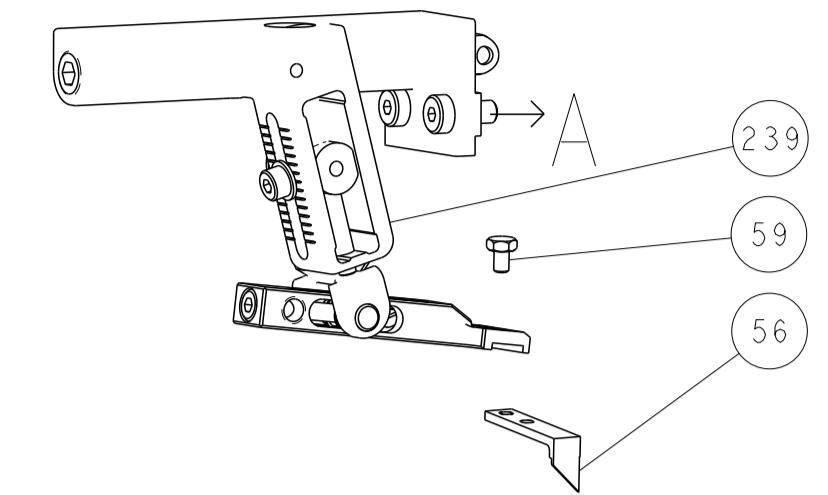
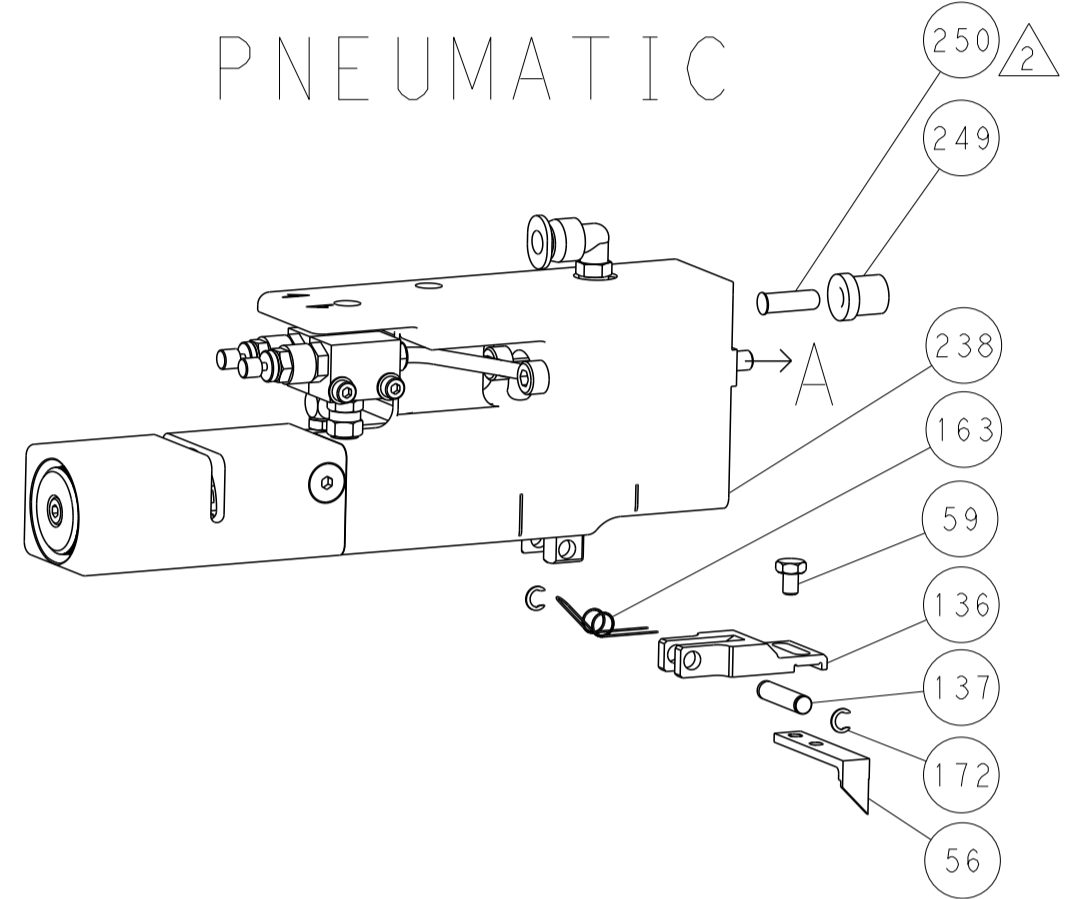


LOC		DIST		REVISIONS				
P	LTN	DATE	DMN	APVD	DESCRIPTION	DATE	DMN	APVD
-	-	-	-	-	SEE SHEET 1	-	-	-

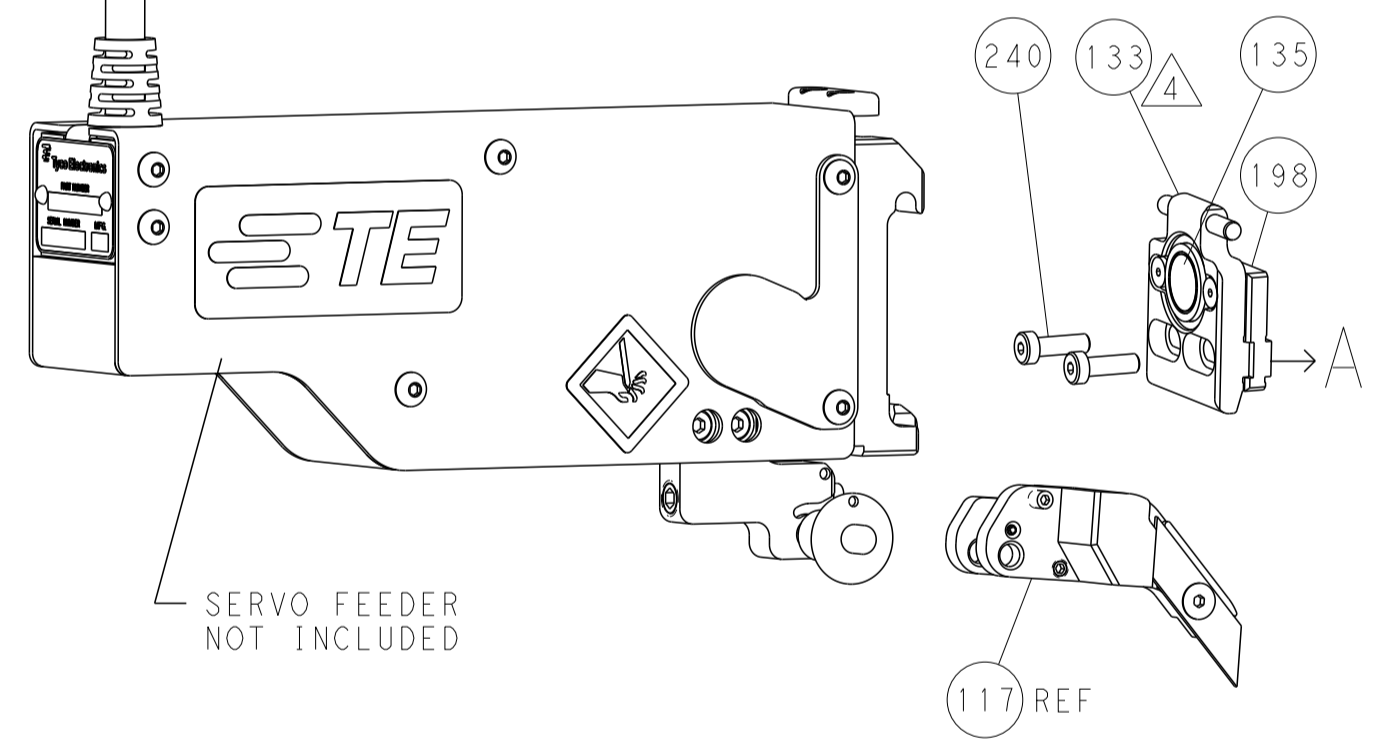
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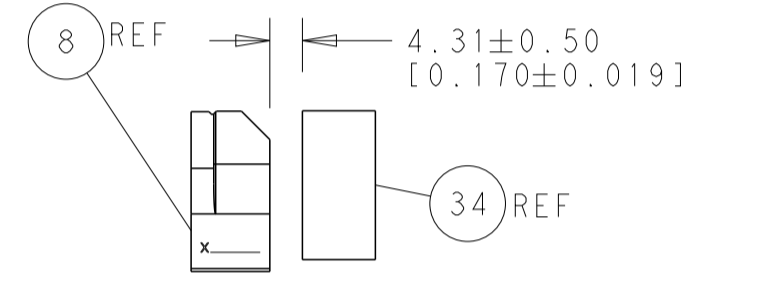
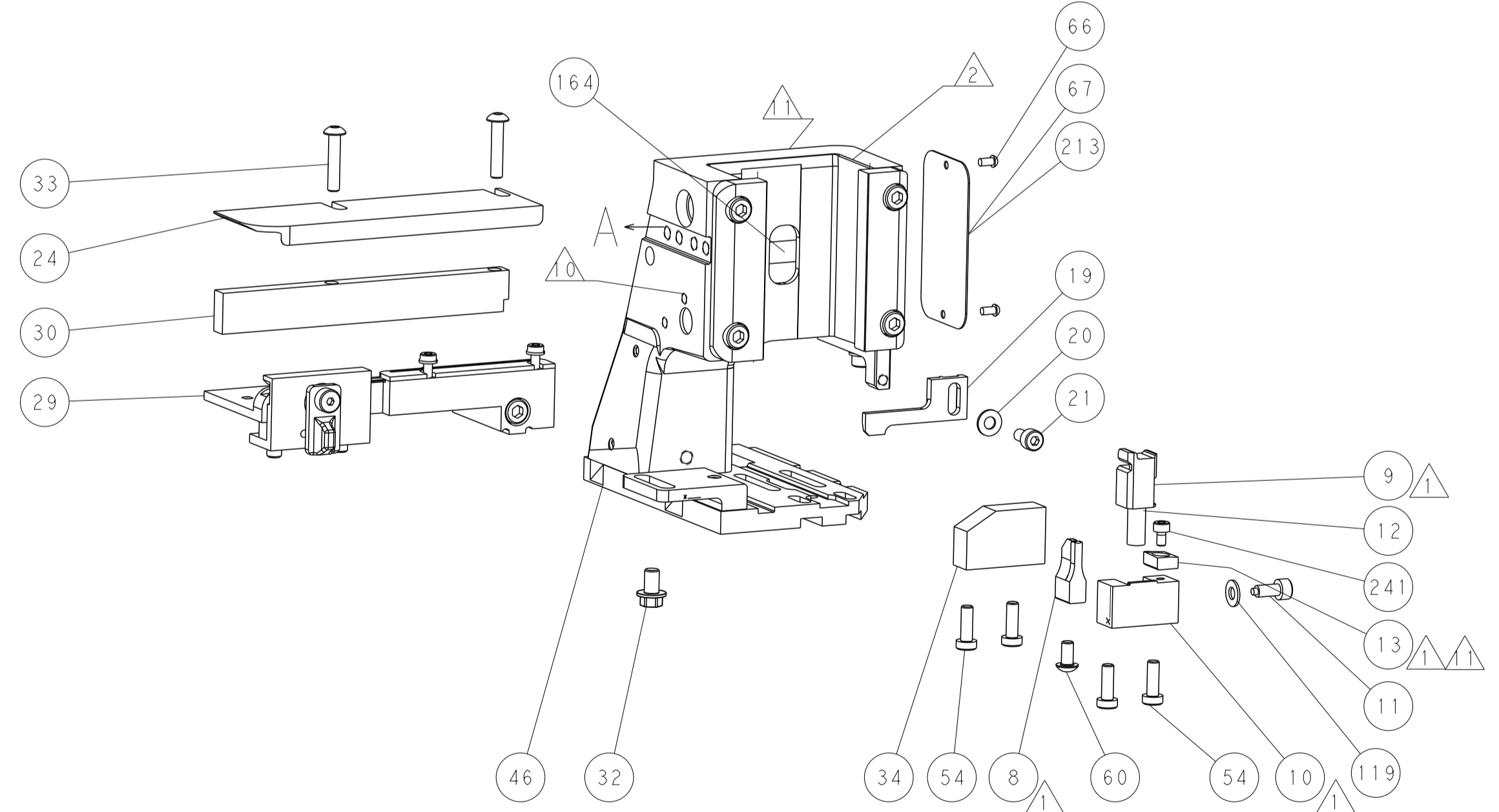
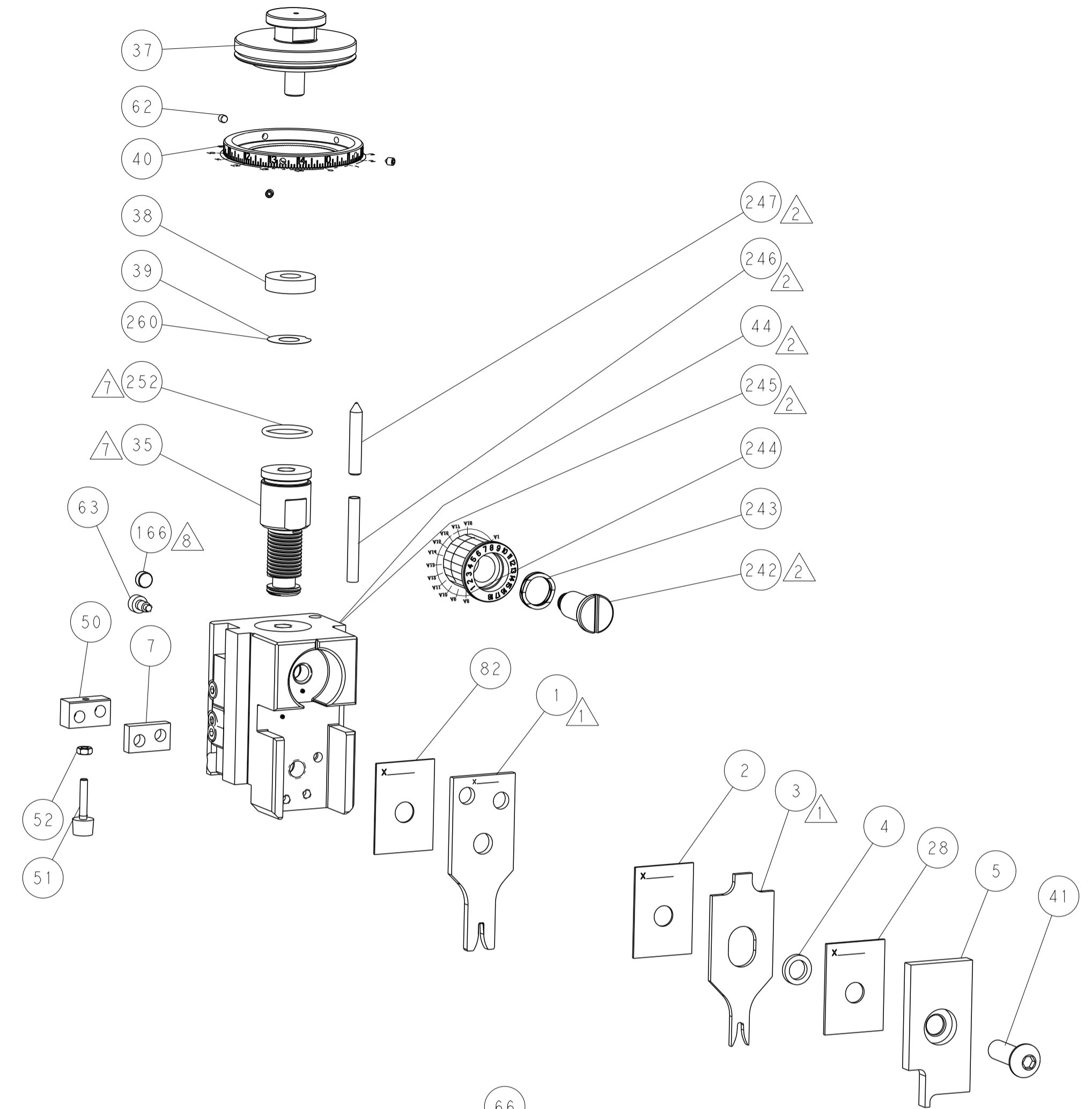
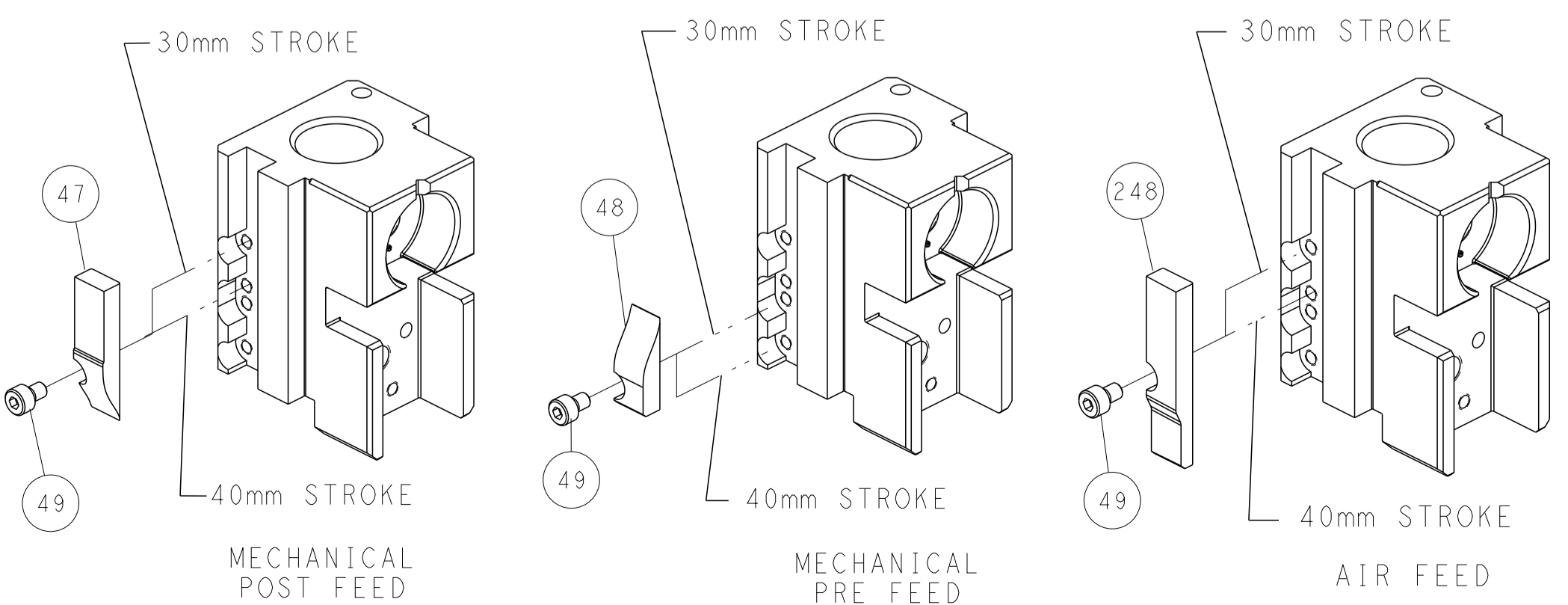
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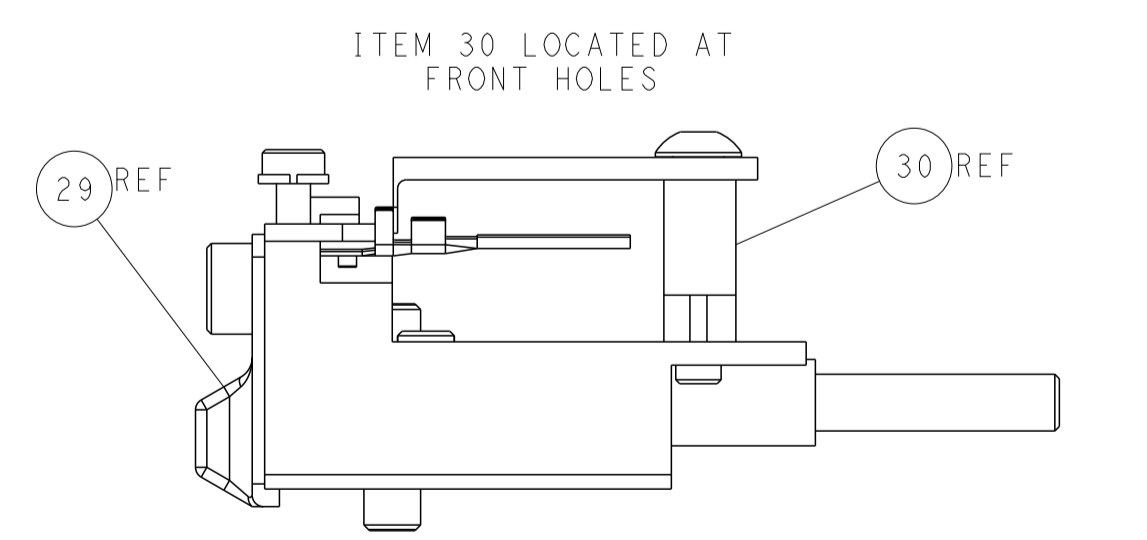
SERVO LATCH PLATE



CAM POSITIONS



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: C. CHEN 29NOV2011 CHK: S. XI 29NOV2011 APVD: J. CRUZ 29NOV2011	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151379	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: C
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 1 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES FINISH ±	MATERIAL: - FINISH: -	WEIGHT: - PRODUCT SPEC: - APPLICATION SPEC: -	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1
	2-2151379-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	-	8-2151379-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151379-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
2-2151379-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151379-5	1901094-3	-	2168400-6 (QUANTITY 2)	
				SMART APPLICATOR	2161326-1	-	8-2151379-4	-	-		
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	
2-2151379-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119951-1	-	8-2151379-5	1901094-3	-	2168400-6 (QUANTITY 2)		
2-2151379-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151379-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 2.03 mm [.080]	F	
INSUL 2.79 mm [.110]	OV	
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 2.8mm FASTIN FASTON TAB			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.60 mm [1.57-.181 IN]		Ø1.40-2.30 mm [0.055-.091 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18014	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928930-1	928930-2	928930-4	928930-5

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.56 +/- 0.05 [0.061 +/- .002]	5.8
0.75mm2	1.47 +/- 0.05 [0.058 +/- .002]	6.7
0.50mm2	1.38 +/- 0.05 [0.054 +/- .002]	7.6

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151379-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151379-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151379-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 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.

***WARNING**
 ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

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		LOC	DIST	REVISIONS			
2119599-1	A	66		REV	DATE	BY	APPV
				1			
				2			

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO			
-	-	-	-	SEE SHEET 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, MISMUMI	249			
-	1	1	1	1-22279-3 SPRING, COMPRESSION	246			
-	1	1	1	2119082-9 CAM, SNAIL, INSULATION ADJUSTMENT	244			
-	1	1	1	2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST	243			
-	1	1	1	2119083-1 RETAINER, INSULATION DIAL	242			
-	1	1	1	18023-1 SCR, SKT HD CAP M3 X 5.0	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	994969-1 MAGNET, RARE EARTH HIGH ENERGY	166			
-	REF	REF	REF	994970-2 COUNTER, MAGNETIC	164			
-	-	-	1	240638-1 SPRING, FEED FINGER	163			
-	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	2119798-2 DETENT PIN	145			
-	1	1	1	2079383-8 SCR, BHSC, RoHS (M4 X 16)	144			
-	4	4	4	2168400-5 SHCS, LOW HEAD, RoHS, M4 X 20	143			
-	-	-	1	2119653-2 FEED CAM, POST FEED	142			
-	1	1	1	1-2119656-0 APPLICATOR BASIC ASSEMBLY, SF	141			
-	1	1	1	2119650-1 RAM, ASIAN STYLE, SIDE FEED	140			
-	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	1-18028-2 WASHER, FLAT, REG M4	119			
-	-	REF	-	2119944-1 FEED FINGER ASSEMBLY, SF	117			
-	1	1	1	455888-6 SPACER, CRIMPER	82			
-	1	1	1	2119956-1 DOCUMENTATION PACKAGE	71			
-	1	-	1	2119740-1 TAG, IDENTIFICATION	67			
-	2	2	2	2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188	66			
-	1	1	1	2119793-1 LIMITER, ADJUSTMENT BOLT	63			
-	3	3	3	992763-5 SCR, SET, SOC, CONE POINT, M3 X 4.0	62			
-	-	-	1	5-18022-5 SCR, HEX HD CAP, M4 X 6.0	59			
-	-	-	1	1338685-1 PAWL, FEED	56			
-	2	2	2	2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	53			
-	1	1	1	5018030-1 NUT, HEX, REG, RoHS, M3	52			
-	1	1	1	811242-5 BUMPER, HOLD DOWN	51			
-	1	1	1	690753-2 SPACER, TONKER	50			
-	-	-	1	18023-9 SCR, SKT HD CAP M4 X 6.0	49			
-	-	-	1	2119652-1 FEED CAM, PRE FEED	48			
-	1	1	1	2079383-7 SCR, BHSC, RoHS (M8 X 25)	41			
-	1	1	1	2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT	40			
-	1	1	1	2119957-1 APPLICATOR SHIM PACK	39			
-	1	1	1	1-2119644-2 RAM WASHER, PRECISION	38			
-	1	1	1	1-1752356-9 SUPPORT, TERMINAL	34			
-	2	2	2	2079383-5 SCR, BHSC, RoHS (M4 X 20)	33			
-	1	1	1	2161328-1 HEX HEAD, FLANGED, M5 X 8mm LONG	32			
-	1	1	1	1320908-3 SPACER, STRIP GUIDE	30			
-	1	1	1	2119959-2 ASSEMBLY, STRIP GUIDE	29			
-	1	1	1	1-455888-0 SPACER, CRIMPER	28			
-	1	1	1	1320928-2 STRIP GUIDE	24			
-	1	1	1	2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0	21			
-	1	1	1	1-18028-2 WASHER, FLAT, REG M4	20			
-	1	1	1	2119533-1 STRIPPER, SIDE FEED	19			
-	1	1	1	2119806-1 INSERT, SHEAR	13			
-	1	1	1	3-22280-3 SPRING, COMPRESSION	12			
-	1	1	1	1-356885-4 STOP, SHEAR	11			
-	1	1	1	2119805-1 SHEAR HOLDER, FRONT	10			
-	1	1	1	454276-5 FLOATING SHEAR, FRONT	9			
-	1	1	1	2-1333204-9 ANVIL, COMBINATION	8			
-	1	1	1	1-240641-0 SPACER	7			
-	-	-	-	-	6			
-	1	1	1	2119757-4 DEPRESSOR, SHEAR	5			
-	1	1	1	238011-8 BLOCK, CRIMPER SPACER	4			
-	1	1	1	1-2119785-3 CRIMPER, INSULATION OVERLAP PREMIUM	3			
-	1	1	1	455888-7 SPACER, CRIMPER	2			
-	1	1	1	1-456405-5 CRIMPER, WIRE PREMIUM	1			
-	77	27	25	22	21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	0 PLC ±.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001
	ANGLES ±.001	FINISH			

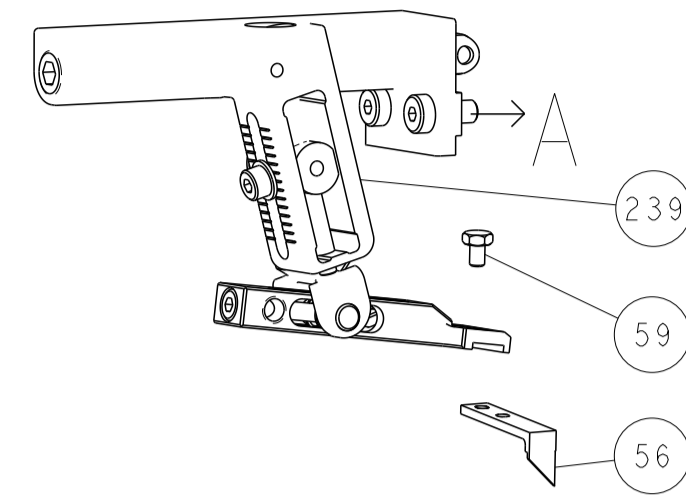
OWN	CHEK	APVD	DATE
C. CHEN	S. XI	J. CRUZ	29NOV2011

NAME	SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
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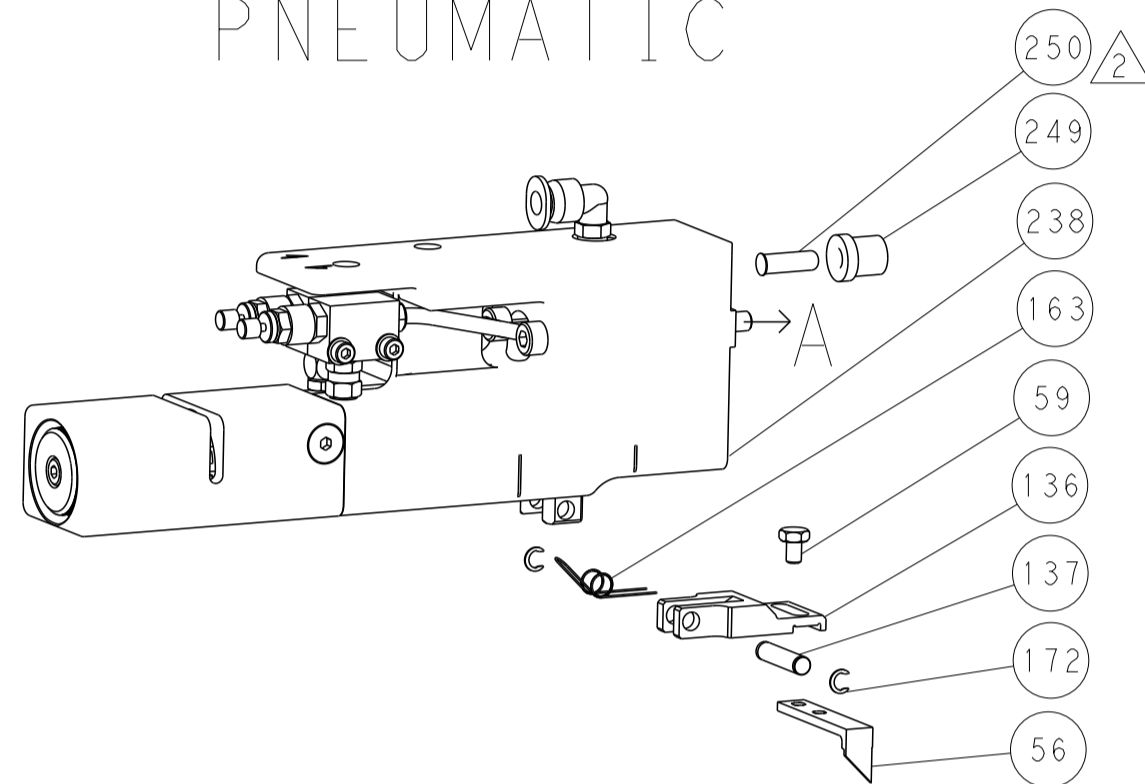
Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV C

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

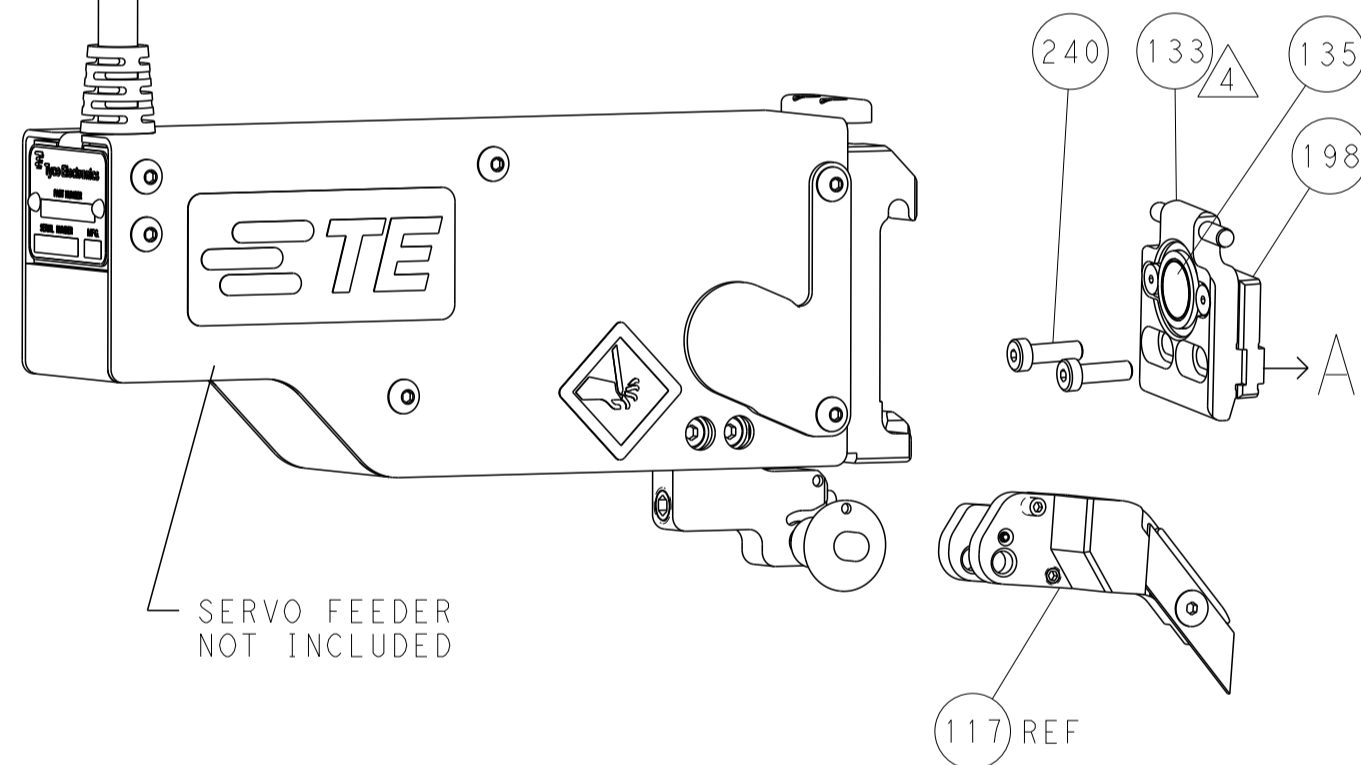
FEED TYPE MECHANICAL



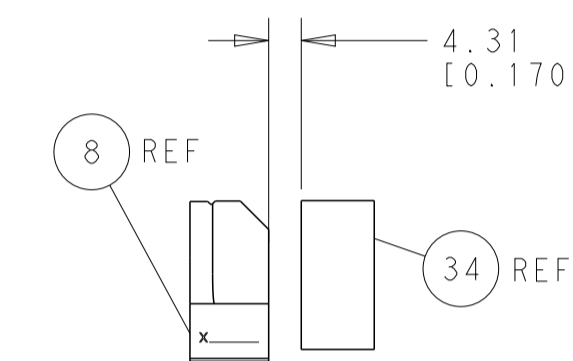
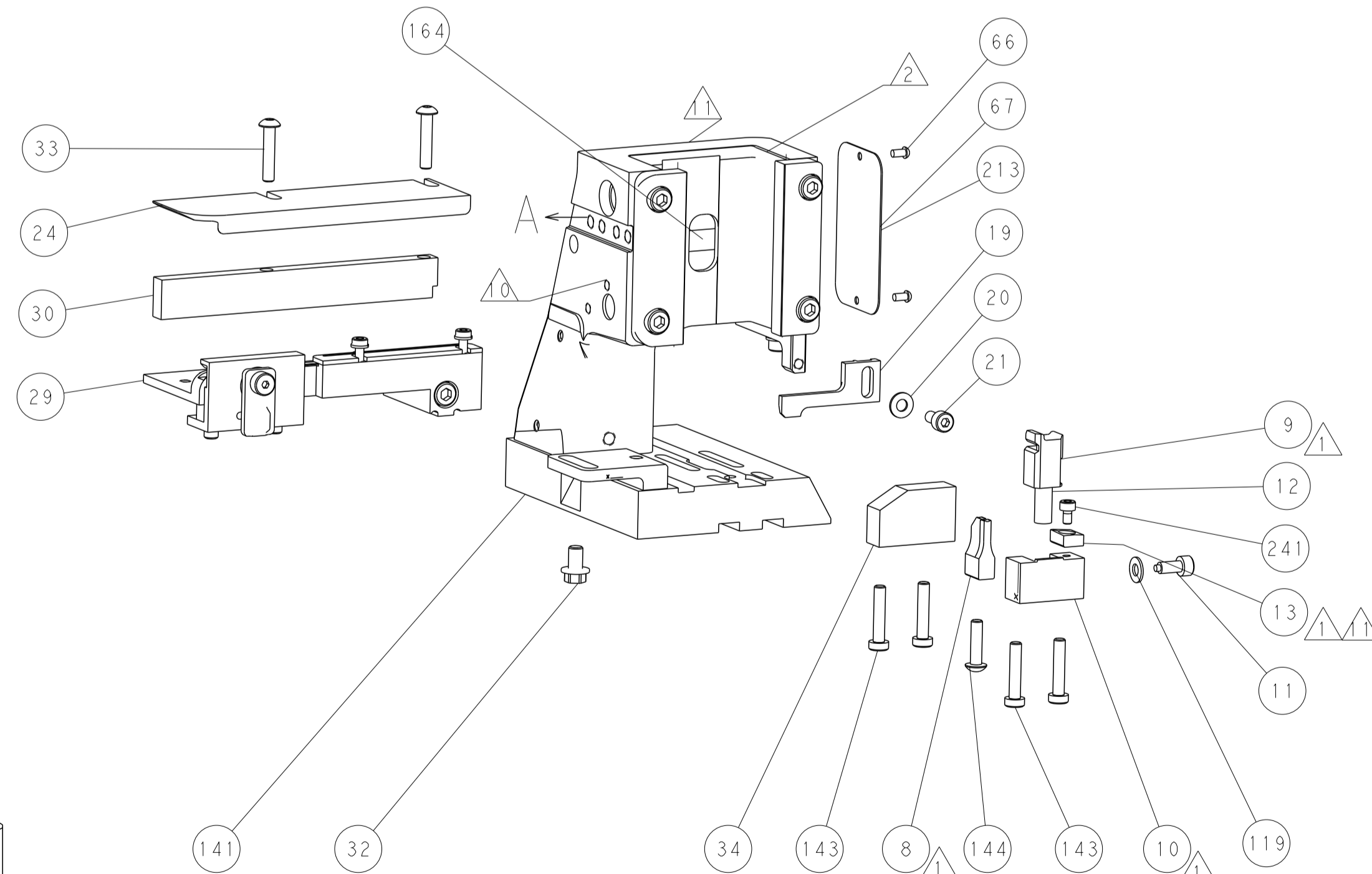
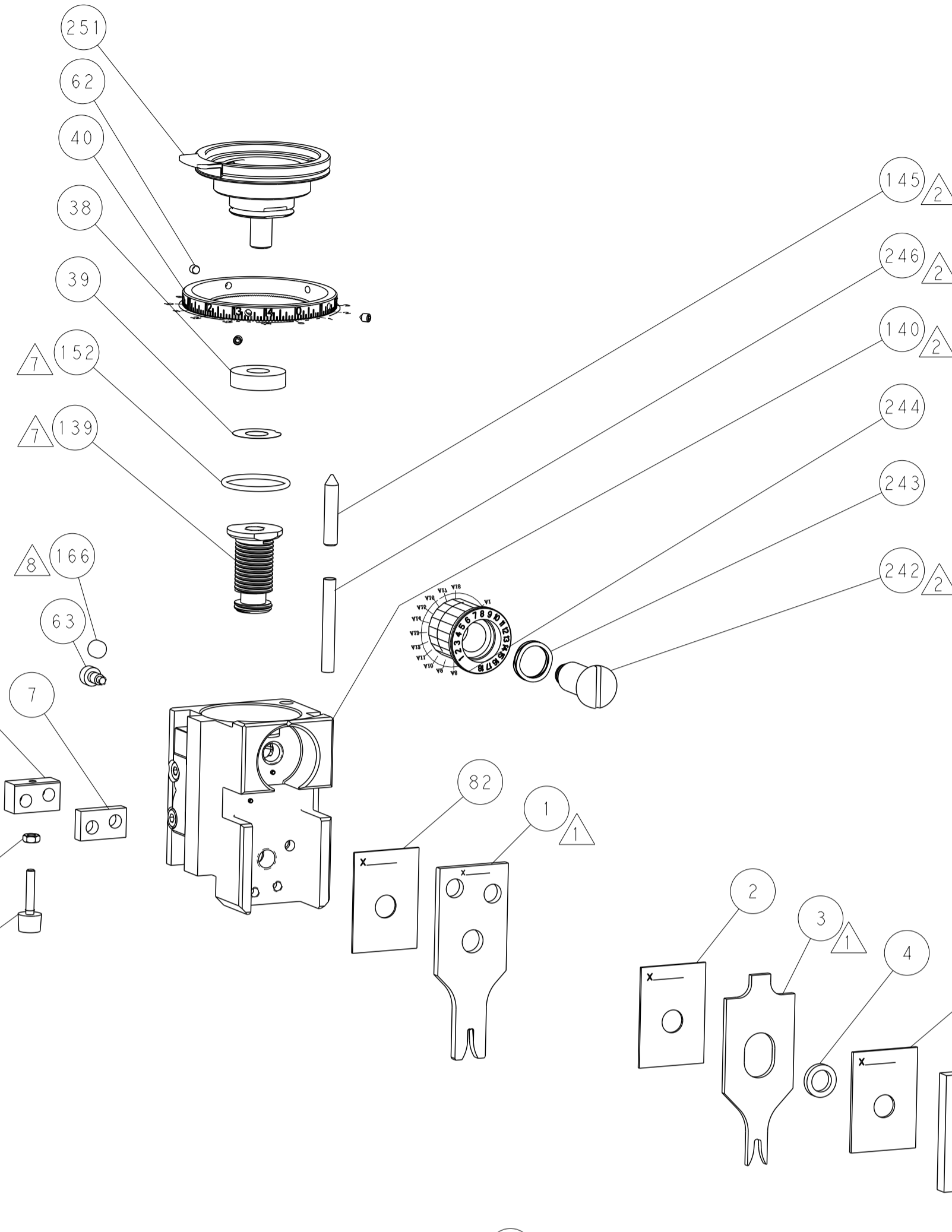
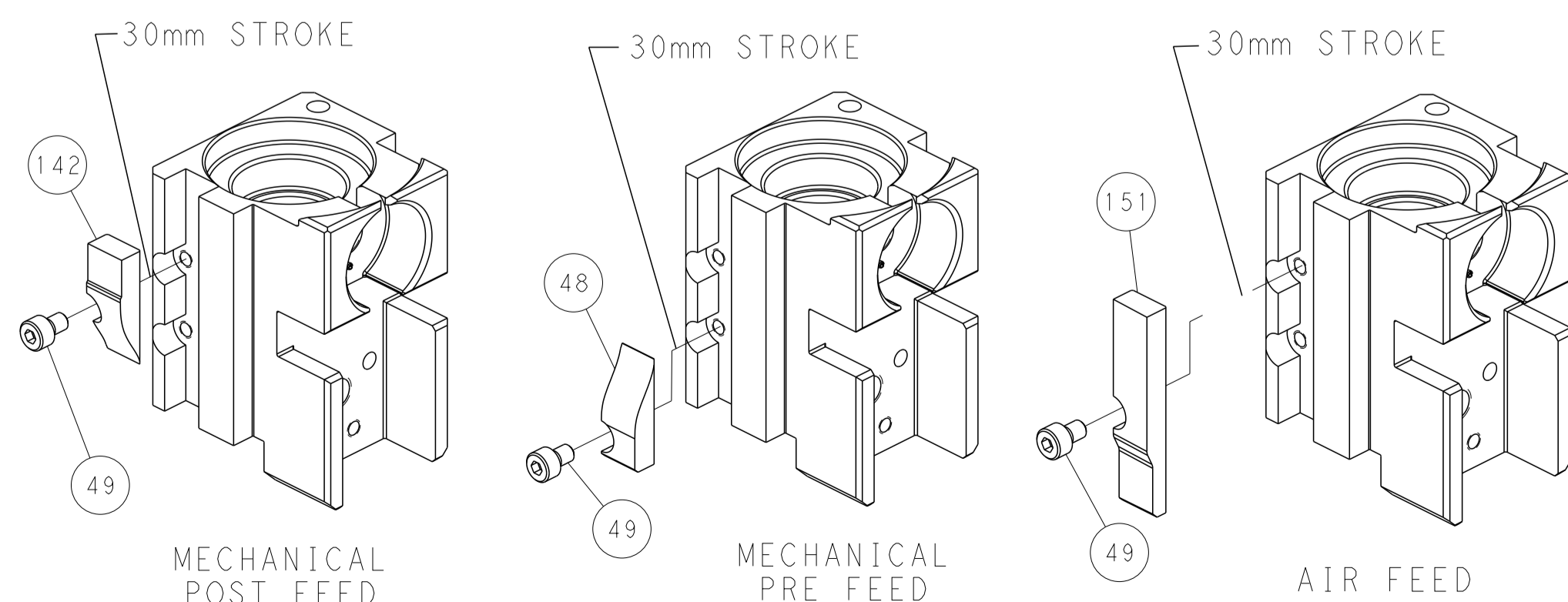
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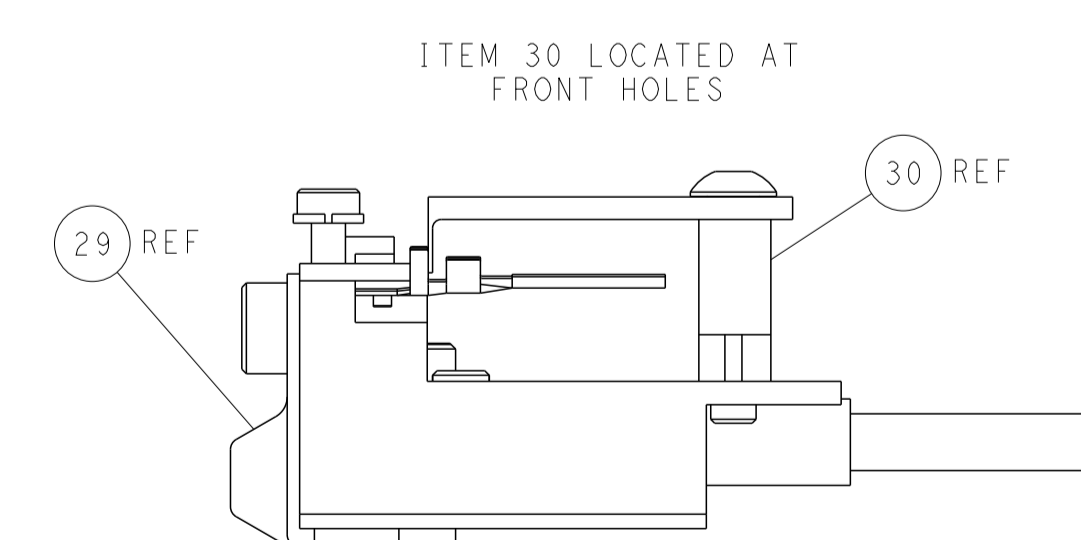
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



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 C. CHEN 29NOV2011		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD J. CRUZ 29NOV2011	NAME Ocean Side Feed Applicator
MATERIAL:		FINISH:		WEIGHT:		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
				A 00779 C=2151379		Customer Accessible Production Drawing SCALE 1:2 SHEET 4 OF 4 REV C	