

APPLICATOR STYLE CONVERSION CHART. Table with columns: CONVERT TO, PART NUMBERS REQUIRED, SERVO LATCH PLATE, SMART APPLICATOR, PNEUMATIC FEED, etc.

APPLICATOR DATA. Table with columns: CRIMP SIZE, WIRE, INSUL, APPLICATOR INSTRUCTIONS 408-10389.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Table with columns: TERMINAL NAME, WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table with columns: WIRE SIZE, CRIMP HEIGHT, CRIMP HEIGHT REFERENCE SETTING.

- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151813-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151813-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151813-6
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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 99 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
8. MAGNET, ITEM 166 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. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
11. 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.
12. WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT.
13. SET THE FINE CRIMP HEIGHT ADJUSTMENT HEAD TO PROPER CRIMP HEIGHT PRIOR TO TIGHTENING/LOCKING THE BRASS TIP SET SCREW, ITEM 99, AGAINST THE ADJUSTMENT BOLT THREADS.
14. APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

*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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Includes items like THREAD BOLT GEWINDEBOLZEN, APPLICATOR SHIM PACK, O-RING, PUSH ROD, AIR FEED, BUSHING, FEED CAM, AIR FEED, DETENT PIN, SPRING, COMPRESSION, RAM, AMP STYLE, SIDE FEED, NON-ADJ.

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

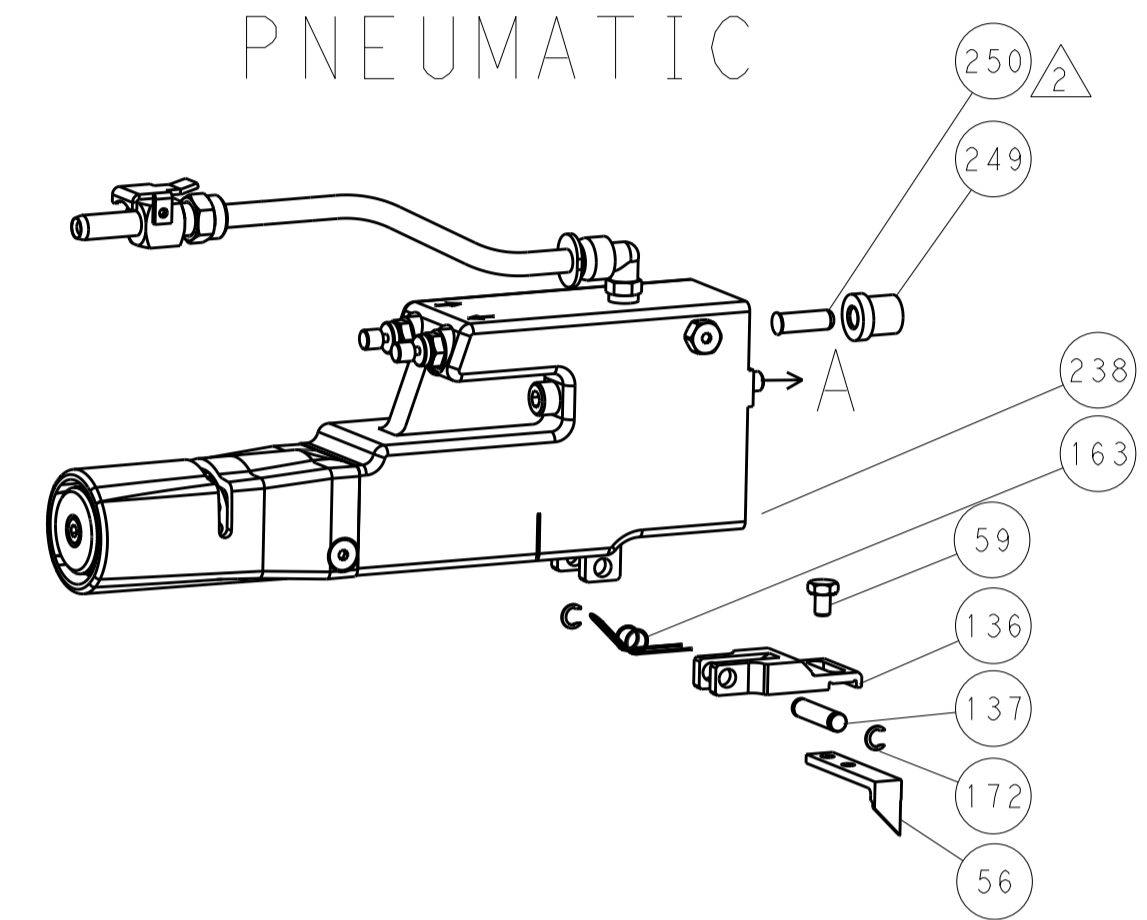
REVISIONS. Table with columns: REVISIONS, DESCRIPTION, DATE, DWN, APVD. Includes revisions C4, C5, D, E.

Main parts list table with columns: QTY, PART NO, DESCRIPTION, ITEM NO. Includes items like CAM, SNAIL, INSULATION ADJUSTMENT, WASHER, WAVE SPRING, CREST-TO-CREST, RETAINER, INSULATION DIAL, SCR, SKT HD CAP M3 X 4.0, SHCS, LOW HEAD, RoHS, M5 X 16, AIR FEED MODULE, TAG, IDENTIFICATION, SPACER, FEEDER, RING, RETAIN, EXTERN, 3/16 CRESCENT, MAGNET, RARE EARTH HIGH ENERGY, COUNTER, MAGNETIC, SPRING, FEED FINGER, PIN, RETAIN, GRVD, 3/16 X .854, HOLDER, FEED FINGER, AF, MEMORY CHIP, PROGRAMMED, SERVO FEED LATCH ASM, SPRING, COMPRESSION, WASHER, FLAT, REG M4, SCR, SET, SOFT TIP, M4, FRONT STRIP GUIDE, SCR, SKT HD CAP, RoHS, M3 X 8.0, SCR, SKT HD CAP, RoHS, M5 X 65, SPACER, CRIMPER, DOCUMENTATION PACKAGE, TAG, IDENTIFICATION, SCREW, DRIVE, RH, RoHS, 2 x .188, LIMITER, ADJUSTMENT BOLT, SCR, SET, SOC, CONE POINT, M3 X 4.0, SCR, SET, FLT POINT M5 X 20.0, SCR, BHSC, RoHS (M4 X 8), SCR, HEX HD CAP, M4 X 6.0, PAWL, FEED, SHCS, LOW HEAD, RoHS, M4 X 12, SCR, SKT HD CAP, RoHS, M4 X 16, NUT, HEX, REG, RoHS, M3, BUMPER, HOLD DOWN, SPACER, TONKER, SCR, SKT HD CAP M4 X 6.0, APPLICATOR BASIC ASSEMBLY, SF, RAM, AMP STYLE, SIDE FEED, SCR, BHSC, RoHS (M8 X 25), DISC, NUMBERED FA WIRE ADJUSTMENT, APPLICATOR SHIM PACK, RAM WASHER, PRECISION, FA HEAD, ATLANTIC STYLE, BOLT, ADJUSTMENT, SUPPORT, TERMINAL, SCR, BHSC, RoHS (M4 X 20), HEX HEAD, FLANGED, M5 X 8mm LONG, SPACER, STRIP GUIDE, PLATE, STRIP GUIDE, SPACER, CRIMPER, SPRING, COMPRESSION, LEVER, DRAG RELEASE, DRAG, TERMINAL, STRIP GUIDE, SCR, SKT HD SHLDR 5.0 DIA X 6.0, SCR, SKT HD CAP, RoHS, M4 X 8.0, WASHER, FLAT, REG M4, STRIPPER, INSERT, SHEAR, SPRING, COMPRESSION, STOP, SHEAR, SHEAR HOLDER, FRONT, FLOATING SHEAR, FRONT, ANVIL, COMBINATION, SPACER, SHEAR DEPRESSOR ASSEMBLY, BLOCK, CRIMPER SPACER, CRIMPER, INSULATION F, CRIMPER, WIRE, CONICAL BLEND.

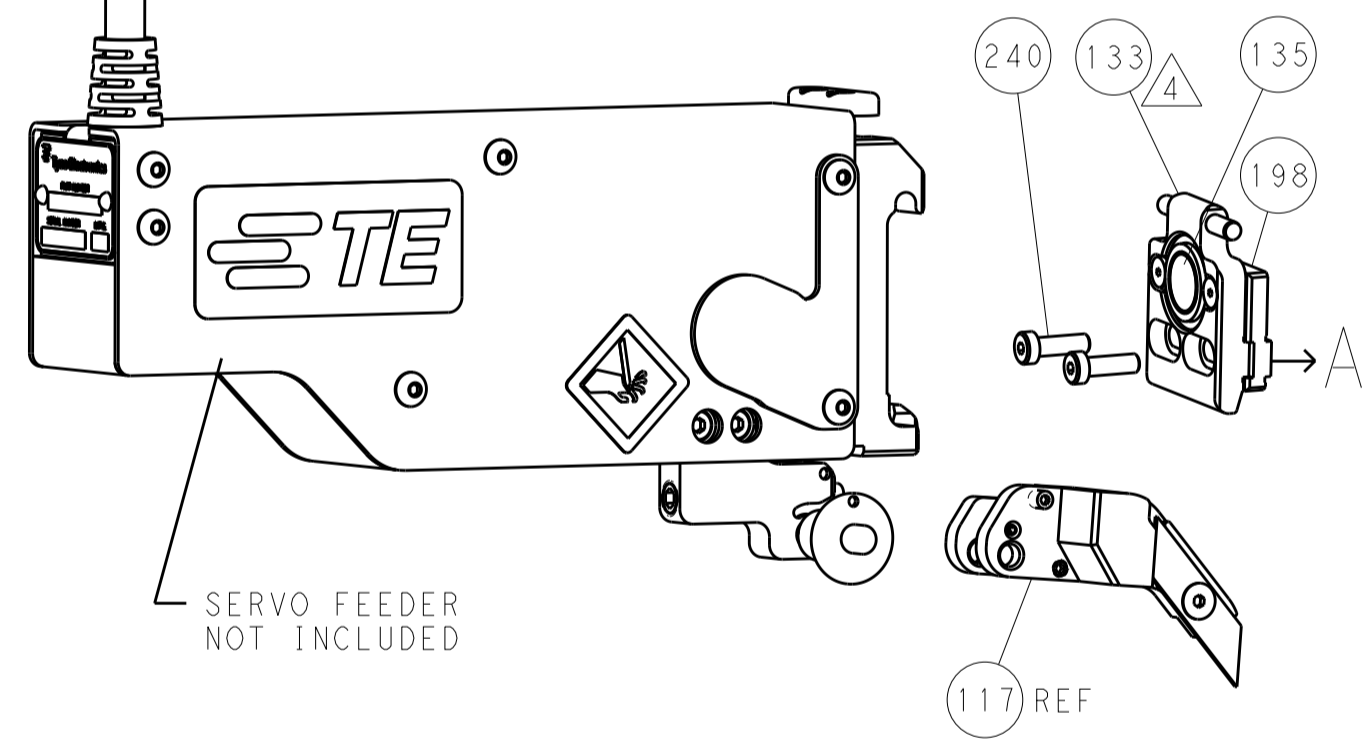
Product information block including dimensions, tolerances, material, finish, weight, scale, and drawing information. Includes STC logo and contact info.

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

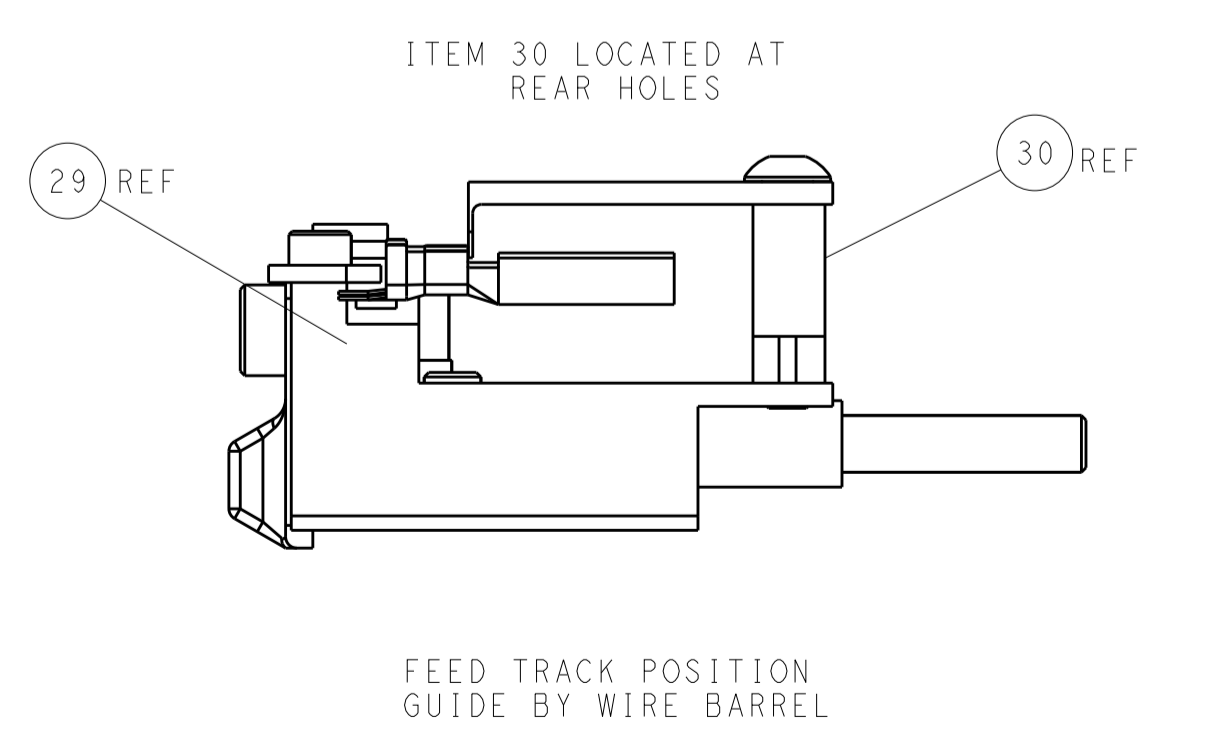
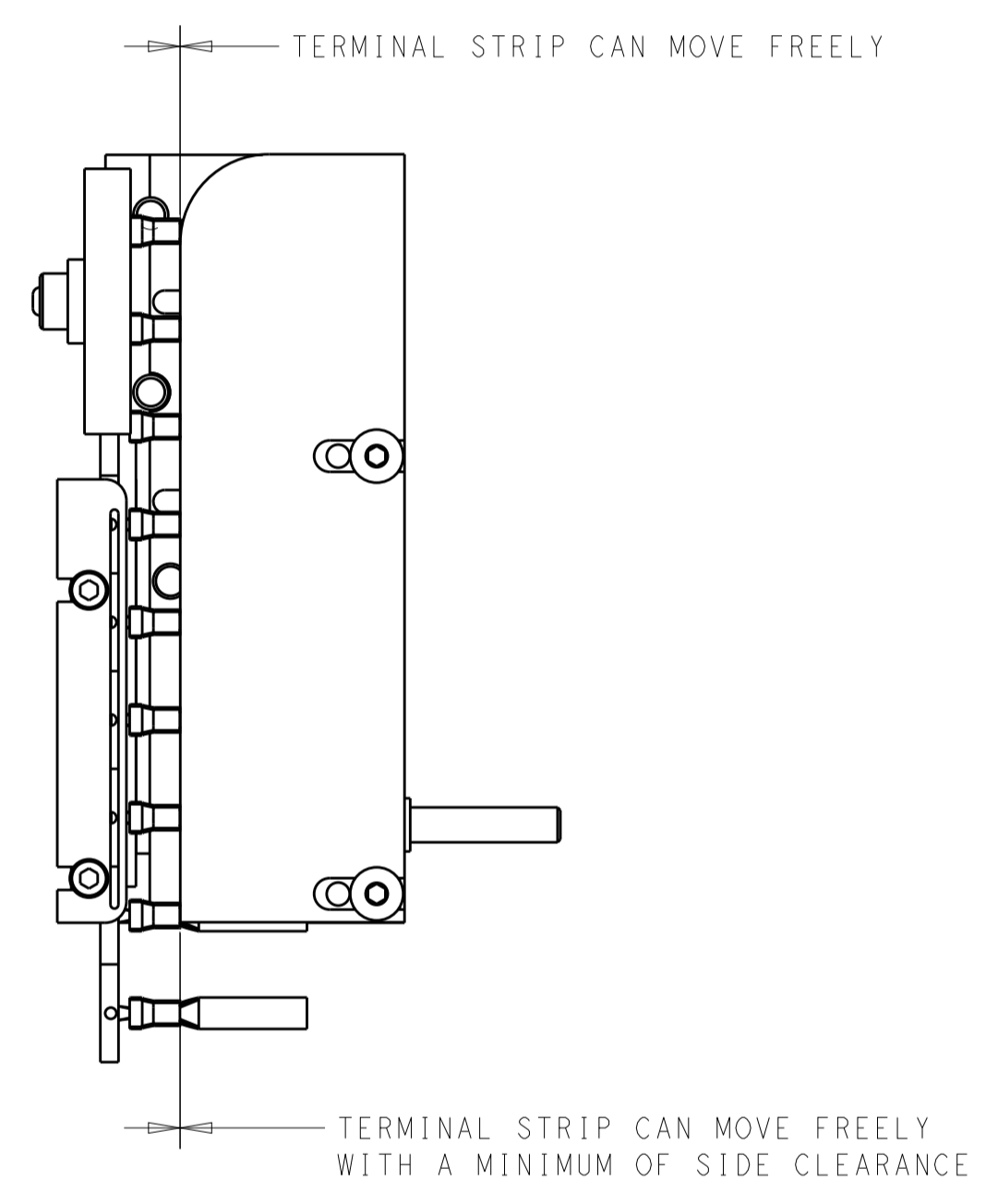
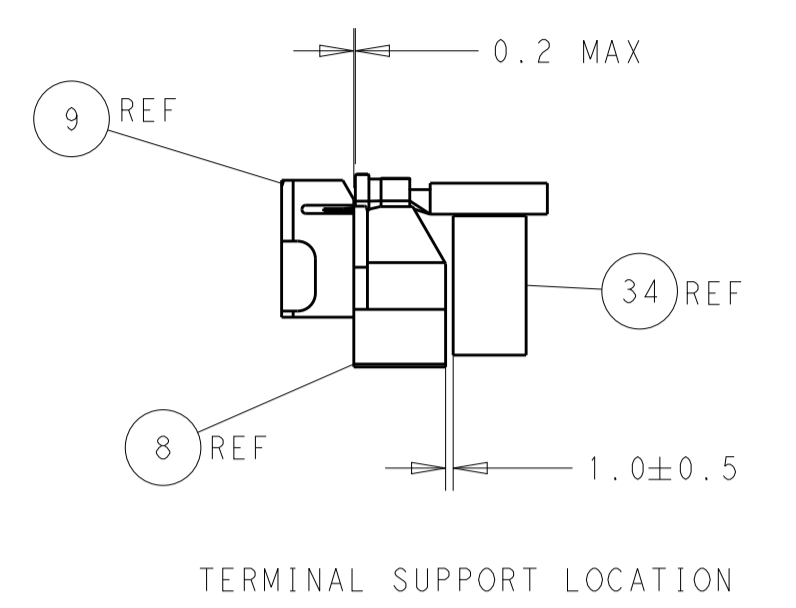
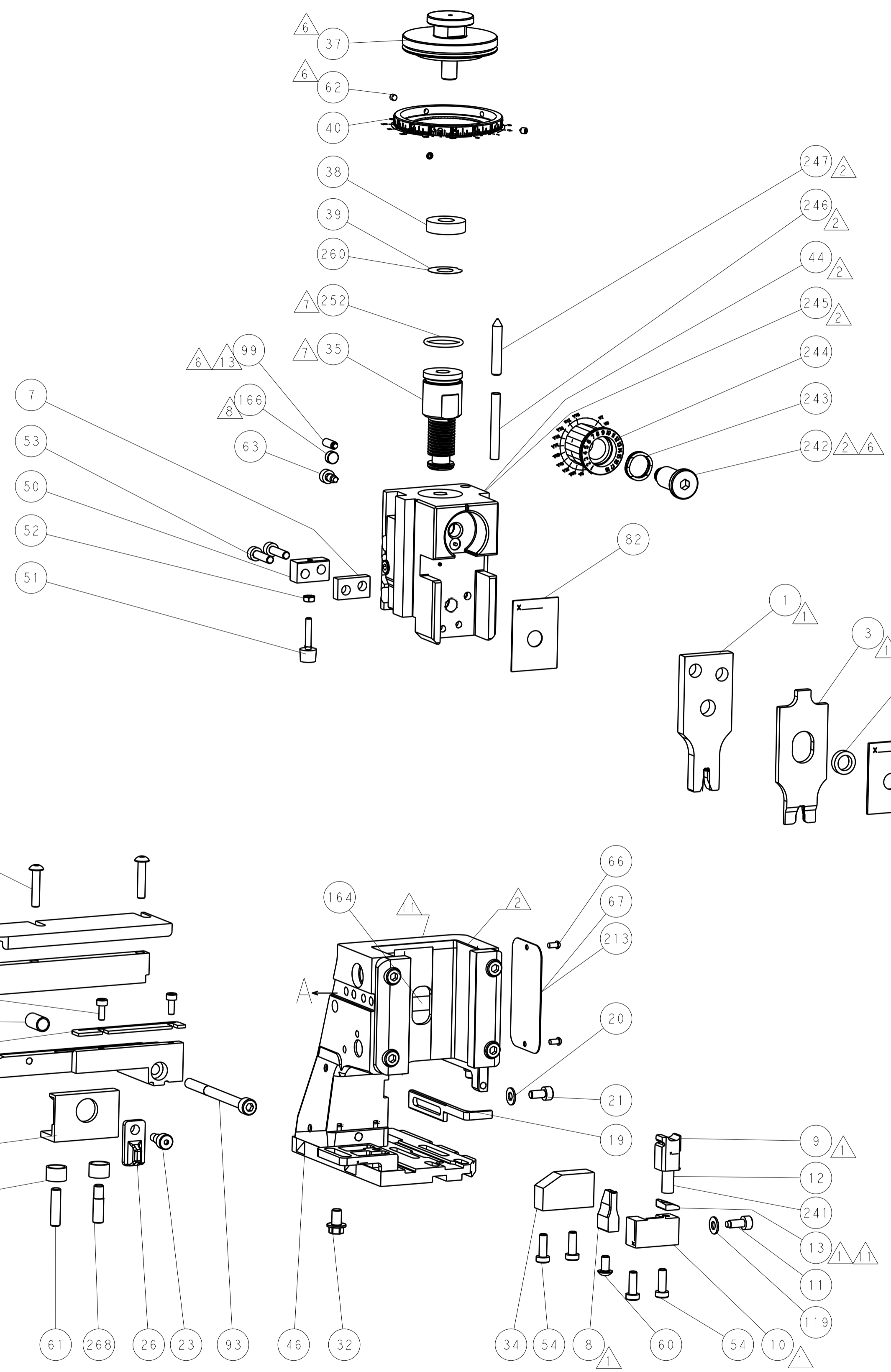
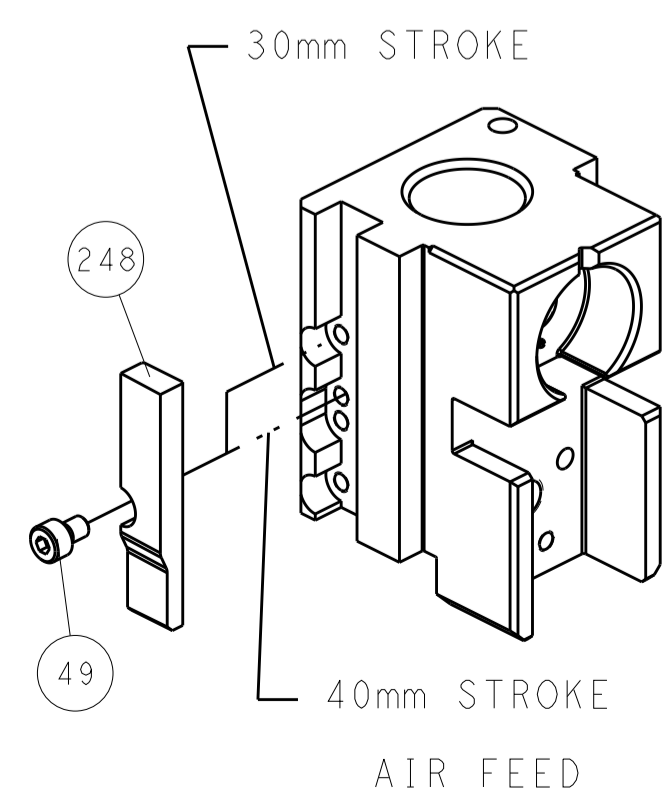
FEED TYPE PNEUMATIC



SERVO LATCH PLATE



CAM POSITION



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: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± MATERIAL: - FINISH: -		NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:2	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151813 SHEET 2 OF 4 REV E

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
				CONVERT TO	PART NUMBERS REQUIRED					
2-2151813-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151813-5	1901094-3	-	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2151813-4	-	-	-
2-2151813-5	E	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-
				PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
2-2151813-7	E	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2151813-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.30 mm [.130]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB 2.8 X 0.8 LITEALUM	
WIRE STRIP LENGTH 3.20-3.80 mm [1.26-.150 IN]	INSULATION DIAMETER RANGE Ø2.88-3.04 mm [1.113-.120 IN]
TERMINAL APPLICATION SPECIFICATION 114-94204	

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-2177895-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.52±0.04 [.0598±.0016]	3.2



- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151813-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151813-5
- 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 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 99 & 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET 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.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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.
- SET THE FINE CRIMP HEIGHT ADJUSTMENT HEAD TO PROPER CRIMP HEIGHT PRIOR TO TIGHTENING/LOCKING THE BRASS TIP SET SCREW, ITEM 99, AGAINST THE ADJUSTMENT BOLT THREADS.
- APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

***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	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	268
-	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	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-77	-27	-25	-22	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)

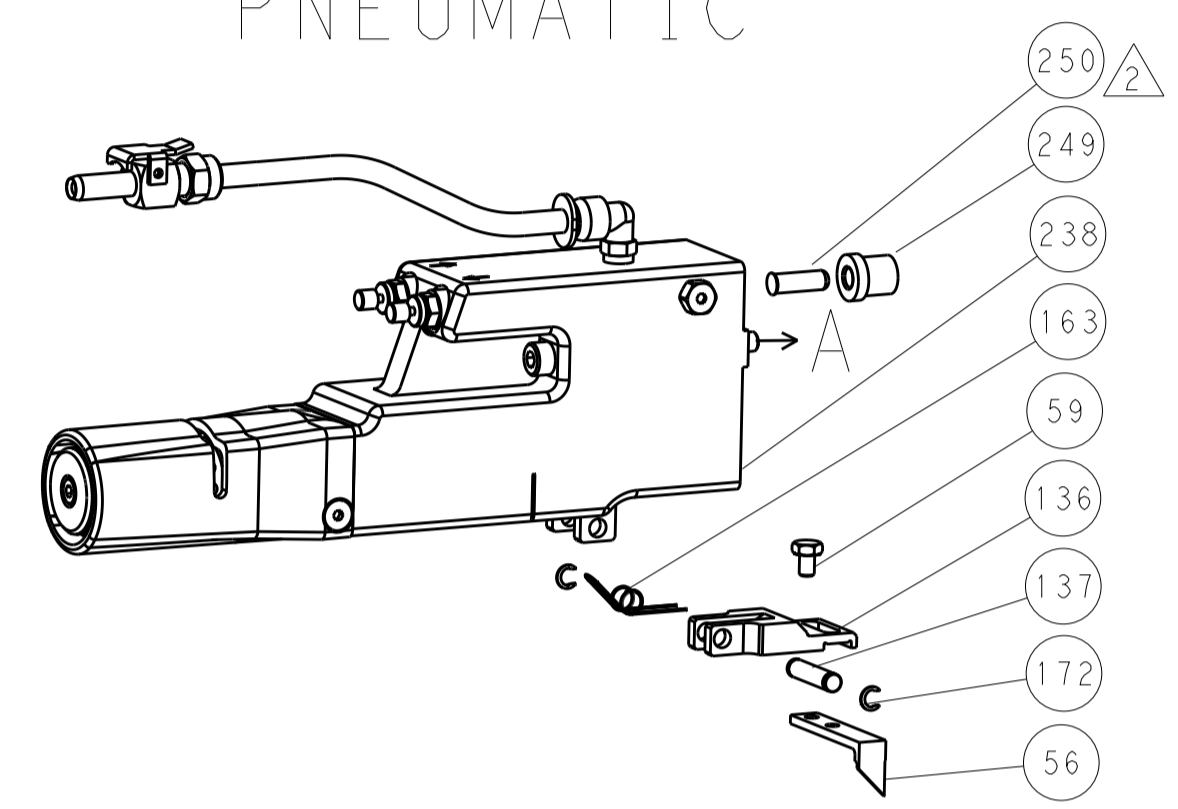
LOC	DIST	REV	DATE	BY	APPD
A	66				

REV	LTN	DESCRIPTION	DATE	BY	APPD	
-	-	SEE SHEET 1	-	-	-	
△6	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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	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
△8	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	240638-1	SPRING, FEED FINGER	163
△7	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	2119798-2	DETENT PIN	145
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	1	1	1	2-2119656-4	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
△7	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	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
△2	△6	1	1	2256587-1	SCR, SET, SOFT TIP, M4	99
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 6.5	93
-	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
△6	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
-	1	1	1	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1338685-1	PAWL, FEED	56
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
-	1	1	1	1320908-7	SPACER, STRIP GUIDE	30
-	1	1	1	1901086-1	PLATE, STRIP GUIDE	29
-	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1803142-1	DRAG, TERMINAL	25
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	690472-2	STRIPPER	19
△1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-5	STOP, SHEAR	11
△1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
△1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
△1	1	1	1	2161316-5	ANVIL, COMBINATION	8
-	1	1	1	2-240641-9	SPACER	7
-	-	-	-	-	-	6
-	1	1	1	1-1722335-0	SHEAR DEPRESSOR ASSEMBLY	5
-	1	1	1	3-238011-8	BLOCK, CRIMPER SPACER	4
△1	1	1	1	1-1722335-2	CRIMPER, INSULATION F	3
-	-	-	-	-	-	2
△1	1	1	1	2217303-2	CRIMPER, WIRE, CONICAL BLEND	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

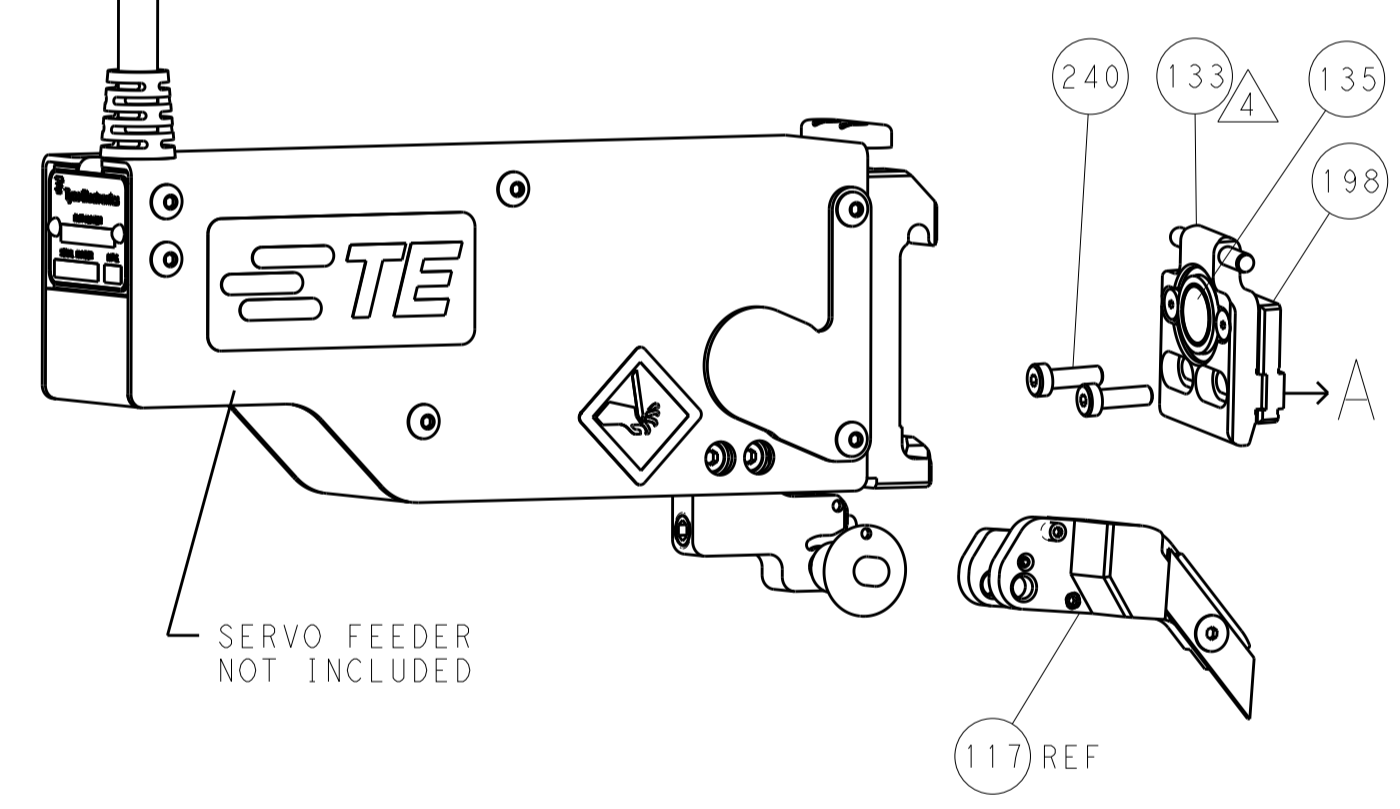
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	1 PLC ±.05	APPD	J. CRUZ	07FEB2013	
	2 PLC ±.02	NAME			
	3 PLC ±.01	Ocean Side Feed			
	4 PLC ±.005	Applicator			
	ANGLES ±.5	SIZE	CAGE CODE		DRAWING NO
MATERIAL	FINISH	A1		00779	©=2151813
		Customer Accessible Production Drawing		SCALE	1:2 SHEET 3 OF 4 REV E

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

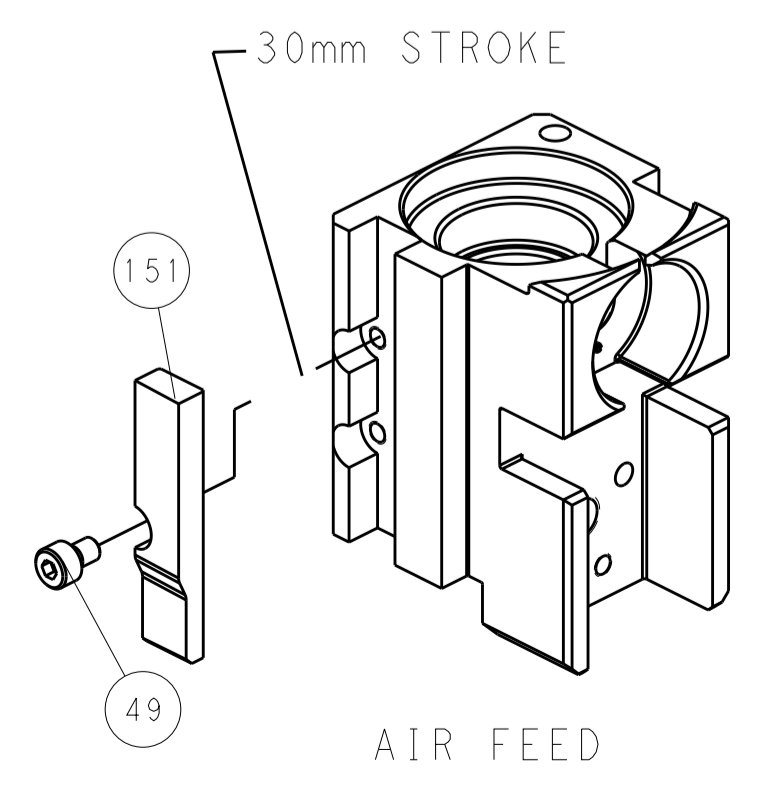
FEED TYPE PNEUMATIC



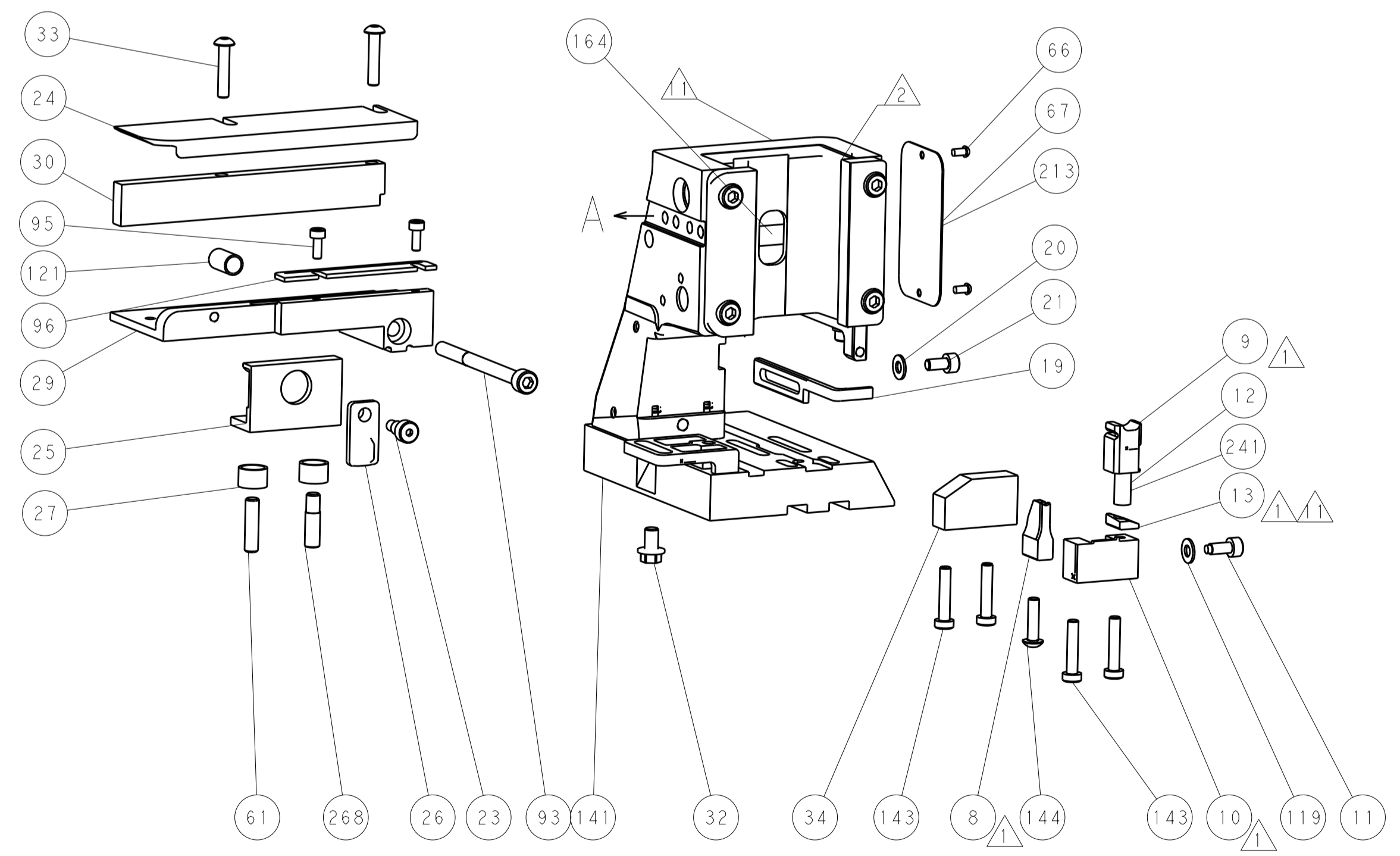
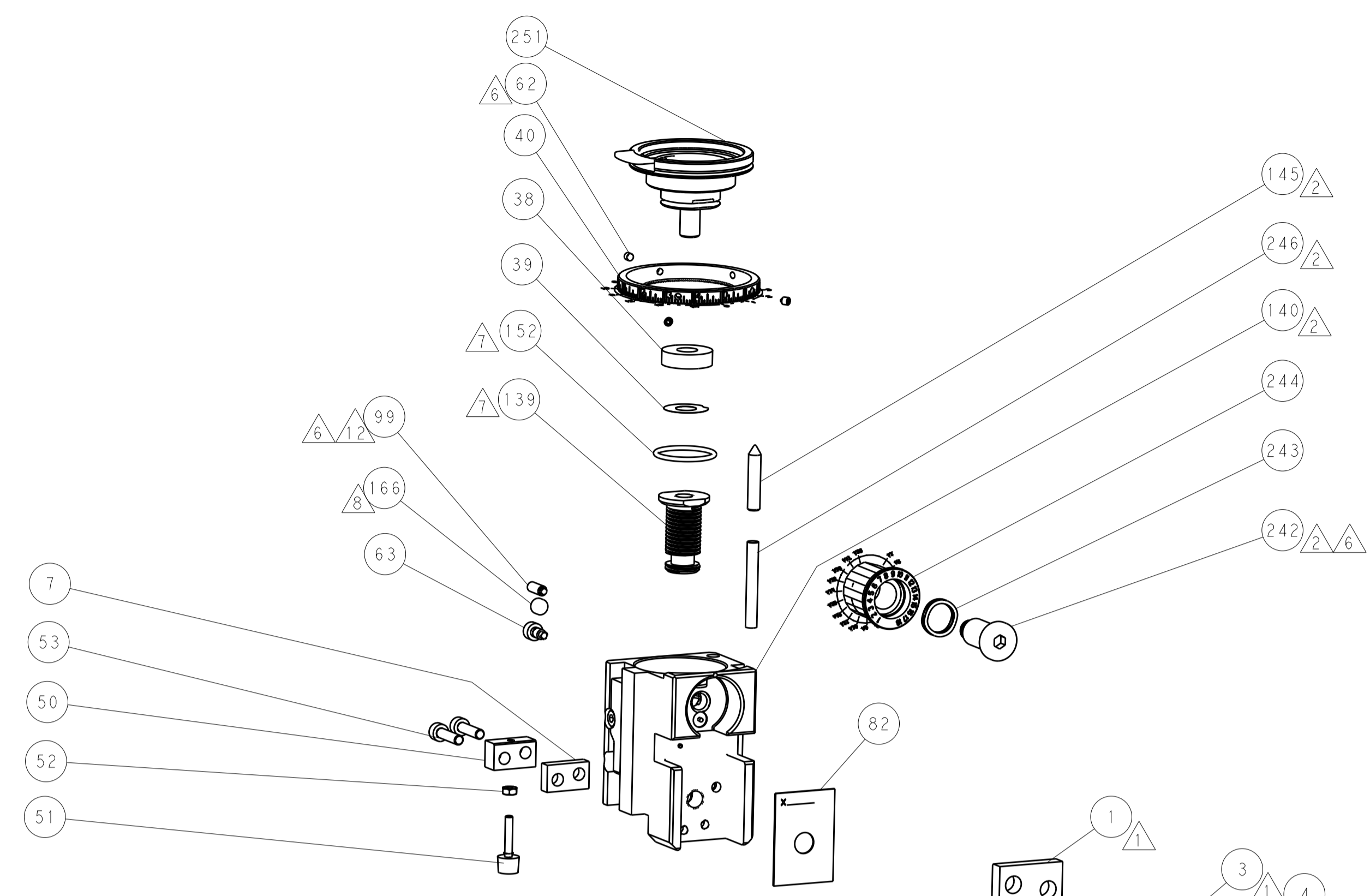
SERVO LATCH PLATE



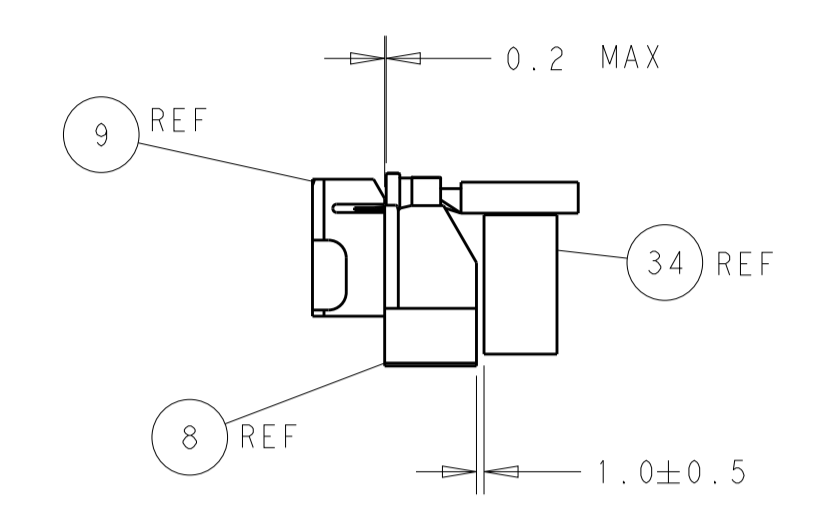
CAM POSITION



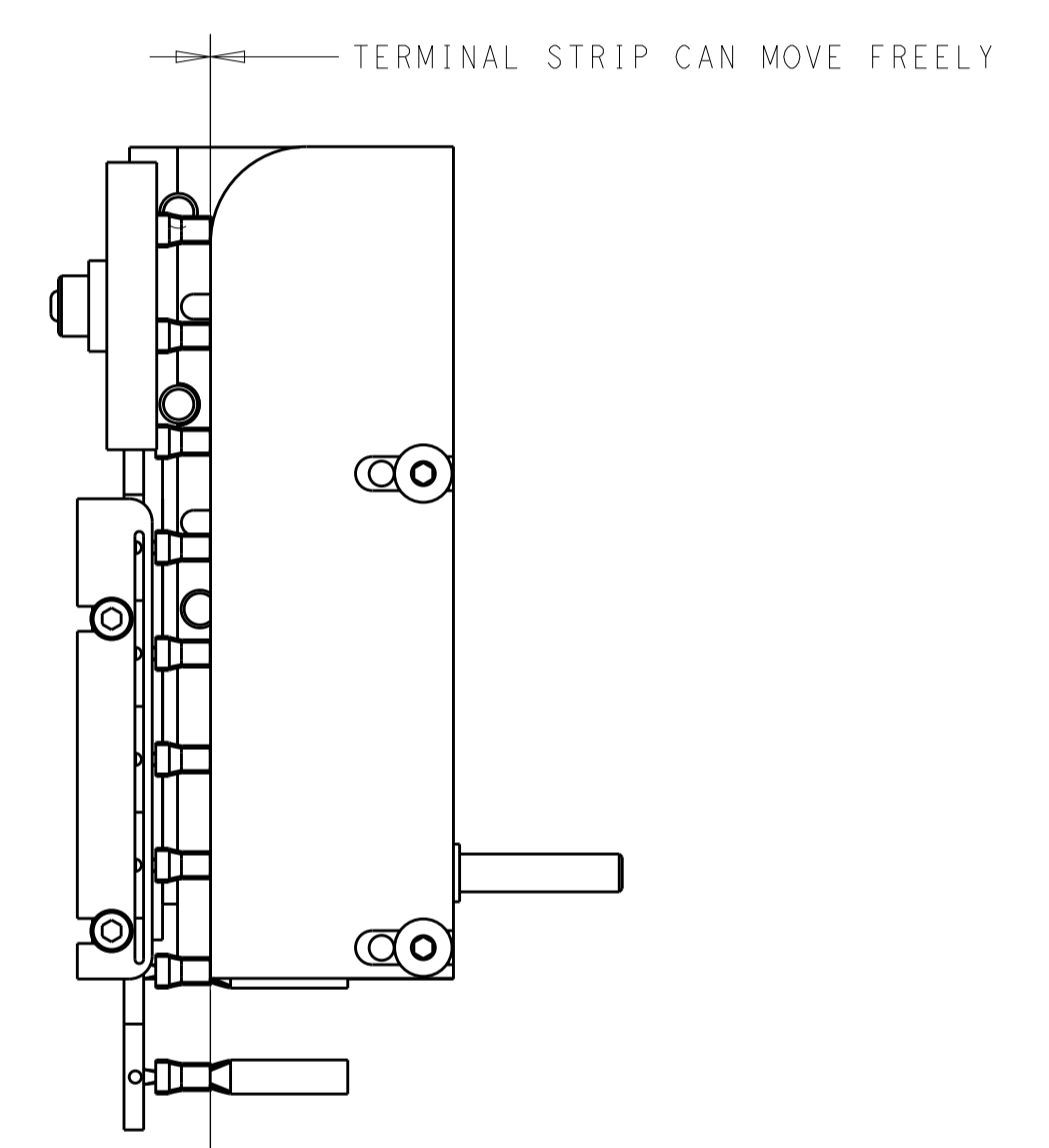
AIR FEED



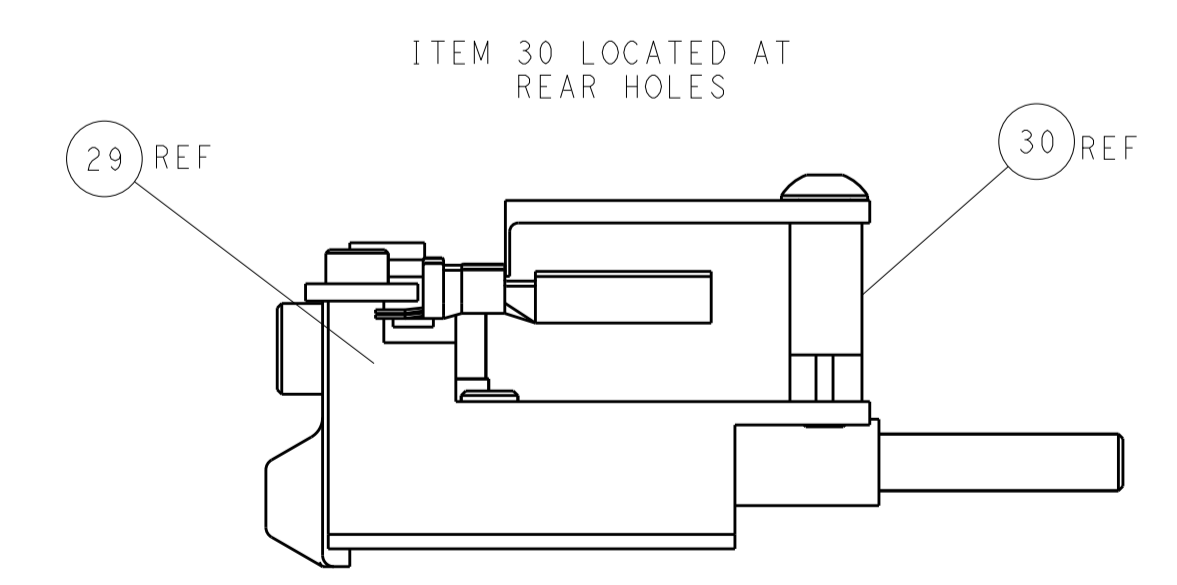
PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)



TERMINAL SUPPORT LOCATION



TERMINAL STRIP CAN MOVE FREELY WITH A MINIMUM OF SIDE CLEARANCE



FEED TRACK POSITION GUIDE BY WIRE BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. CHEN 07FEB2013		STE TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	APVD S. XI 07FEB2013	NAME Ocean Side Feed Applicator
	ANGLES ±	FINISH		PRODUCT SPEC	APPLICATION SPEC	SIZE A1	CAGE CODE DRAWING NO 00779 C=2151813
MATERIAL				RESTRICTED TO	SCALE 1:2	SHEET 4	OF 4
				Customer Accessible Production Drawing		REV E	