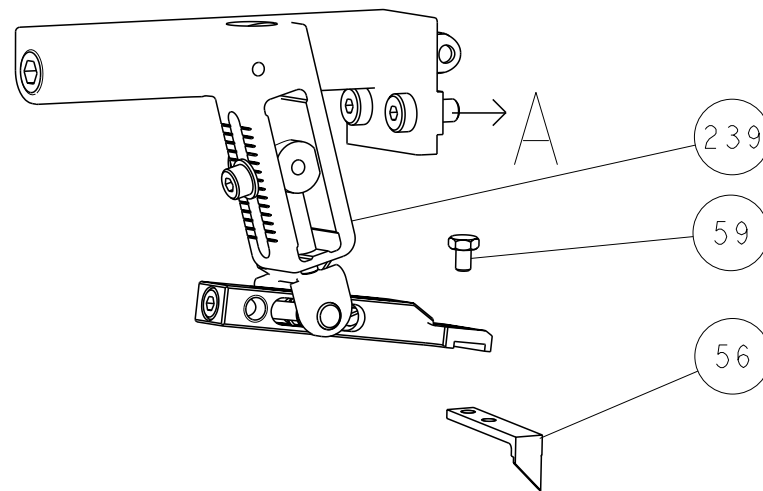
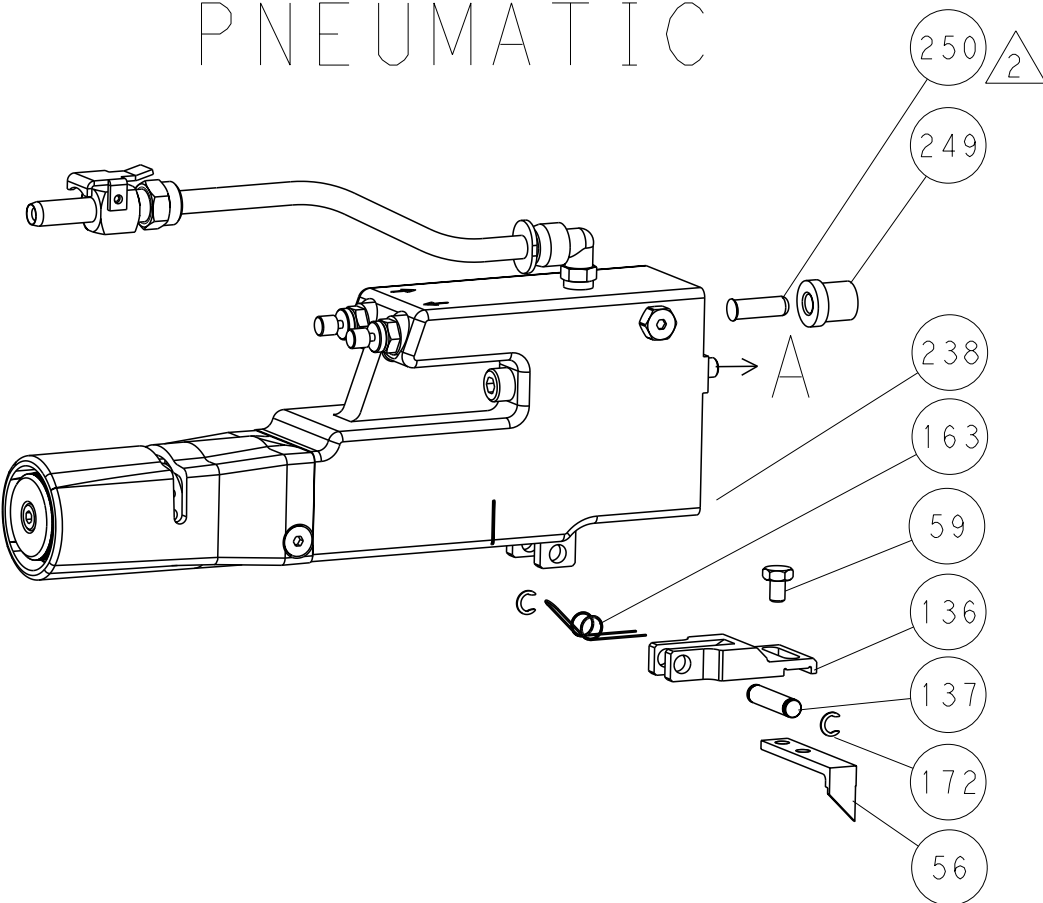


LOC		DIST		REVISIONS				
A	66	P	LYR	DESCRIPTION	DATE	DWN	APVD	
		-		SEE SHEET 1	-	-	-	

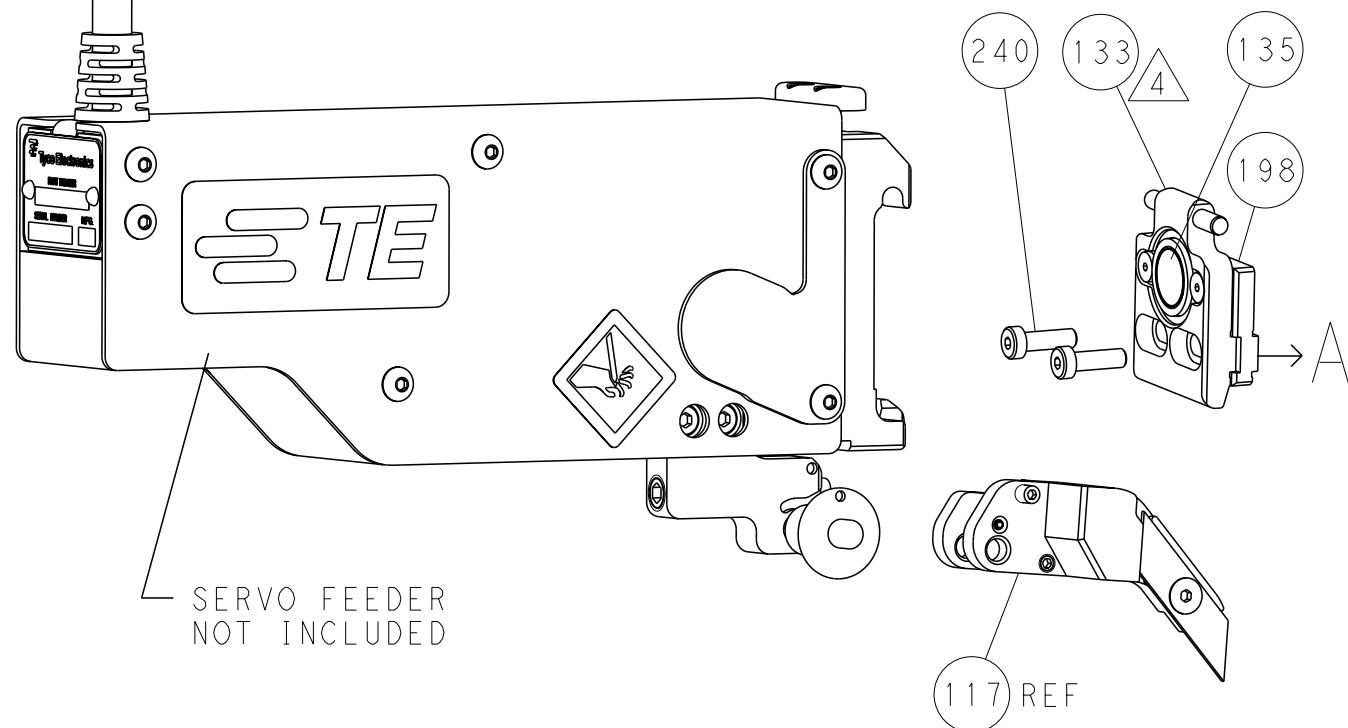
FEED TYPE MECHANICAL



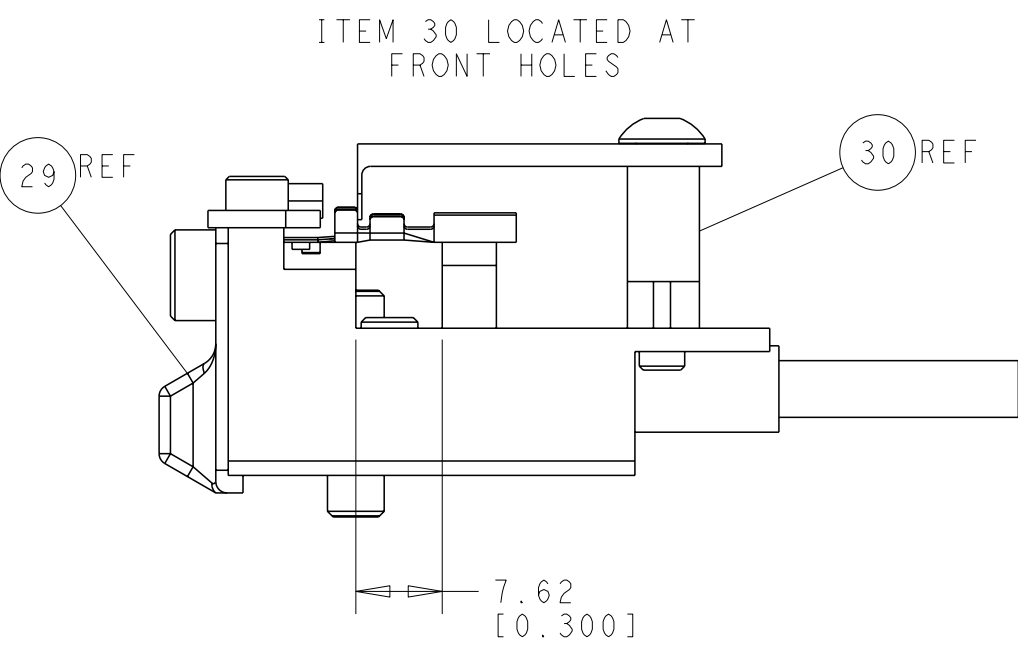
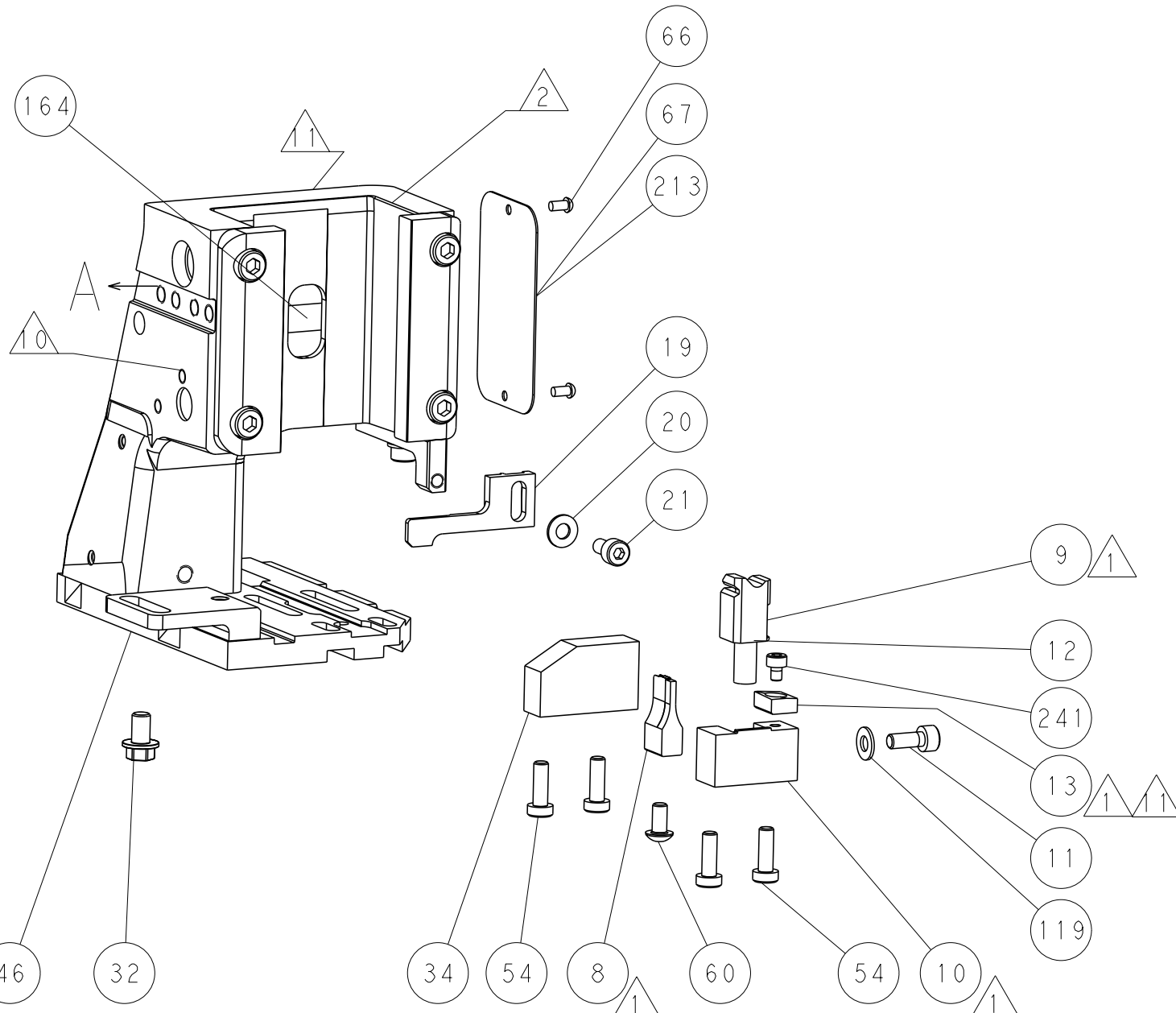
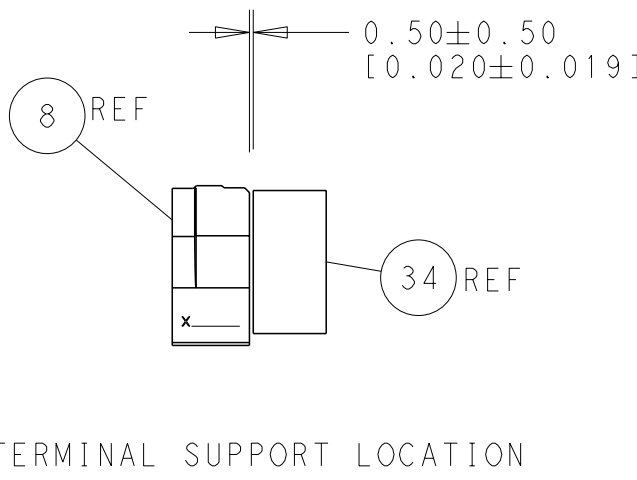
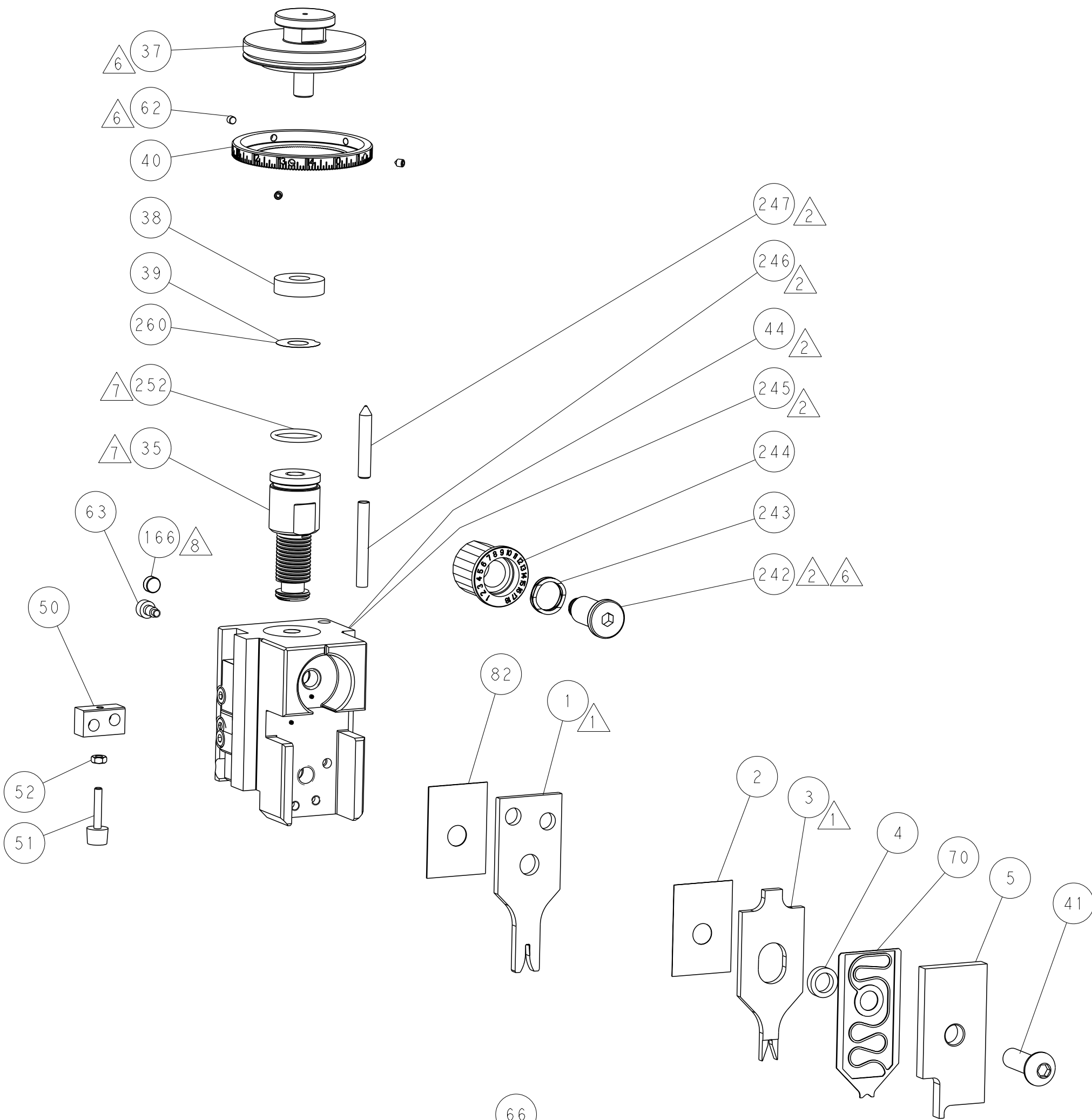
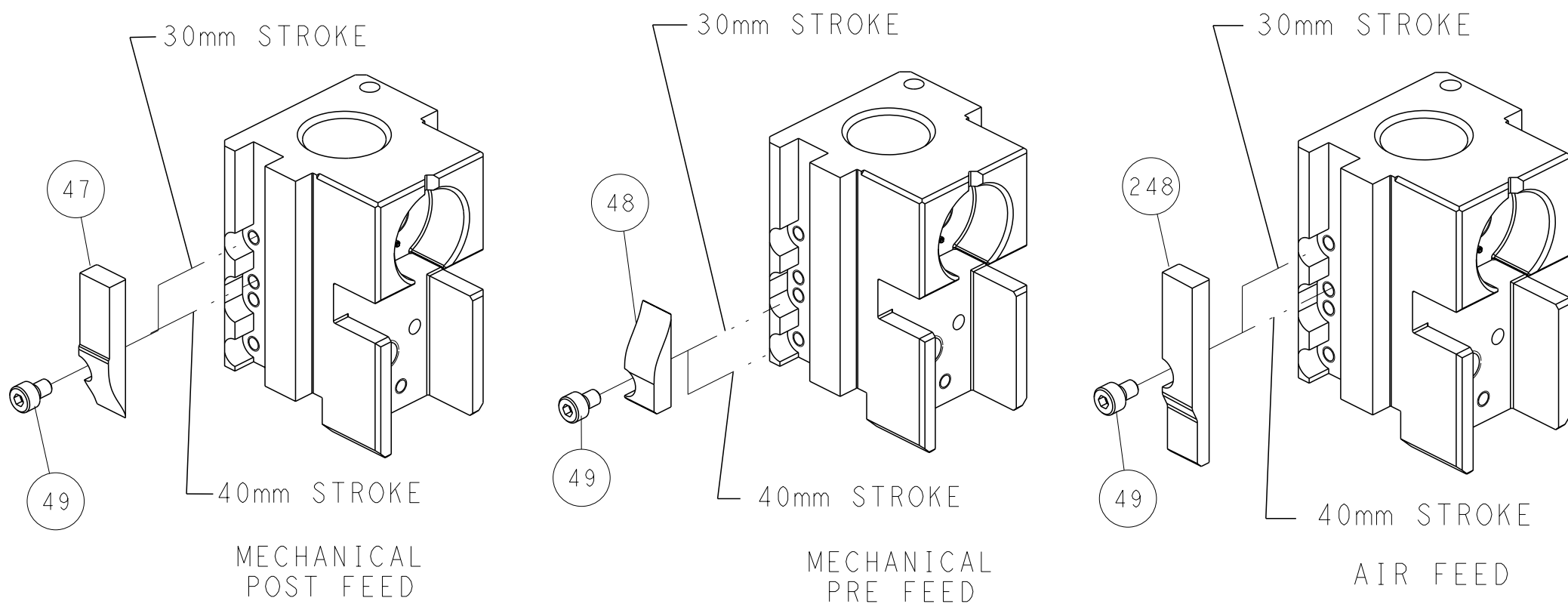
PNEUMATIC



SERVO LATCH PLATE

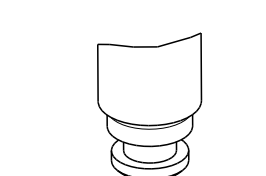


CAM POSITIONS



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 R. KNEPPER 21MAY2013		TE Connectivity	
mm		0 PLC ±0.5		CHK G. BAILEY 21MAY2013		Harrisburg, PA 17105-3608	
FINISH		1 PLC ±0.13		APVD M. CLIFFORD 21MAY2013		NAME Ocean Side Feed Applicator	
MATERIAL		2 PLC ±0.013		PRODUCT SPEC		SIZE CAGE CODE DRAWING NO	
		4 PLC ±0.0001		APPLICATION SPEC		A1 00779 C=2151068	
		ANGLES		WEIGHT		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 of 4 REV E	

8		7		6		5		4		3			
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20									
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
						CONVERT TO	PART NUMBERS REQUIRED						
		2-2151068-1	E	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	-	8-2151068-5	1901094-3	1-1752354-8	2168400-6 (QUANTITY 2)	
						SMART APPLICATOR	2161326-1	-	8-2151068-4	-	-	-	
		2-2151068-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	-
						SERVO LATCH PLATE	2119951-1	-	8-2151068-5	1901094-3	1-1752354-8	2168400-6 (QUANTITY 2)	
						SMART APPLICATOR	2161326-1	-	8-2151068-4	-	-	-	
		2-2151068-5	E	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	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	
		2-2151068-7	E	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
		7-2151068-7	D	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.83 mm [.072]	BX
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MCON-1.2 CB			
WIRE STRIP LENGTH 3.00-3.60 mm [.118-.142 IN]		INSULATION DIAMETER RANGE Ø1.40-1.90 mm [.055-.075 IN]	
TERMINAL APPLICATION SPECIFICATION		TERMINAL APPLICATION SPECIFICATION	
114-18464		114-18464	
114-18464		114-18464	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1670144-1	1670144-2	1670144-3	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING 
0.75mm ²		0.95+/-0.03 [0.037+/- .001]		8.9
20 AWG OR 0.50mm ²		0.84+/-0.03 [0.033+/- .001]		10.2



 RECOMMENDED SPARE PARTS

2 GREASE BEARING SURFACES LIGHTLY

3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

4 Δ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT
ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151068-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151068-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151068-5

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 ITEM 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.

 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.

12 MAXIMUM CRIMP WIDTH 2.05mm & MAXIMUM INSULATION
CRIMP HEIGHT 2.05mm. SEE APPLICATION SPECIFICATION TO CLARIFY.

2		1	
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISONS
P	LTR	DESCRIPTION	DATE DWN APVD
	-	SEE SHEET 1	- - -

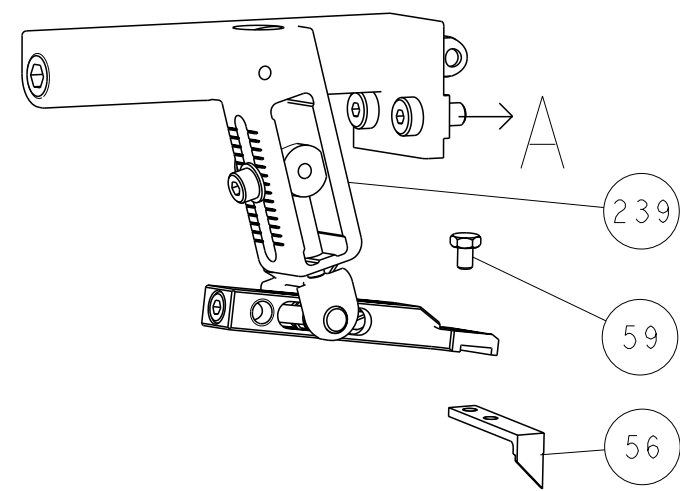
-	-	-	1		2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 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
-	-	-	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
-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	79
-	1	1	1	1	1633782-2	FENCE	78
-	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, 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	1338685-1	PAWL, FEED	56
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	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	3-1752356-3	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	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	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	1-18023-1	SCR, SKT HD CAP M4 X 10.0	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-6	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1333231-2	ANVIL, COMBINATION, SPECIAL	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1-1633989-6	CRIMPER, INSULATION, SPECIAL	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	1	5-456403-0	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

-	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

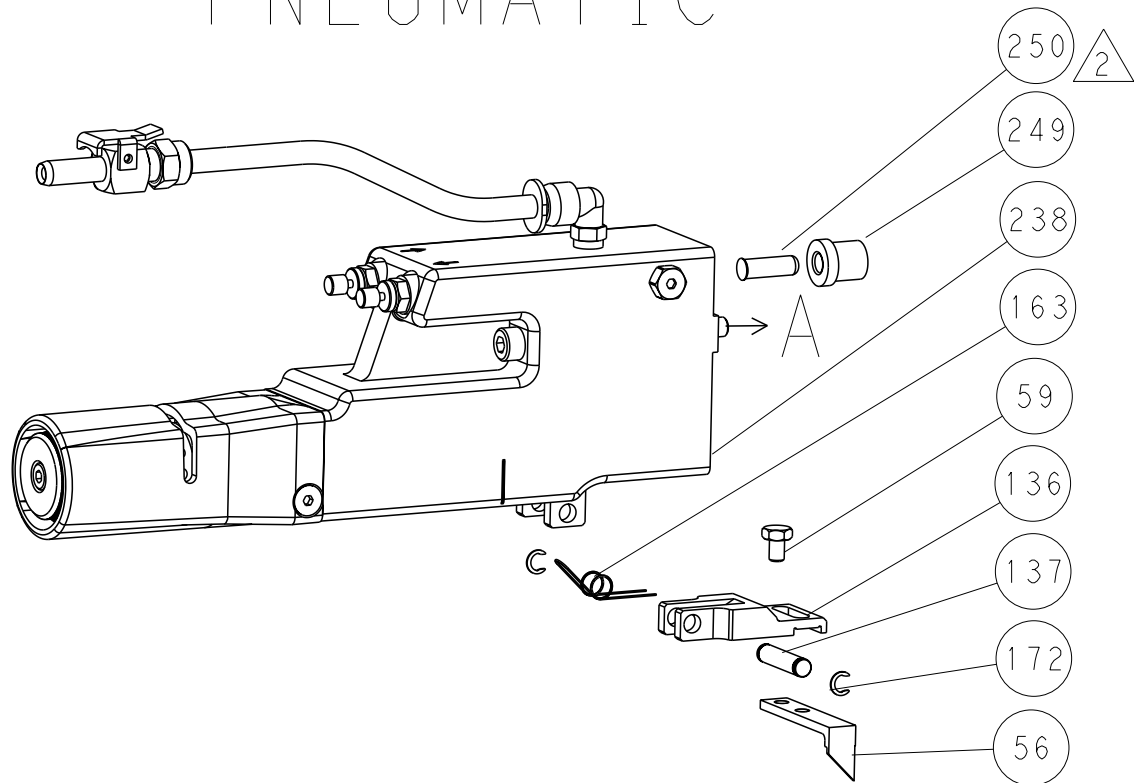
PACIFIC VERSION
(Atlantic version shown on sheets 1 of 4 & 2 of 4)
Shown on sheets 3 of 4 & 4 of 4

DIMENSIONS: mm 		TOLERANCES, UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		DWG DATE E. KNEPPER 21MAY2013 CHK G. BAILEY 21MAY2013 APP M. CLIFFORD PRODUCT SPEC - APPLICATION SPEC - WEIGHT -		NAME Ocean Side Feed Applicator -		TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL - FINISH -				SIZE CASE CODE DRAWING NO A 00779 C=2151068		RESTRICTED TO -			
Customer Accessible Production Drawing				SCALE 1:2		SHEET 3 OF 4		REV E	

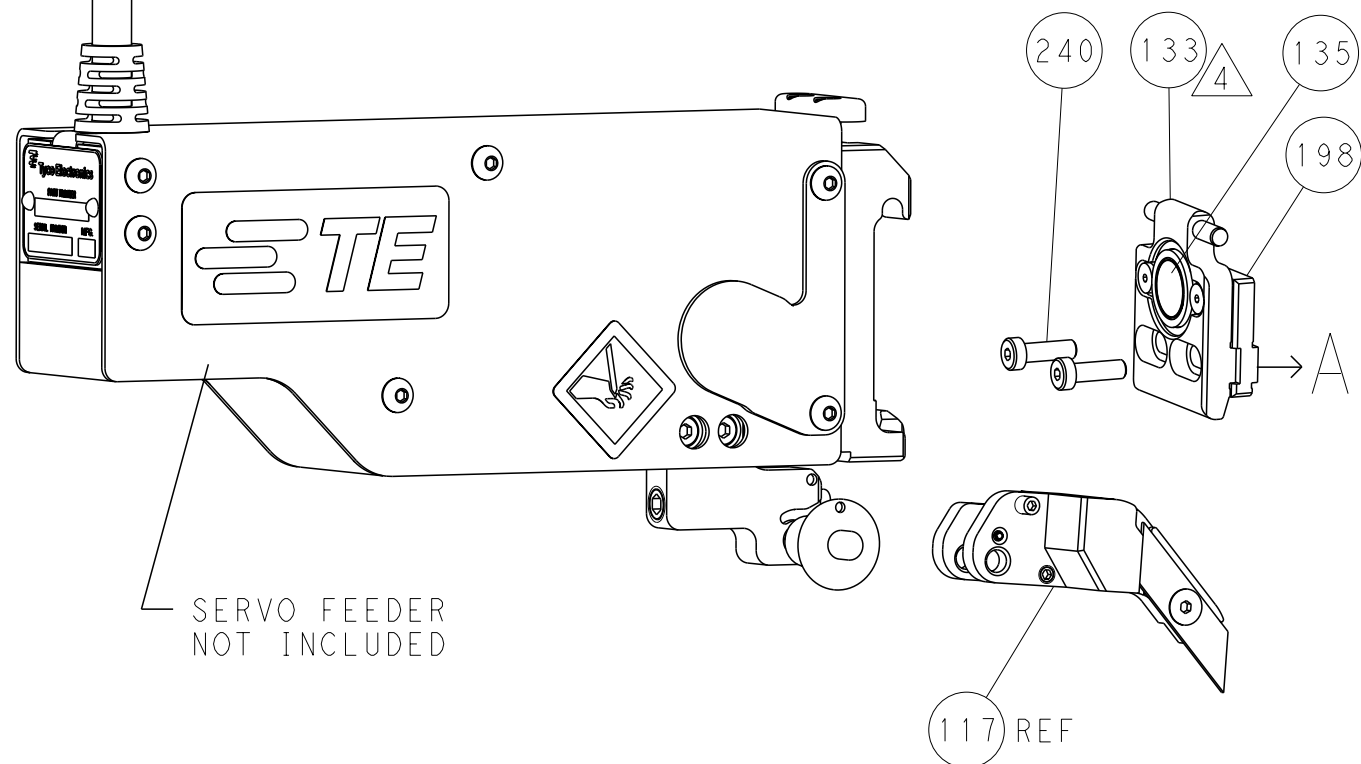
FEED TYPE MECHANICAL



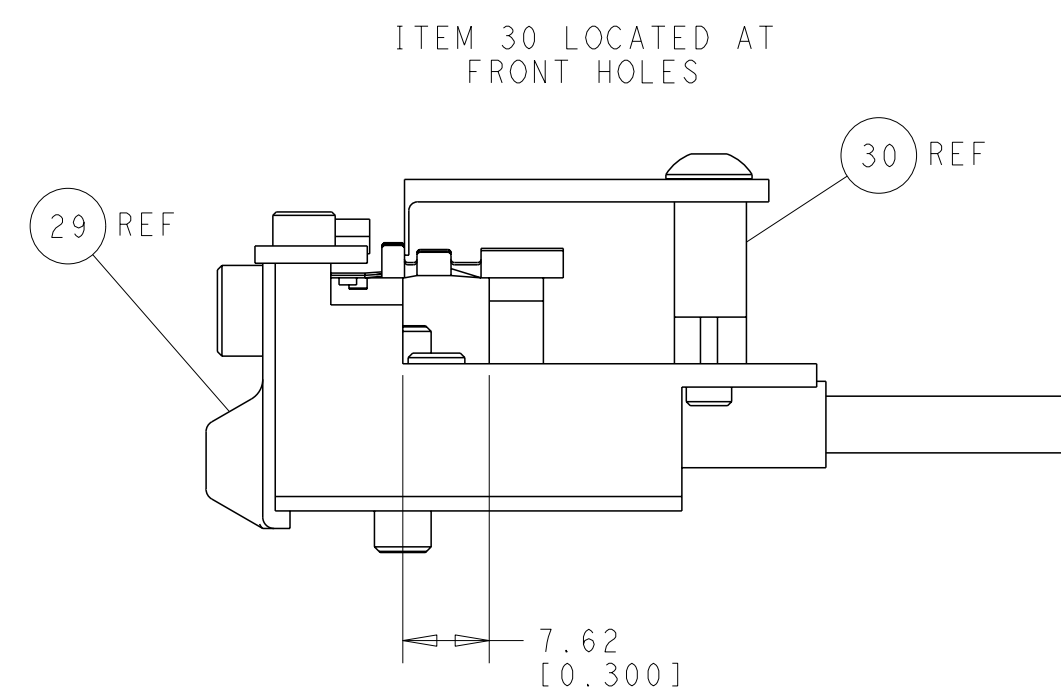
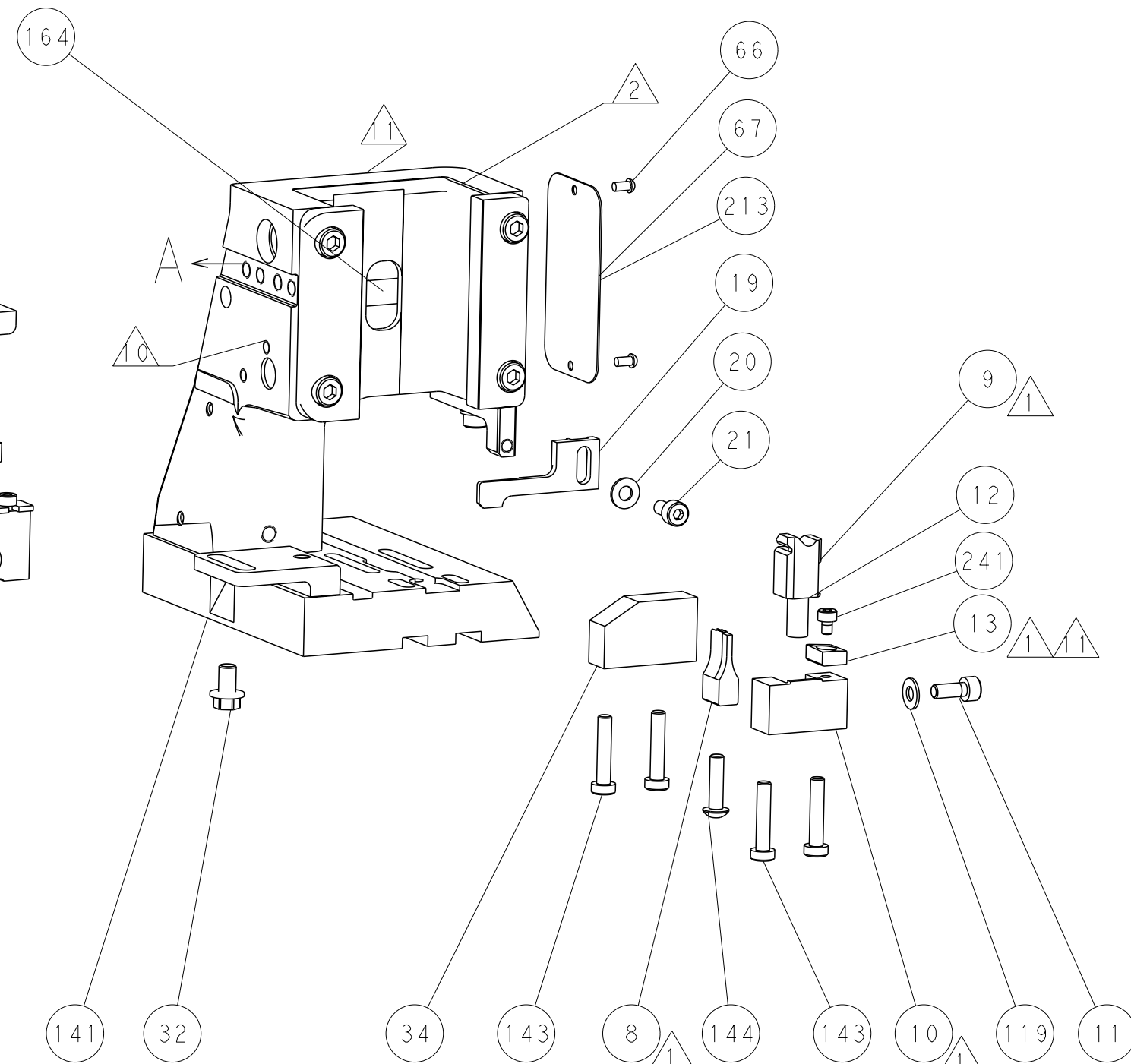
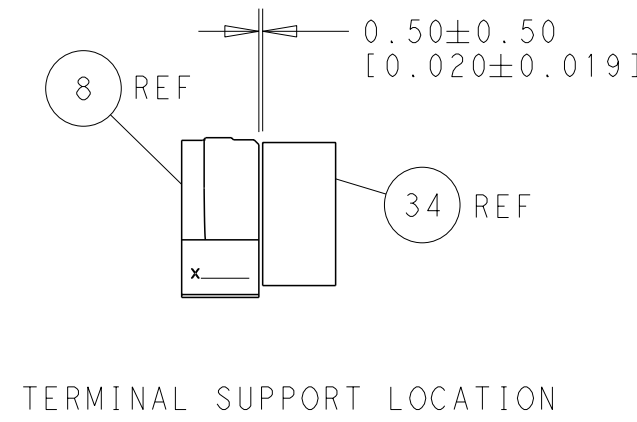
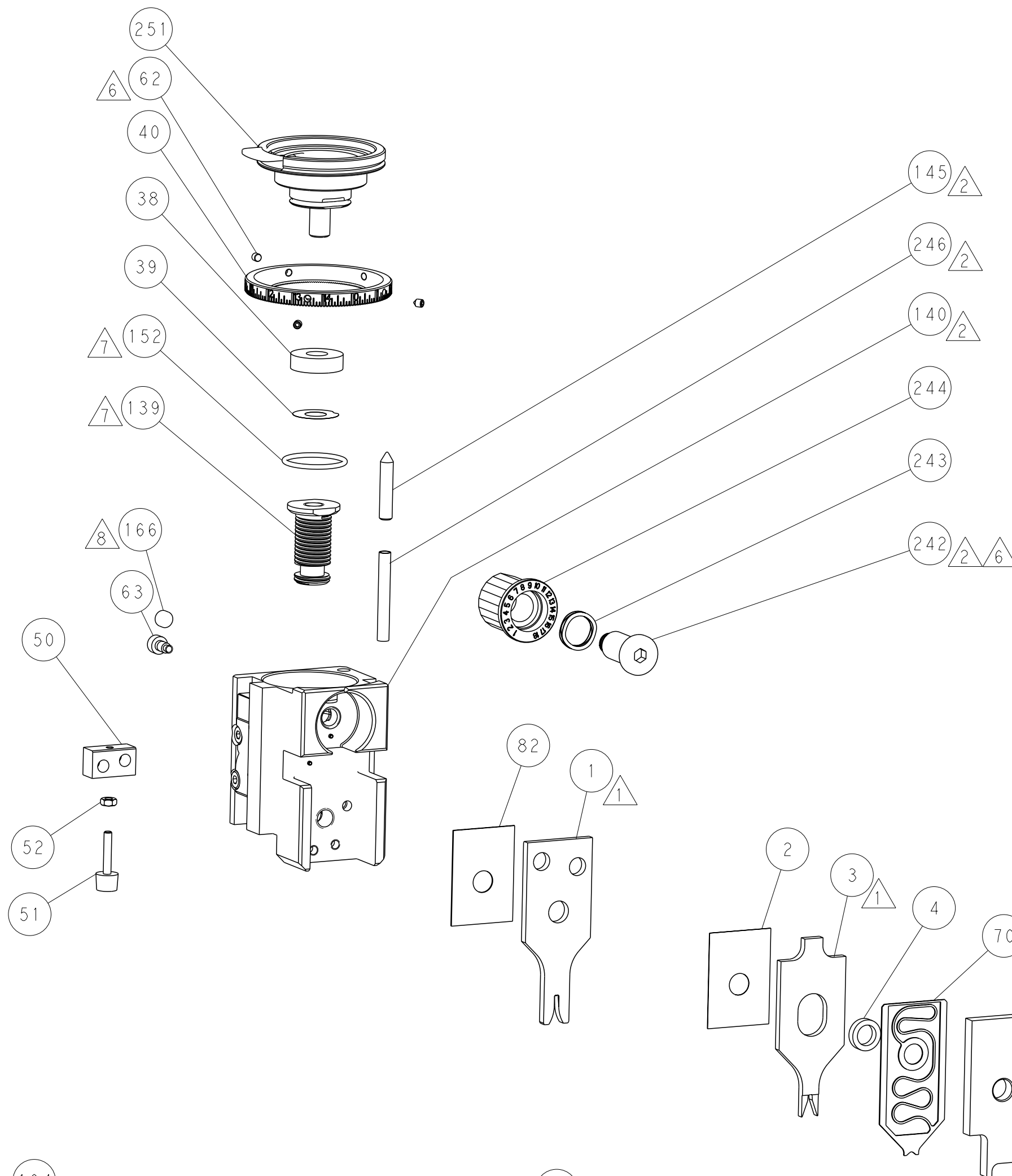
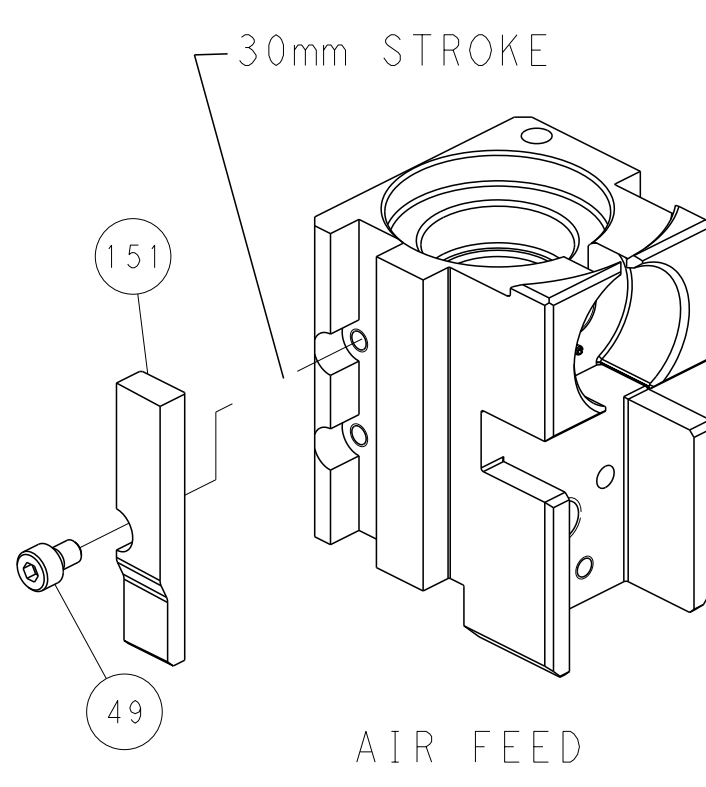
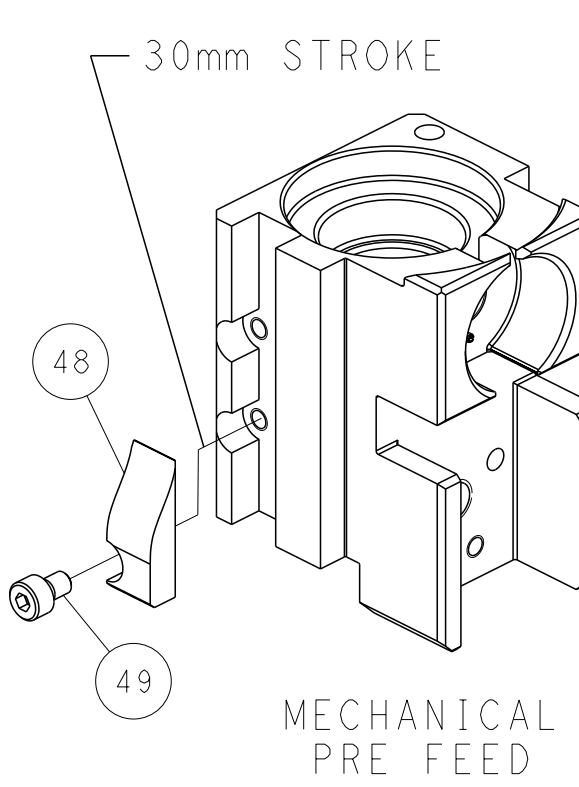
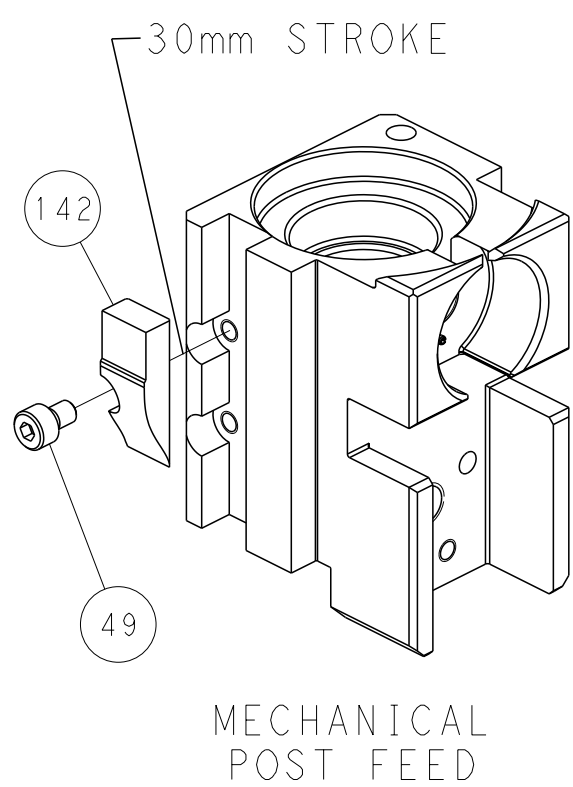
PNEUMATIC



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 TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO THE LATEST REVISION. SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN R. KNEPPER 21MAY2013	NAME Ocean Side Feed Applicator
DIMENSIONS: mm		CHK G. BAILEY 21MAY2013	SIZE A1
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.5		APVD W. CLIFFORD 21MAY2013	CAGE CODE 00779
MATERIAL -		PRODUCT SPEC -	DRAWING NO C=2151068
FINISH -		APPLICATION SPEC -	RESTRICTED TO -
Customer Accessible Production Drawing		SCALE 1:2	SHEET 4 of 4
		REV E	

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