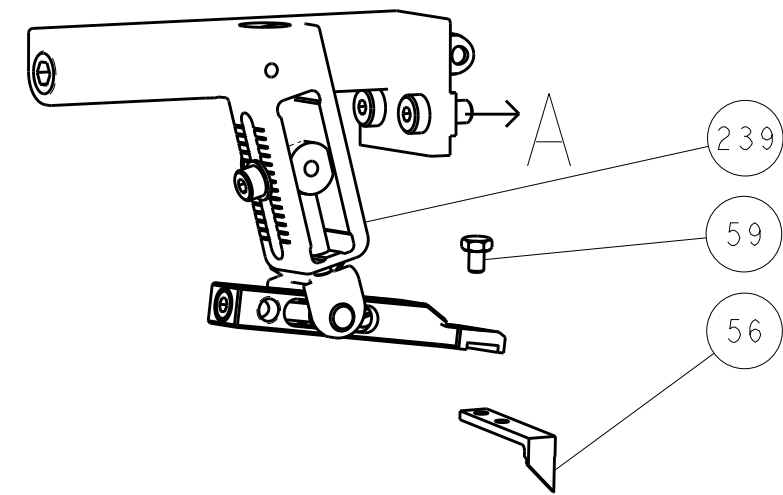
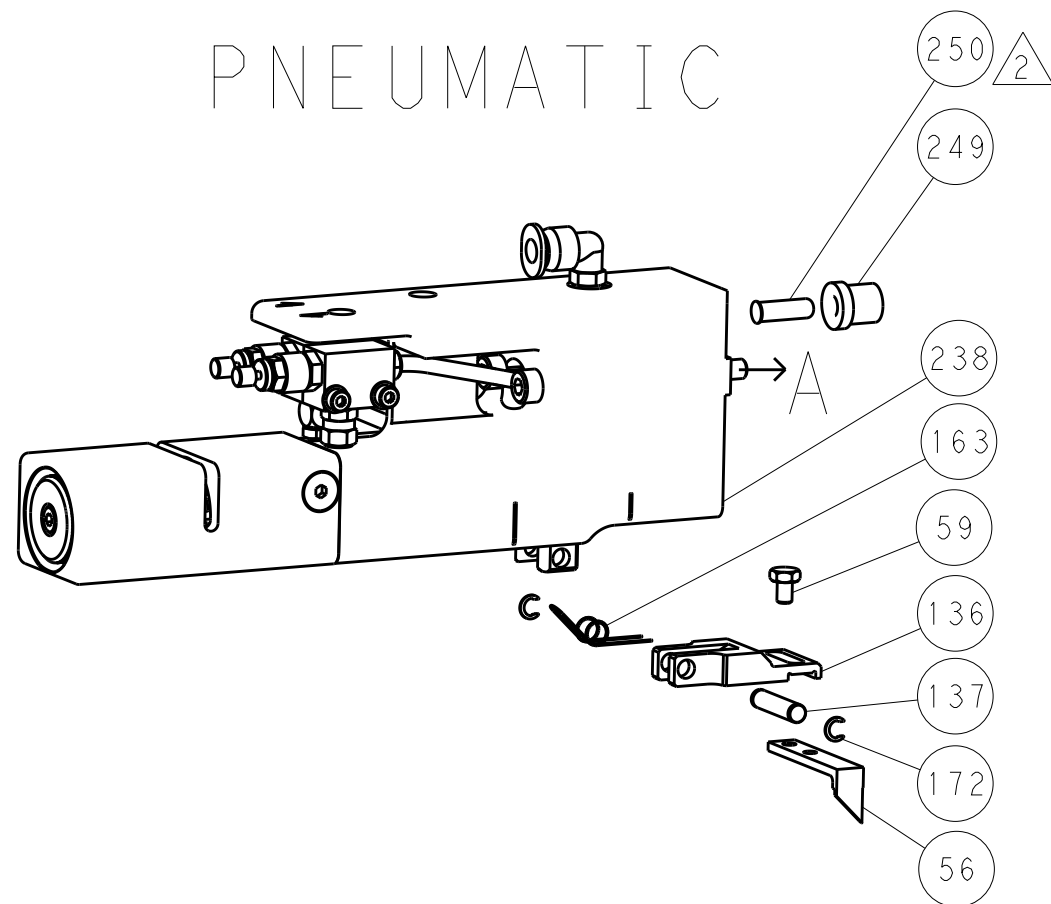


LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

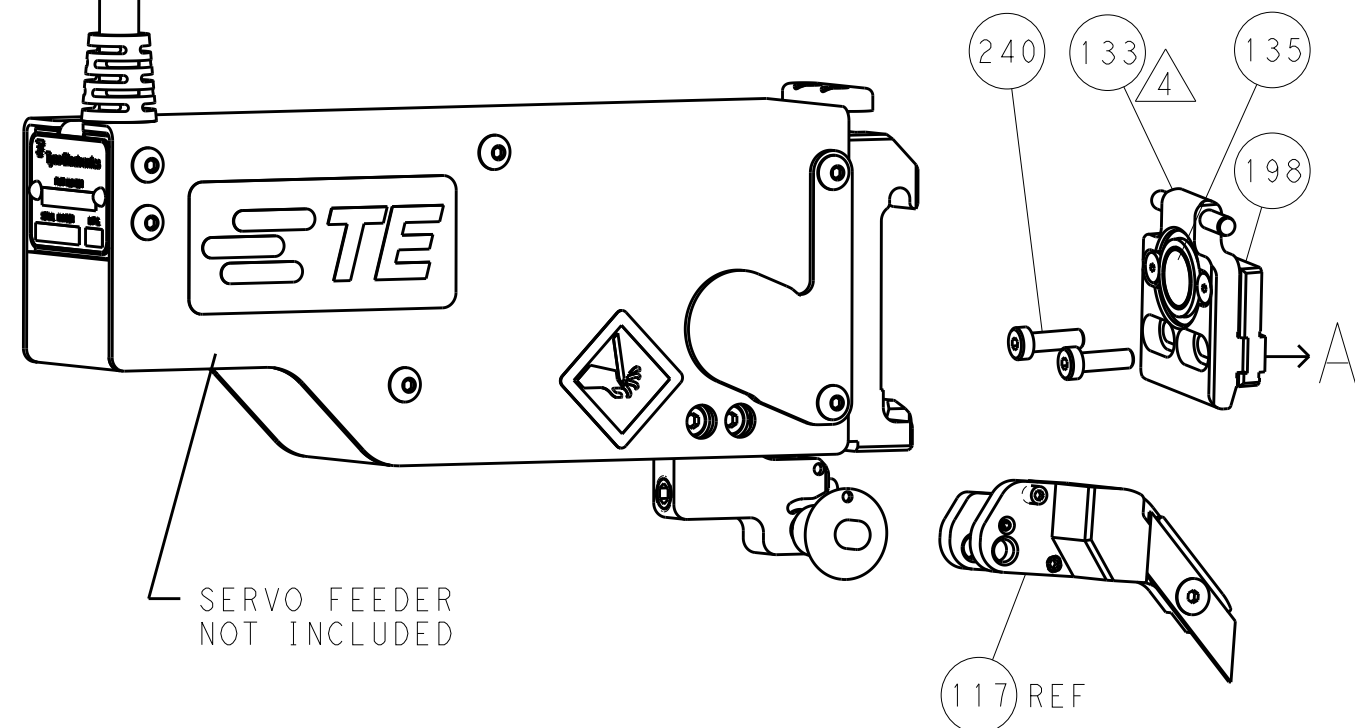
FEED TYPE
MECHANICAL



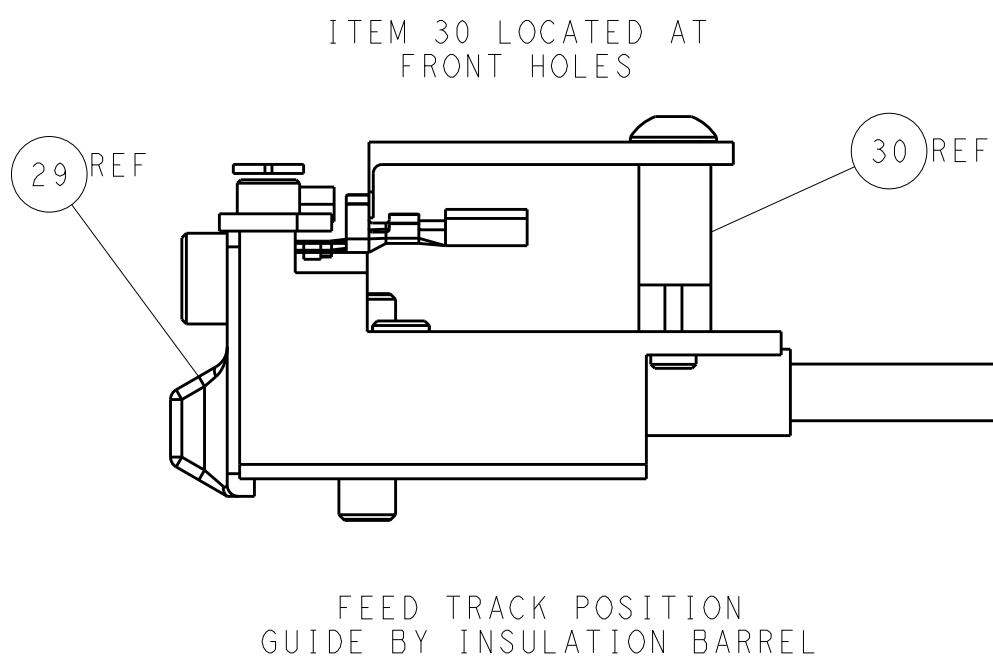
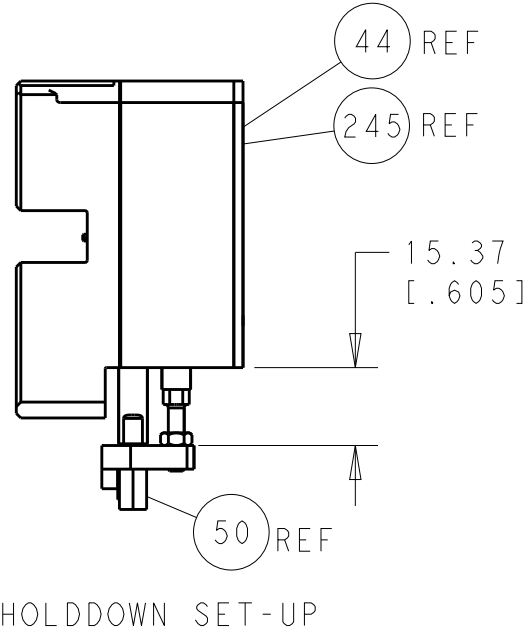
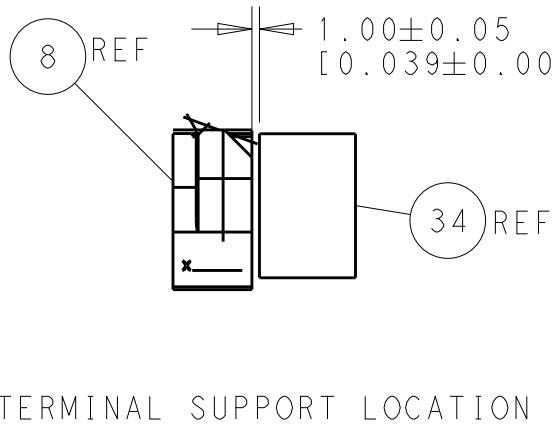
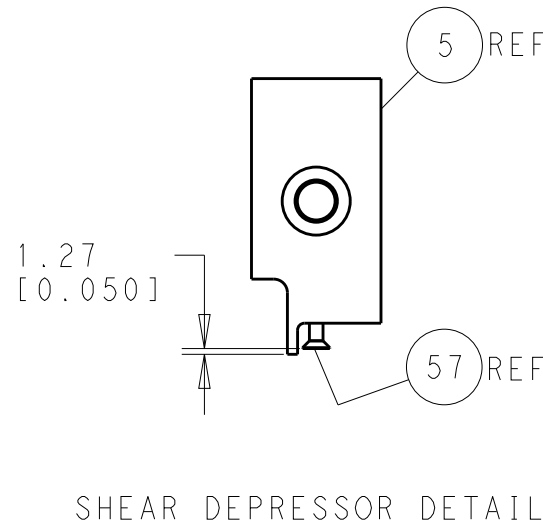
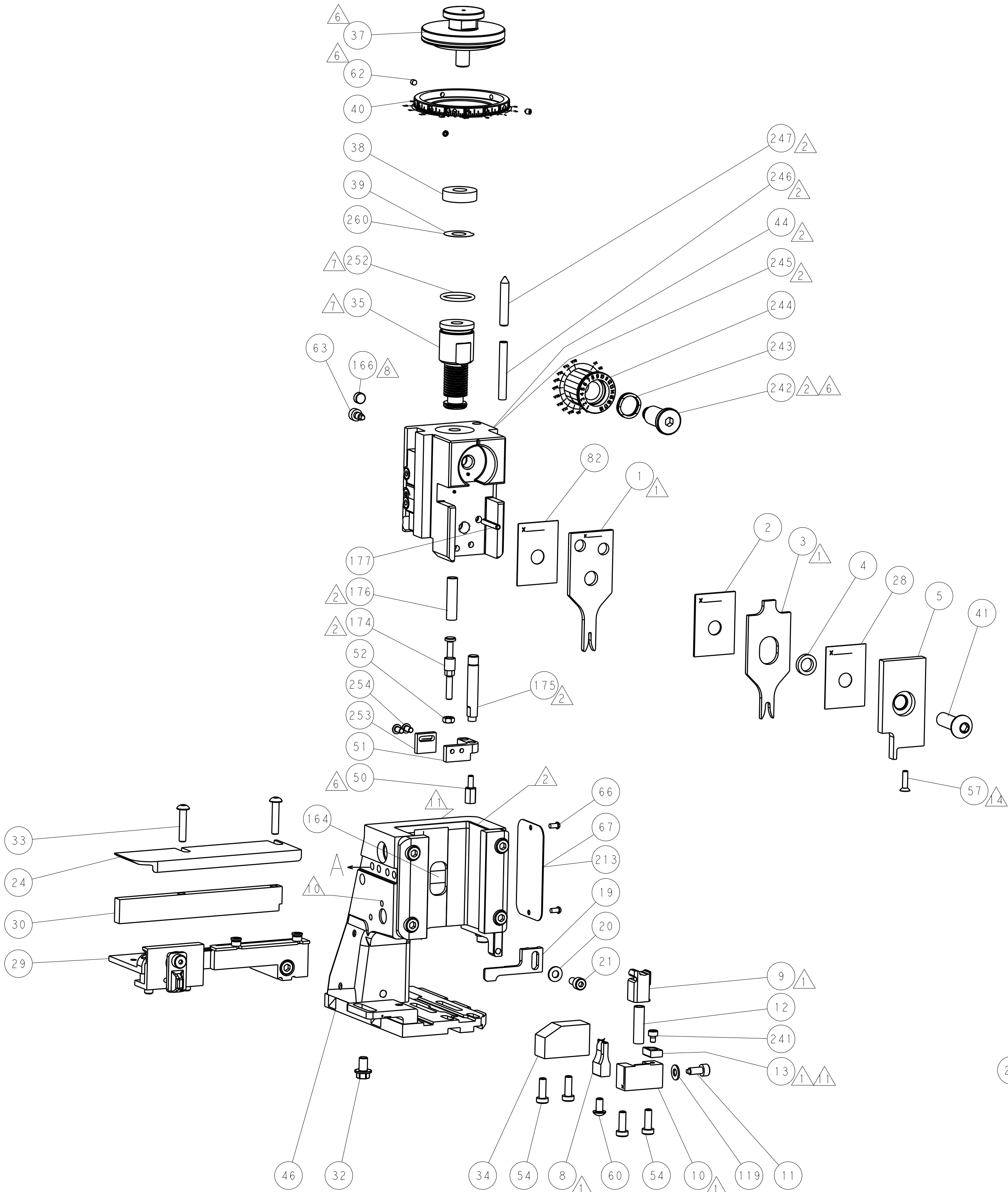
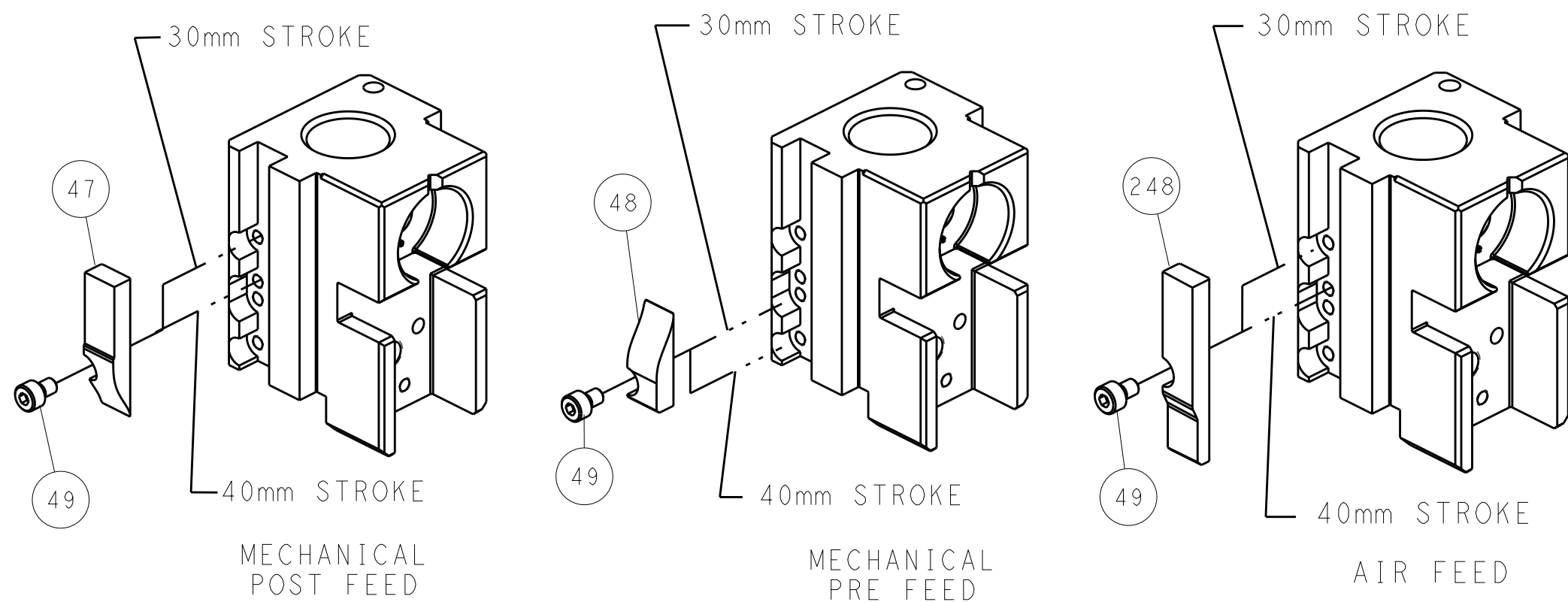
PNEUMATIC



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		TE Connectivity	
mm		0 PLC ±.5		S. ZOU		Harrisburg, PA 17105-3608	
		1 PLC ±0.13		C. ELBIN			
		2 PLC ±0.13		S. X1			
		3 PLC ±0.013		APVD			
		4 PLC ±0.0001		PRODUCT SPEC			
		FINISH		APPLICATION SPEC			
MATERIAL		WEIGHT		SIZE		RESTRICTED TO	
		< select from list >		A1		00779 ©=2151041	
				SCALE		1:2	
				SHEET		2 of 4	
				REV		D	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151041-1	D	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	-	8-2151041-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151041-4	-	-	-
	2-2151041-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151041-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151041-4	-	-	-
	2-2151041-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	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
	2-2151041-7	D	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151041-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.27 mm [.050]	F
INSUL	3.05 mm [.120]	O
APPLICATOR INSTRUCTIONS 408-10135		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 1.2 LL SWS			
WIRE STRIP LENGTH 3.50-3.52 mm [.138-.138 IN]			INSULATION DIAMETER RANGE Ø1.10-1.75 mm [.043-.069 IN]
TERMINAL APPLICATION SPECIFICATION	114-18464	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1452665-1	1452665-2	967067-1 	967067-2 
1452665-3	7-1452665-1	963142-2 	
7-1452665-2	7-1452665-3		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
0.35mm2		0.84+/-0.03 [.033+/-0.001]		7.7
22AWG		0.83+/-0.03 [.033+/-0.001]		7.8
0.25mm2		0.78+/-0.03 [.031+/-0.001]		8.3
24AWG		0.75+/-0.03 [.030+/-0.001]		8.6



- 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: 8-2151041-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151041-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151041-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151041-6
- 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 50, 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.
TO THE SEAL 967067-2,INSULATION RANGE IS Ø1.10-1.40 [.043 - .055 IN.]
TO THE SEAL 967067-1,INSULATION RANGE IS Ø1.40-1.75 [.055 - .069 IN.]
TO THE SEAL 963142-2,INSULATION RANGE IS Ø1.10-1.30 [.043 - .052 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 DUE TO THE DEMANDS OF APPLICATION SPEC 114-18464 IT IS IMPORTANT, IF THE ANVIL IS MOVED OR REPLACED, THAT IT IS BAISED TOWARDS THE OPERATORS POSITION AS FOR AS POSSIBLE WHEN RESCUING TO THE BASE PLATE.

-	2	2	2	2	1655785-9	SCR, BTN SKT HD CAP (M3 X 6)	254
-	1	1	1	1	1-1976053-3	LOCATER BLOCK,TERMINAL	253
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-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)

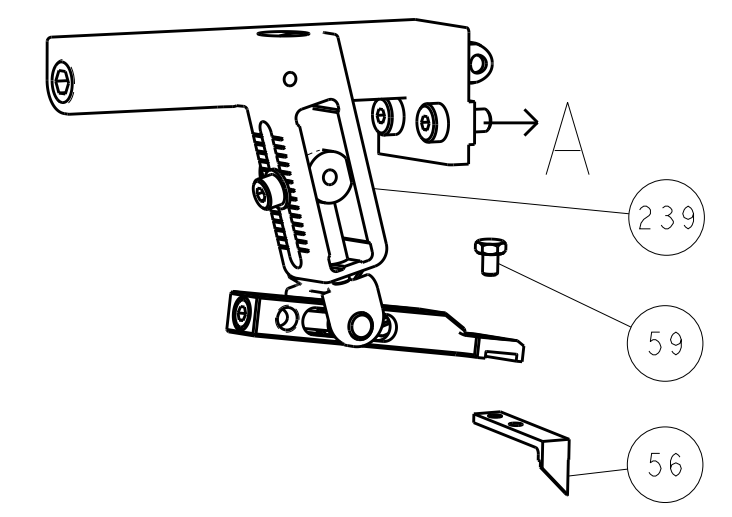
SET UP GAUGE 2119599-1	LOC A	DIS 66	REVISIONS					
			P	LTR	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-4	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	9931111-1	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	1	1	985575-4	SCR, FLT SKT HD CAP M3 X 12.0	57
-	-	-	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	1-1901681-0	HOLDDOWN, TERMINAL	51
-	1	1	1	1	2-1752354-0	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	2119644-1	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	1-1320908-0	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-2	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	318707-9	FLOATING SHEAR, FRONT	9
-	1	1	1	1	3-1333225-9	ANVIL, COMBINATION	8
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-4	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1633965-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-9	SPACER, CRIMPER	2
-	1	1	1	1	1-1673600-0	CRIMPER, WIRE	1

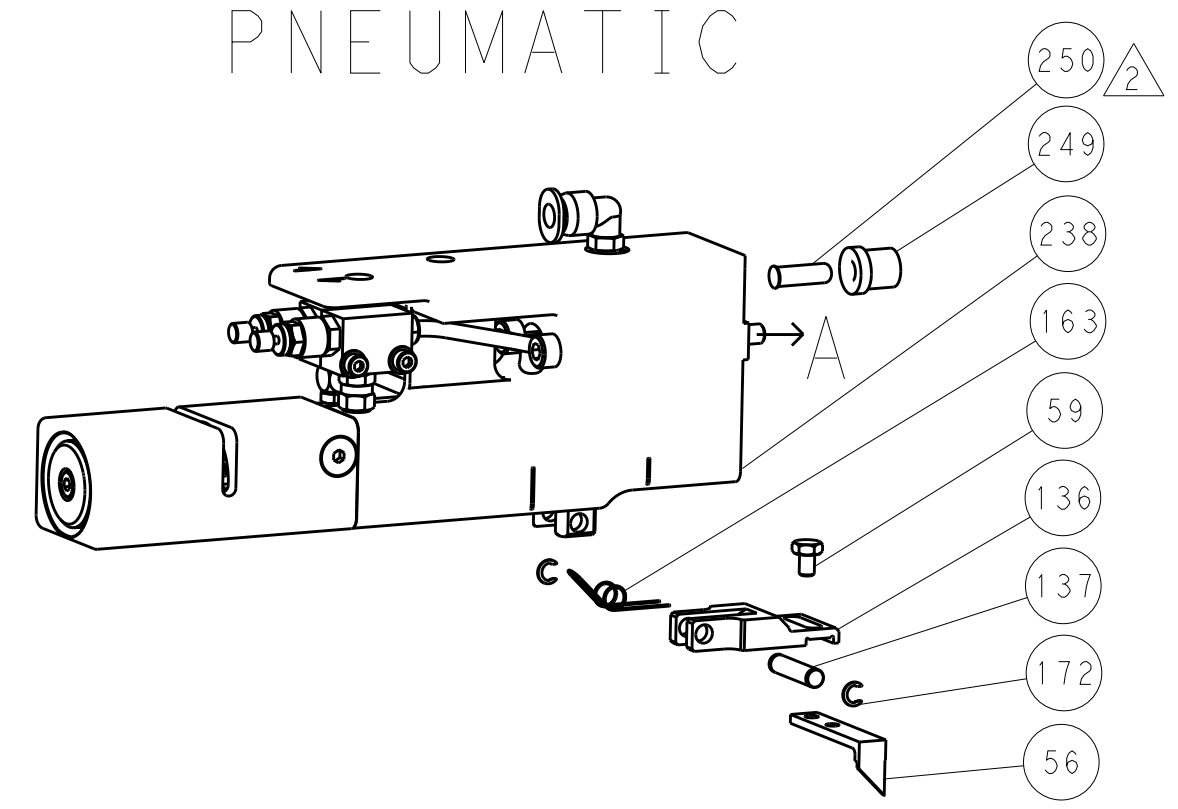
THIS DOCUMENT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE CONTACTED FOR THE LATEST REVISION.				OWN S.ZOU	11MAR2011	 TE Connectivity Harrisburg, PA 17105-3608				
				CHK T.ELBIN	11MAR2011					
DIMENSIONS: mm						APVD S.XI	11MAR2011	NAME Ocean Side Feed Applicator		
						PRODUCT SPEC				
				APPLICATION SPEC						
MATERIAL -				WEIGHT -		SIZE A1		CAGE CODE 00779	DRAWING NO C=2151041	RESTRICTED TO -
< select from list >						SCALE 1:2		SHEET 3 of 4	REV D	

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

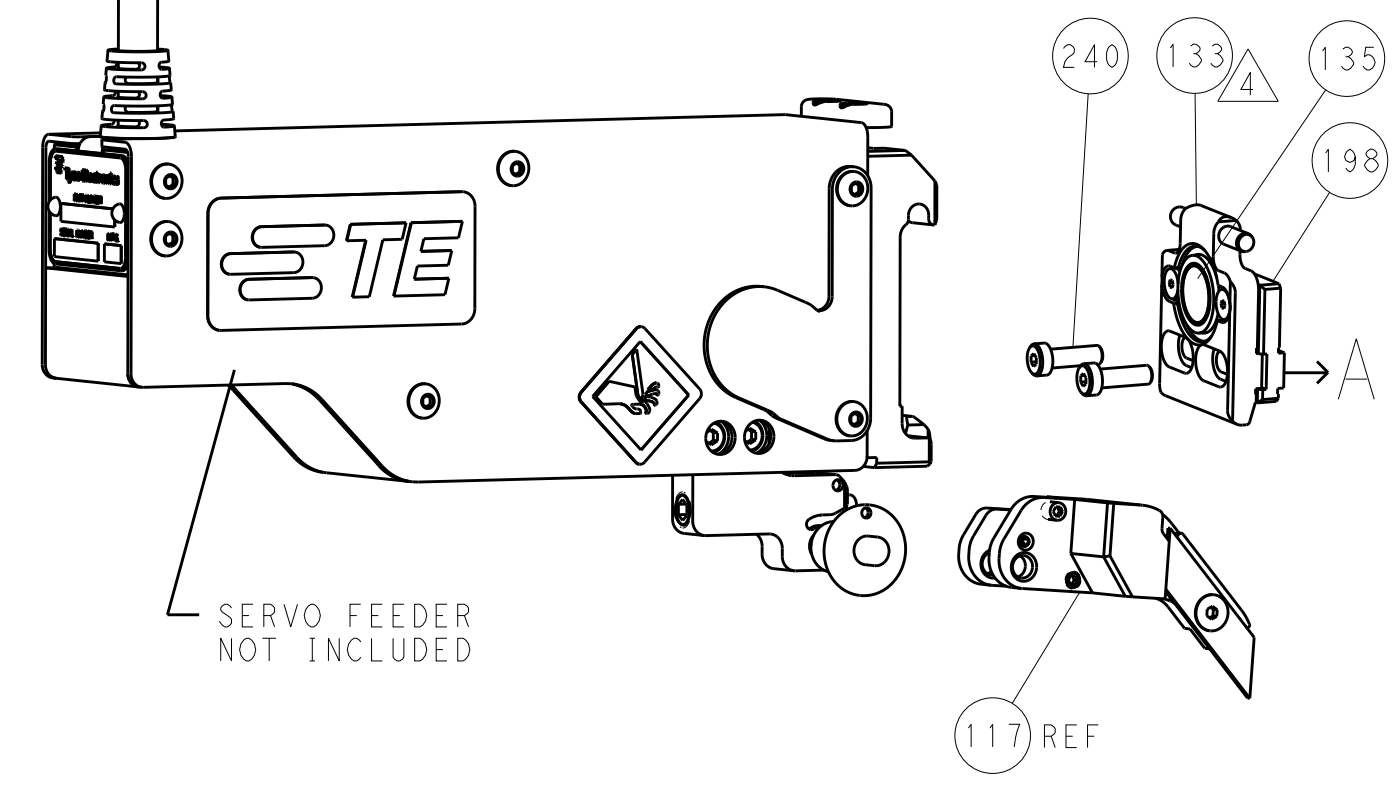
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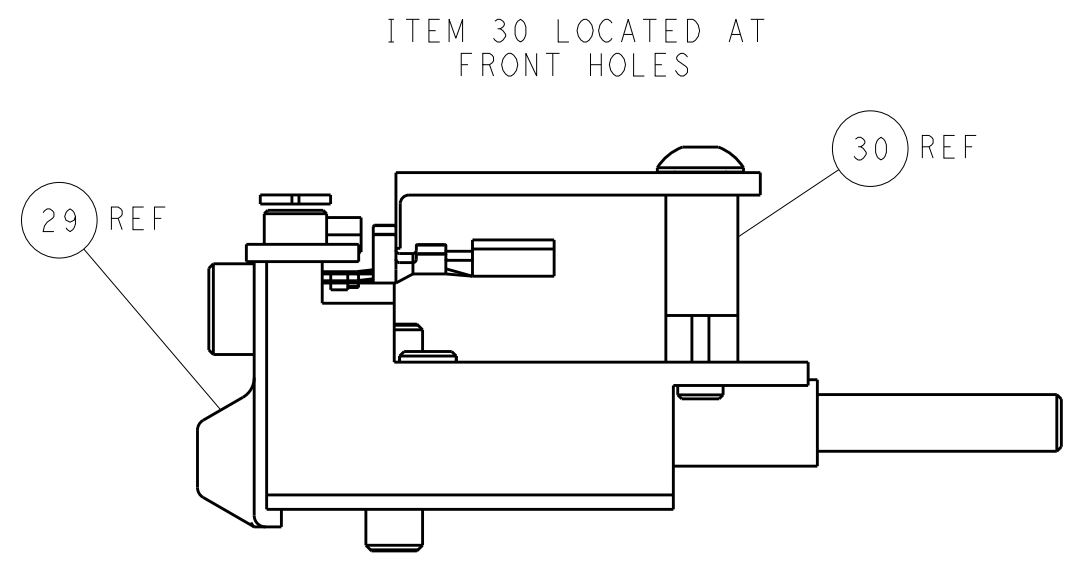
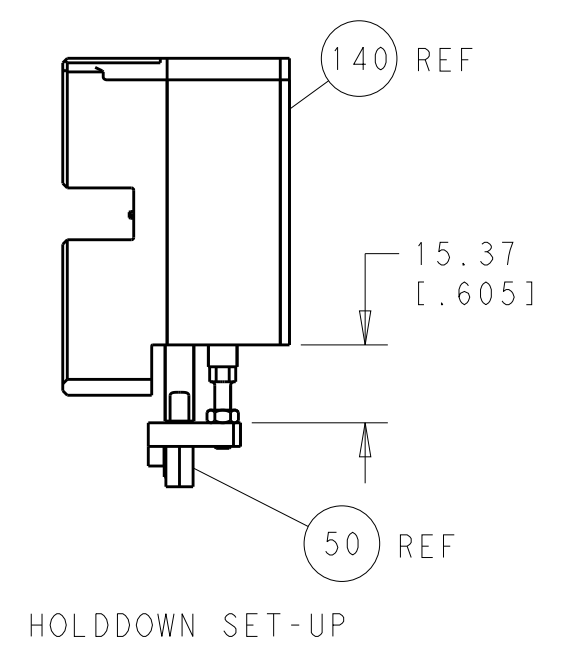
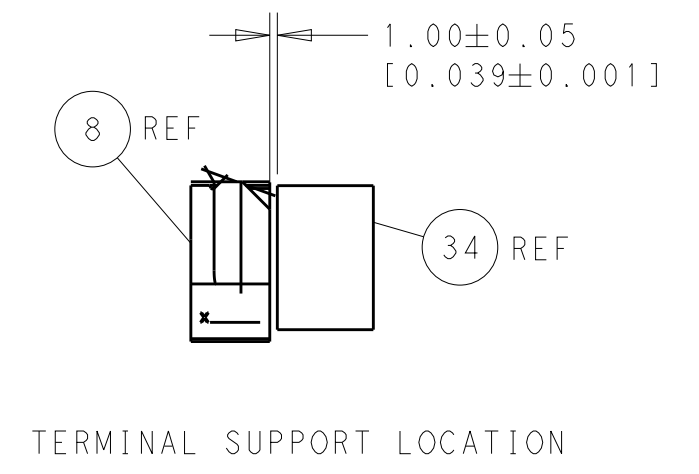
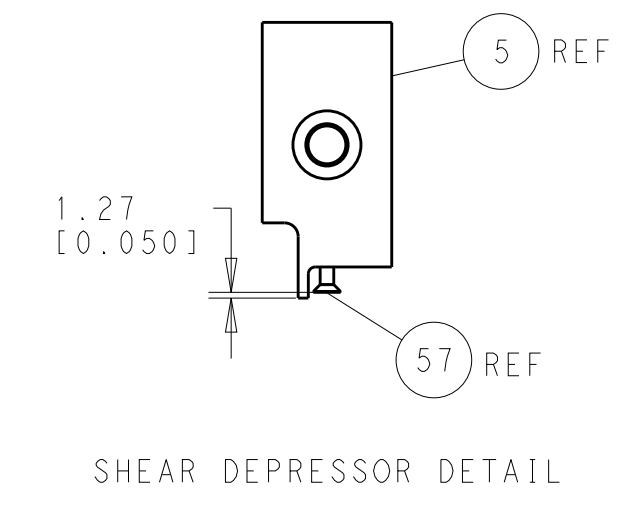
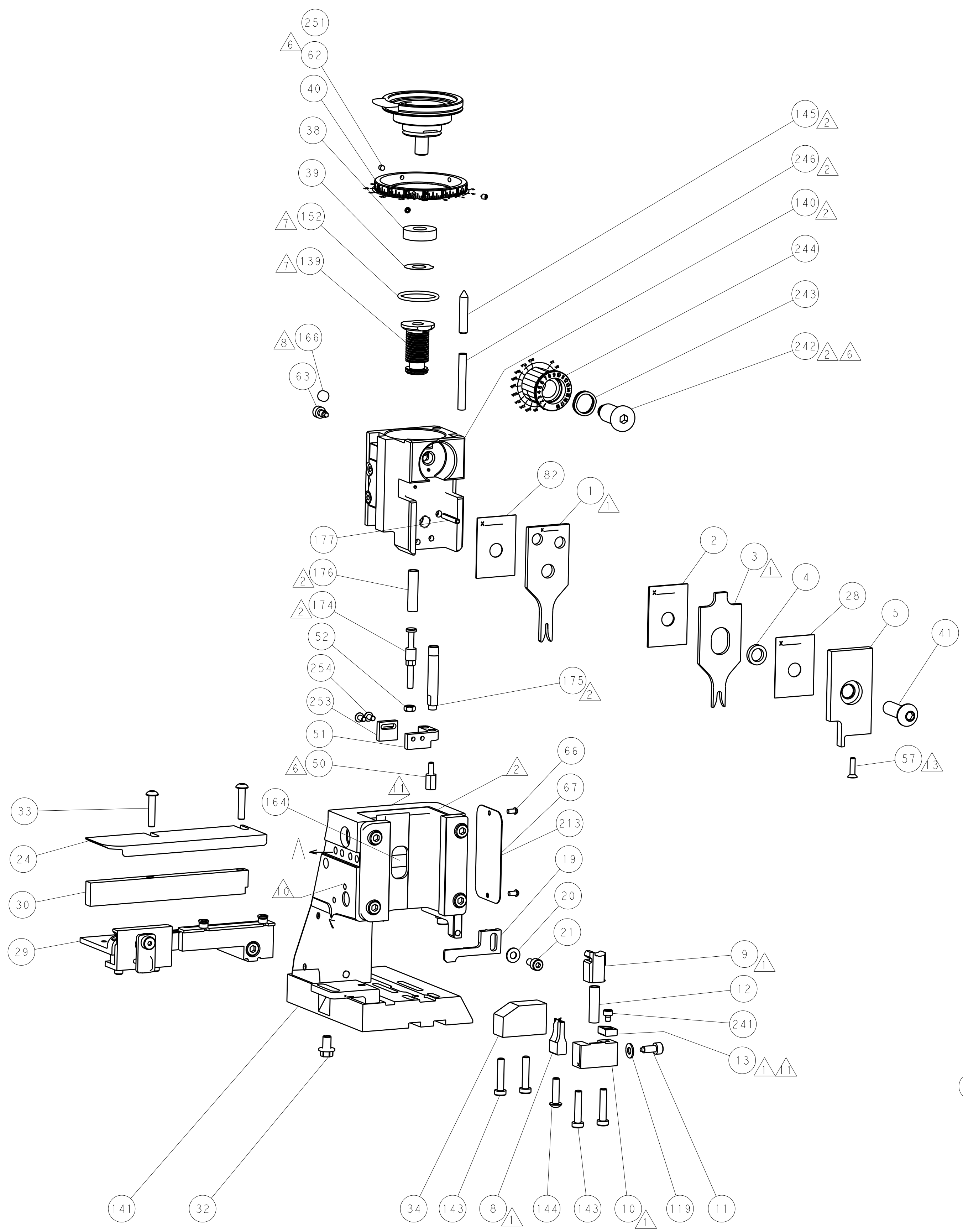
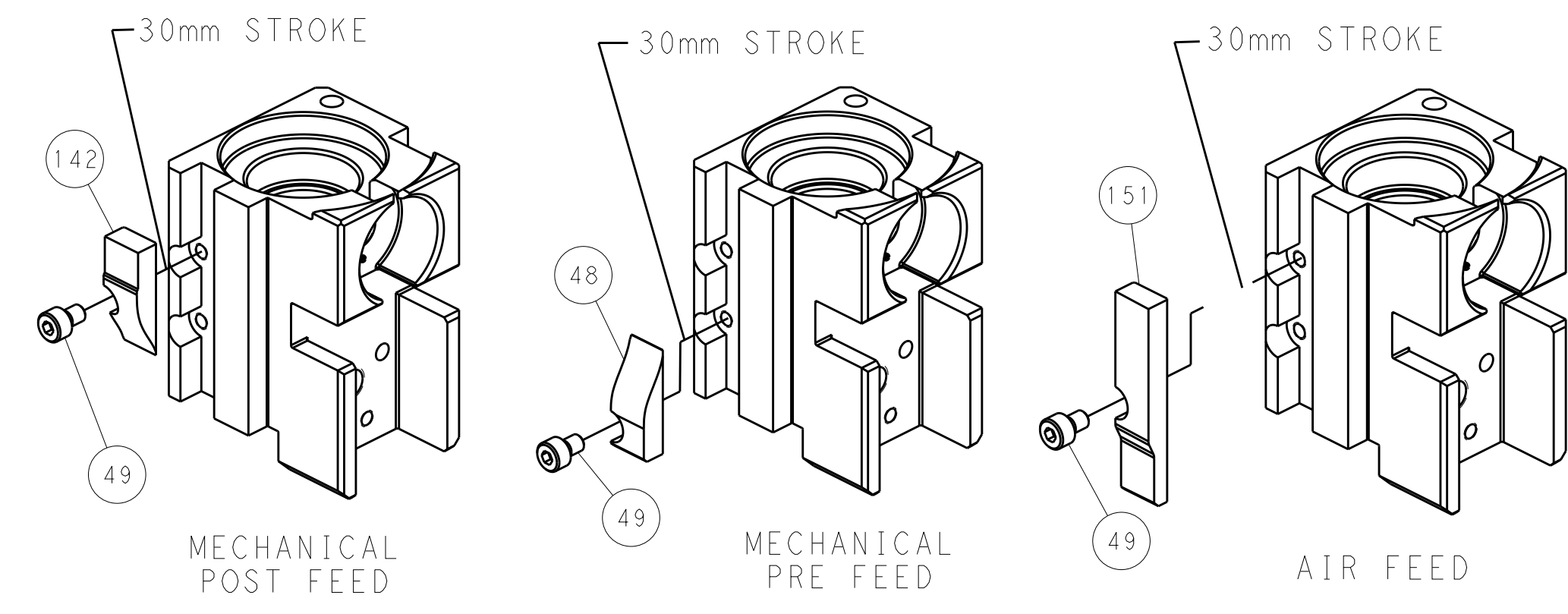
PNEUMATIC



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 11MAR2011		CHK T. ELBIN 11MAR2011		APVD S. XI 11MAR2011		NAME Ocean Side Feed Applicator	
mm		0 PLC ±.5		PRODUCT SPEC		APPLICATION SPEC		SIZE A1		CAGE CODE 00779	
MATERIAL		FINISH		WEIGHT		DRAWING NO C=2151041		RESTRICTED TO		SCALE 1:2	
						SHEET 4 OF 4		REV D			

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