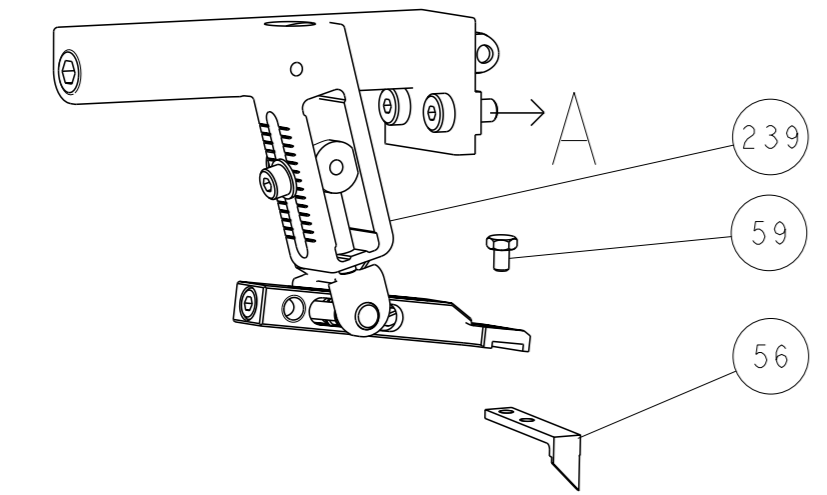
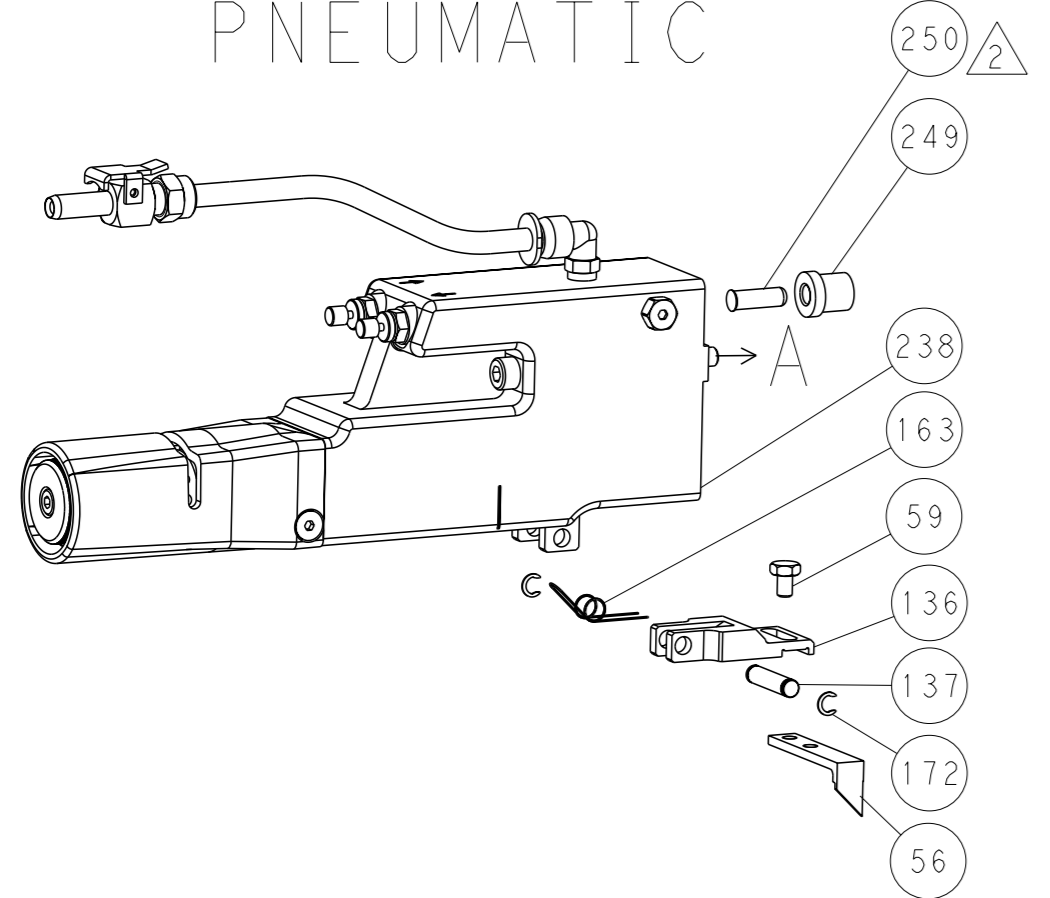


REVISONS		DATE	OWN	APVD
LOC	DIST			
A	66			
P	LYR			
		SEE SHEET 1		

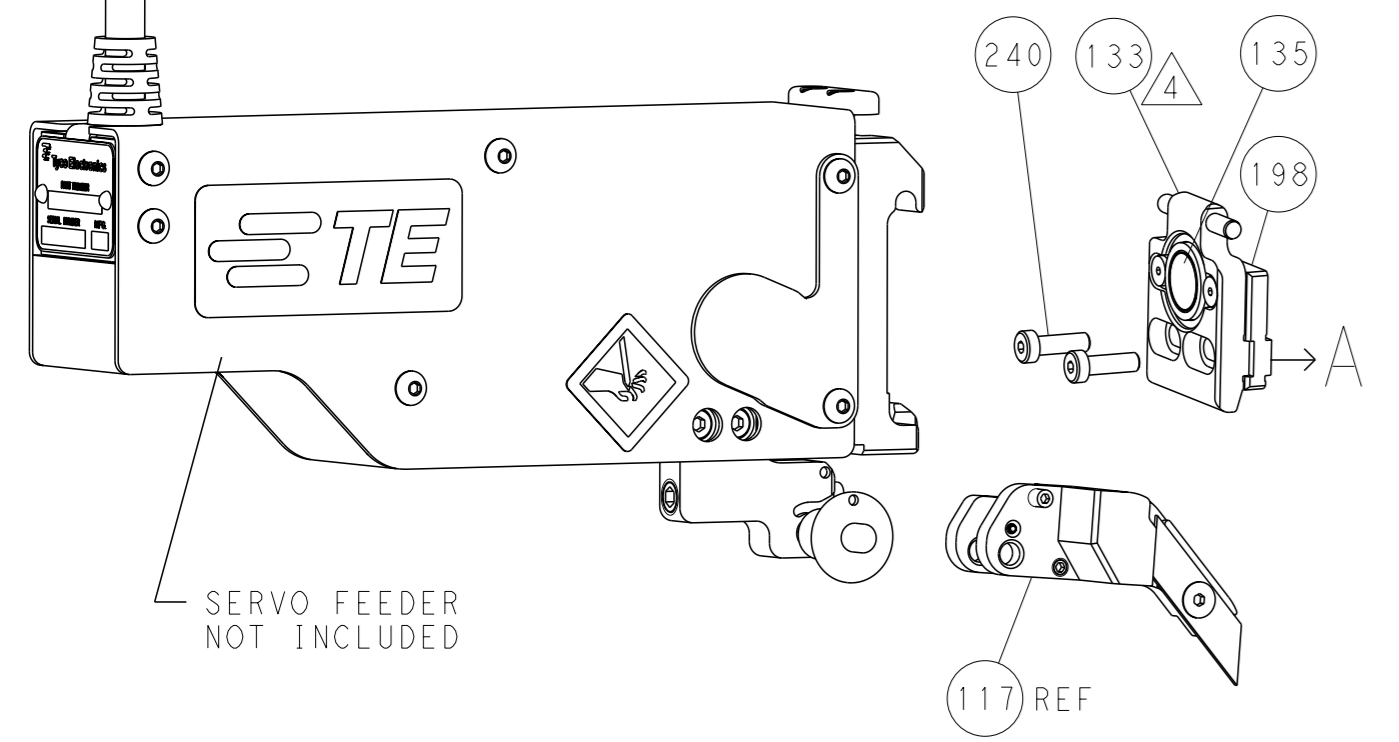
FEED TYPE MECHANICAL



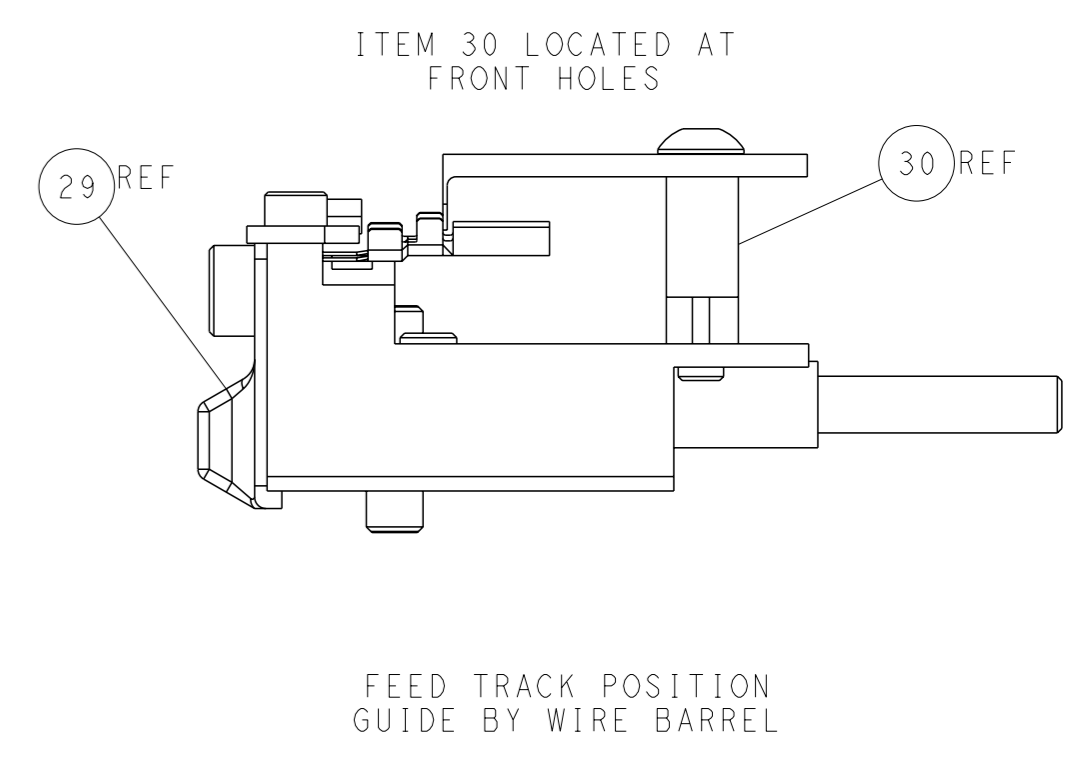
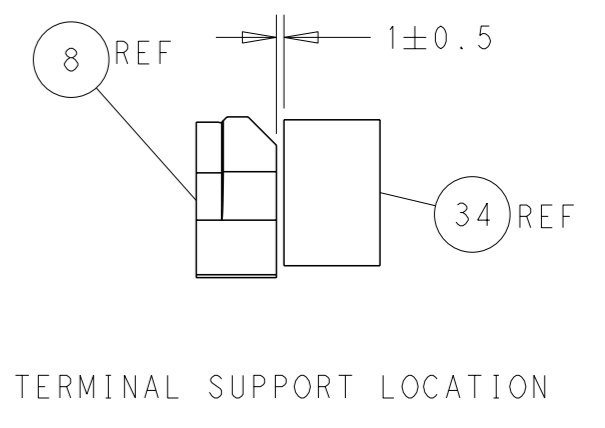
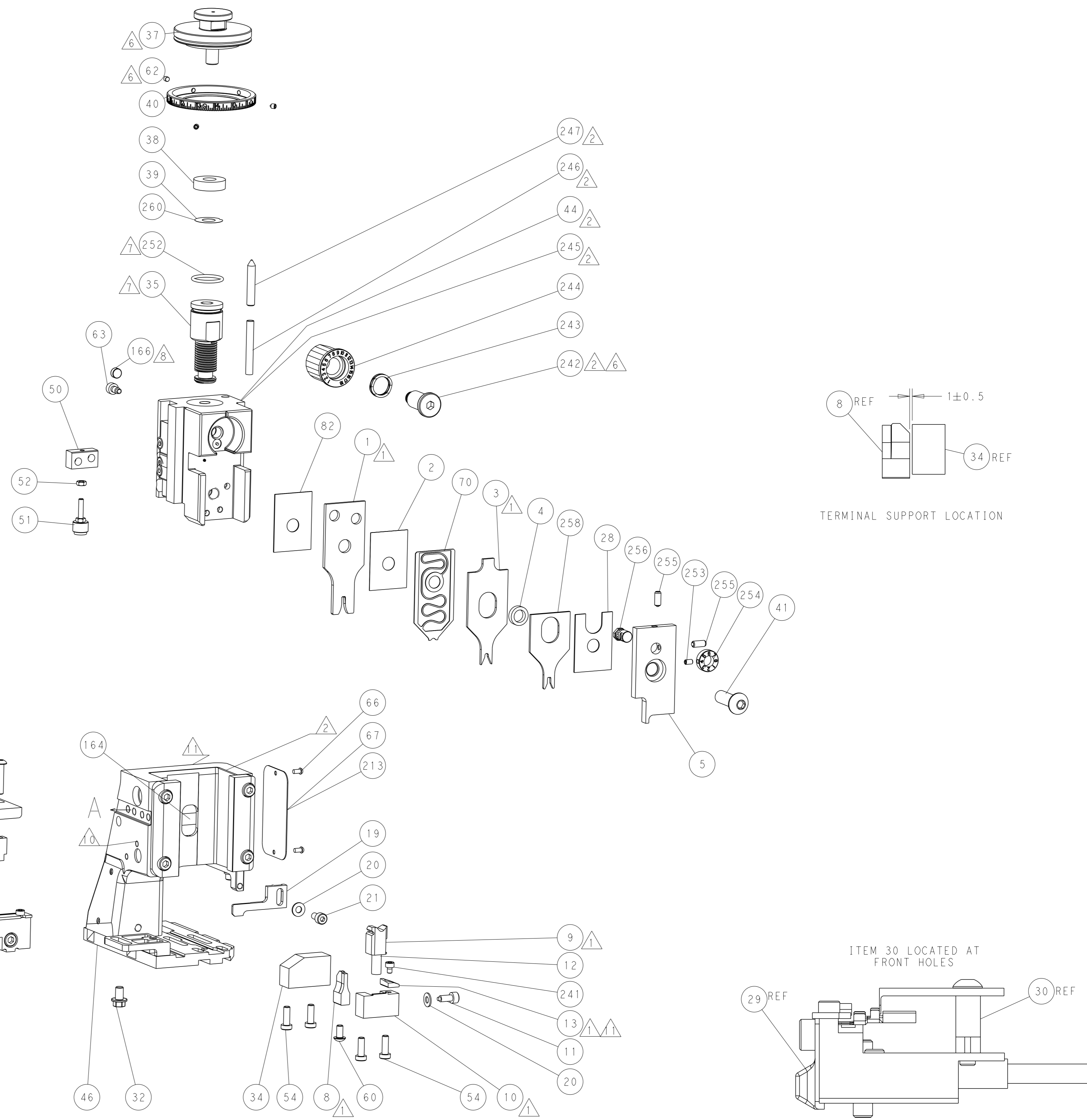
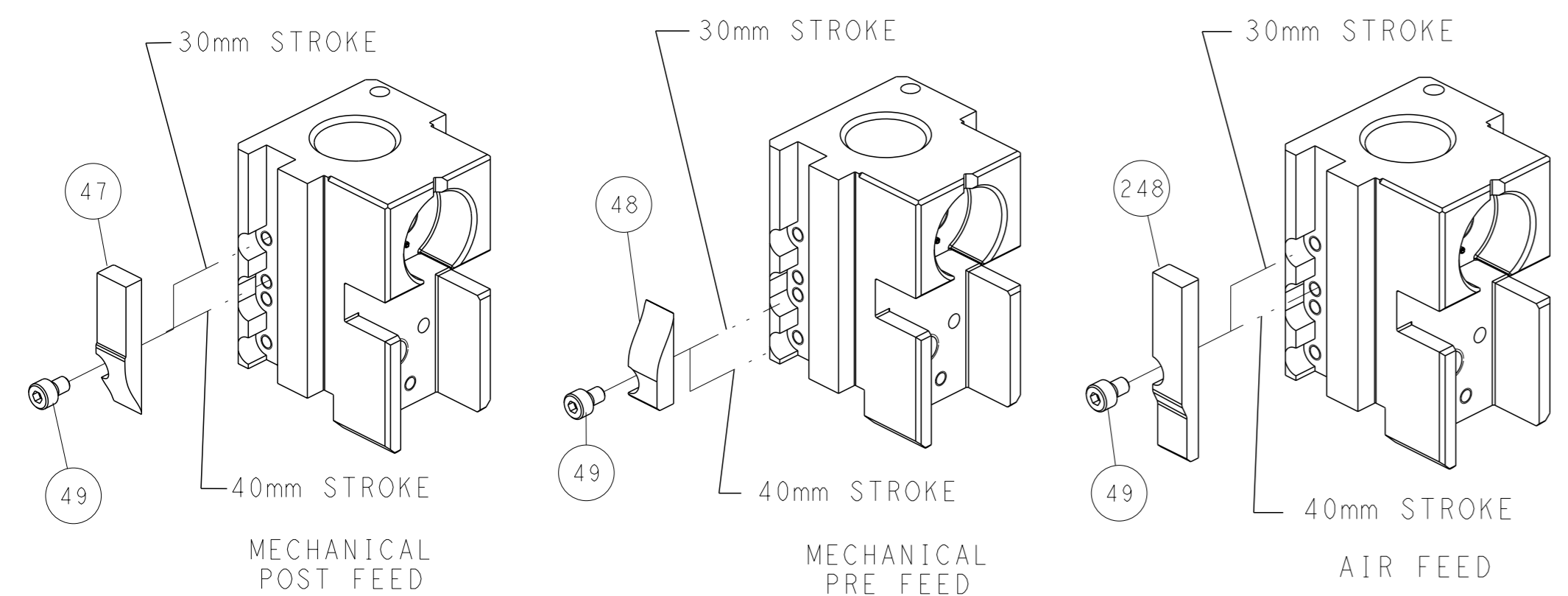
PNEUMATIC



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 TO CONTROLING DISCRETION. DIMENSIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.</small>		DWN: K. HUANG 27APR2016 CHK: K. HUANG 27APR2016 APVD: L. ZHANG 27APR2016	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: 2151335 WEIGHT: - SCALE: 1:2	RESTRICTED TO: - SHEET 2 OF 4 REV A
MATERIAL: - FINISH: -		Customer Accessible Production Drawing	

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

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO						PART NUMBERS REQUIRED					
					PNEUMATIC FEED	SERVO LATCH PLATE	SMART APPLICATOR	MECHANICAL FEED	SERVO LATCH PLATE	SMART APPLICATOR	PNEUMATIC FEED	SERVO LATCH PLATE	SMART APPLICATOR	MECHANICAL FEED	SERVO LATCH PLATE	SMART APPLICATOR
	2-2151335-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1	2119951-1	-	8-2151335-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2151335-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	2119951-1	-	8-2151335-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2151335-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2151335-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-	-	-	-	-
	7-2151335-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29 mm [.090]	F
INSUL	2.60 mm [.102]	F
STABILIZER	2.44 mm [.096]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .070 SERIES REC CONTACT FOR CAVUS WIRE (M)			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.50-4.00 mm [.138-.157 IN]		Ø1.20-1.90 mm [.047-.075 IN]	
TERMINAL APPLICATION SPECIFICATION	114-5134	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
175095-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.25mm2	1.52+/-0.05 [.060+/-0.002]	3.1
0.85mm2	1.37+/-0.05 [.054+/-0.002]	4.7
0.50mm2	1.25+/-0.05 [.049+/-0.002]	6.0

		P	LT#	DESCRIPTION	DATE	OWN	APVD
-	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE		251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED		250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI		249
-	1	1	1	1-22279-3	SPRING, COMPRESSION		246
-	1	1	1	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT		244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST		243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL		242
-	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
-	-	-	-	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	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
-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20		143
-	-	-	-	2119653-2	FEED CAM, POST FEED		142
-	1	1	1	1-2119656-0	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
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF		117
-	1	1	1	455888-5	SPACER, CRIMPER		82
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE		71
-	1	1	1	2119791-9	DEPRESSOR, WIRE		70
-	1	-	1	2119740-1	TAG, IDENTIFICATION		67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT		63
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0		62
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	-	-	1	1338685-1	PAWL, FEED		56
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3		52
-	1	1	1	811242-5	BUMPER, HOLD DOWN		51
-	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	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	2119644-1	RAM WASHER, PRECISION		38
-	1	1	1	1752356-3	SUPPORT, TERMINAL		34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)		33
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG		32
-	1	1	1	1-1320908-0	SPACER, STRIP GUIDE		30
-	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE		29
-	1	1	1	2119797-2	SPACER, CRIMPER, SPECIAL		28
-	1	1	1	1320928-2	STRIP GUIDE		24
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	2	2	2	1-18028-2	WASHER, FLAT, REG M4		20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED		19
-	1	1	1	2119806-1	INSERT, SHEAR		13
-	1	1	1	3-22280-3	SPRING, COMPRESSION		12
-	1	1	1	1-356885-4	STOP, SHEAR		11
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT		10
-	1	1	1	1803095-1	FLOATING SHEAR, FRONT		9
-	1	1	1	2-1633921-8	ANVIL, COMBINATION		8
-	-	-	-	-	-		7
-	-	-	-	-	-		6
-	1	1	1	2119349-2	SHEAR DEPRESSOR, STAB. CRIMP ADJ.		5
-	1	1	1	2-238011-6	BLOCK, CRIMPER SPACER		4
-	1	1	1	9-1633966-1	CRIMPER, INSULATION O		3
-	1	1	1	455888-2	SPACER, CRIMPER		2
-	1	1	1	1-456406-8	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: 8-2151335-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151335-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151335-5
- 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.
- SEE TERMINAL APPLICATION SPEC FOR CORRECT STABILIZER CRIMP HEIGHT.

*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.

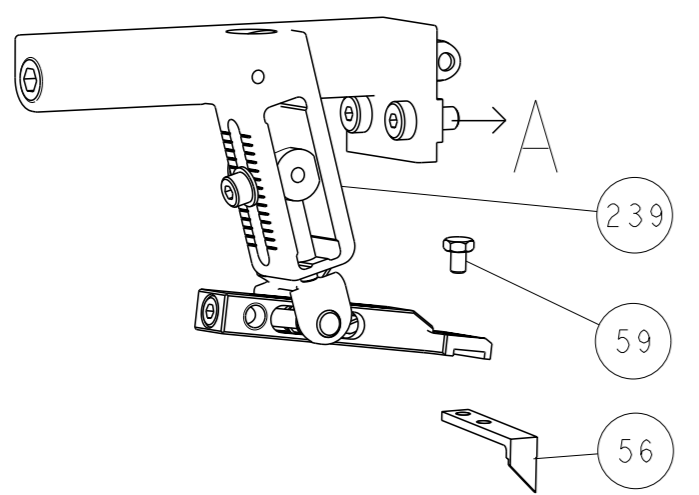
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1	1803406-1	CRIMPER, STABILIZER F PREMIUM	258				
-	2119348-3	SNAIL CAM, STABILIZER CRIMP ADJUSTMENT	256				
-	2079844-1	SPRING PLUNGER, M4	255				
-	2119347-1	KNOB, STABILIZER CRIMP ADJUSTMENT	254				
-	18032-1	SCR, SET, FLT POINT M3 X 5.0	253				
ITEM NO	PART NO	DESCRIPTION	ITEM NO				
-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)

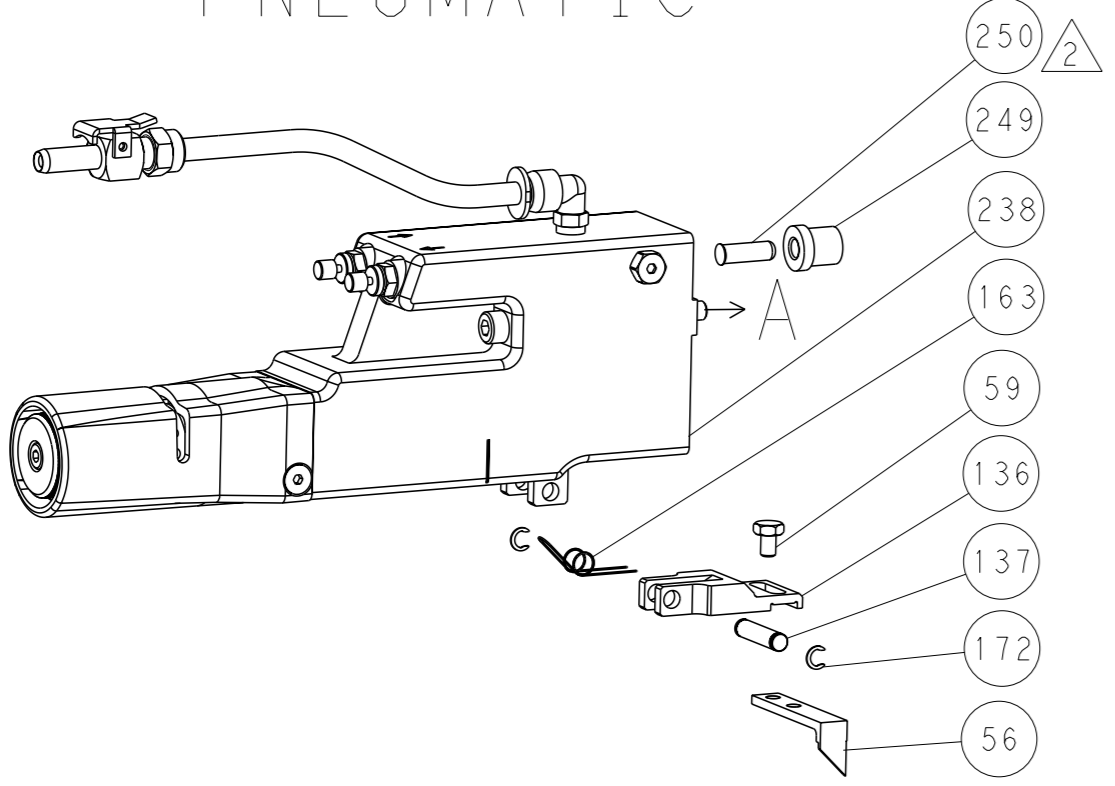
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2 PLC	±	3 PLC	±	K. HUANG	Harrisburg, PA 17105-3608	27APR2016			
4 PLC	±	ANGLES	±	L. ZHANG	Ocean Side Feed	27APR2016			
FINISH	-	FINISH	-		Applicator				
MATERIAL	-	WEIGHT	-		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	
					A1	00779	©=2151335		
Customer Accessible Production Drawing						SCALE	1:2	SHEET 3 of 4	REV A

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

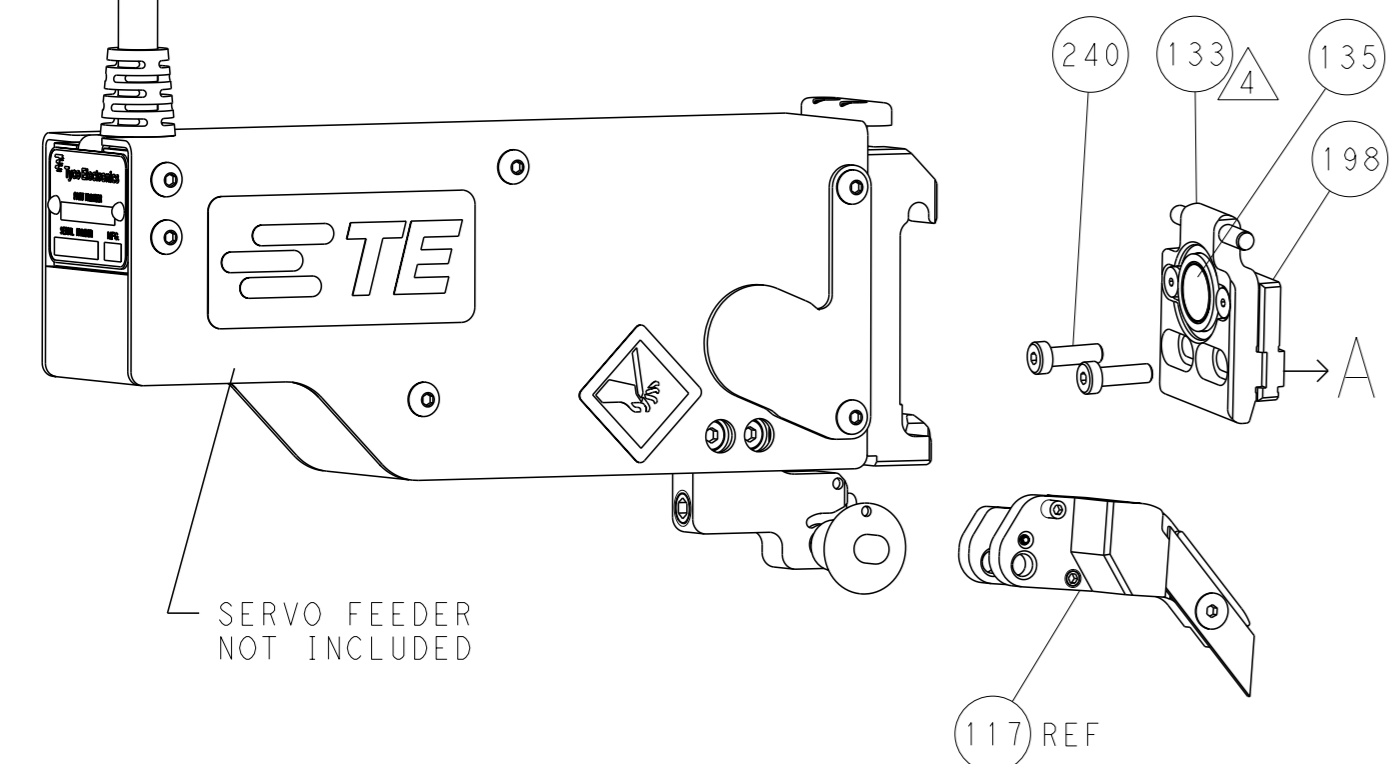
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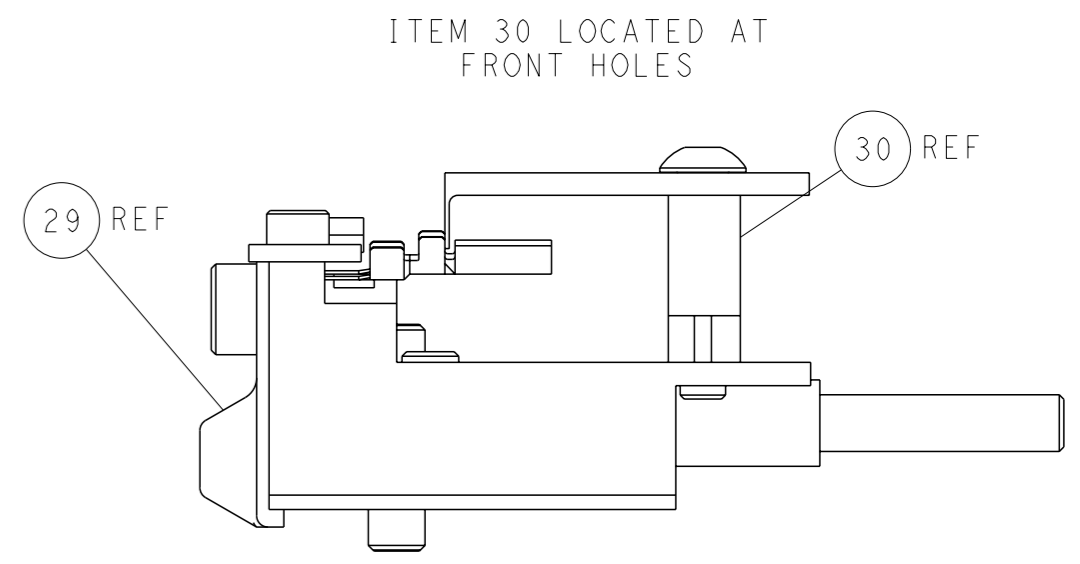
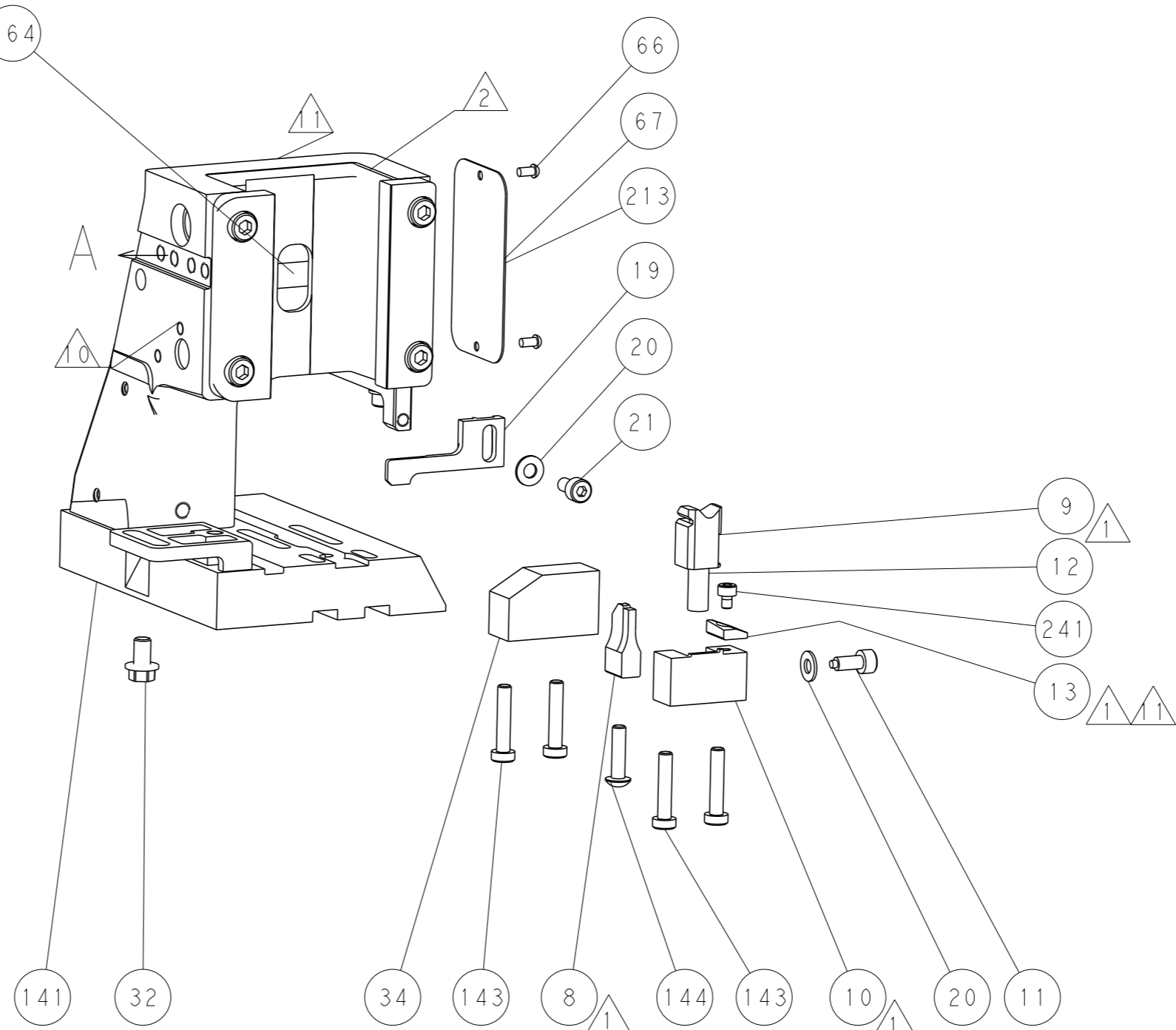
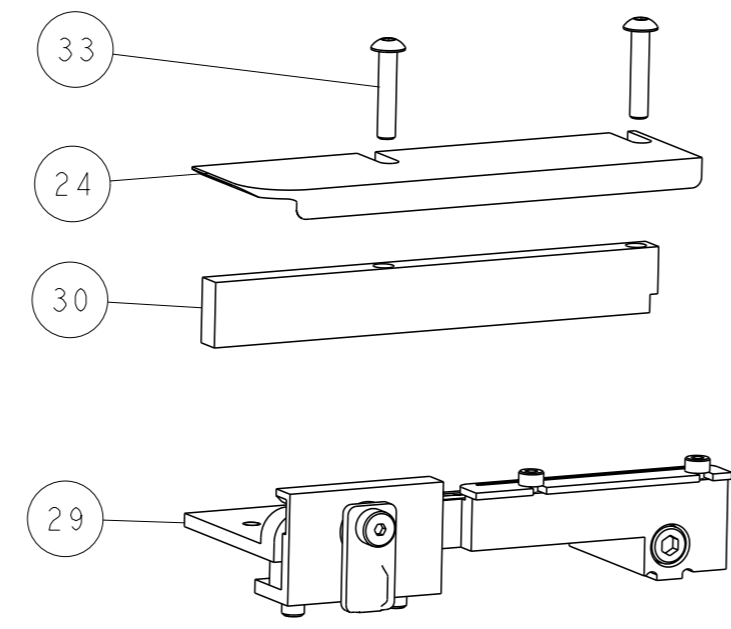
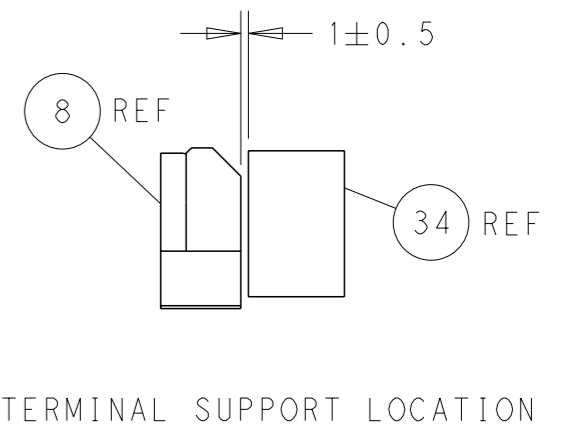
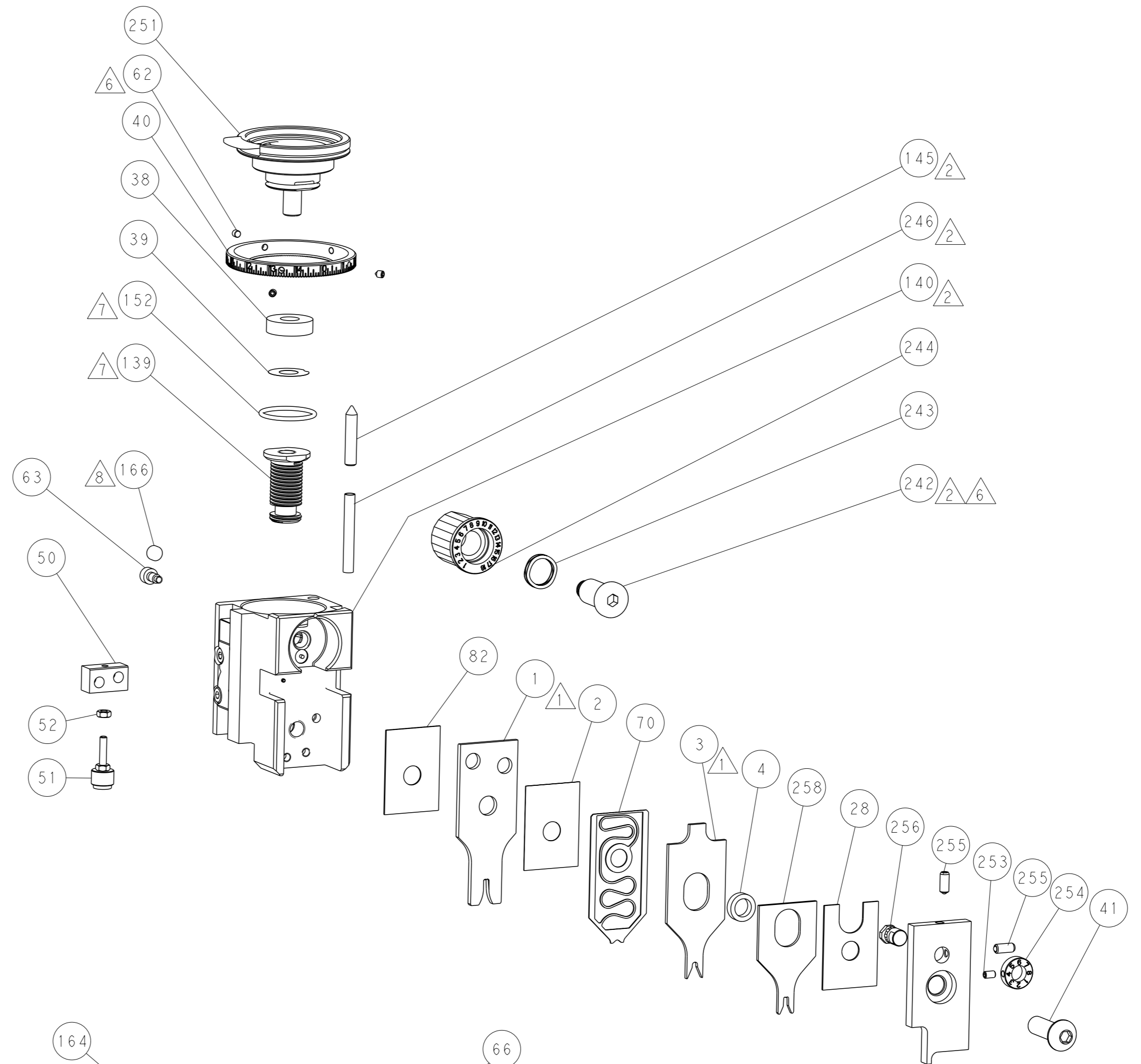
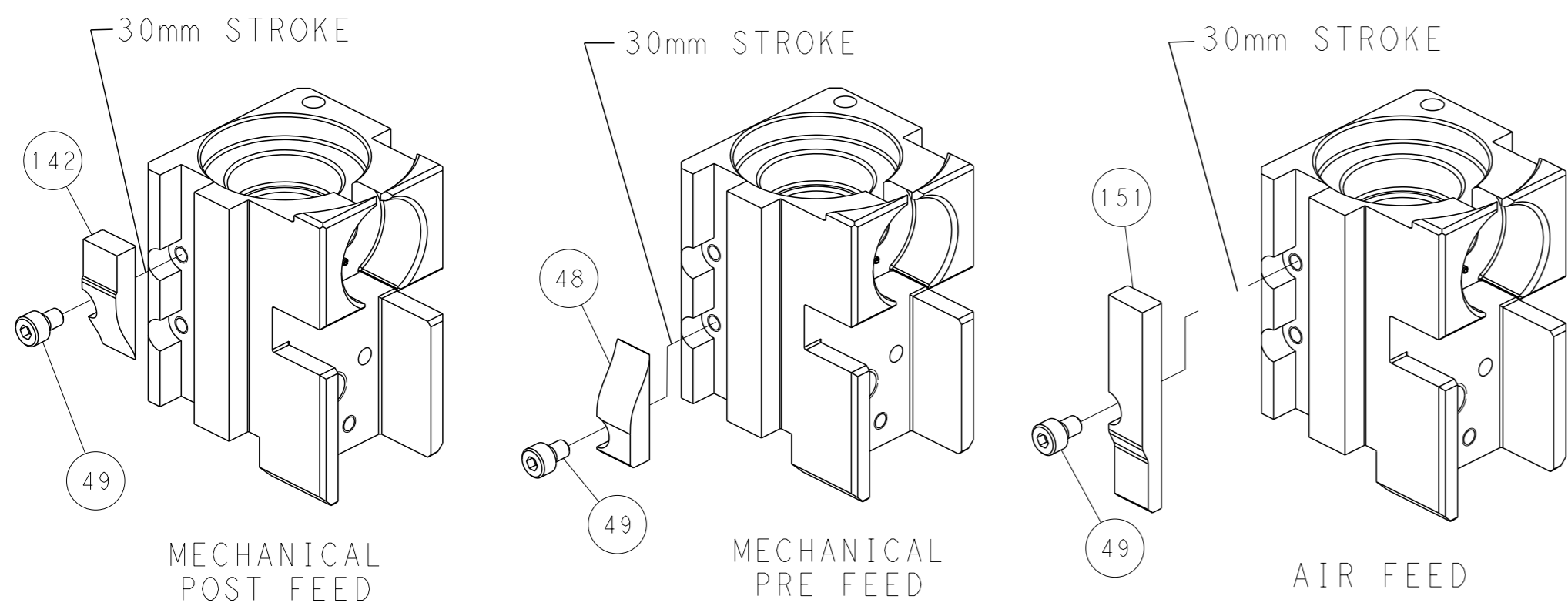
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
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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: 2151335	RESTRICTED TO:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING
MATERIAL:		WEIGHT:	SCALE: 1:2	SHEET 4 OF 4 REV A