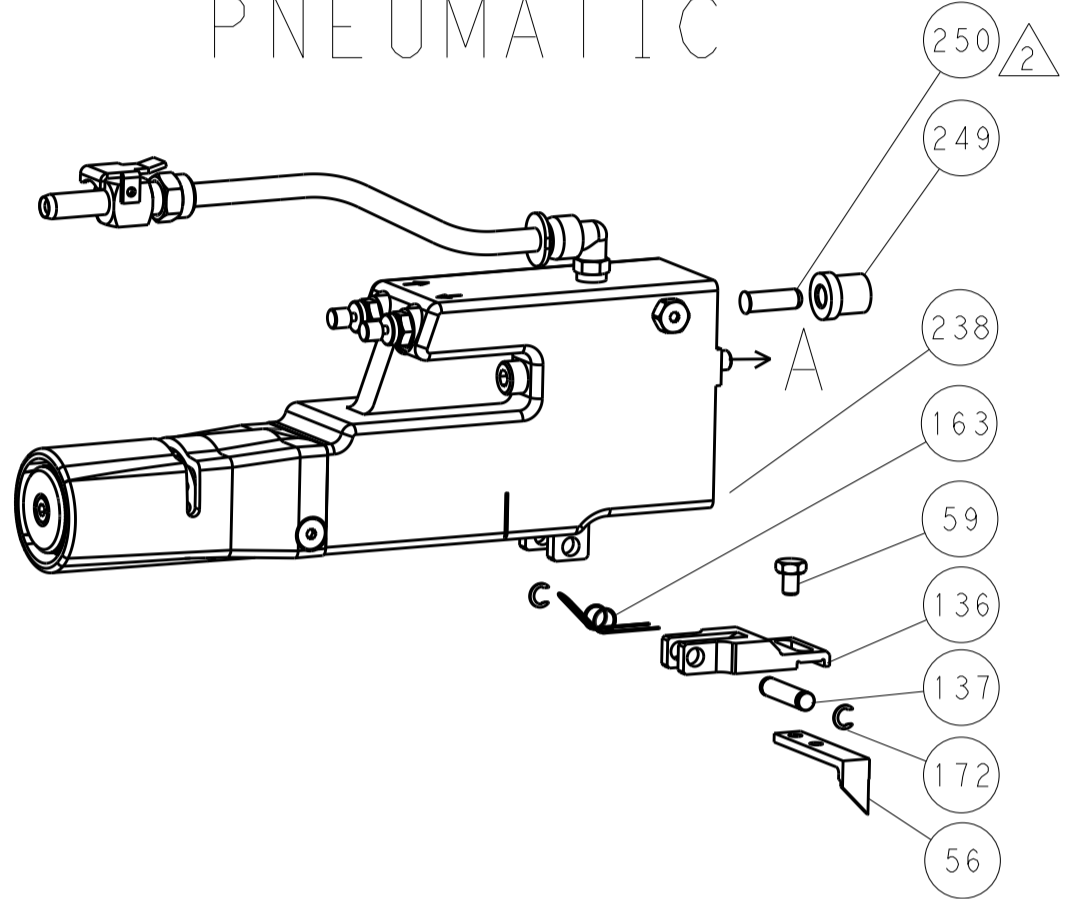


LOC	DIST	REVISIONS			
A	66	REV	DATE	BY	APPROV
		1	SEE SHEET 1		

FEED TYPE MECHANICAL



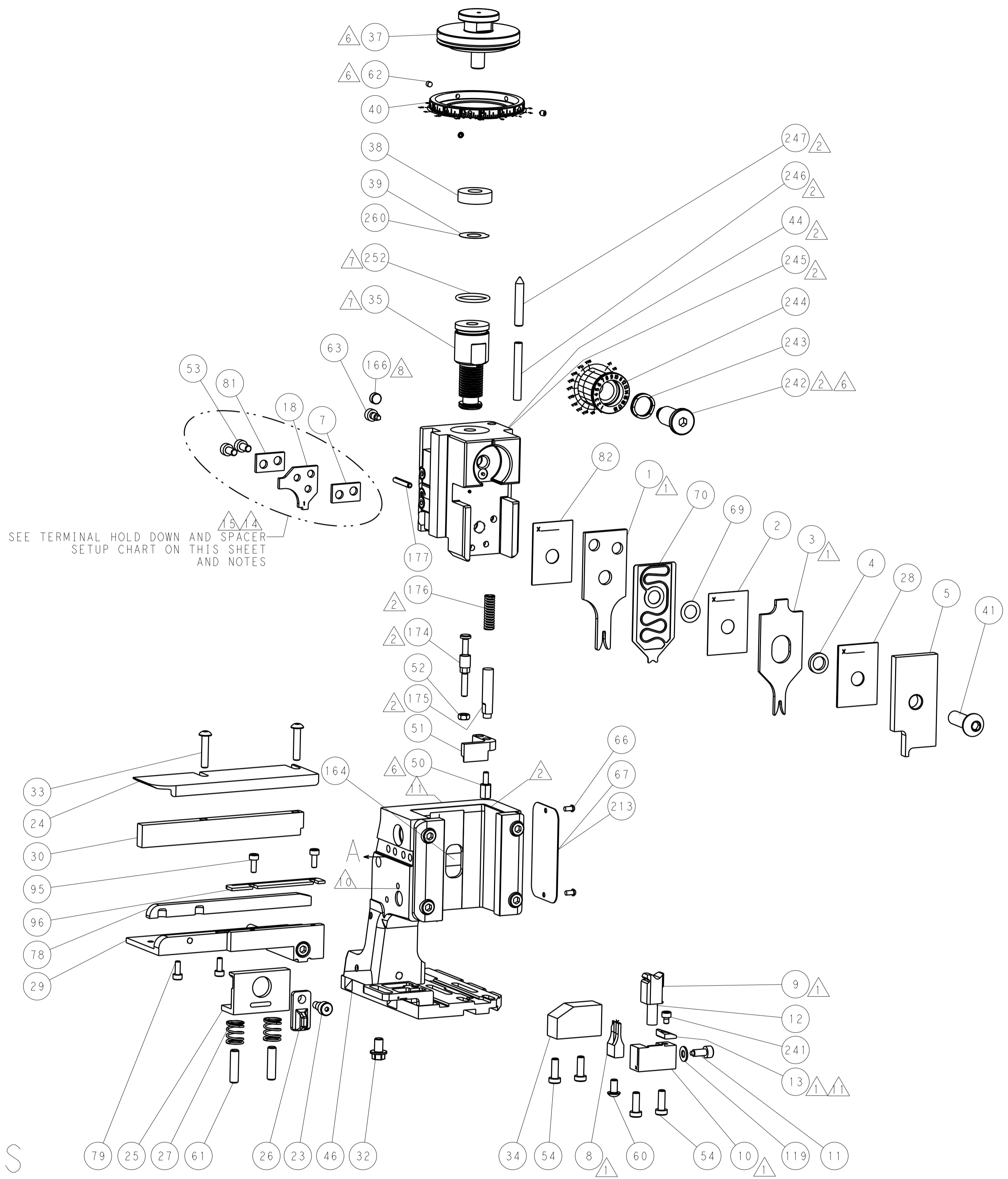
PNEUMATIC



SERVO LATCH PLATE



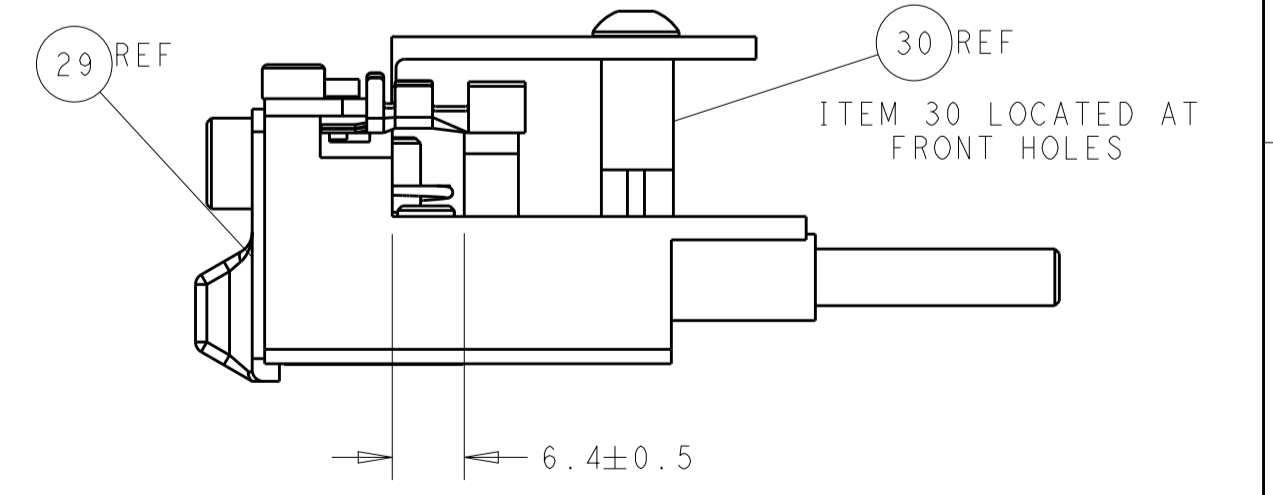
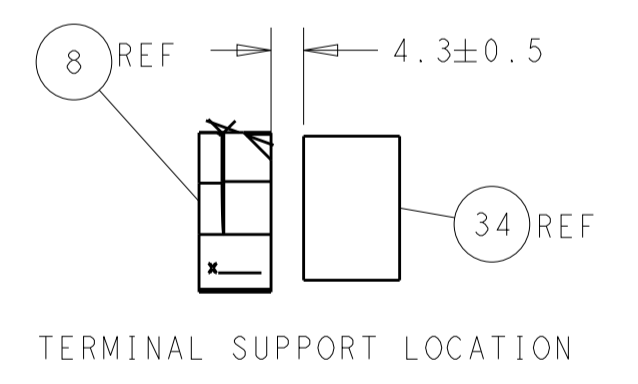
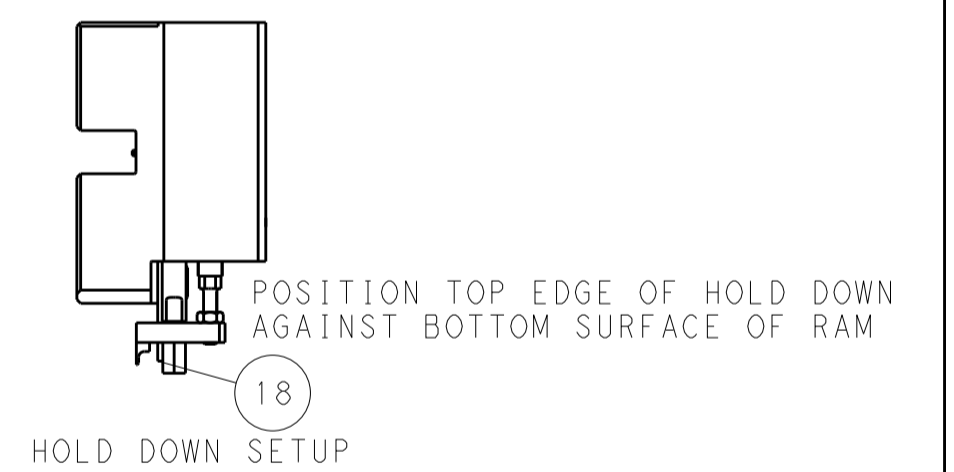
CAM POSITIONS



SEE TERMINAL HOLD DOWN AND SPACER SETUP CHART ON THIS SHEET AND NOTES

TERMINAL HOLD DOWN & SPACER SETUP CHART

GROUP	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:	POSITION
GROUP 1	928999-1 1-928918-2 928999-5 2-928918-2 928999-6 3-928918-2 5-928999-1 5-928918-1 5-928999-5 6-928918-2 5-928999-6 6-928918-3 6-928999-5 1394702-1 928918-1 1394702-2 928918-2 5-1394702-1 1-928918-1 5-1394702-2	POSITION 1
	968893-1	POSITION 1
	968220-1 5-968220-6 968220-5 1703296-1 968220-6 1703296-5 5-968220-1 1534116-1 5-968220-5 1534116-2 5-1534116-1	POSITION 2
	1241918-1	POSITION 2



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

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: Y. YIN 26DEC2013	CHK: G. BAILEY 26DEC2013	APVD: H. GUO 26DEC2013	NAME: Ocean Side Feed Applicator
0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		FINISH:		PRODUCT SPEC	APPLICATION SPEC	SIZE: A1	CAGE CODE: 00779
MATERIAL:		FINISH:		WEIGHT:	SCALE: 1:2	SHEET: 2 of 4	REV: C2

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266152-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2266152-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266152-4	-	-	
	2-2266152-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2266152-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266152-4	-	-	
	2-2266152-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2-2266152-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266152-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	O
APPLICATOR INSTRUCTIONS 408-10389		

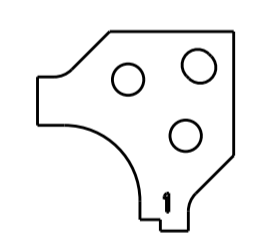
TERMINAL DATA: TE TERMINAL		TE TE CRIMP SPECIFICATION	
TERMINAL NAME: MICRO QUADOCK SYSTEM			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.05-3.35 mm [.120-.132 IN]		Ø1.15-1.60 mm [.045-.063 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18021		

GROUP 1 ³		GROUP 2 ⁴	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
928999-1	5-928918-2	968220-1	1703296-1
928999-5	5-928918-1	968220-5	1703296-5
928999-6	6-928918-1	968220-6	1534116-1
5-928999-1	6-928918-2	5-968220-1	1534116-2
968893-1	6-928918-3	5-968220-5	5-1534116-1
928918-1	1394702-1	5-968220-6	5-1534116-2
928918-2	1394702-2		1241918-1
1-928918-1	5-1394702-1		
1-928918-2	5-1394702-2		
5-928999-5	5-928999-6		
6-928999-5			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm ²	0.86 +/- 0.03 [.034 +/- .001]	5.0
0.35mm ²	0.76 +/- 0.03 [.030 +/- .001]	6.1
0.25mm ²	0.72 +/- 0.03 [.028 +/- .001]	6.6

- 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: 8-2266152-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266152-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266152-5
- 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 50, 62
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.
- ¹¹ 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.
- ¹² REFER TO APPLICATION SPECIFICATION, 114-18021, PAGE 8, NOTE 3 CONCERNING CRIMPING 0.50mm² WIRE.

³ POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS. REFER TO SHEET 4.



⁴ POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS. REFER TO SHEET 4.



¹³ THIS APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	-	2079988-1	BUSHING, LCH5-12, MISHUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-8	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
-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)

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

-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	5-22280-0	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-3	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	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	2-2119656-2	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	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1-240641-3	SPACER	81
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	79
-	1	1	1	1	1633782-2	FENCE	78
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	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
-	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	51
-	1	1	1	1	1-1752354-7	STANDOFF, HOLD-DOWN	50
-	-	-	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	1-2119644-4	RAM WASHER, PRECISION	38
-	1	1	1	1	1752356-6	SUPPORT, TERMINAL	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	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	1803155-1	HOLD DOWN, TERMINAL	18
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1-1338690-2	ANVIL, COMBINATION .055	8
-	1	1	1	1	4-240641-2	SPACER	7
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	1	1	1-562108-5	CRIMPER, WIRE, F	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	DATE	NAME
mm	0 PLC ±	1 PLC ±	2 PLC ±	Y. YIN	G. BAILEY	26DEC2013	TE Connectivity
	3 PLC ±	4 PLC ±	ANGLES ±	U. GUO		26DEC2013	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	PRODUCT SPEC:	APPLICATION SPEC:	SIZE:	CAGE CODE:
			1:2			A1	00779
Customer Accessible Production Drawing				SCALE: 1:2		SHEET 3 OF 4	

