

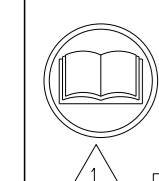
| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | | |
|---|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|--------------------------|-----------|-----------|------------------------|-----------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | | |
| | | | | | | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 |
| | 2151800-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | SERVO LATCH PLATE | 2119951-1 | - | 8-2151800-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | |
| | 2151800-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SMART APPLICATOR | 2161326-1 | - | 8-2151800-4 | - | - | - | |
| | 2151800-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | |
| | 2151800-6 | A | NON-CRIMP HEIGHT ADJUST | | SERVO LATCH PLATE ⁴ | 2151800-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - |
| | 7-2151800-7 | A | CRIMP TOOLING KIT | | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.02 mm [.040] | F |
| INSUL | 1.57 mm [.062] | O |

APPLICATOR INSTRUCTIONS
408-10389

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|-------------------------------------|-------------|------------------------------|-------------|
| TERMINAL NAME: MCON - 1.2mm CONTACT | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.15-3.91 mm [.124-.154 IN] | | Ø0.85-1.05 mm [.033-.041 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-94295 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 2208088-1 | | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 0.17mm2 | 0.70+/-0.02 [.028+/-0.001] | 7.3 |
| 0.13mm2 | 0.68+/-0.02 [.027+/-0.001] | 7.6 |



- 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: 8-2151800-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151800-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151800-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151800-6
- 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 ITEMS 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 50.
- 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. 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 5.10.

***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 |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

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

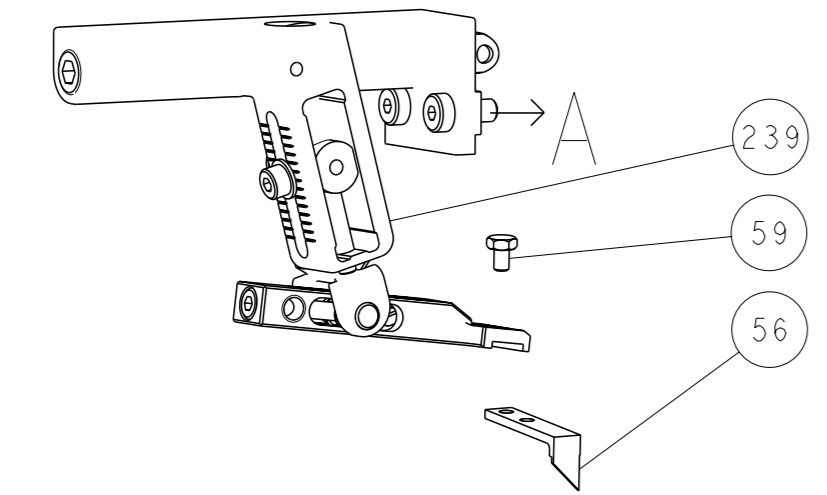
| REVISIONS | | | |
|-----------|---------------|-----------|-------|
| REV | DATE | BY | APPV |
| A | RELEASED | 13NOV2013 | LG TE |
| A1 | ECR-17-001222 | 26JAN2017 | BW JD |

| REV | DATE | BY | APPV | DESCRIPTION | DATE | OWN | APPV | | |
|-----|------|-----|------|-------------|------|-------------|-------------------------------------|--------------------------|----|
| - | 1 | - | 1 | 1 | 1 | 2119798-1 | DETENT PIN | 247 | |
| - | 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 | 2119082-8 | 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 | 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 | 1 | - | - | 2119740-2 | TAG, IDENTIFICATION | 213 | |
| - | - | 1 | 1 | - | - | 1901094-3 | SPACER, FEEDER | 198 | |
| - | 1 | 1 | 1 | 1 | 1 | 993111-1 | PIN, SLOTTED SPRING 3.0 X 20.0 | 177 | |
| - | 1 | 1 | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 | |
| - | 1 | 1 | 1 | 1 | 1 | 1752353-2 | GUIDE PIN, HOLDDOWN | 175 | |
| - | 1 | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN, HOLDDOWN | 174 | |
| - | - | - | - | - | 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 | 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 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 | |
| - | - | REF | REF | - | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | 117 | |
| - | 1 | 1 | 1 | 1 | 1 | 455888-6 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 | |
| - | 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 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 | |
| - | 3 | - | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62 | |
| - | 1 | 1 | 1 | 1 | 1 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 60 | |
| - | - | - | - | - | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 | |
| - | - | - | - | - | 1 | 1338685-1 | PAWL, FEED | 56 | |
| - | 4 | 4 | 4 | 4 | 4 | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 54 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 | |
| - | 1 | 1 | 1 | 1 | 1 | 1901681-5 | HOLDDOWN, TERMINAL | 51 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-1752354-6 | 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 | 2119653-1 | FEED CAM, POST FEED | 47 |
| - | 1 | 1 | 1 | 1 | 1 | 2119656-9 | APPLICATOR BASIC ASSEMBLY, SF | 46 | |
| - | 1 | - | - | - | 1 | 2119370-1 | RAM, AMP STYLE, SIDE FEED | 44 | |
| - | 1 | 1 | 1 | 1 | 1 | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 | |
| - | 1 | - | - | - | 1 | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 | |
| - | 1 | - | - | - | 1 | 2119957-1 | APPLICATOR SHIM PACK | 39 | |
| - | 1 | 1 | 1 | 1 | 1 | 2119644-1 | RAM WASHER, PRECISION | 38 | |
| - | 1 | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 | |
| - | 1 | - | - | - | 1 | 2119092-1 | BOLT, ADJUSTMENT | 35 | |
| - | 1 | 1 | 1 | 1 | 1 | 1752356-1 | 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 | 1320908-6 | SPACER, STRIP GUIDE | 30 | |
| - | 1 | 1 | 1 | 1 | 1 | 2119959-1 | ASSEMBLY, STRIP GUIDE | 29 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 | |
| - | 1 | 1 | 1 | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 | |
| - | 1 | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 | |
| - | 1 | 1 | 1 | 1 | 1 | 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 | 462006-6 | FLOATING SHEAR, FRONT | 9 | |
| - | 1 | 1 | 1 | 1 | 1 | 1333323-5 | ANVIL, COMBINATION, SPECIAL | 8 | |
| - | - | - | - | - | - | - | - | 7 | |
| - | - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 1 | 1 | 1 | 4-238011-7 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 1 | 1 | 1 | 1 | 1633966-2 | CRIMPER, INSULATION O | 3 | |
| - | - | - | - | - | - | - | - | 2 | |
| - | 1 | 1 | 1 | 1 | 1 | 5-1633738-8 | CRIMPER, WIRE | 1 | |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO | |

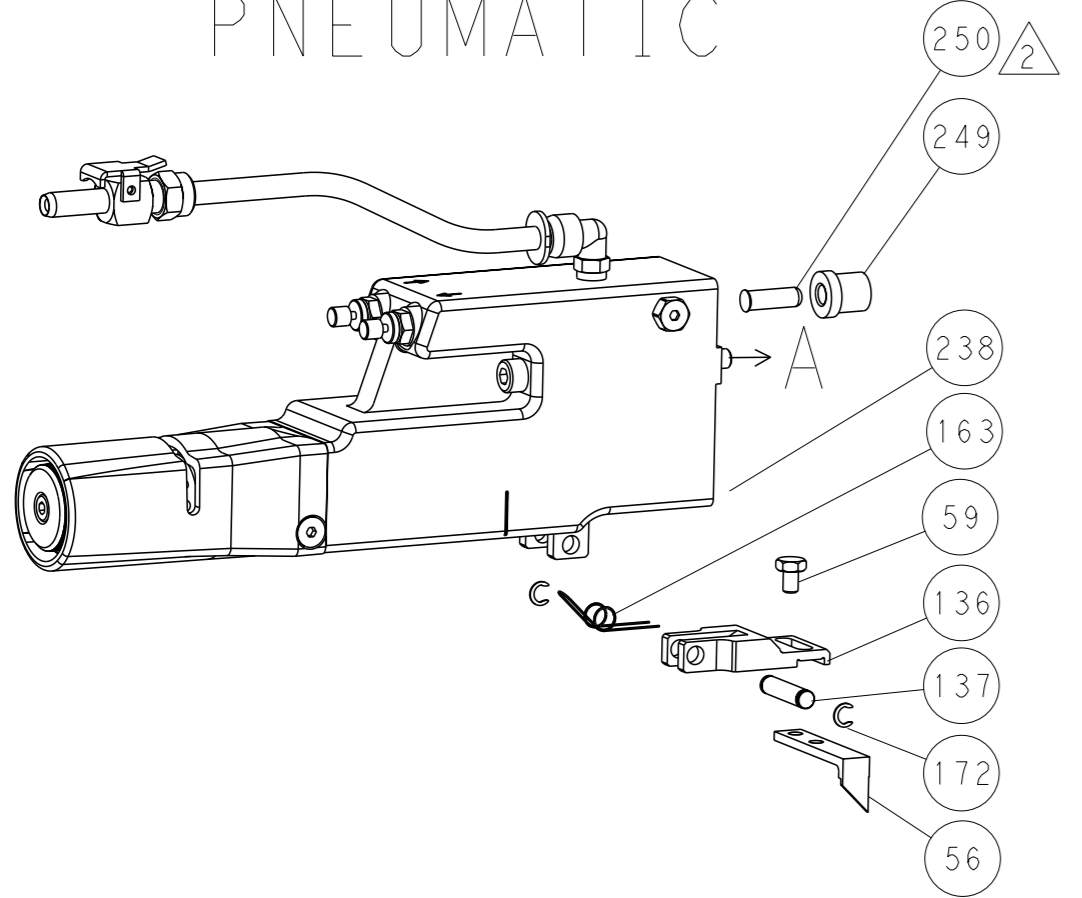
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN | CHK | APV | DATE | DATE | DATE |
|-------------|--------|--|--|--|-----------|-------|-----------|-----------|-----------|
| mm | 0 PLC | ± | | STAKEM | G. BAILEY | ELBIN | 08NOV2012 | 08NOV2012 | 08NOV2012 |
| | 1 PLC | ± | | NAME: Ocean Side Feed Applicator | | | | | |
| | 2 PLC | ± | | SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO | | | | | |
| | 3 PLC | ± | | A1 00779 ©=2151800 | | | | | |
| | 4 PLC | ± | | Customer Accessible Production Drawing | | | | | |
| | ANGLES | ± | | SCALE: 1:2 SHEET 1 of 4 REV A1 | | | | | |

| LOC | DIST | REV | DESCRIPTION | DATE | OWN | APVD |
|-----|------|-----|-------------|------|-----|------|
| A | 66 | | SEE SHEET 1 | | | |

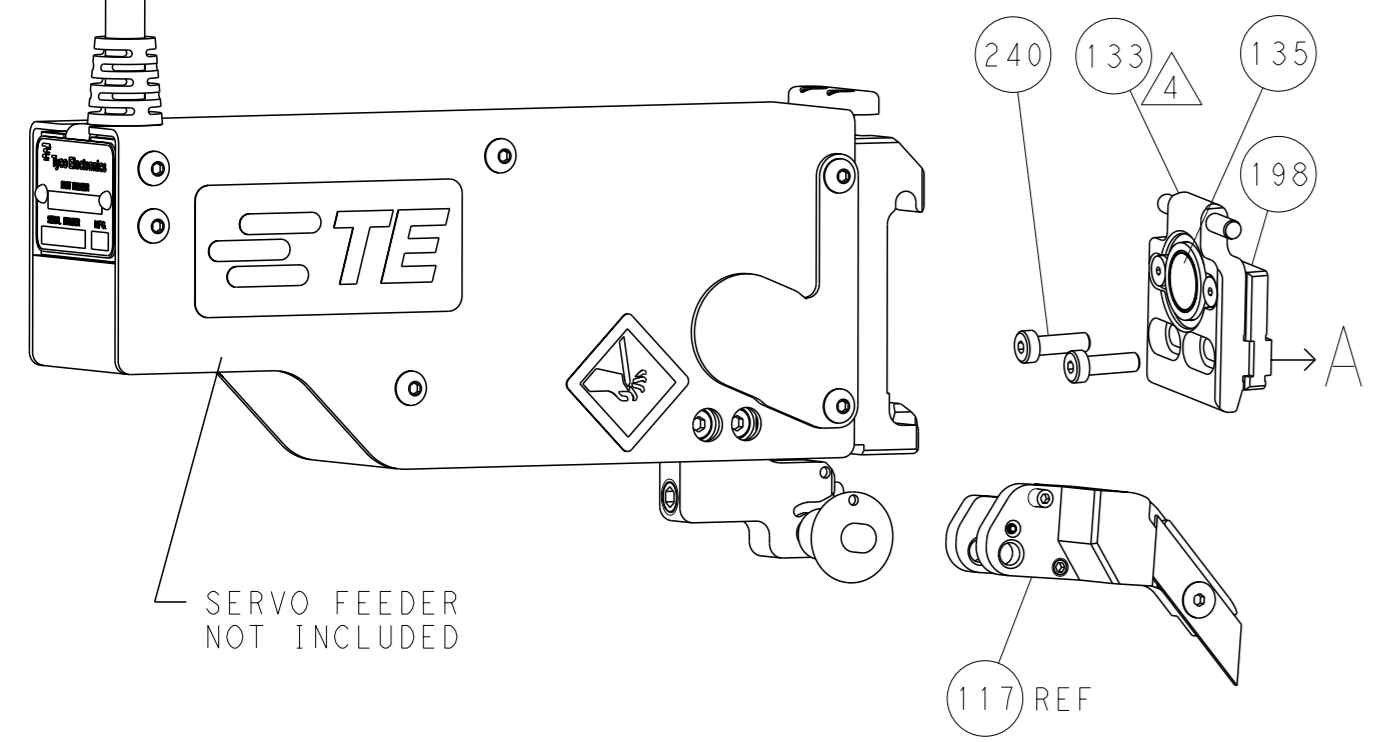
FEED TYPE MECHANICAL



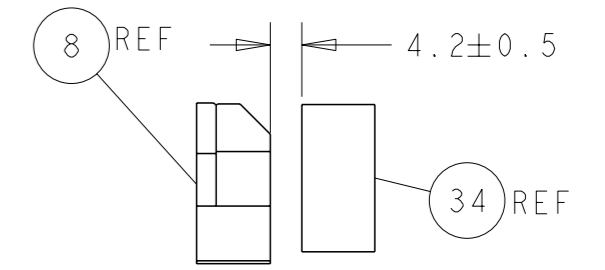
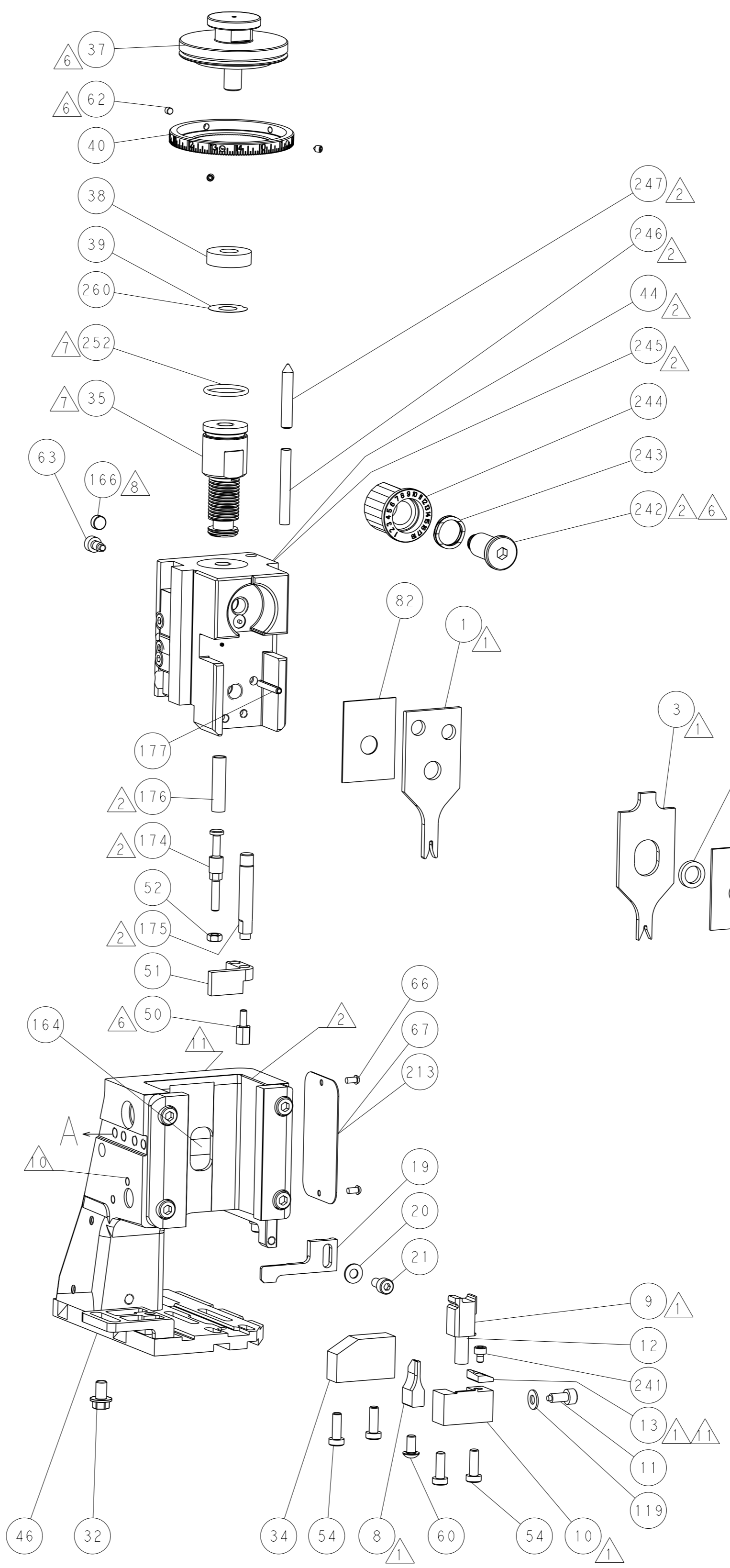
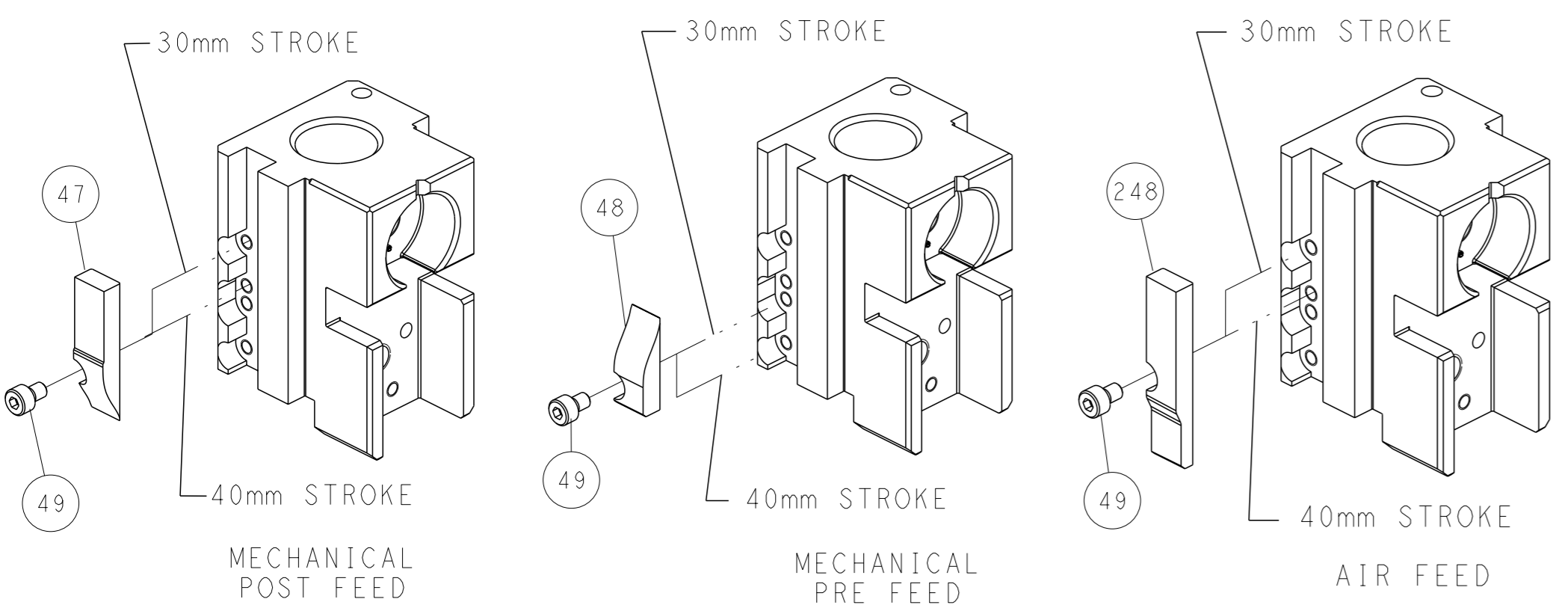
PNEUMATIC



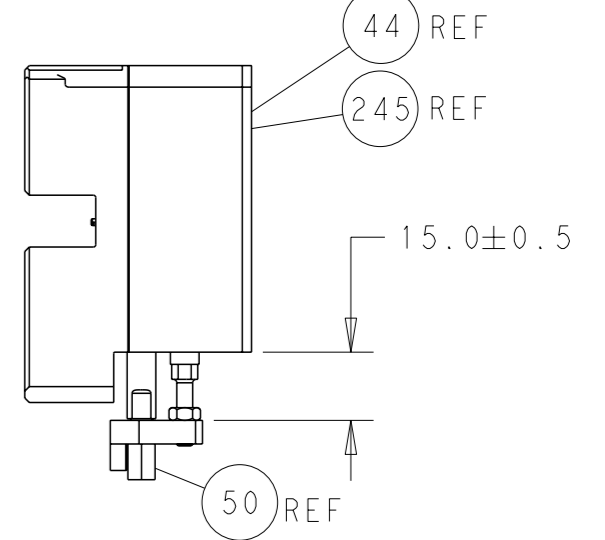
SERVO LATCH PLATE



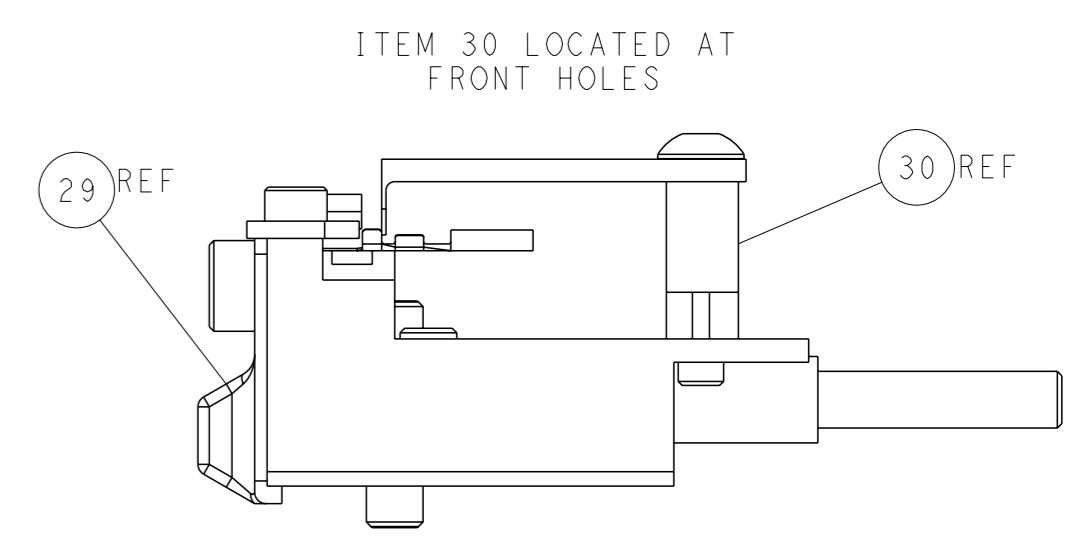
CAM POSITIONS



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)

| | | | | |
|--|--|---|--|--|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND TO CONTROL AND INSPECTION DISCRETION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | OWN: R. STAKEM CHK: G. BAILEY APVD: T. ELBIN | 08NOV2012 08NOV2012 08NOV2012 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ± | | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: ©=2151800 | RESTRICTED TO: - SCALE: 1:2 SHEET: 2 of 4 REV: A1 | CUSTOMER ACCESSIBLE PRODUCTION DRAWING |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2151800-1 | 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 | - | 8-2151800-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151800-4 | - | - | - |
| | 2-2151800-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151800-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151800-4 | - | - | - |
| | 2-2151800-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 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 |
| | 2-2151800-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2151800-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.02 mm (.040) | F |
| INSUL | 1.57 mm (.062) | O |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|-------------------------------------|-------------|------------------------------|-------------|
| TERMINAL NAME: MCON - 1.2mm CONTACT | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.15-3.91 mm (.124-.154 IN) | | Ø0.85-1.05 mm (.033-.041 IN) | |
| TERMINAL APPLICATION SPECIFICATION | 114-94295 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 2208088-1 | | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 0.17mm2 | 0.70 +/- 0.02 [.028 +/- .001] | 7.3 |
| 0.13mm2 | 0.68 +/- 0.02 [.027 +/- .001] | 7.6 |

- 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: 8-2151800-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151800-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151800-5
- 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 ITEM 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.

***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 | 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 |
| -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)

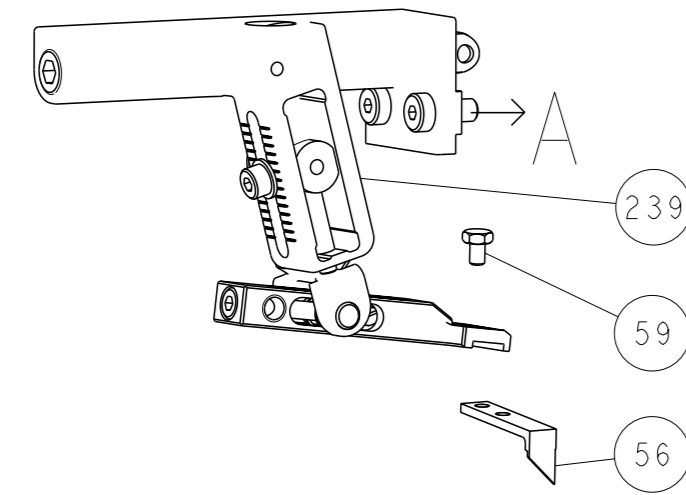
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|-------------|----|------|
| 2119599-1 | A | 66 | # | DATE | BY | APPV |
| | | | - | SEE SHEET 1 | - | - |

| | | | | | | | |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 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 |
| - | 1 | 1 | 1 | 1 | 993111-1 | PIN, SLOTTED SPRING 3.0 X 20.0 | 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 |
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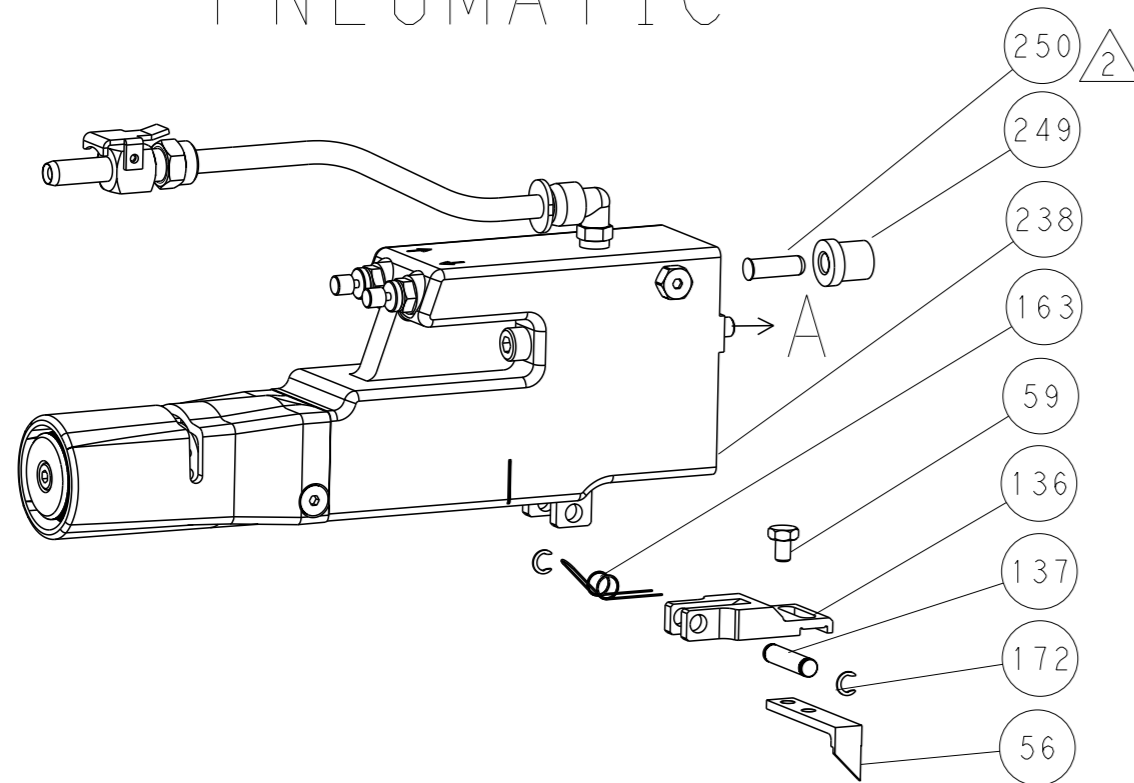
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|-------------|---------|--|---------|---------|---------|-------|--|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | APV | STAKEM |
| | ANGLES | FINISH | | | | ELBIN | TE Connectivity |
| MATERIAL | | | | | | | Harrisburg, PA 17105-3608 |
| | | | | | | | Ocean Side Feed Applicator |
| | | | | | | | Customer Accessible Production Drawing |

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

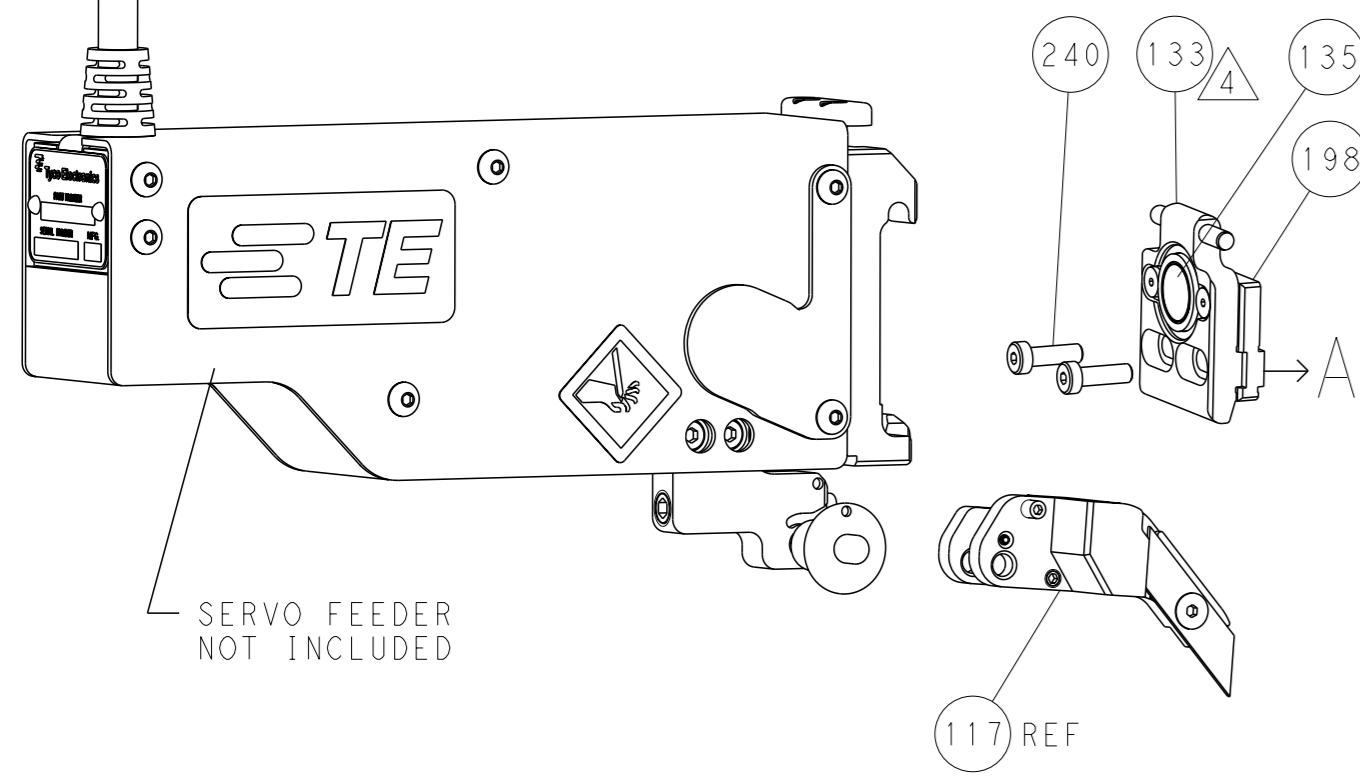
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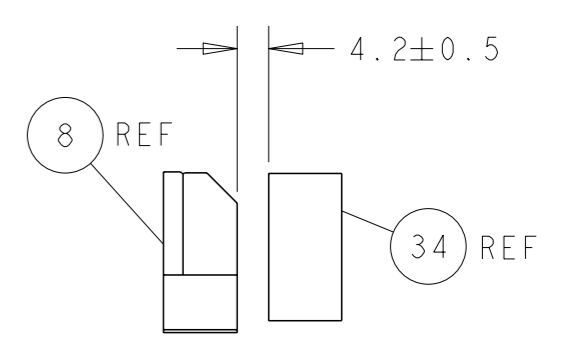
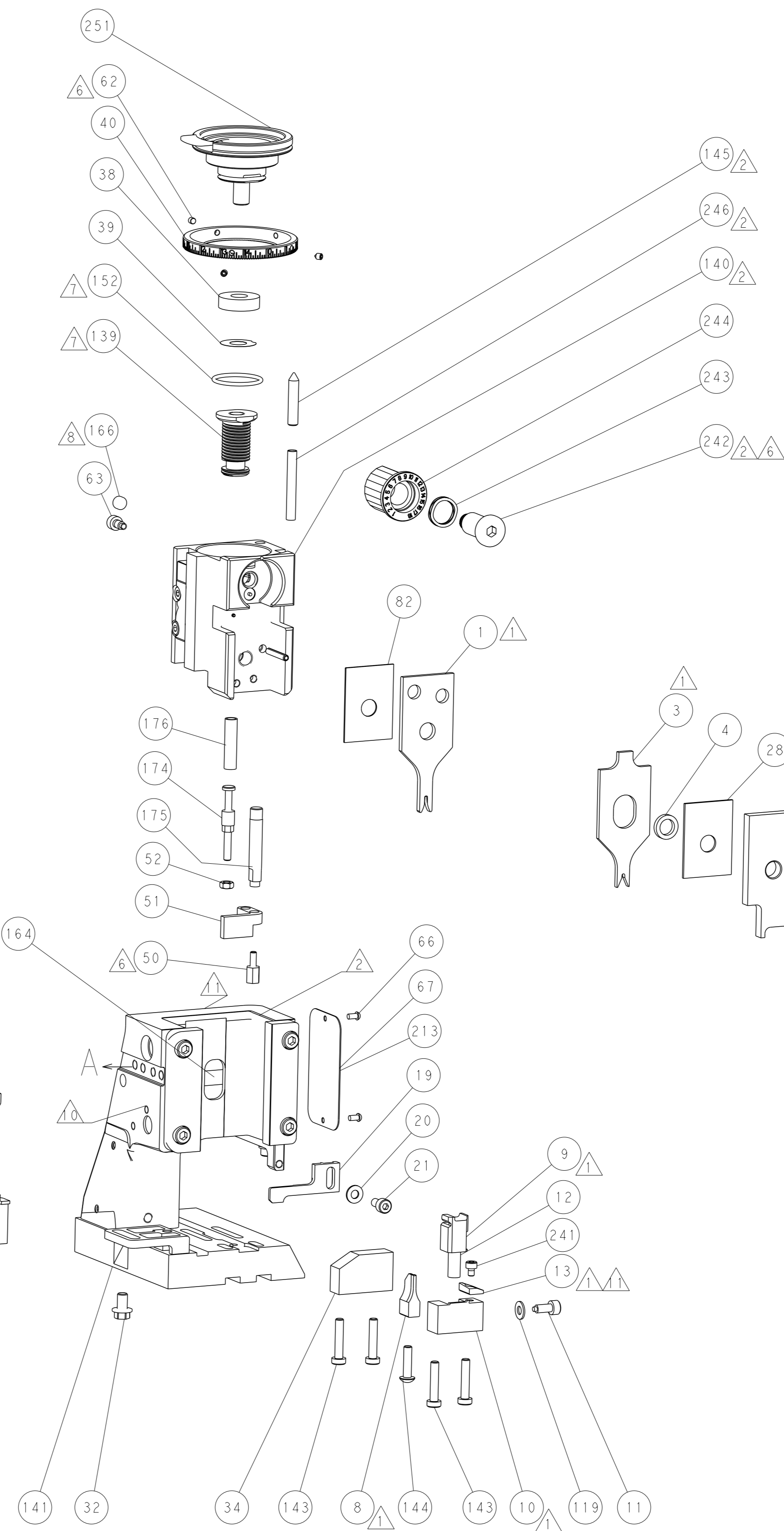
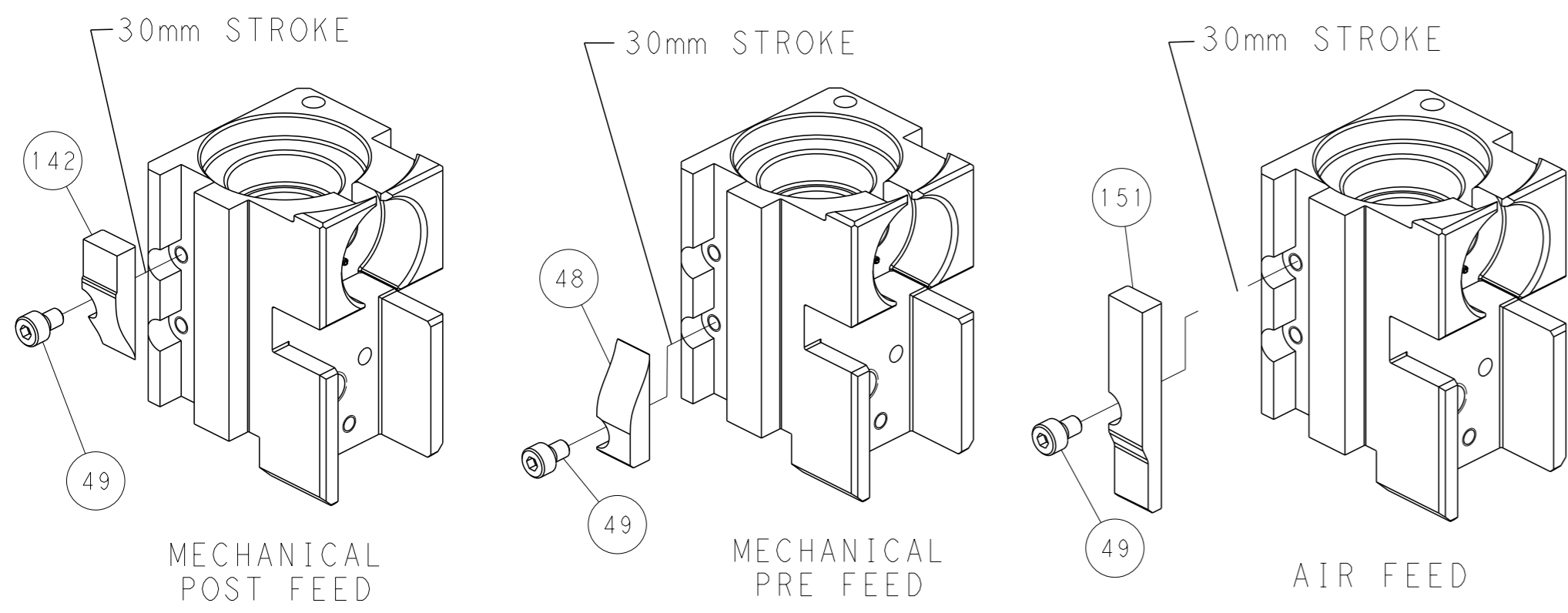
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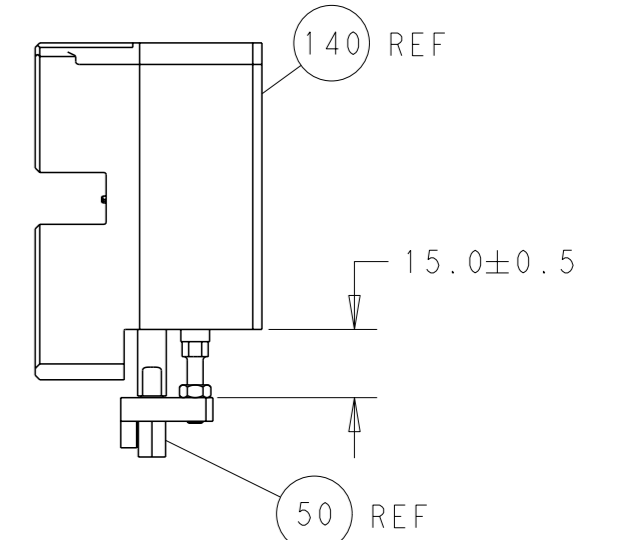
SERVO LATCH PLATE



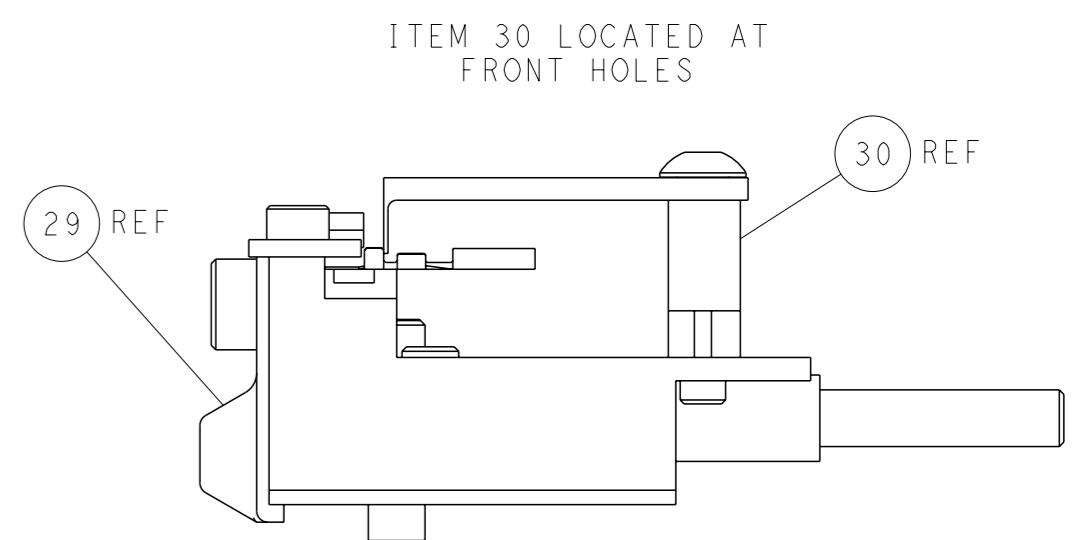
CAM POSITIONS



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)

| | | | |
|--|--|--|--|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | DWN: H. STAKEM 08NOV2012 CHK: G. BAILEY 08NOV2012 APVD: T. ELBIN 08NOV2012 | TE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH * | | NAME: Ocean Side Feed Applicator APPLICATION SPEC: - SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151800 | RESTRICTED TO: - SCALE: 1:2 SHEET: 4 of 4 REV: A1 |
| MATERIAL: - FINISH: - | | WEIGHT: - Customer Accessible Production Drawing | SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION |