

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 and insul specifications.

TERMINAL DATA: TE TERMINAL. TE CRIMP SPECIFICATION. Includes wire strip length, insulation diameter range, and terminal application specifications.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table with columns for wire size and crimp height settings.



- 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 50, 62 & 242.
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 -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT 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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists spare parts like applicator shim pack, o-ring, and push rod.

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

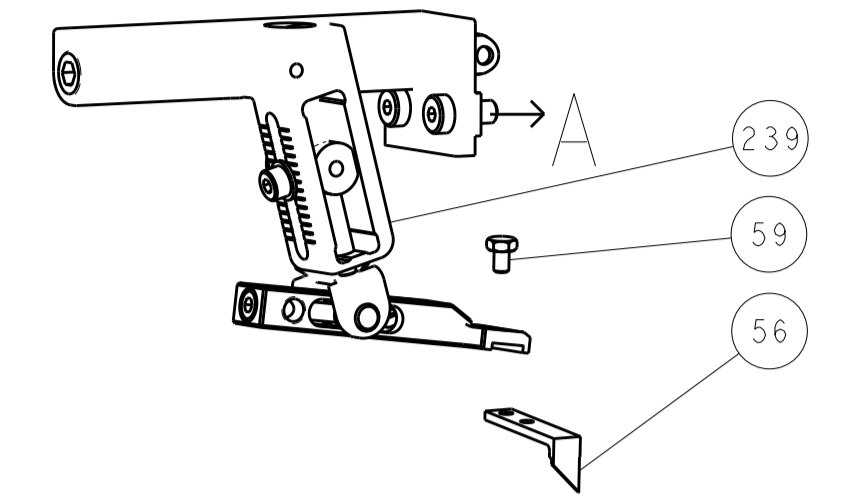
REVISIONS table with columns: REVISION, DESCRIPTION, DATE, DWN, APVD. Shows revision A1 for ECR-13-012447.

Main assembly list table with columns: QTY, P, LTR, DESCRIPTION, DATE, DWN, APVD. Lists various components like bushing, feed cam, detent pin, spring, washer, etc.

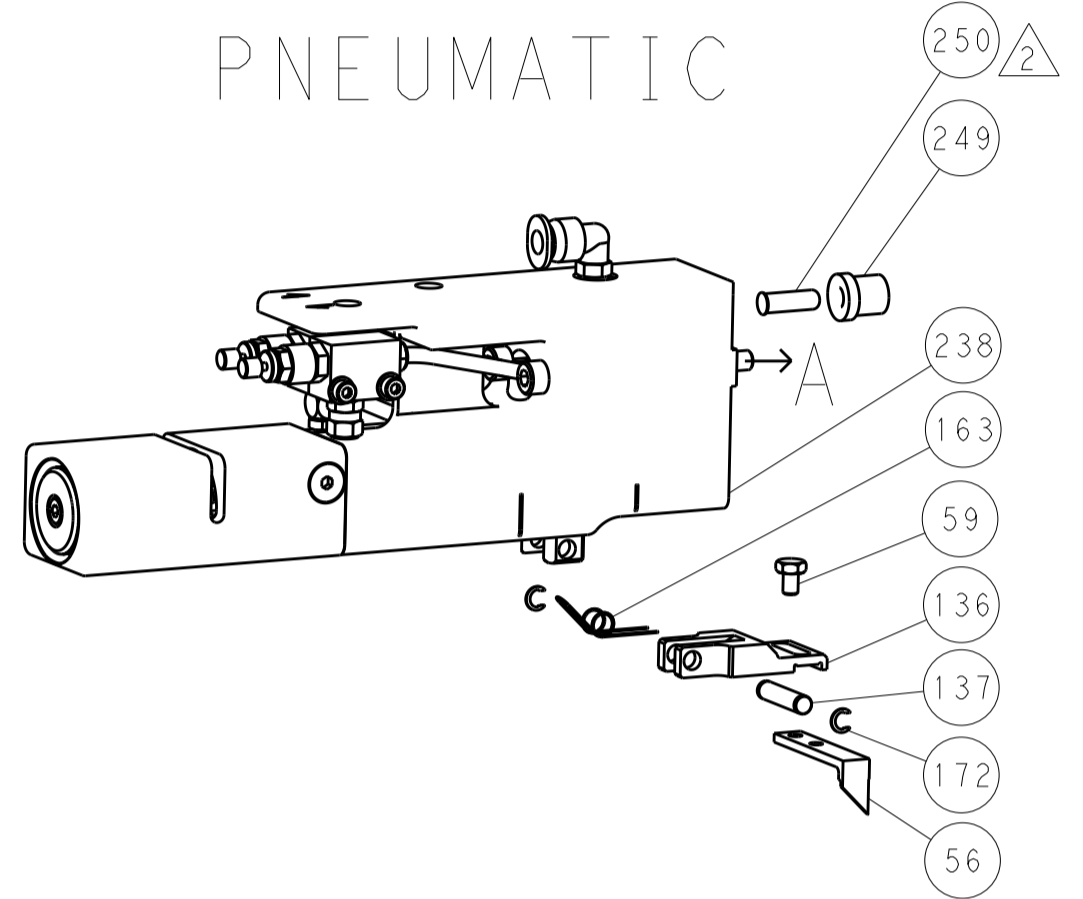
TE Connectivity logo and product information: Ocean Side Feed Applicator. Includes dimensions, tolerances, material, and drawing scale.

LOC		DIST		REVISIONS			
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
-	-	-	-	SEE SHEET 1	-	-	-

FEED TYPE MECHANICAL



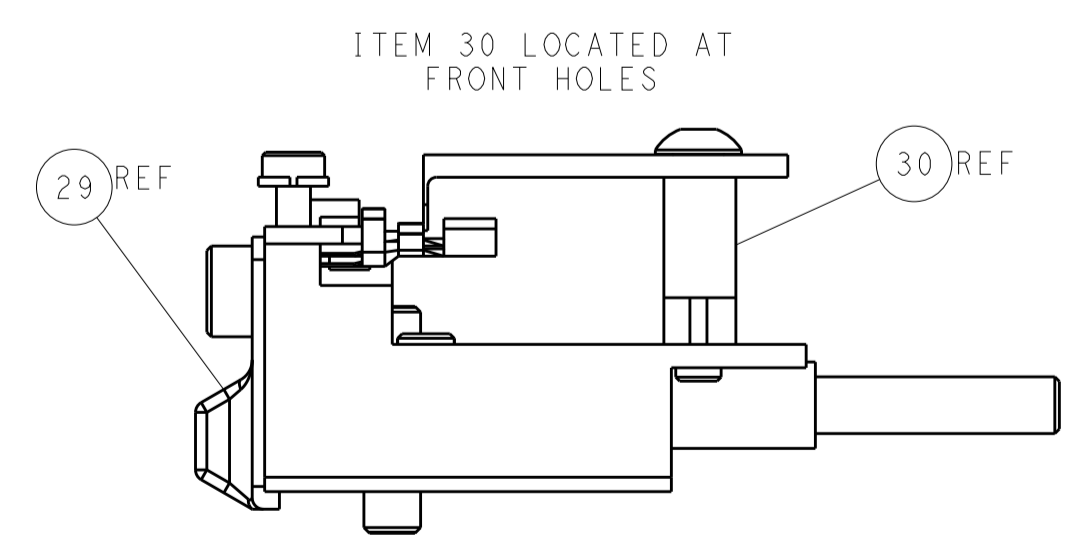
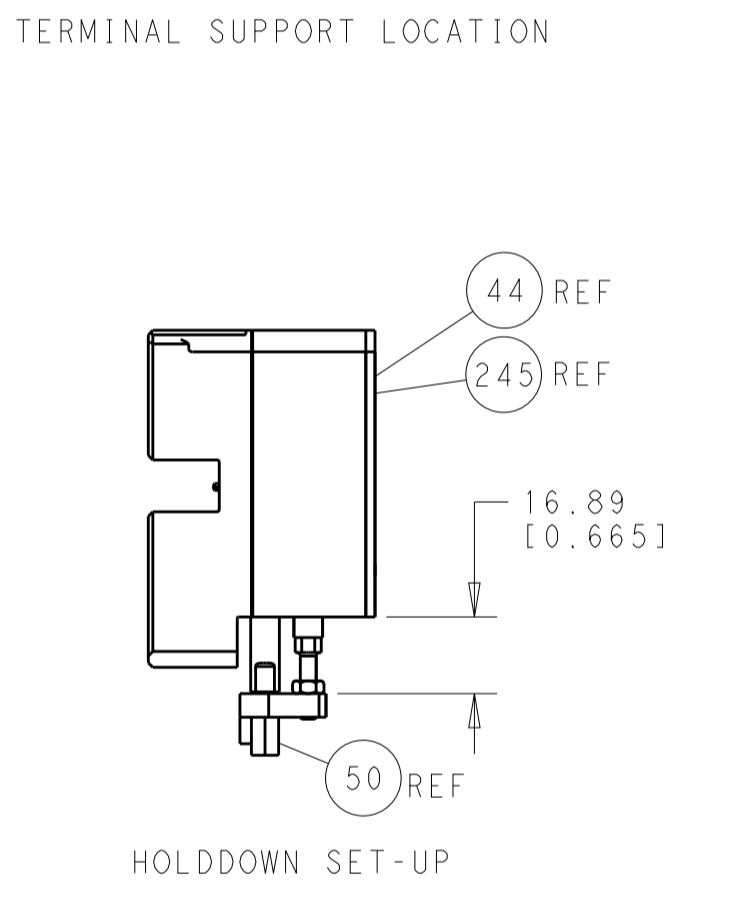
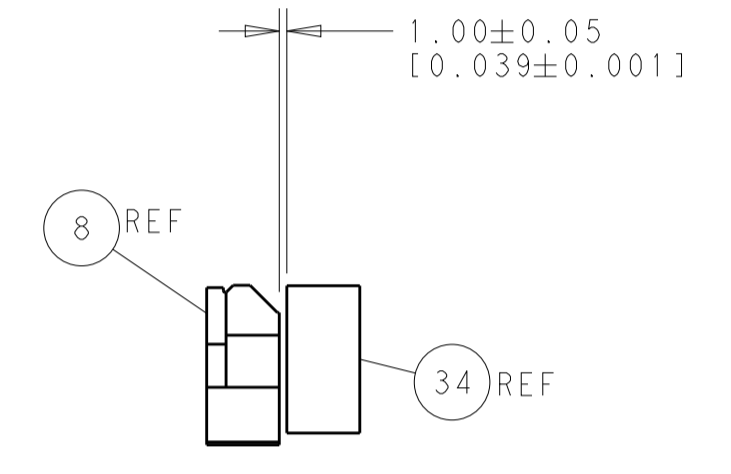
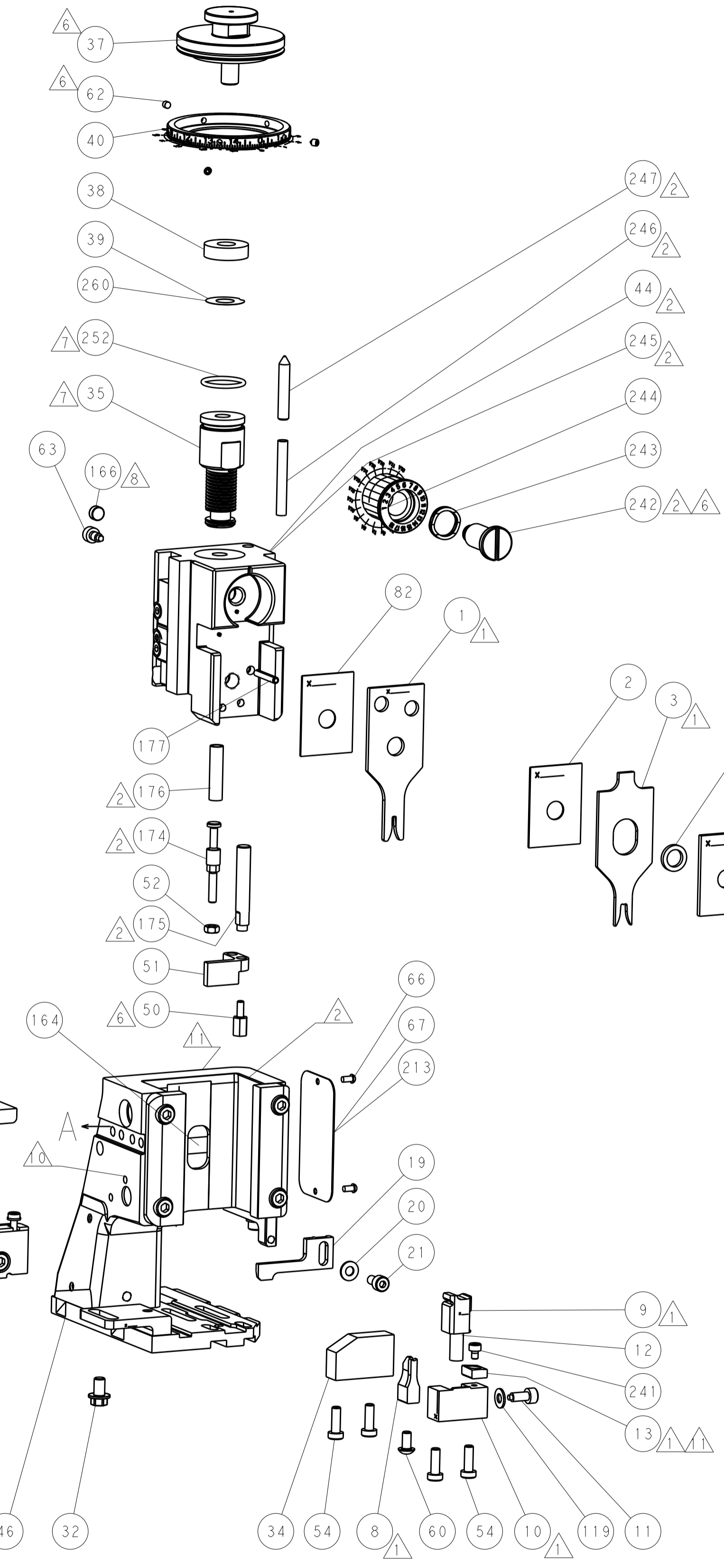
PNEUMATIC



SERVO LATCH PLATE

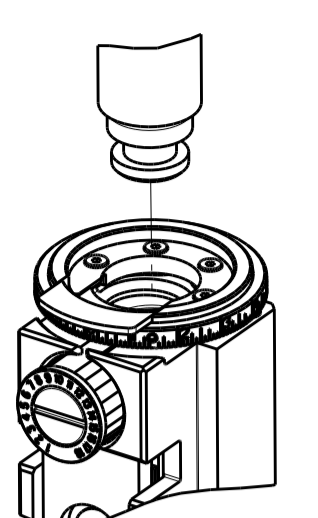


CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.13	2 PLC ±0.013	3 PLC ±0.001	DMN	23JUN2011	TE Connectivity
	4 PLC ±0.001	ANGLES ±		CHK	S.XI	23JUN2011	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	APVD:	I. CRUZ	23JUN2011	NAME
			1:2	PRODUCT SPEC			Ocean Side Feed Applicator
			SHEET 2 of 4	APPLICATION SPEC			SIZE
			REV A1	RESTRICTED TO			A1 00779 ©=2151130
			Customer Accessible Production Drawing				

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO						
					PART NUMBERS REQUIRED						
	2-2151130-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151130-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2151130-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151130-5	1901094-3	-	2168400-6 (QUANTITY 2)
	2-2151130-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4	SMART APPLICATOR	2161326-1	-	8-2151130-4	-	-	-
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
	2-2151130-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
					-	-	-	-	-	-	-
	7-2151130-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

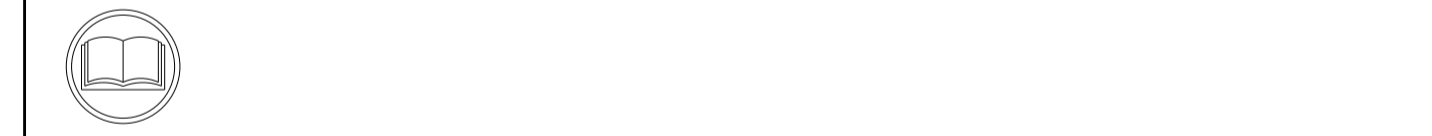
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	3.30 mm [.130]	F

408-10389

TERMINAL NAME: 5.0 POWER KEY CONN REC CTC	
WIRE STRIP LENGTH 3.00-4.00 mm [.118-.157 IN]	INSULATION DIAMETER RANGE Ø1.70-2.70 mm [.067-.106 IN]
TERMINAL APPLICATION SPECIFICATION 114-5292	-

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1376348-1	1376348-2		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG or 0.51-0.53 mm ²	0.96+/-0.05 [.038+/-0.002]	4.7
22 AWG or 0.31-0.37 mm ²	0.86+/-0.05 [.034+/-0.002]	5.7
24 AWG or 0.22-0.23 mm ²	0.80+/-0.05 [.031+/-0.002]	6.3



- 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: 8-2151130-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151130-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151130-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151130-6
- 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 50, 62 & 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.

-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251

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

REV	DATE	DESCRIPTION	APPD	CHK
1	2119599-1	SET UP GAUGE	A	66

REV	DATE	DESCRIPTION	APPD	CHK
-	-	SEE SHEET 1		
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DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE: 23JUN2011	CHK: J.X ZHAO
mm	0 PLC ±.5 1-5 PLC ±0.13 6-9 PLC ±0.013 10-12 PLC ±0.001	APVD: J. CRUZ	DATE: 23JUN2011
MATERIAL:	FINISH:	PRODUCT SPEC:	NAME: Ocean Side Feed Applicator
Customer Accessible Production Drawing		SCALE: 1:2	SHEET 3 OF 4

STE TE Connectivity
Harrisburg, PA 17105-3608

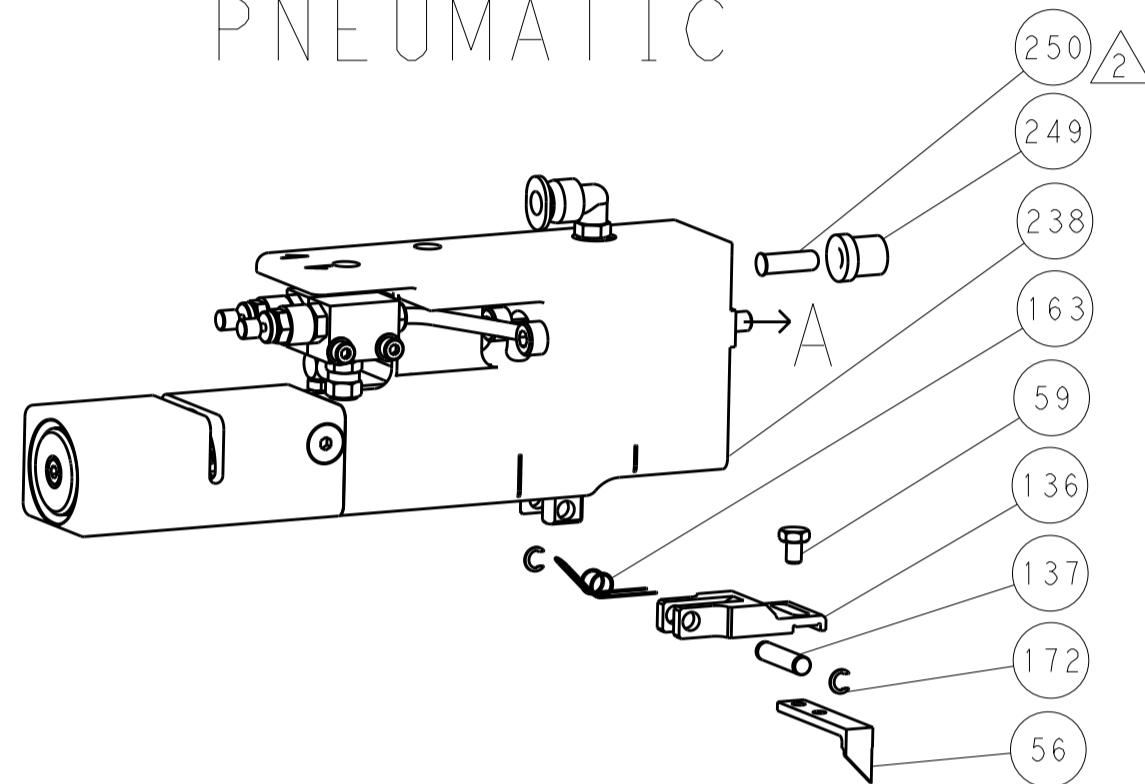
RESTRICTED TO:
A1

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

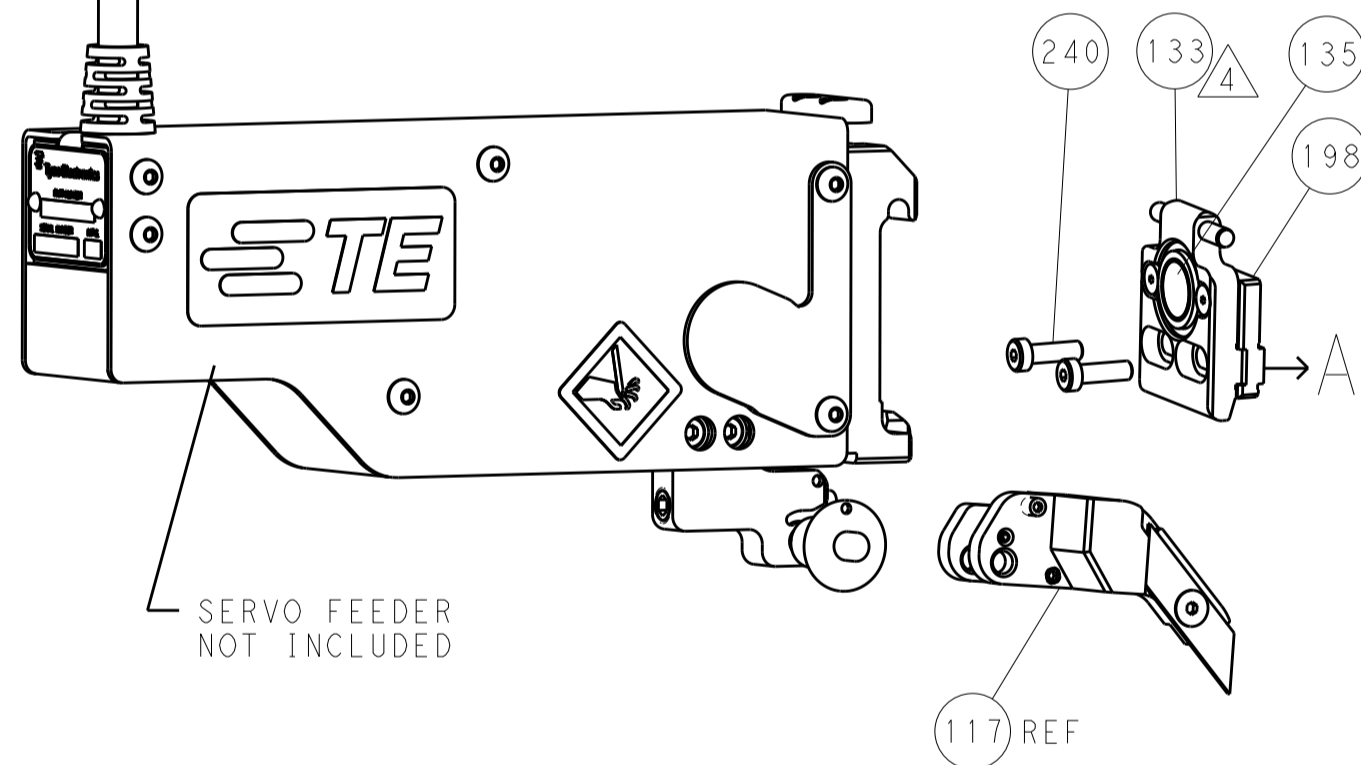
FEED TYPE MECHANICAL



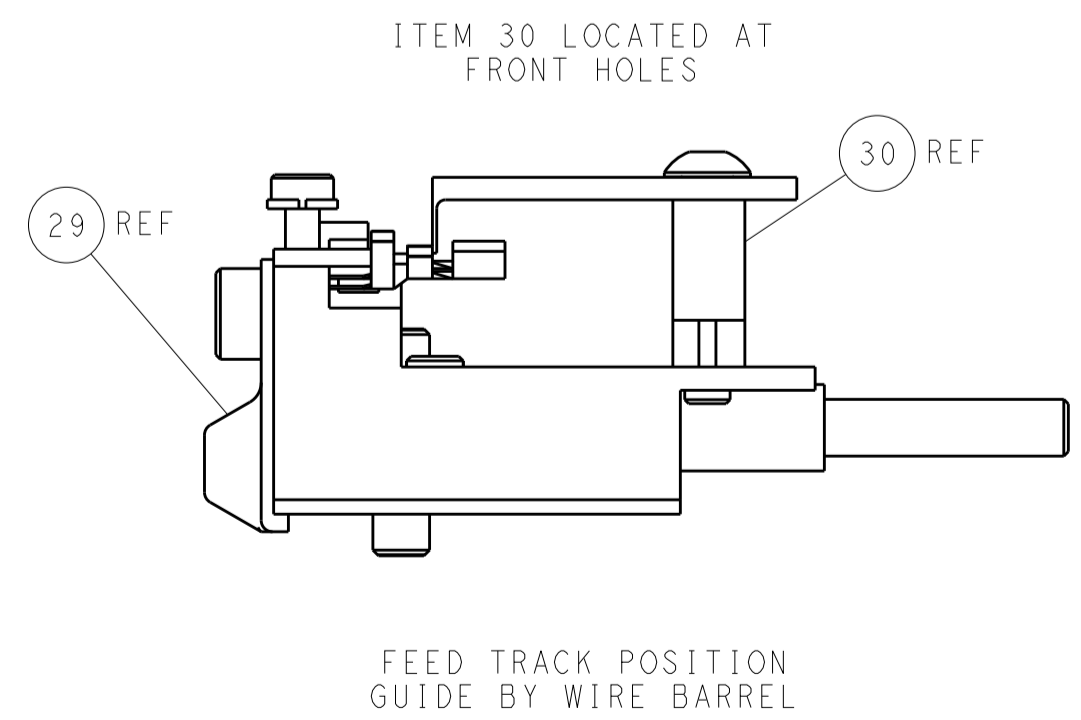
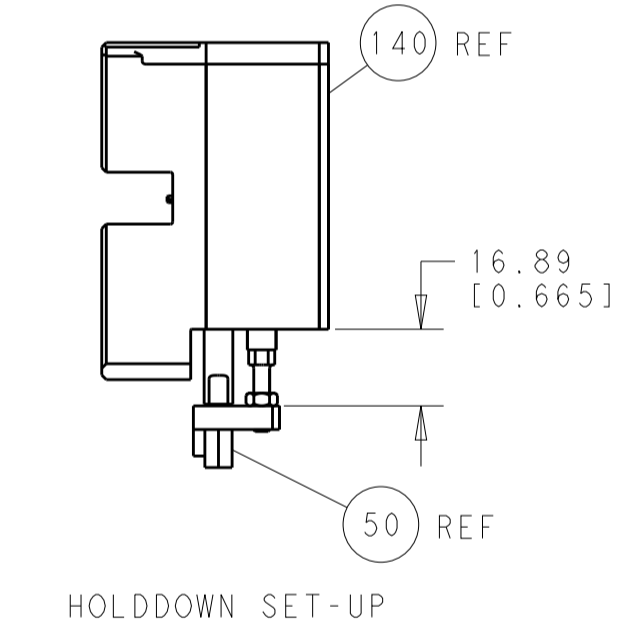
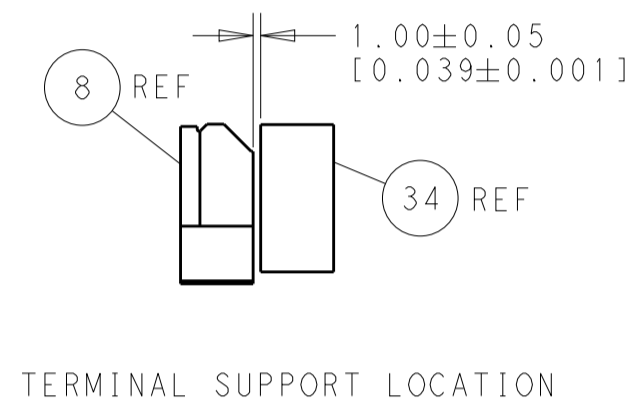
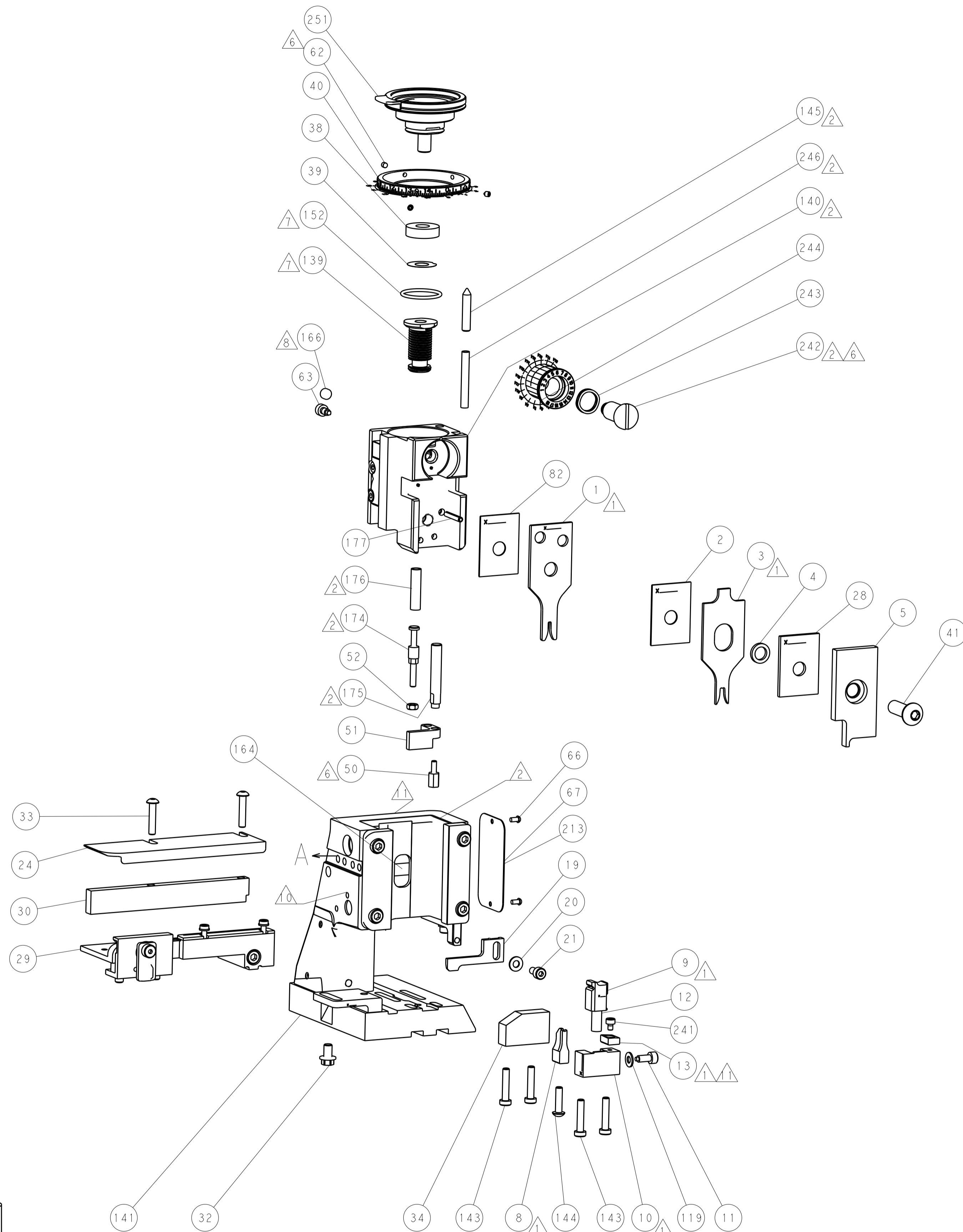
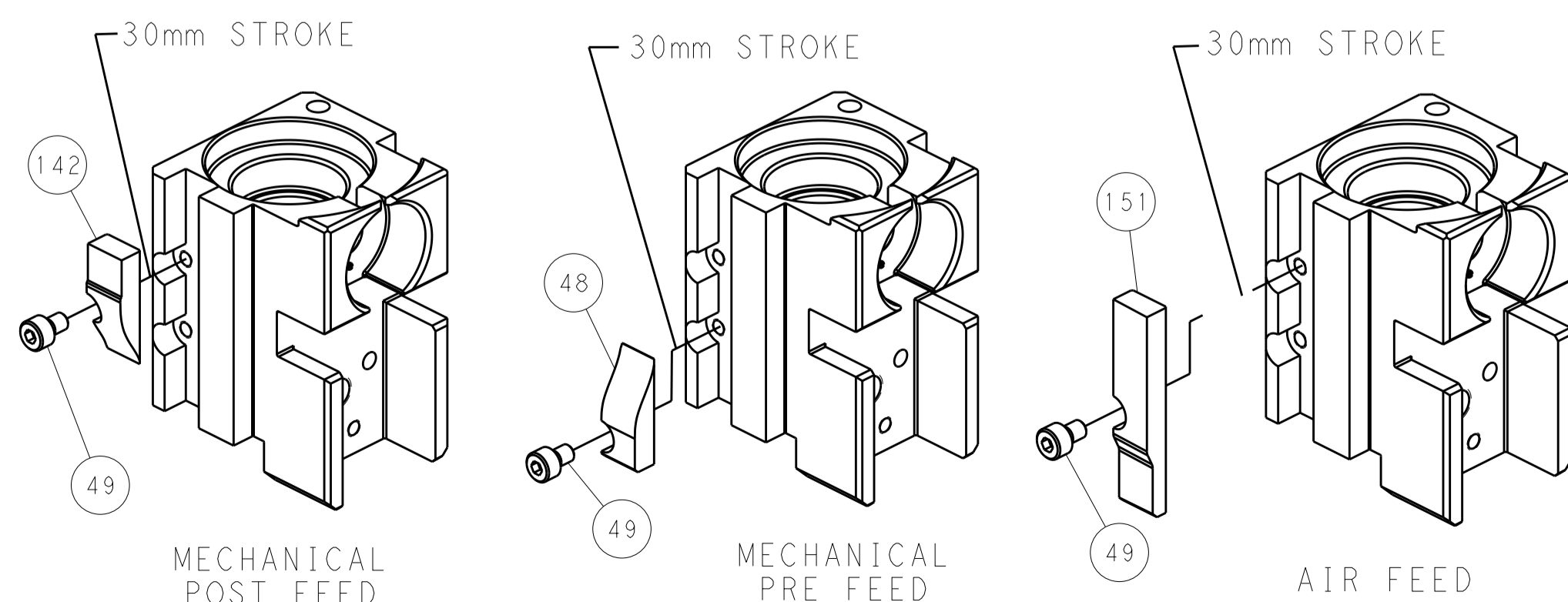
PNEUMATIC



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:		DWG: X_ZHAO 23JUN2011		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD: J_CRUZ 23JUN2011	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
-		-		SIZE: A1		CAGE CODE: 00779	
-		-		DRAWING NO: 2151130		SCALE: 1:2	
-		-		SHEET: 4		OF: 4	
-		-		REV: A1		-	