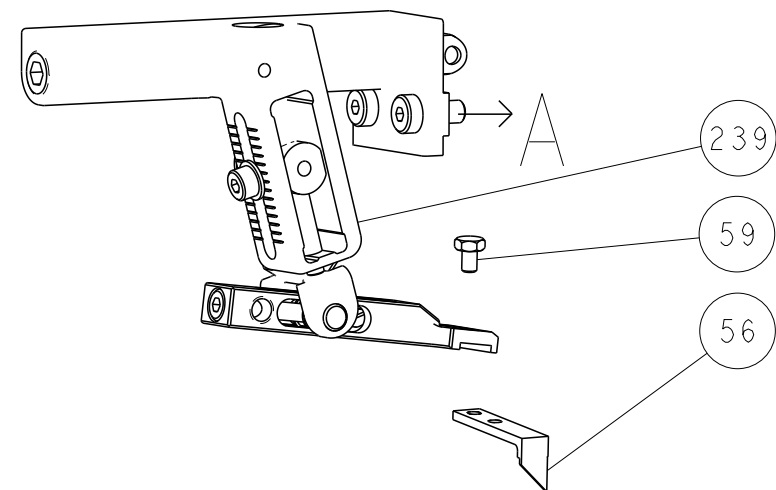
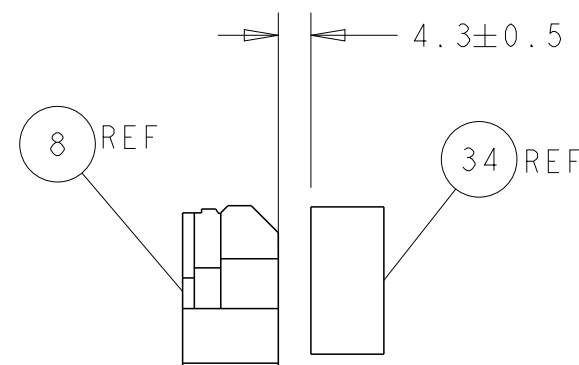
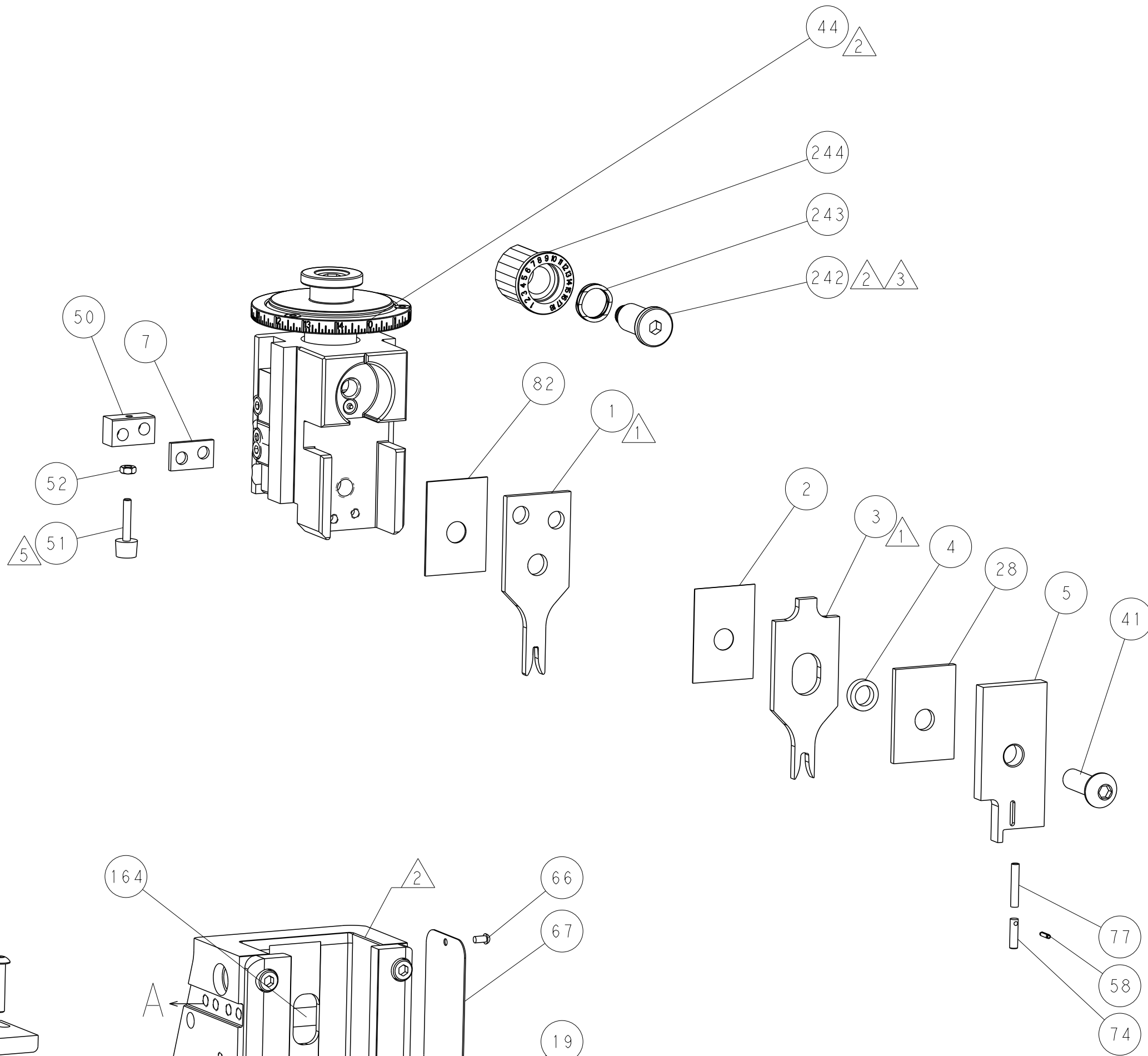
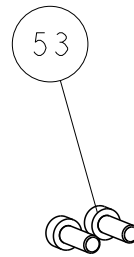
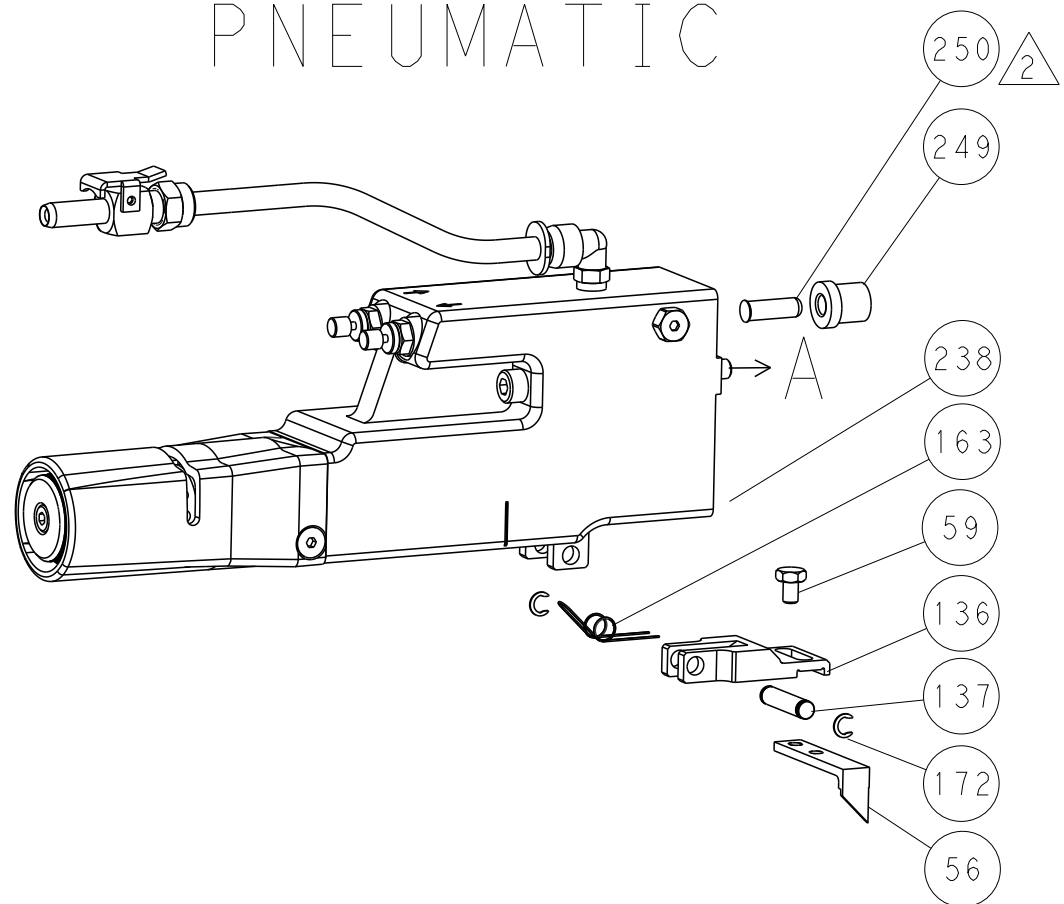


LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

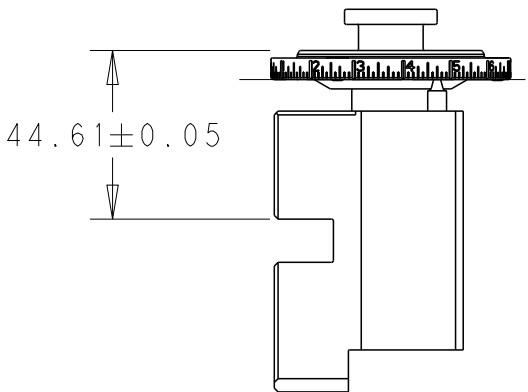
FEED TYPE
MECHANICAL



PNEUMATIC

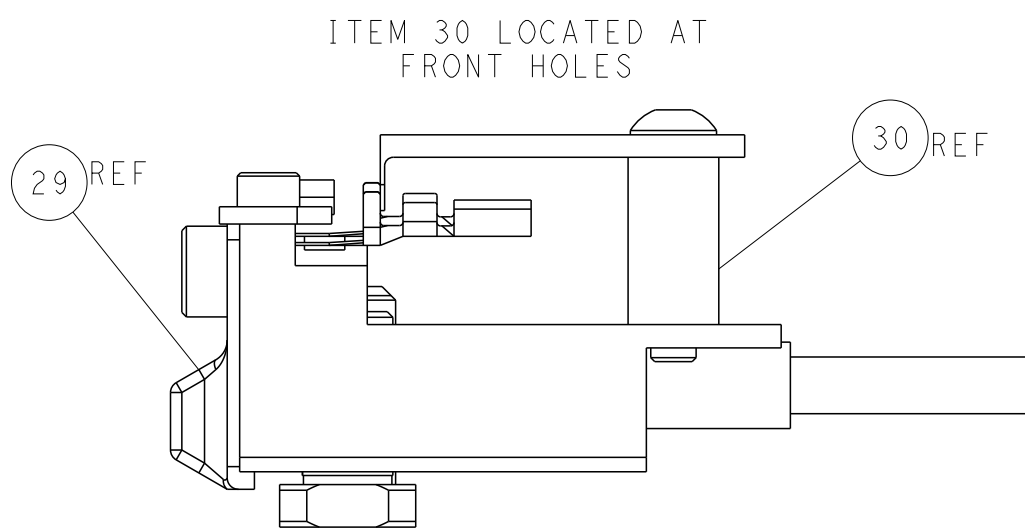
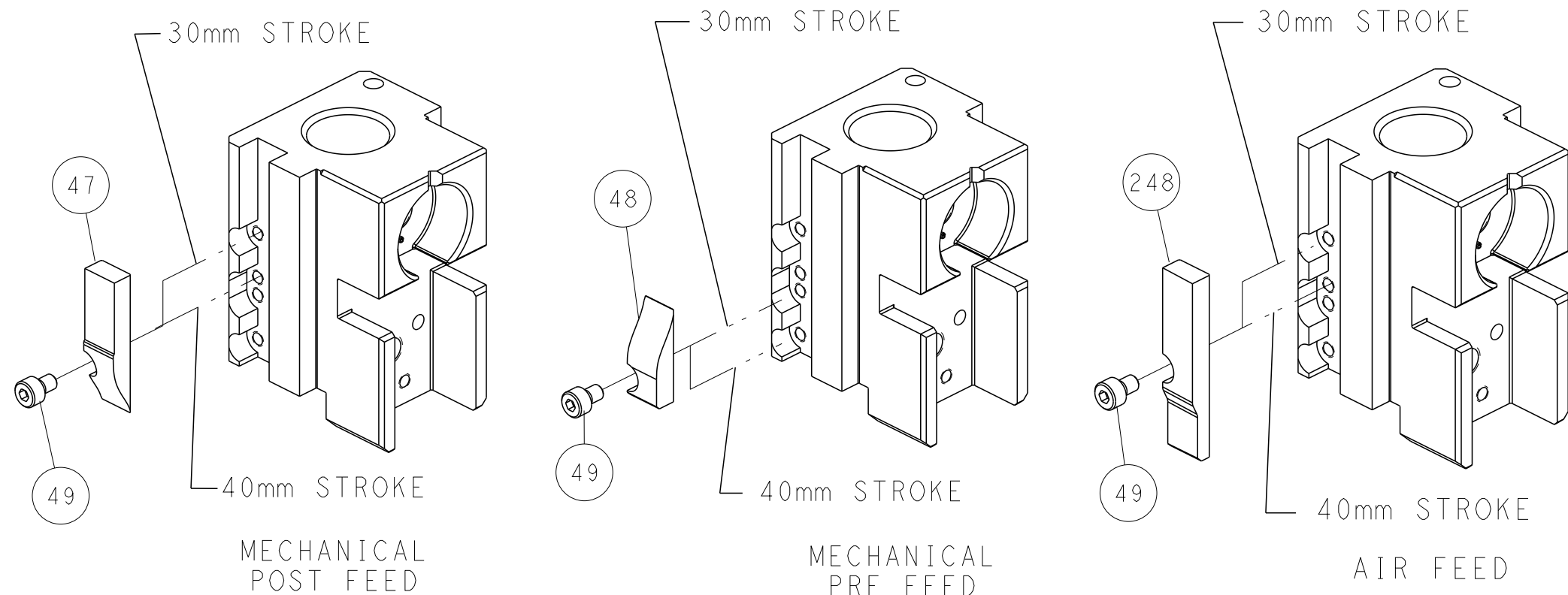


TERMINAL SUPPORT LOCATION



RAM SET-UP

CAM POSITIONS



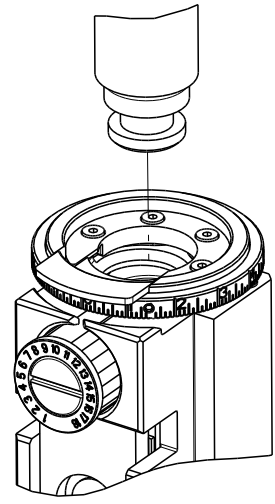
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

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DIMENSIONS:		CHK	03SEP2012	Harrisburg, PA 17105-3608	
mm		APVD	03SEP2012	NAME	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		Ocean Side Feed Applicator	
0 PLC ±		APPLICATION SPEC		SIZE	
1 PLC ±		WEIGHT		CAGE CODE	
2 PLC ±		Customer Accessible Production Drawing		DRAWING NO	
3 PLC ±		SCALE	1:2	RESTRICTED TO	
4 PLC ±		SCALE	1:2	SHEET	
ANGLES		SCALE	1:2	REV	
FINISH		SCALE	1:2	REV	
MATERIAL		SCALE	1:2	REV	
-		SCALE	1:2	REV	
-		SCALE	1:2	REV	

8		7	
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20		20	
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PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151743-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151743-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151743-7	B	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	3.56 mm [.140]	OV
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: NEXT GENERATION SOFT SHELL CONTACT			
WIRE STRIP LENGTH 4.20-4.80 mm [.165-.189 IN]		INSULATION DIAMETER RANGE Ø2.00-3.30 mm [.079-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-106118	-	-
	(B)114-106147	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 1971783-1	(A) 1971783-2	(A) 1971784-1	(A) 1971784-2
(B) 2232723-1	(B) 2232723-2	(B) 2232724-1	(B) 2232724-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
16 AWG OR 1.27mm2	1.37+/-0.04 [.054+/- .002]	2.6
18 AWG OR 0.80mm2	1.21+/-0.04 [.048+/- .002]	4.4
19 AWG OR 0.70mm2	1.08+/-0.04 [.043+/- .002]	5.7
(2) 22 AWG	1.07+/-0.04 [.042+/- .002]	5.8

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: NEXT GENERATION SOFT SHELL CONTACT			
WIRE STRIP LENGTH 4.20-4.80 mm [.165-.189 IN]		INSULATION DIAMETER RANGE Ø2.00-3.30 mm [.079-.130 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-106118	-	-
	-	-	-
TERMINALS APPLIED			
(A)2238066-1	(A)2238066-2	(A)2238067-1	(A)2238067-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.80mm2	0.99+/-0.03 [.069+/- .001]	6.4



1. RECOMMENDED SPARE PARTS
2. REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
3. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
4. 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.
5. ADJUST ITEM 51 WHEN SWITCHING TERMINALS.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
7. FOR (2) 22 AWG WIRE, MAXIMUM INSULATION DIAMETER PER WIRE IS Ø 2.03mm.

*WARNING
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

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			
P	LTR	DESCRIPTION		DATE	DWN	APVD	
-	-	SEE SHEET 1		-	-	-	

-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2063440-1	AIR FEED MODULE	238
-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-6	SPACER, CRIMPER	82
-	1	1	22278-8	SPRING, COMPRESSION	77
-	1	1	854769-4	HOLDER, INS	74
-	1	1	1803607-1	DOCUMENTATION PACKAGE	71
-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
5	-	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	50
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2-2844962-8	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	2-455888-2	SPACER, CRIMPER	28
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
△	-	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
△	-	1	2119805-1	SHEAR HOLDER, FRONT	10
△	-	1	1803095-1	FLOATING SHEAR, FRONT -	9
△	1	1	1-1803079-3	ANVIL, WITH STABILIZER	8
-	1	1	4-240641-2	SPACER	7
-	-	-	-	-	6
-	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
-	1	1	238011-2	BLOCK, CRIMPER SPACER	4
△	1	1	2-2119785-6	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	455888-2	SPACER, CRIMPER	2
△	1	1	5-456405-6	CRIMPER, WIRE PREMIUM	1

-77	-22	-21	PART NO	DESCRIPTION	ITEM NO
			DWN L.ZHANG CHK L.ZHANG APVD S.XI	03SEP2012 03SEP2012 03SEP2012	
			TE Connectivity Harrisburg, PA 17105-3608		
			NAME Ocean Side Feed Applicator		
			SIZE A1	CAGE CODE 00779	DRAWING NO C=2151743
			RESTRICTED TO -		
			Customer Accessible Production Drawing	SCALE 1:2	SHEET 3 OF 4
			REV E		

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

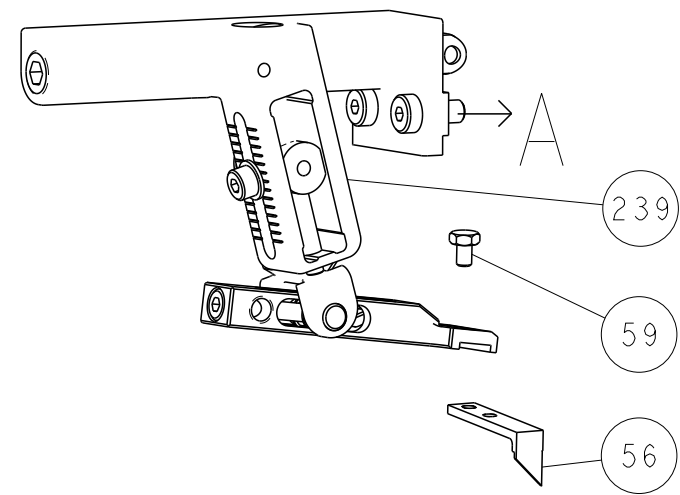
D

C

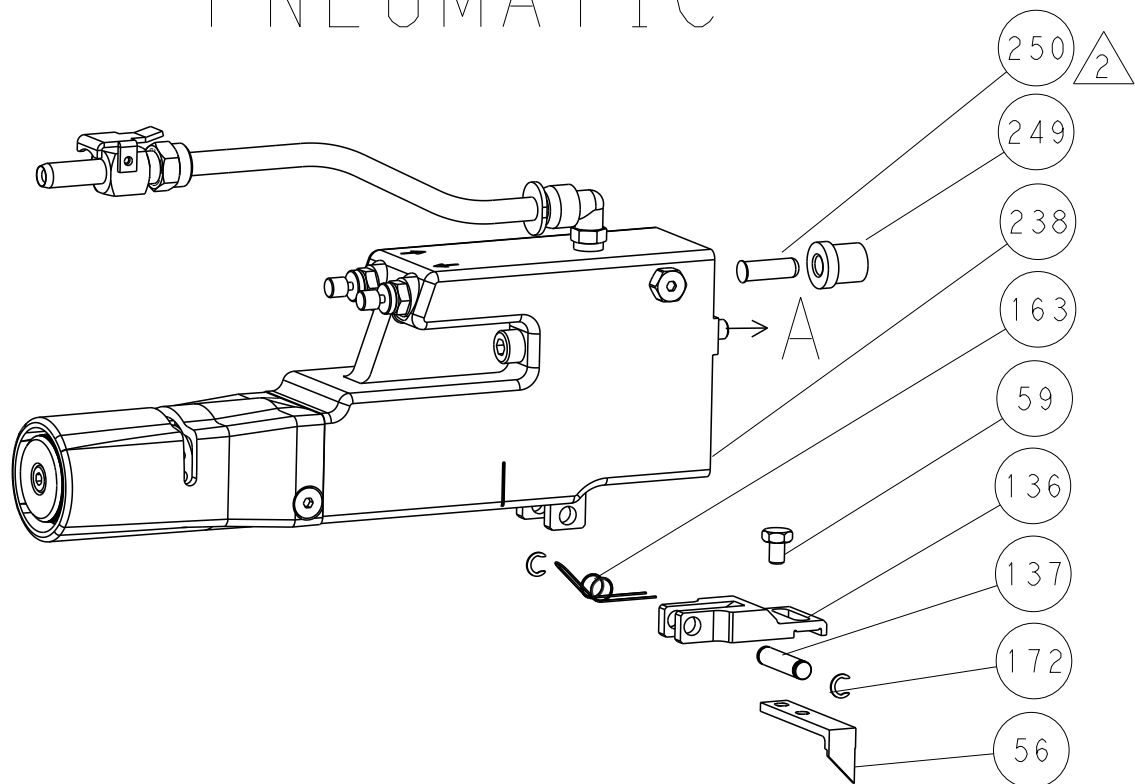
B

A

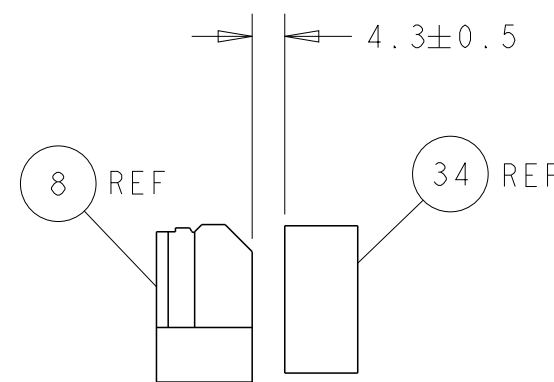
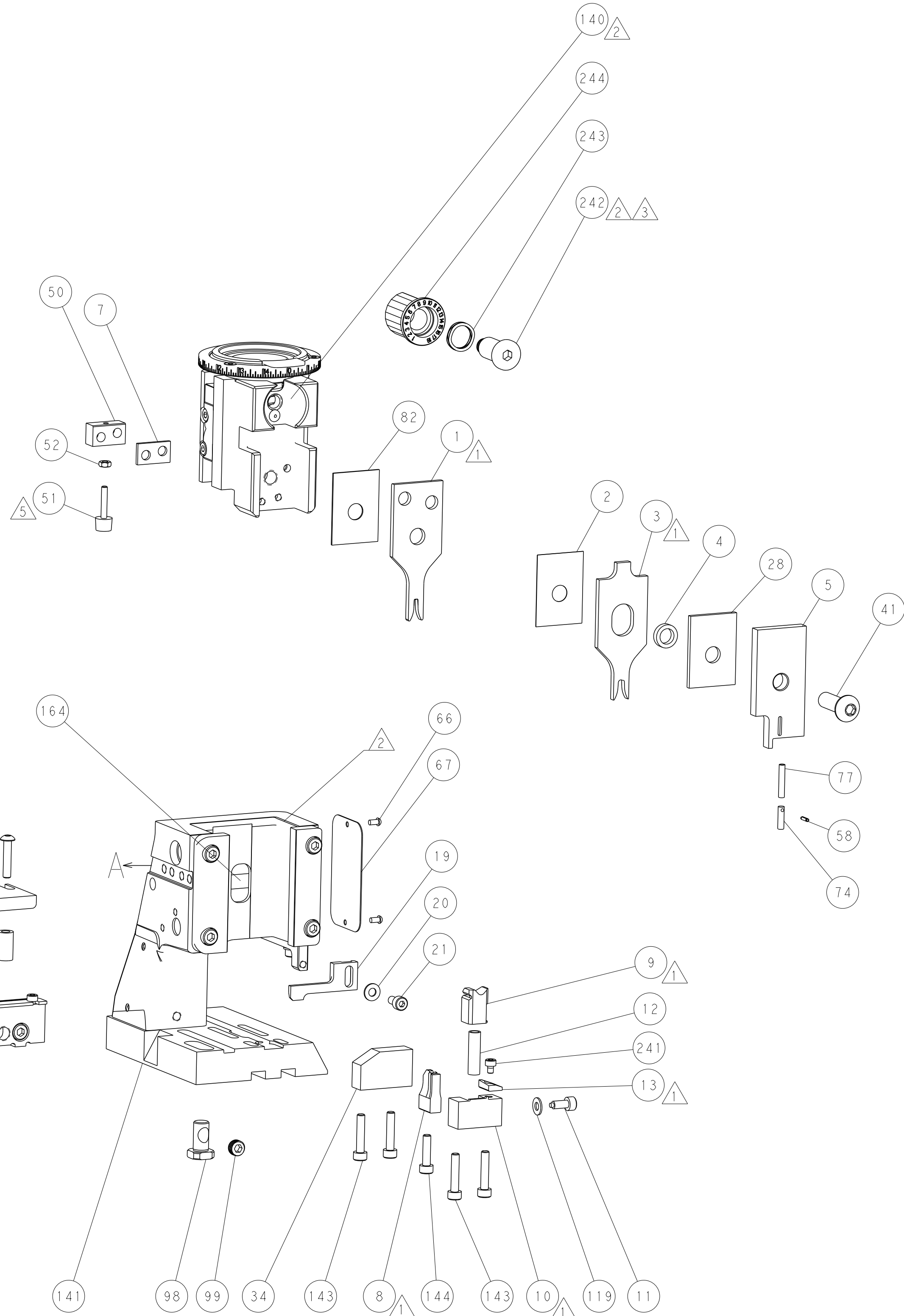
FEED TYPE MECHANICAL



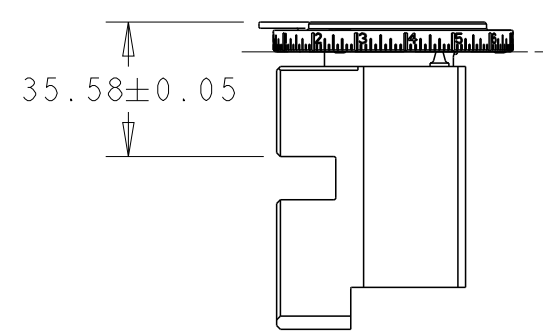
PNEUMATIC



53

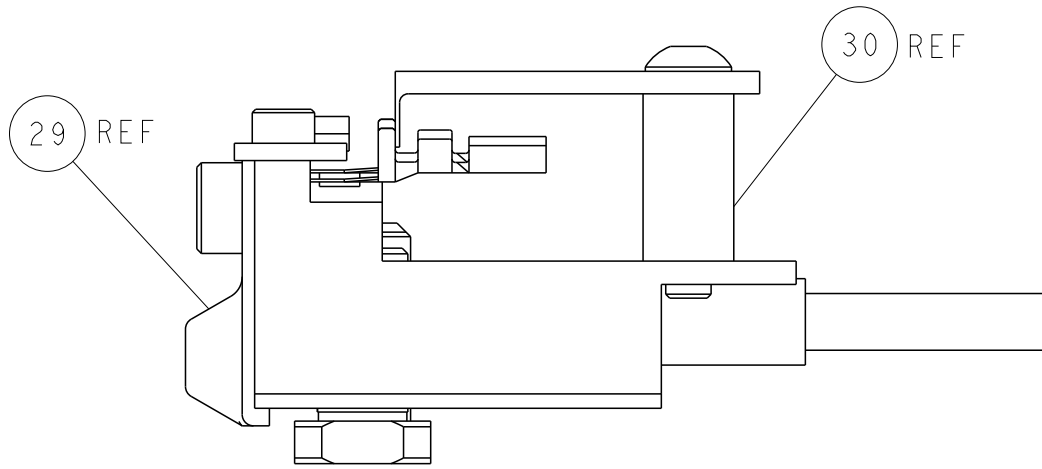


TERMINAL SUPPORT LOCATION

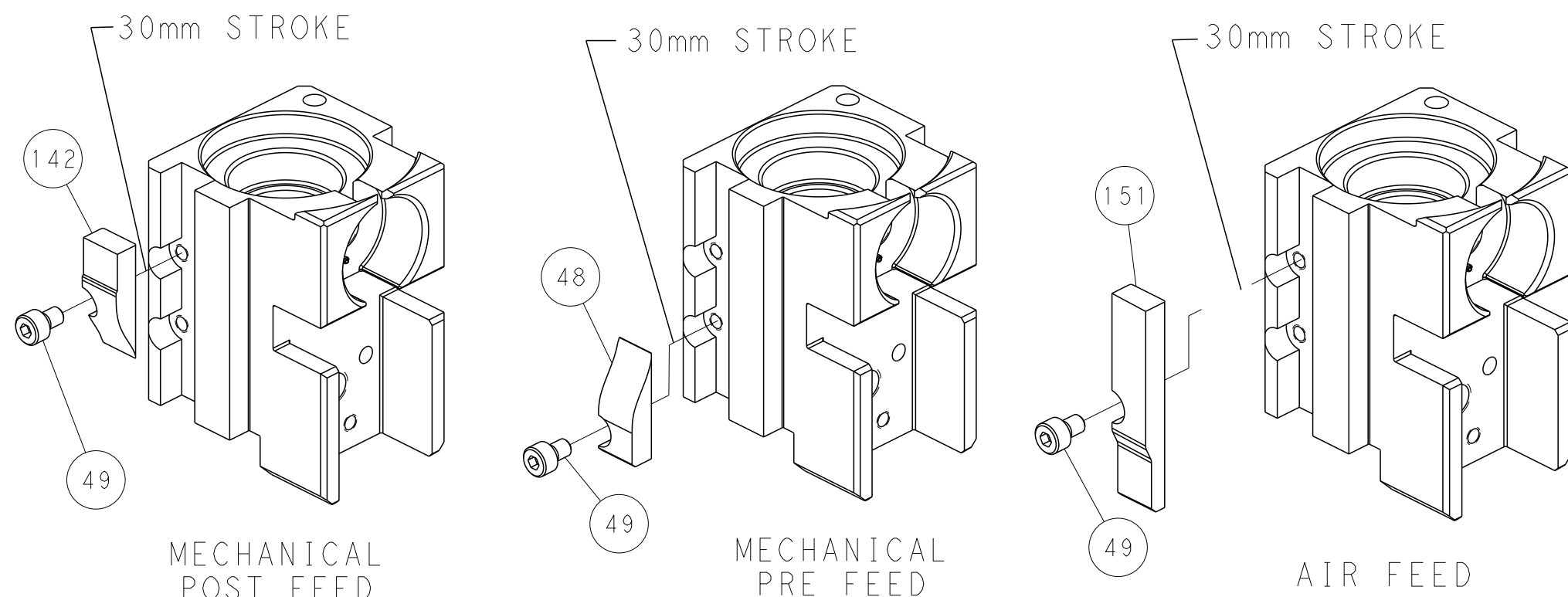


RAM SET-UP

ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL



MECHANICAL
POST FEED

MECHANICAL
PRE FEED

AIR FEED

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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DIMENSIONS: mm		CHK L. ZHANG 03SEP2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		APVD S. XI 03SEP2012	SIZE A1	
MATERIAL -		PRODUCT SPEC APPLICATION SPEC WEIGHT -	CAGE CODE 00779	
		Customer Accessible Production Drawing	SCALE 1:2	
			SHEET 4	
			REV E	