

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO						
				PART NUMBERS REQUIRED						
				PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
2151622-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	-	8-2151622-5	1901094-3	-	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2151622-4	-	-	
2151622-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
				SERVO LATCH PLATE	2119951-1	-	8-2151622-5	1901094-3	-	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2151622-4	-	-	
2151622-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	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
2151622-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-
2151622-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
7-2151622-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

REVIS	DATE	BY	APPV	DESCRIPTION
1	25APR2012	CAM	TE	ORIGINAL
A	07JUN2012	CAM	GB	RELEASED

CRIMP	SIZE	TYPE
WIRE	1.78 mm [ .070 ]	F
INSUL	3.56 mm [ .140 ]	F

APPLICATOR INSTRUCTIONS  
408-10389

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63934-1	61723-1	61656-1	-

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.22 +/- 0.05 [ .048 +/- .002 ]	11.6
20 AWG	1.09 +/- 0.05 [ .043 +/- .002 ]	13.1
22 AWG	1.02 +/- 0.05 [ .040 +/- .002 ]	13.9

- 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: 8-2151622-4
  - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151622-4
  - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151622-5
  - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151622-6
- 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 ITEM 50.
- 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. 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12. WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT
- 13. CUT TO LENGTH AT ASSEMBLY.

**\*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
-	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	2119082-9	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
-	-	2	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-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)

-	-	-	-	1	-	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	1	1	1	1	1	2063687-2	PLATE, REAR SHEAR	233
-	1	1	1	1	1	2161951-1	BLADE, SLUG	232
-	-	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	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	2217068-1	BRACKET, AIR BLAST	130
-	457	457	457	457	457	2030758-3	TUBING, POLYURETHANE	129
-	1	1	1	1	1	5018030-2	NUT, HEX, REG, RoHS, M4	128
-	1	1	1	1	1	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	127
-	1	1	1	1	1	986220-3	CLAMP, CABLE, BLACK	126
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	23238-1	INSERT, COUPLING	101
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	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
-	2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1	1338683-9	FEED PAWL	56
-	1	1	1	1	1	1-811242-0	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	3-18031-6	SCR, SET, CUP POINT M2.5 X 3.0	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	2119656-1	APPLICATOR BASIC ASSEMBLY, SF	46
-	2	2	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	45
-	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	1	1	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	43
-	1	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	2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	36
-	1	-	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	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	1-1320908-5	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE	29
-	2	2	2	2	2	1-22284-0	SPRING, COMPRESSION	27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	3-690754-8	DRAG, SPECIAL	25
-	1	1	1	1	1	1633653-3	PLATE, 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
-	4	4	4	4	4	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-2	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	1-2119928-8	FENCE	12
-	1	1	1	1	1	1803011-4	HOLDER, SLUG BLADE	11
-	-	-	-	-	-	-	-	10
-	-	-	-	-	-	-	-	9
-	-	-	-	-	-	-	-	6
-	-	-	-	-	-	-	-	5
-	1	1	1	1	1	2-238009-3	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	1	2-2119582-4	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	2
-	1	1	1	1	1	5-456404-5	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

**STE** TE Connectivity  
Harrisburg, PA 17105-3608

**Ocean Side Feed Applicator**

SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO

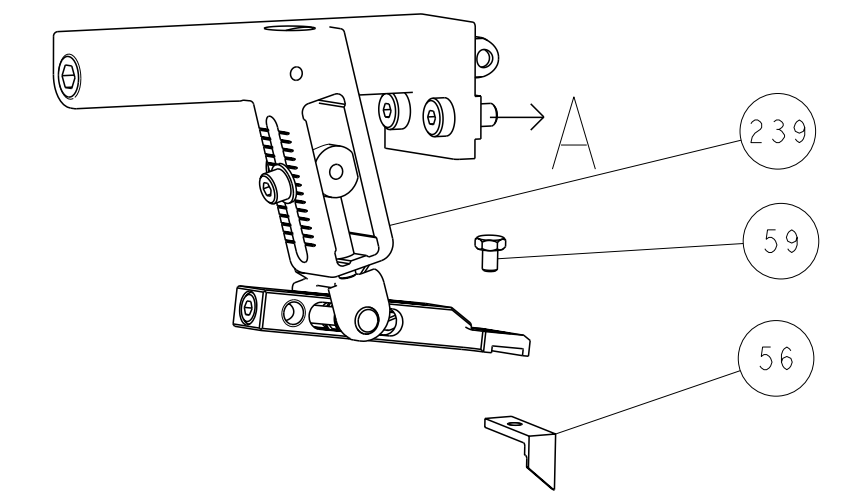
APV01 ELBIN 25APR2012

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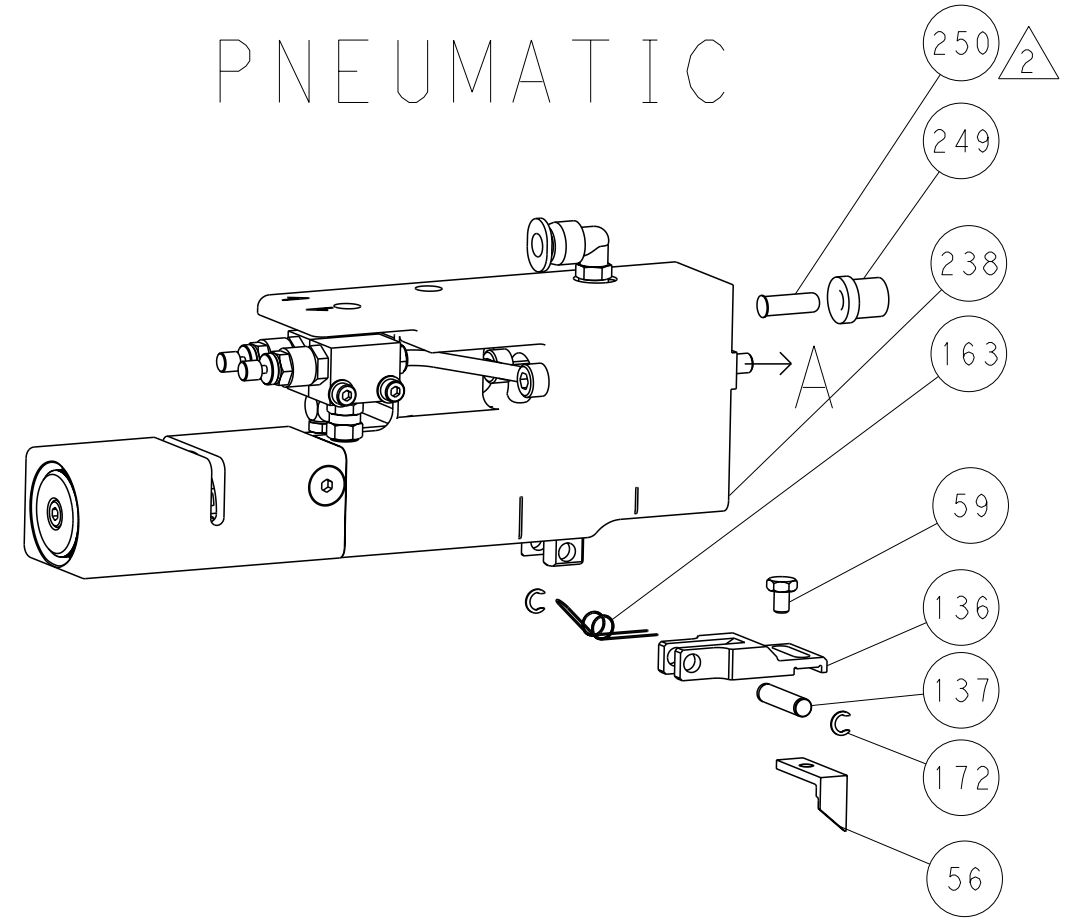
CUSTOMER ACCESSIBLE PRODUCTION DRAWING

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

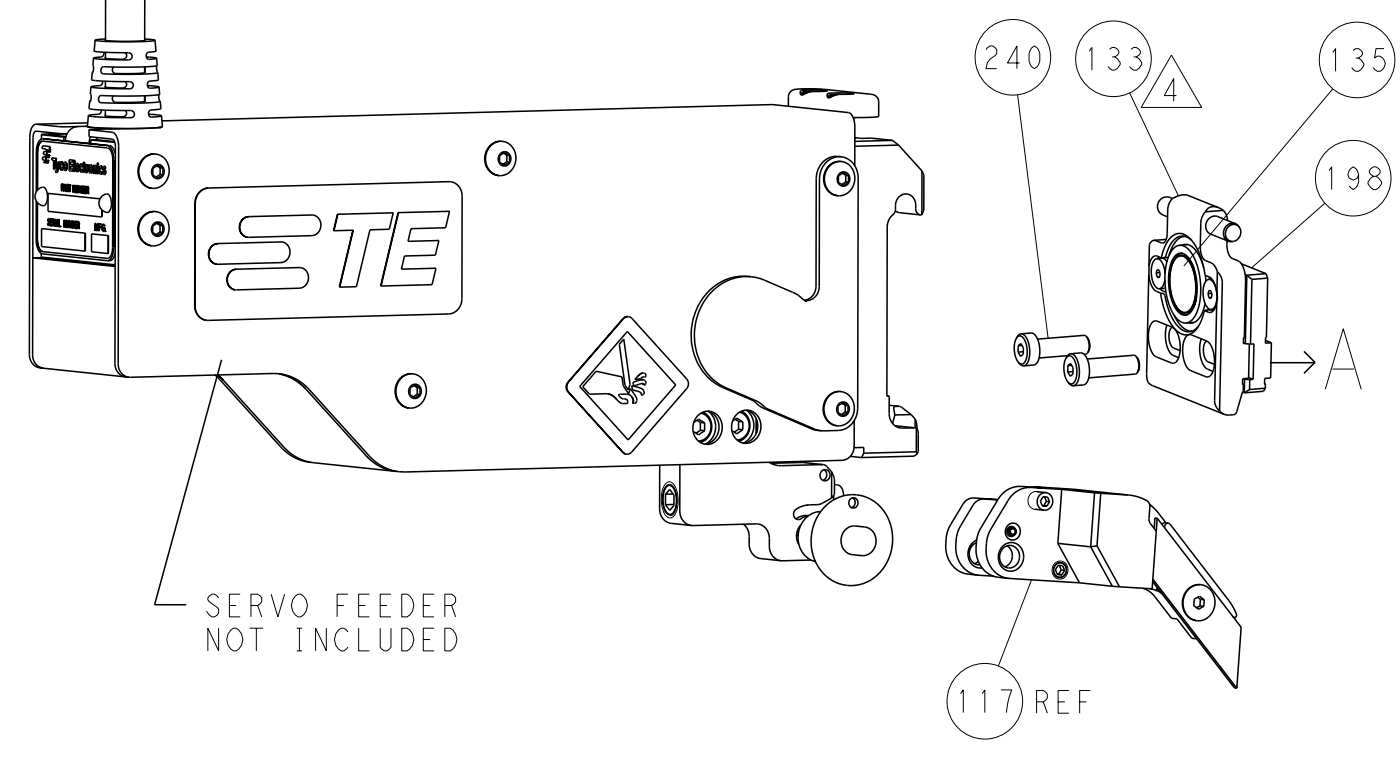
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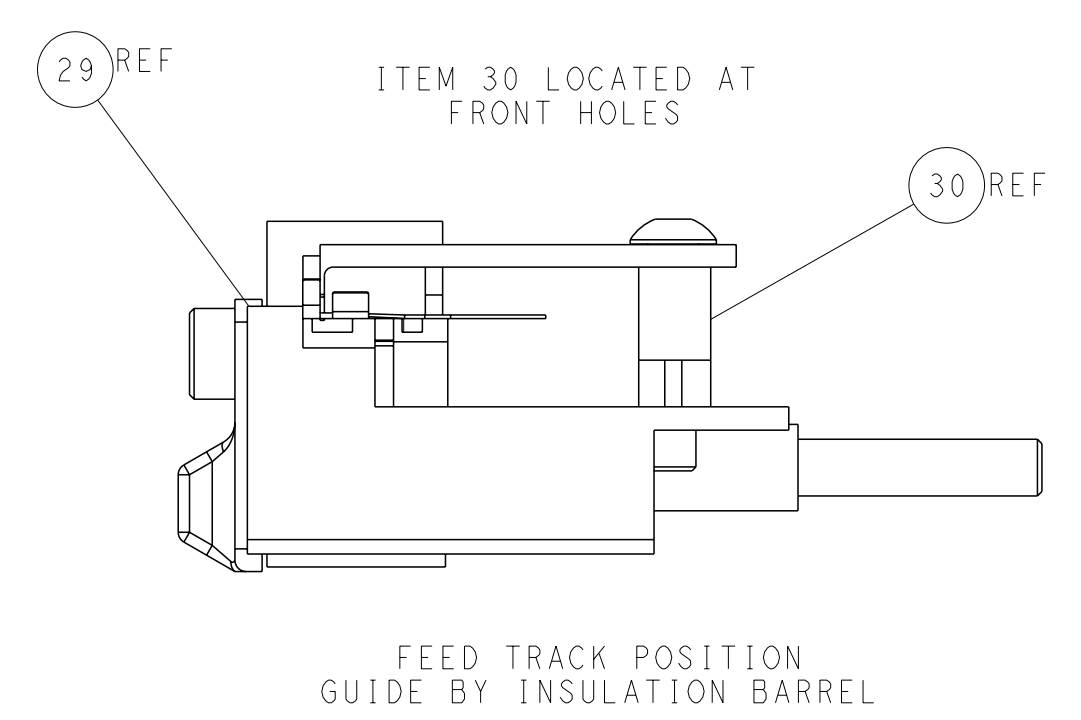
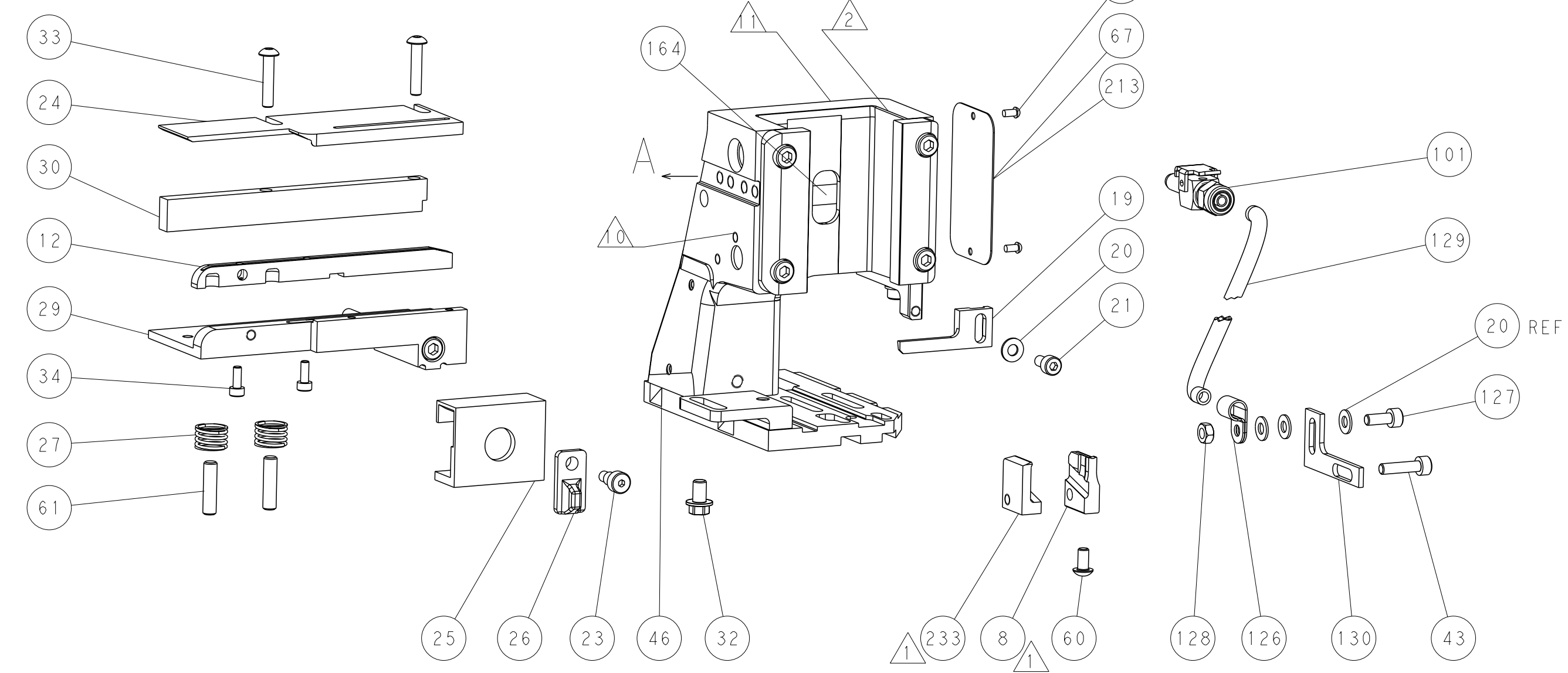
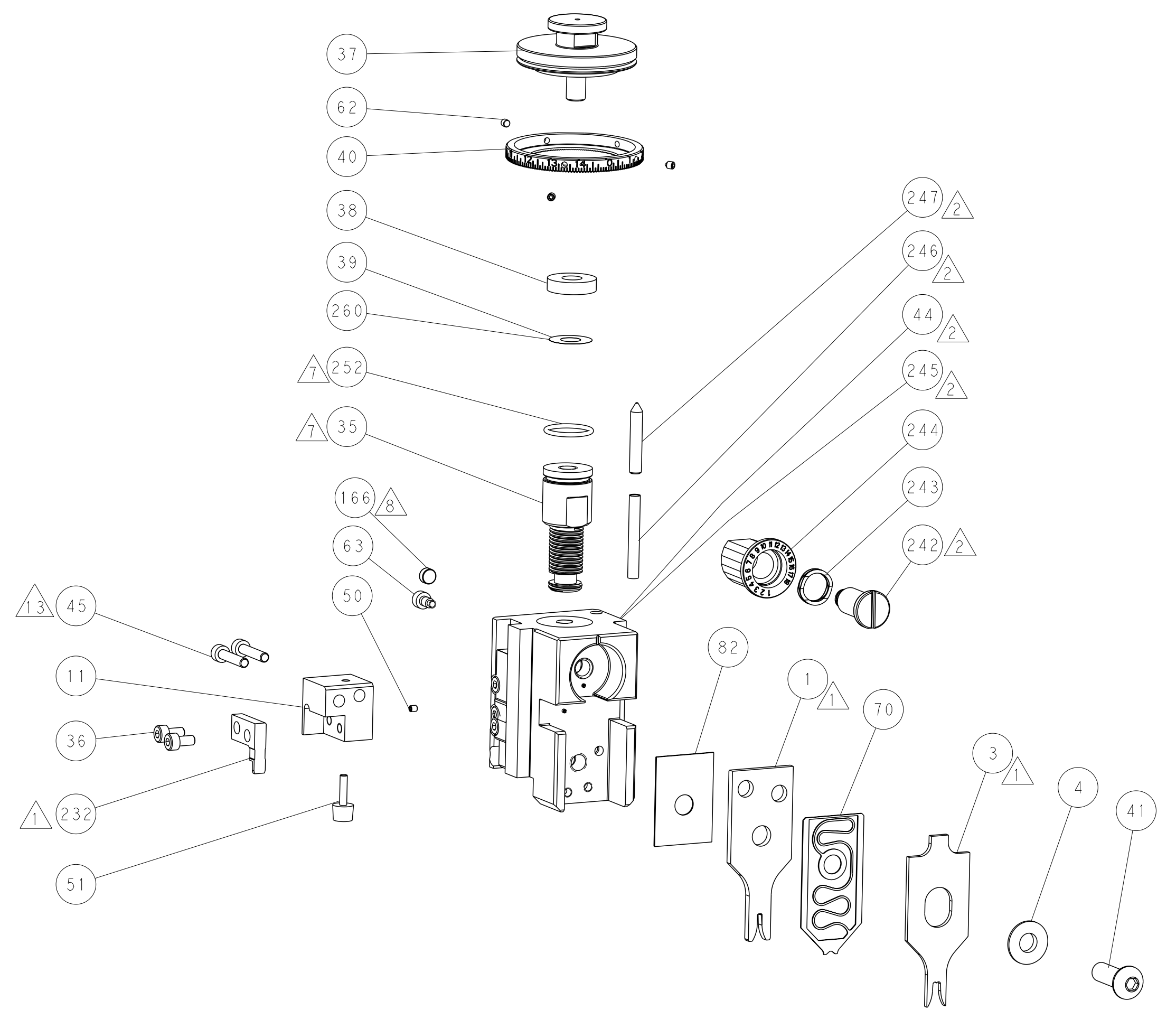
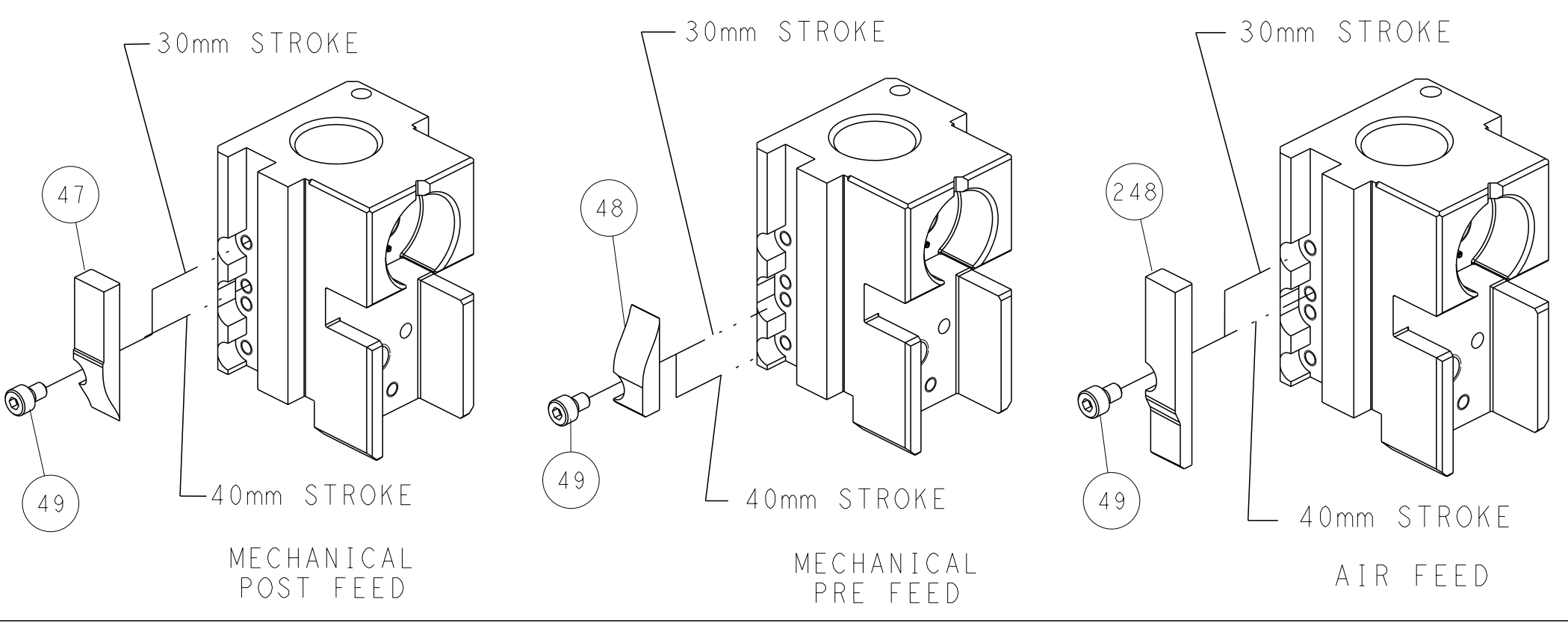
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS

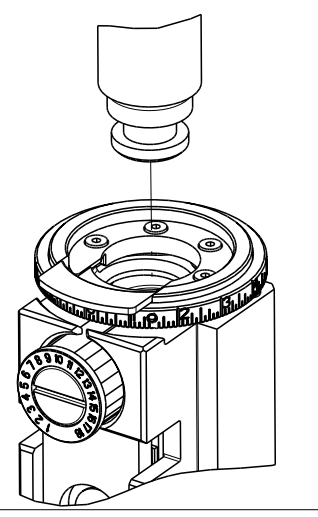


**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. MOYER 25APR2012		TE Connectivity	
mm	9 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.02	4 PLC ±0.005	5 PLC ±0.005	Harrisburg, PA 17105-3608
	ANGLES	FINISH		CHK T. ELBIN 25APR2012		NAME	
				APVD T. ELBIN 25APR2012		Ocean Side Feed Applicator	
MATERIAL		WEIGHT		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
				A11	00779	C=2151622	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE	1:1	SHEET 2 OF 4	REV A

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009

Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.



DIMENSIONS AND TOLERANCING PER ASME Y14.5M-2018

APPLICATOR DATA table with columns: CRIMP, WIRE, INSUL, APPLICATOR INSTRUCTIONS.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Includes terminal names, wire strip length, insulation diameter range, and terminal application specifications.

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



- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

\*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. List of spare parts including various assemblies and components.

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

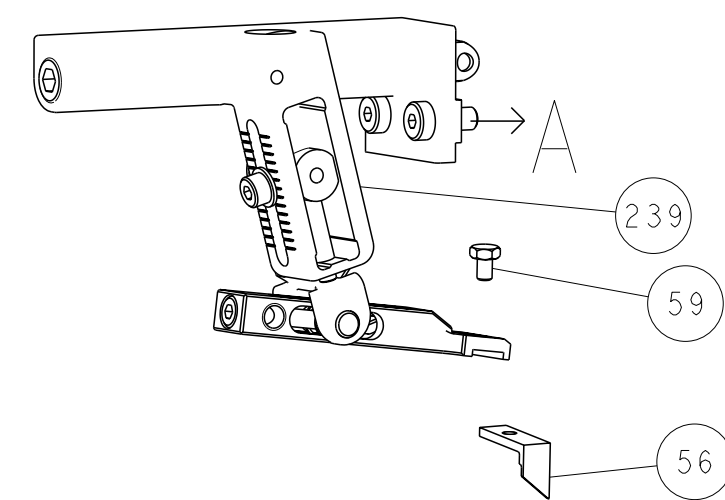
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Product information table including dimensions, tolerances, material, and customer accessible production drawing.

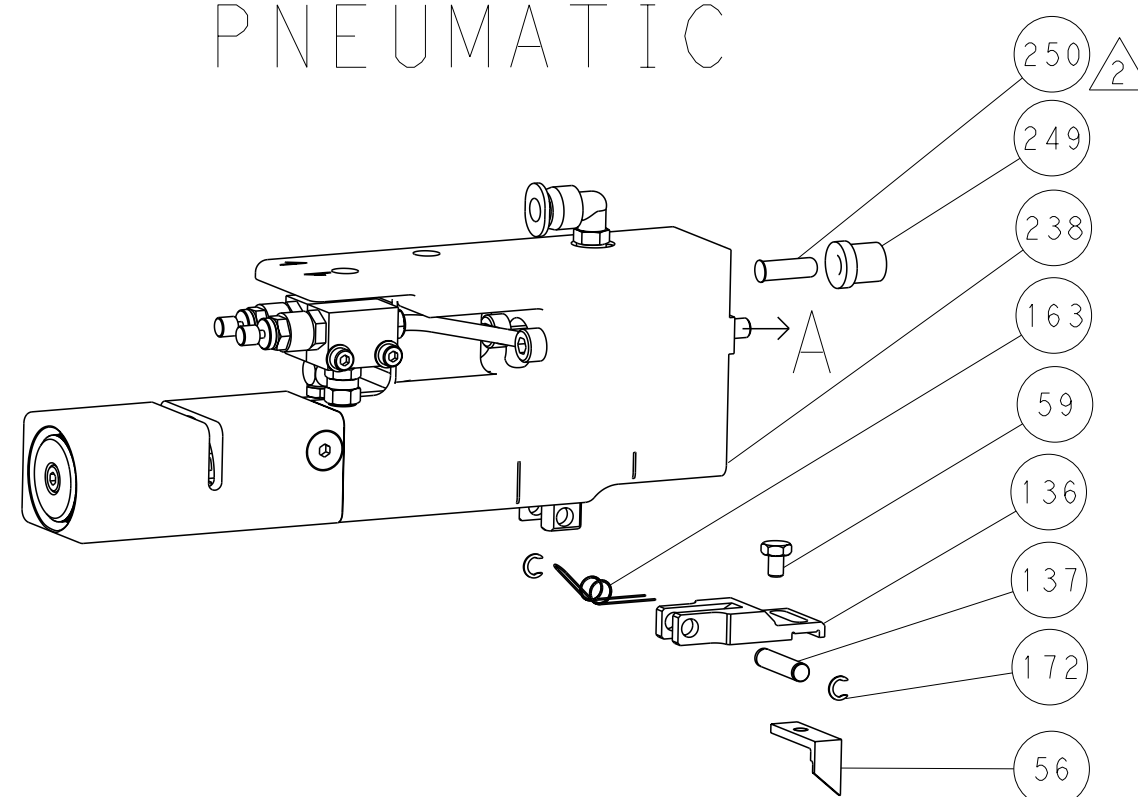
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
				SEE SHEET 1			

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009

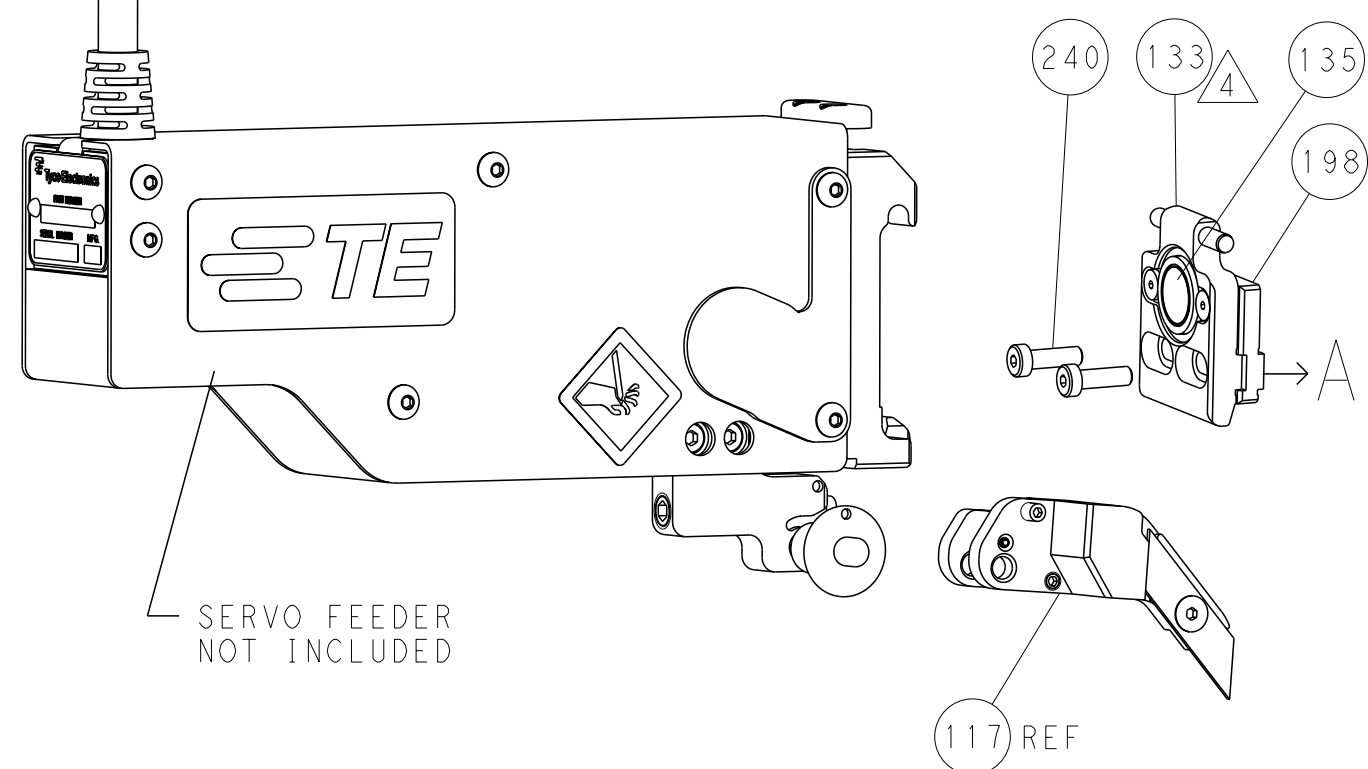
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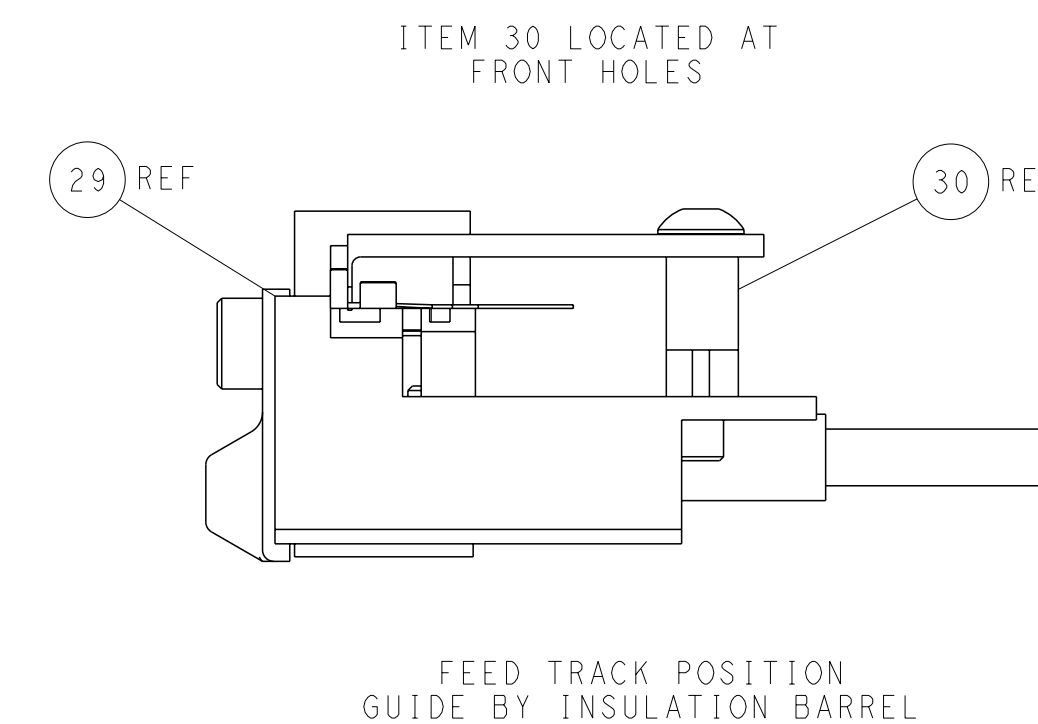
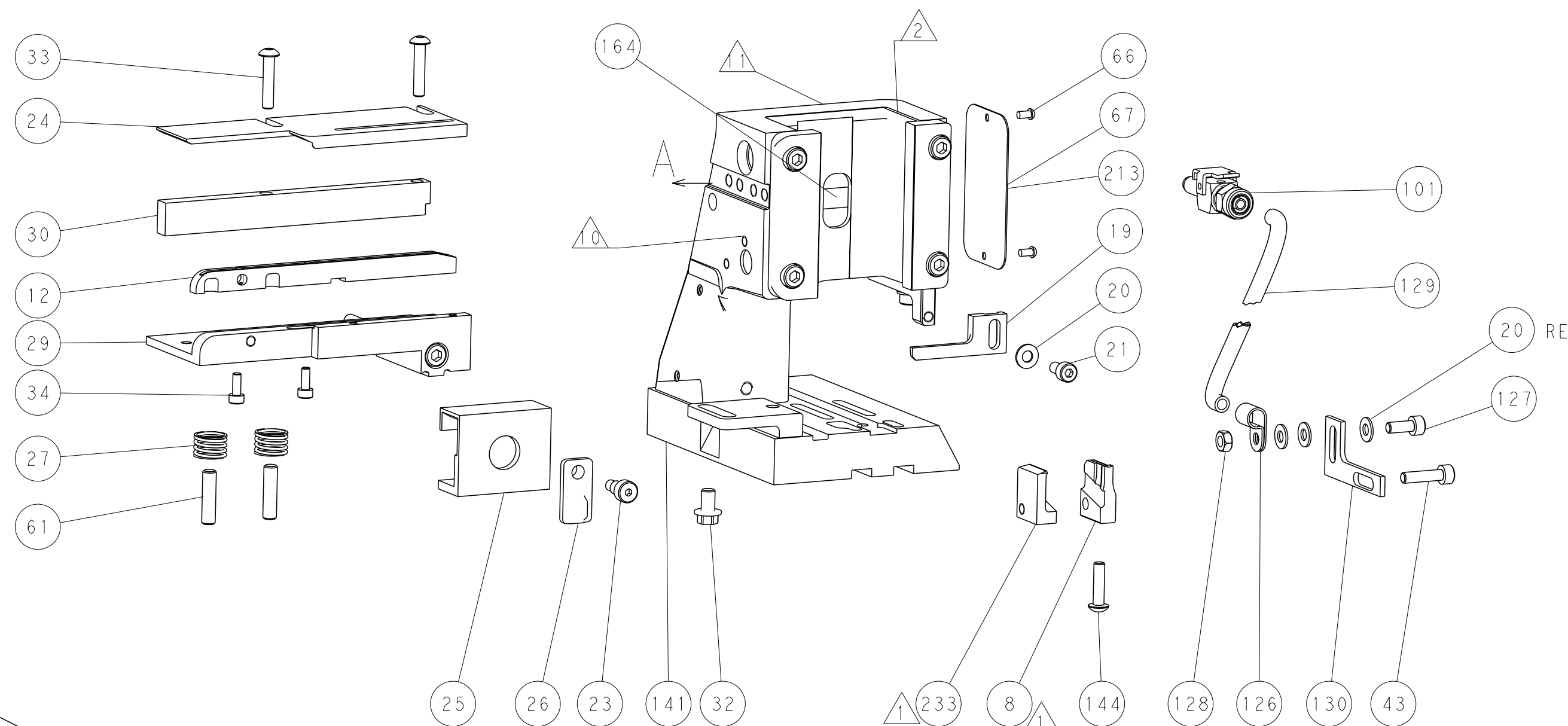
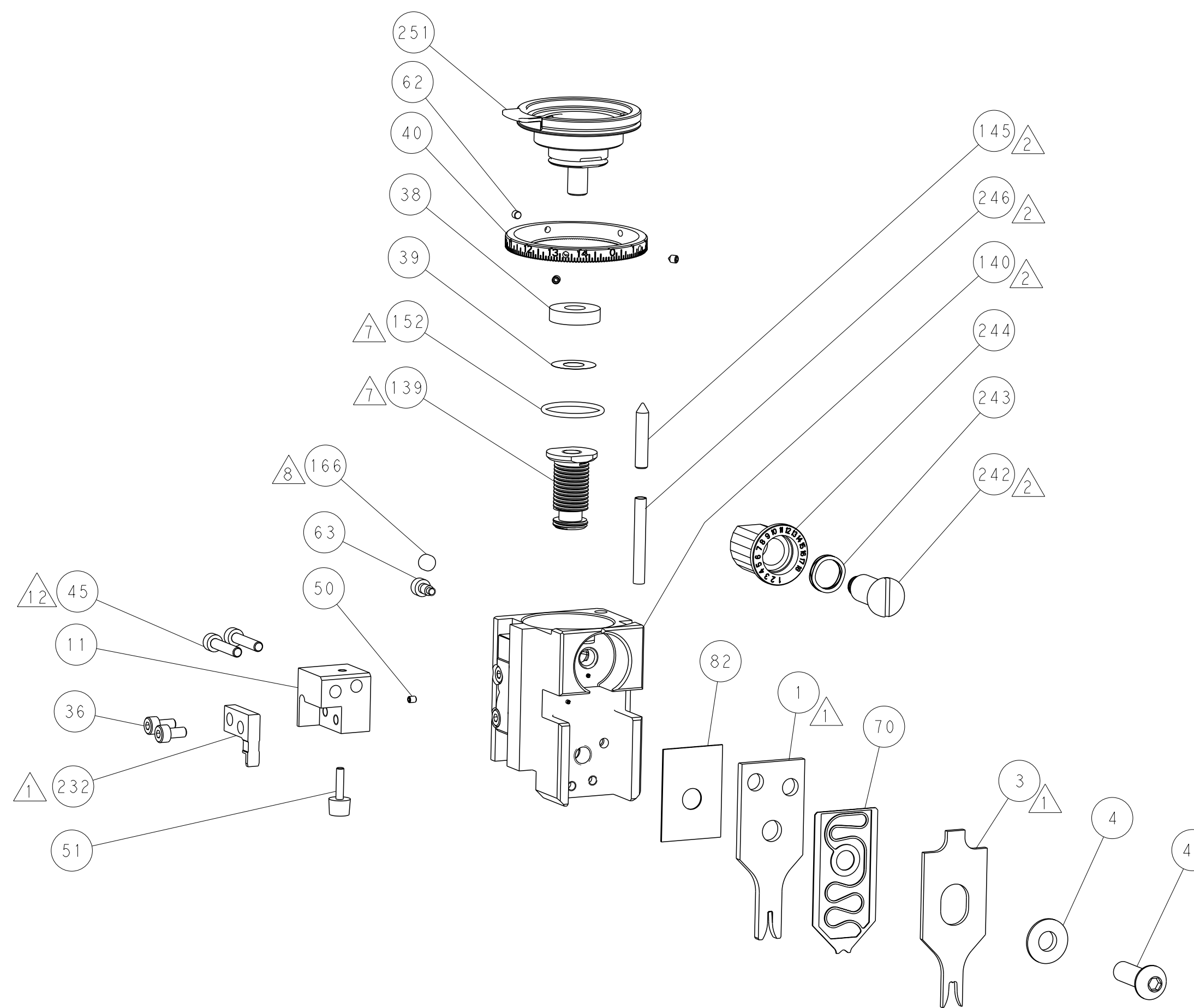
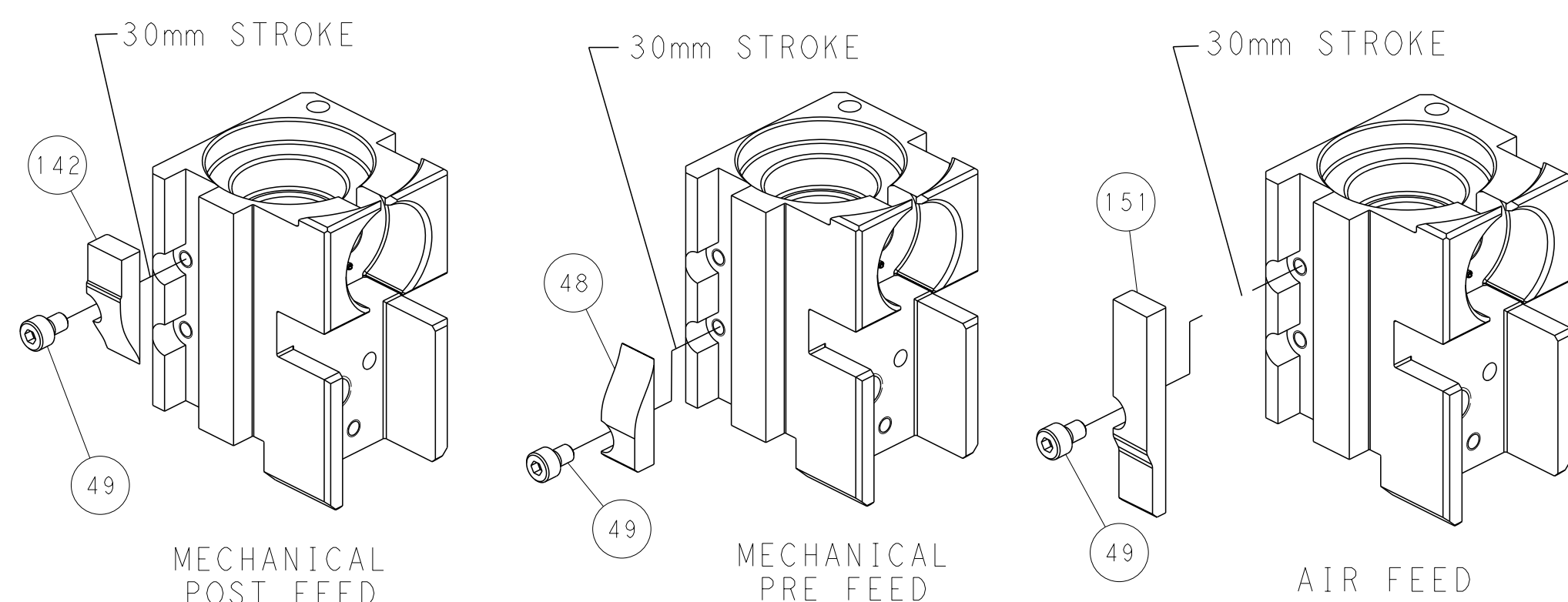
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



**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 C. MOYER 25APR2012		TE Connectivity	
mm		9 PLC ±0.1		CHK T. ELBIN 25APR2012		Harrisburg, PA 17105-3608	
		1 PLC ±0.02		APVD T. ELBIN 25APR2012		NAME Ocean Side Feed	
		3 PLC ±0.005		PRODUCT SPEC		Applicator	
		4 PLC ±0.005		APPLICATION SPEC		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		A 00779 C-2151622	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE 1:1		SHEET 4 OF 4 REV A	