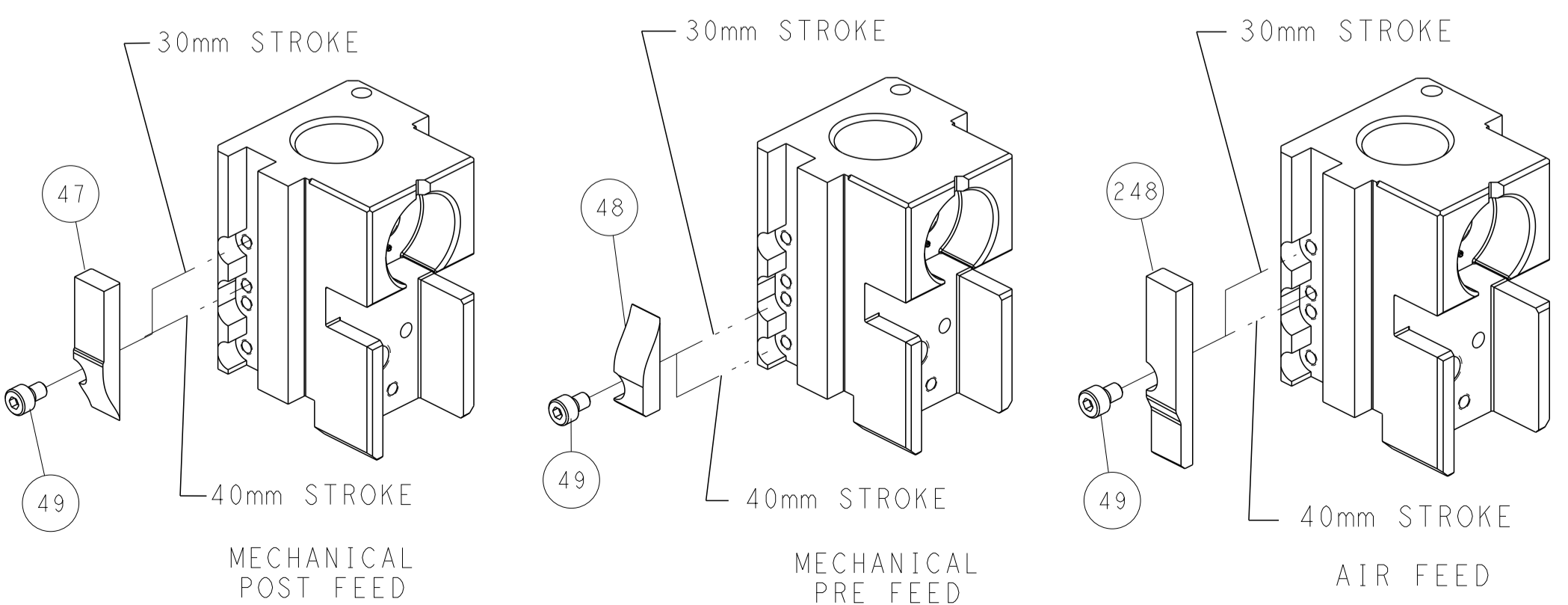
PNEUMATIC



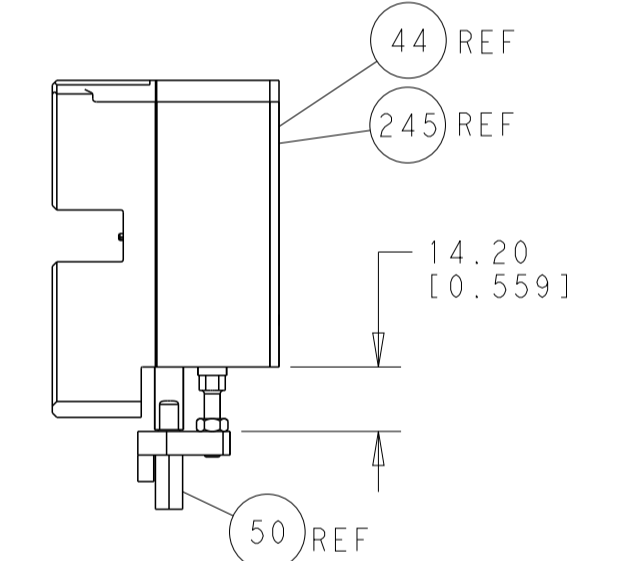
SERVO LATCH PLATE



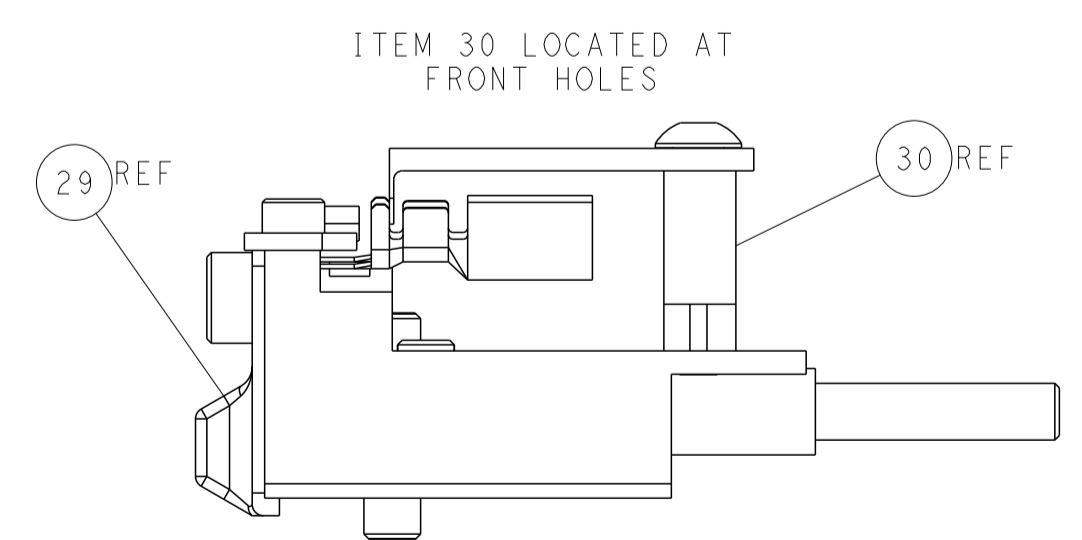
CAM POSITIONS



TERMINAL SUPPORT LOCATION



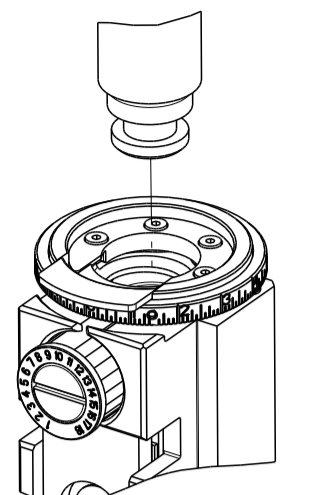
HOLDDOWN SET-UP



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: R. HUANG 28JUL2011 CHK: S. XI 28JUL2011 APVD: S. XI 28JUL2011	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151171	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH ±	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: B	RESTRICTED TO: -	Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO	PART NUMBERS REQUIRED					
	2-2151171-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2151171-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151171-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2151171-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	SMART APPLICATOR	2161326-1	-	8-2151171-4	-	-	-
	2-2151171-7	B	FINE CRIMP HEIGHT ADJUST	NONE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
	7-2151171-7	A	CRIMP TOOLING KIT	-	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION
TERMINAL NAME: STANDARD-POWER-TIMER CONTACT

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
4.40-5.00 mm [.173-.197 IN]	\varnothing 2.70-3.70 mm [.106-.146 IN]

TERMINAL APPLICATION SPECIFICATION	114-18037-1
------------------------------------	-------------

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
927829-1	927829-2	927829-5	1-927829-5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
4.00mm ²	2.35 +/- 0.05 [.093 +/- .002]	10.1



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: 8-2151171-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151171-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151171-5

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 ITEM 50 & 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.

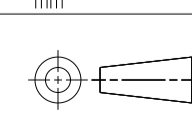
***WARNING**
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251					
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250					
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249					
-	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)

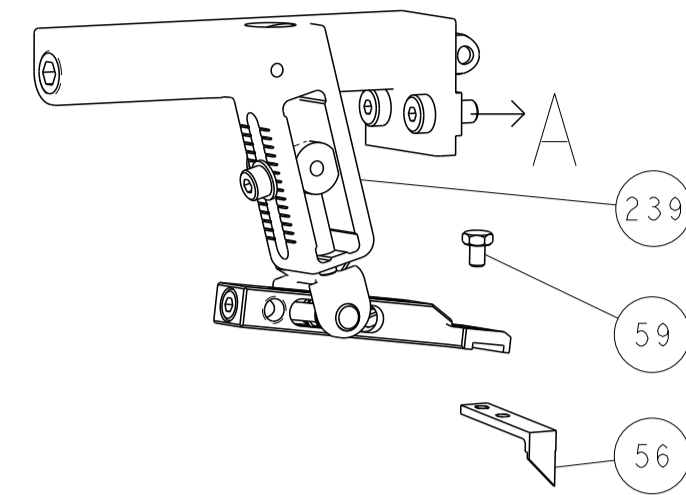
REVISIONS	DATE	OWN	APVD
SEE SHEET 1	-	-	-

-	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	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	455888-4	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					
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52					
-	1	1	1	1	1901681-5	HOLDDOWN, TERMINAL	51					
-	1	1	1	1	3-1752354-2	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	2119644-3	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					
-	1	1	1	1	2-1320908-2	SPACER, STRIP GUIDE	30					
-	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29					
-	1	1	1	1	1-455888-1	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	454276-5	FLOATING SHEAR, FRONT	9					
1	1	1	1	1	1-1333209-1	ANVIL, COMBINATION .130	8					
-	-	-	-	-	-	-	7					
-	-	-	-	-	-	-	6					
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5					
-	1	1	1	1	3-238011-3	BLOCK, CRIMPER SPACER	4					
1	1	1	1	1	1-1633961-4	CRIMPER, INSULATION F PREMIUM	3					
-	1	1	1	1	455888-3	SPACER, CRIMPER	2					
1	1	1	1	1	456410-4	CRIMPER, WIRE PREMIUM	1					
-	77	-	27	-	25	-	22	-	21	PART NO	DESCRIPTION	ITEM NO

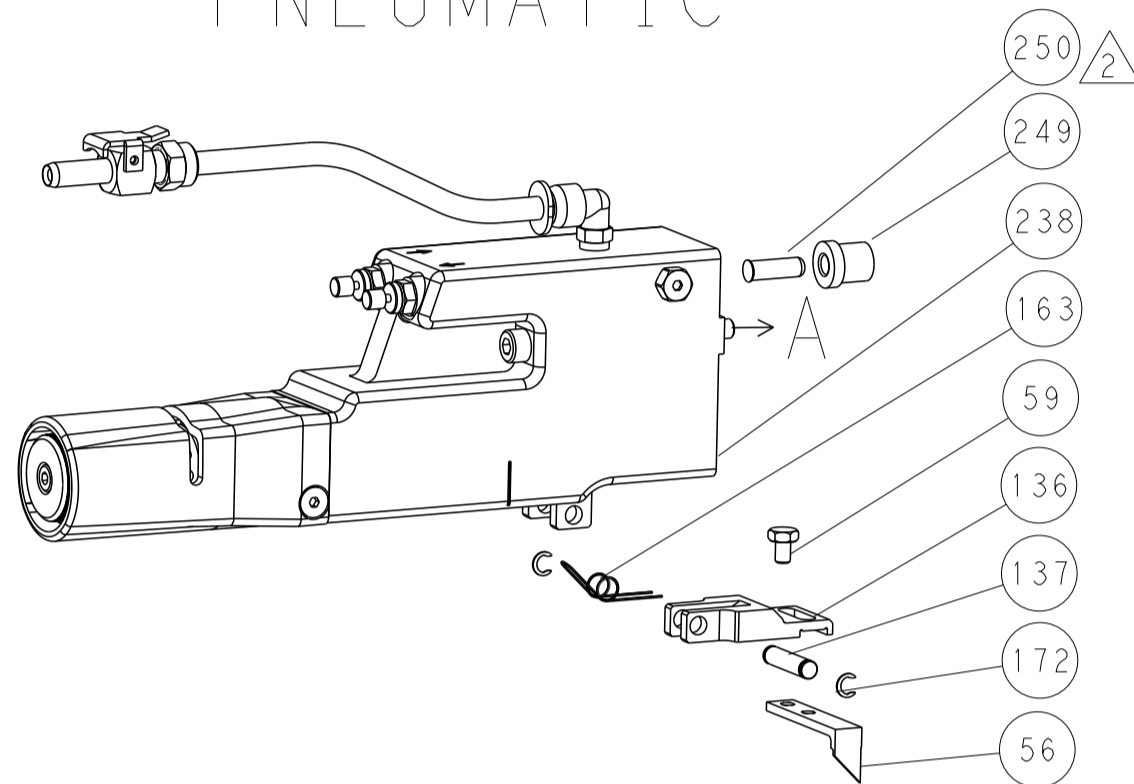
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MATERIAL:		FINISH:		WEIGHT:	

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

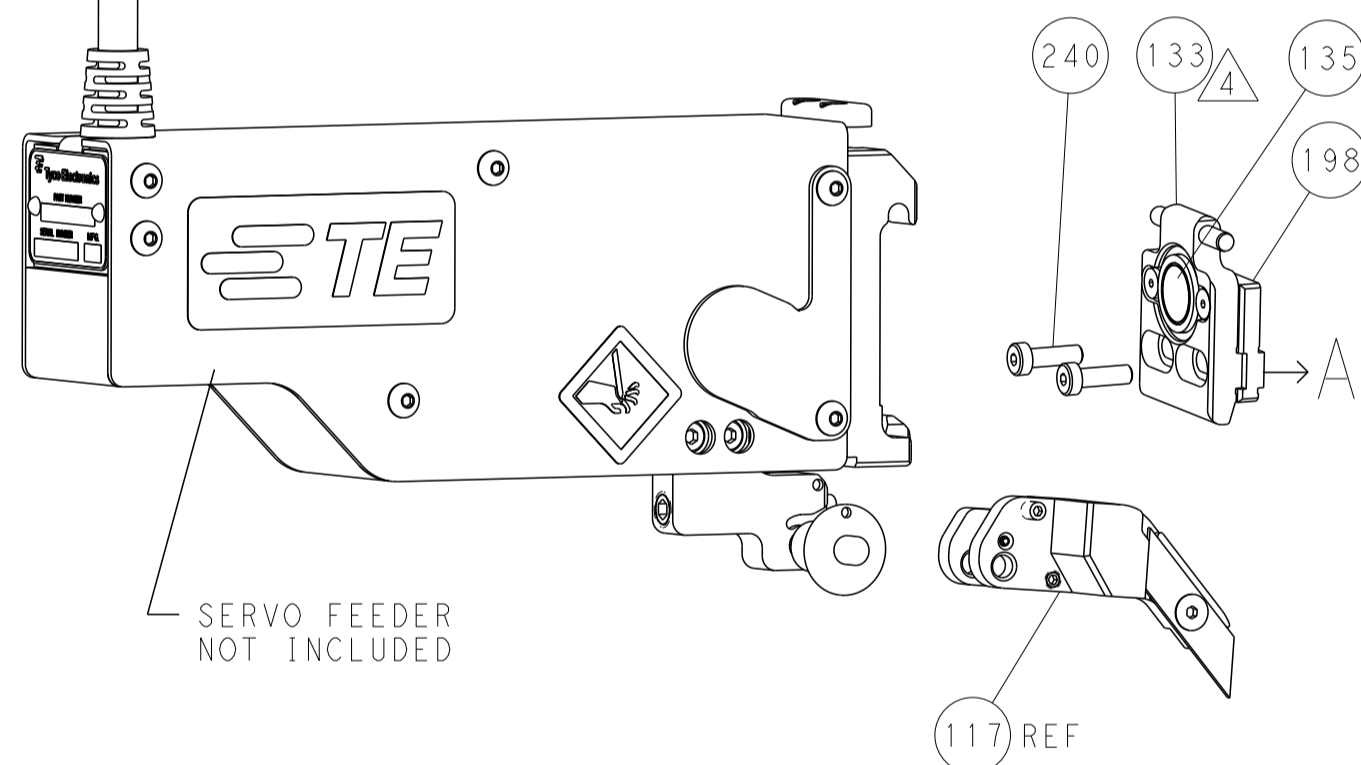
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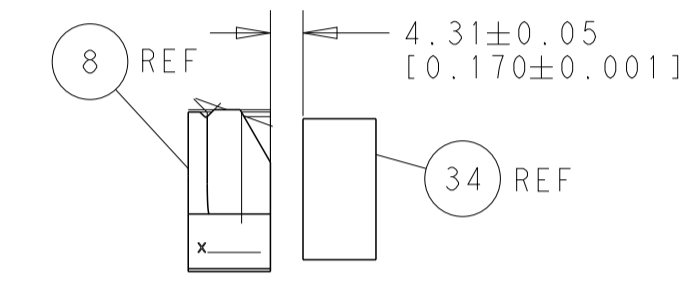
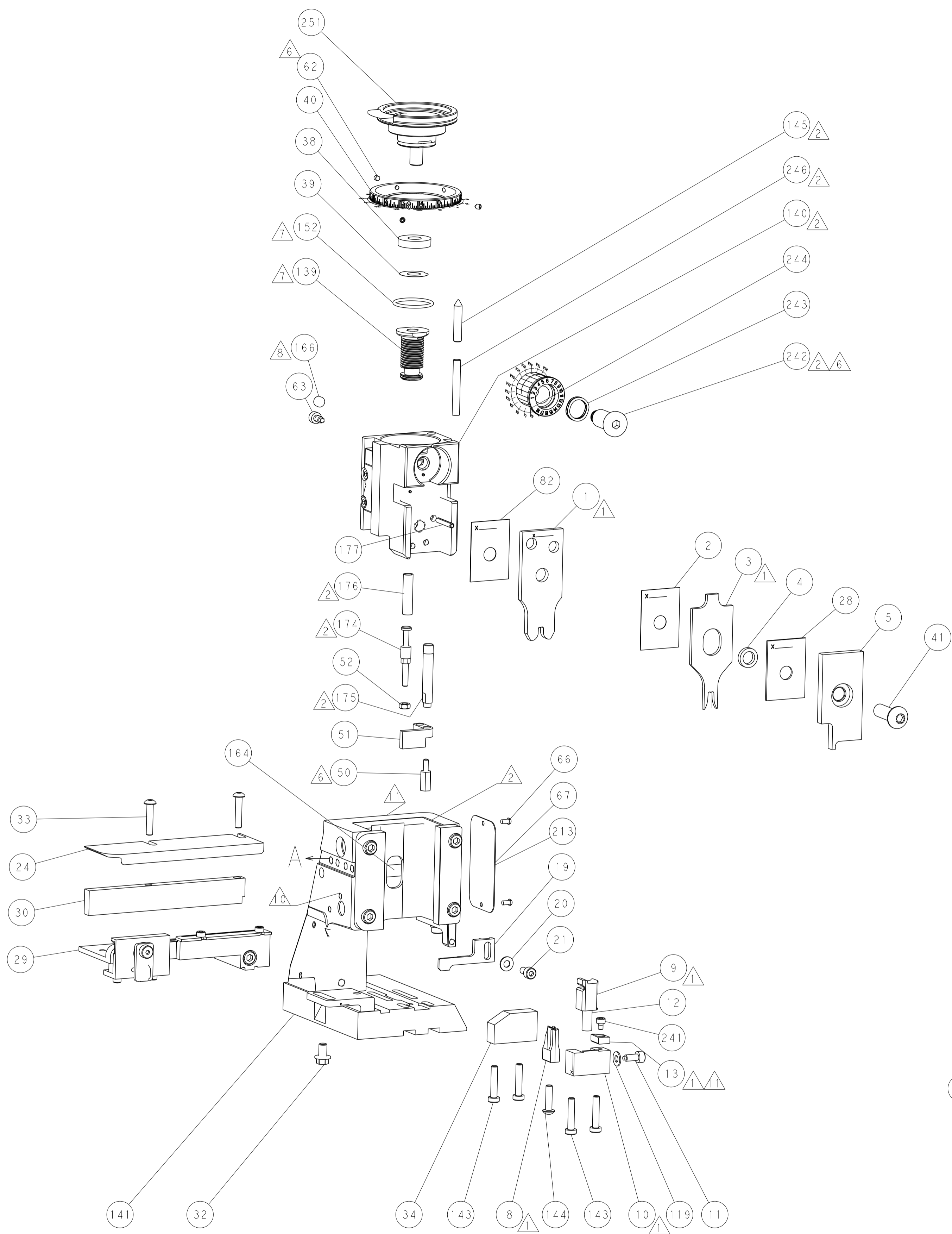
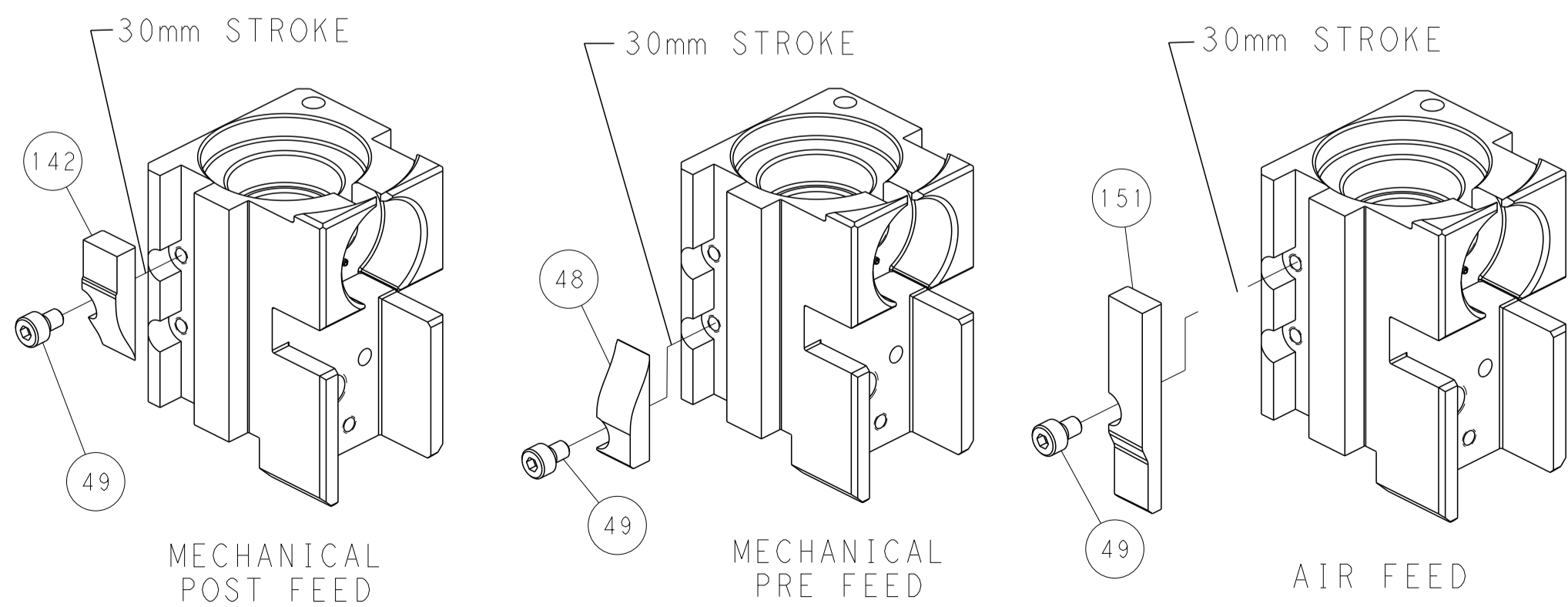
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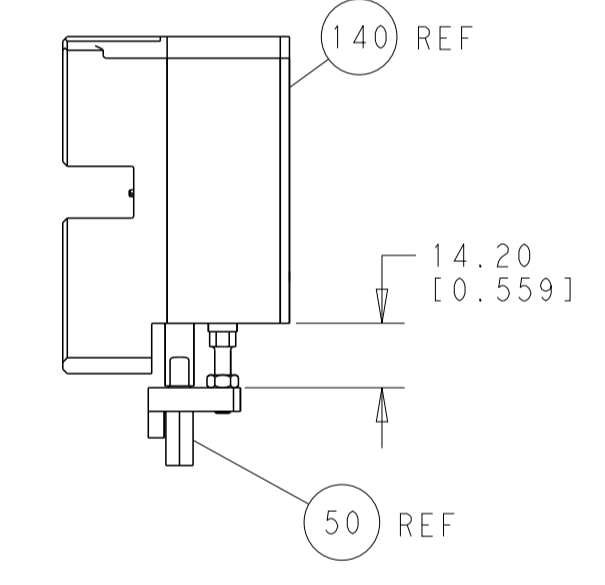
SERVO LATCH PLATE



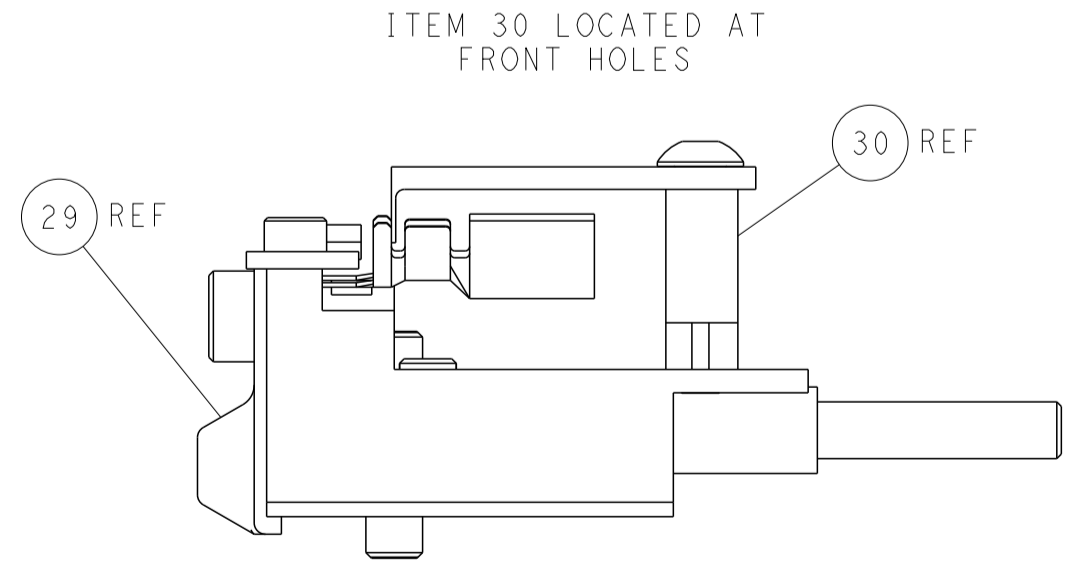
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH ±.		DWN R. HUANG 28JUL2011 CHK S. XI 28JUL2011 APVD S. XI 28JUL2011 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A1 00779 C=2151171 RESTRICTED TO	
MATERIAL		FINISH		SCALE 1:2		SHEET 4 OF 4 REV B	