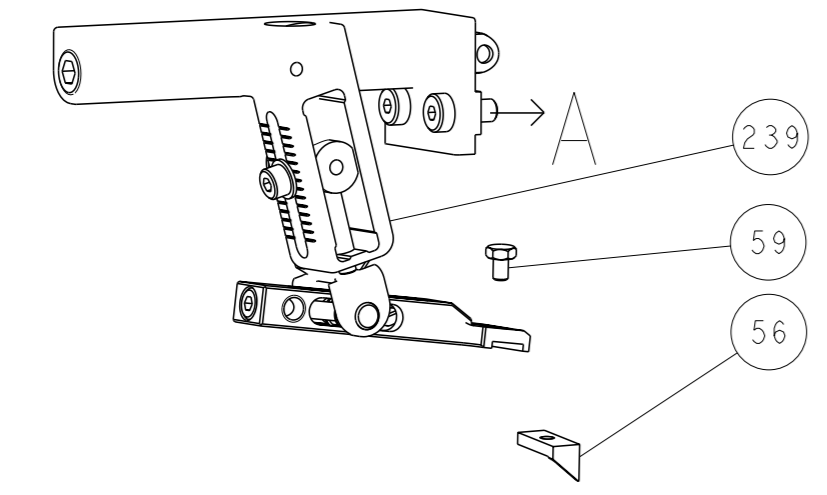
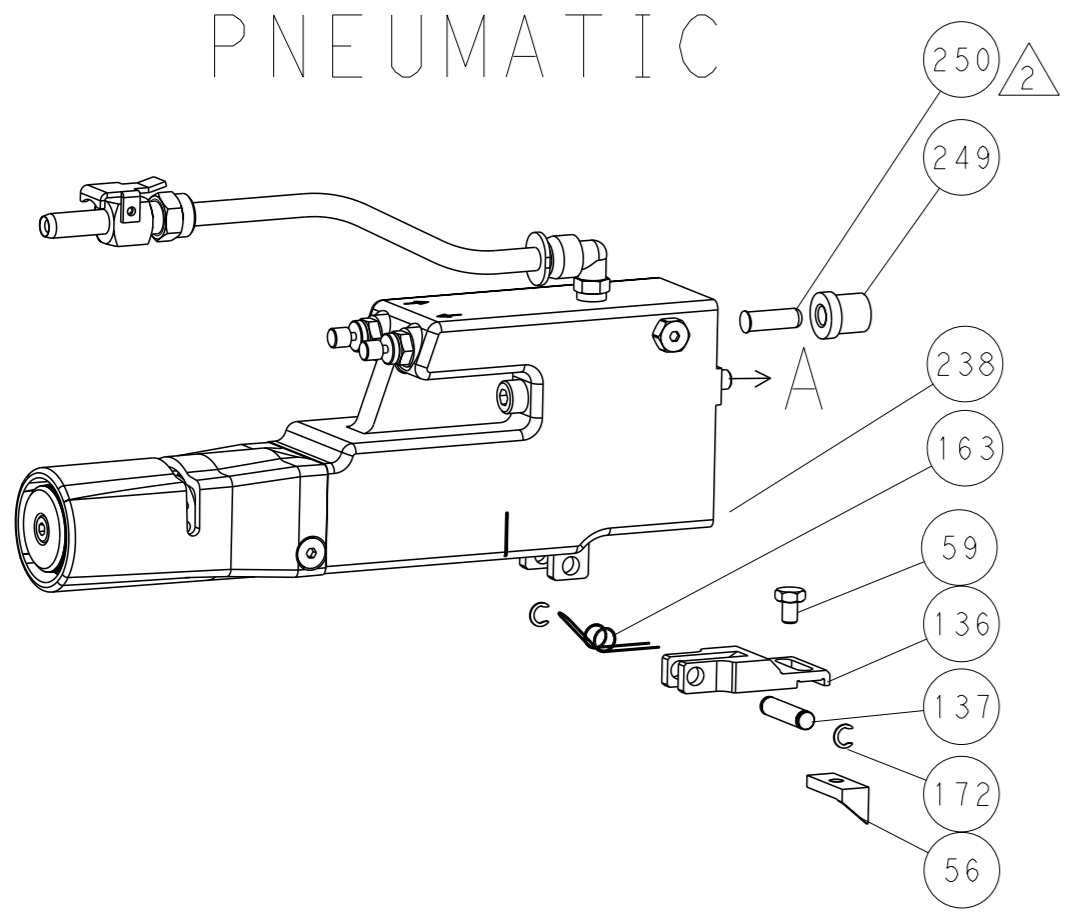


LOC		DIST		REVISONS			
A	66	P	LYR	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

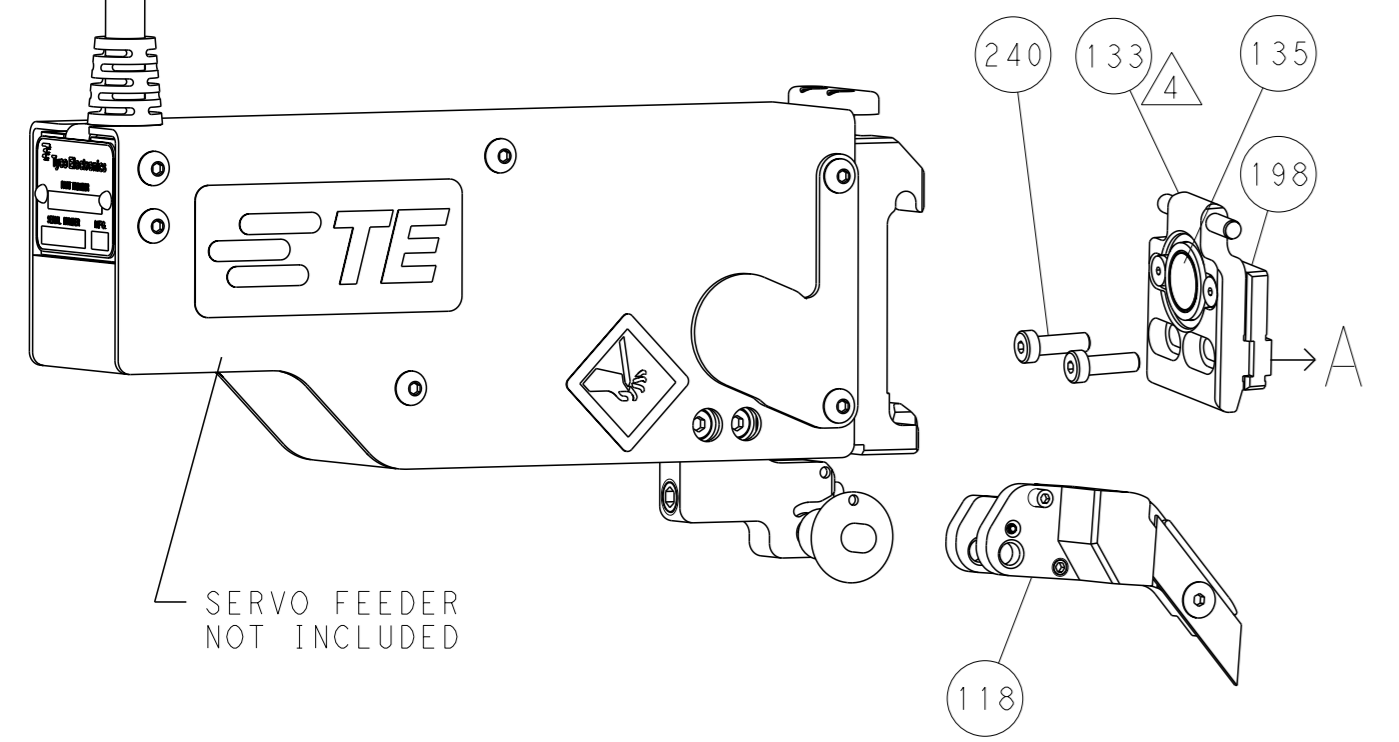
FEED TYPE MECHANICAL



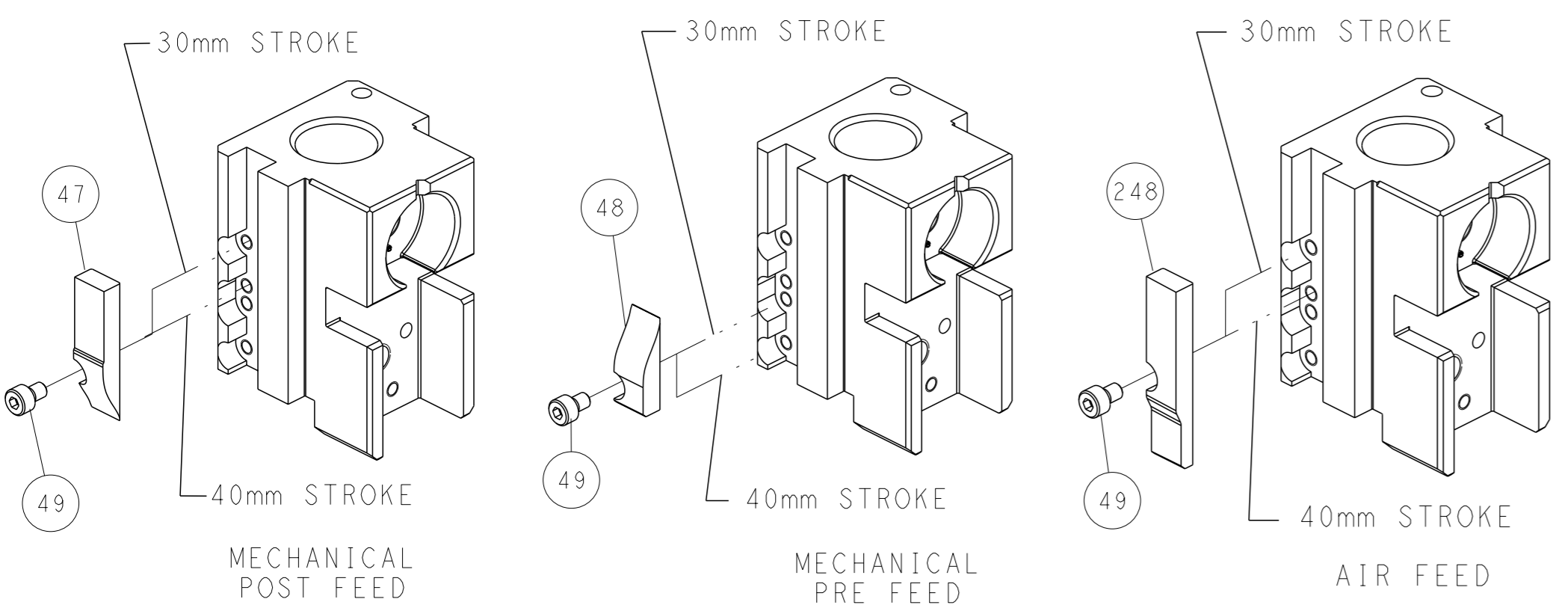
PNEUMATIC



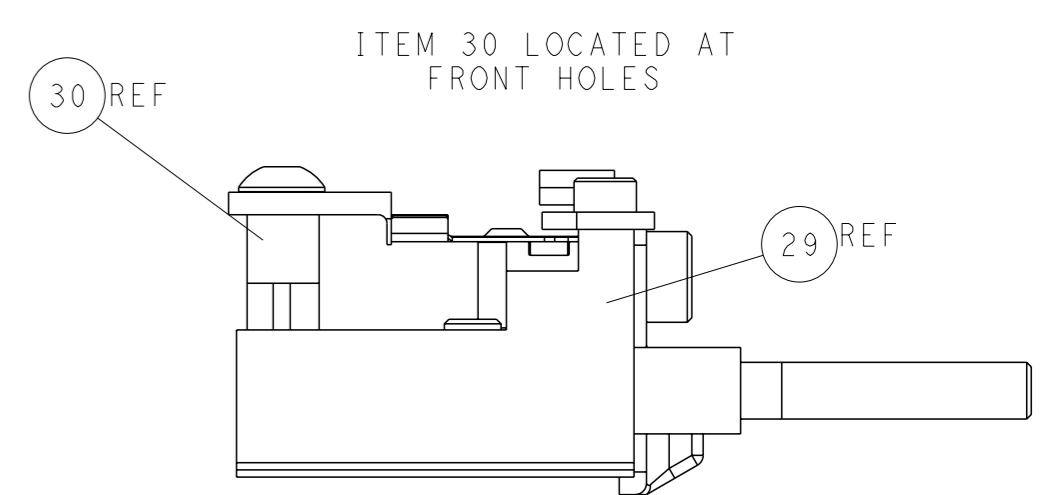
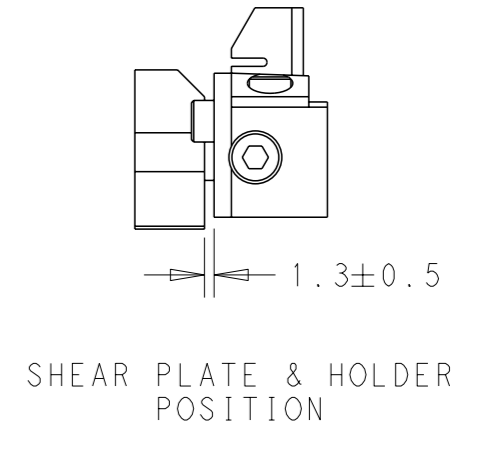
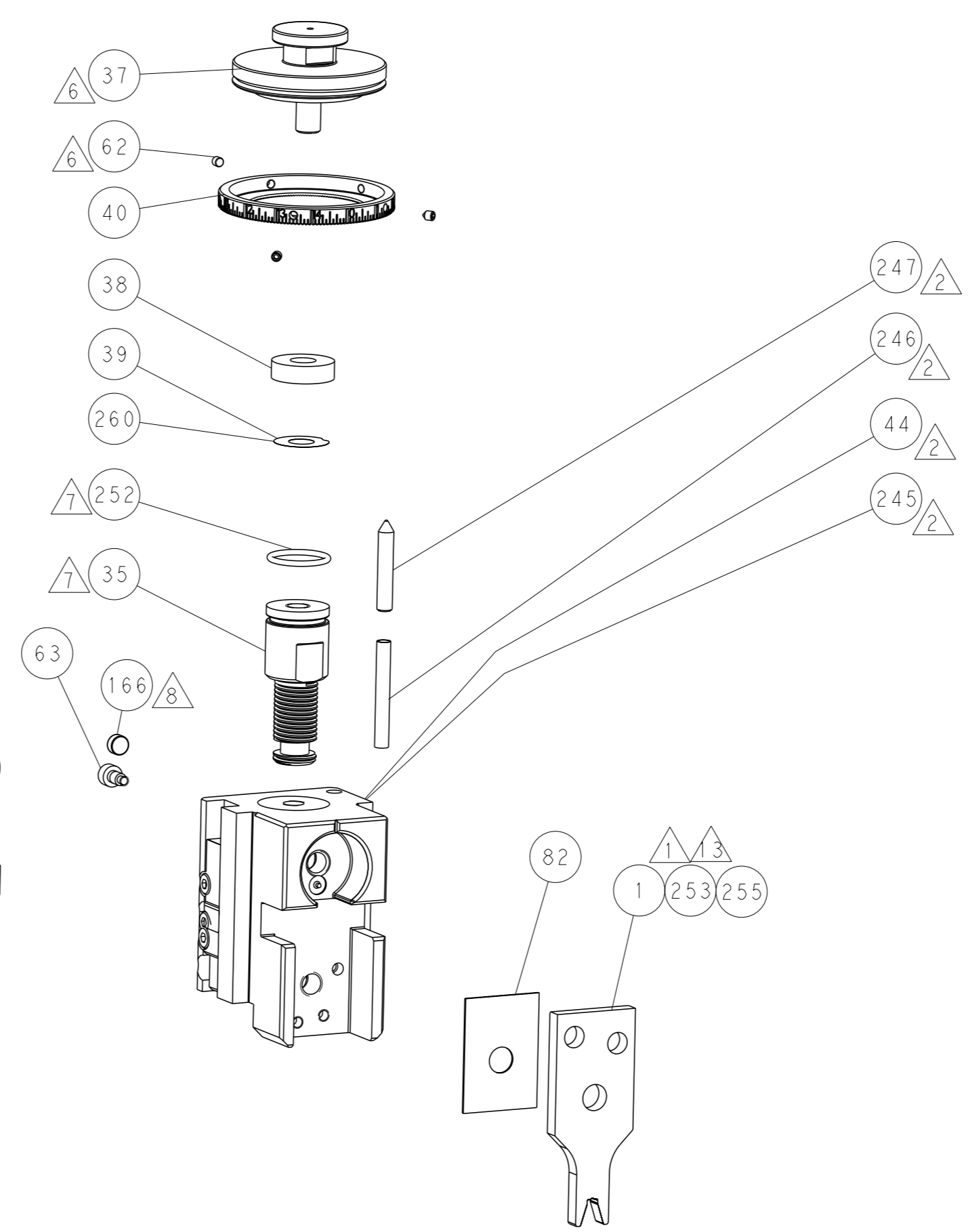
SERVO LATCH PLATE



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		OWN: R. CLIFFORD 25APR2013 CHK: T. ELBIN 25APR2013 APVD: M. CLIFFORD 25APR2013 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2151914 SCALE: 1:2 SHEET: 2 of 4 REV: B		RESTRICTED TO:	
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION									

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO		PART NUMBERS REQUIRED				
					PNEUMATIC FEED	SERVO LATCH PLATE	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1
	2-2151914-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	1901092-1	8-2151914-5	1901094-3	1-1752354-1	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151914-4	-	-	-
	2-2151914-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	1901092-1	8-2151914-5	1901094-3	1-1752354-1	2168400-6 (QUANTITY 2)
	2-2151914-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
	2-2151914-7	B	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	7-2151914-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.82 mm [1.50]	SP
INSUL	-	-
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: SUMIKOU TECH TERMINAL SEE TABLE CRIMP SPECIFICATION	
TERMINAL NAME: RING TERMINAL	
WIRE STRIP LENGTH 0.17-0.19 mm [0.007-0.007 IN]	INSULATION DIAMETER RANGE ∅0.55-0.75 mm [0.022-0.030 IN]
TERMINAL APPLICATION SPECIFICATION	SEE TABLE Rev BELOW
TERMINALS APPLIED	
TE TERMINAL 2113330-1	SUMIKOU TECH TERMINAL 950100-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING ⁹	WIRE CRIMPER	CRIMP SPECIFICATION
0.75 mm MAG WIRE	1.35 +/- 0.030 [0.0531 +/- 0.0012]	4.9	1803102-1	TE ENGINEERING
0.70 mm MAG WIRE	1.30 +/- 0.030 [0.0512 +/- 0.0012]	7.1	1803102-1	TE ENGINEERING
0.65 mm MAG WIRE	1.25 +/- 0.030 [0.0492 +/- 0.0012]	8.9	1803102-1	SUMIKOU TECH A1834
0.60 mm MAG WIRE	1.20 +/- 0.025 [0.0472 +/- 0.0010]	8.7	1803102-2	TE ENGINEERING
0.55 mm MAG WIRE	1.15 +/- 0.025 [0.0453 +/- 0.0010]	9.6	1803102-2	SUMIKOU TECH A2268
0.45 mm MAG WIRE	1.08 +/- 0.025 [0.0425 +/- 0.0010]	7.9	1803102-3	SUMIKOU TECH A2151

- RECOMMENDED SPARE PARTS
- 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: 8-2151914-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151914-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151914-5
- 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.
- 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 USE WIRE CRIMPER LISTED IN CHART FOR DESIGNATED MAG WIRE SIZE.
- ¹³ ITEM NOT SHOWN.

REVISONS	DATE	OWN	APVD
1	SEE SHEET 1	-	-

REV	QTY	DESCRIPTION	DATE	OWN	APVD
-	-	1901094-3			198
-	-	1976043-1			180
-	-	21045-3			172
-	-	994969-1			166
-	REF	994970-2			164
-	-	240638-1			163
-	-	8-21084-1			152
-	-	2119641-2			151
-	-	2119798-2			145
-	-	2079383-8			144
-	-	2168400-5			143
-	-	2119653-2			142
-	-	1-2119656-0			141
-	-	2119650-1			140
-	-	2119092-2			139
-	-	3-23627-7			137
-	-	2119799-1			136
-	-	SEE NOTE 4			135
-	-	1633743-1			133
-	-	1-22281-8			121
-	-	1901092-1			118
-	-	1-690438-0			96
-	-	2168083-1			95
-	-	2168083-6			93
-	-	455888-5			82
-	-	1-240641-0			81
-	-	1962431-2			77
-	-	1803104-1			74
-	-	2119956-1			71
-	-	2119740-1			67
-	-	2168078-1			66
-	-	2119793-1			63
-	-	992763-3			62
-	-	2-18032-5			61
-	-	5-18022-5			59
-	-	21028-2			58
-	-	1338683-1			56
-	-	2168400-1			54
-	-	2168083-8			53
-	-	18023-9			49
-	-	2119652-1			48
-	-	2079383-7			41
-	-	2119645-1			40
-	-	2119957-1			39
-	-	2119644-1			38
-	-	2079383-8			33
-	-	2161328-1			32
-	-	1-1320908-6			30
-	-	1803089-1			29
-	-	2-455888-1			28
-	-	22283-1			27
-	-	356835-1			26
-	-	240792-1			25
-	-	1633630-2			24
-	-	980371-4			21
-	-	1803105-1			19
-	-	690518-1			18
-	-	690463-1			17
-	-	1-2168083-1			16
-	-	690464-1			15
-	-	2119862-1			14
-	-	2280441-1			13
-	-	3-22280-3			12
-	-	1803103-1			10
-	-	-			9
-	-	1-1633933-7			8
-	-	-			7
-	-	690468-1			6
-	-	2119780-1			5
-	-	-			4
-	-	-			3
-	-	-			2
-	-	1803102-1			1

*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.

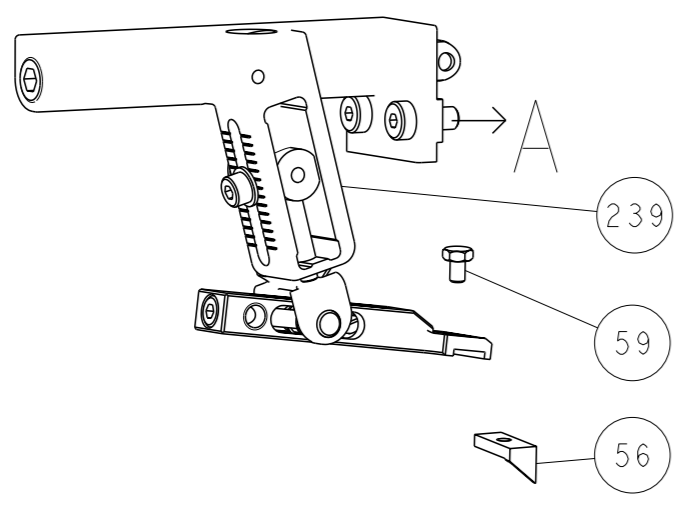
1	1	1	1	1	1803102-3	CRIMPER, WIRE	255
1	1	1	1	1	1803102-2	CRIMPER, WIRE	253
-	-	-	-	-	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	-	1-22279-3	SPRING, COMPRESSION	246
-	-	-	-	-	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	-	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	-	2063440-1	AIR FEED MODULE	238
-	-	-	-	-	356885-4	STOP, SHEAR	237
-	-	-	-	-	2119740-2	TAG, IDENTIFICATION	213

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

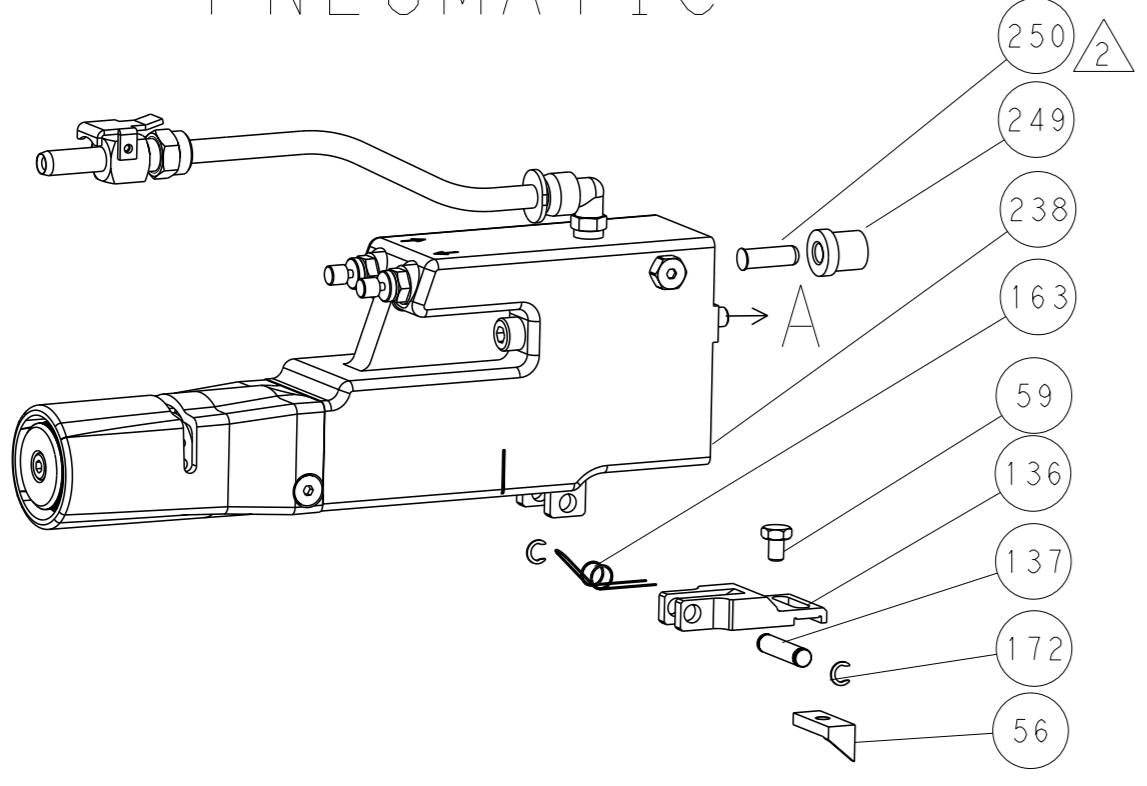
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		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		CHK: T. ELBIN 25APR2013	
MATERIAL		FINISH		APVD: M. CLIFFORD 25APR2013	NAME: Ocean Side Feed Applicator
				PRODUCT SPEC	SIZE: A1
				APPLICATION SPEC	CAGE CODE: 00779
				WEIGHT	DRAWING NO: 2151914
					RESTRICTED TO: -
					Customer Accessible Production Drawing
					SCALE: 1:2 SHEET 3 of 4 REV B

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

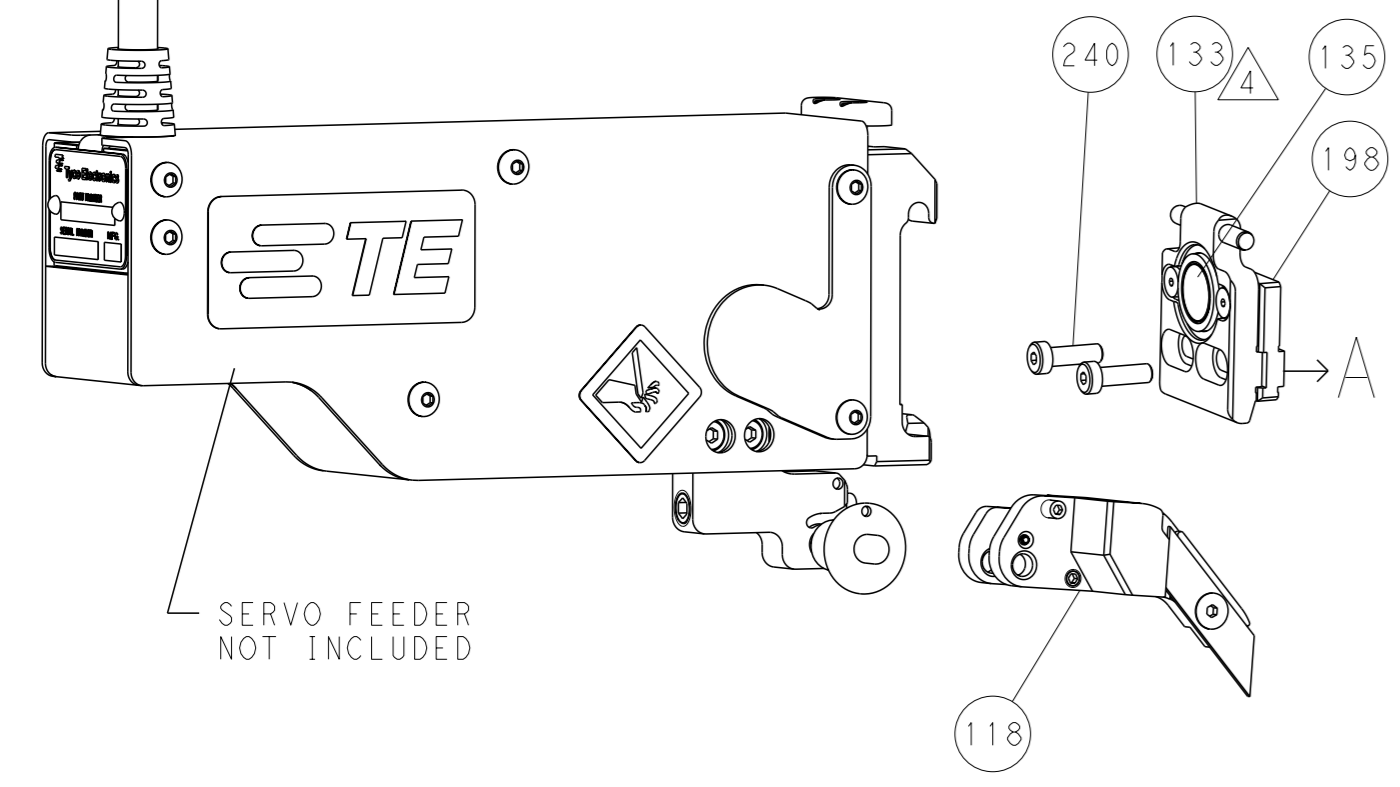
FEED TYPE MECHANICAL



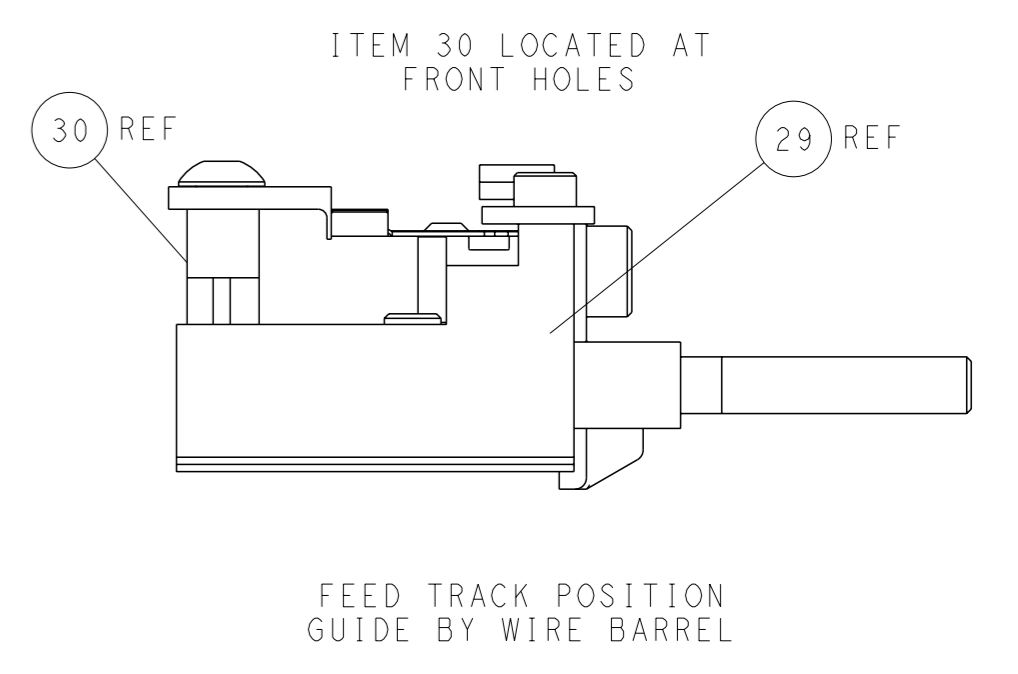
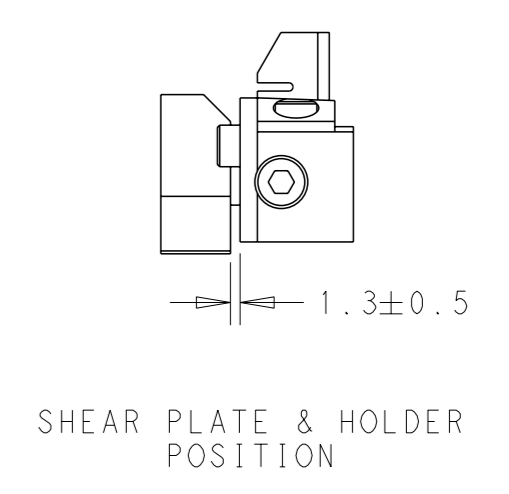
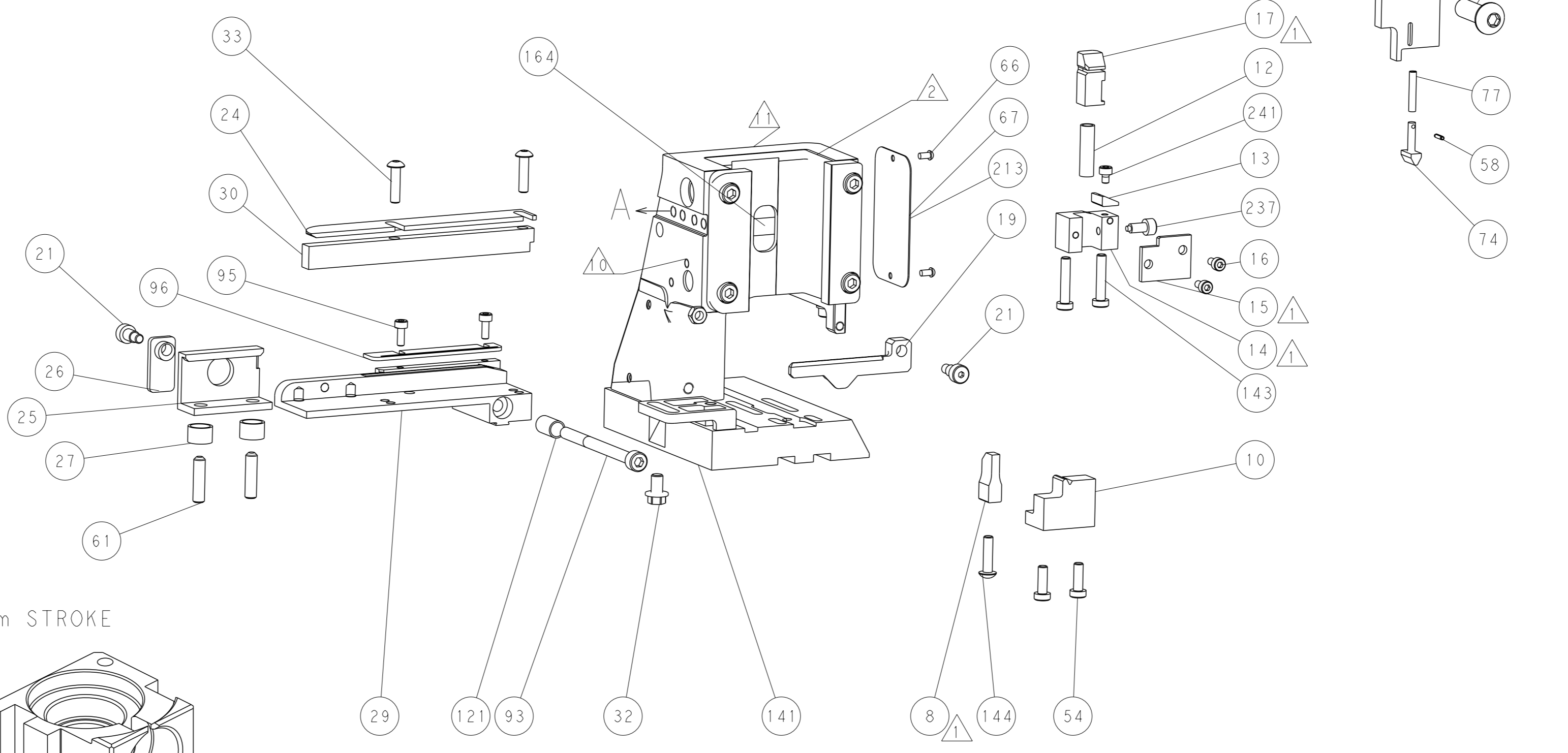
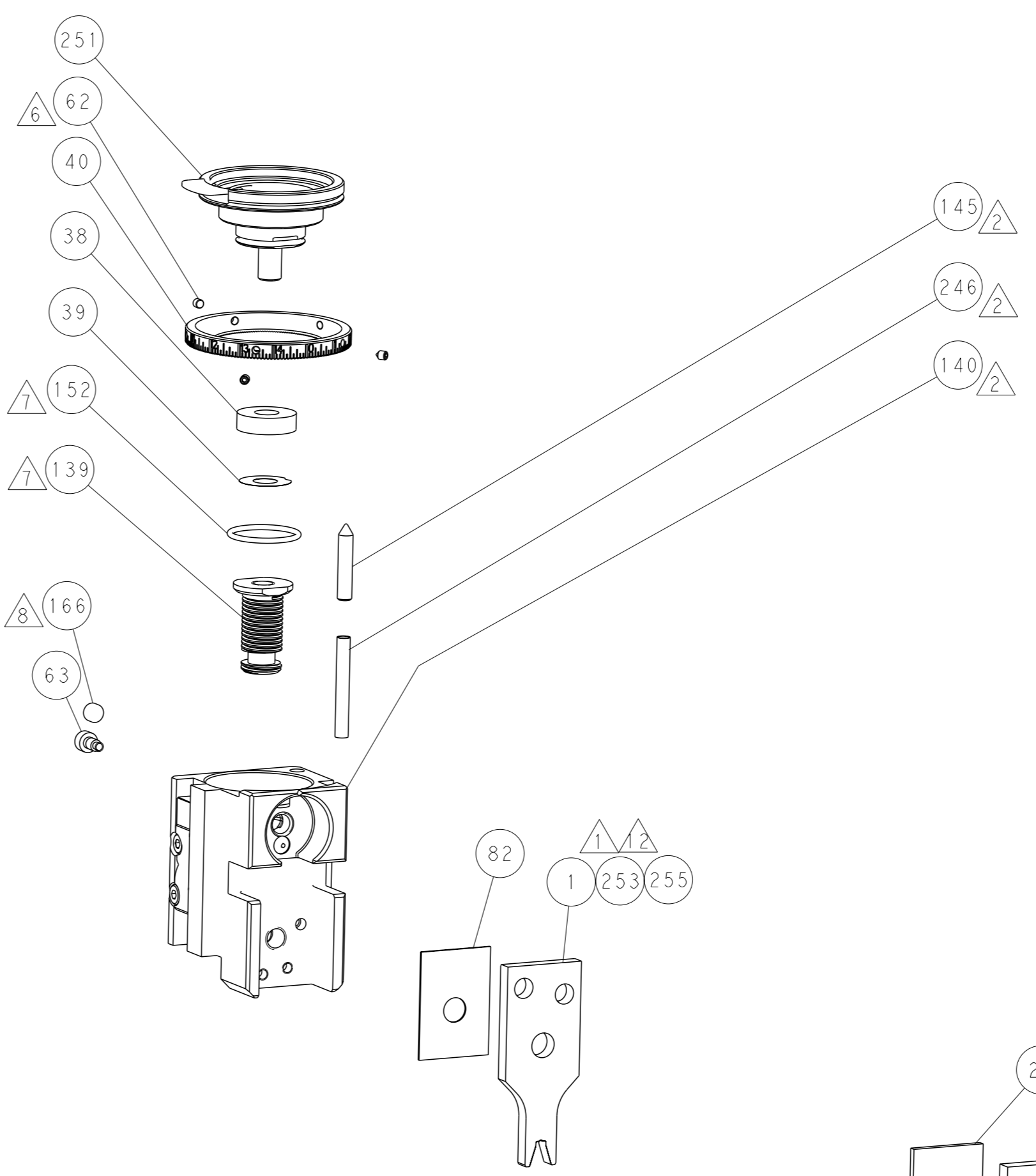
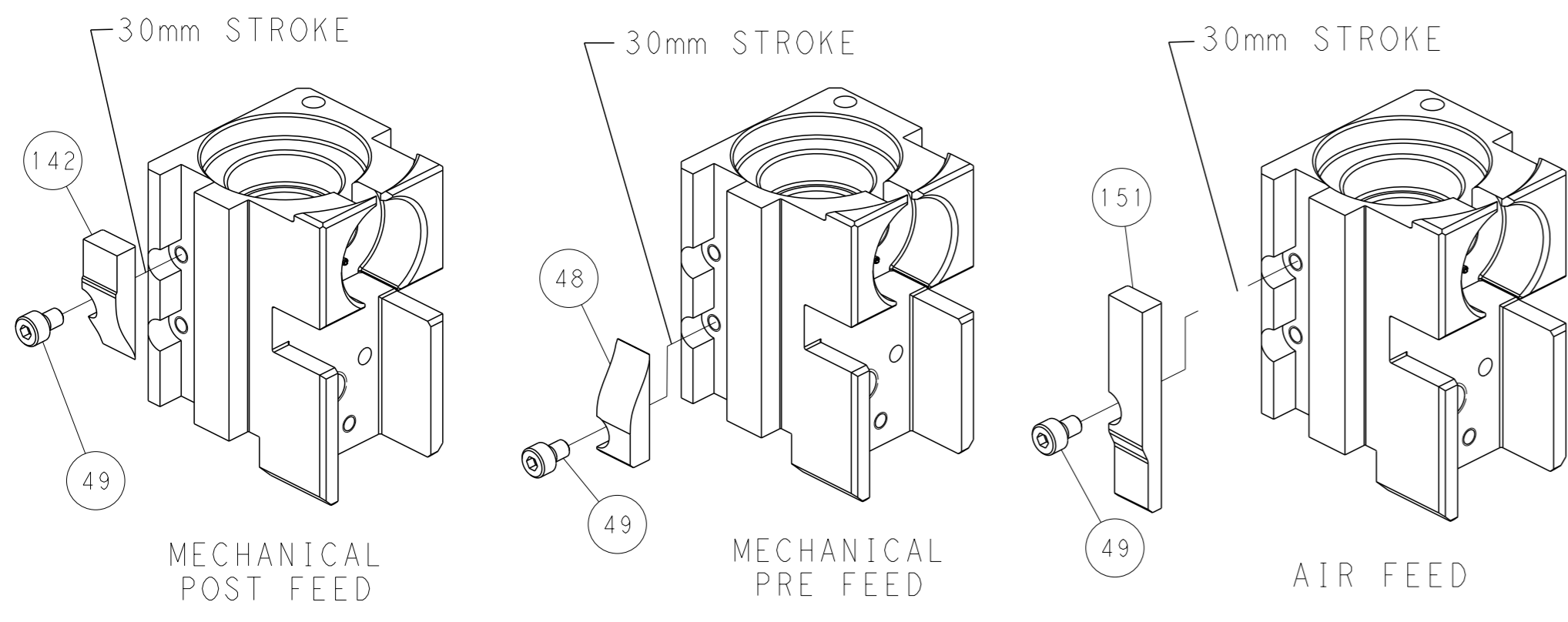
PNEUMATIC



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: R. CLIFFORD 25APR2013 CHK: T. ELBIN 25APR2013 APVD: M. CLIFFORD 25APR2013	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151914	RESTRICTED TO: B
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±	WEIGHT: - SCALE: 1:2 SHEET: 4 of 4 REV: B	Customer Accessible Production Drawing		