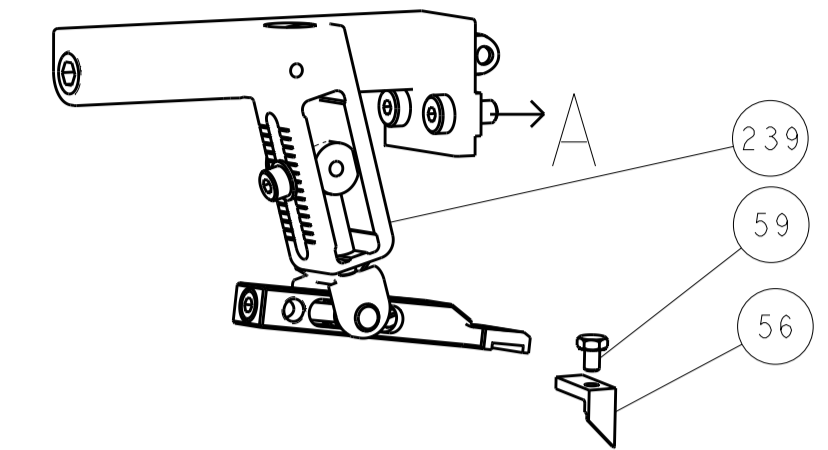
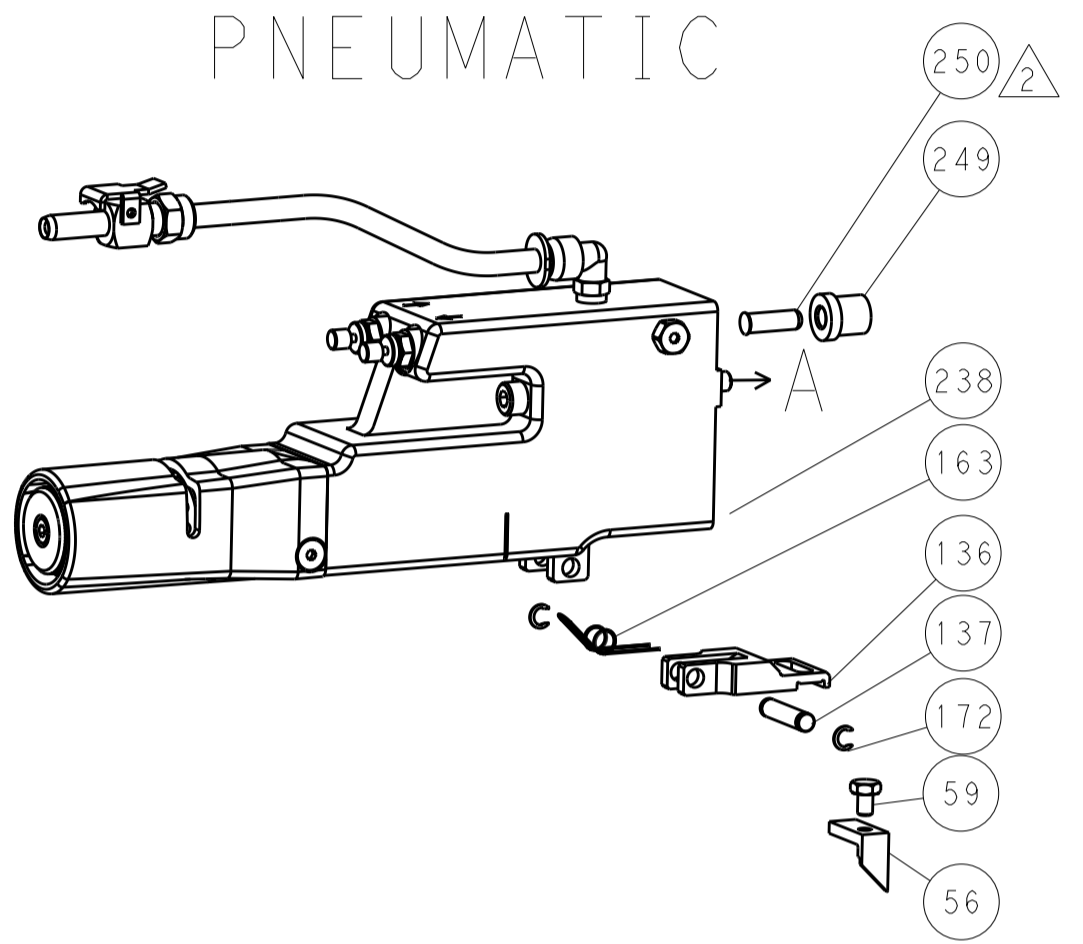


LOC	DIST	REV	DATE	BY	APPV
A	66				

FEED TYPE MECHANICAL



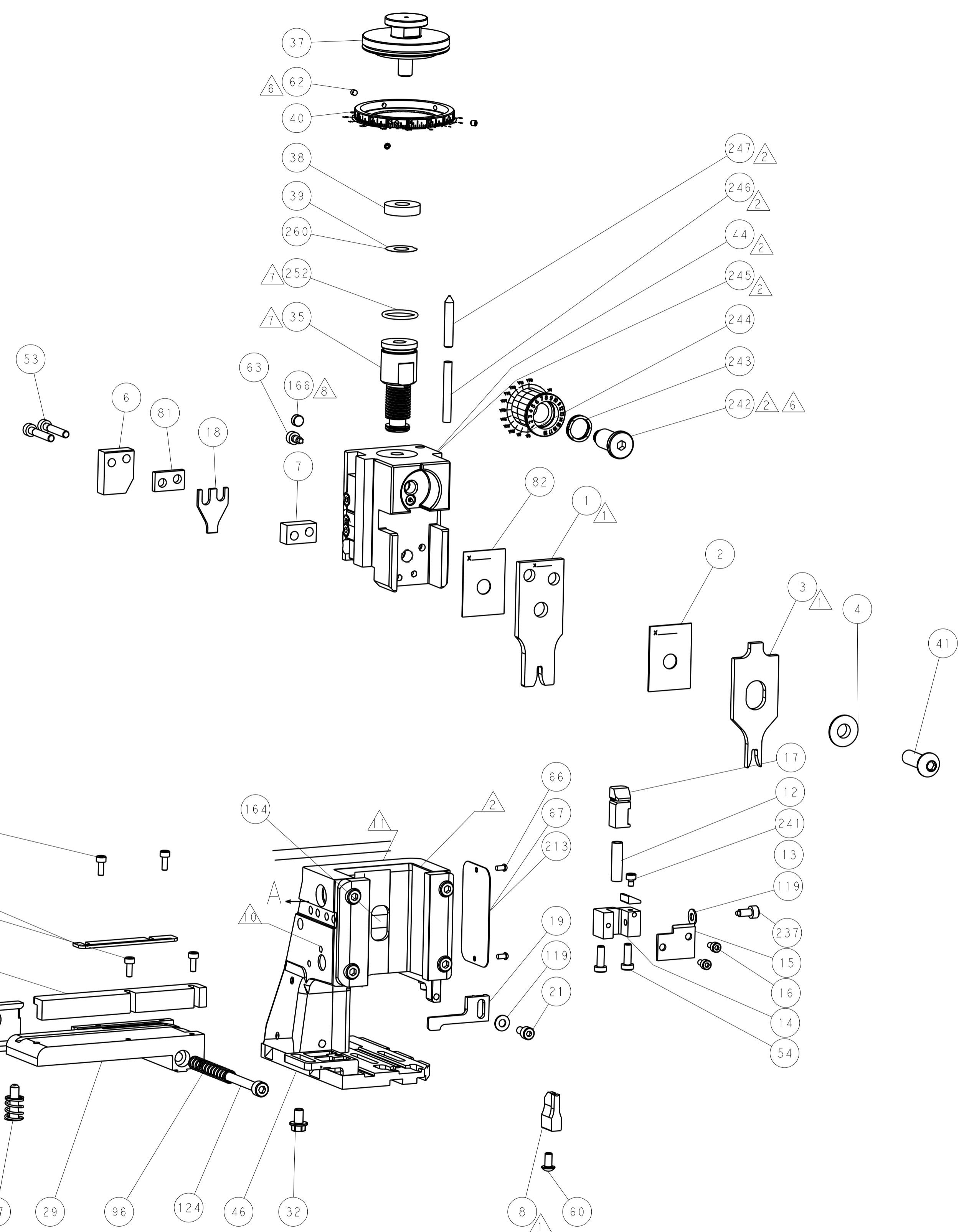
PNEUMATIC



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 ±		DWN Y. YIN 21SEP2012 CHK G. BAILEY 21SEP2012 APVD S. XI 21SEP2012 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 ©=2151770 SCALE 1:2 SHEET 2 OF 4 REV B		TE Connectivity Harrisburg, PA 17105-3608	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
				CONVERT TO	PART NUMBERS REQUIRED					
2-2151770-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338683-1	5-18022-5	2119641-2	2119799-1	2063440-1
				SERVO LATCH PLATE	2119951-1	-	8-2151770-5	1901094-3	-	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2151770-4	-	-	
2-2151770-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338683-1	5-18022-5	2119653-2	-	-
				SERVO LATCH PLATE	2119951-1	-	8-2151770-5	1901094-3	-	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2151770-4	-	-	
2-2151770-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338683-1	5-18022-5	2119653-2	-	-
				PNEUMATIC FEED	2119950-1	1338683-1	5-18022-5	2119641-2	2119799-1	2063440-1
2-2151770-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2151770-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 2.72 mm [1.07]	F	
INSUL 3.60 mm [1.42]	F	
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: MOLEX TERMINAL		MOLEX CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL PUSH-ON CRIMP			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
5.13-5.14 mm [1.202-.202 IN]	Ø2.60-3.20 mm [1.02-.126 IN]		
TERMINAL APPLICATION SPECIFICATION	ATS-638821100		
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
2113299-1	40-02-1602	2113299-2	41422-5001

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
14 AWG OR 2.00mm2	1.725+/-0.025 [1.068+/-0.01]	9.4
16 AWG OR 1.30mm2	1.625+/-0.025 [1.064+/-0.01]	10.5
18 AWG OR 0.80mm2	1.525+/-0.025 [1.060+/-0.01]	11.6

- 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: 8-2151770-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151770-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151770-5
- 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.

***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.

ITEM NO	DESCRIPTION	ITEM NO
251	FINE ADJUST HEAD ASM, PACIFIC STYLE	2119782-1
250	PUSH ROD, AIR FEED	2119640-1
249	BUSHING, LCH5-12, MISUMI	2079988-1
246	SPRING, COMPRESSION	1-22279-3
244	CAM, SNAIL, INSULATION ADJUSTMENT	2119082-9
243	WASHER, WAVE SPRING, CREST-TO-CREST	2079764-1
242	RETAINER, INSULATION DIAL	2119083-1
-77	PART NO	-27 -25 -22 -21

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

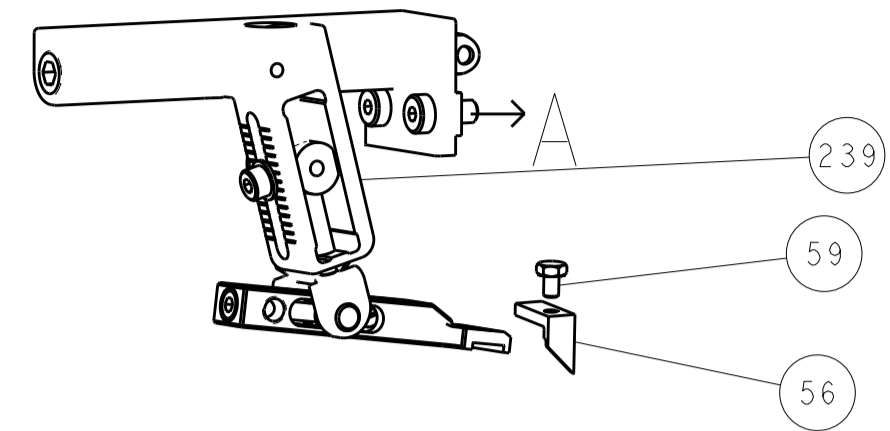
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
			-	SEE SHEET 1		

REV	DATE	BY	APPV	DESCRIPTION	DATE	BY	APPV
-	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	1	1	356885-4	STOP, SHEAR		237
-	-	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
-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20		143
-	-	-	1	2119653-2	FEED CAM, POST FEED		142
-	1	1	1	2119656-2	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	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65		124
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4		119
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF		117
-	1	1	1	1-22281-8	SPRING, COMPRESSION		96
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0		83
-	1	1	1	455888-5	SPACER, CRIMPER		82
-	1	1	1	240641-5	SPACER		81
-	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
-	4	4	4	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		65
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT		63
-	3	3	3	992763-5	SCR, SET, SOC, CONE PNT, M3 X 4.0		62
-	2	2	2	2-18032-5	SCR, SET, FLT PNT, M5 X 20.0		61
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	-	-	1	1-1338683-0	FEED PAWL		56
-	2	2	2	1-2168083-2	SCR, SKT HD CAP, RoHS, M4 X 25		53
-	-	-	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	2119644-2	RAM WASHER, PRECISION		38
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG		32
-	1	1	1	1901091-2	PLATE, REAR STRIP GUIDE		29
-	2	2	2	22283-1	SPRING, COMPRESSION		27
-	1	1	1	356835-1	LEVER, DRAG RELEASE		26
-	1	1	1	240792-1	DRAG, TERMINAL		25
-	1	1	1	3-189124-2	GUIDE, FRONT STRIP		24
-	1	1	1	1-690438-0	FRONT STRIP GUIDE		23
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	1	1	1	2119533-1	STRIPPER, SIDE FEED		19
-	1	1	1	690518-1	HOLD DOWN, TERMINAL		18
-	1	1	1	690463-2	FLOATING SHEAR, REAR		17
-	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6		16
-	1	1	1	1-690464-5	SHEAR PLATE, REAR		15
-	1	1	1	2119862-1	SHEAR HOLDER, REAR		14
-	1	1	1	2280441-1	INSERT, SHEAR		13
-	1	1	1	3-22280-3	SPRING, COMPRESSION		12
-	-	-	-	-	-		10
-	-	-	-	-	-		9
-	1	1	1	1803054-7	ANVIL, COMBINATION		8
-	1	1	1	7-240641-2	SPACER		7
-	1	1	1	690468-6	DEPRESSOR SHEAR, REAR		6
-	-	-	-	-	-		5
-	1	1	1	1-238009-1	BLOCK, FL CRIMPER SPACER		4
-	1	1	1	5-2119582-8	CRIMPER, INSULATION F PREMIUM		3
-	1	1	1	455888-8	SPACER, CRIMPER		2
-	1	1	1	6-1633609-8	CRIMPER, WIRE		1

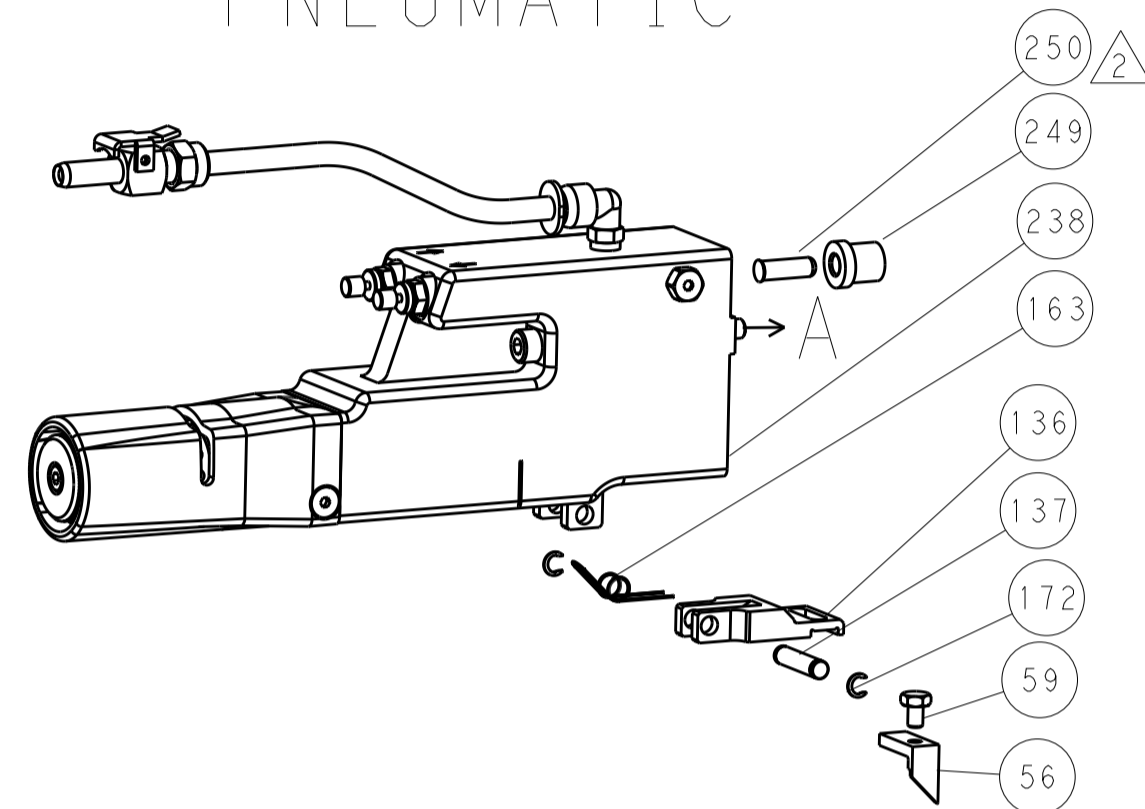
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	21SEP2012	TE Connectivity Harrisburg, PA 17105-3608
mm	0 PLC ±	1 PLC ±	2 PLC ±	CHK	21SEP2012	
	3 PLC ±	4 PLC ±	ANGLES ±	BY	G. BAILEY	NAME Ocean Side Feed Applicator
	FINISH			APPV	21SEP2012	
MATERIAL		WEIGHT		PRODUCT SPEC		SIZE
				APPLICATION SPEC		CAGE CODE
						DRAWING NO
						RESTRICTED TO
						A1 00779 ©=2151770
						Customer Accessible Production Drawing
						SCALE 1:2 SHEET 3 OF 4 REV B

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

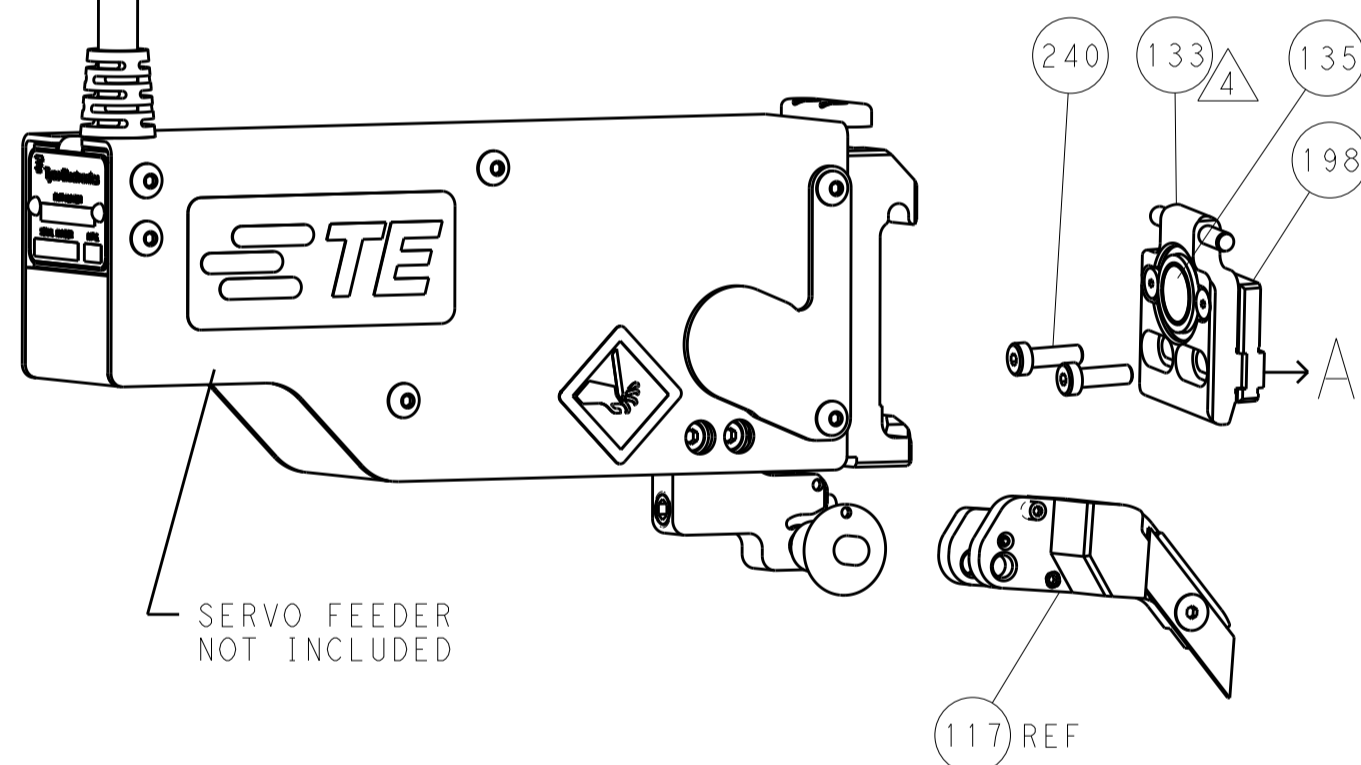
FEED TYPE MECHANICAL



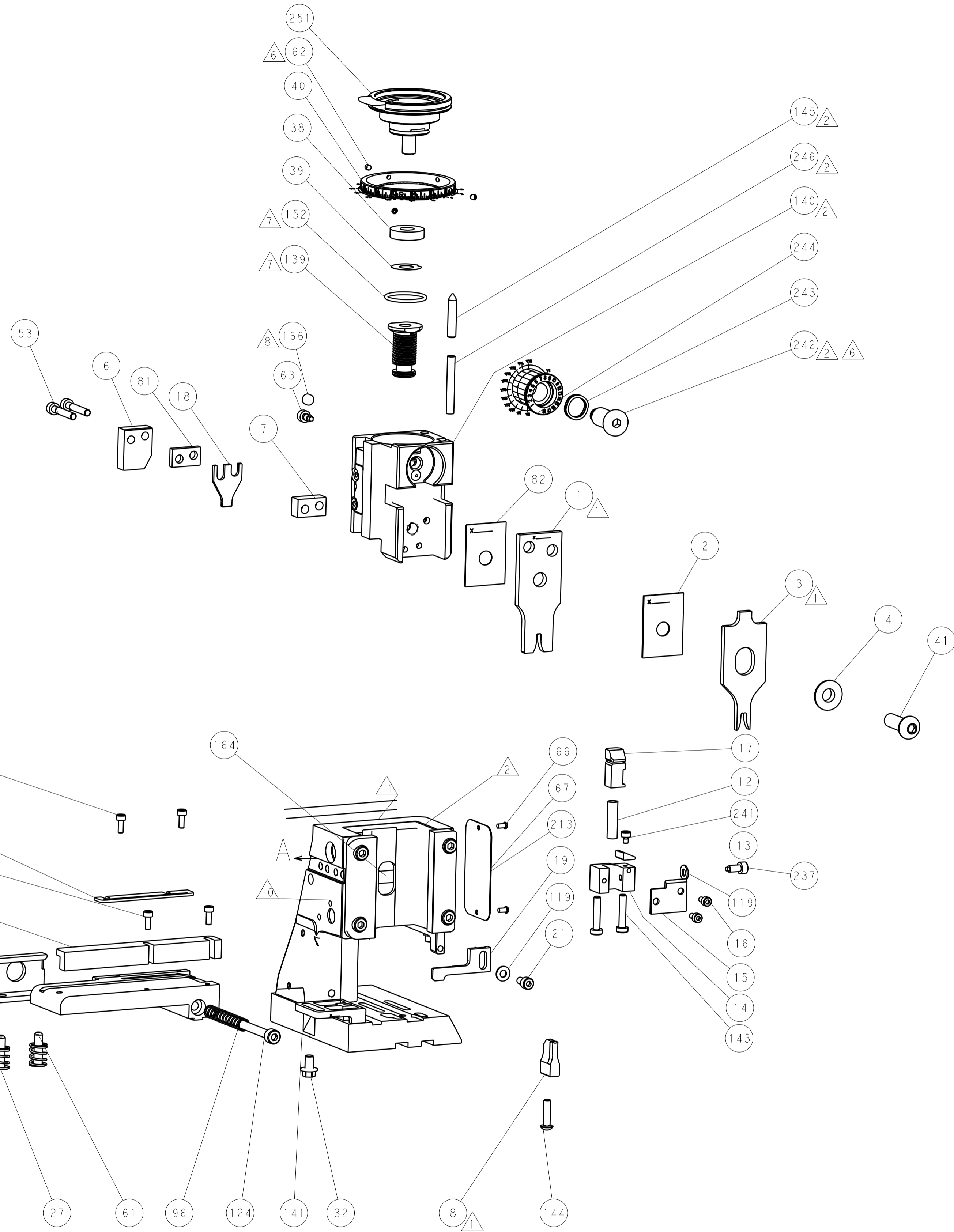
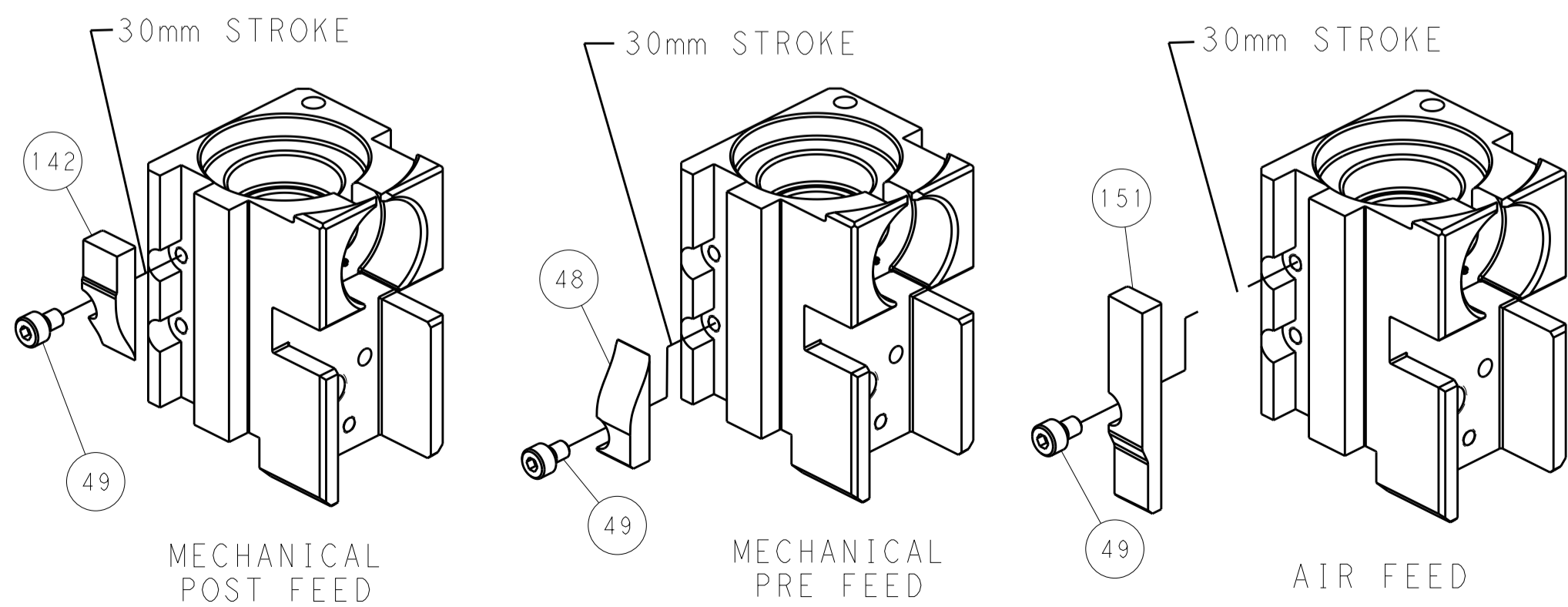
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN Y. YIN 21SEP2012		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD S. XI 21SEP2012	NAME Ocean Side Feed Applicator
MATERIAL:		FINISH:		WEIGHT:		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
				A 00779 C=2151770		Customer Accessible Production Drawing SCALE 1:2 SHEET 4 OF 4 REV B	