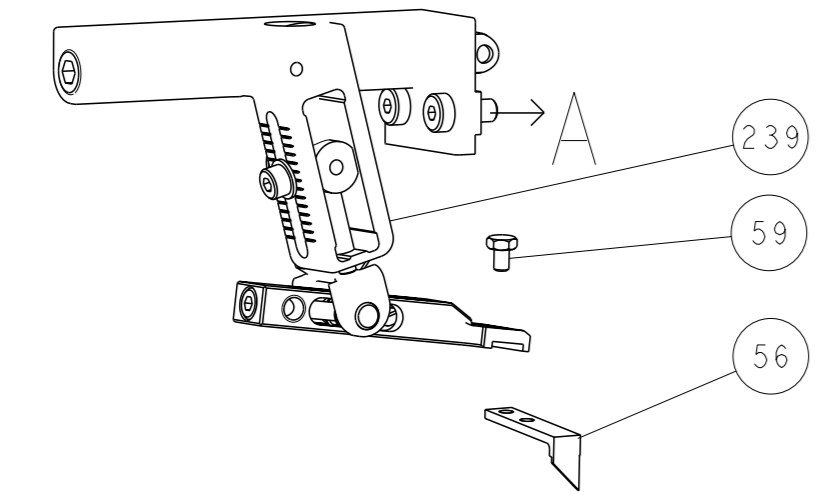
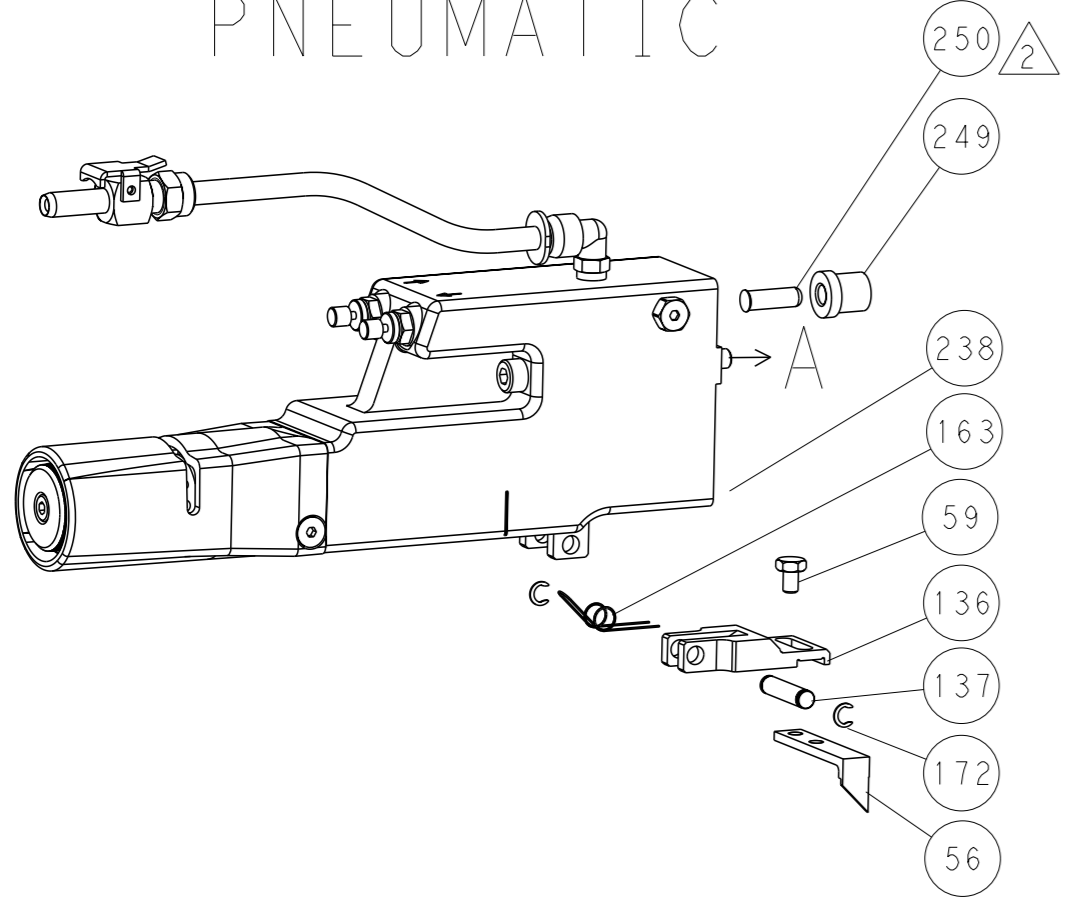


LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
-	SEE SHEET 1	-	-	-	-

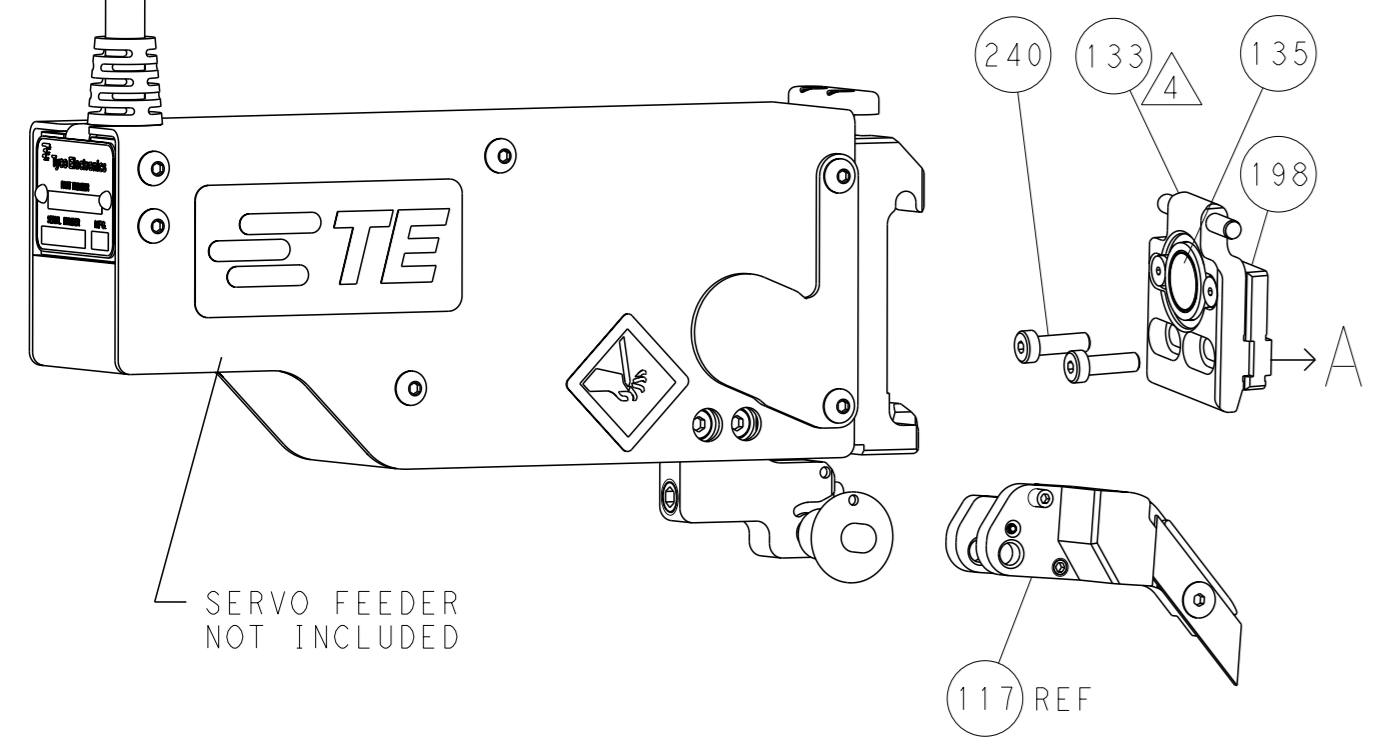
FEED TYPE MECHANICAL



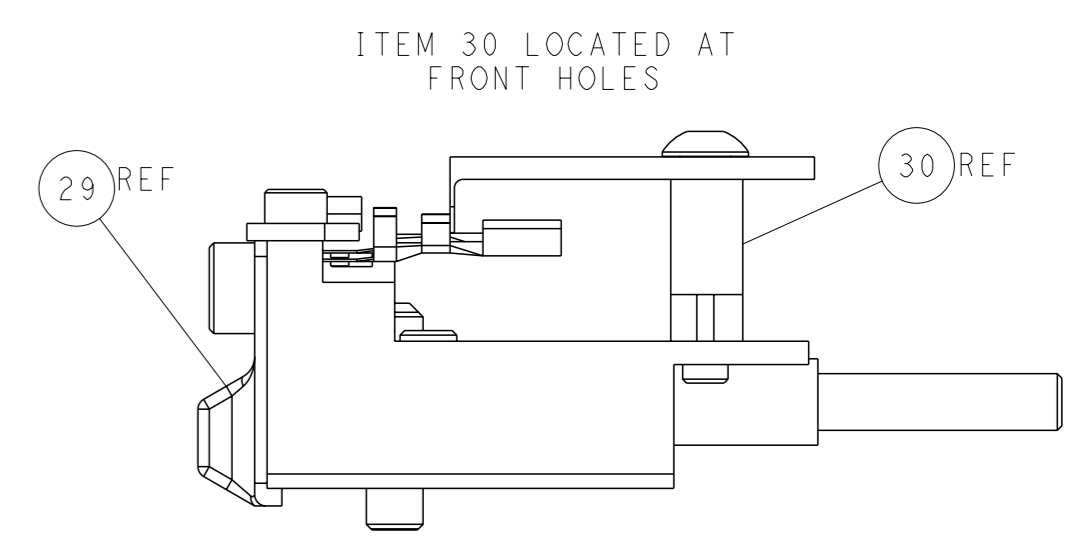
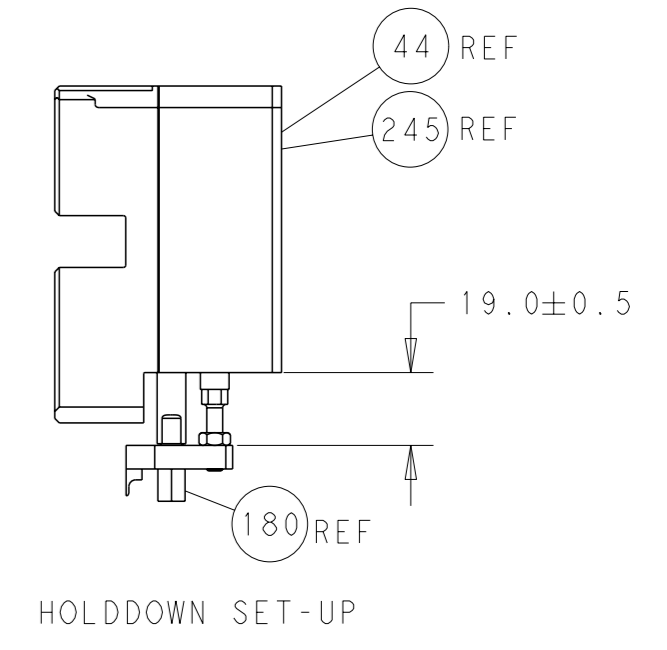
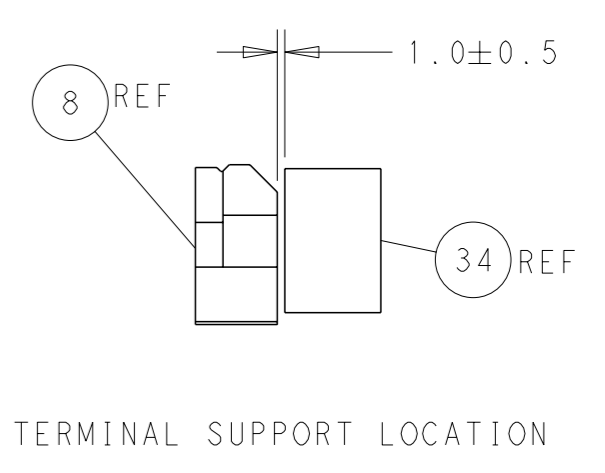
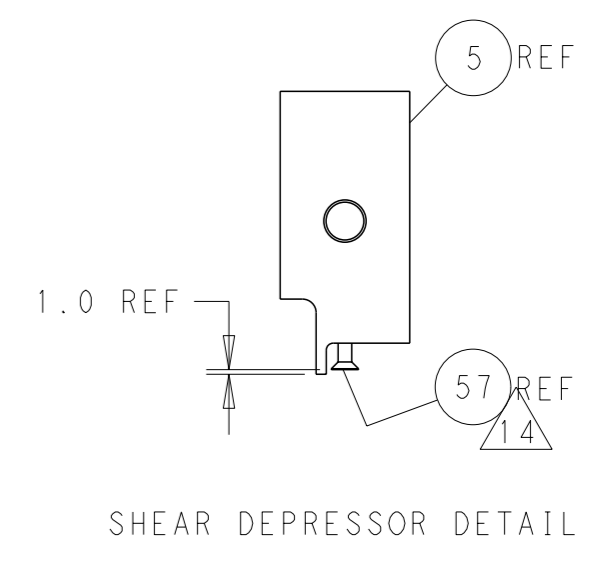
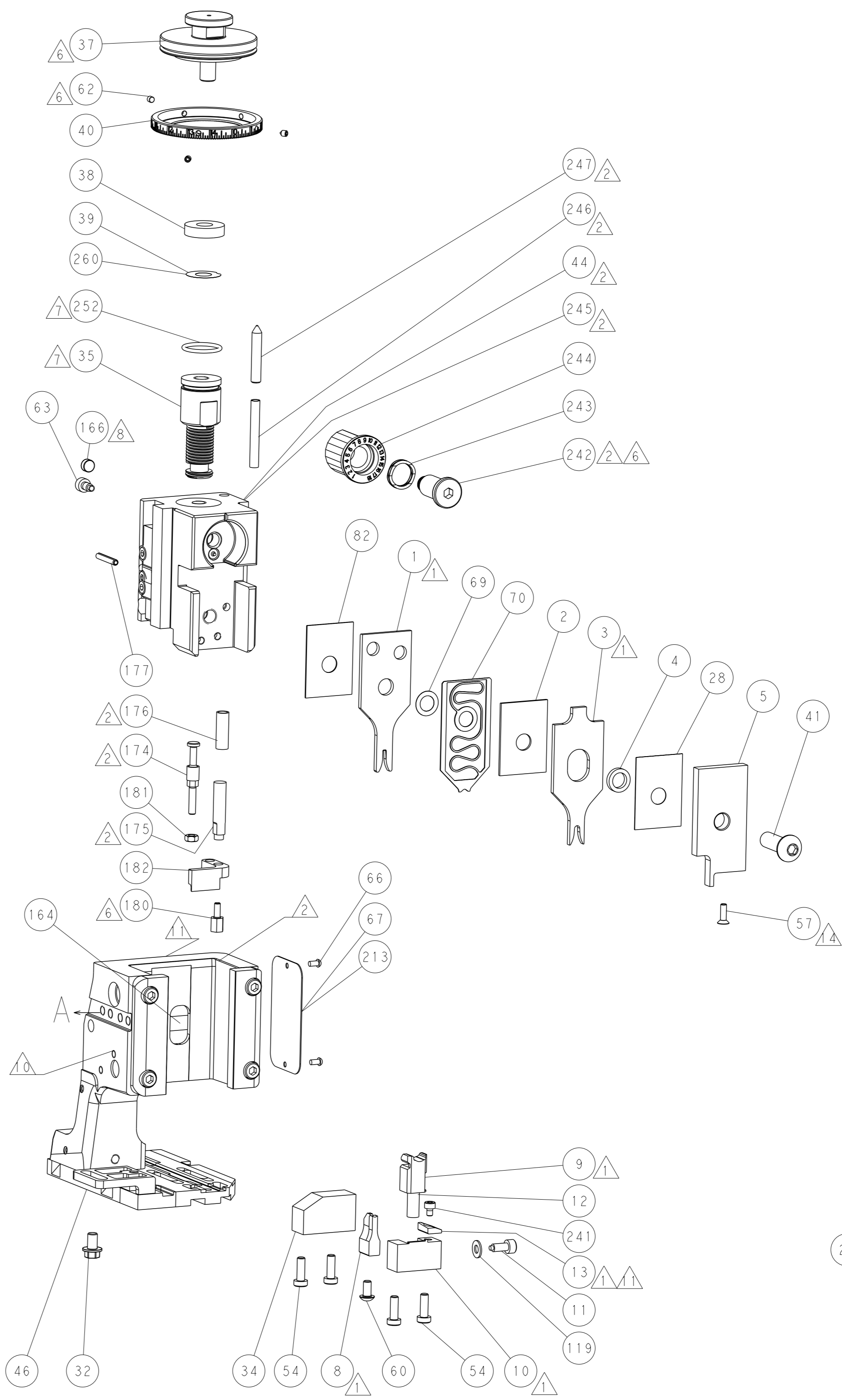
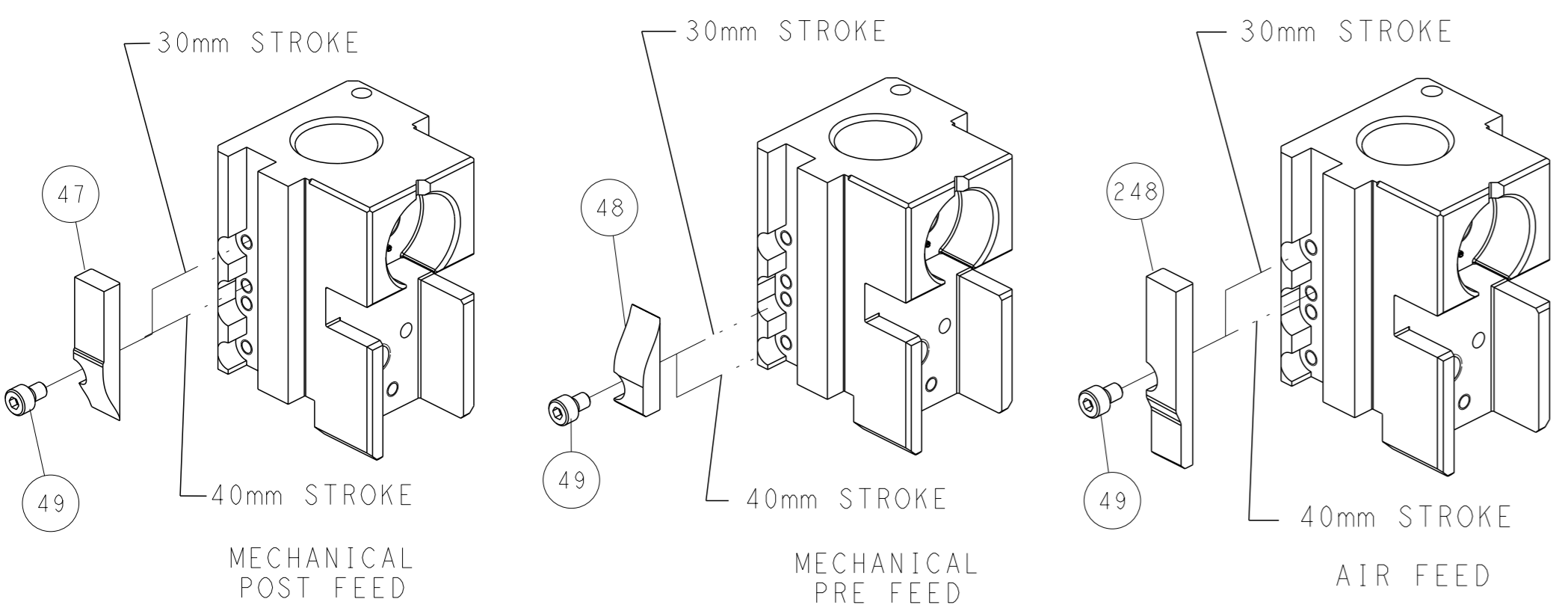
PNEUMATIC



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)

<small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROL AND REVISIONS ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		OWN: Y. YIN 12OCT2013 CHK: G. BAILEY 12OCT2013 APVD: H. GUO 12OCT2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2151459	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: C2
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. BY TYCO ELECTRONICS CORPORATION, ALL RIGHTS RESERVED.

Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE. Rows include: 2-2151459-1 C FINE CRIMP HEIGHT ADJUST MECHANICAL OBSOLETE, 2-2151459-2 C FINE CRIMP HEIGHT ADJUST PNEUMATIC OBSOLETE, 2-2151459-5 C FINE CRIMP HEIGHT ADJUST SERVO LATCH PLATE OBSOLETE, 2-2151459-7 C FINE CRIMP HEIGHT ADJUST NONE OBSOLETE, 7-2151459-7 B CRIMP TOOLING KIT.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Includes: WIRE 1.63 mm [.064] F, INSUL 3.05 mm [1.20] O. Also includes APPLICATOR INSTRUCTIONS 408-10389.

TERMINAL DATA: KOSTAL TERMINAL KOSTAL CRIMP SPECIFICATION. Includes: WIRE STRIP LENGTH 2.80-3.40 mm [.110-.134 IN], INSULATION DIAMETER RANGE Ø1.65-2.10 mm [.065-.083 IN].

TERMINALS APPLIED table with columns: TE TERMINAL, KOSTAL TERMINAL, TE SEAL, KOSTAL SEAL. Lists various terminal part numbers and their corresponding KOSTAL terminal and seal part numbers.

WIRE SIZE table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Rows for 1.00mm2, 18 AWG, 0.75mm2.

- 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.
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 & 180.
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.
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.

TERMINAL DATA: KOSTAL TERMINAL KOSTAL CRIMP SPECIFICATION. Includes: WIRE STRIP LENGTH 2.80-3.40 mm [.110-.134 IN], INSULATION DIAMETER RANGE Ø1.40-1.90 mm [.055-.075 IN].

TERMINALS APPLIED table with columns: TE TERMINAL, KOSTAL TERMINAL, TE SEAL, KOSTAL SEAL. Lists various terminal part numbers and their corresponding KOSTAL terminal and seal part numbers.

WIRE SIZE table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Rows for 0.75mm2, 20 AWG, 0.50mm2.

- *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.
THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Rows include: 2119782-1 FINE ADJUST HEAD ASM, PACIFIC STYLE 251, 2119640-1 PUSH ROD, AIR FEED 250, 2079988-1 BUSHING, LCH5-12, MISUMI 249.

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

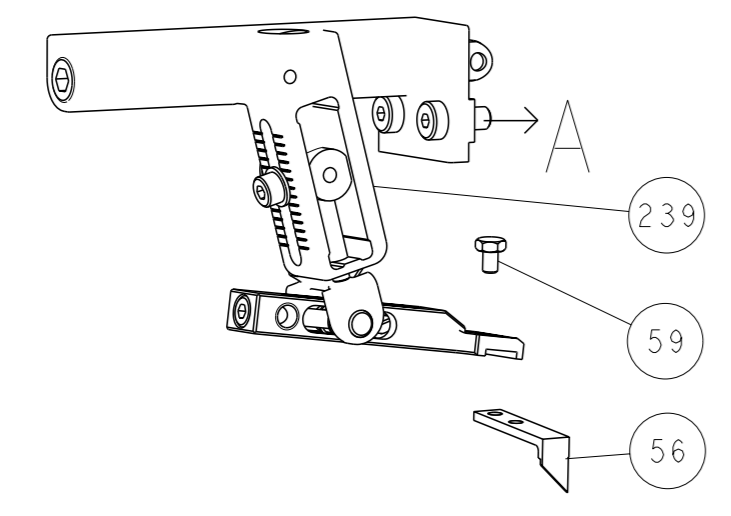
SET UP GAUGE 2119599-1, LOC A, DIST 66. REVISIONS table with columns: P, LTR, DESCRIPTION, DATE, OWN, APVD.

Main parts list table with columns: QTY, PART NUMBER, DESCRIPTION, DATE, OWN, APVD. Lists numerous components like SPRING, CAM, WASHER, SCR, MAGNET, COUNTER, FEED CAM, etc.

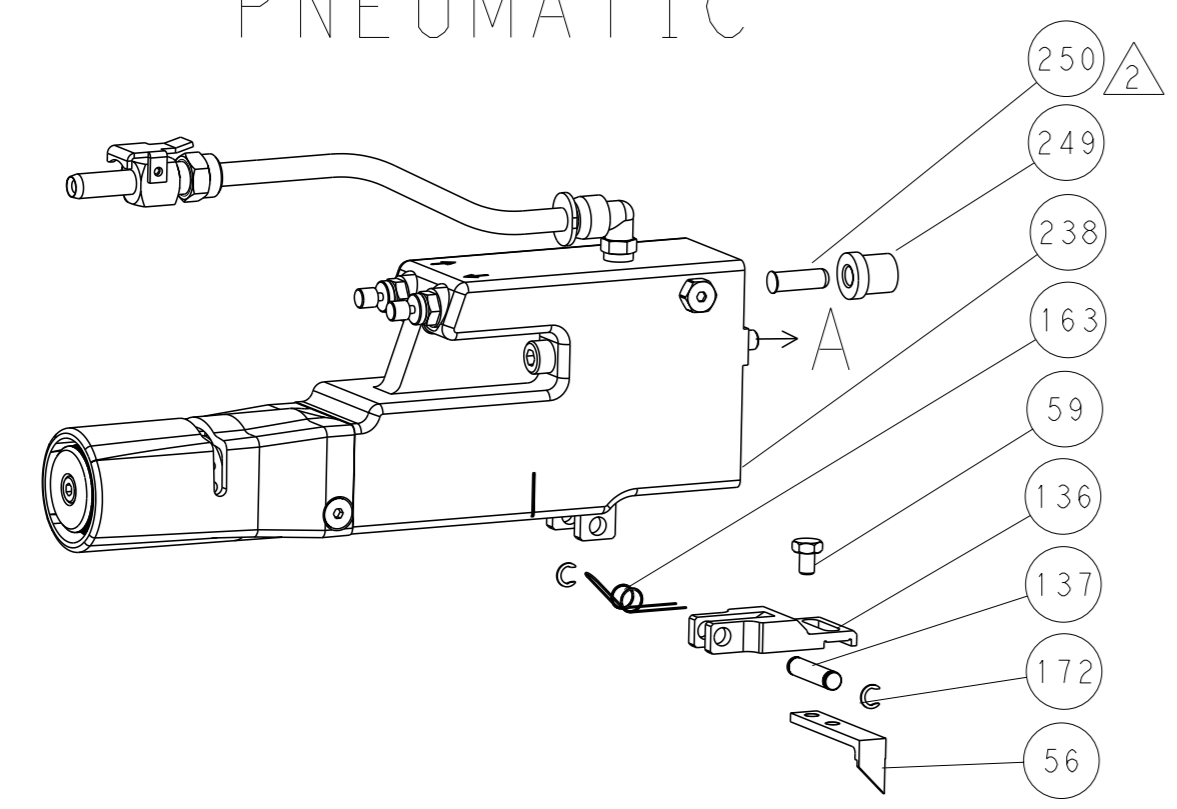
STE logo and technical specifications including DIMENSIONS, TOLERANCES, MATERIAL, FINISH, WEIGHT, SCALE 1:2, SHEET 3 OF 4, REV C2.

LOC	DIST	REVISIONS			
A	66	REV	DATE	OWN	APVD
		-	SEE SHEET 1	-	-

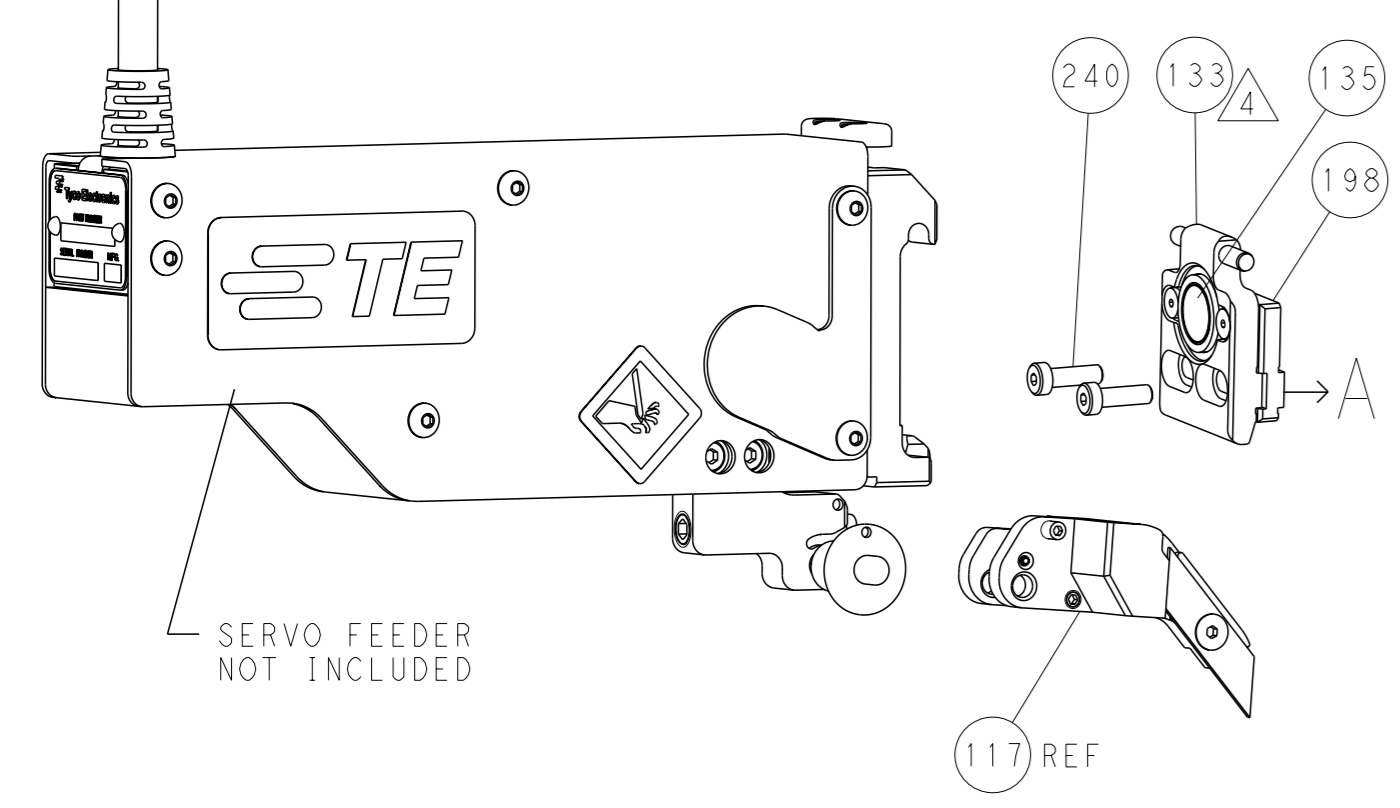
FEED TYPE MECHANICAL



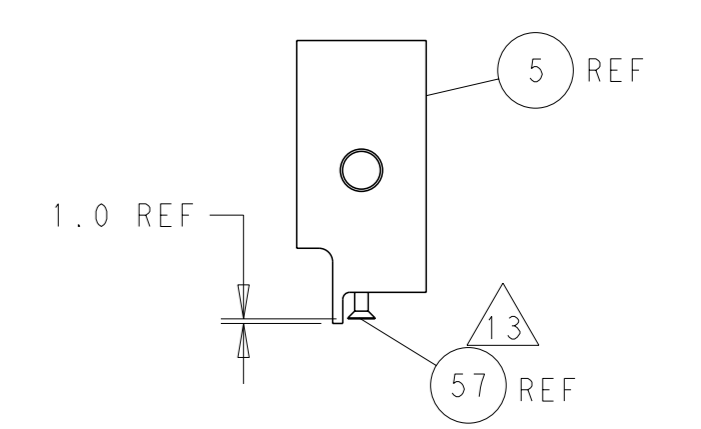
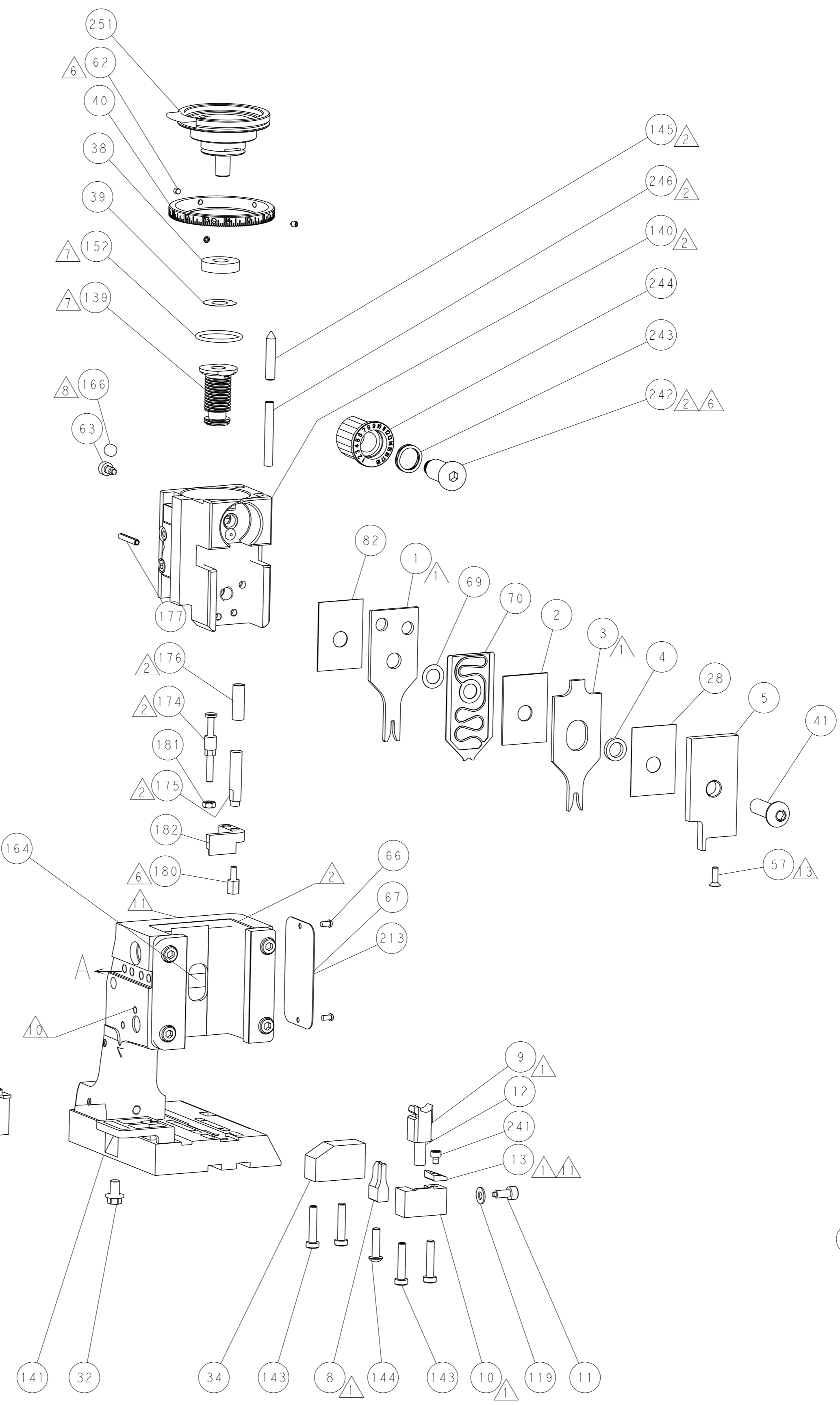
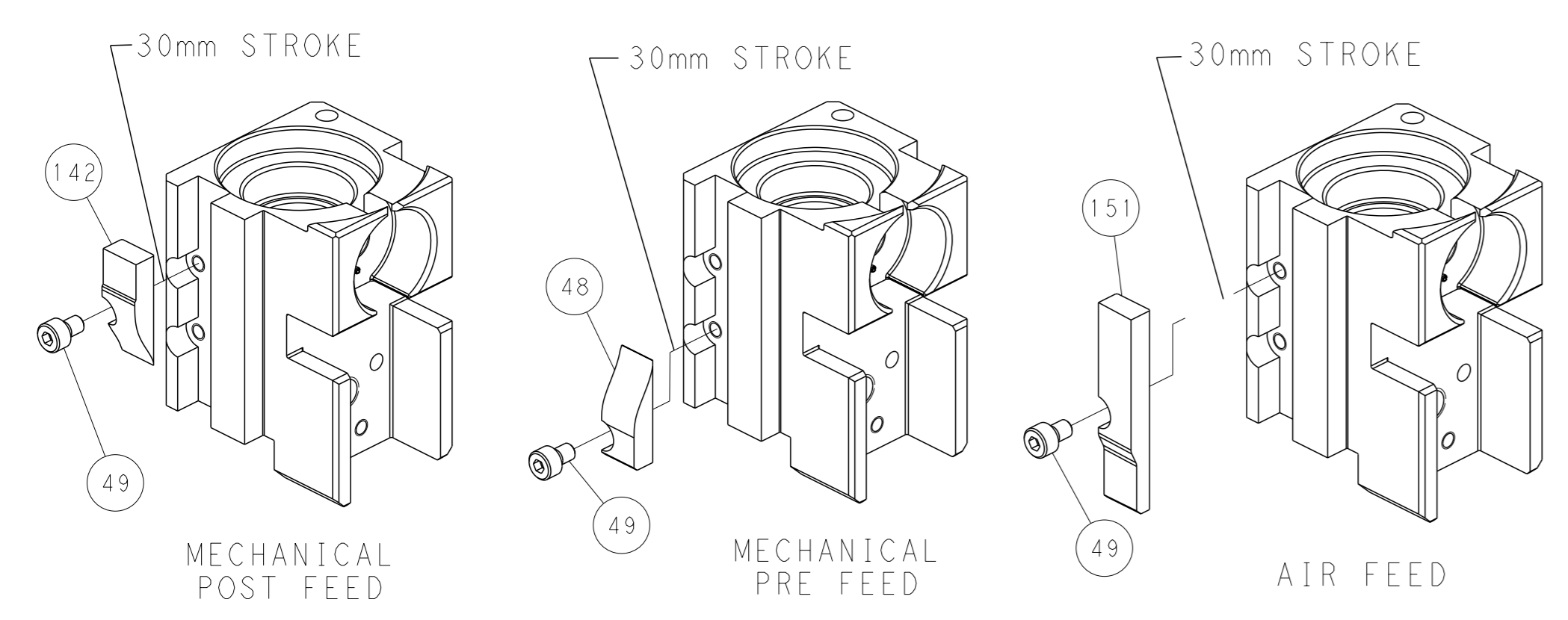
PNEUMATIC



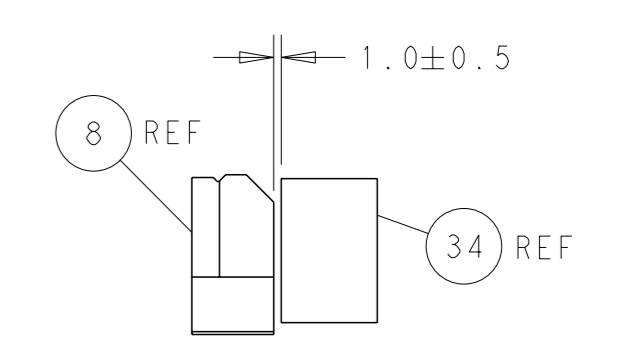
SERVO LATCH PLATE



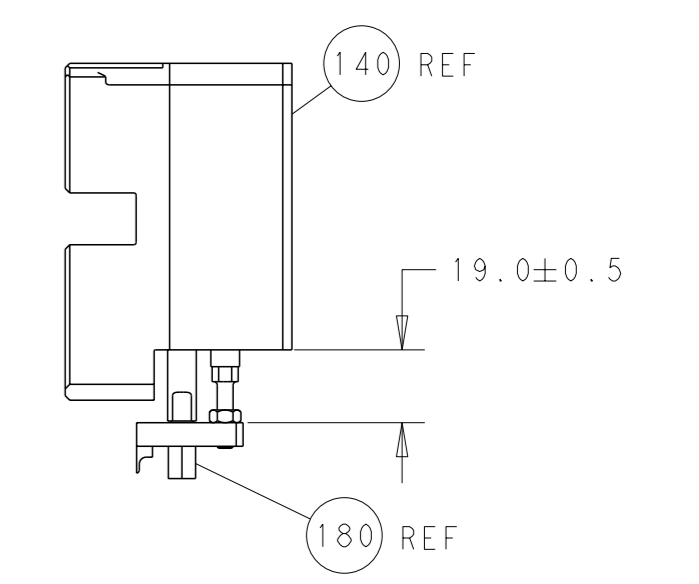
CAM POSITIONS



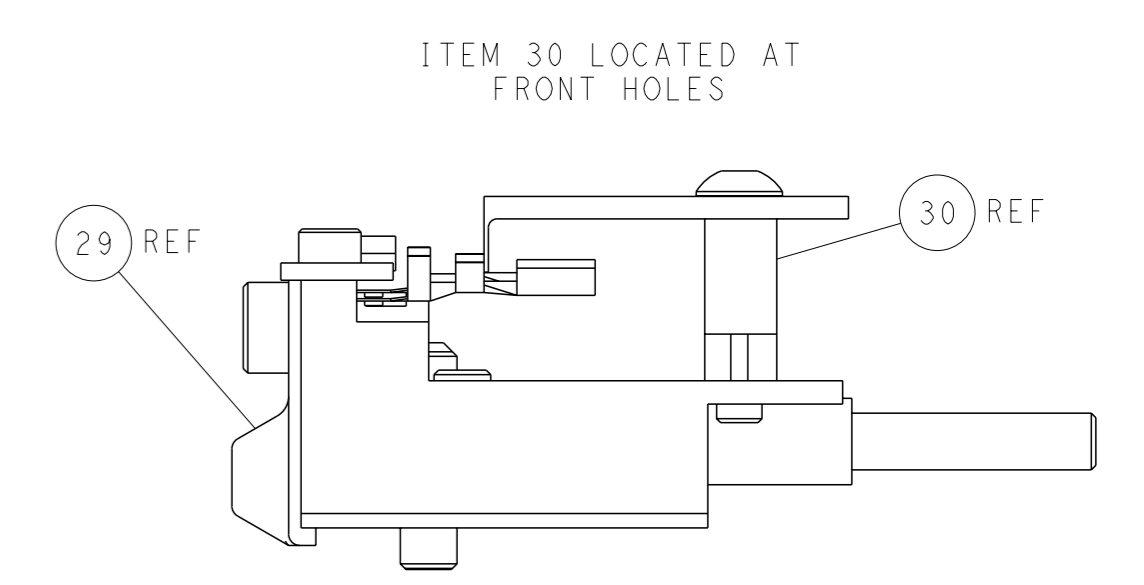
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



ITEM 30 LOCATED AT FRONT HOLES

FEED TRACK POSITION GUIDE BY WIRE BARREL

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 ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: Y. YIN 12OCT2013 CHK: G. BAILEY 12OCT2013 APVD: H. GUO 12OCT2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2151459	RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: C2
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION