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

APPLICATOR STYLE CONVERSION CHART. Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Includes WIRE 1.30 mm [.051] F and INSUL 2.03 mm [.080] O.

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

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

- 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 ITEMS 62.
GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING.
WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.89.

*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.

Large parts list table with columns: PART NO, DESCRIPTION, ITEM NO. Includes items like 2119957-2 APPLICATOR SHIM PACK, 8-21084-0 O-RING, 2119640-1 PUSH ROD, AIR FEED, etc.

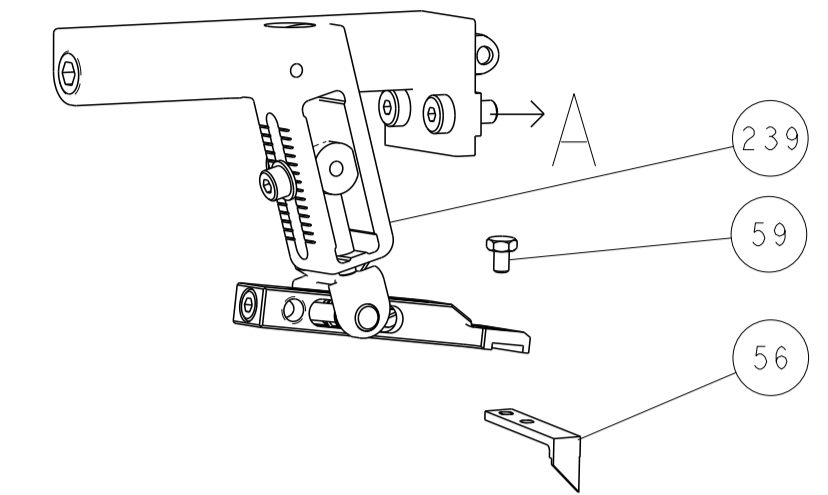
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

Technical drawing header and footer including dimensions, tolerances, material, weight, scale 1:2, and SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION.

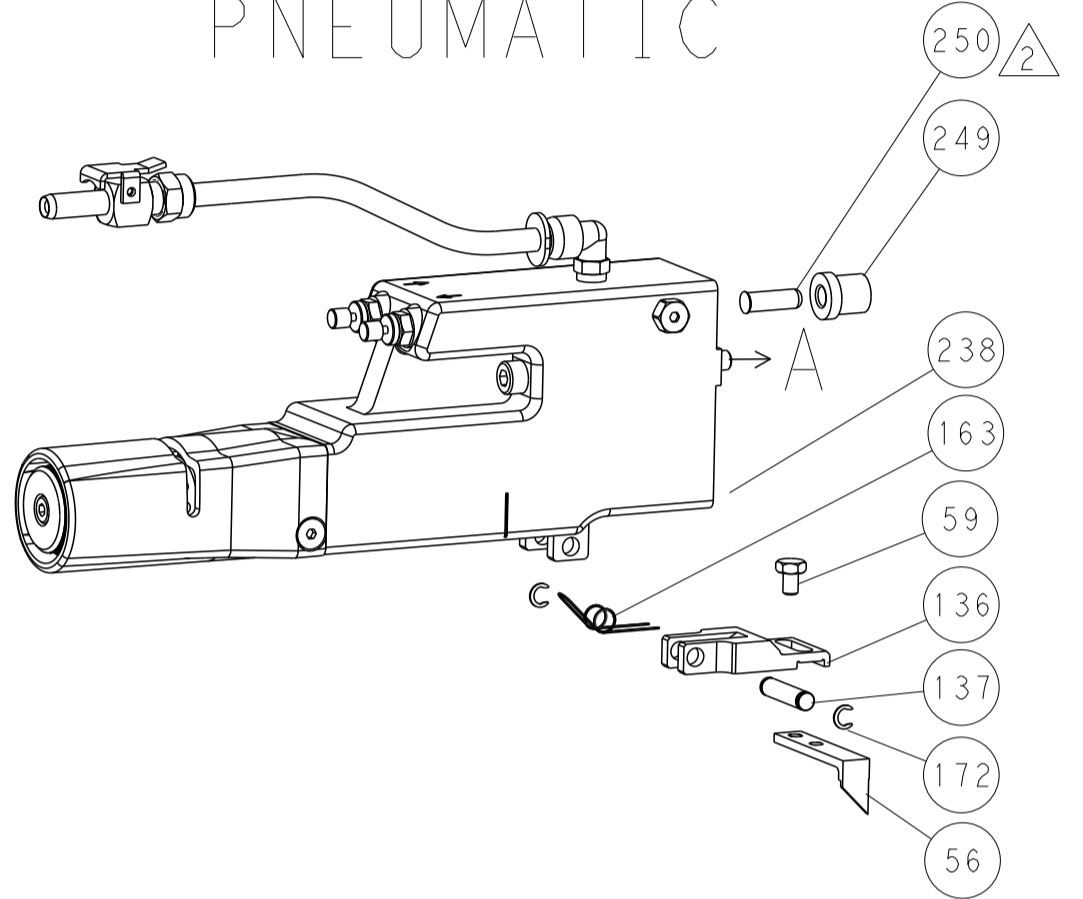
LOC	DIST	REV	DATE	BY	APPV
A	66				

REVISIONS			
REV	DATE	DESCRIPTION	BY
-	-	SEE SHEET 1	-

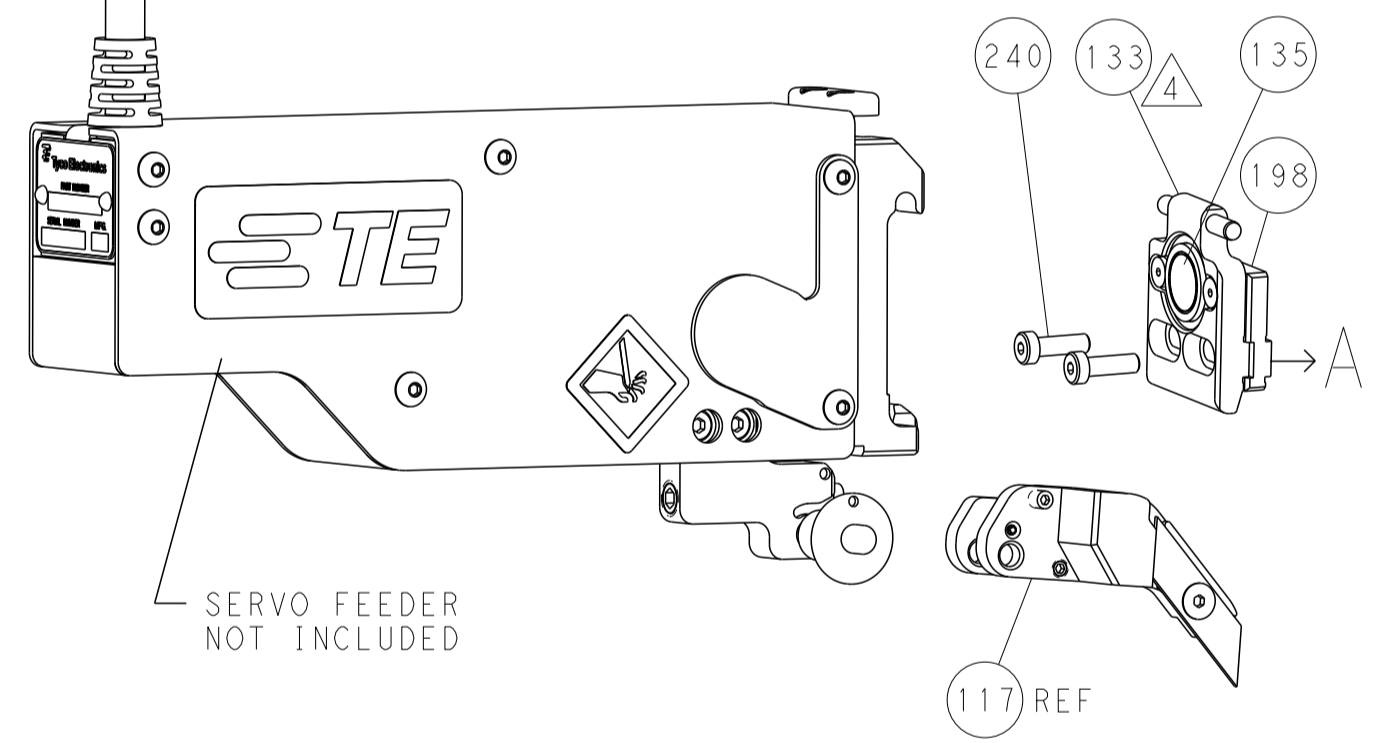
FEED TYPE MECHANICAL



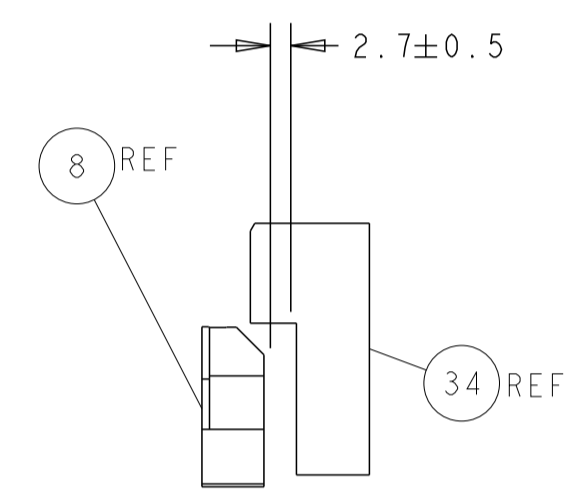
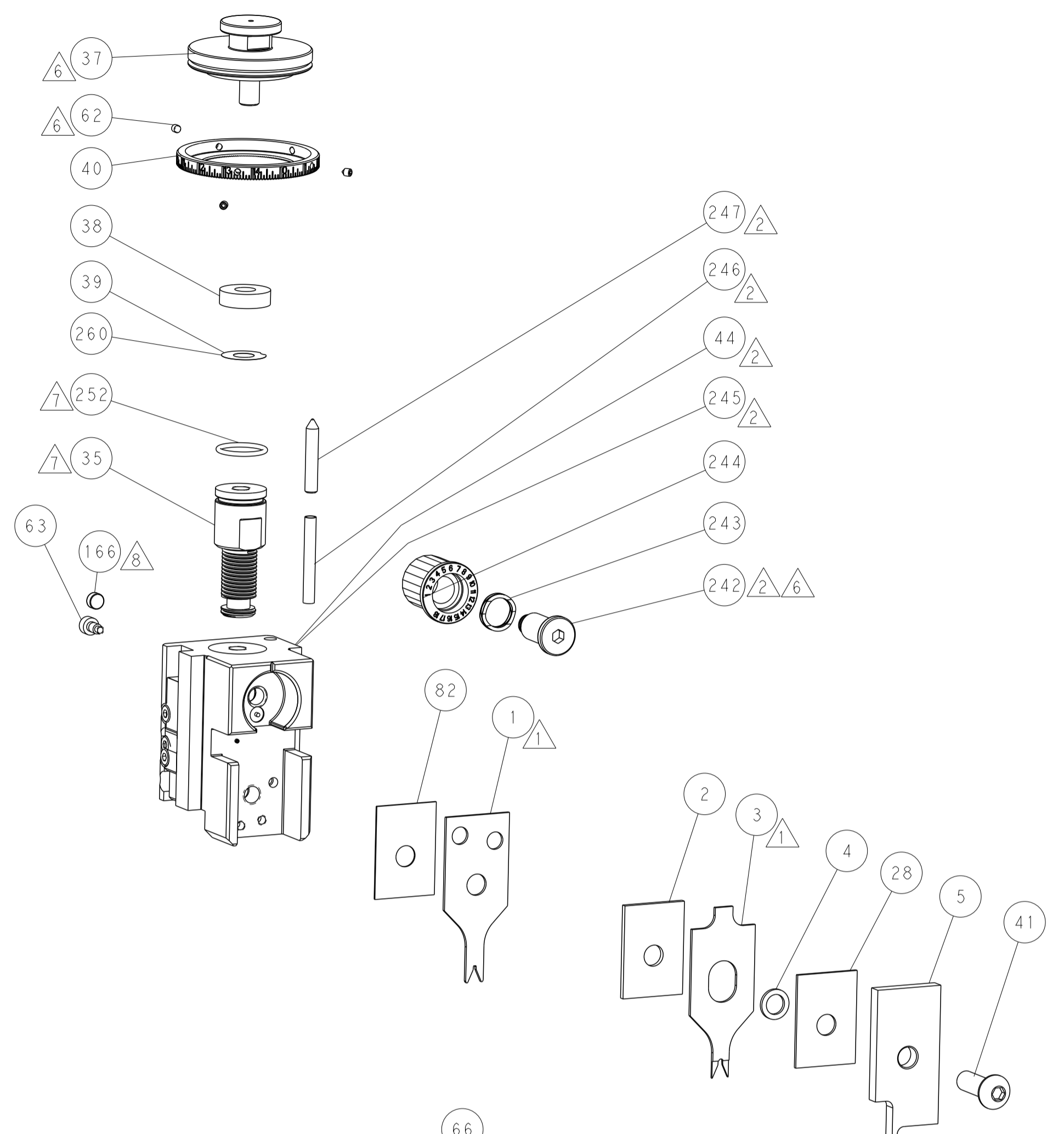
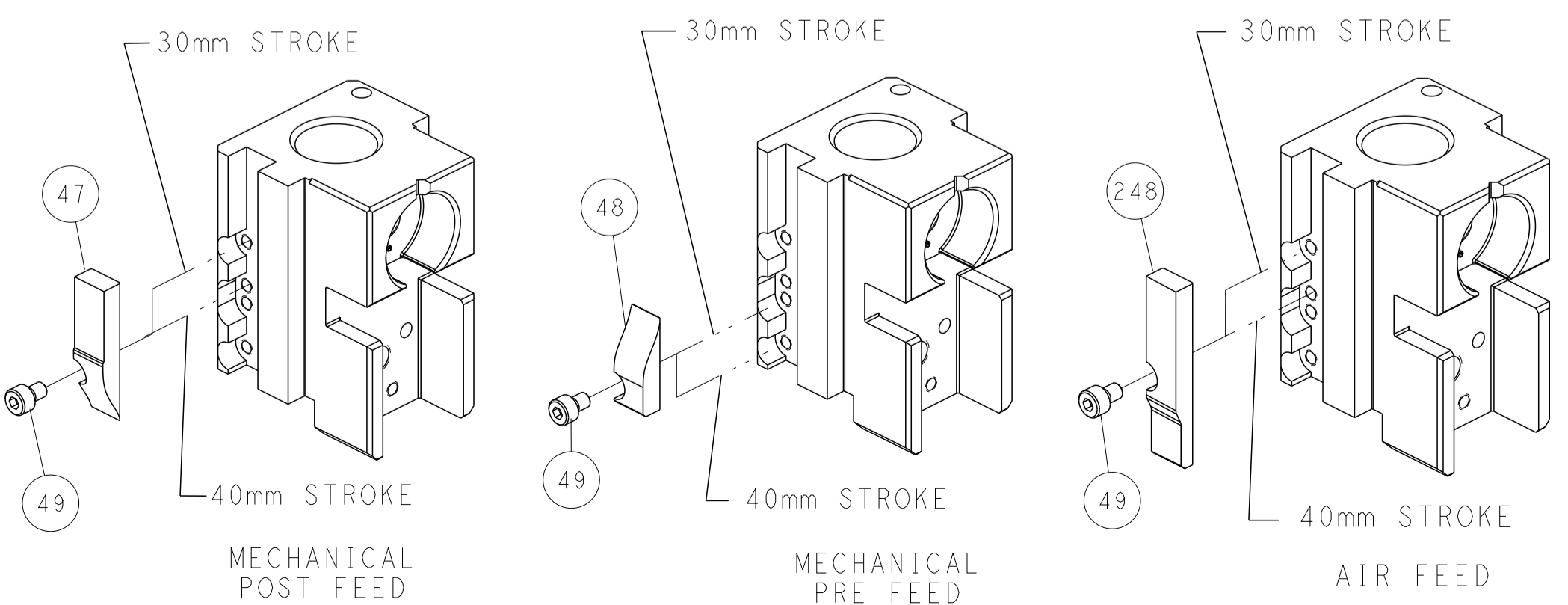
PNEUMATIC



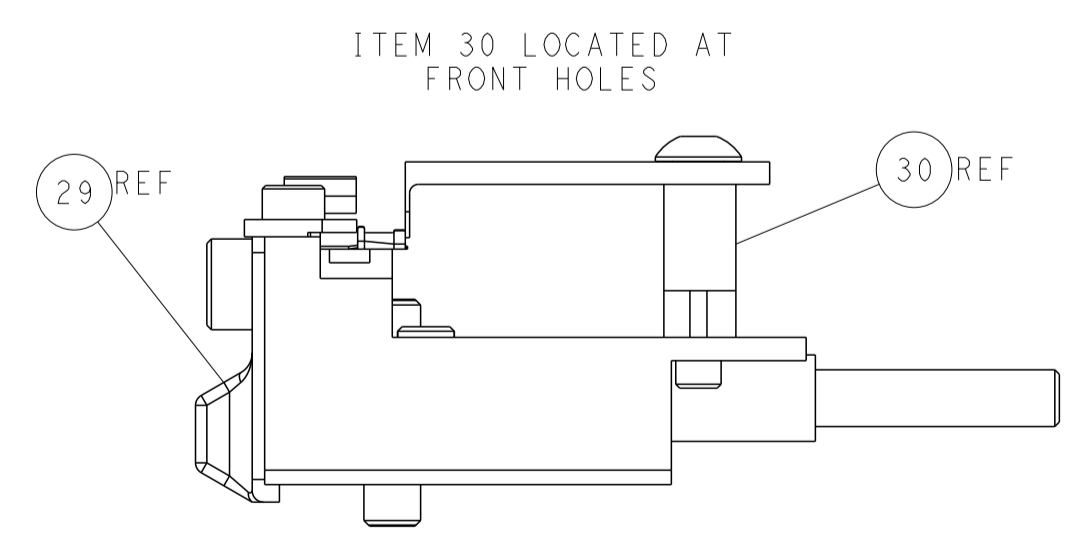
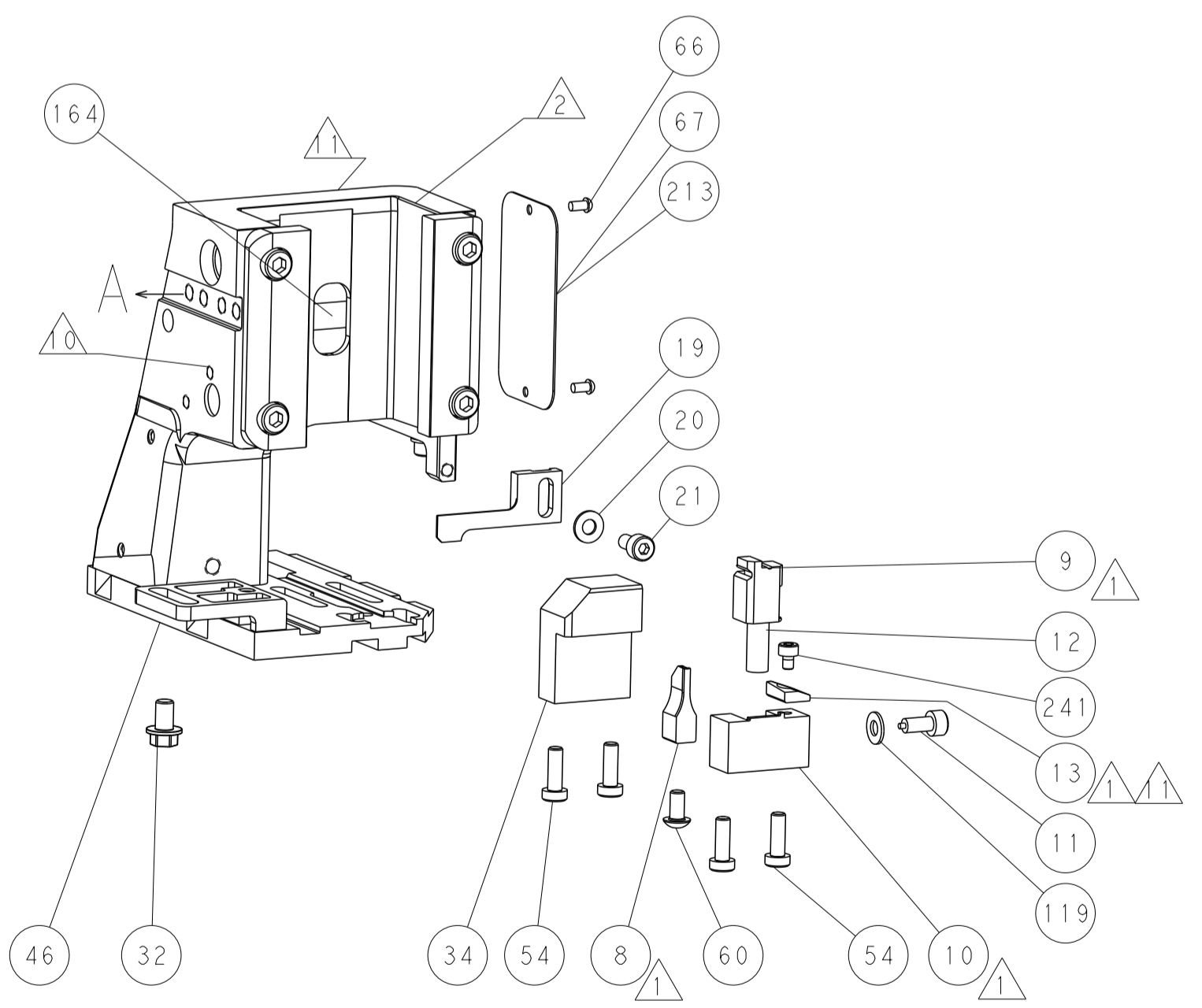
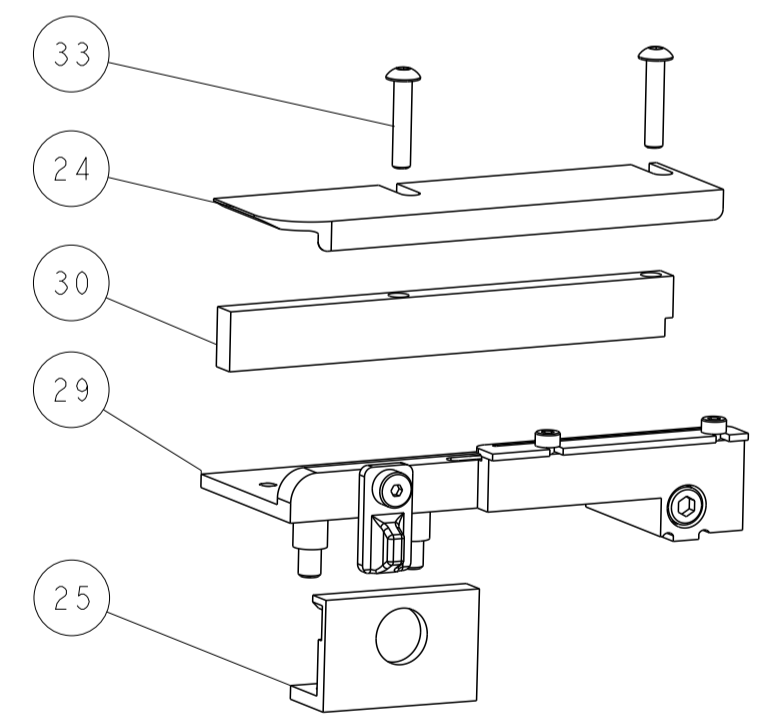
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY WIRE 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 27JUN2013 CHK: U. GUO 27JUN2013 APVD: J. CRUZ 27JUN2013	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151095	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	TOLERANCES UNLESS OTHERWISE SPECIFIED: ± ± ± ± ±	PRODUCT SPEC APPLICATION SPEC WEIGHT	RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: C	Customer Accessible Production Drawing

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2151095-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL
	2-2151095-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2151095-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴
	2-2151095-7	C	FINE CRIMP HEIGHT ADJUST	NONE
	7-2151095-7	B	CRIMP TOOLING KIT	-

CRIMP	SIZE	TYPE
WIRE	1.30 mm [.051]	F
INSUL	2.03 mm [.080]	O

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME: CRIMP TYPE RECEPTACLE CONTACT	
WIRE STRIP LENGTH 2.70-3.40 mm [1.06-.134 IN]	INSULATION DIAMETER RANGE ∅1.00-1.50 mm [0.039-.059 IN]
TERMINAL APPLICATION SPECIFICATION 114-5140	
TERMINALS APPLIED	
TE TERMINAL	TE TERMINAL
1-175102-1	1-175102-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG	0.91+/-0.05 [0.036+/-0.002]	7.5
24 AWG	0.84+/-0.05 [0.033+/-0.002]	8.0
26 AWG	0.79+/-0.05 [0.031+/-0.002]	8.5



- ▲ 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: 8-2151095-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151095-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151095-5
- 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 ITEMS 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.

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

APPLICATOR STYLE CONVERSION CHART

CONVERT TO	PART NUMBERS REQUIRED							
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1		
SERVO LATCH PLATE	2119951-1	-	8-2151095-5	1901094-3	-	2168400-6 (QUANTITY 2)		
SMART APPLICATOR	2161326-1	-	8-2151095-4	-	-	-		
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-		
SERVO LATCH PLATE	2119951-1	-	8-2151095-5	1901094-3	-	2168400-6 (QUANTITY 2)		
SMART APPLICATOR	2161326-1	-	8-2151095-4	-	-	-		
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-		
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1		

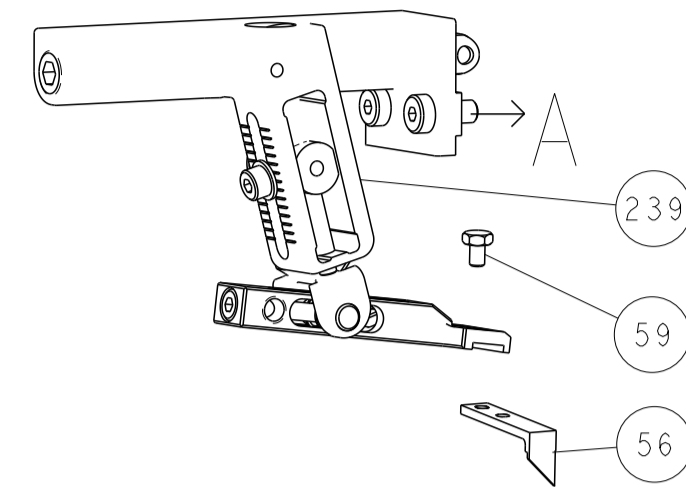
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LN	DESCRIPTION	DATE	OWN	APVD
-	-	-	-	-	SEE SHEET 1	-	-	-

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	1803259-1	BUSHING, FLANGED	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
-	-	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	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	1-2119656-0	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	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 POINT, M3 x 4.0	62
-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	-	-	1	2	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	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1424190-1	STOP, WIRE	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	1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-4	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	240792-3	DRAG, TERMINAL	25
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-3	STRIPPER, SIDE FEED	19
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-3	STOP, SHEAR	11
-	1	1	1	1	2-2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1633861-3	SHEAR, FLOATING	9
-	1	1	1	1	1803363-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-0	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	2-1633966-1	CRIMPER, INSULATION O	3
-	1	1	1	1	1-455888-8	SPACER, CRIMPER	2
-	1	1	1	1	3-1633713-9	CRIMPER, WIRE PREMIUM	1

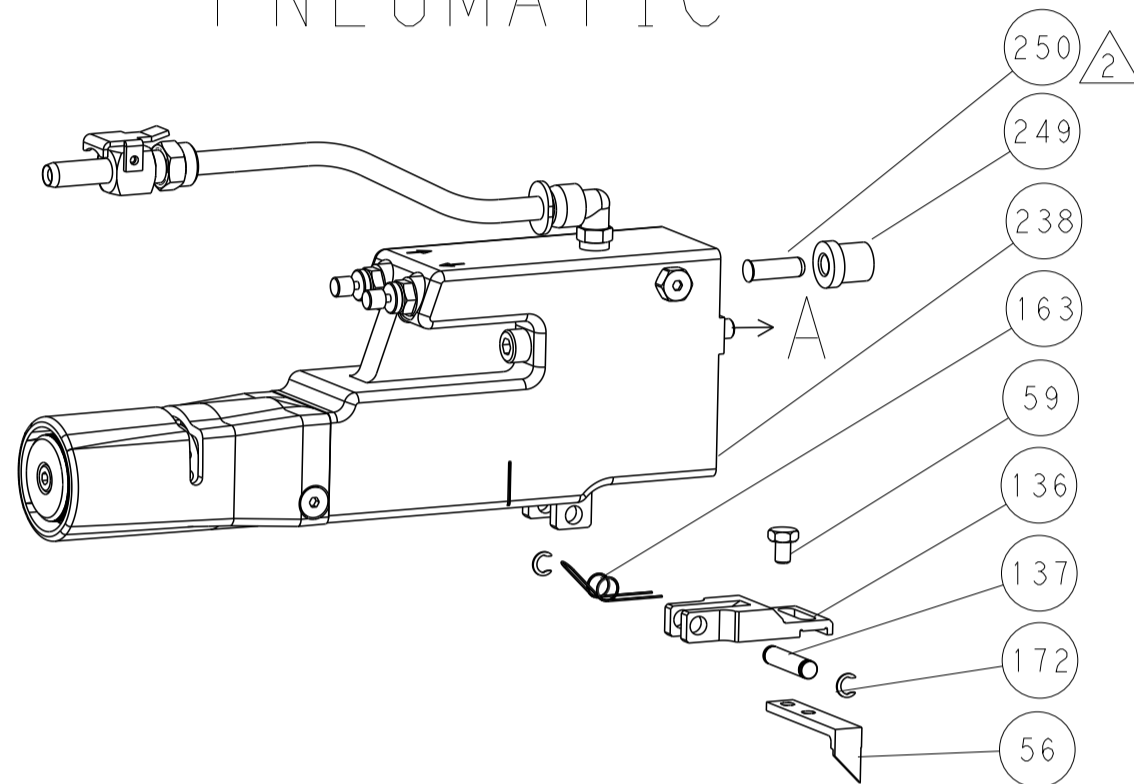
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	1 PLC	±	0.5					Harrisburg, PA 17105-3608				
	2 PLC	±	1.0					Ocean Side Feed				
	3 PLC	±	1.5					Applicator				
	4 PLC	±	2.0									
	5 PLC	±	2.5									
	6 PLC	±	3.0									
	ANGLES	±	0.5									
	FINISH	±	0.25									

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

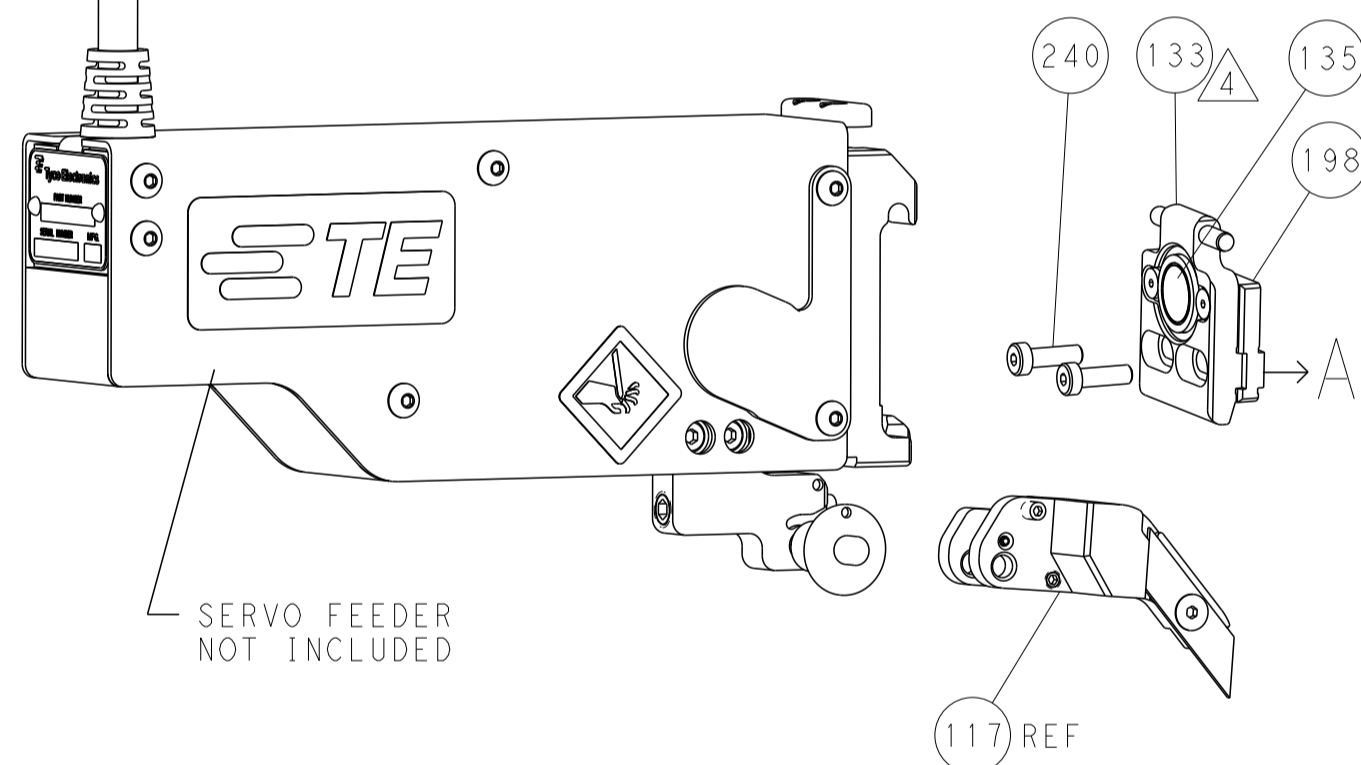
FEED TYPE MECHANICAL



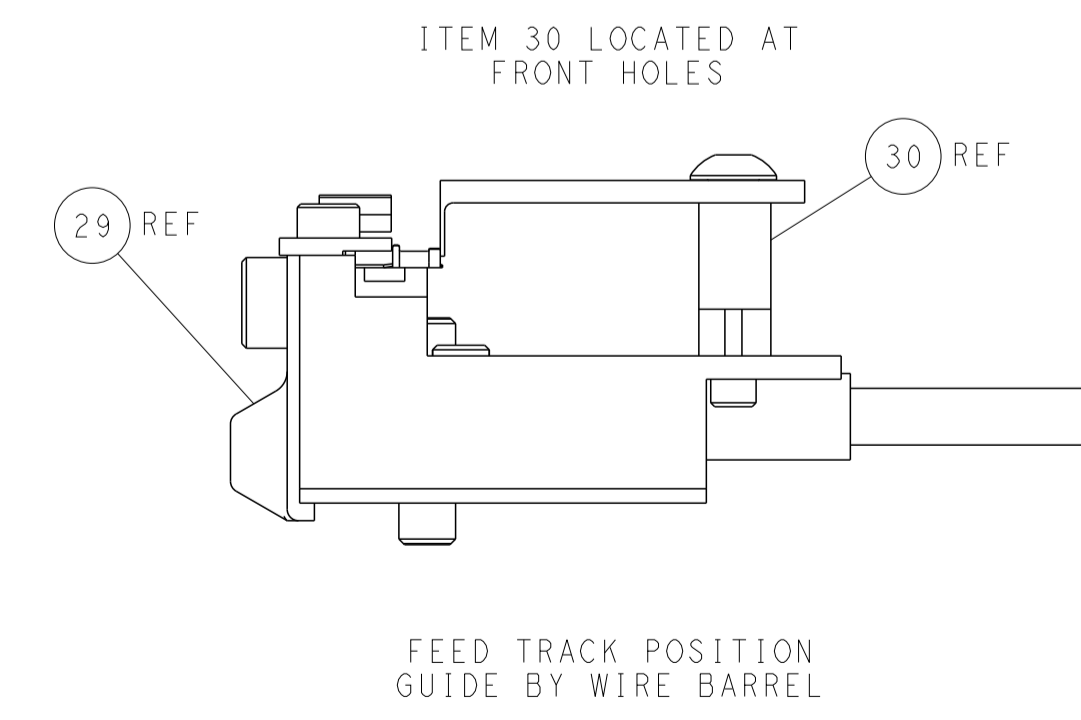
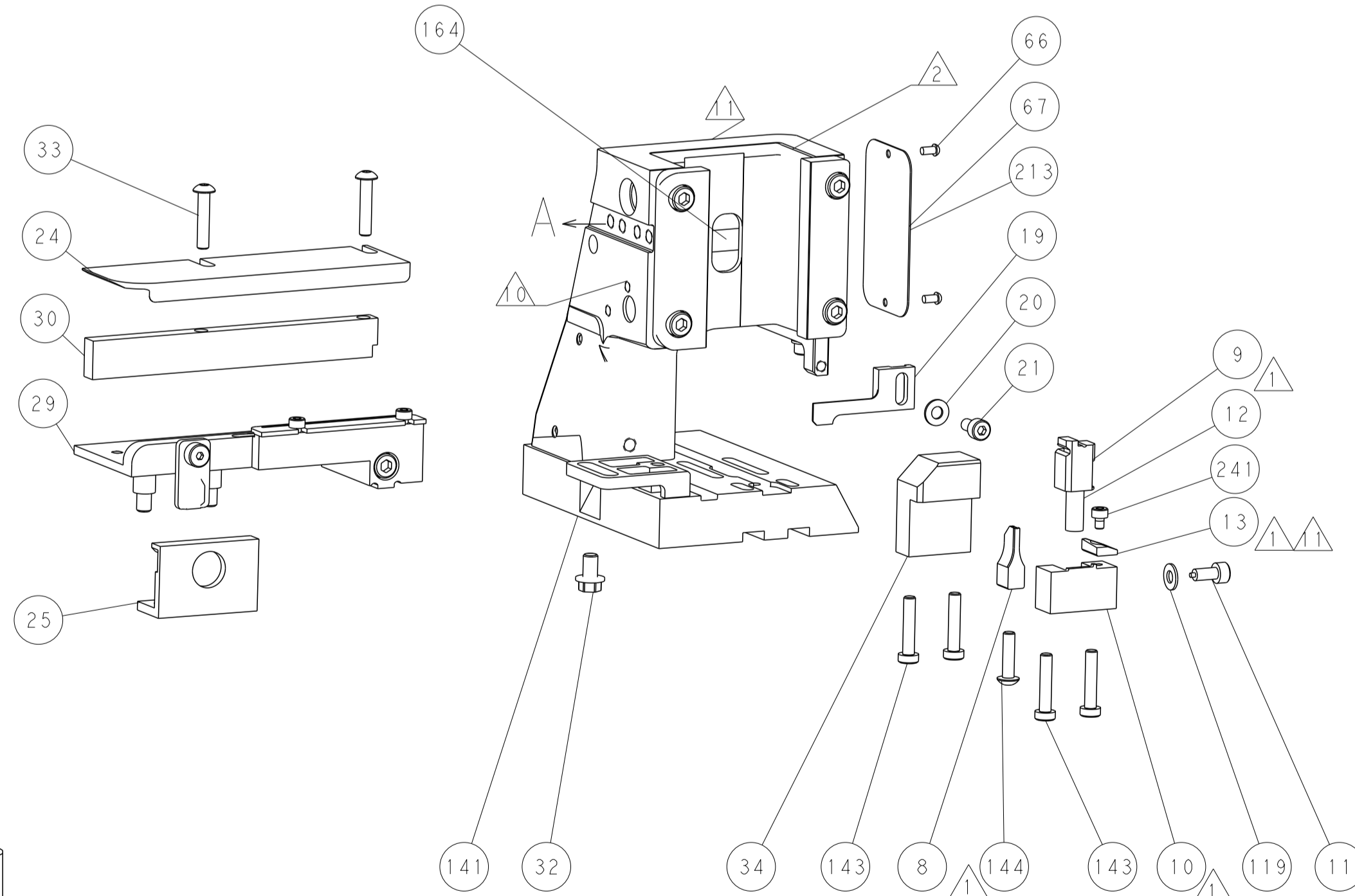
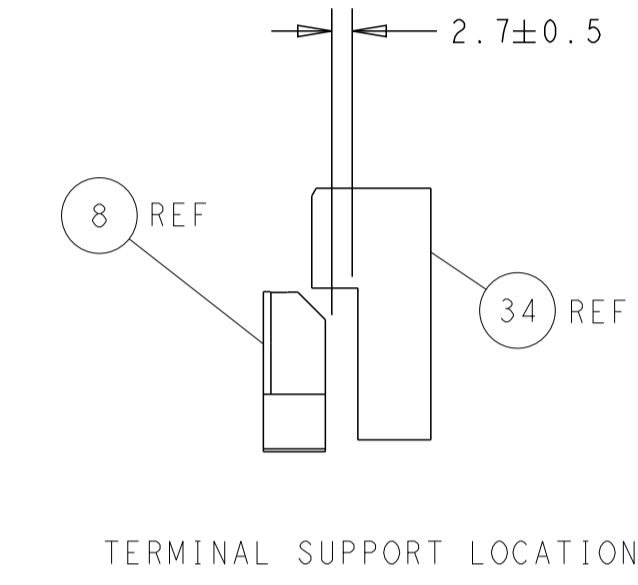
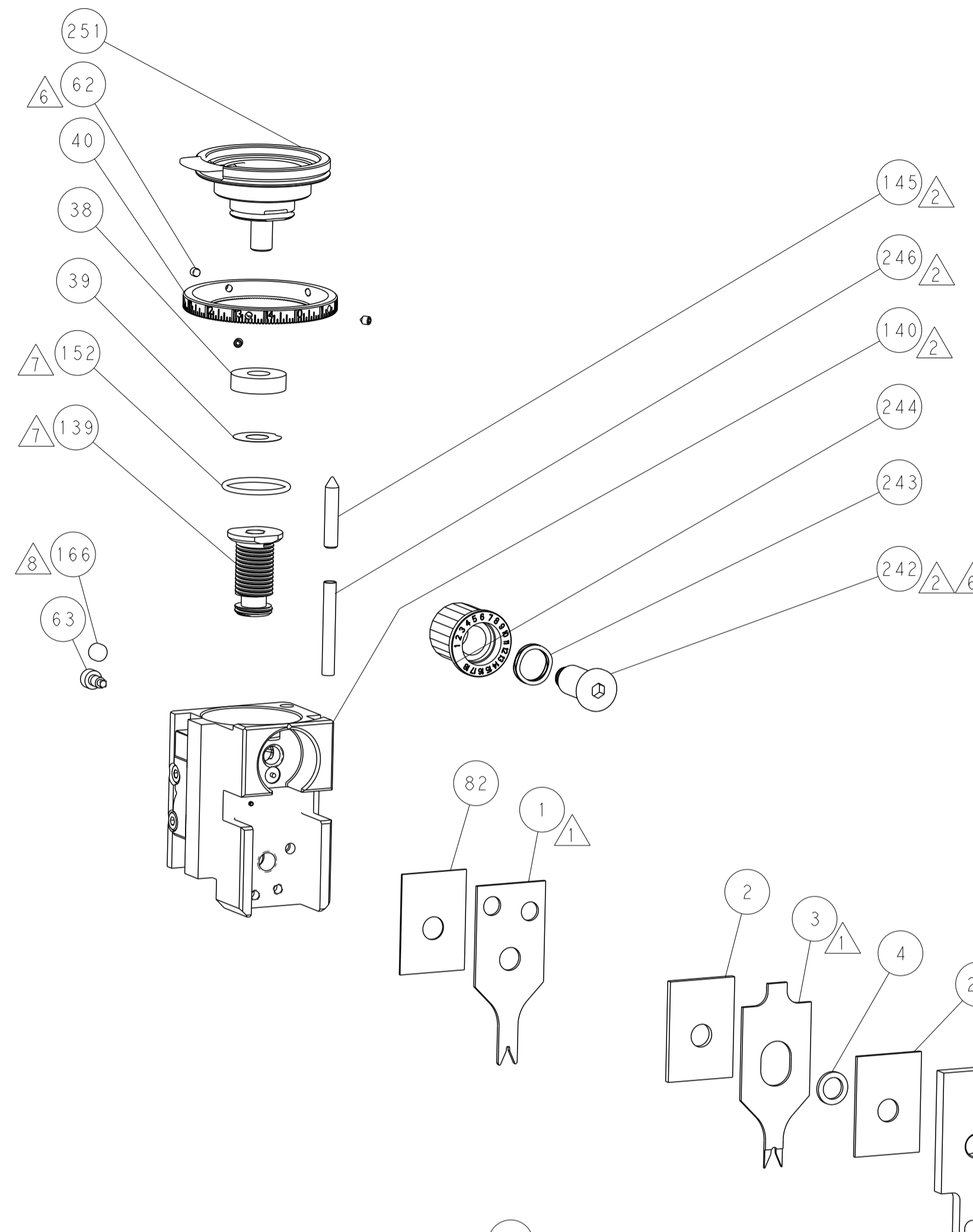
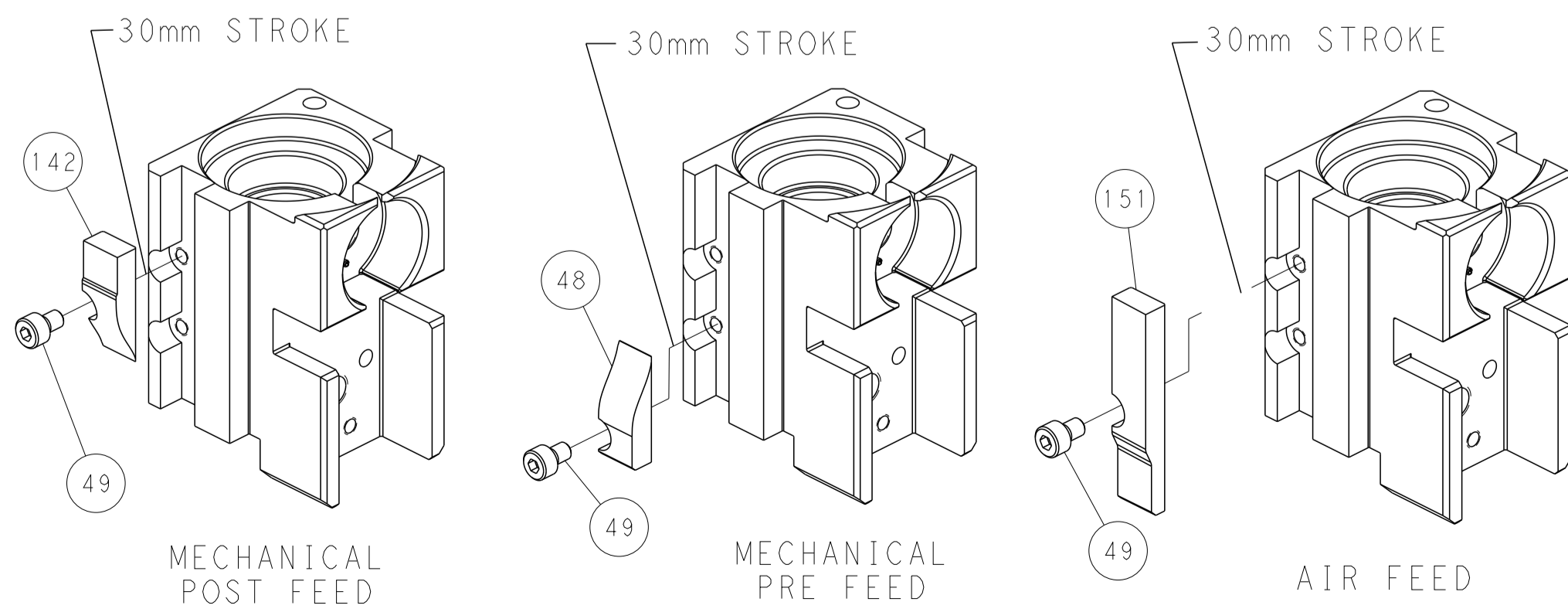
PNEUMATIC



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN C. CHEN 27JUN2013 CHK U. GUO 27JUN2013 APVD J. CRUZ 27JUN2013 PRODUCT SPEC APPLICATION SPEC		NAME STE TE Connectivity Harrisburg, PA 17105-3608	
MATERIAL:		WEIGHT:		SIZE CAGE CODE DRAWING NO A1 00779 C=2151095		RESTRICTED TO	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 4 OF 4 REV C	