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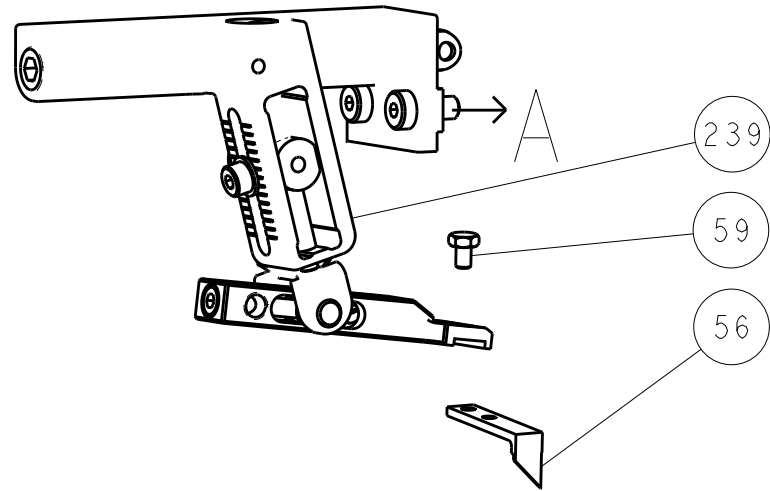
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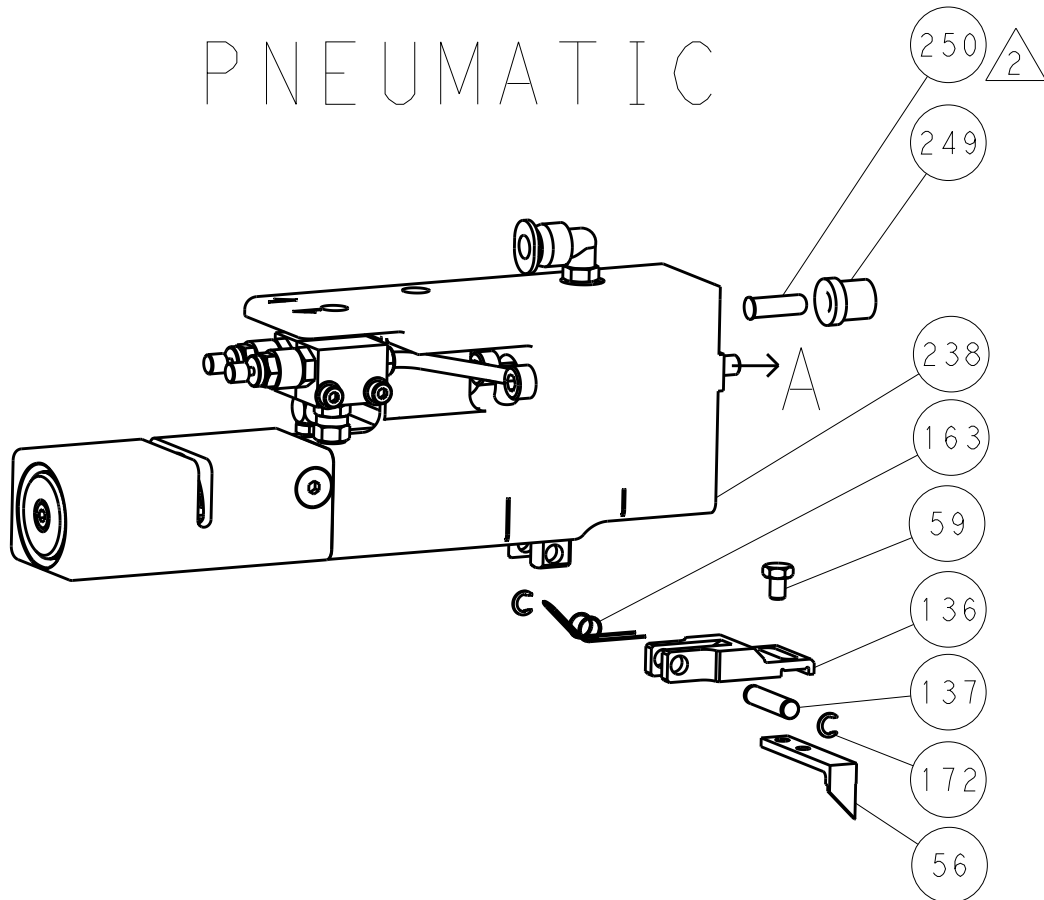


LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

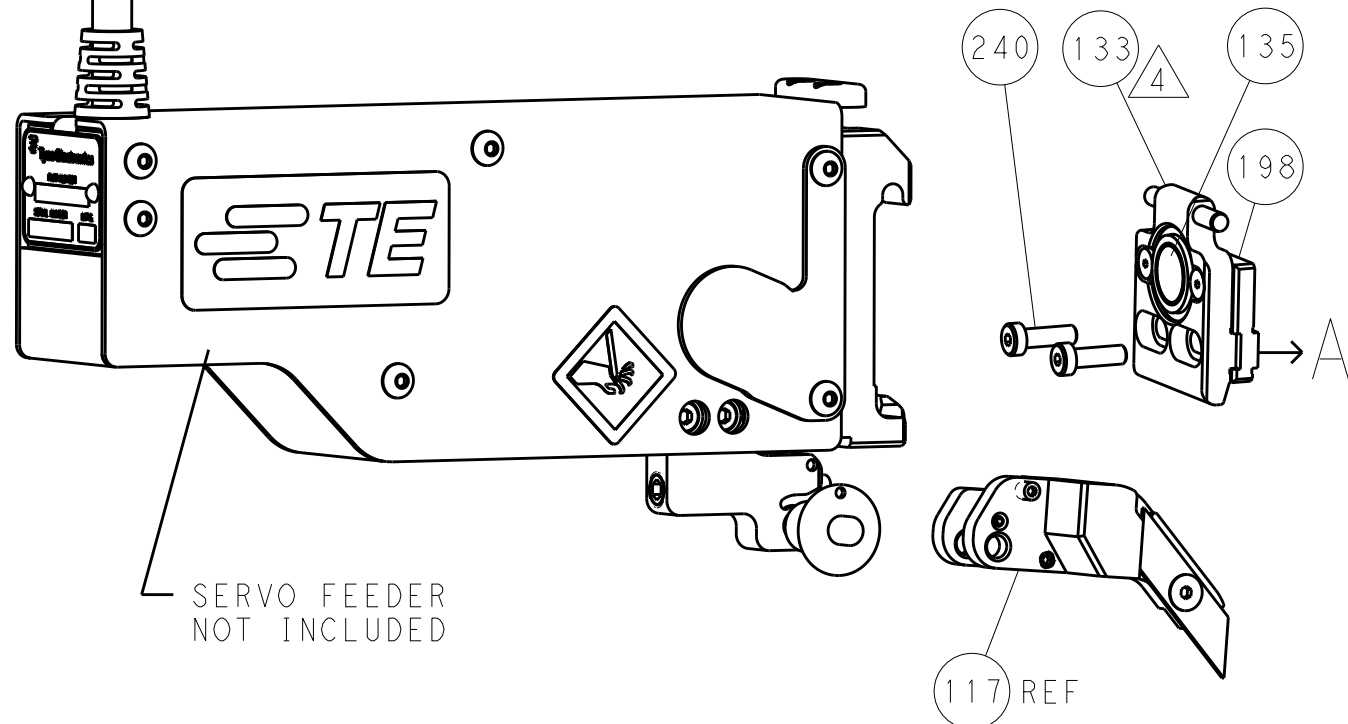
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MECHANICAL



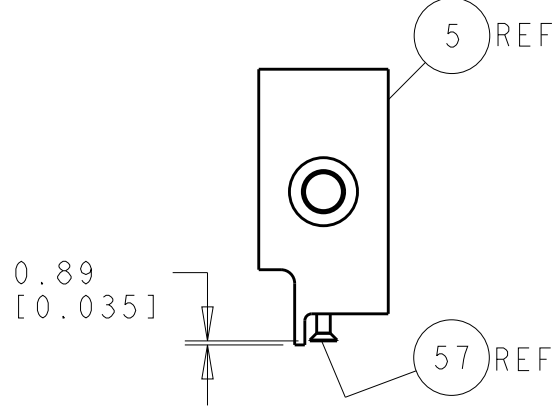
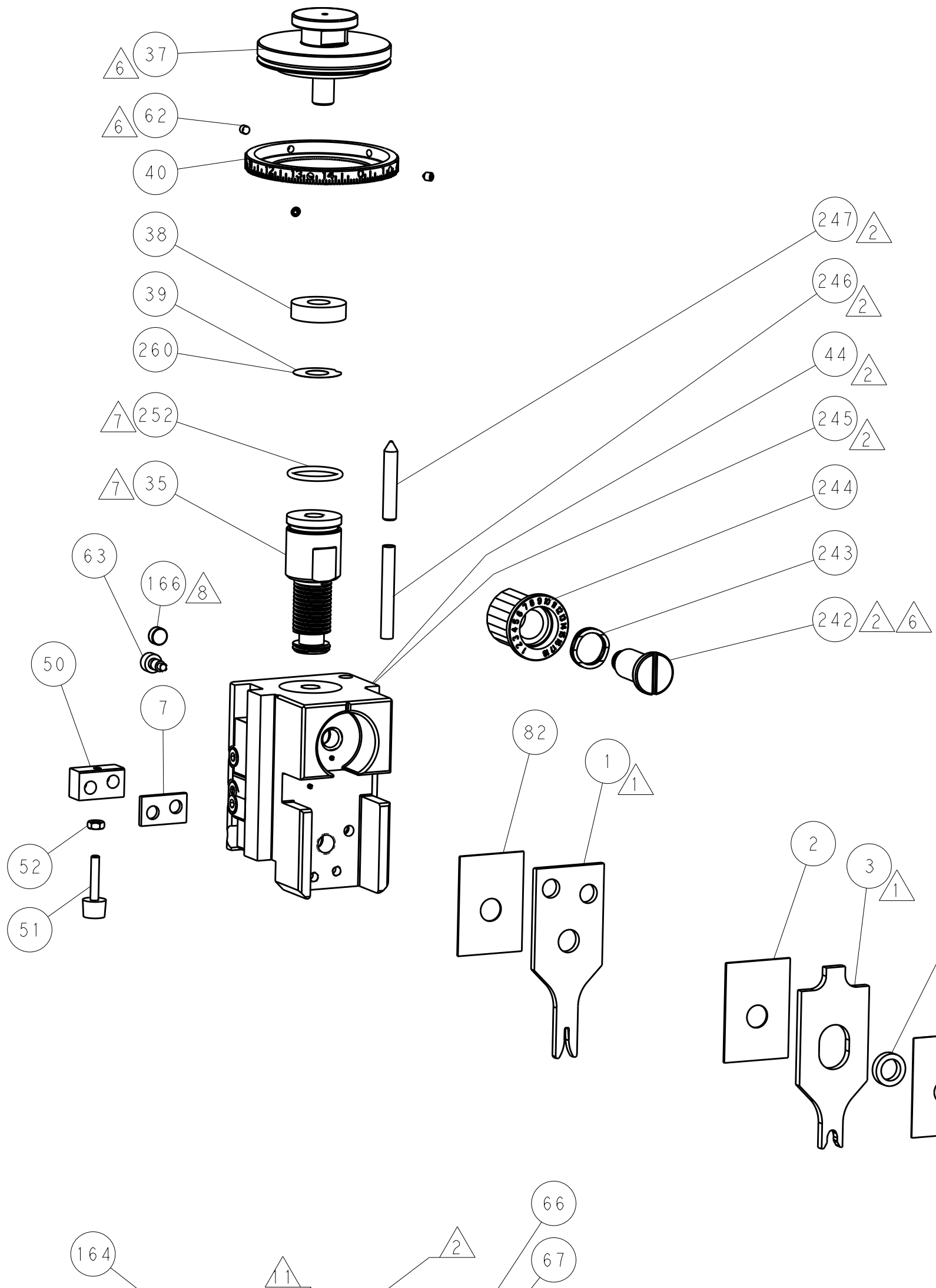
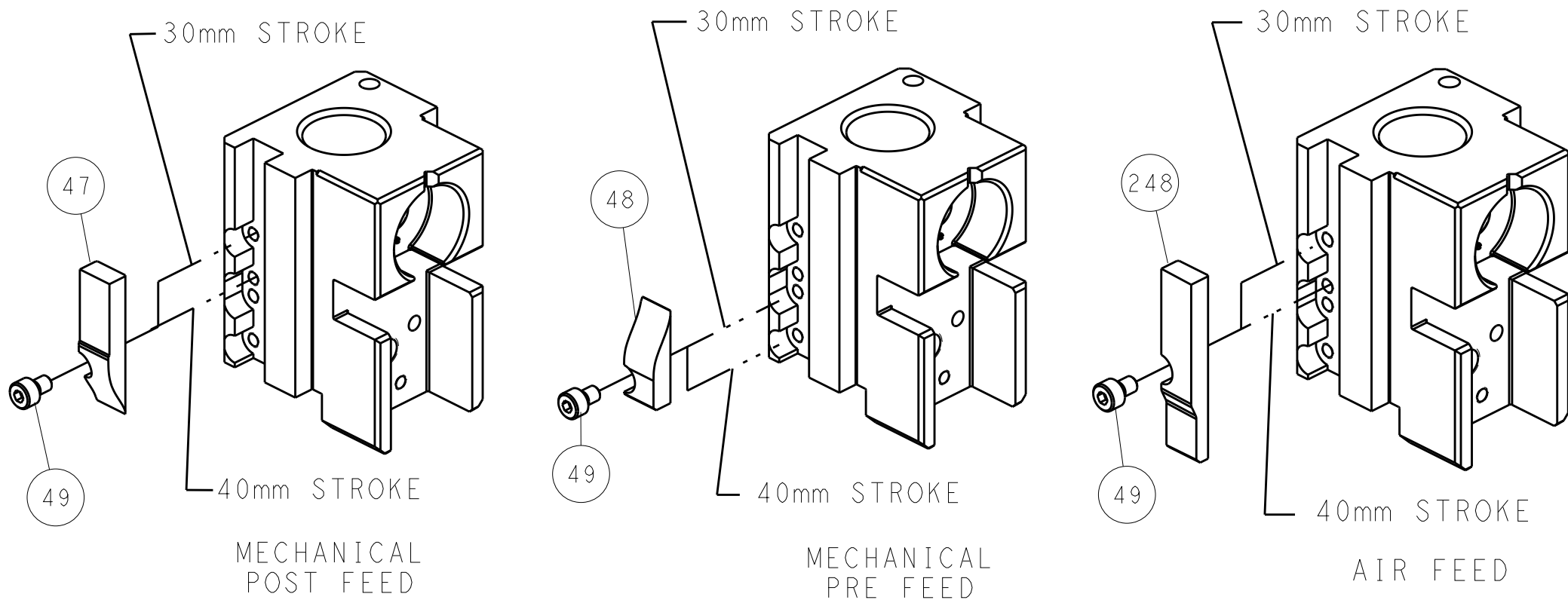
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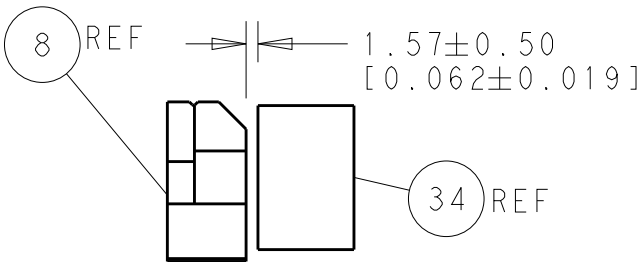
SERVO
LATCH PLATE



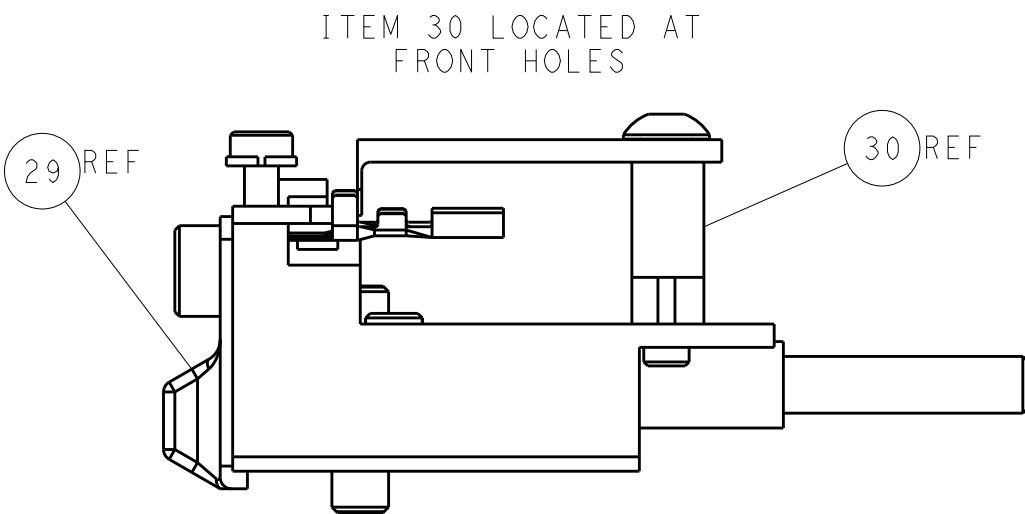
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE CONTACTED FOR THE LATEST VERSION.				DWN: K. HUANG 17APR2013 CHK: L. ZHANG 17APR2013 APVD: J. GUO 17APR2013				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.02 2 PLC ±.02 3 PLC ±.005 4 PLC ±.0005 ANGLES .1				NAME: Ocean Side Feed Applicator			
MATERIAL: -				FINISH: -				SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151928			
Customer Accessible Production Drawing				SCALE: 1:1				SHEET 2 OF 4 REV A			

8

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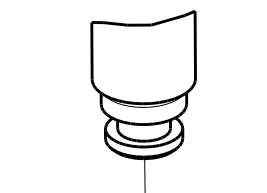
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER 	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151928-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151928-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2151928-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SMART APPLICATOR	2161326-1	-	8-2151928-4	-	-	-
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151928-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2151928-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	SMART APPLICATOR	2161326-1	-	8-2151928-4	-	-	-
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
	2-2151928-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	7-2151928-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

ASME - Y14.5M-2013

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	3.43 mm [.135]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MQS 1mm SOCKET CONTACT, SWS			
WIRE STRIP LENGTH 3.45-3.75 mm [.136-.148 IN]		INSULATION DIAMETER RANGE Ø 2.40-2.60mm [.094-.102 IN] 	
TERMINAL APPLICATION  114-18231		-	
SPECIFICATION		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1670448-2		967067-1	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.50mm2		1.01 +/- 0.03 [.040 +/- .001]		7.5
0.35mm2		0.92 +/- 0.03 [.036 +/- .001]		8.4



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: 8-2151928-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151928-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151928-5
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 ITEMS 62, 180 & 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. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION RANGE QUOTED IS THAT OF THE TERMINAL. THE SEAL INSULATION RANGE IS 1.4- 2.1mm [.055 - .083 IN.]
13. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
14. INSULATION CRIMP HEIGHT 2.8mm MAX, CRIMP WIDTH 3.6mm MAX.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-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	DIST 66	REVISIONS				
	P	LTR	DESCRIPTION			DATE	OWN	APVD		
		-	SEE SHEET 1			-	-	-		
-	-	1	-	2119640-1	PUSH ROD, AIR FEED			250		
-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI			249		
1	1	1	1	1-22279-3	SPRING, COMPRESSION			246		
1	1	1	1	2119082-7	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			24		
1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0			24		
-	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		
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	455888-5	SPACER, CRIMPER			82		
1	1	1	1	2119956-1	DOCUMENTATION PACKAGE			7		
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	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0			57		
-	-	1	1	1338685-1	PAWL, FEED			56		
2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0			53		
1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3			52		
1	1	1	1	811242-5	BUMPER, HOLD DOWN			51		
1	1	1	1	690753-2	SPACER, TONKER			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	1752356-6	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	2119959-1	ASSEMBLY, STRIP GUIDE			29		
1	1	1	1	455888-3	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	318707-1	FLOATING SHEAR, FRONT			9		
1	1	1	1	1-1633128-3	ANVIL, COMBINATION .055			8		
1	1	1	1	4-240641-2	SPACER			7		
-	-	-	-	-	-			6		
1	1	1	1	2119781-1	DEPRESSOR, SHEAR			5		
1	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER			4		
1	1	1	1	1-1633996-4	CRIMPER, INSULATION SPECIAL			3		
1	1	1	1	455888-6	SPACER, CRIMPER			2		
1	1	1	1	3-456402-5	CRIMPER, WIRE PREMIUM			1		
-27	-25	-22	-21	PART NO	DESCRIPTION			ITEM NO		

(THIS DRAWING IS A COMPUTER GENERATED FILE) ALL DIMENSIONS ARE TO BE VERIFIED BY THE CUSTOMER PRIOR TO PRODUCTION THIS DRAWING IS NOT VALID FOR CONSTRUCTION PURPOSES						DWG NO. 17APR2013 CHE HUANG		 TE Connectivity Morrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.05 4 PLCS ±0.005 ANGLES ±°		DWG NO. 17APR2013 CHE ZHANG		NAME			
		PRODUCT SPEC APPLICATION SPEC		NAME Ocean Side Feed Applicator -		SCALE A 00779 C=2151928		RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		SCALE		SHEET 3 OF 4 REV A	
				Customer Accessible Production Drawing					

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

