

| 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 |
| | 2151246-1 | B | FINE CRIMP HEIGHT ADJUST | MECHANICAL | SERVO LATCH PLATE | 2119951-1 | - | 8-2151246-5 | 1901094-3 | 1-1752354-2 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151246-4 | - | - | - |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - |
| 2151246-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | - | 8-2151246-5 | 1901094-3 | 1-1752354-2 | 2168400-6 (QUANTITY 2) | |
| | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151246-4 | - | - | - | |
| | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | |
| 2151246-5 | B | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | |
| | | | | - | - | - | - | - | - | - | |
| | | | | - | - | - | - | - | - | - | |
| 2151246-6 | B | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | - | - | - | - | - | - | - | |
| | | | | - | - | - | - | - | - | - | |
| | | | | - | - | - | - | - | - | - | |
| 2151246-7 | B | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| | | | | - | - | - | - | - | - | - | |
| 7-2151246-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.22 mm [.048] | F |
| INSUL | 1.57 mm [.062] | F |

APPLICATOR INSTRUCTIONS 408-10389

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---|-------------|-----------------------------|-------------|
| TERMINAL NAME: LOW PROFILE MINI AMP IN TERMINAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 2.80-3.20 mm [.110-.126 IN] | | 1.40-1.50 mm [.055-.059 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-5062-1 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 172782-5 | 172782-7 | 172782-9 | 1-172782-2 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------|----------------------------|--------------------------------|
| 22 AWG OR 0.30mm2 | 0.85+/-0.05 [.033+/-0.002] | 7.9 |
| 24 AWG OR 0.20mm2 | 0.77+/-0.05 [.030+/-0.002] | 8.9 |
| 26 AWG OR 0.13mm2 | 0.72+/-0.05 [.028+/-0.002] | 9.3 |

- 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: 8-2151246-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151246-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151246-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151246-6
- 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 62 & 180. 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 ITEM 37 & 180.
- 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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.95.

***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 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |
|-----|----|----|----|----|----|-----------|-------------------------------------|---------|
| - | - | 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 | 2119082-8 | 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 |

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

| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|---------------|-----------|-------|
| 2119599-1 | A | 66 | | | | |
| | | | 1 | DEVELOPMENT | 06SEP2013 | XZ XZ |
| | | | A | RELEASED | 30SEP2013 | BH TE |
| | | | B | ECR-16-008583 | 14JUN2016 | YY TE |

| | | | | | | | | | |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----------------------------------|----|
| - | - | 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 | 1-1752354-2 | STANDOFF, HOLD-DOWN | 180 | |
| - | 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 | 1-690438-0 | FRONT STRIP GUIDE | 96 | |
| - | 2 | 2 | 2 | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 95 | |
| - | 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 | 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 | 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 | 1-1901681-8 | HOLDDOWN, TERMINAL | 51 | |
| - | - | - | - | - | 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 | 1-1752356-9 | 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 | 2119959-3 | ASSEMBLY, STRIP GUIDE | 29 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 | |
| - | 2 | 2 | 2 | 2 | 2 | 22283-1 | SPRING, COMPRESSION | 27 | |
| - | 1 | 1 | 1 | 1 | 1 | 356835-1 | LEVER, DRAG RELEASE | 26 | |
| - | 1 | 1 | 1 | 1 | 1 | 240792-5 | DRAG, TERMINAL | 25 | |
| - | 1 | 1 | 1 | 1 | 1 | 1320928-2 | 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 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 | |
| - | 1 | 1 | 1 | 1 | 1 | 2119533-3 | 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 | 1803095-1 | FLOATING SHEAR, FRONT | 9 | |
| - | 1 | 1 | 1 | 1 | 1 | 4-1333225-3 | ANVIL, COMBINATION | 8 | |
| - | - | - | - | - | - | - | - | 7 | |
| - | - | - | - | - | - | - | - | 6 | |
| - | 1 | 1 | 1 | 1 | 1 | 2119757-5 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-238011-3 | BLOCK, CRIMPER SPACER | 4 | |
| - | 1 | 1 | 1 | 1 | 1 | 4-1633961-0 | CRIMPER, INSULATION F PREMIUM | 3 | |
| - | - | - | - | - | - | - | - | 2 | |
| - | 1 | 1 | 1 | 1 | 1 | 568176-5 | CRIMPER, WIRE | 1 | |

| DIMENSIONS: | | | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | | |
|-------------|--------|---|--|--|---|--|--|
| mm | 0 PLC | ± | | 1 PLC | ± | | |
| | 2 PLC | ± | | 3 PLC | ± | | |
| | 4 PLC | ± | | 5 PLC | ± | | |
| | ANGLES | ± | | FINISH | ± | | |

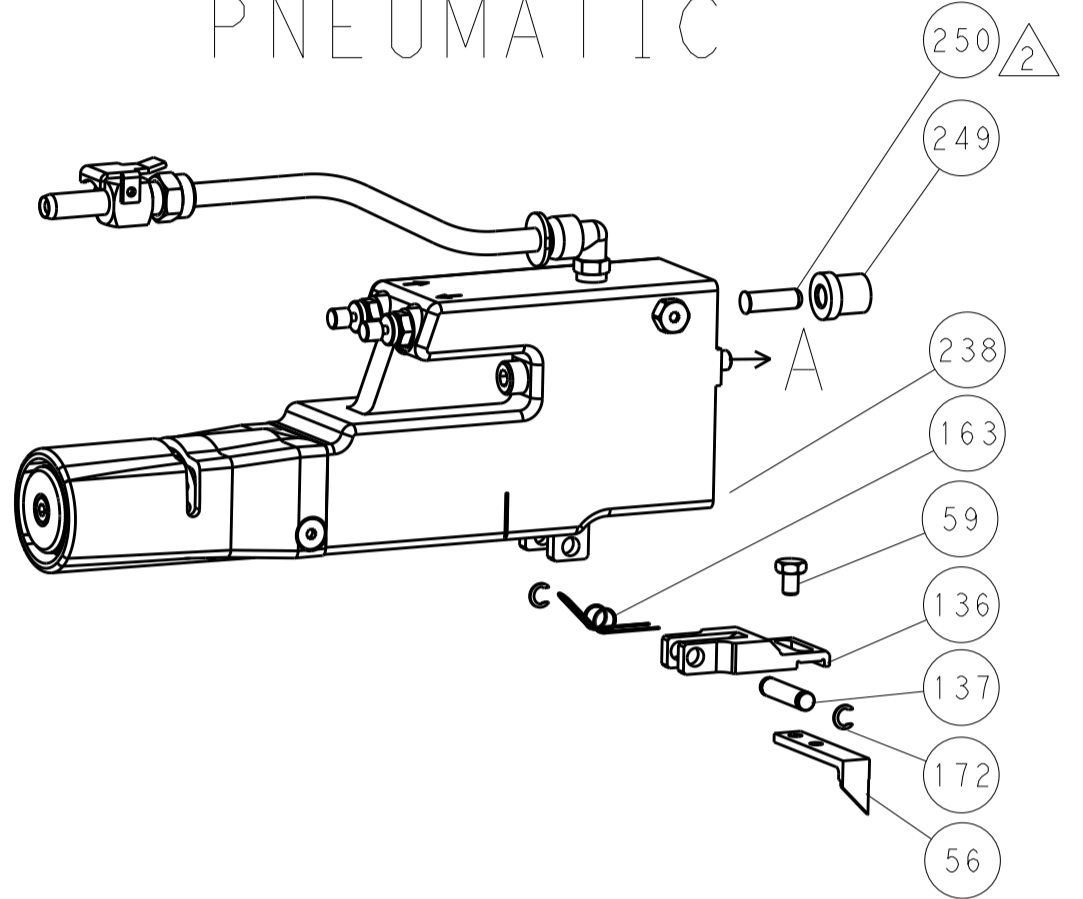
| | | | |
|--|-----------|----------------------------|---------------|
| OWNER | DATE | DESIGN | DATE |
| J. ZHAO | 06SEP2013 | T. ELBIN | 06SEP2013 |
| APVD | DATE | NAME | |
| L. ZHANG | 06SEP2013 | Ocean Side Feed Applicator | |
| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| A1 | 00779 | C=2151246 | - |
| Customer Accessible Production Drawing | | | |
| SCALE | SHEET | OF | REV |
| 1:2 | 1 | 4 | B |

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

FEED TYPE MECHANICAL



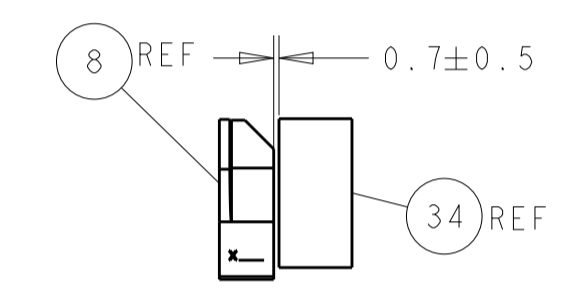
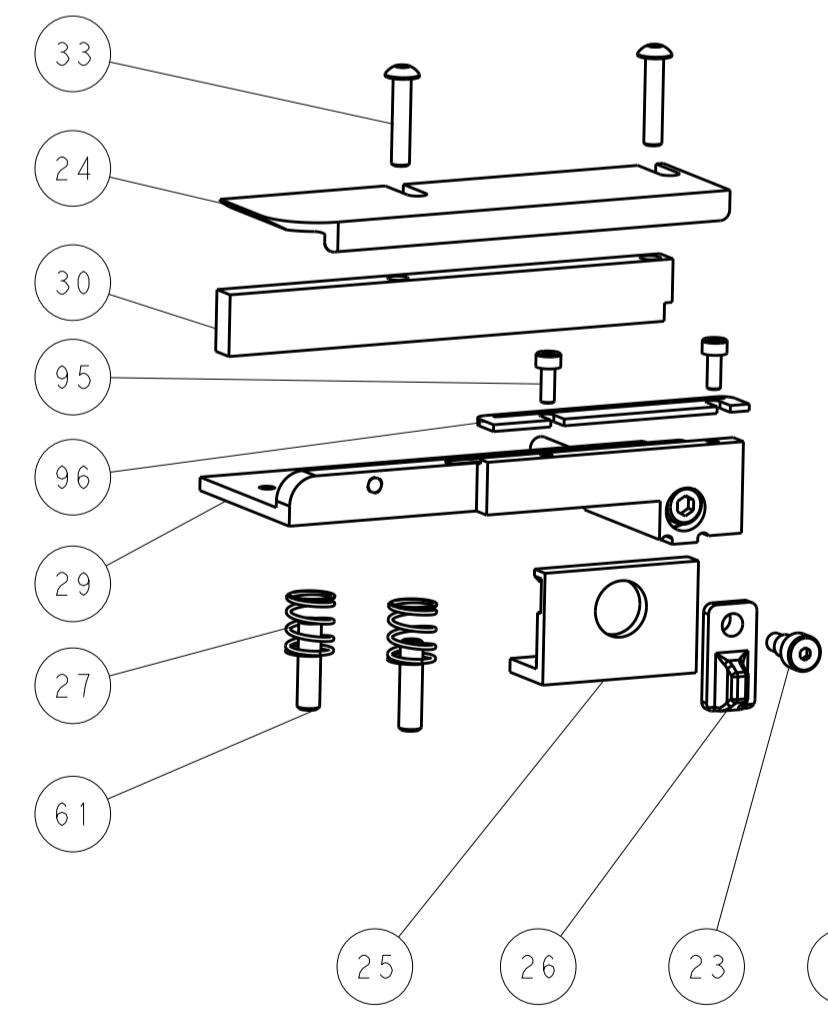
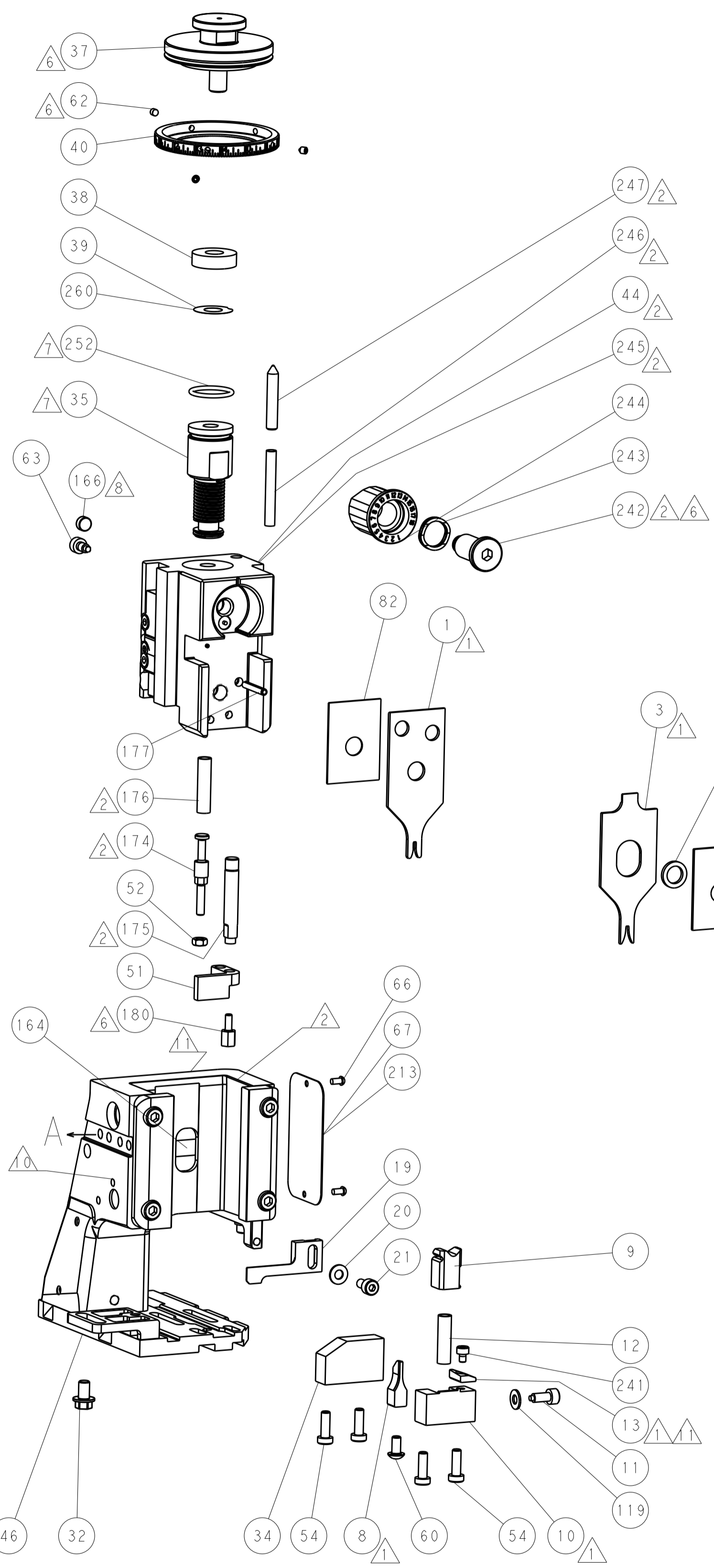
PNEUMATIC



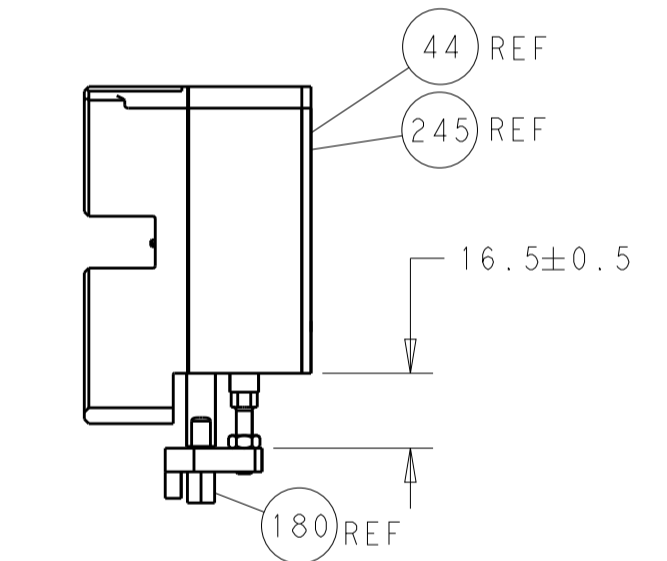
SERVO LATCH PLATE



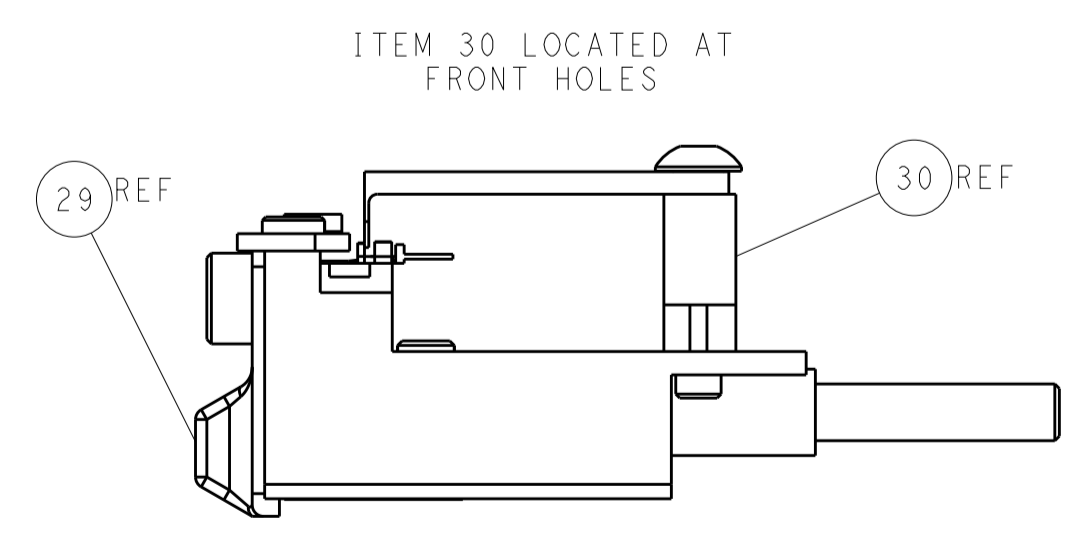
CAM POSITIONS



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: | | DWN X ZHAO 06SEP2013 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | Harrisburg, PA 17105-3608 | |
| MATERIAL: | | FINISH: | | APVD L ZHANG 06SEP2013 | | NAME Ocean Side Feed Applicator | |
| | | | | PRODUCT SPEC | | SIZE CAGE CODE DRAWING NO | |
| | | | | APPLICATION SPEC | | RESTRICTED TO | |
| | | | | WEIGHT | | A1 00779 ©=2151246 | |
| | | | | Customer Accessible Production Drawing | | SCALE 1:2 SHEET 2 OF 4 REV B | |

| PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | | |
|-------------|-------------|-------------|--------------------------|-----------------------------------|-----------------------|-----------|-----------|-------------|-----------|-------------|------------------------|
| | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | | |
| | 2-2151246-1 | B | 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 | - | 8-2151246-5 | 1901094-3 | 1-1752354-2 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151246-4 | - | - | - |
| | 2-2151246-2 | B | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151246-5 | 1901094-3 | 1-1752354-2 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151246-4 | - | - | - |
| | 2-2151246-5 | B | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE Δ 4 | 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 |
| | 2-2151246-7 | B | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2151246-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|-----------------------------------|------------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.22 mm [.048] | F |
| INSUL | 1.57 mm [.062] | F |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---|-------------|---|-------------|
| TERMINAL NAME: LOW PROFILE MINI AMP IN TERMINAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 2.80-3.20 mm [.110-.126 IN] | | \varnothing 1.40-1.50 mm [.055-.059 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-5062-1 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 172782-5 | 172782-7 | 172782-9 | 1-172782-2 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING Δ 9 |
|-------------------------------|---------------------------------|---|
| 22 AWG OR 0.30mm ² | 0.85 +/- 0.05 [.033 +/- .002] | 7.9 |
| 24 AWG OR 0.20mm ² | 0.77 +/- 0.05 [.030 +/- .002] | 8.9 |
| 26 AWG OR 0.13mm ² | 0.72 +/- 0.05 [.028 +/- .002] | 9.3 |

- Δ RECOMMENDED SPARE PARTS
- Δ GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- Δ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151246-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151246-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151246-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- Δ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62 & 180. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- Δ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- Δ MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- Δ 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.
- Δ SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- Δ 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.

| ITEM NO | DESCRIPTION | ITEM NO |
|---------|-------------------------------------|---------|
| 251 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| 250 | PUSH ROD, AIR FEED | 250 |
| 249 | BUSHING, LCH5-12, MISUMI | 249 |
| 246 | SPRING, COMPRESSION | 246 |
| 244 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| 243 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| 242 | RETAINER, INSULATION DIAL | 242 |
| 241 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| 240 | SHCS, LOW HEAD, RoHS, M5 X 16 | 240 |
| 239 | MECHANICAL FEED ASSEMBLY | 239 |
| 238 | AIR FEED MODULE | 238 |
| ITEM NO | DESCRIPTION | ITEM NO |
| -77 | -27 | -25 |
| -22 | -21 | PART NO |

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

| REV | DATE | BY | DESCRIPTION |
|-----|------|----|-------------|
| - | - | - | SEE SHEET 1 |

| REV | DATE | BY | DESCRIPTION | ITEM NO | |
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| ITEM NO | DESCRIPTION | ITEM NO | | | |
| -77 | -27 | -25 | | | |
| -22 | -21 | PART NO | | | |

| | | | | | | |
|----------------|--|--|--|----------------------------------|-------------------------|------------------------|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | APV: X ZHANG 06SEP2013 | CHK: T. ELBIN 06SEP2013 | OWN: J. ZHAO 06SEP2013 |
| | | 0 PLC ± | | NAME: Ocean Side Feed Applicator | | |
| | | 1 PLC ± | | SIZE: A1 | | |
| | | 2 PLC ± | | CAGE CODE: 00779 | | |
| | | 3 PLC ± | | DRAWING NO: C=2151246 | | |
| | | 4 PLC ± | | SCALE: 1:2 | | |
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| | | FINISH | | REV B | | |

Customer Accessible Production Drawing

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

FEED TYPE MECHANICAL



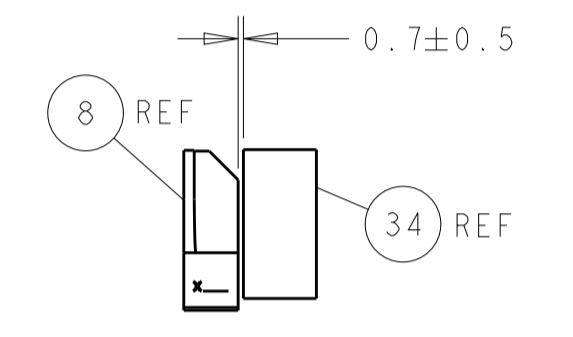
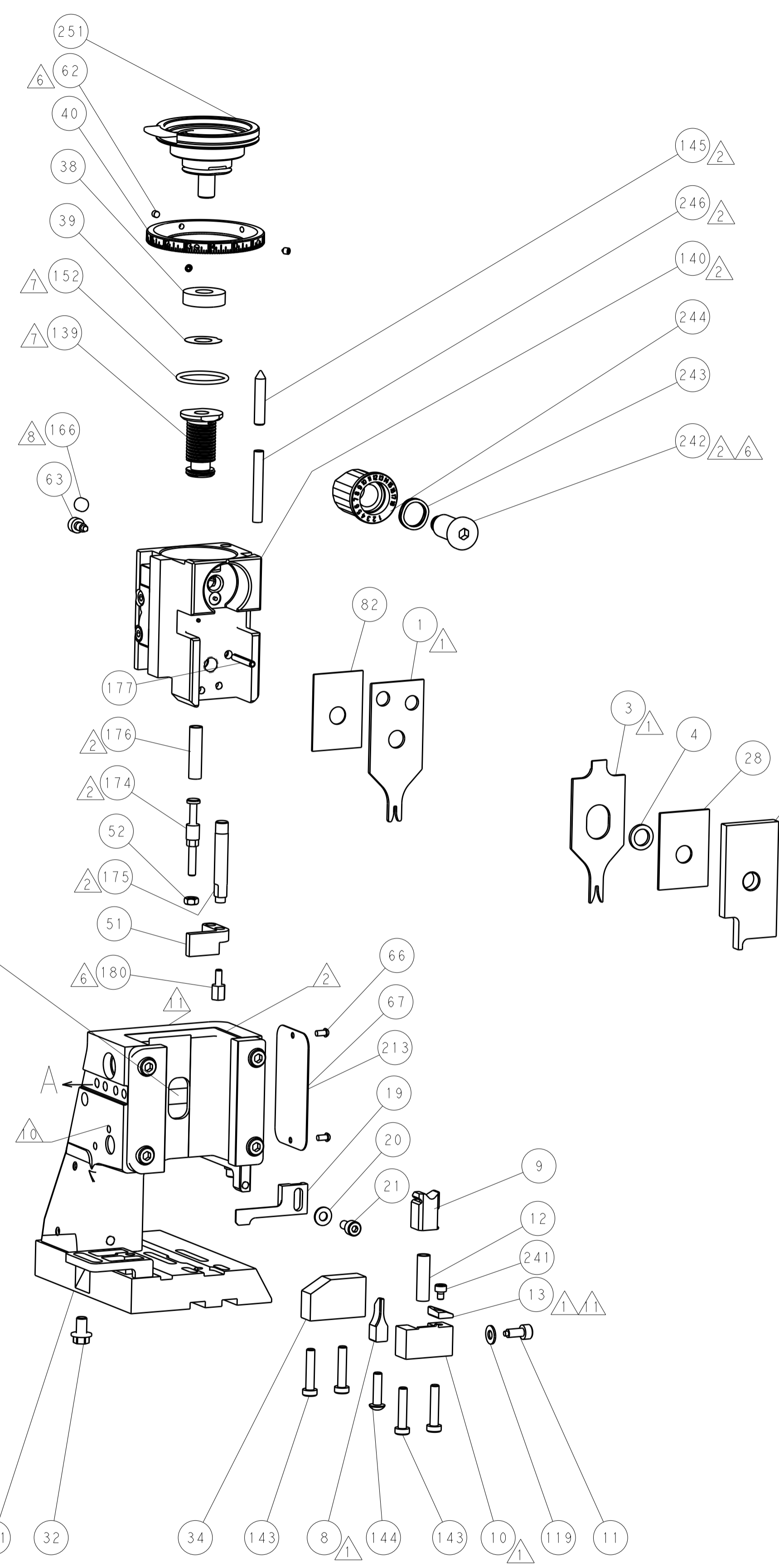
PNEUMATIC



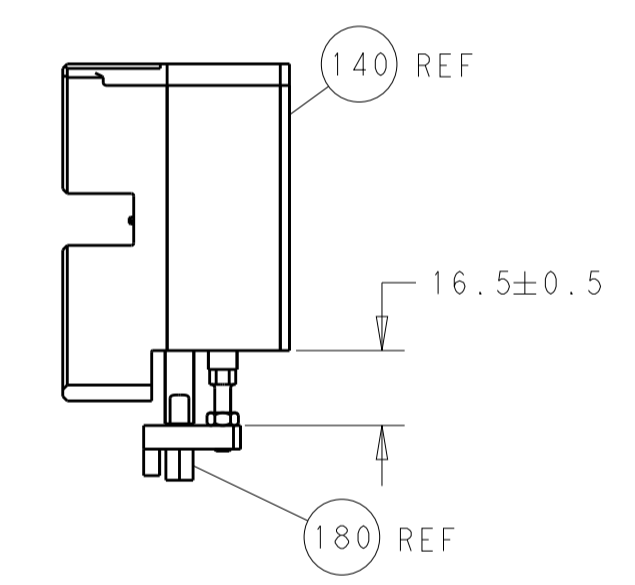
SERVO LATCH PLATE



CAM POSITIONS

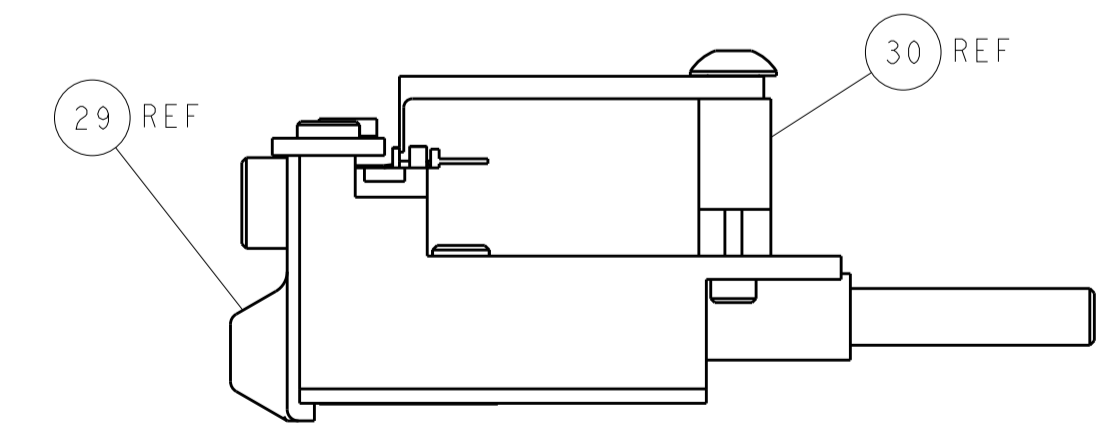


TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP

ITEM 30 LOCATED AT FRONT HOLES



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: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN X ZHAO 06SEP2013 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | CHK T. ELBIN 06SEP2013 | | NAME | |
| | | | | APVD L. ZHANG 06SEP2013 | | Ocean Side Feed Applicator | |
| | | | | PRODUCT SPEC | | SIZE CAGE CODE DRAWING NO | |
| | | | | APPLICATION SPEC | | A1 00779 C=2151246 | |
| | | | | WEIGHT | | RESTRICTED TO | |
| | | | | Customer Accessible Production Drawing | | SCALE 1:2 SHEET 4 OF 4 REV B | |