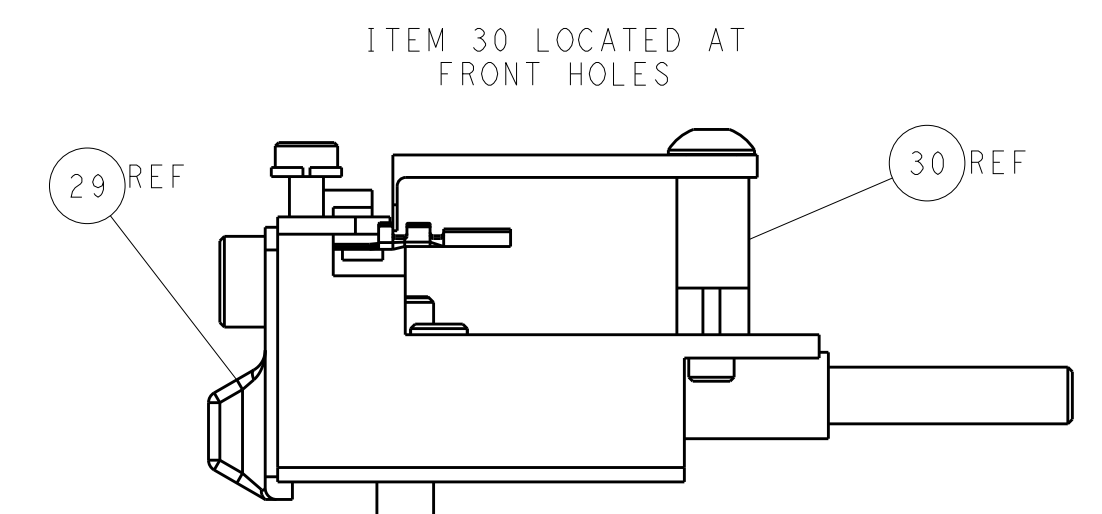
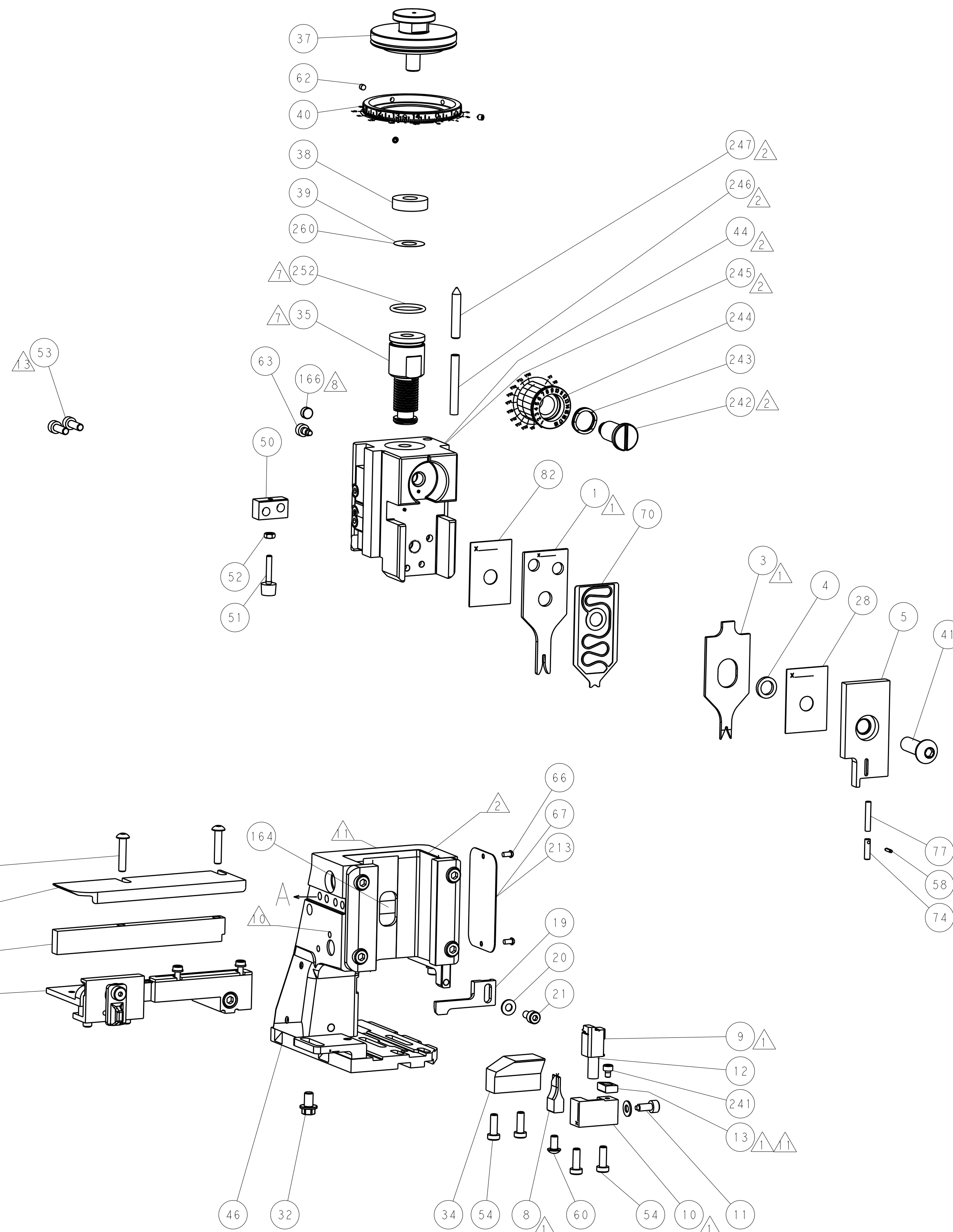
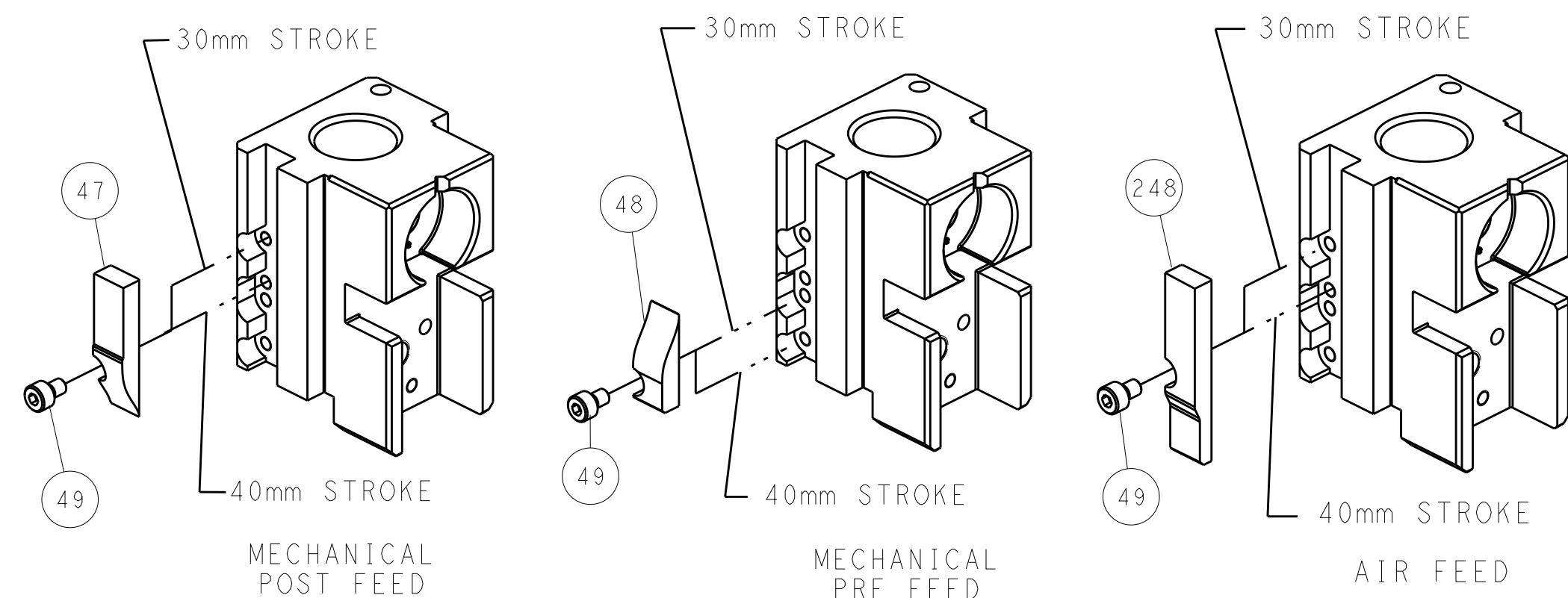


PNEUMATIC

SERVO
LATCH PLATE

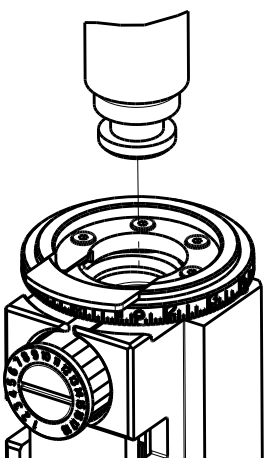
CAM POSITIONS



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ENGINEERING CORPORATION IT IS SUBJECT TO CHANGES AND THE CONTROLLING ENGINEERING ORGANIZATION MAY BE CONTROLLED FOR THIS PURPOSE BY THE ENGINEERING CORPORATION		DWN S_ZOW 21JUN2011	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK ELBIN 21JUN2011		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD S_XJ 21JUN2011	NAME Ocean Side Feed Applicator -	
mm		PRODUCT SPEC -		
		APPLICATION SPEC -	SIZE A1	
MATERIAL		WEIGHT		
FINISH		RESTRICTED TO	CAGE CODE 00779	
			DRAWING NO C=2151132	
			SCALE 1:2	
			SHEET 2 OF 4	
			REV A	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				

8		7		6		5		4		3		
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		29								
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
						CONVERT TO	PART NUMBERS REQUIRED					
		2-2151132-1	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	-	8-2151132-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2151132-4	-	-	-
		2-2151132-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
						SERVO LATCH PLATE	2119951-1	-	8-2151132-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2151132-4	-	-	-
		2-2151132-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
		2-2151132-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
		7-2151132-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-
						-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	1.45 mm [.057]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: REC. & TAB FOR MINI MULTILOCK CONN.			
WIRE STRIP LENGTH 3.00-3.50 mm [.118-.138 IN]		INSULATION DIAMETER RANGE Ø1.40-1.70 mm [.055-.067 IN]	
TERMINAL APPLICATION SPECIFICATION		114-5193 - -	
TERMINALS APPLIED			
TE TERMINAL 917308-1	TE TERMINAL 917309-1	TE TERMINAL	TE TERMINAL

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.50mm2		1.02+/-0.05 [0.040+/-0.002]		6.6
0.30mm2		0.90+/-0.05 [0.035+/-0.002]		7.9



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: 8-2151132-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151132-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151132-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151132-6
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 ITEMS 62 & 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. CUT TO LENGTH AT ASSEMBLY.

[illegible]

6	-	1	1	1	1	2119782-1	LINE ADJUST HEAD ASM, PACIFIC STYLE	251
	-	-	-	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	2119082-8	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	
-	-	-	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	22278-8	SPRING, COMPRESSION	77	
-	1	1	1	1	854769-4	HOLDER, INS	74	
-	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	66	
-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
6	-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	-	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	-	-	1	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5	BUMPER, HOLLOW	51
-	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	1	2	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1633861-1	SHEAR, FLOATING	9
1	1	1	1	1	1	8-1333225-5	ANVIL, COMBINATION	8
-	1	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1-1633966-5	CRIMPER, INSULATION O	3
1	1	1	1	1	1	6-568176-8	CRIMPER, WIRE	1

[illegible]

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

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

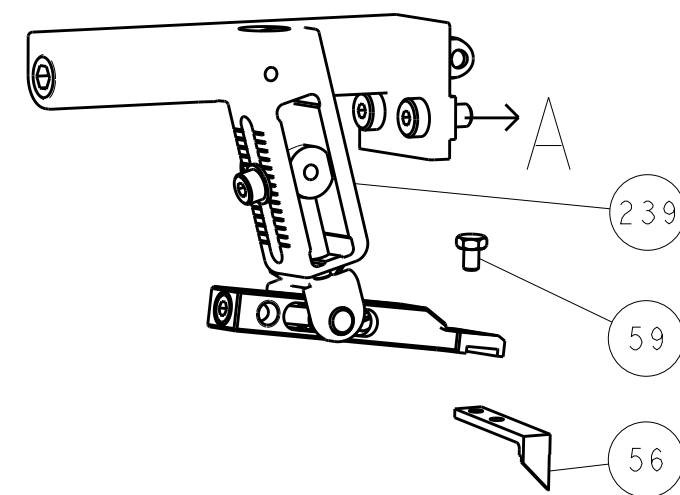
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C

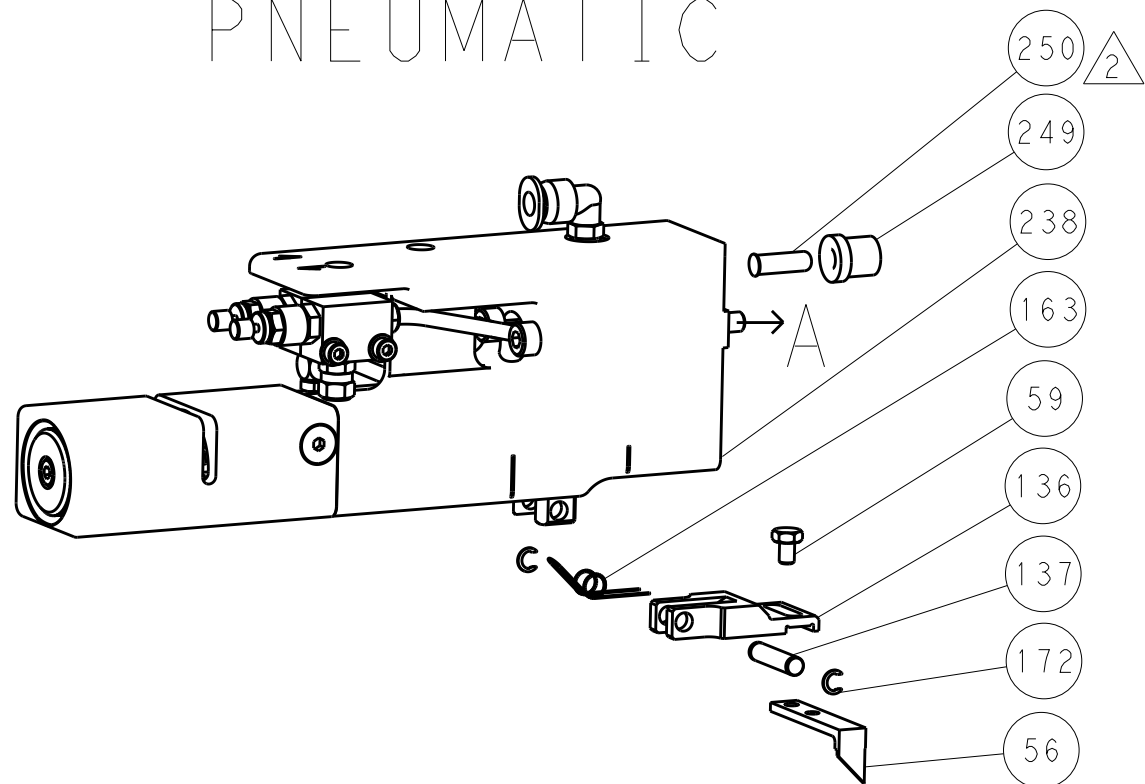
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A

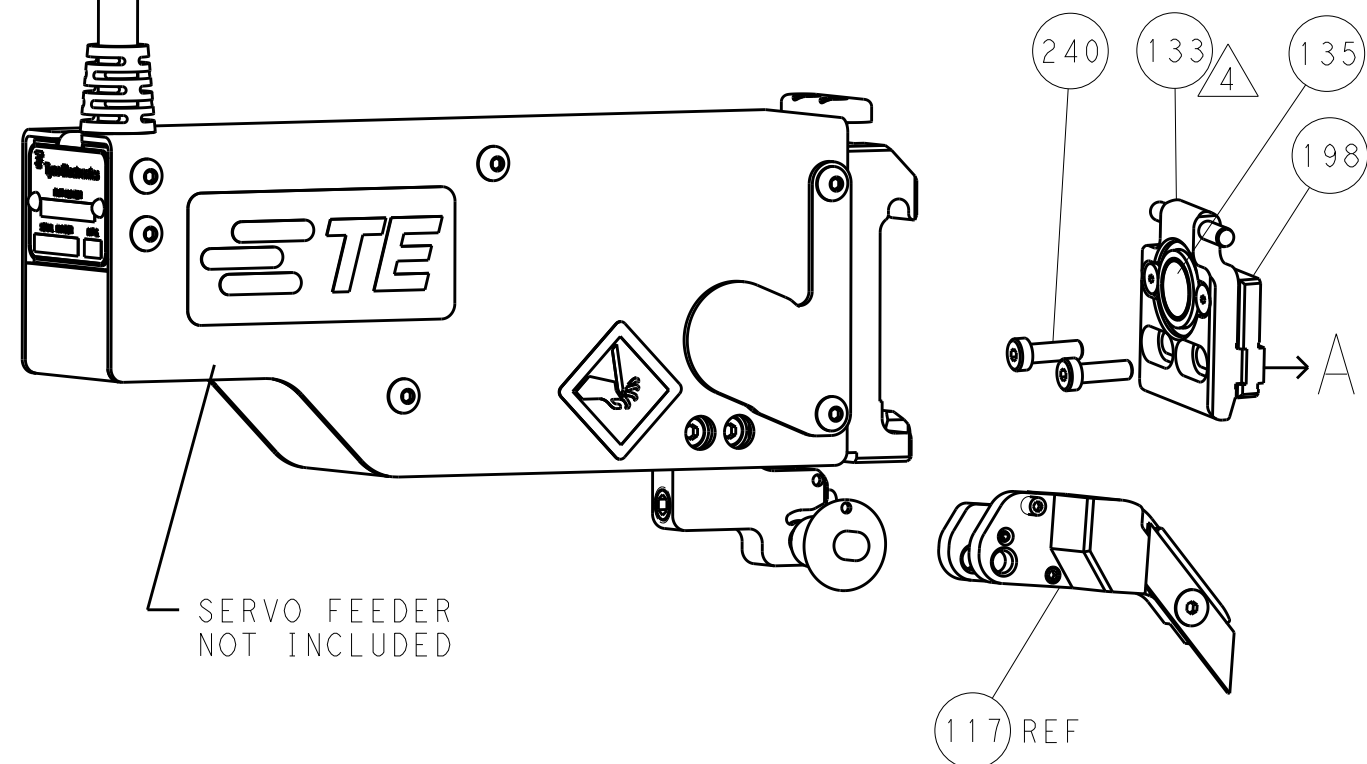
FEED TYPE MECHANICAL



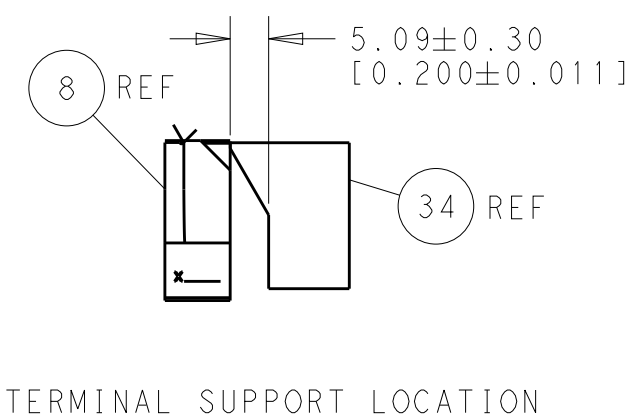
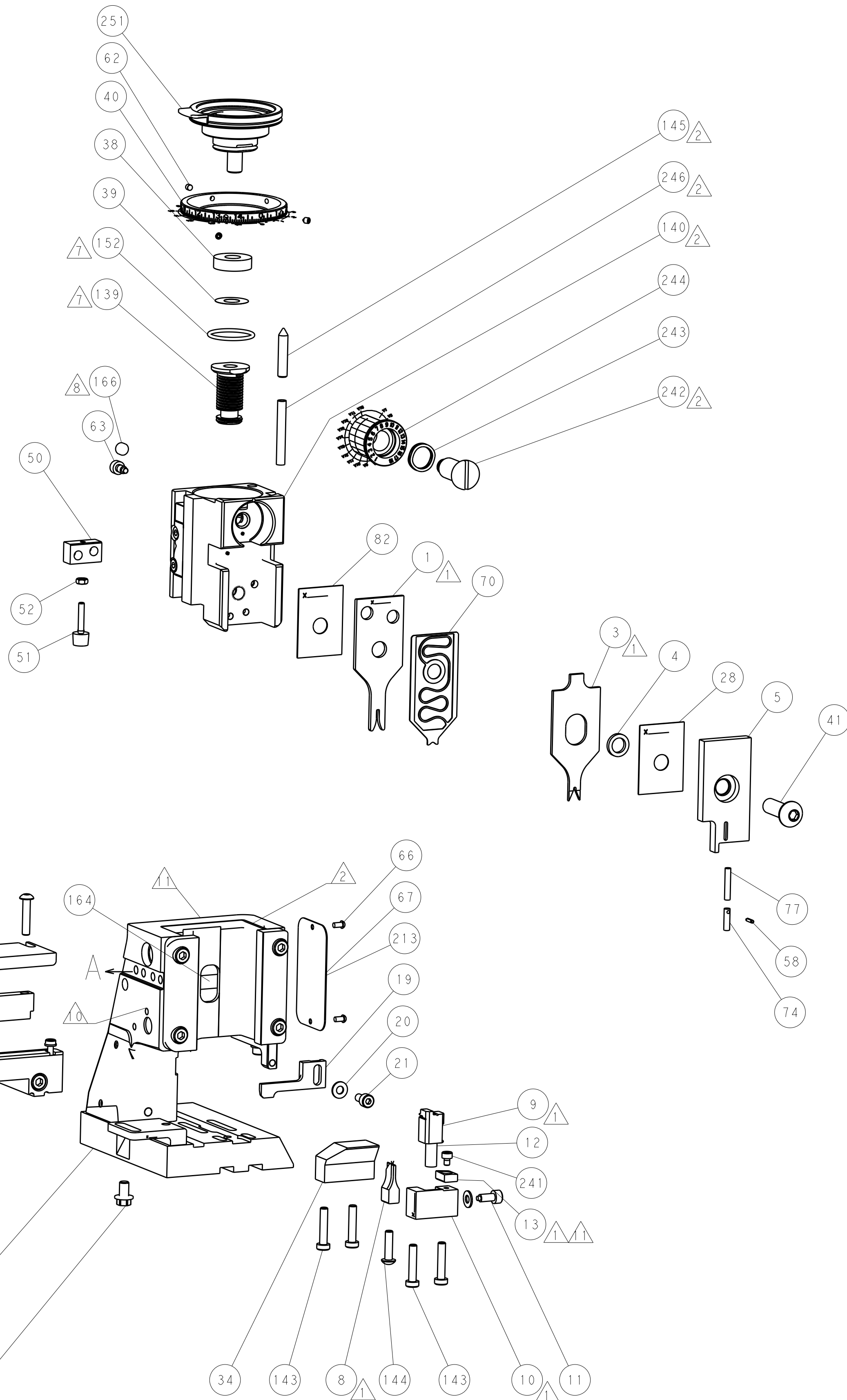
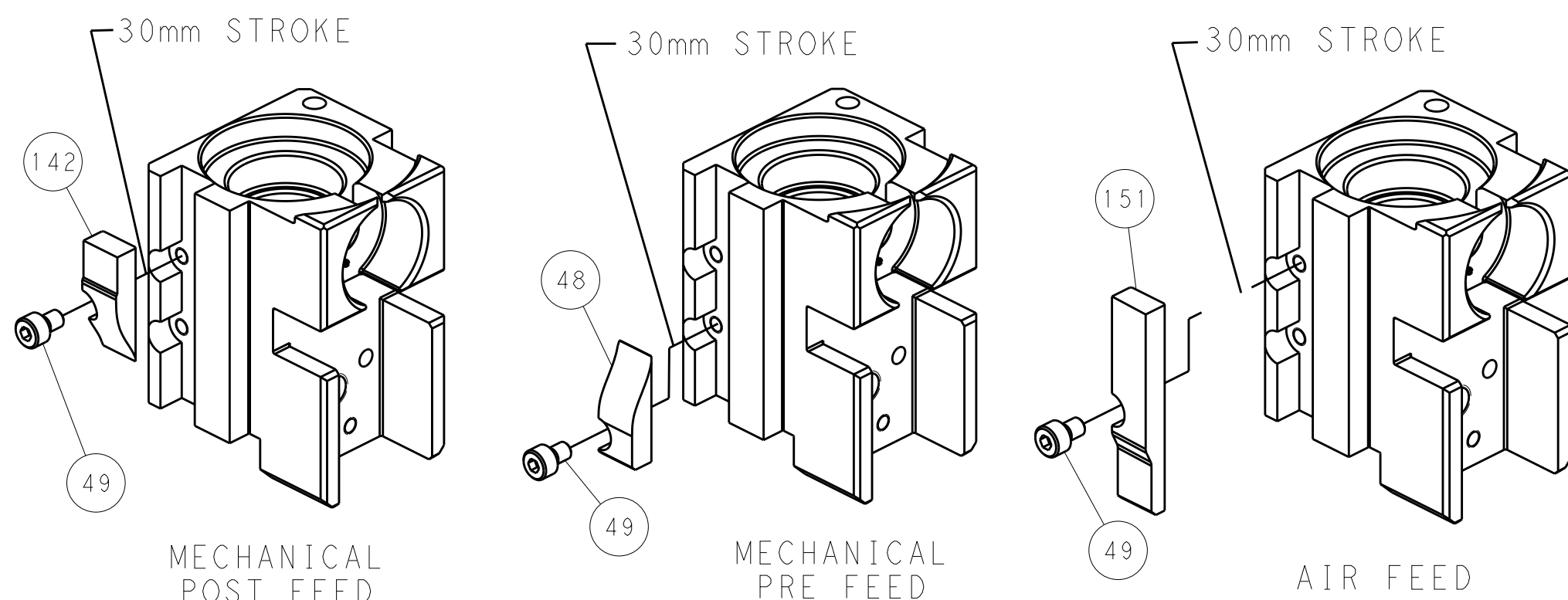
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION

ITEM 30 LOCATED AT
FRONT HOLES

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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		S. ZOU		21JUN2011		TE Connectivity	
mm		0 PLC ±0.5		CHK		T. ELBIN		21JUN2011		Harrisburg, PA 17105-3608	
		1 PLC ±0.13		APVD		S. XI		21JUN2011		NAME	
		2 PLC ±0.013								Ocean Side Feed	
		3 PLC ±0.001								Applicator	
		4 PLC ±0.0001									
MATERIAL		FINISH		WEIGHT		SIZE		CAGE CODE		DRAWING NO	
						A1		00779		2151132	
										RESTRICTED TO	
										CUSTOMER ACCESSIBLE PRODUCTION DRAWING	
										SCALE	
										1:2	
										SHEET	
										4	
										OF	
										4	
										REV	
										A	

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