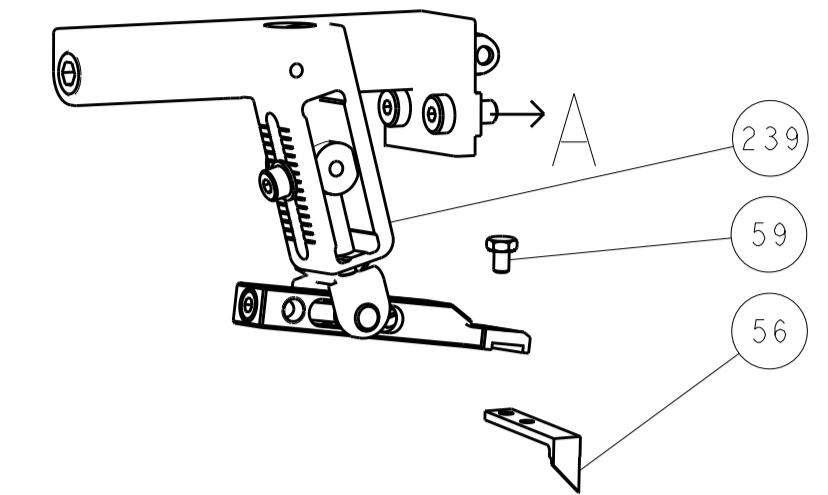


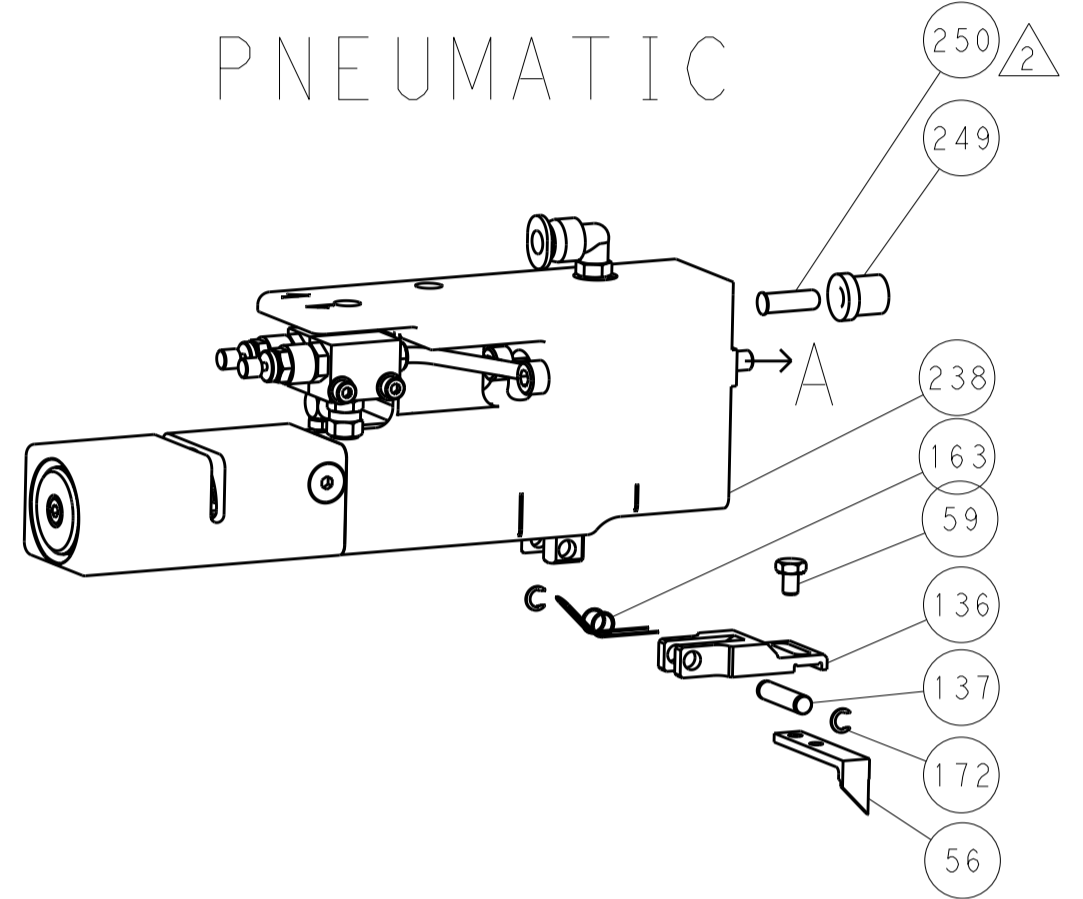


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

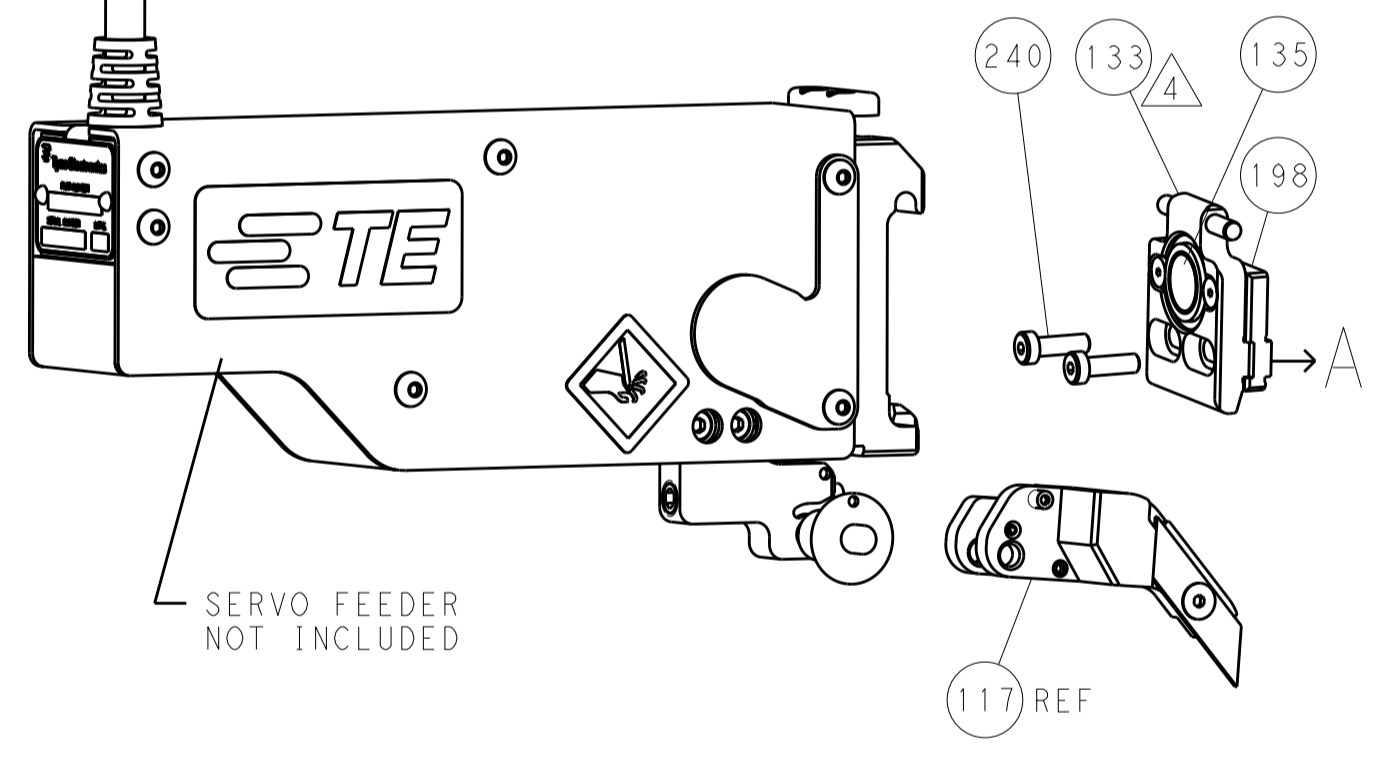
### FEED TYPE MECHANICAL



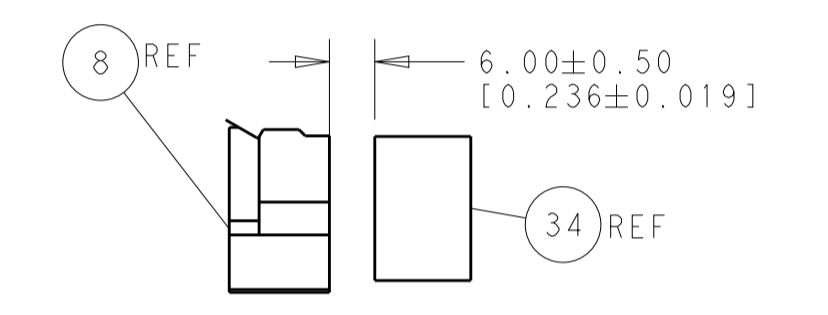
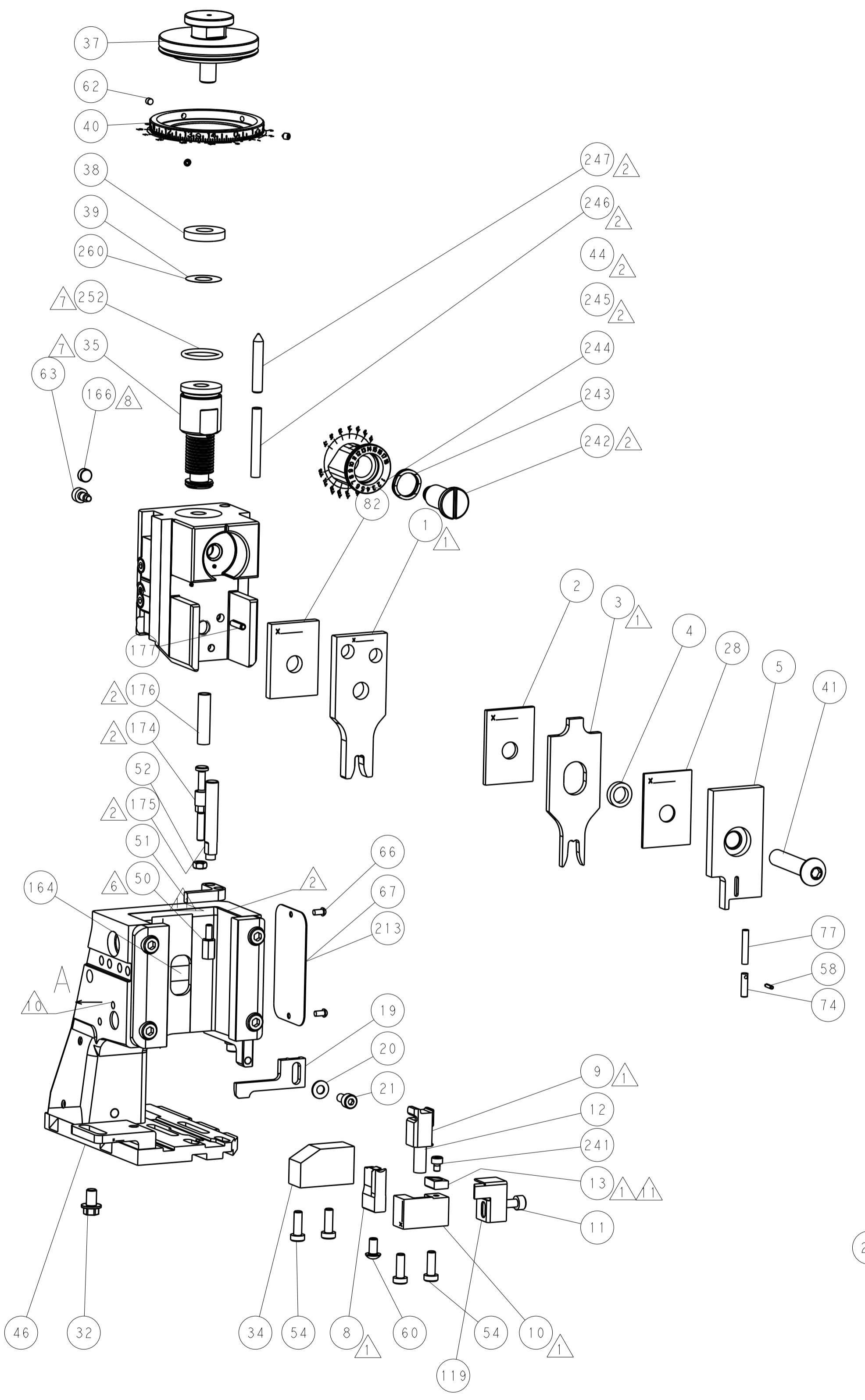
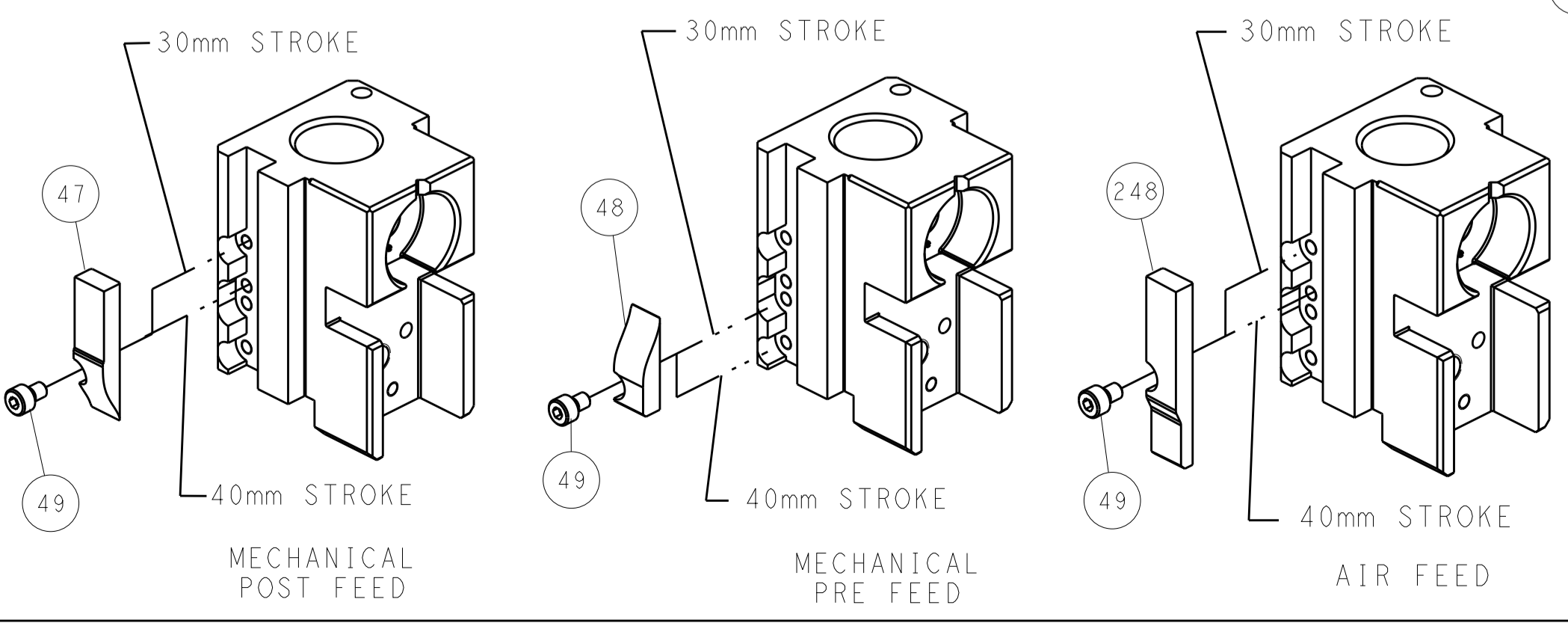
### PNEUMATIC



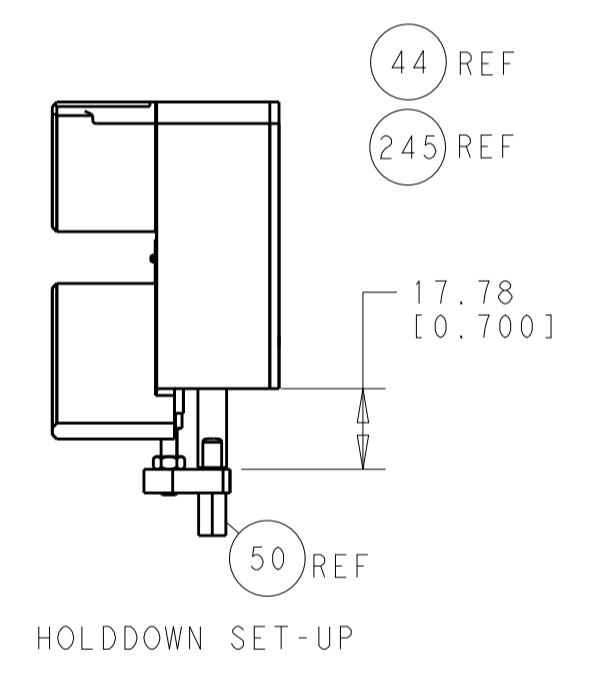
### SERVO LATCH PLATE



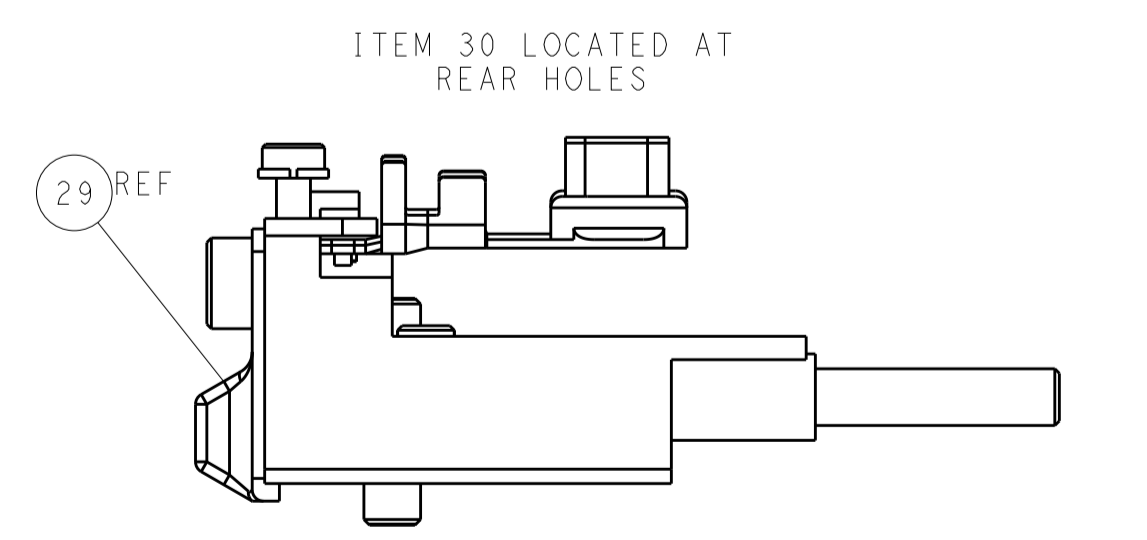
### CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN: BOB HIGMAN 17JUL2012		TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	5 ANGLES ±0.0005	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: M. CLIFFORD 17JUL2012		NAME: Ocean Side Feed Applicator	
Customer Accessible Production Drawing		SCALE: 1:1		SHEET: 2 of 4		REV: A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151687-1	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	-	8-2151687-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151687-4	-	-	
	2-2151687-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151687-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151687-4	-	-	
	2-2151687-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	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
2-2151687-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-
7-2151687-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
	4.70 mm [.185]	F
INSUL	6.10 mm [.240]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: LEAR TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CLAW TERMINAL WITH NUT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
4.85-5.57 mm [.191-.219 IN]	Ø0.00-4.70 mm [.000-.185 IN]		
TERMINAL APPLICATION SPECIFICATION	NONE		
TERMINALS APPLIED			
TE TERMINAL	LEAR TERMINAL	TE TERMINAL	LEAR TERMINAL
2142386-1	25020.212.179		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
6.00mm2	3.42 +/- 0.05 [1.135 +/- .002]	6.8
5.00mm2	3.24 +/- 0.05 [1.128 +/- .002]	8.8
4.00mm2	3.07 +/- 0.05 [1.121 +/- .002]	10.5
3.00mm2	2.89 +/- 0.05 [1.114 +/- .002]	12.6

- RECOMMENDED SPARE PARTS**
- 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: 8-2151687-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151687-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151687-5
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 ITEM 50.
- 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.
13. TERMINAL LUBRICANT IS RECOMMENDED.

\*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
-	-	-	-	-	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	-	1-22279-3	SPRING, COMPRESSION	246

**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	REV	DATE	BY	APPD
-	-	-	SEE SHEET 1	-	-	-

-	1	1	1	1	2119082-9	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	
-	-	-	-	-	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	
-	1	1	1	1	993111-8	PIN, SLOTTED SPRING 3.0 X 12.0	177	
-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1	1	1752353-2	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	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1	1	1	2161312-1	RAM, STEPPED, 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	318563-1	GUARD, FRONT CHIP	119	
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
-	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113	
-	1	1	1	1	2-455888-8	SPACER, CRIMPER	82	
-	1	1	1	1	22278-8	SPRING, COMPRESSION	77	
-	1	1	1	1	854769-4	HOLDER, INS	74	
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, ROHS	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	
-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	-	-	-	1	1338685-1	PAWL, FEED	56	
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, ROHS, M3.5	52	
-	1	1	1	1	1901681-2	HOLDDOWN, TERMINAL	51	
-	1	1	1	1	2-1752354-2	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	1-2079383-5	SCR, BHSC, ROHS (M8 X 40)	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	2119644-5	RAM WASHER, PRECISION	38	
-	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34	
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32	
-	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, ROHS, M4 X 8.0	21	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
-	1	1	1	1	2119806-1	INSERT, SHEAR	13	
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1	1-356885-3	STOP, SHEAR	11	
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	1	454276-5	FLOATING SHEAR, FRONT	9	
-	1	1	1	1	1-1633927-5	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5	
-	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4	
-	1	1	1	1	1-2119582-6	CRIMPER, INSULATION F PREMIUM	3	
-	1	1	1	1	2-455888-1	SPACER, CRIMPER	2	
-	1	1	1	1	4-1633738-4	CRIMPER, WIRE	1	
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO	

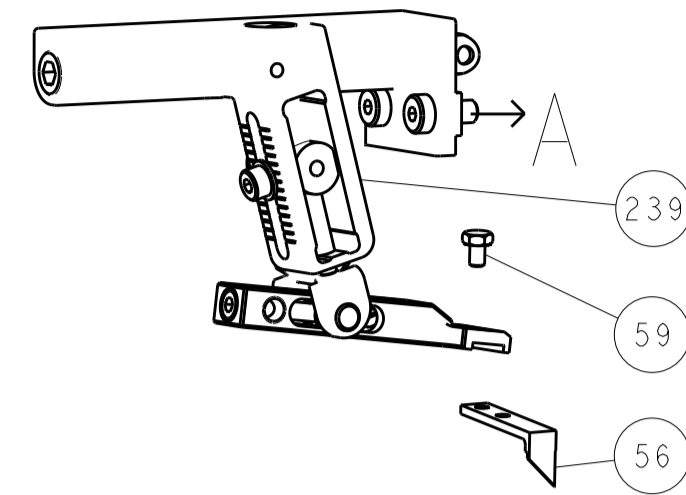
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		APPLICATOR DATA		DRAWING INFORMATION	
mm	0 PLC	±	0.1	APPLICATOR SPEC	APPLICATOR SPEC	DATE	17JUL2012
	1 PLC	±	0.02			BY	BOB HIGMAN
	2 PLC	±	0.005			APPD	G. BAILEY
	3 PLC	±	0.005				M. CLIFFORD
	4 PLC	±	0.0005				
	ANGLES	±	0.0005				
MATERIAL	FINISH			WEIGHT	SCALE	CAGE CODE	00779
					1:1	DRAWING NO	2151687

TE Connectivity  
 Harrisburg, PA 17105-3608

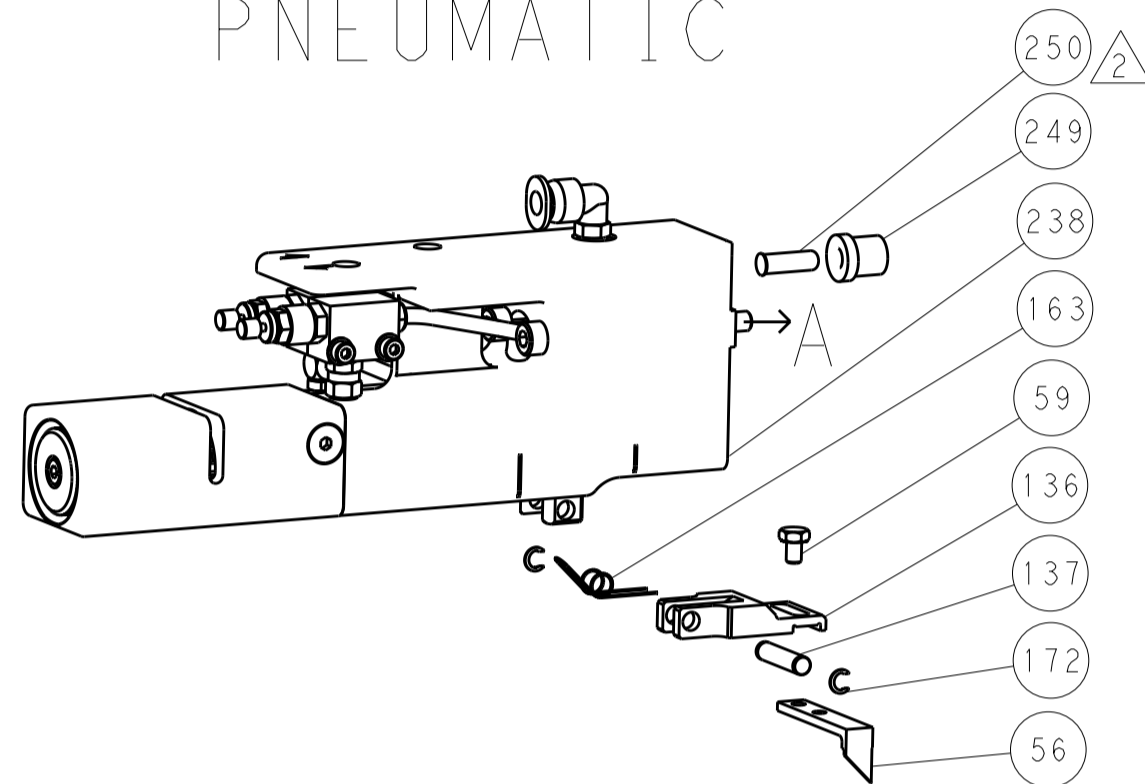
**Ocean Side Feed Applicator**

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

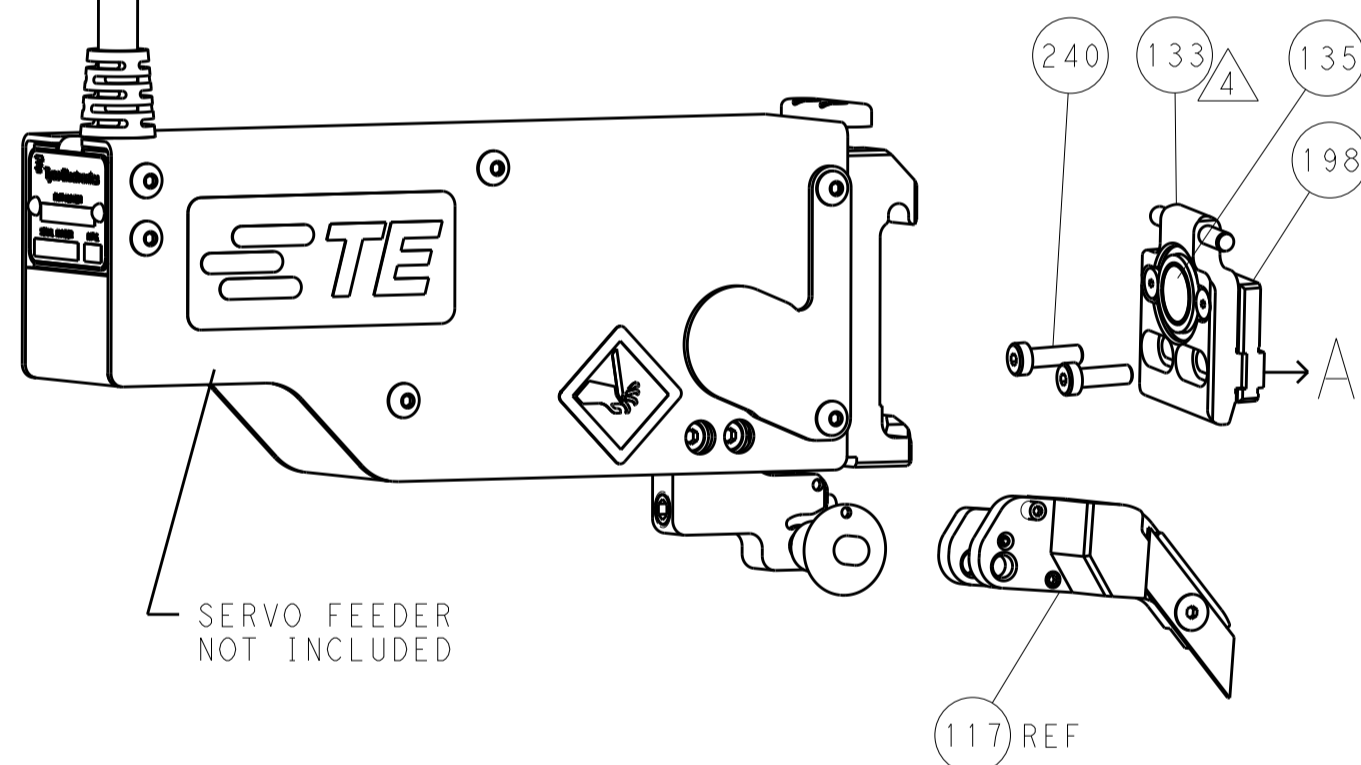
# FEED TYPE MECHANICAL



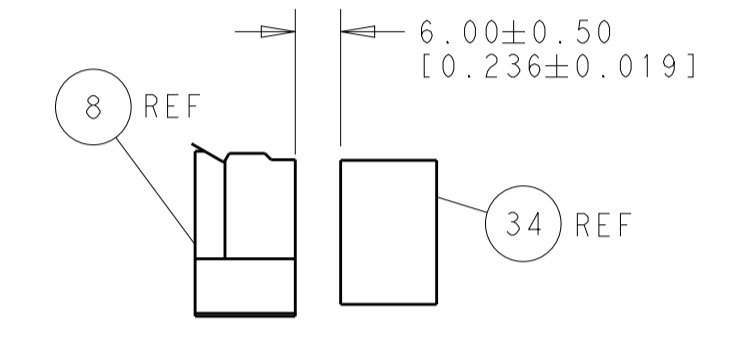
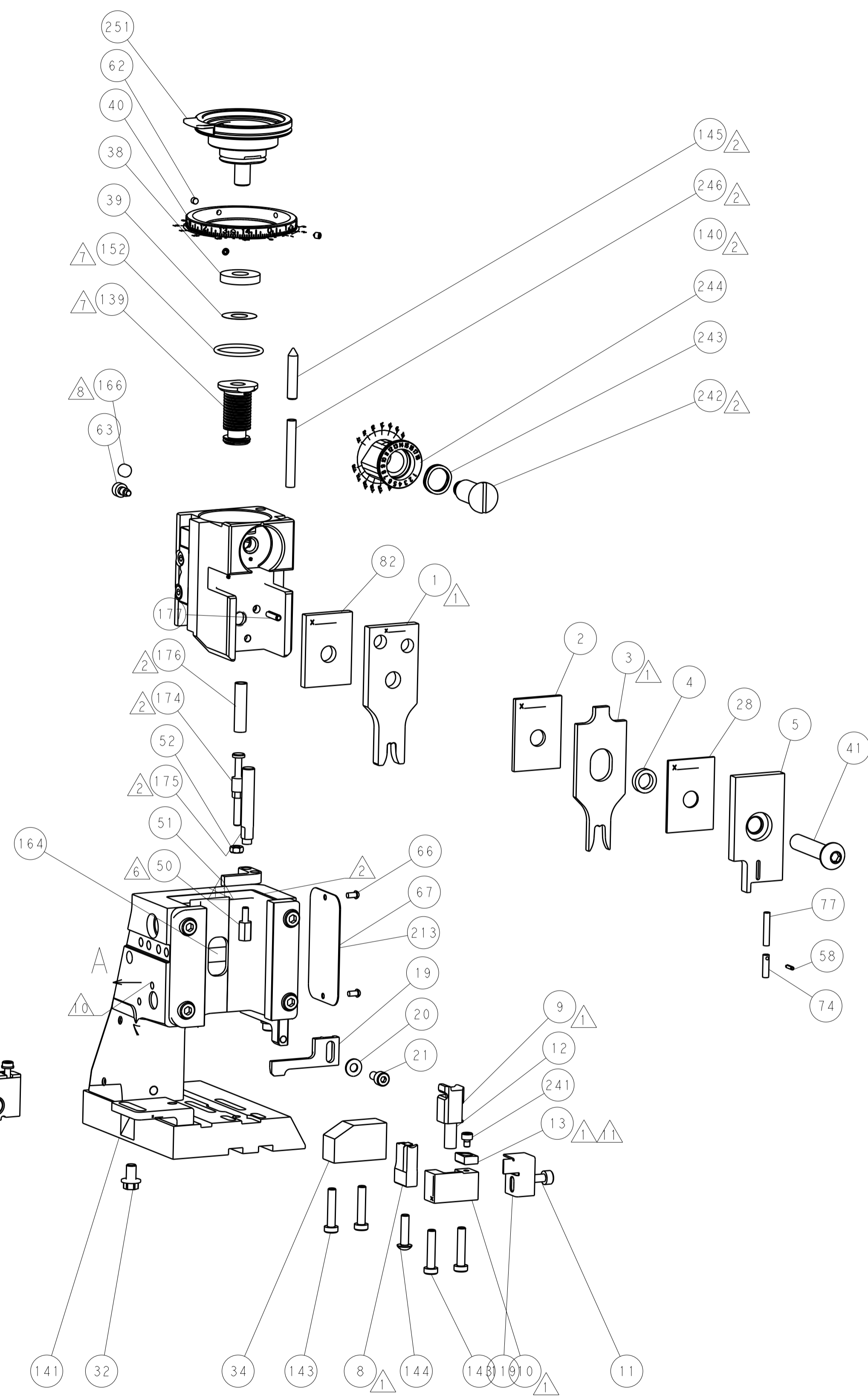
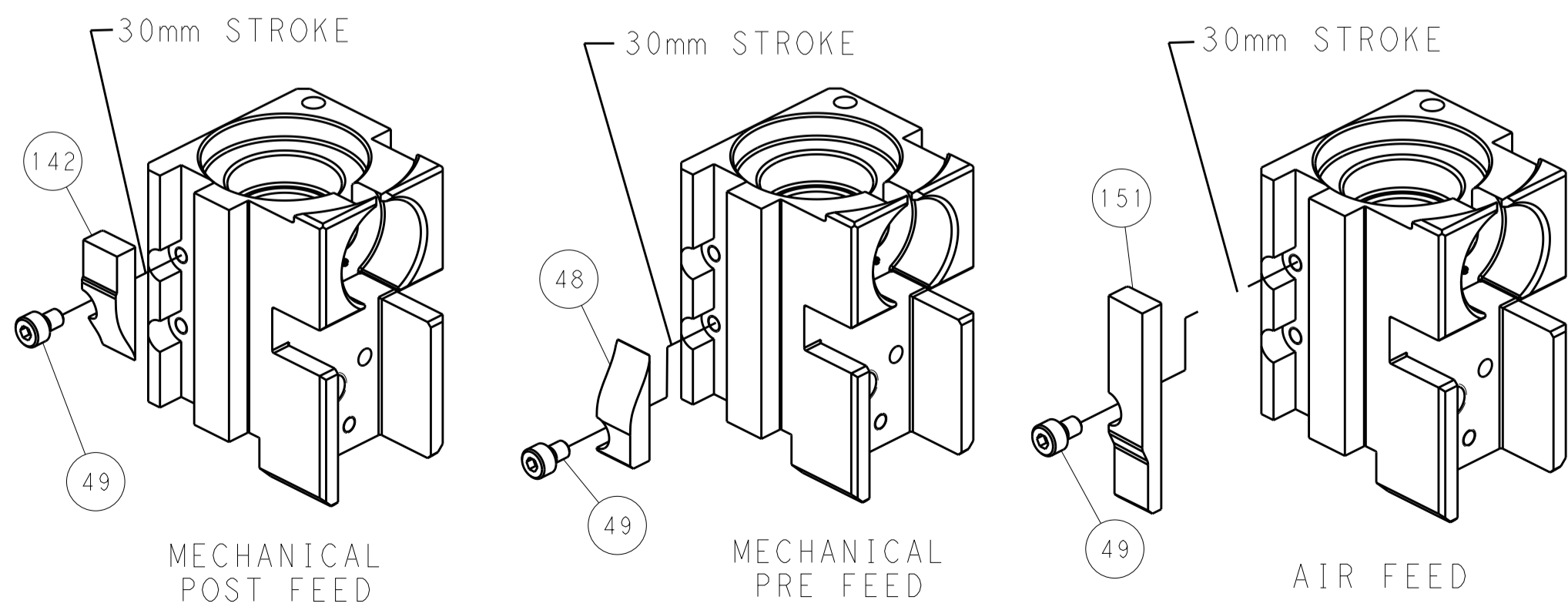
# PNEUMATIC



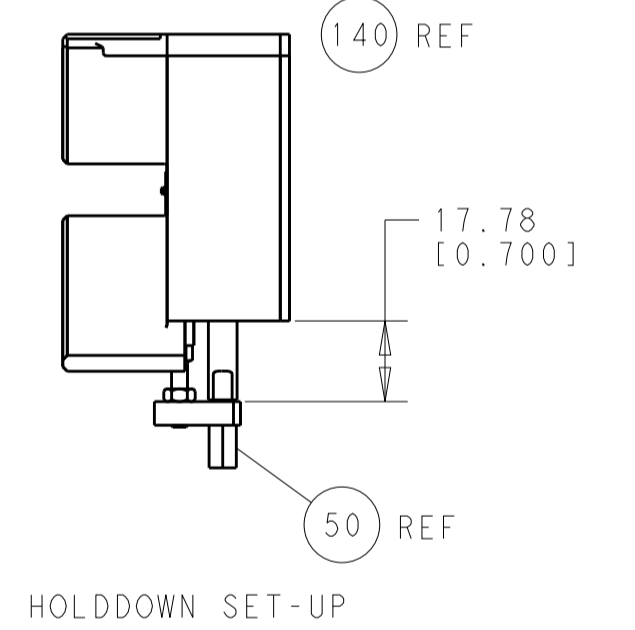
# SERVO LATCH PLATE



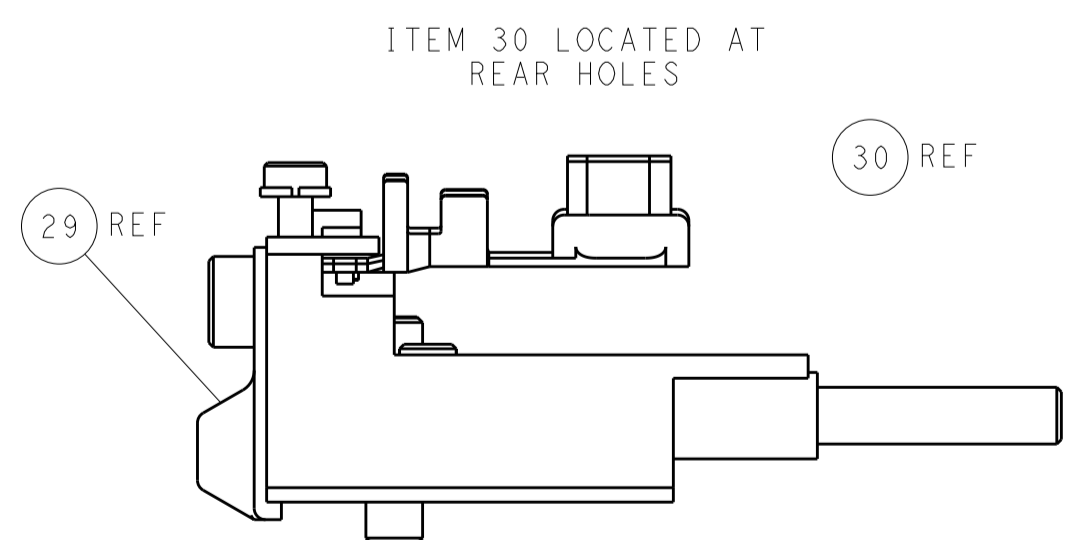
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±0.0005		DWN BOB HIGMAN 17JUL2012 CHK G. BAILEY 17JUL2012 APVD M. CLIFFORD 17JUL2012		NAME Ocean Side Feed Applicator	
MATERIAL:		FINISH:		WEIGHT:		SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151687	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 4 OF 4 REV A	