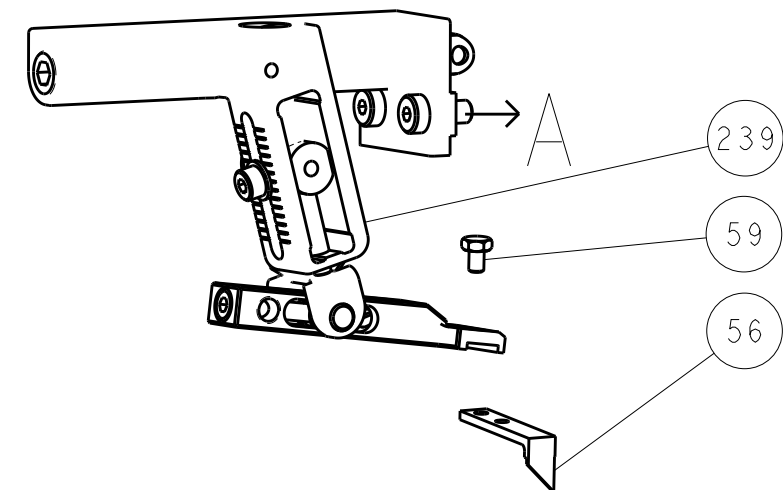
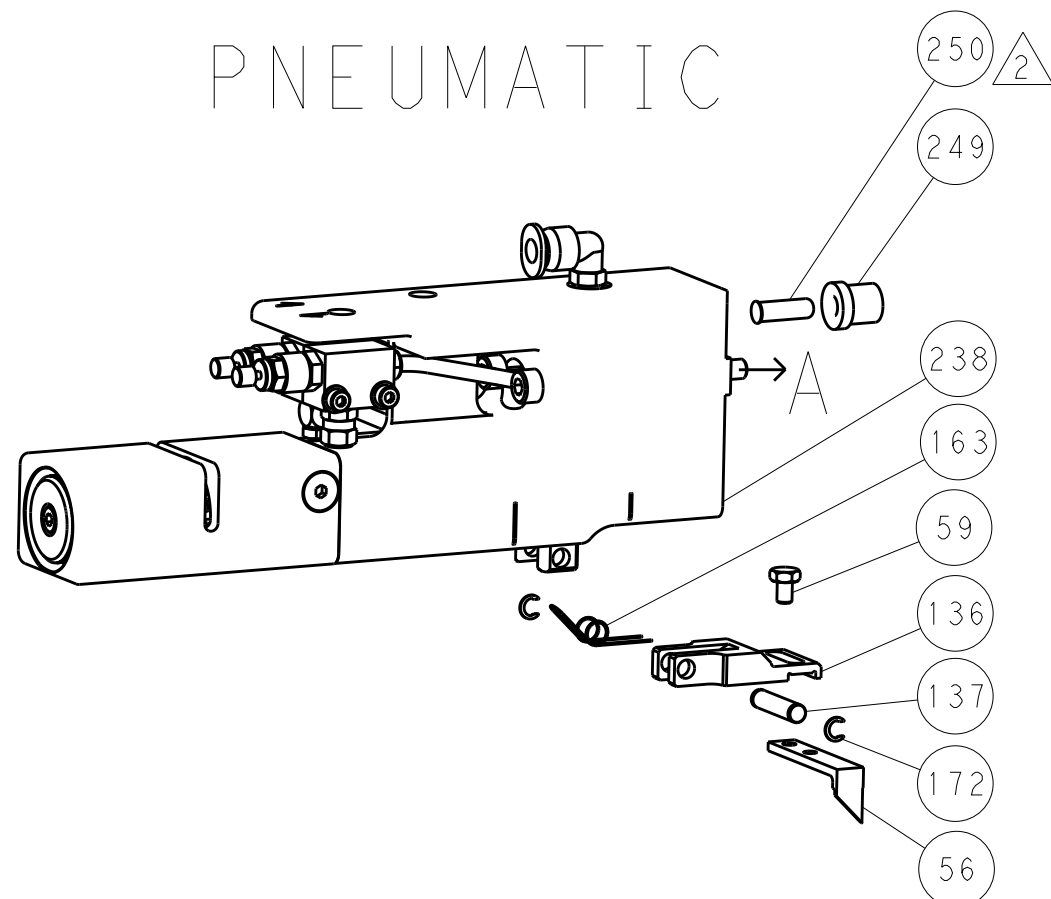


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A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-		SEE SHEET 1	-	-	-

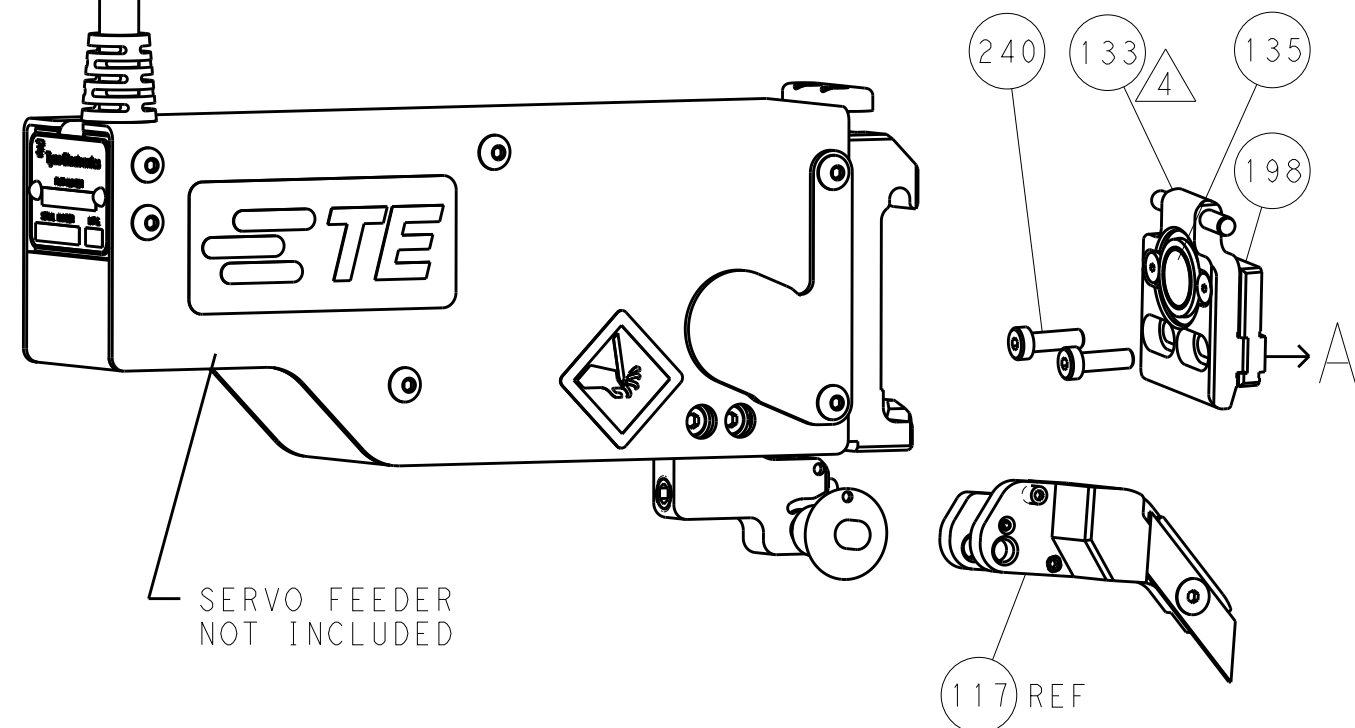
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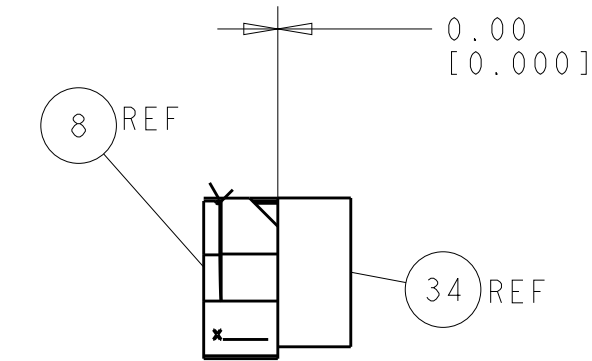
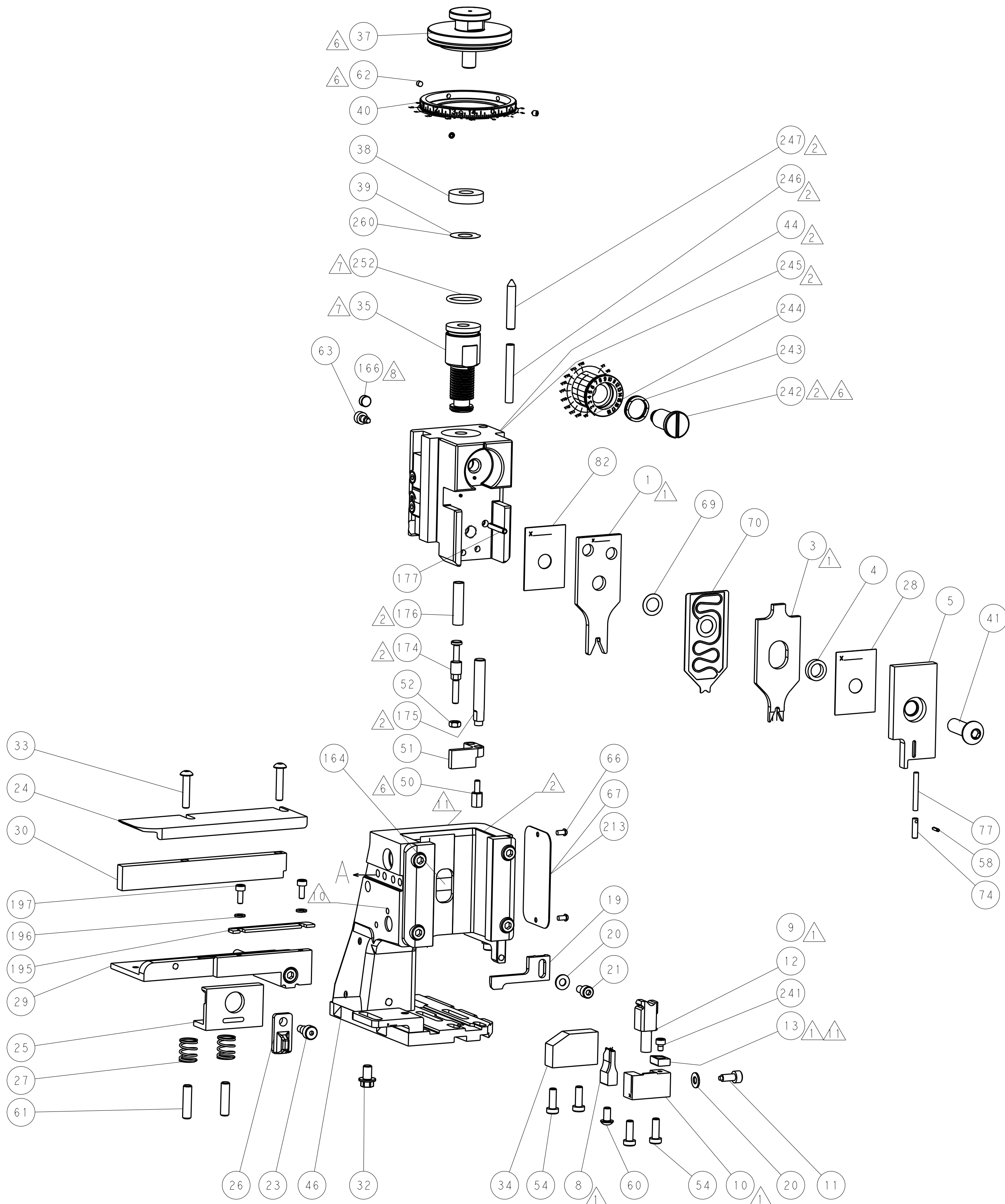
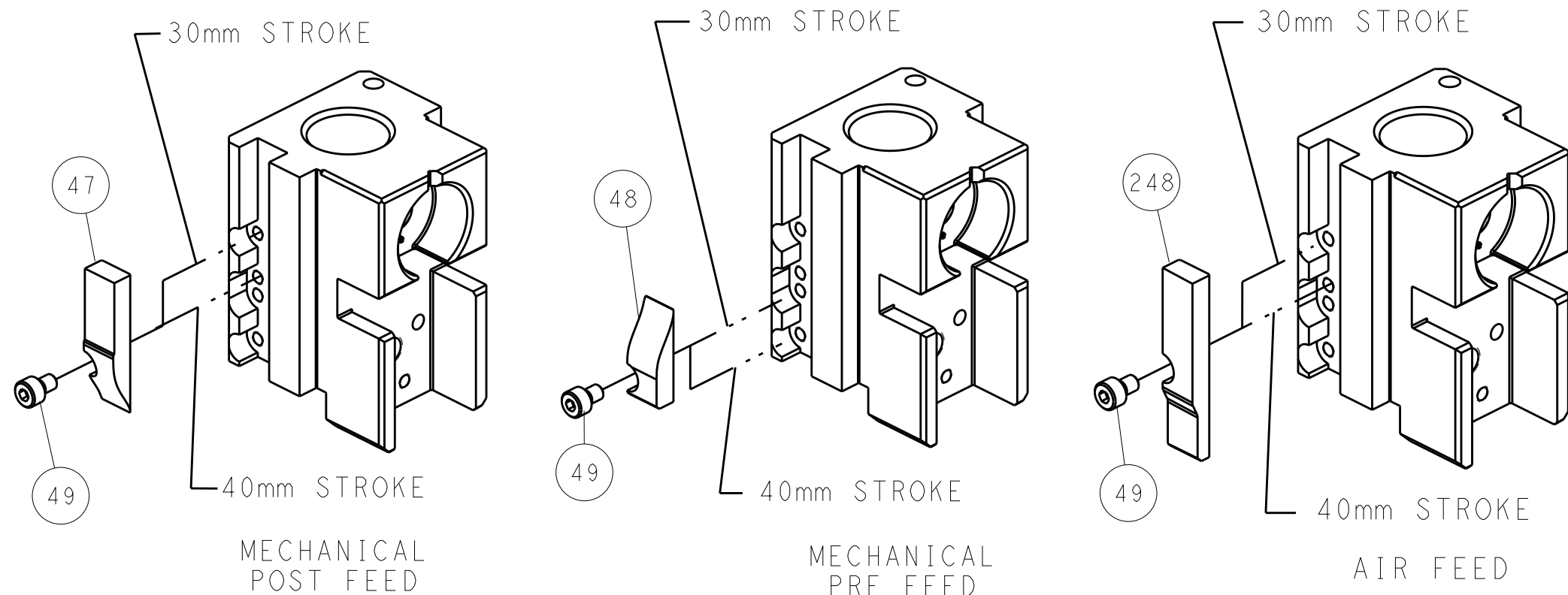
PNEUMATIC



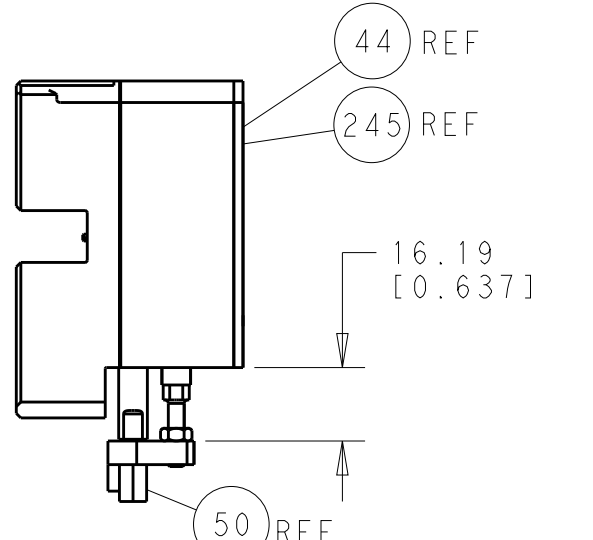
SERVO
LATCH PLATE



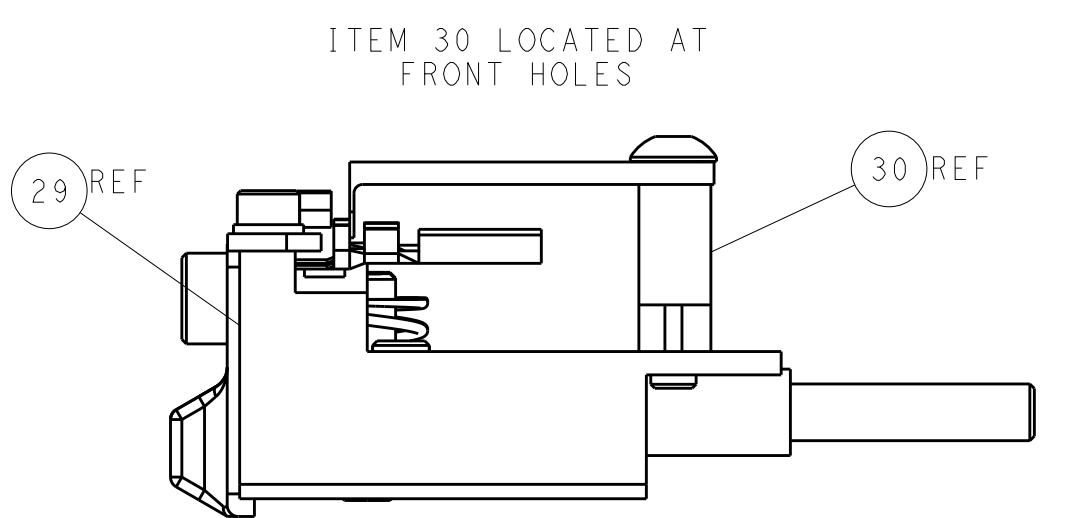
CAM POSITIONS



TERMINAL SUPPORT LOCATION

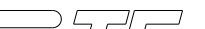


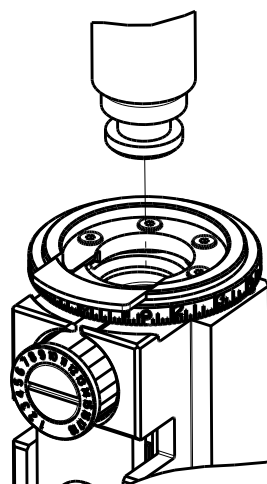
HOLDDOWN SET-UP



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING MUST BE CONTACTED FOR THE LATEST REVISION.		DWN	Y. YIN		25AUG2011				TE Connectivity		Harrisburg, PA 17105-3608		
DIMENSIONS:		CHK	G. BAILEY		25AUG2011		NAME		Ocean Side Feed				
mm		APVD	S. XI		25AUG2011		PRODUCT SPEC		Applicator				
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		APPLICATION SPEC		SIZE		CAGE CODE		DRAWING NO		RESTRICTED TO	
0 PLC		±0.5				A1		00779		©=2151073		-	
1 PLC		±0.13											
2 PLC		±0.13											
3 PLC		±0.013											
4 PLC		±0.0001											
ANGLES		FINISH		WEIGHT									
MATERIAL													
-													

8		7		6		5		4		3	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151073-1	C	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	-	8-2151073-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151073-4	-	-	-
	2-2151073-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151073-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151073-4	-	-	-
	2-2151073-5	C	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
	2-2151073-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2151073-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	2.79 mm [.110]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPEC	
TERMINAL NAME: 3L SIZE DYNAMIC D-3 RECEPTACLE			
WIRE STRIP LENGTH 4.30-5.30 mm [.169-.209 IN]		INSULATION DIAMETER RANGE Ø3.10-3.40 mm [.122-.134 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5148	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
353715-2	1-353715-3	353716-3	1-353716-5
353715-3	1-353715-5	1-353716-2	
1-353715-2	353716-2	1-353716-3	

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
14 AWG OR 2.20mm2			1.68+/-0.05 [1.066+/- .002]		9.4
16 AWG OR 1.25mm2			1.45+/-0.05 [1.057+/- .002]		11.9



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: 8-2151073-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151073-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151073-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151073-6
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 & 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.

-	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
-	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	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
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

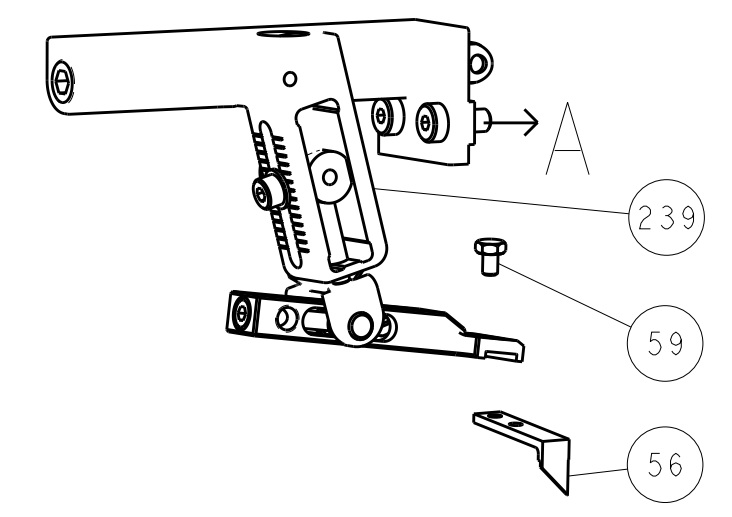
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

2				1					
SET UP GAUGE 2119599-1				LOC A	DIST 66	REVISIONS			
P		LTR		DESCRIPTION		DATE	DWN	APVD	
	-		SEE SHEET 1			-	-	-	
-	1	-	-	1901094-3	SPACER, FEEDER			198	
2	2	2	2	4-1655316-4	SCR, SKT HD CAP, M3 X 8.0			197	
2	2	2	2	18026-1	WASHER, SPRG LOCK, REG M3			196	
1	1	1	1	690438-1	FRONT STRIP GUIDE			195	
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	
-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF			117	
1	1	1	1	455888-5	SPACER, CRIMPER			82	
1	1	1	1	5-547505-2	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	1	2119943-1	WASHER, SPACER			69	
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	
2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0			61	
-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0			59	
1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250			58	
-	-	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	1901681-1	HOLDDOWN, TERMINAL			51	
1	1	1	1	1-1752354-7	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	2119644-2	RAM WASHER, PRECISION			38	
1	1	1	1	1-1752356-9	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	2119959-3	ASSEMBLY, STRIP GUIDE			29	
1	1	1	1	455888-3	SPACER, CRIMPER			28	
2	2	2	2	22283-1	SPRING, COMPRESSION			27	
1	1	1	1	356835-1	LEVER, DRAG RELEASE			26	
1	1	1	1	240792-3	DRAG, TERMINAL			25	
1	1	1	1	1320928-2	STRIP GUIDE			24	
1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0			23	
1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0			21	
2	2	2	2	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	1803095-1	FLOATING SHEAR, FRONT			9	
1	1	1	1	3-1333206-9	ANVIL, COMBINATION .100			8	
1	1	1	1	1-2119780-3	DEPRESSOR, SHEAR			5	
1	1	1	1	238011-2	BLOCK, CRIMPER SPACER			4	
1	1	1	1	1-1803019-0	CRIMPER, INSULATION O			3	
1	1	1	1	2-1633860-4	CRIMPER, WIRE			1	
-27	-25	-22	-21	PART NO	DESCRIPTION			ITEM NO	

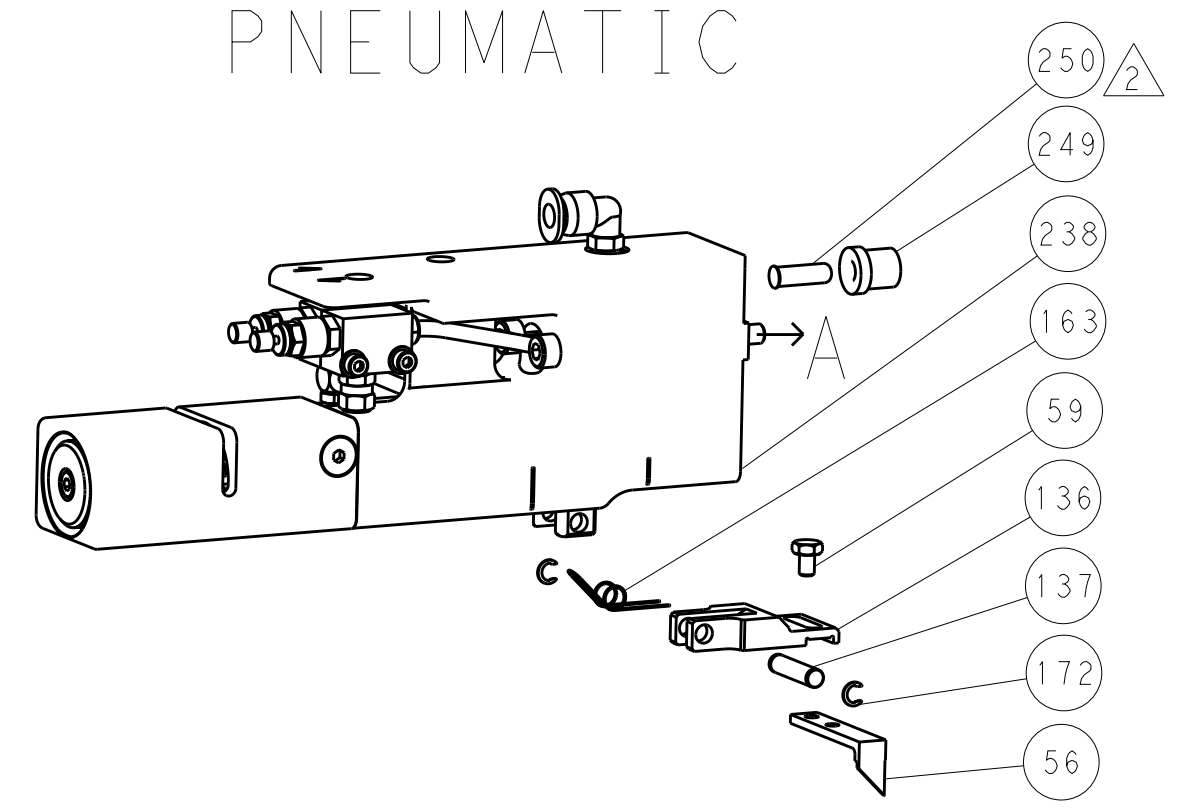
(1) IF PART IS TO BE USED IN THE UNITED STATES, THE FOLLOWING INFORMATION IS REQUIRED: (2) IF THE PART IS TO BE USED OUTSIDE THE UNITED STATES, THE FOLLOWING INFORMATION SHOULD BE CONTACTED FOR THE APPROPRIATE INFORMATION:		DWN 25AUG2011 JIN CHK G.BAILEY 25AUG2011 RYD SVI 25AUG2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
MATERIAL -		APPLICATION SPEC		A 1 00779 C=2151073	
FINISH -		WEIGHT -		RESTRICTED TO -	
Customer Accessible		Drawing		SCALE 1:2 SHEET 3 OF 4 REV C	

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

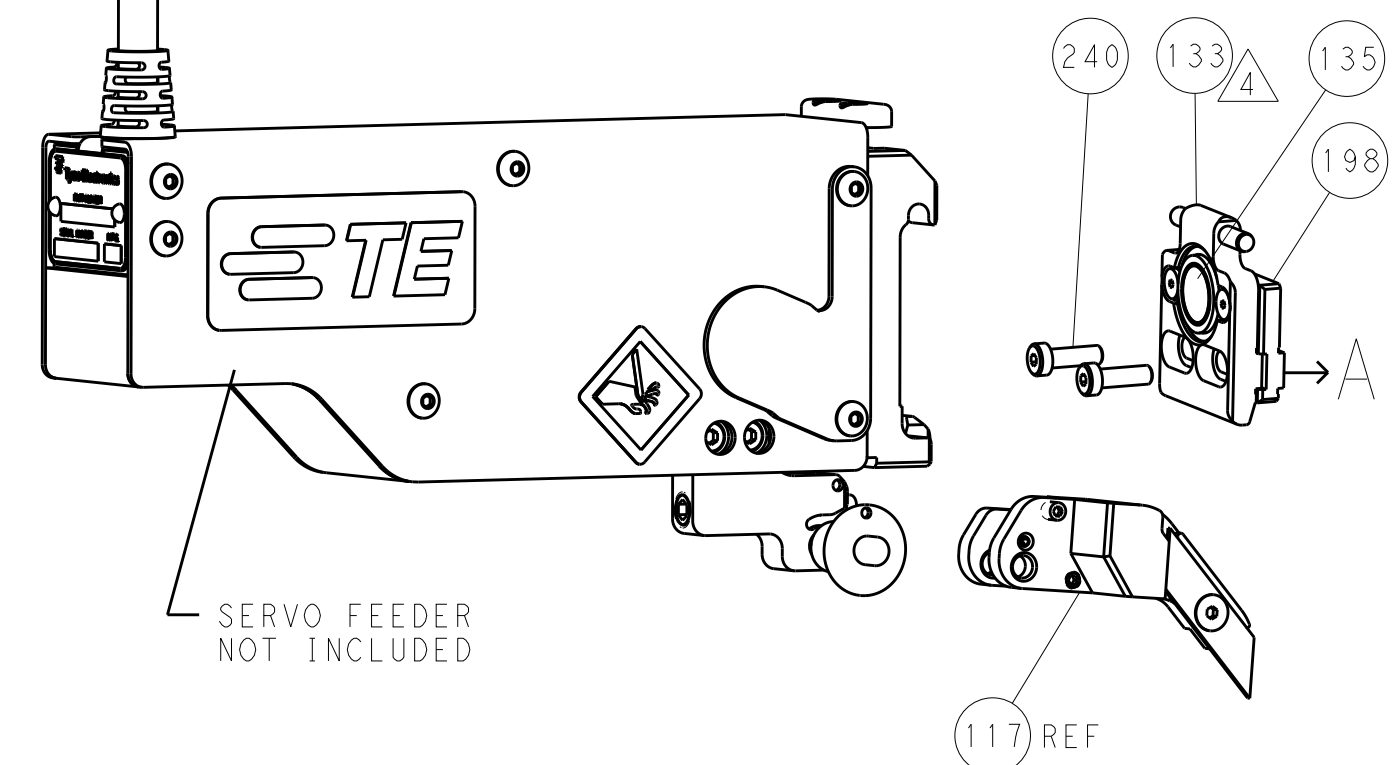
FEED TYPE
MECHANICAL



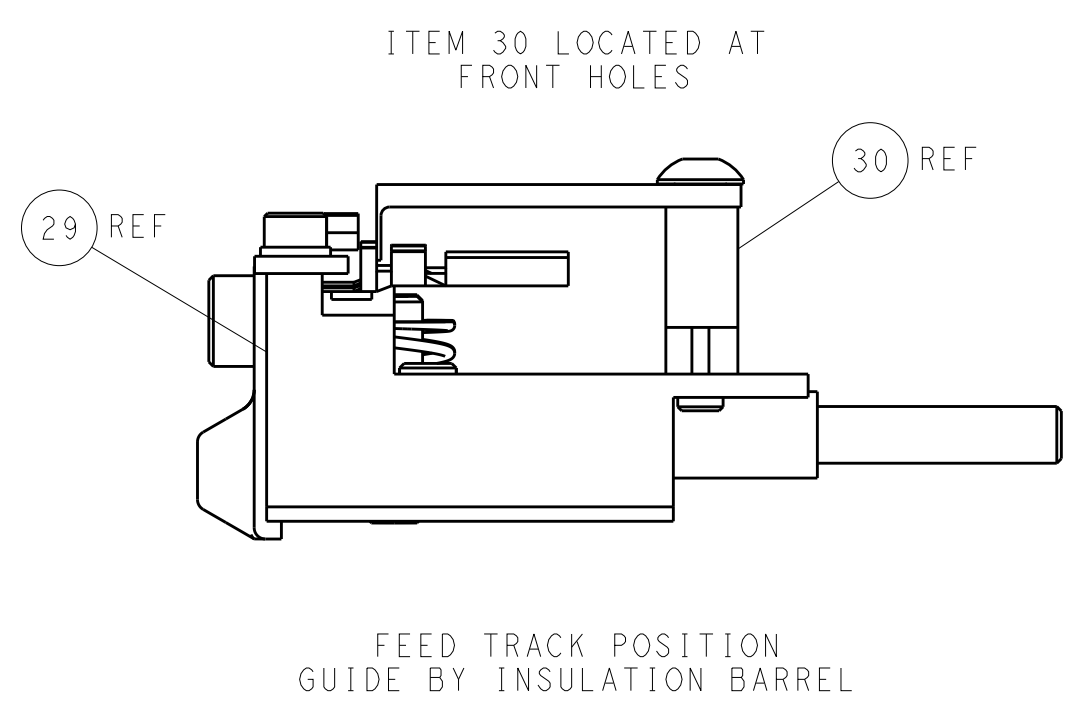
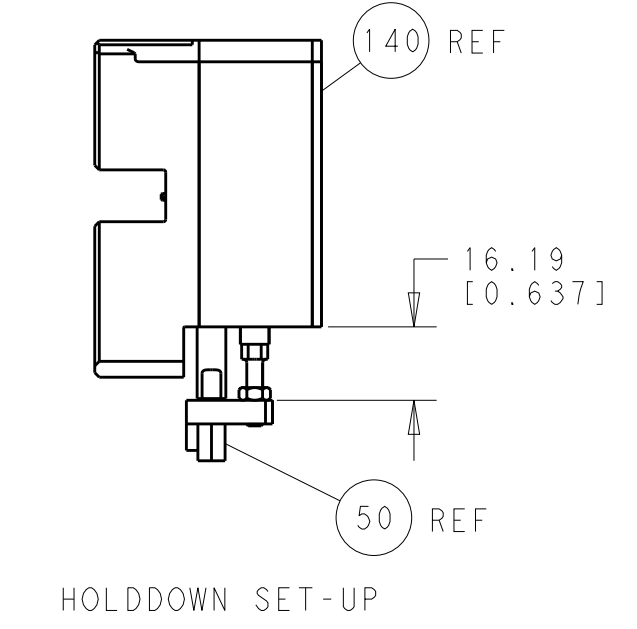
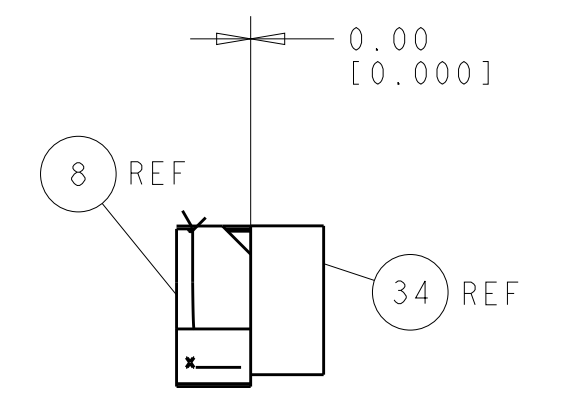
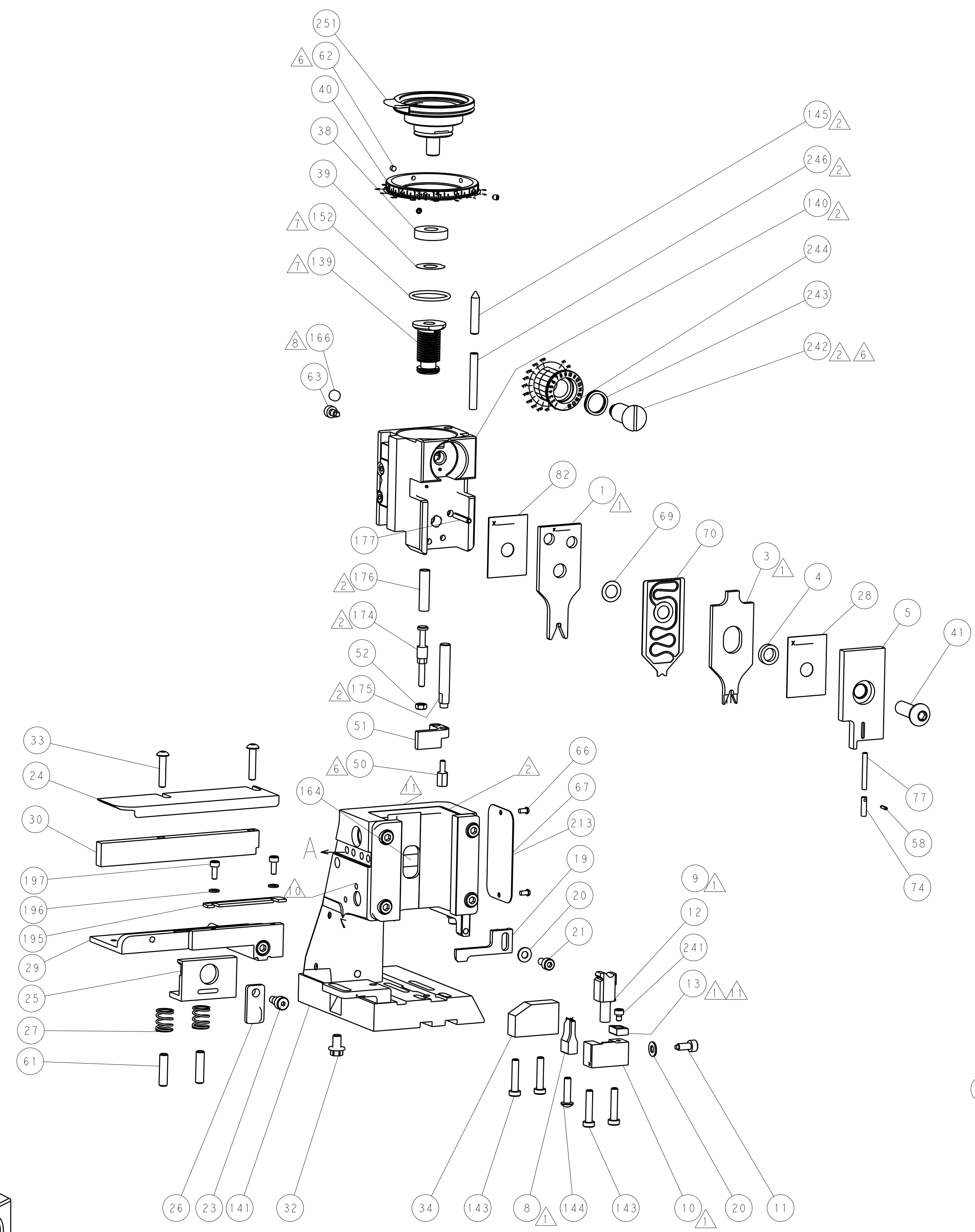
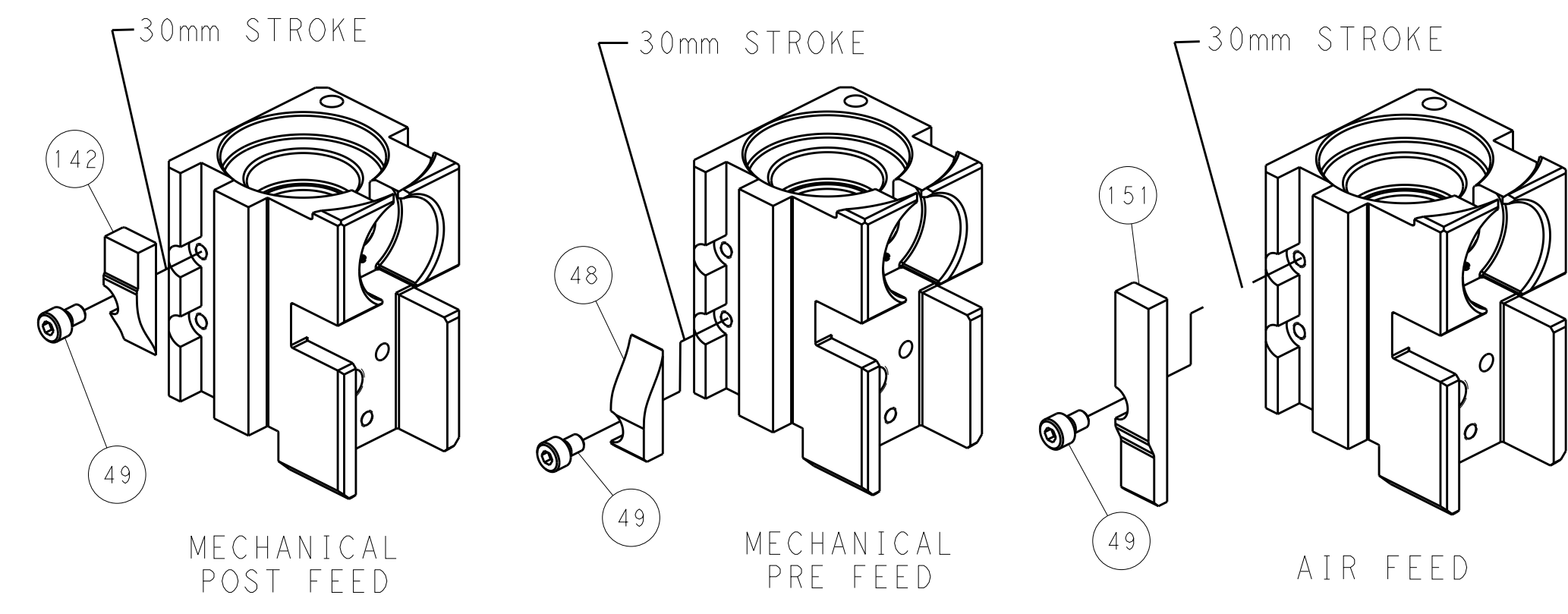
PNEUMATIC



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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TEO ELECTRONICS CORPORATION IT IS SUBJECT TO THE TEO ELECTRONICS CORPORATION POLICY ON DOCUMENTATION AND SHOULD BE CONTROLLED FOR THE LATEST REVISION.				DWN Y. YIN 25AUG2011	 TE Connectivity Harrisburg, PA 17105-3608						
DIMENSIONS: mm				CHK G. BAILEY 25AUG2011							
TOLERANCES UNLESS OTHERWISE SPECIFIED:				APVD S. XI 25AUG2011	NAME						
				PRODUCT SPEC	Ocean Side Feed Applicator -						
				-							
				APPLICATION SPEC							
				-							
MATERIAL				WEIGHT	SIZE		CAGE CODE	DRAWING NO	RESTRICTED TO		
FINISH				-	A1		00779	C-2151073	-		
				Customer Accessible Production Drawing				SCALE	1:2	SHEET 4 OF 4	REV C

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