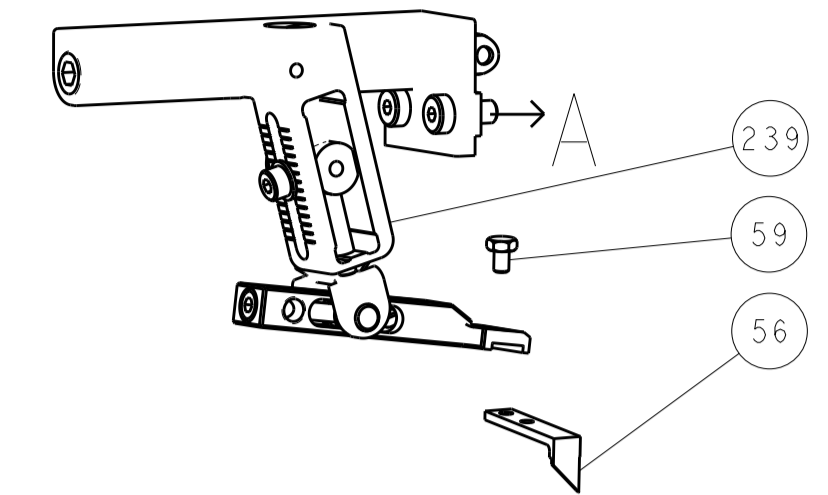
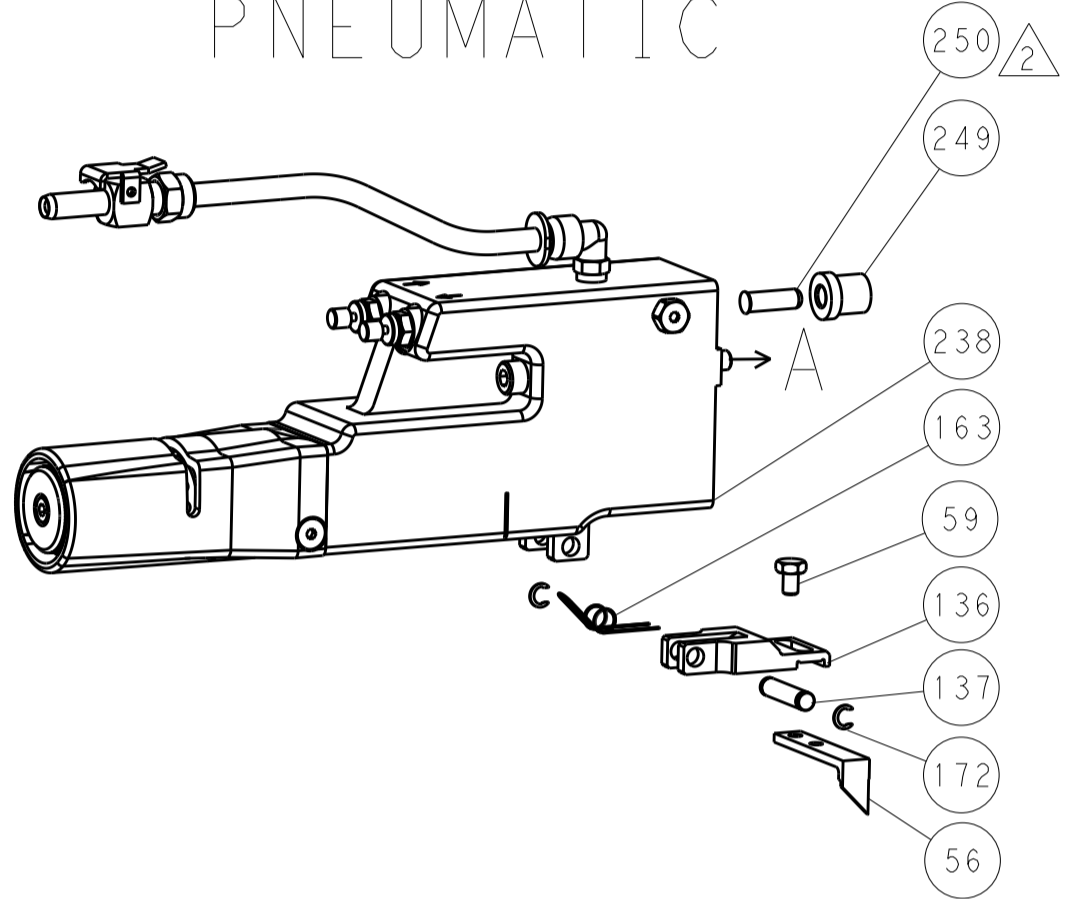


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE MECHANICAL



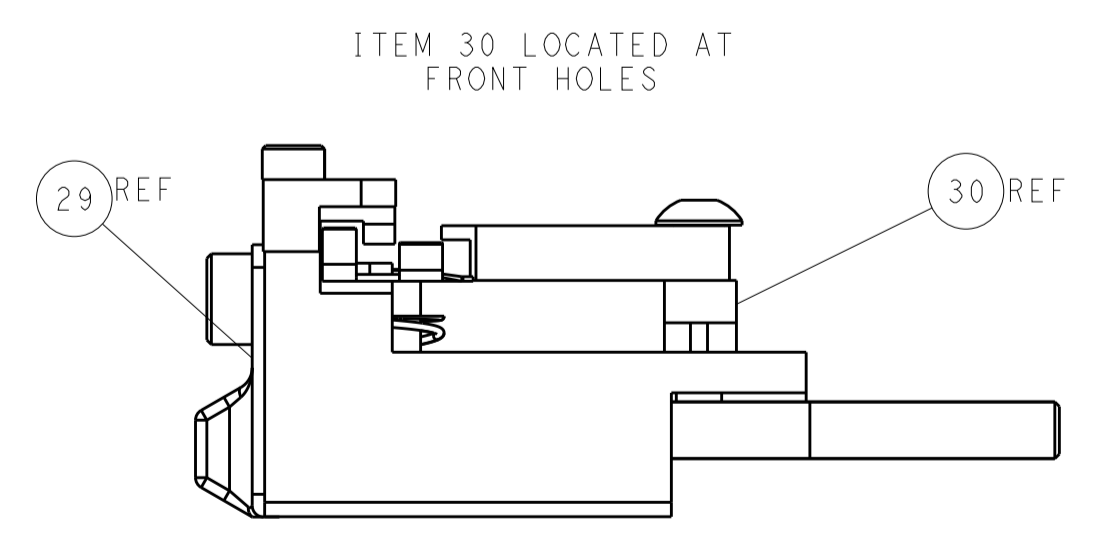
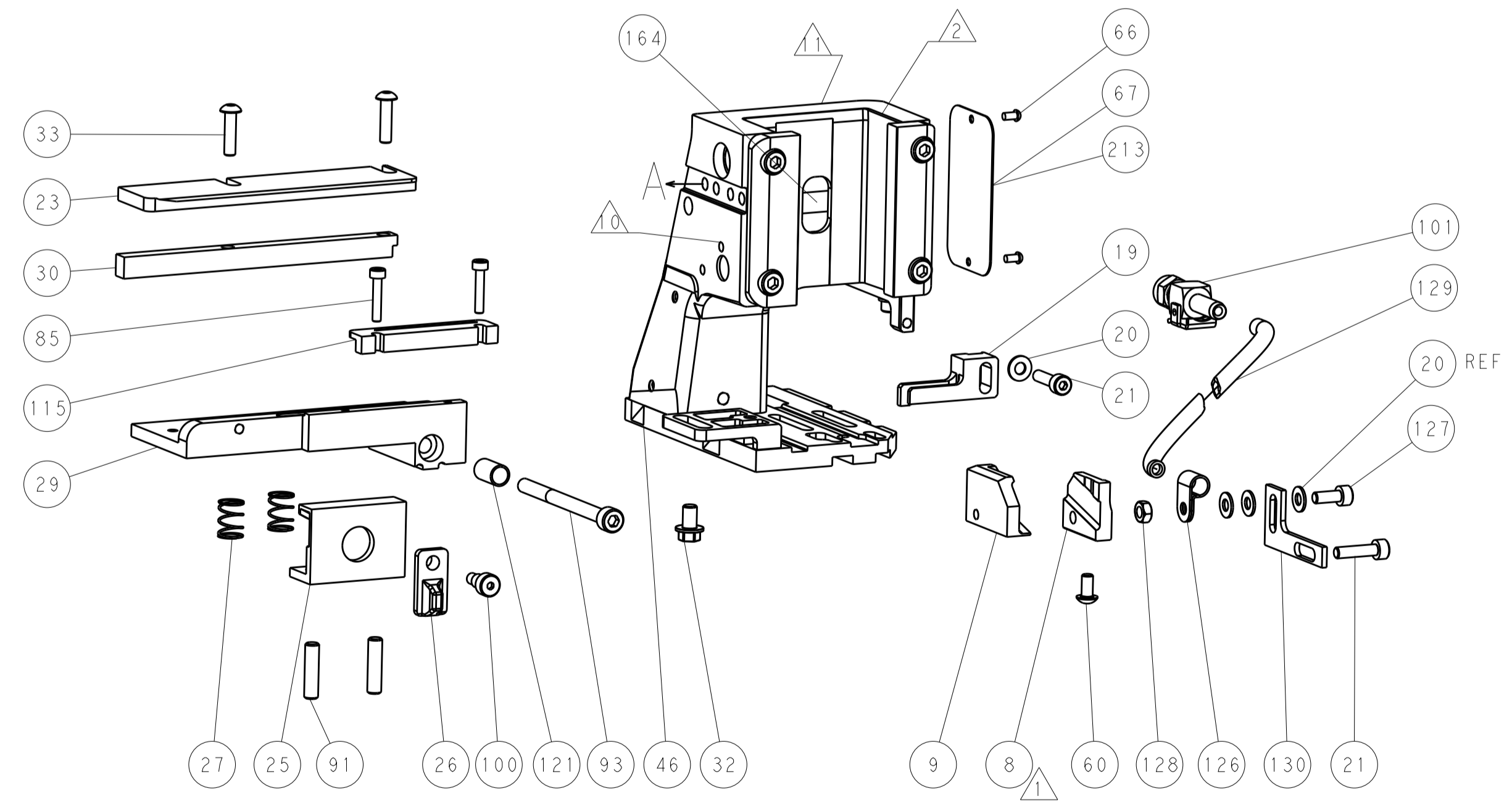
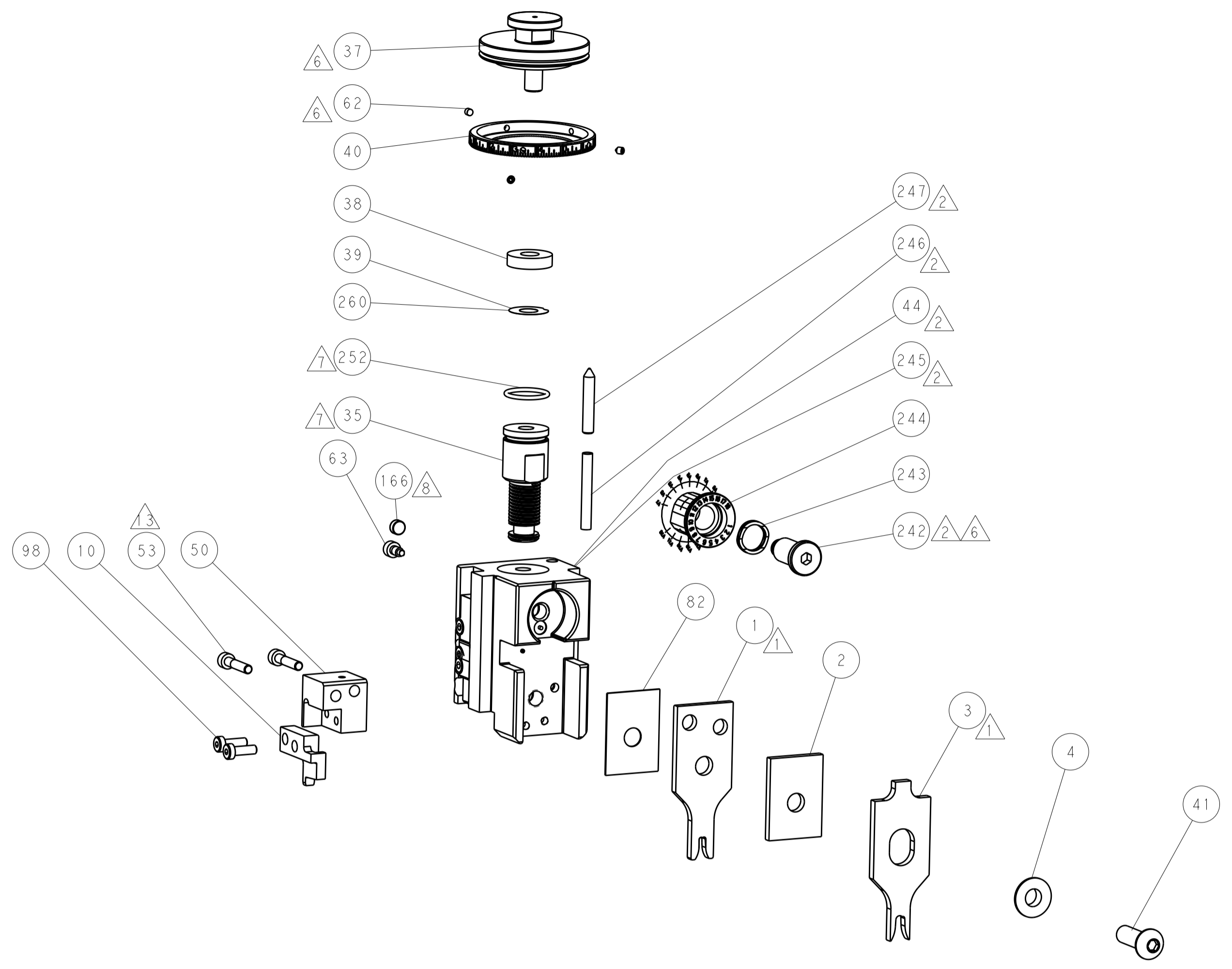
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN S.ZOU 26AUG2011		TE Connectivity	
mm	0 PLC	±		CHK T.ELBIN 26AUG2011	NAME	Ocean Side Feed Applicator	
	1 PLC	±		APVD S.XI 26AUG2011	SIZE	CAGE CODE	DRAWING NO
	2 PLC	±			RESTRICTED TO		
	3 PLC	±			A1 00779 ©=2151089		
	4 PLC	±			SCALE 1:2 SHEET 2 OF 4 REV C		
	ANGLES	±		CUSTOMER DRAWING			

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151089-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-2	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151089-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151089-4	-	-	-
	2-2151089-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-2	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151089-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151089-4	-	-	-
	2-2151089-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-2	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-2	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2151089-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151089-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.05 mm [.120]	F
INSUL	4.57 mm [.180]	OV
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: FASTIN-FASTON CONNECTOR .312 FLAG REC. CONTACT.		
WIRE STRIP LENGTH 6.40-7.20 mm [.252-.283 IN]		INSULATION DIAMETER RANGE Ø2.50-3.80 mm [.098-.150 IN]
TERMINAL APPLICATION SPECIFICATION 114-3118	-	-
TERMINALS APPLIED		
TE TERMINAL	TE TERMINAL	TE TERMINAL
180453-1	180453-2	180453-4
1-180453-2		180453-6

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.90 +/- 0.05 [.075 +/- .002]	6.8
2.00mm2	1.75 +/- 0.05 [.069 +/- .002]	8.6
1.50mm2	1.62 +/- 0.05 [.064 +/- .002]	9.6
1.00mm2	1.47 +/- 0.05 [.058 +/- .002]	11.3

- 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: 8-2151089-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151089-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151089-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151089-6
- 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.
- GRIND TO LENGTH AT ASSEMBLY.

***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)

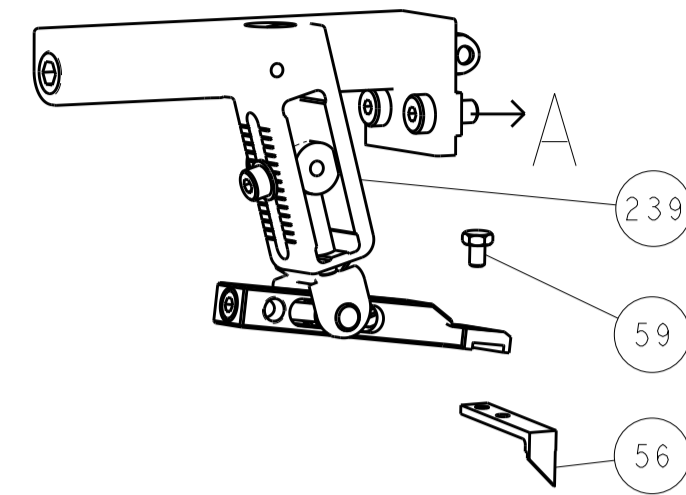
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-6	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
-	-	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
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	2119656-2	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	2217068-1	BRACKET, AIR BLAST	130
-	457	457	457	457	2030758-3	TUBING, POLYURETHANE	129
-	1	1	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	128
-	1	1	1	1	1-21680083-0	SCR, SKT HD CAP, RoHS, M4 X 10	127
-	1	1	1	1	986220-3	CLAMP, CABLE, BLACK	126
-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	3-690487-8	GUIDE, FRONT STRIP	115
-	1	1	1	1	23238-1	INSERT, COUPLING	101
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	100
-	2	2	2	2	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	98
-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	91
-	2	2	2	2	1-21680083-3	SCR, SKT HD CAP, RoHS, M3 X 16	85
-	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	1338685-2	PAWL, FEED	56
-	2	2	2	2	1-18023-4	SCR, SKT HD CAP M4 X 20.0	53
-	1	1	1	1	1803011-4	HOLDER, SLUG BLADE	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	2119644-2	RAM WASHER, PRECISION	38
-	2	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)	33
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
-	1	1	1	1	1-1320908-1	SPACER, STRIP GUIDE	30
-	1	1	1	1	1-1901086-9	PLATE, STRIP GUIDE	29
-	2	2	2	2	22282-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	6-690754-4	DRAG, SPECIAL	25
-	1	1	1	1	7-690440-5	GUIDE, REAR STRIP	23
-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	21
-	4	4	4	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2161830-1	COMBINATION STRIPPER	19
-	1	1	1	1	2-1583859-0	BLADE, SLUG	10
-	1	1	1	1	2-1803012-3	PLATE, REAR SHEAR	9
-	1	1	1	1	1803010-1	ANVIL, SPECIAL, COMBINATION	8
-	1	1	1	1	238009-3	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	7-2119785-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	3-455888-7	SPACER, CRIMPER	2
-	1	1	1	1	2-456409-9	CRIMPER, WIRE .120 "F" PREMIUM	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

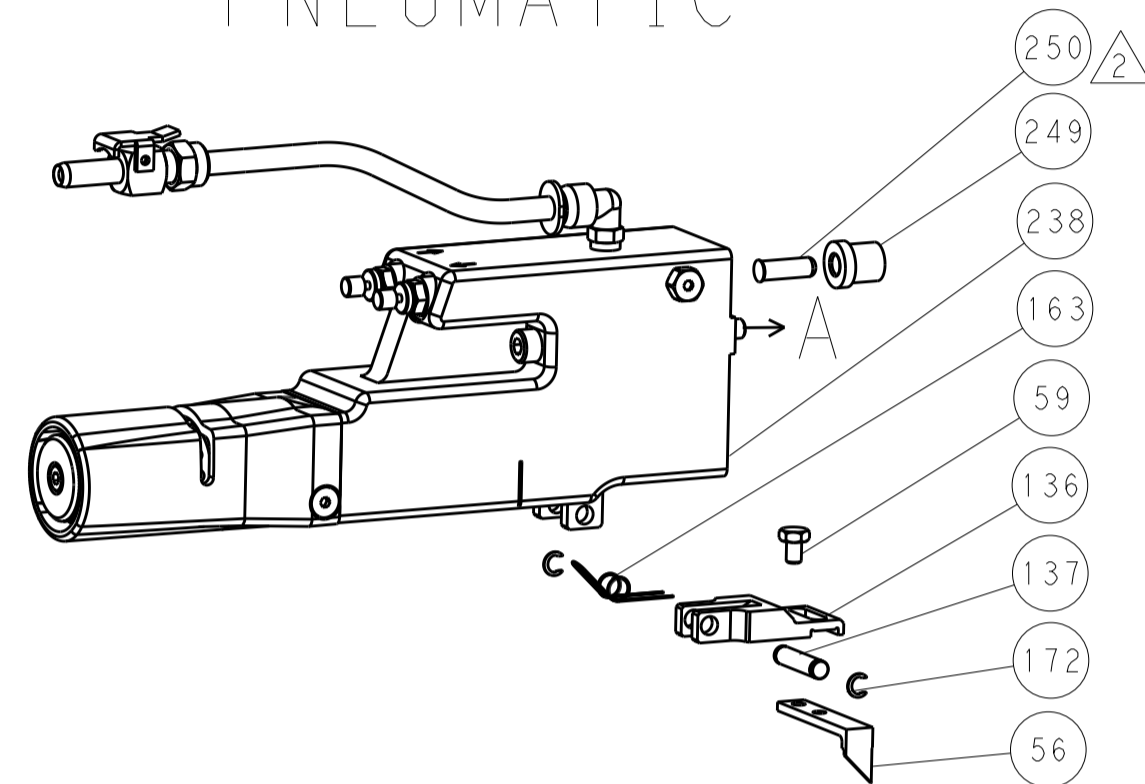
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mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	PRODUCT SPEC		APPLICATION SPEC		SIZE: A1	
MATERIAL:		FINISH:		WEIGHT:		CAGE CODE: 00779		DRAWING NO: C-2151089		RESTRICTED TO:	
				CUSTOMER DRAWING				SCALE: 1:2		SHEET 3 OF 4	

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

FEED TYPE MECHANICAL



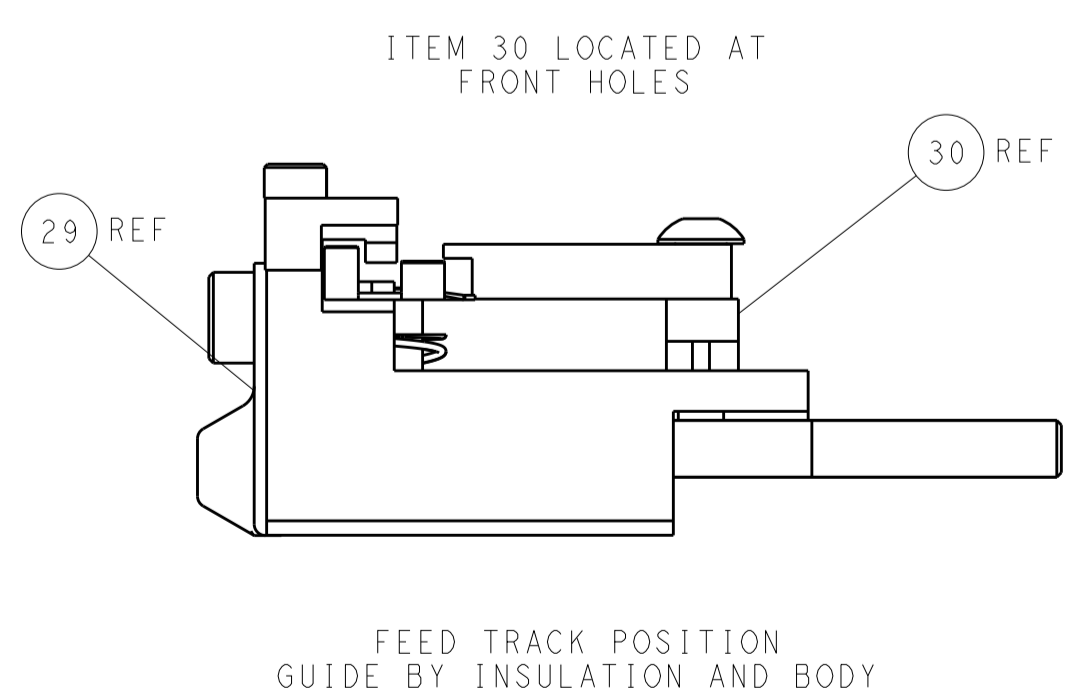
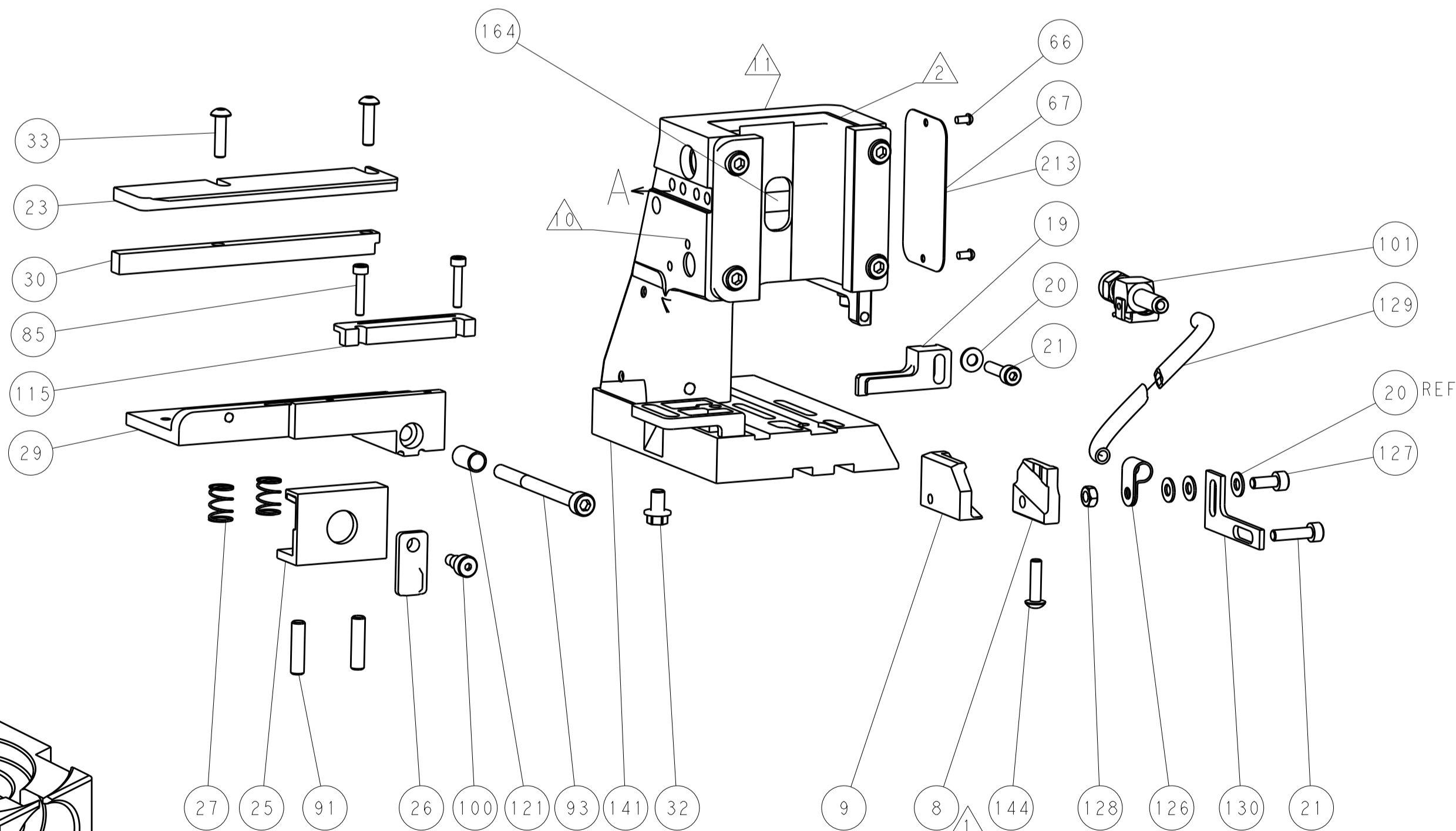
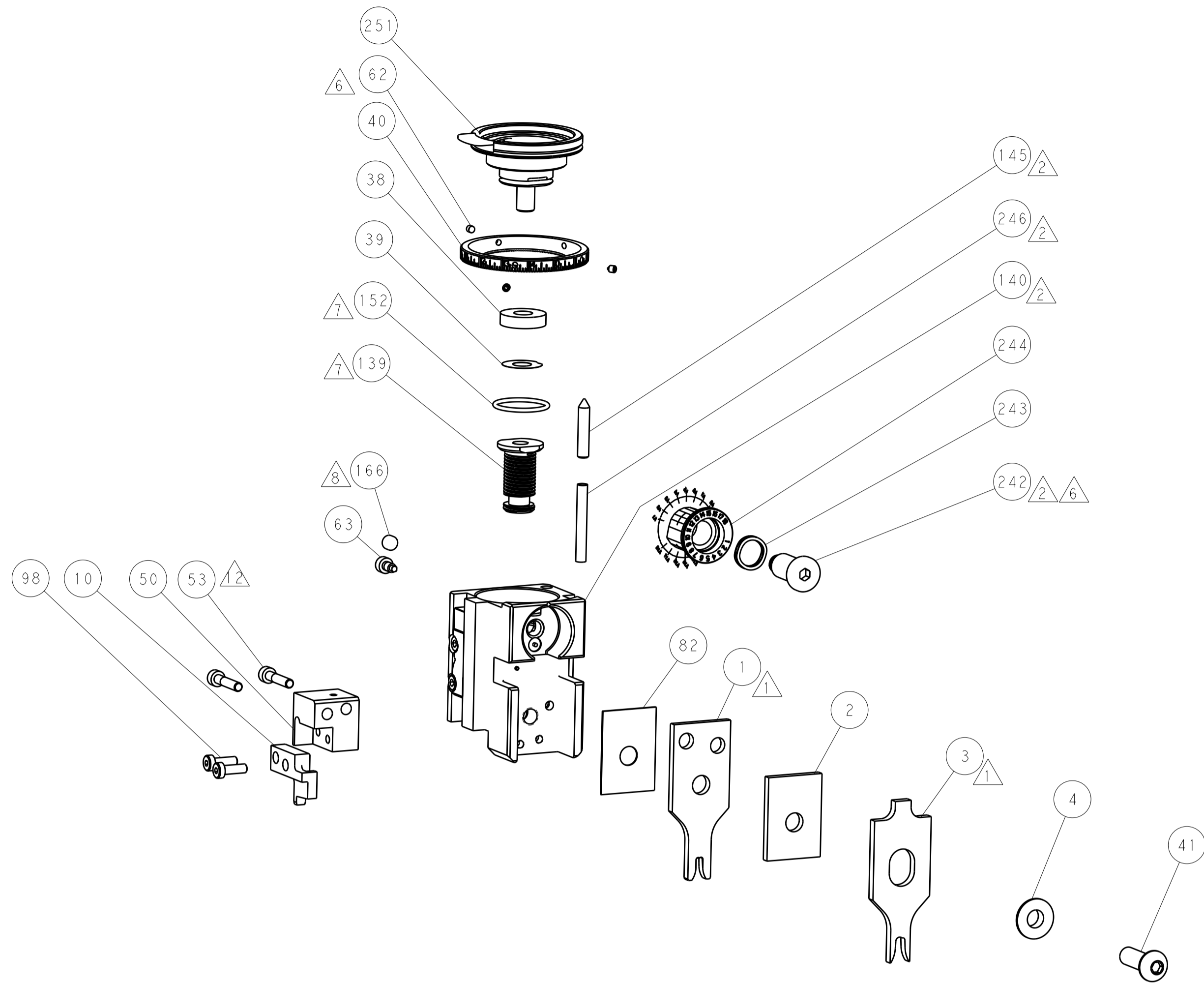
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN S_ZOU 26AUG2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	CUSTOMER DRAWING:	APVD S_XI 26AUG2011	NAME	SIZE	CAGE CODE
					Ocean Side Feed Applicator	RESTRICTED TO	
					A11 00779 ©=2151089	SCALE	1:2 SHEET 4 OF 4 REV C