

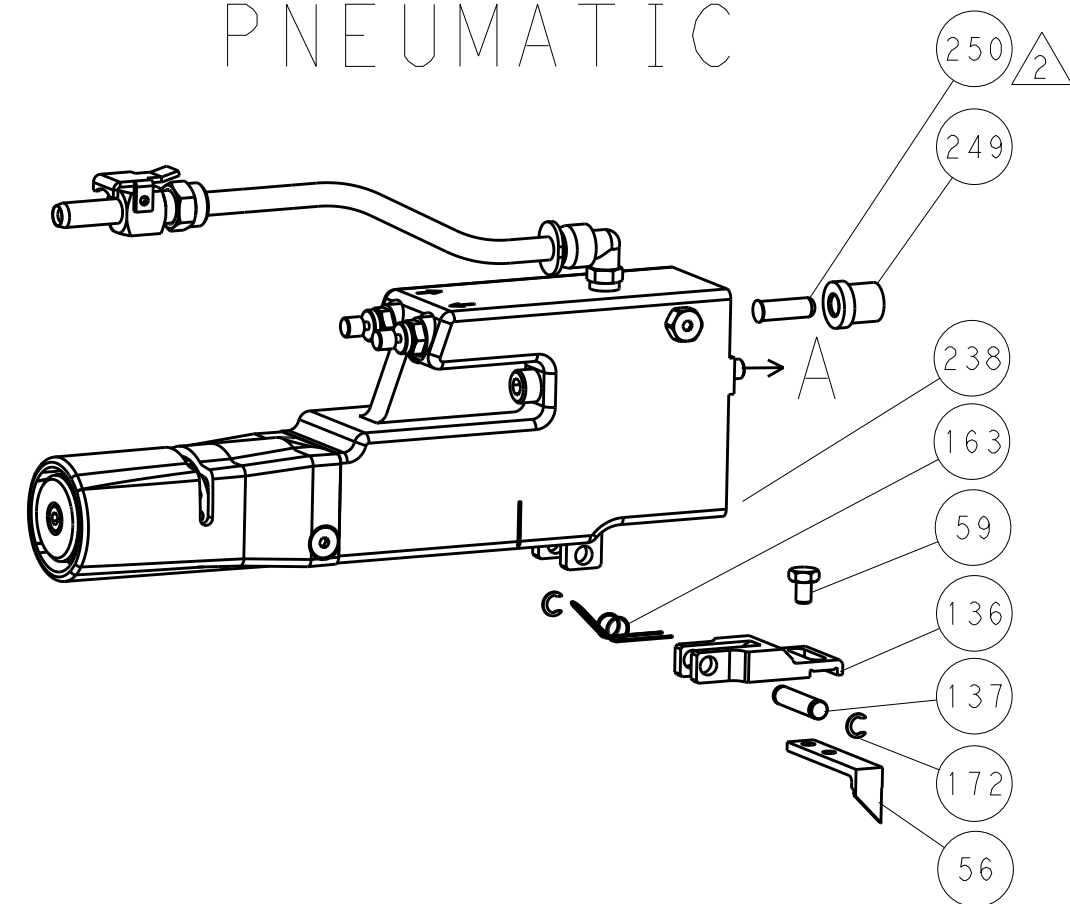
*WARNING

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.

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

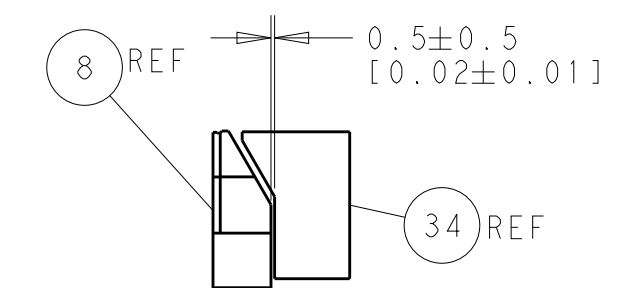
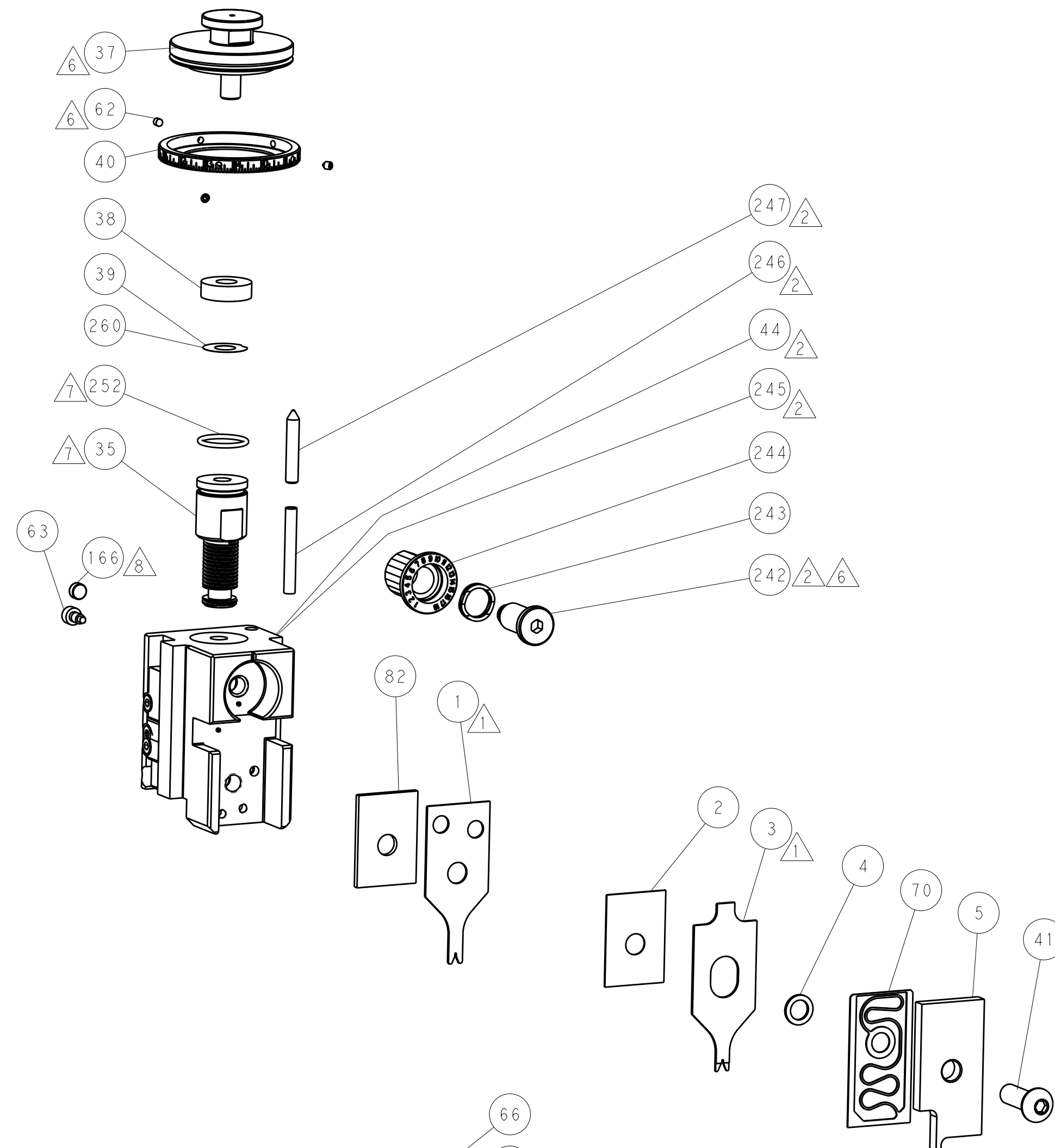
SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS					
P	LTR	DESCRIPTION			DATE	OWN	APVD		
	I	ORIGINAL			14APR2015	YY	TE		
	A	DEVELOPMENT			30APR2015	YY	TE		
-	1	-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	2	-	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	1	1	2119580-1	MECHANICAL FEED ASSEMBLY	23
-	-	-	-	1	-	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1	-	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	2	-	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	1	-	-	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	REF	REF	-	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
-	-	REF	REF	-	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	1	1	2-455888-0	SPACER, CRIMPER	82
-	1	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	1-2119791-7	DEPRESSOR, WIRE	70
-	1	-	-	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-	2	2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	1	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	-	-	-	1	2	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	1	1	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	1	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44

PNEUMATIC

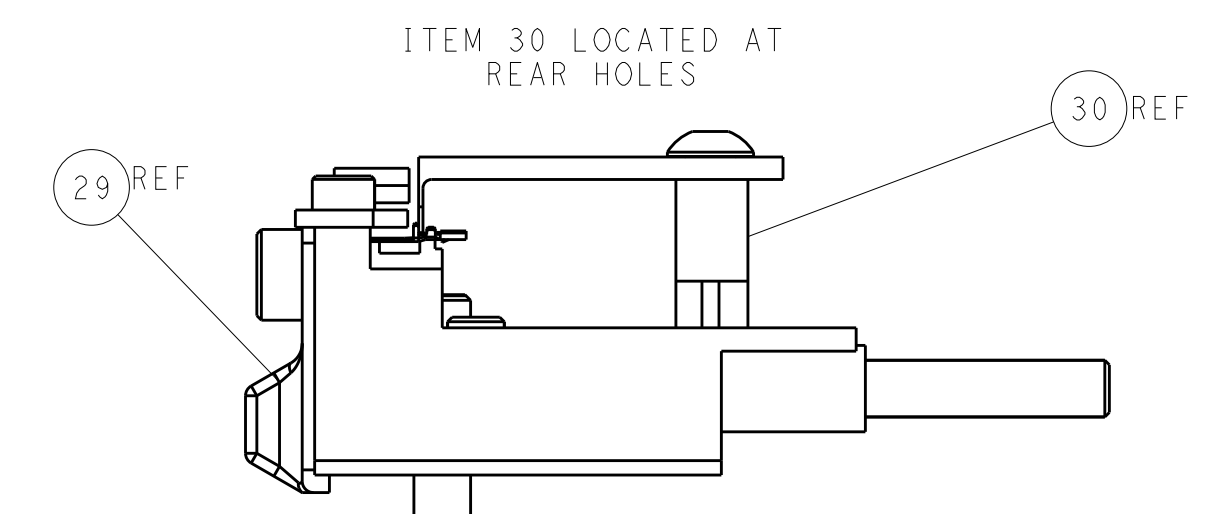
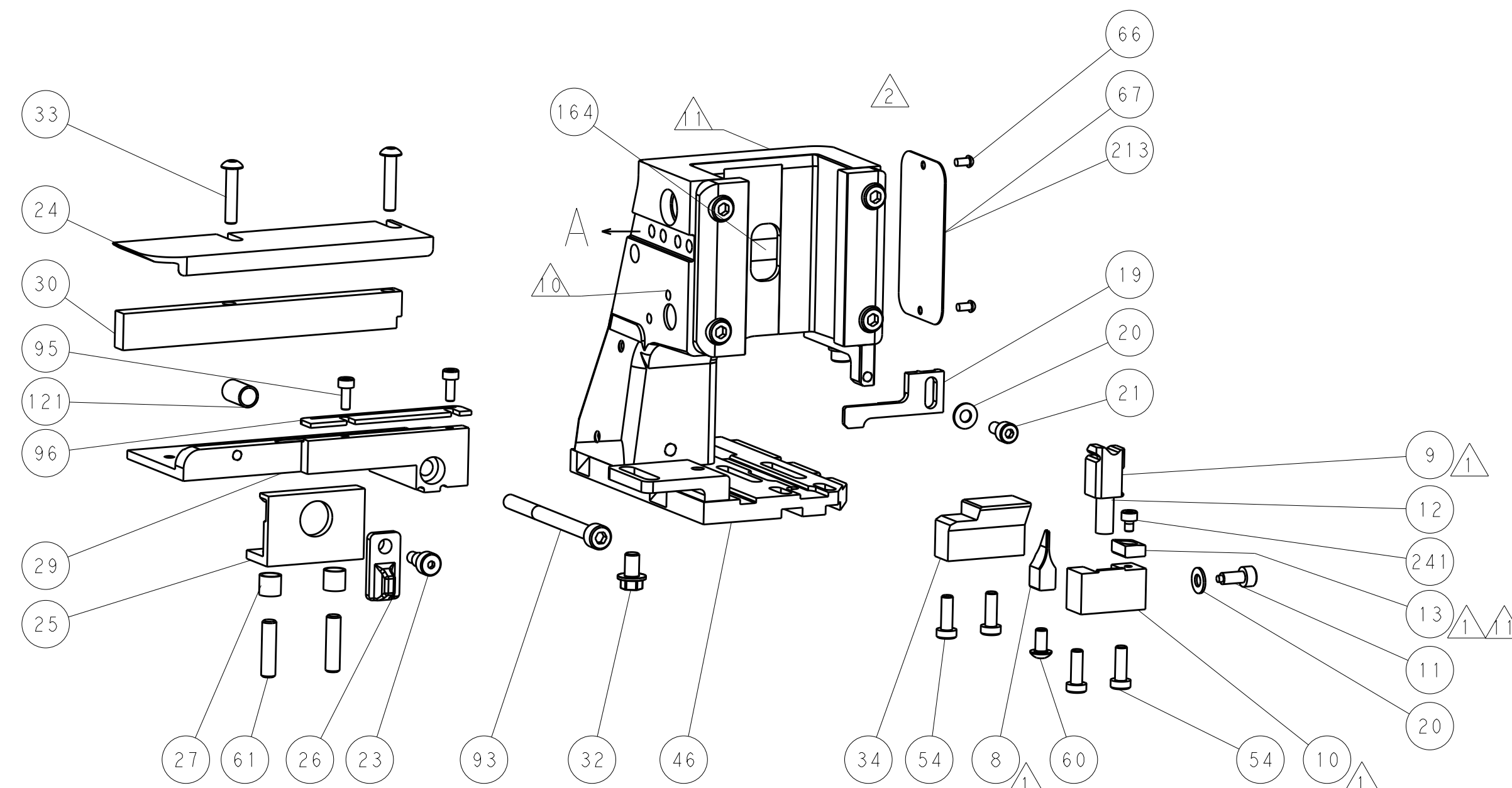


The diagrams illustrate three different feed mechanisms for the tool holder:

- MECHANICAL POST FEED:** Shows a vertical feed mechanism with a 30mm STROKE and a 40mm STROKE. The feed is controlled by a lever (47) and a pin (49).
- MECHANICAL PRE FEED:** Shows a vertical feed mechanism with a 30mm STROKE and a 40mm STROKE. The feed is controlled by a lever (48) and a pin (49).
- AIR FEED:** Shows a vertical feed mechanism with a 30mm STROKE and a 40mm STROKE. The feed is controlled by a lever (248) and a pin (49).



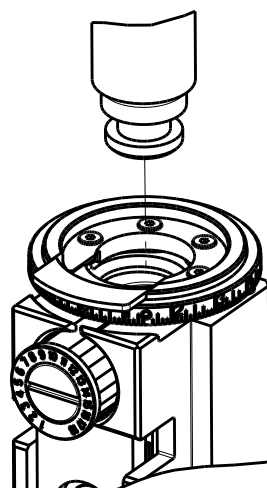
TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

[illegible]

8		7		6		5		4		3	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION		20							
(C) COPYRIGHT 20		BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.									
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER 	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	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	-	8-2266755-5	1901094-3	1752354-6	2168400-6 (QUANTITY 2)			
	SMART APPLICATOR	2161326-1	-	8-2266755-4	-	-	-				
	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-				
	SERVO LATCH PLATE	2119951-1	-	8-2266755-5	1901094-3	1752354-6	2168400-6 (QUANTITY 2)				
	SMART APPLICATOR	2161326-1	-	8-2266755-4	-	-	-				
	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				
-	-	-	-	-	-	-	-	-	-		
-	-	-	-	-	-	-	-	-	-		

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	0.66 mm [.026]	F
INSUL	0.69 mm [.027]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 2.8K		FLAT TYPE RECEPTACLE	
WIRE STRIP LENGTH 0.80-1.50 mm [.031-.059 IN]		INSULATION DIAMETER RANGE Ø0.53-0.77 mm [.021-.030 IN]	
TERMINAL APPLICATION SPECIFICATION	 CHM-1-165 Rev 12/19/02	-	-
TERMINALS APPLIED			
TE TERMINAL 2113441-1	JST TERMINAL SSHL-003T-PO.2	TE TERMINAL 2113441-2	JST TERMINAL SSHL-003GA1-PO.2

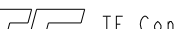
WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
28 AWG			0.45+/-0.02 [0.018+/-0.001]		6.8
30 AWG			0.42+/-0.02 [0.017+/-0.001]		7.0
32 AWG			0.40+/-0.02 [0.016+/-0.001]		7.3



1. RECOMMENDED SPARE PARTS
2. GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
4. APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266755-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266755-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266755-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
6. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 242.
7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
8. MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
9. 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.
10. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

-	1	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	1-22279-3	SPRING, COMPRESSION	246
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

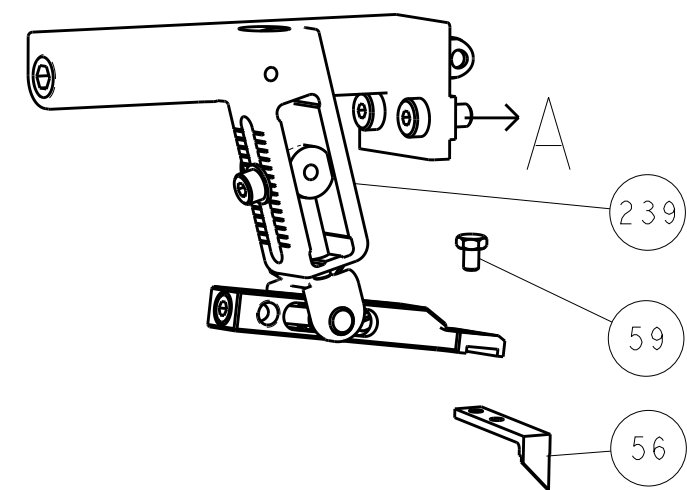
					2						1	
SET UP GAUGE 2119599-1				LOC A	DIST 66	REVISIONS						
P		LTR		DESCRIPTION			DATE	OWN	APVD			
	-			SEE SHEET 1			-	-	-			
1	1	1	1	1	2119082-1	CAM, SNAIL, INSULATION ADJUSTMENT	244					
1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243					
1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242					
1	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	23					
-	-	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	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166					
REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164					
-	-	1	-	-	240638-1	SPRING, FEED FINGER	163					
1	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	1	2119798-2	DETENT PIN	145					
1	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144					
4	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	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141					
1	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140					
1	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	1-22281-8	SPRING, COMPRESSION	121					
-	REF	-	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117					
1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96					
2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95					
1	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 x 65	93					
1	1	1	1	1	2-455888-0	SPACER, CRIMPER	82					
1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71					
1	1	1	1	1	1-2119791-7	DEPRESSOR, WIRE	70					
1	-	1	1	1	2119740-1	TAG.IDENTIFICATION	67					
2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66					
1	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63					
3	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62					
2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61					
-	-	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59					
-	-	1	1	1	1338685-1	PAWL, FEED	56					
-	-	1	2	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49					
-	-	-	1	1	2119652-1	FEED CAM, PRE FEED	48					
1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41					
1	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40					
1	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39					
1	1	1	1	1	1-2119644-4	RAM WASHER, PRECISION	38					
1	1	1	1	1	2-1752356-6	SUPPORT, TERMINAL	34					
2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33					
1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32					
1	1	1	1	1	1320908-8	SPACER, STRIP GUIDE	30					
1	1	1	1	1	2-1901086-0	PLATE, STRIP GUIDE	29					
2	2	2	2	2	22281-8	SPRING, COMPRESSION	27					
1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26					
1	1	1	1	1	240792-1	DRAG, TERMINAL	25					
1	1	1	1	1	1320928-2	STRIP GUIDE	24					
1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23					
1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21					
2	2	2	2	2	1-18028-2	WASHER, FLAT, REG M4	20					
1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19					
1	1	1	1	1	2119806-1	INSERT, SHEAR	13					
1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12					
1	1	1	1	1	1-356885-4	STOP, SHEAR	11					
1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10					
1	1	1	1	1	1803095-3	FLOATING SHEAR, FRONT	9					
1	1	1	1	1	8-1633927-1	ANVIL, COMBINATION	8					
-	-	-	-	-	-	-	7					
-	-	-	-	-	-	-	6					
1	1	1	1	1	2119757-1	DEPRESSOR, SHEAR	5					
1	1	1	1	1	3-238011-6	BLOCK, CRIMPER SPACER	4					
1	1	1	1	1	1803167-1	CRIMPER, INSULATION F SPECIAL	3					
1	1	1	1	1	455888-4	SPACER, CRIMPER	2					
1	1	1	1	1	1-1633713-4	CRIMPER, WIRE PREMIUM	1					
-27	-25	-22	-21		PART NO	DESCRIPTION		ITEM NO				

THIS DRAWING IS THE PROPERTY OF TFC CONNECTIVITY CORPORATION IT IS TO BE USED FOR THE MANUFACTURE OF THE PARTS SPECIFIED HEREIN AND IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN CONSENT OF TFC CONNECTIVITY CORPORATION						OWN <u>T.YIN</u> DATE <u>14APR2015</u>		 TFC Connectivity			
DIMENSIONS: mm						CHK <u>G.BAILEY</u> DATE <u>14APR2015</u>		Harrisburg Pa 17105-3608			
						APP'D <u>J.GUO</u> DATE <u>14APR2015</u>					
						PRODUCT SPEC <u>N GUO</u>		NAME Ocean Side Feed Applicator			
						APPLICATION SPEC					
MATERIAL -						WEIGHT -		SIZE CAGE CODE DRAWING NO. <u>A 00779 C=2266755</u>		RESTRICTED TO	
FINISH -						Customer Accessible Production Drawing		SCALE 1:2		SHEET 3	OF 4
										REV A	

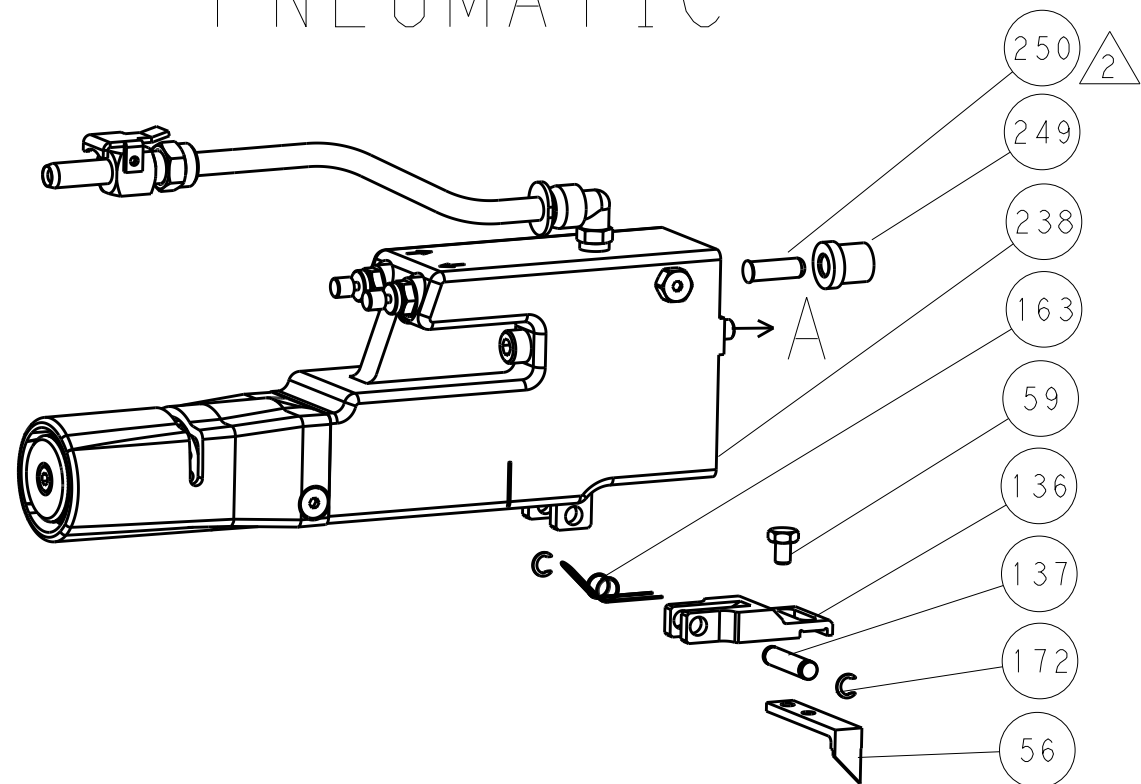
SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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

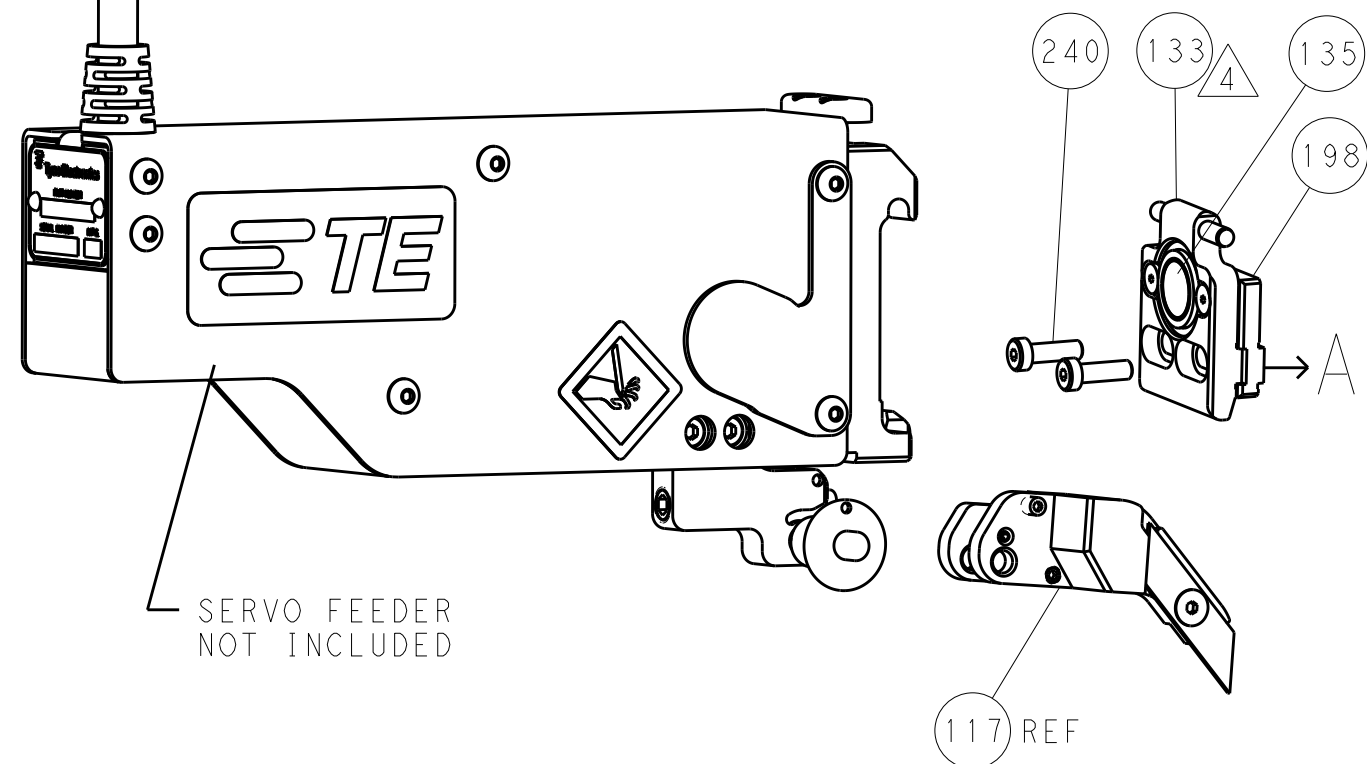
FEED TYPE MECHANICAL



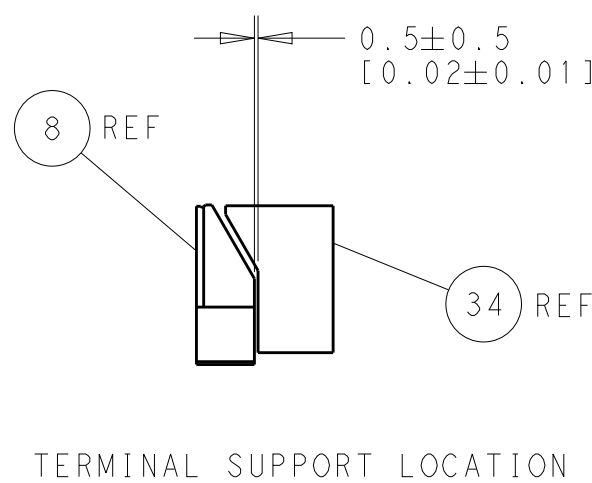
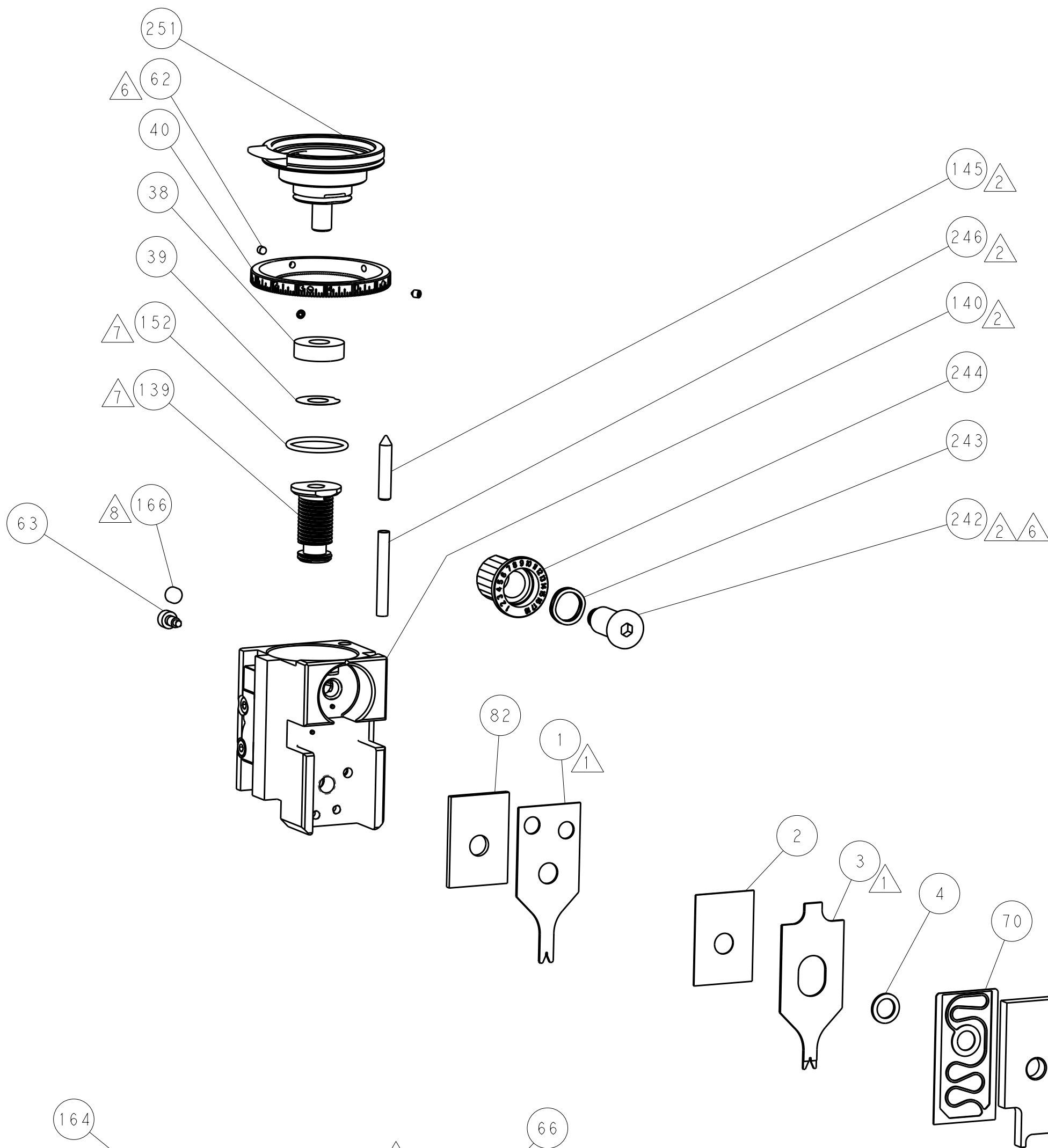
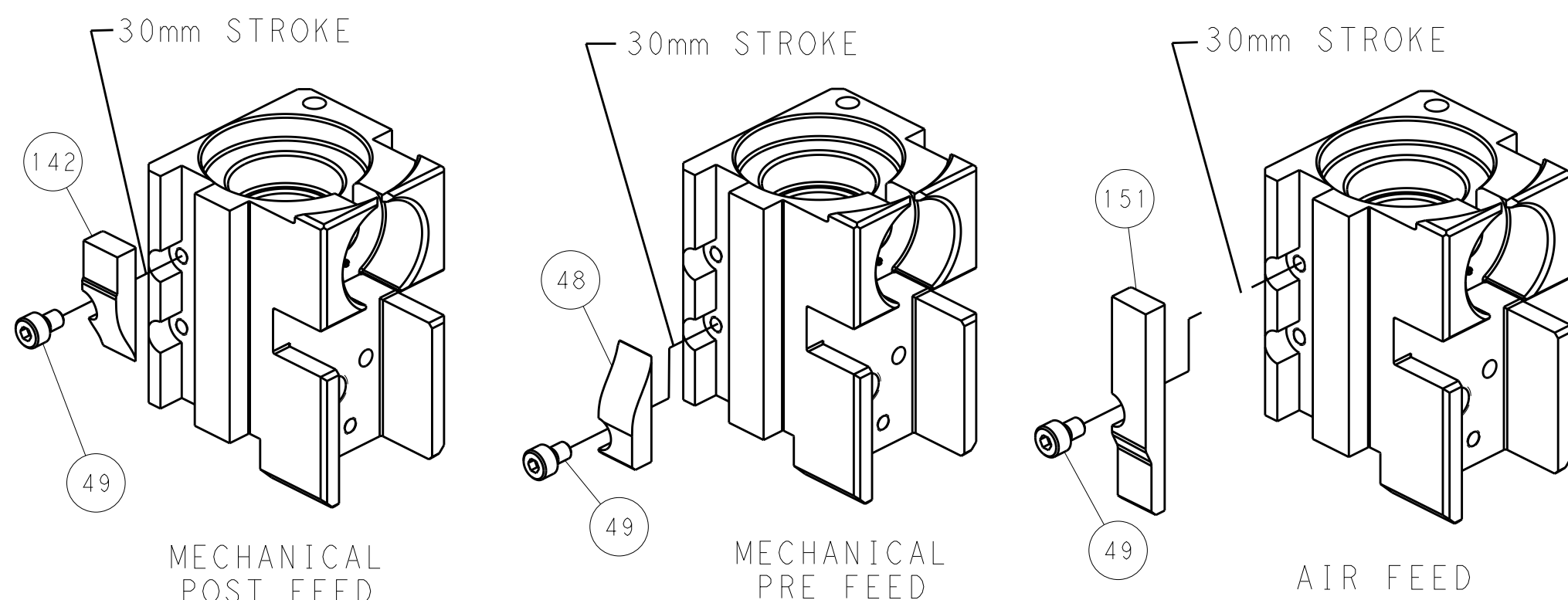
PNEUMATIC



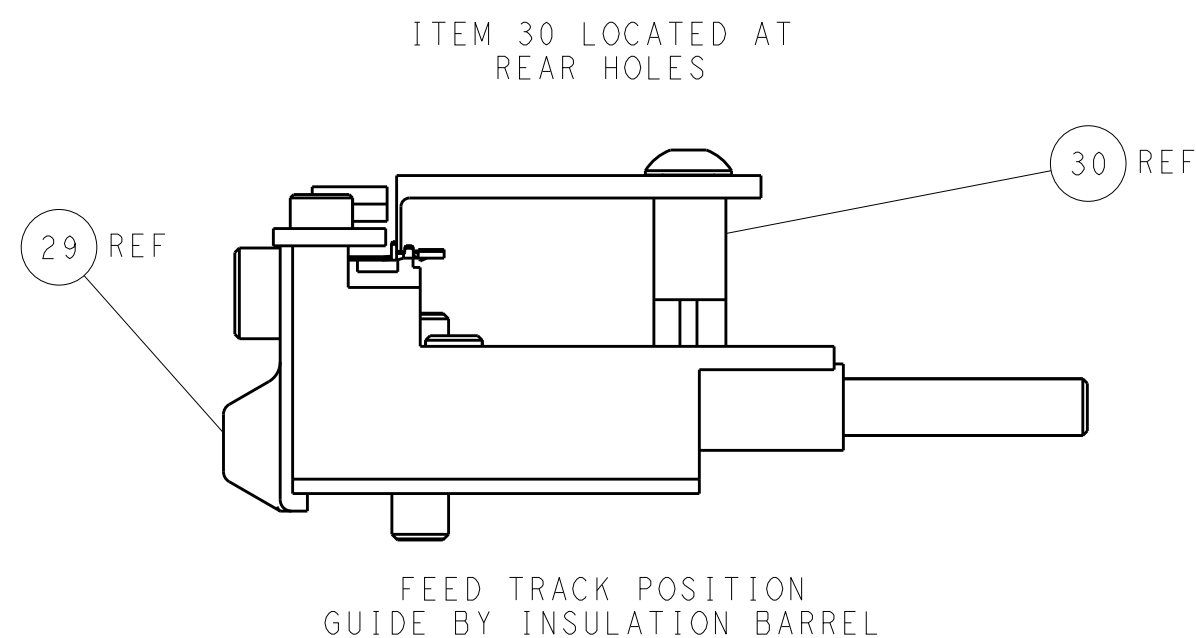
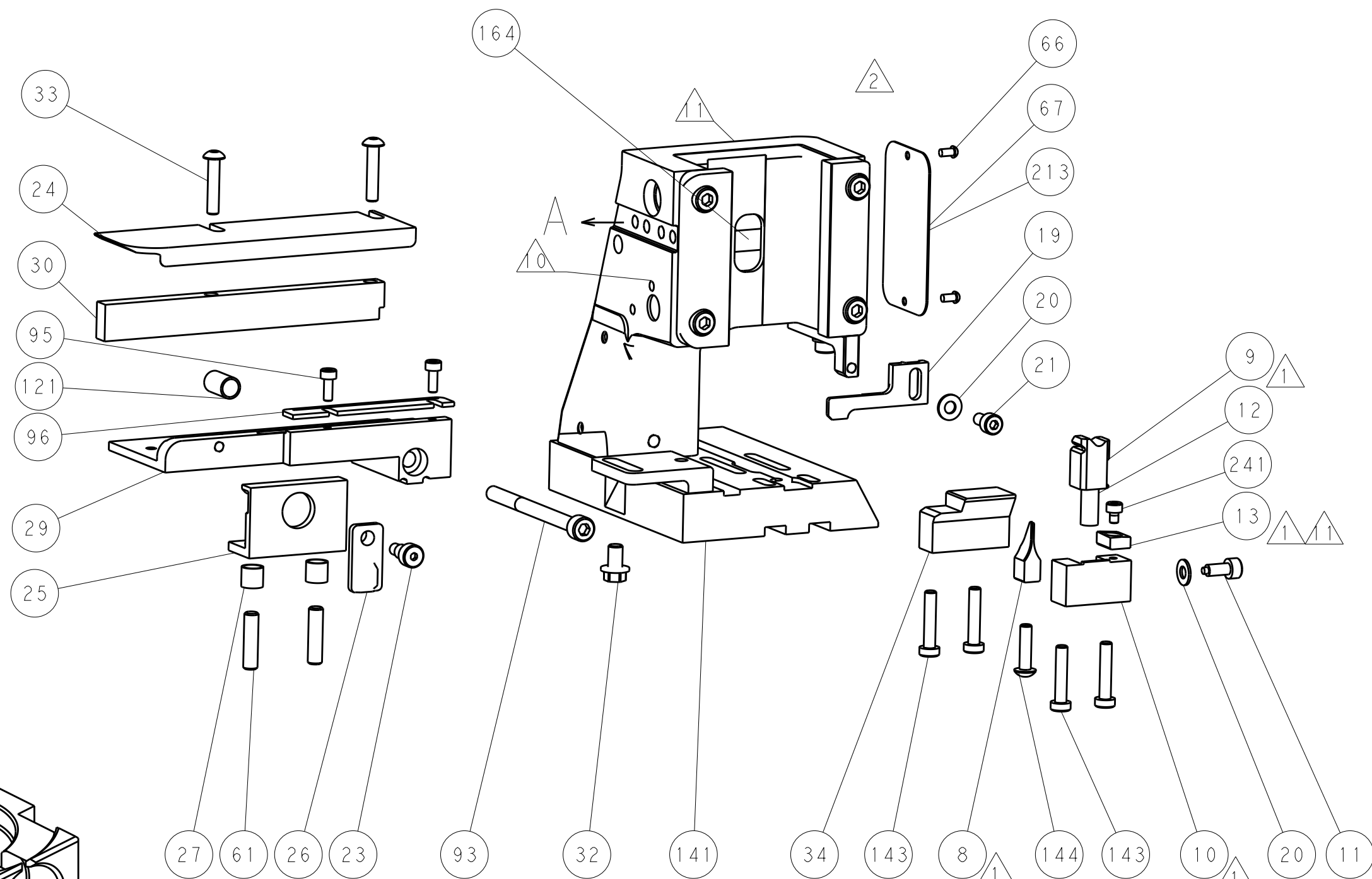
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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 14APR2015		CHK G. BAILEY 14APR2015		APVD J. GUO 14APR2015		NAME Ocean Side Feed Applicator	
mm		0 PLC ±0.5		1 PLC ±0.5		2 PLC ±0.13		3 PLC ±0.013		4 PLC ±0.001	
MATERIAL		FINISH		WEIGHT		SIZE A1		CAGE CODE 00779		DRAWING NO C=2266755	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 4 OF 4		REV A		RESTRICTED TO			