

Table with 5 columns: ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER, PART NUMBER, REVISION, DESCRIPTION, FEED TYPE. Includes a technical drawing of the applicator.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Includes APPLICATOR INSTRUCTIONS 408-10389.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED.

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Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

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- 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.
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.
7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
8. MAGNET, ITEM 166 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.
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 THE BACK SIDE OF THE HOUSING.
12. WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.17.
13. THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.
14. TERMINAL LUBRICANT IS RECOMMENDED.

*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.

Table with 7 columns: Part number, description, item number. Lists various components like APPLICATOR SHIM PACK, O-RING, PUSH ROD, etc.

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

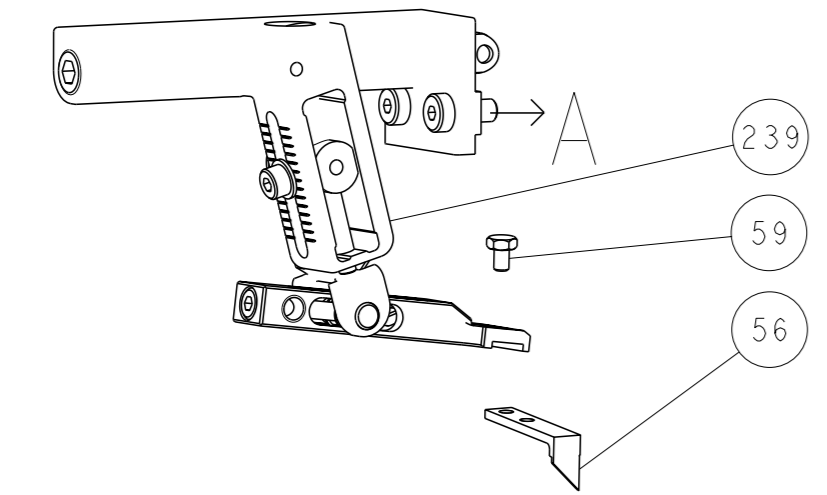
Table with columns: SET UP GAUGE, LOC, DIST, REVISIONS. Includes revision details for ECR-14-016138, ECR-15-014874, ECR-18-009948.

Large parts list table with columns: Part number, description, item number. Lists numerous components like RETAINER, SCR, SHCS, MECHANICAL FEED ASSEMBLY, AIR FEED MODULE, etc.

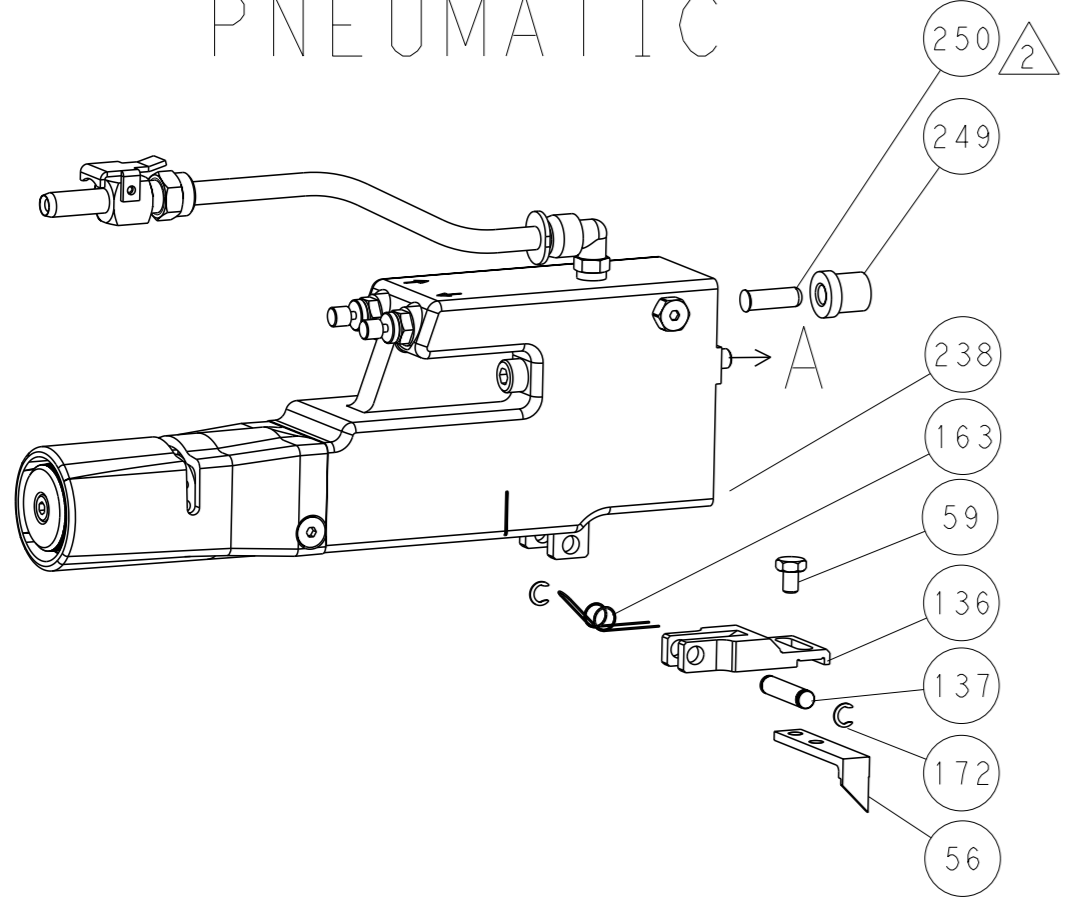
Technical drawing area including DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, and customer information for STC Ocean Side Feed Applicator.

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

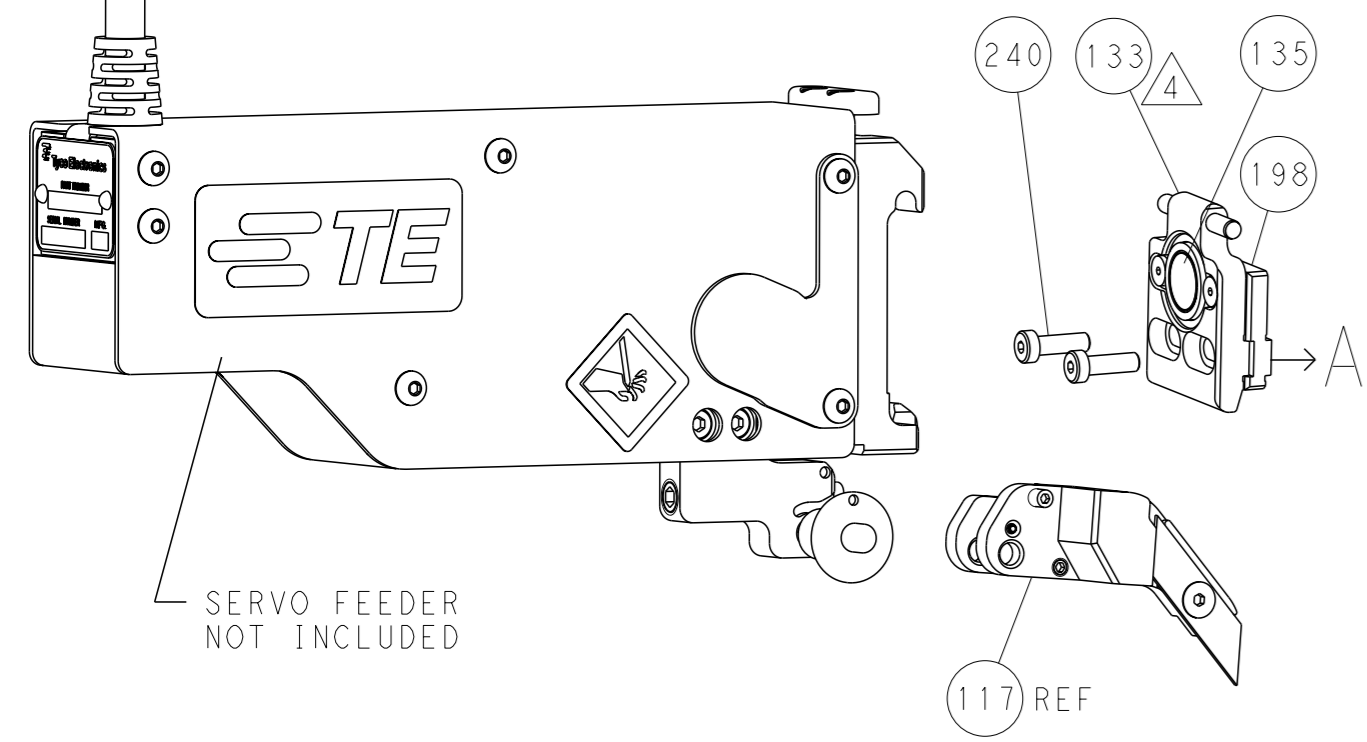
FEED TYPE MECHANICAL



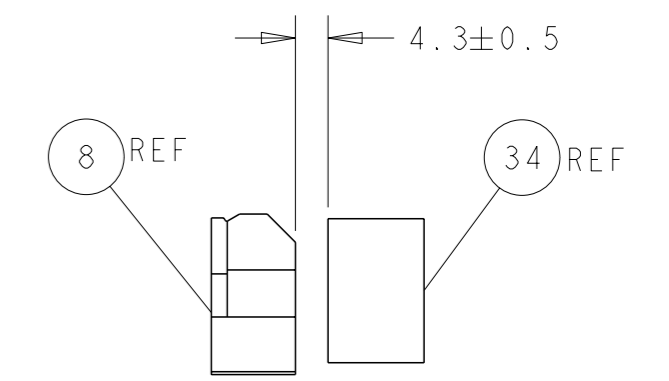
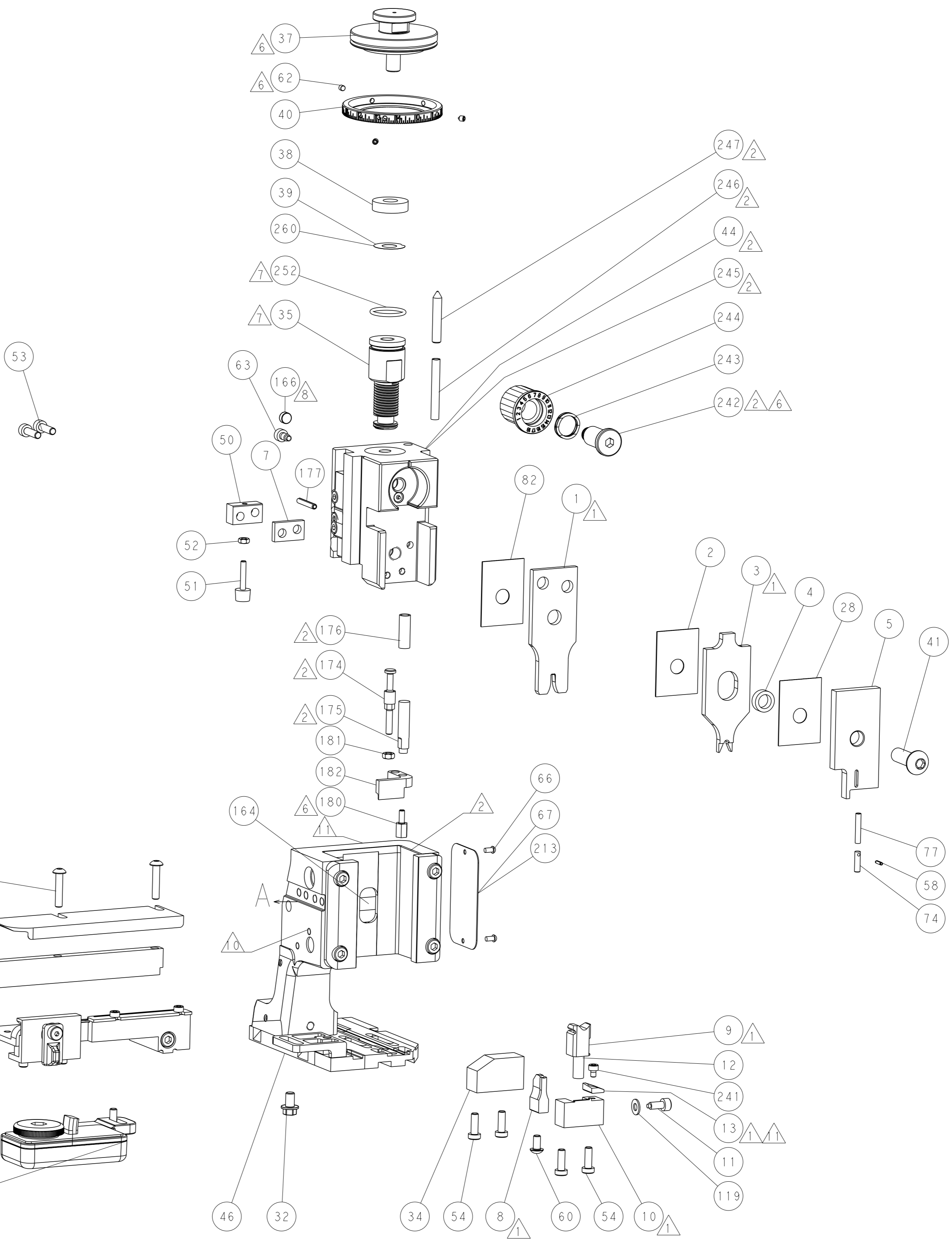
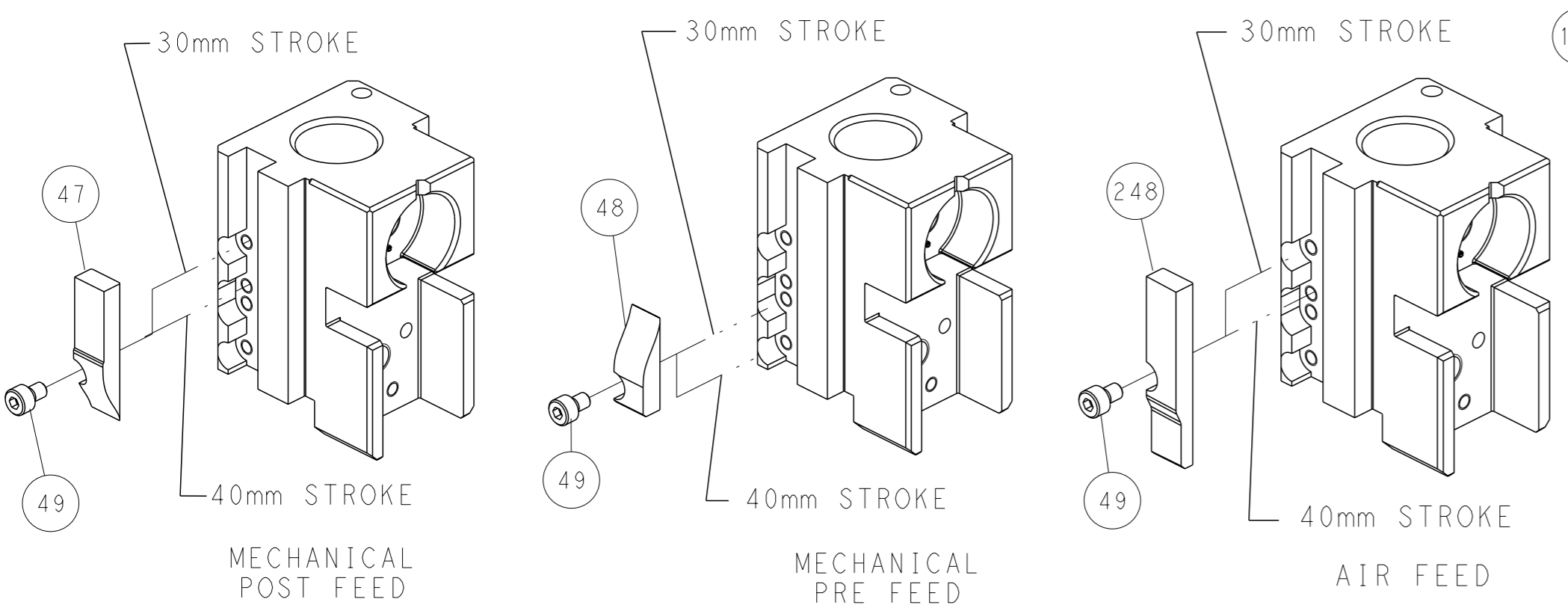
PNEUMATIC



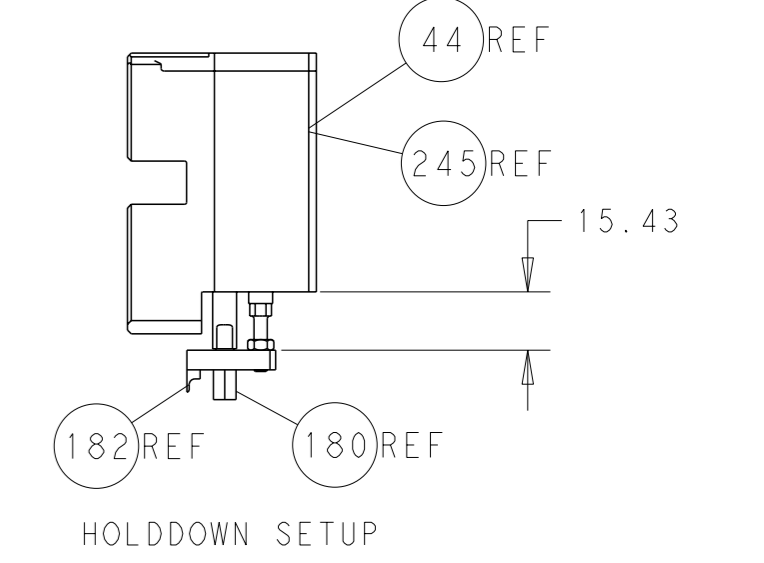
SERVO LATCH PLATE



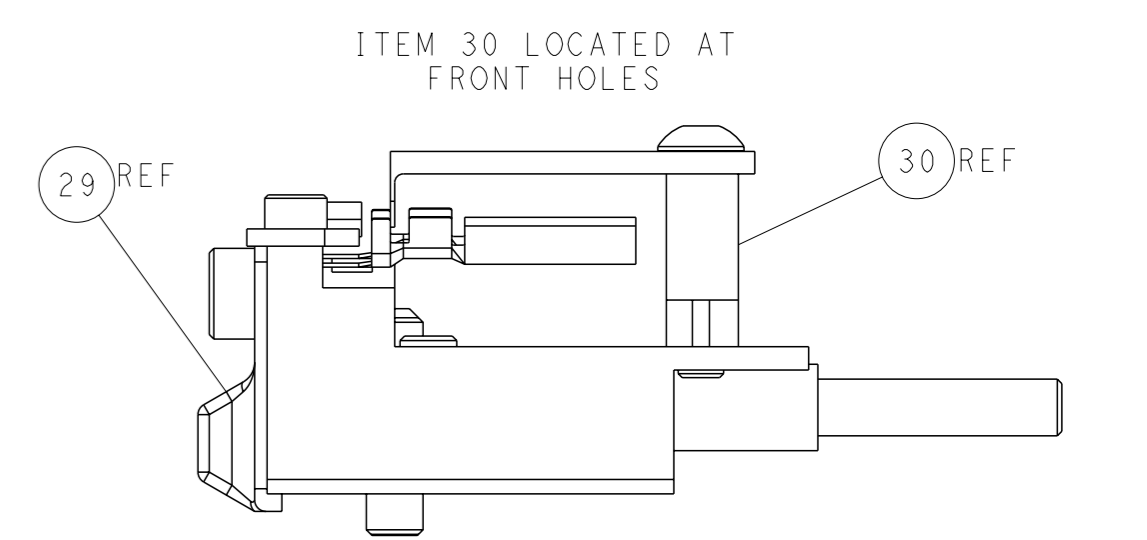
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SETUP



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 A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND ENGINEERING DESIGNATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: X. ZHAO 26NOV2013 CHK: L. ZHANG 26NOV2013 APVD: J. ELBIN 26NOV2013	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151238	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: B1
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±0.1	MATERIAL: - FINISH: -	WEIGHT: - CUSTOMER ACCESSIBLE PRODUCTION DRAWING	TE Connectivity Harrisburg, PA 17105-3608	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	
	2-2151238-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	OBSOLETE
	2-2151238-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	OBSOLETE
	2-2151238-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	OBSOLETE
	2-2151238-7	B	FINE CRIMP HEIGHT ADJUST	NONE	OBSOLETE
	7-2151238-7	A	CRIMP TOOLING KIT	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.30 mm [.130]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: SOCKET/PIN CONTACT		
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
4.70-5.50 mm [.185-.217 IN]		Ø2.26-3.30 mm [.089-.130 IN]
TERMINAL APPLICATION SPECIFICATION	114-13045	-
TERMINALS APPLIED ³		
TE TERMINAL	TE TERMINAL	TE TERMINAL
776492-1	776492-2	638078-1

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TERMINAL APPLICATION SPECIFICATION	114-13045	-
TERMINALS APPLIED ³		
TE TERMINAL	TE TERMINAL	TE TERMINAL
776493-1	776493-2	776349-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG	1.63+/-0.05 [.064+/-0.002]	5.5
16 AWG	1.55+/-0.05 [.061+/-0.002]	6.9
18 AWG	1.37+/-0.05 [.054+/-0.002]	8.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.32+/-0.05 [.052+/-0.002]	8.3
20 AWG	1.22+/-0.05 [.048+/-0.002]	9.4

REVISED	DATE	OWN	APPROV
-	-	-	-

P	LTN	DESCRIPTION	DATE	OWN	APPROV	
-	-	SEE SHEET 1	-	-	-	
-	-	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	4-1722335-3 STRIPPER, SIDE FEED	182
-	1	1	1	1	1-5018030-0 NUT, HEX, REG, RoHS, M3.5	181
-	1	1	1	1	1-1752354-6 STANDOFF, HOLD-DOWN	180
-	1	1	1	1	993111-1 PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	5-22280-0 SPRING, COMPRESSION	176
-	1	1	1	1	1752353-3 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	2-2119656-2 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	2119955-1 ASSY, LUBRICATOR, SIDE FEED	113
-	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	-	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 PNT, M3 x 4.0	62
-	-	-	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	-	1338685-1 PAWL, FEED	56
-	2	2	2	2	2-2168083-5 SCR, SKT HD CAP, RoHS, M4 X 14	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	-	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	1-2119644-2 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	1-1320908-2 SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-1 ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-4 SPACER, CRIMPER	28
-	1	1	1	1	1320928-2 STRIP GUIDE	24
-	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	1633133-8 ANVIL, COMBINATION .100	8
-	1	1	1	1	240641-5 SPACER	7
-	-	-	-	-	-	6
-	1	1	1	1	1-2119780-1 DEPRESSOR, SHEAR	5
-	1	1	1	1	4-238011-1 BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1-1803019-9 CRIMPER, INSULATION O	3
-	1	1	1	1	455888-5 SPACER, CRIMPER	2
-	1	1	1	1	2-456407-0 CRIMPER, WIRE PREMIUM	1

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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: 8-2151238-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151238-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151238-5
- 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 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 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.
- THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.
- TERMINAL LUBRICANT IS RECOMMENDED.

***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.

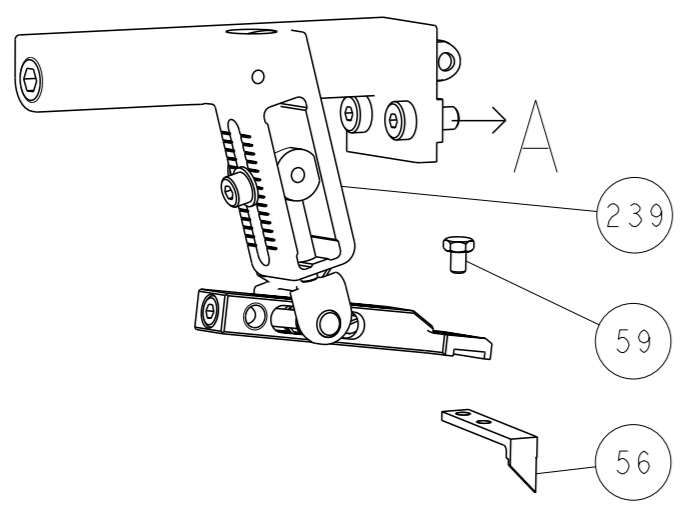
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	-	2079988-1	BUSHING, LCH5-12, MJSUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	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
-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)

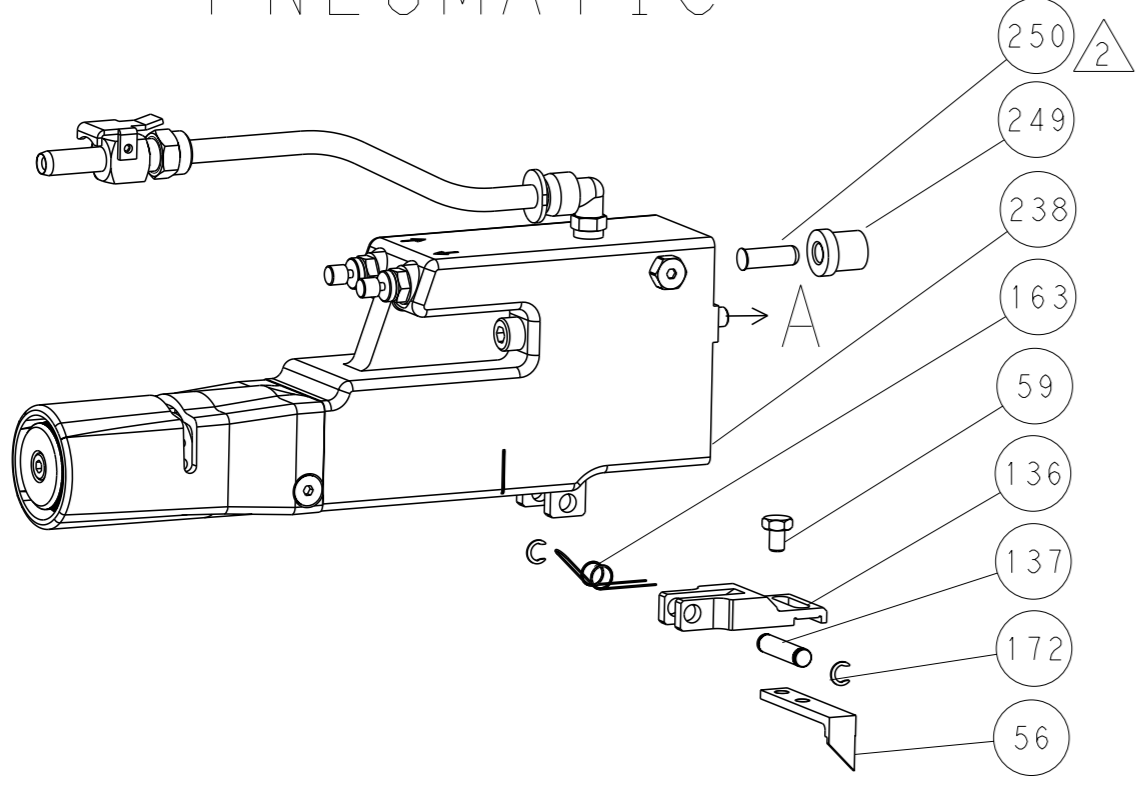
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mm	0 PLC ±0.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001	26NOV2013	X ZHAO	TE Connectivity Harrisburg, PA 17105-3608	A1	00779	©=2151238	-
MATERIAL:	FINISH	26NOV2013	L ZHANG	Ocean Side Feed Applicator	SCALE	1:2	SHEET 3 of 4	REV B1

REVISONS		DATE	OWN	APVD
LOC	DIST			
A	66			
P	LYR			
		DESCRIPTION		
		SEE SHEET 1		

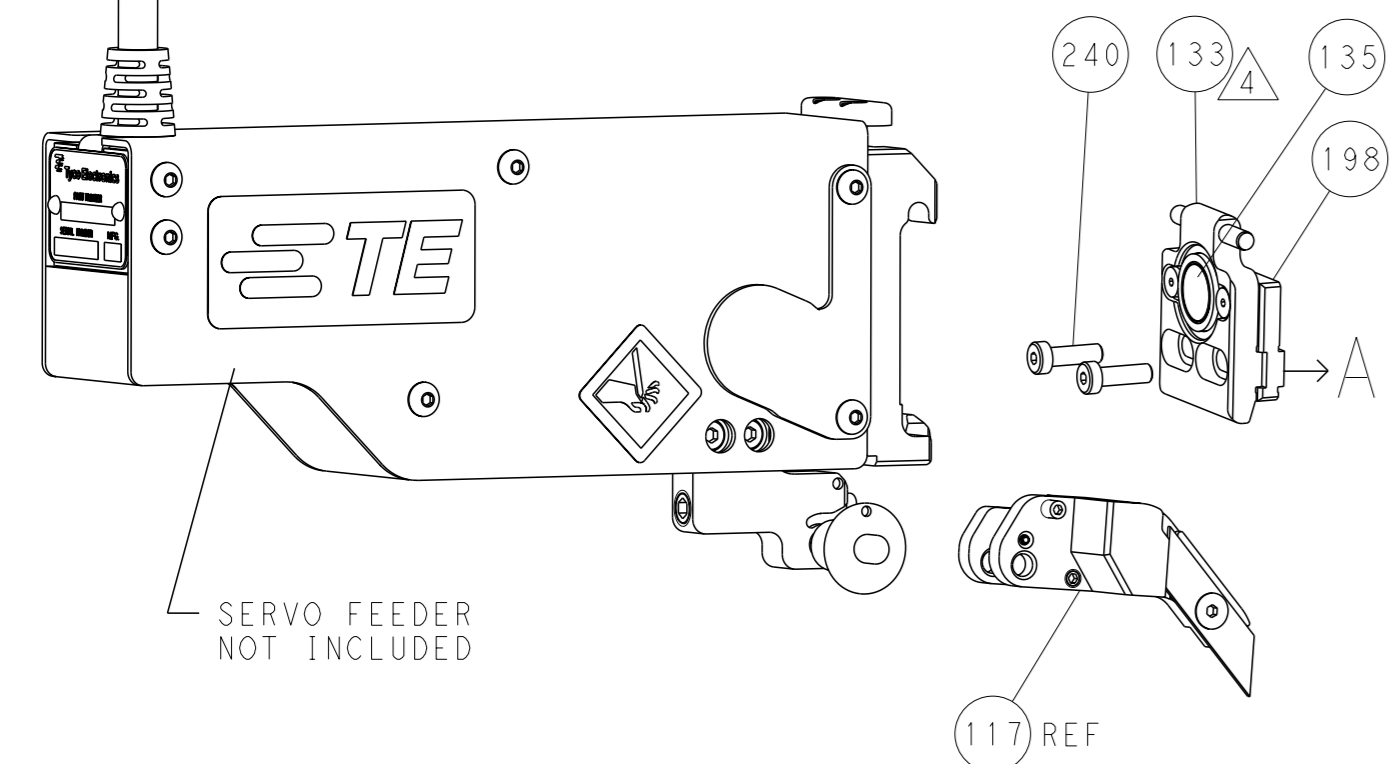
FEED TYPE MECHANICAL



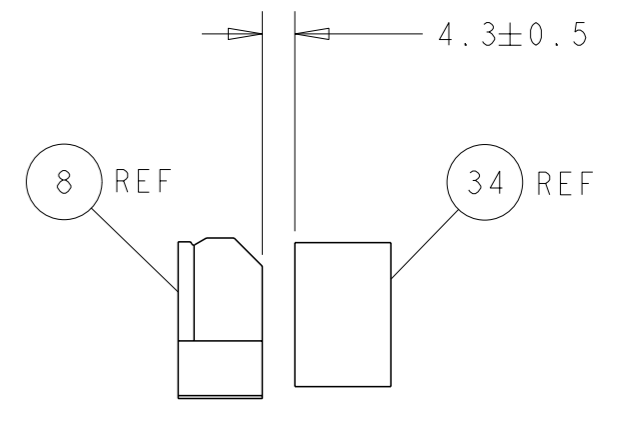
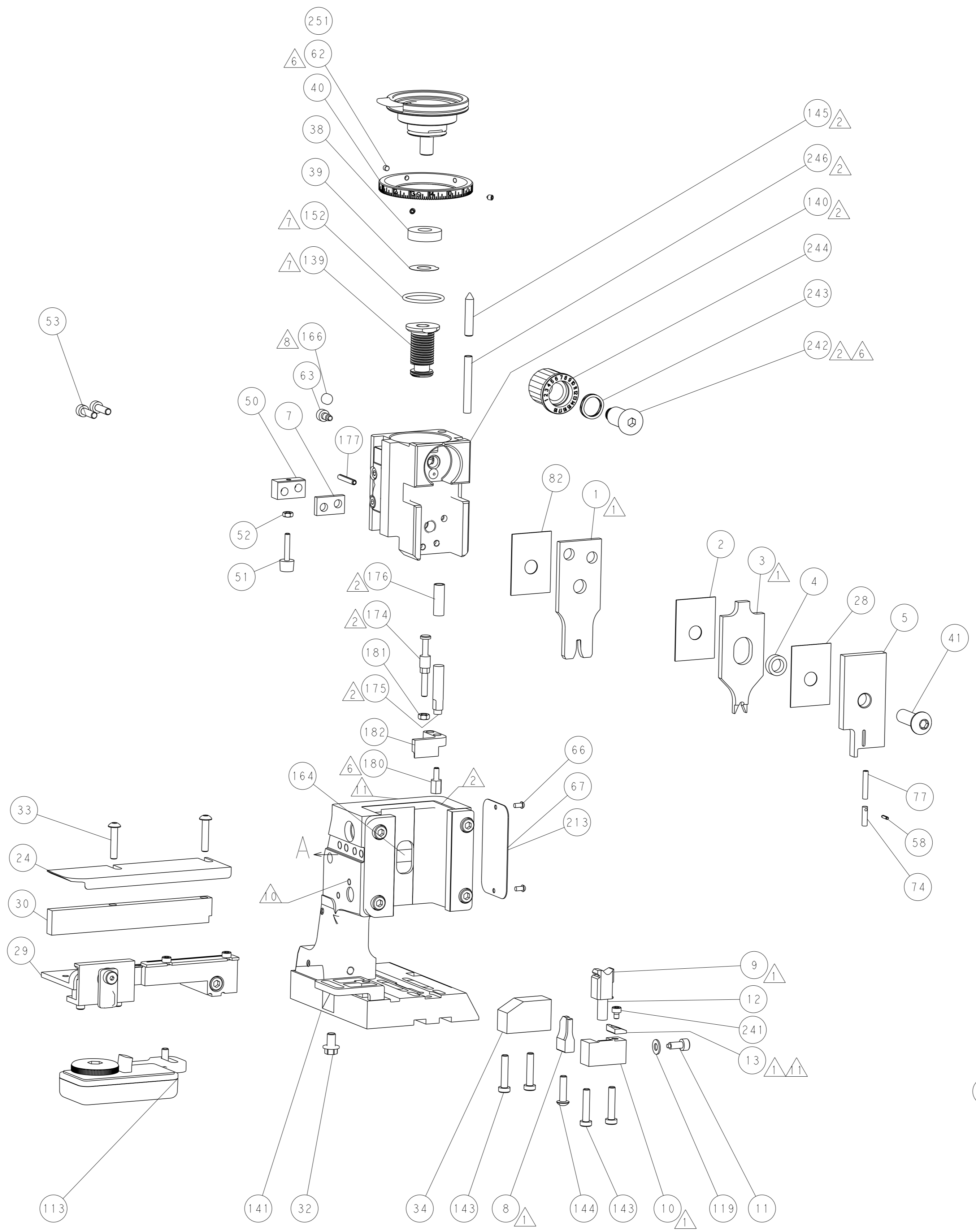
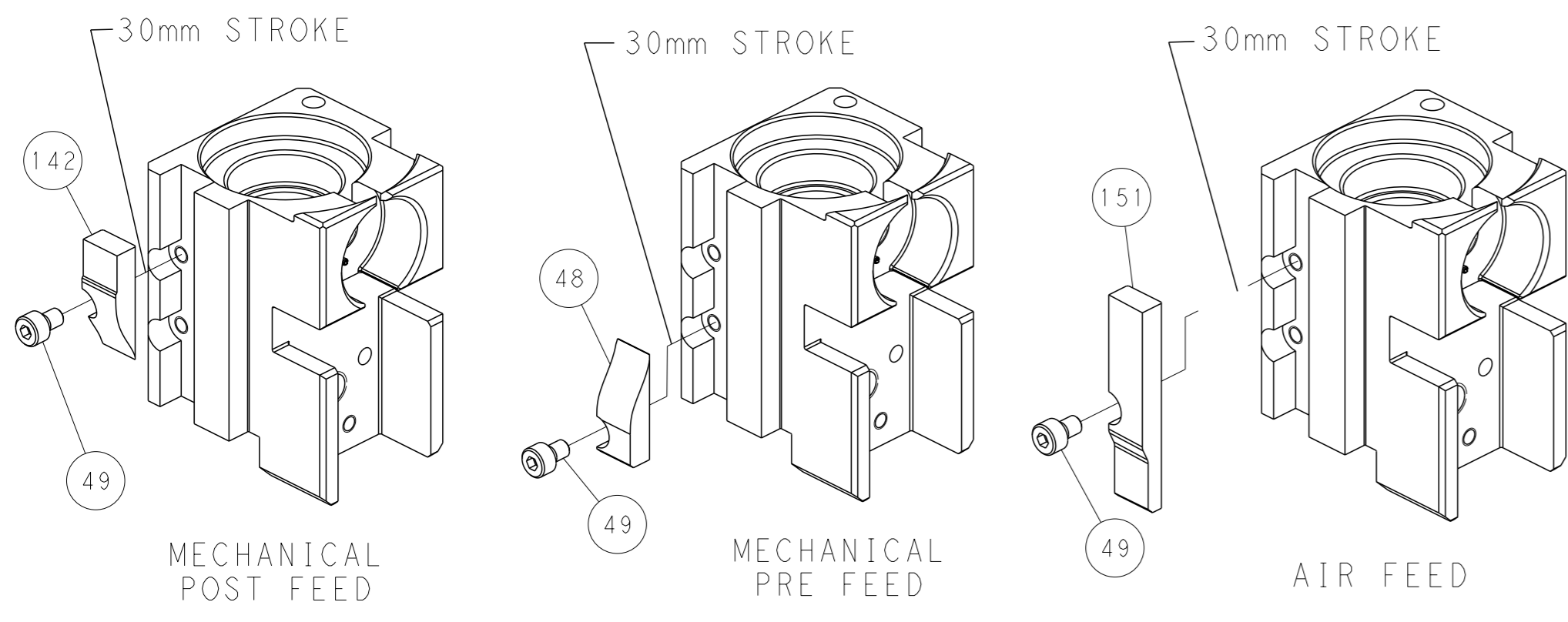
PNEUMATIC



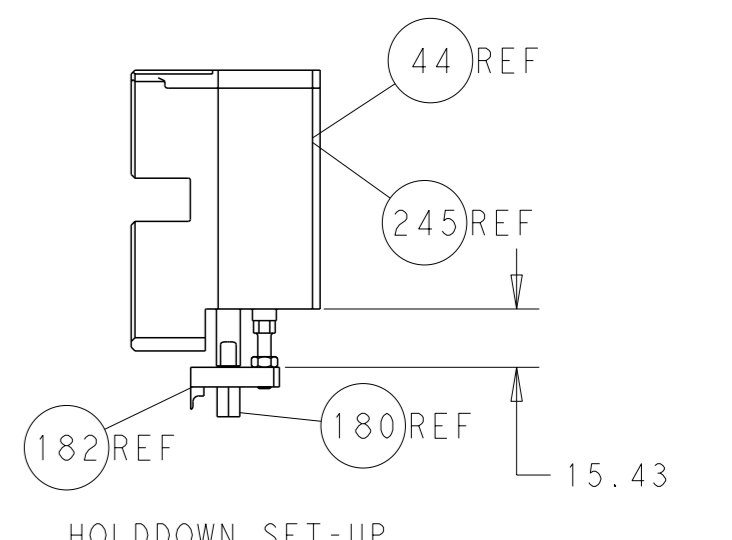
SERVO LATCH PLATE



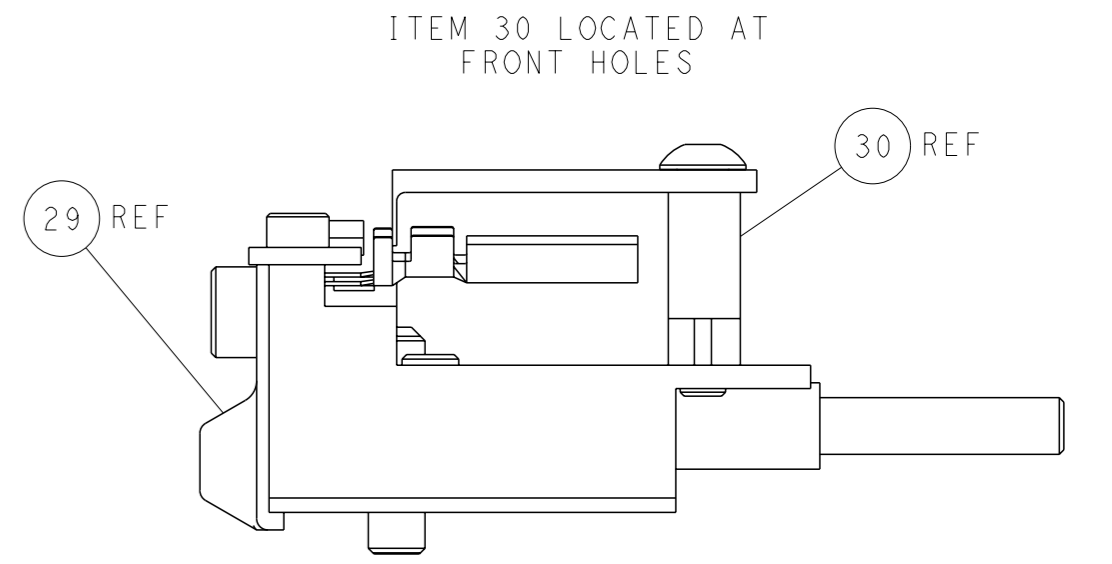
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES FINISH ±.		DWN X_ZHAO 26NOV2013 CHK L_ZHANG 26NOV2013 APVD T_ELFIN 26NOV2013 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. RESTRICTED TO A1 00779 ©=2151238 Customer Accessible Production Drawing SCALE 1:2 SHEET 4 of 4 REV B1	
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