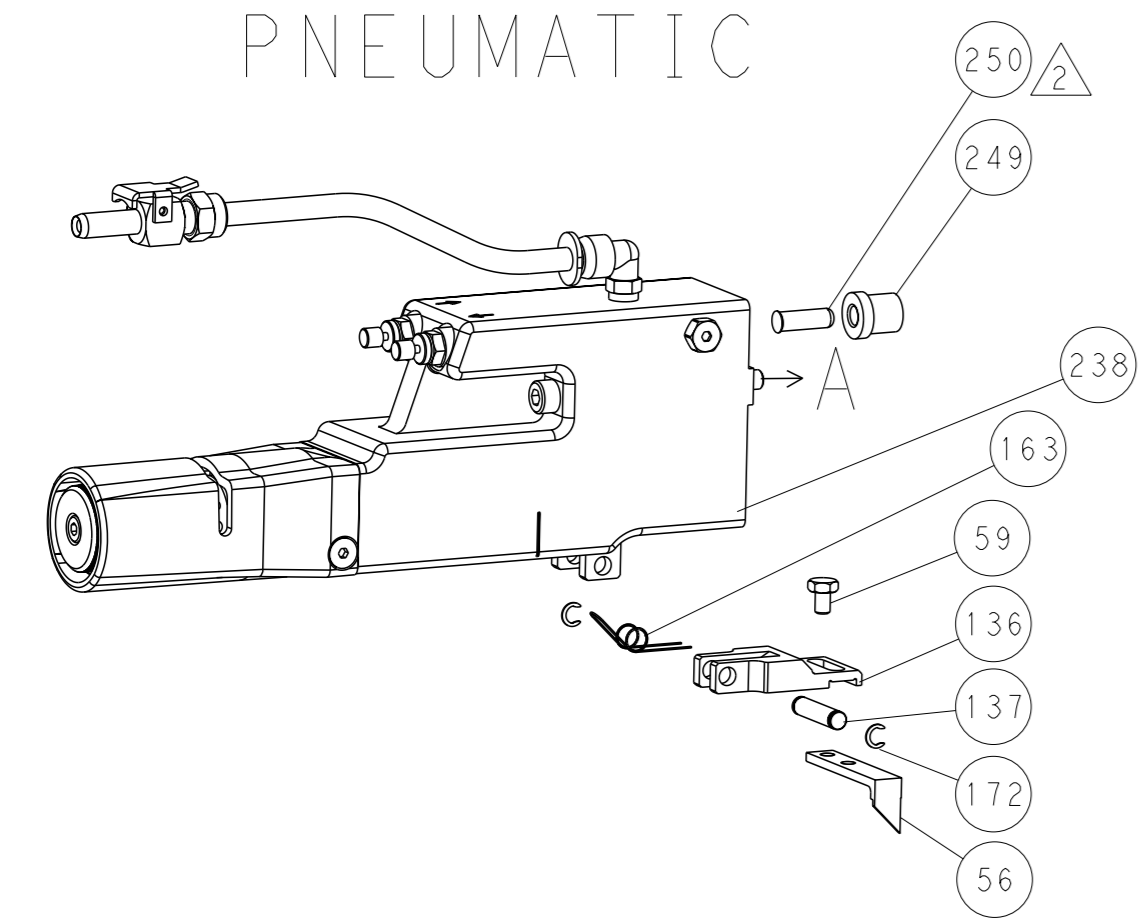


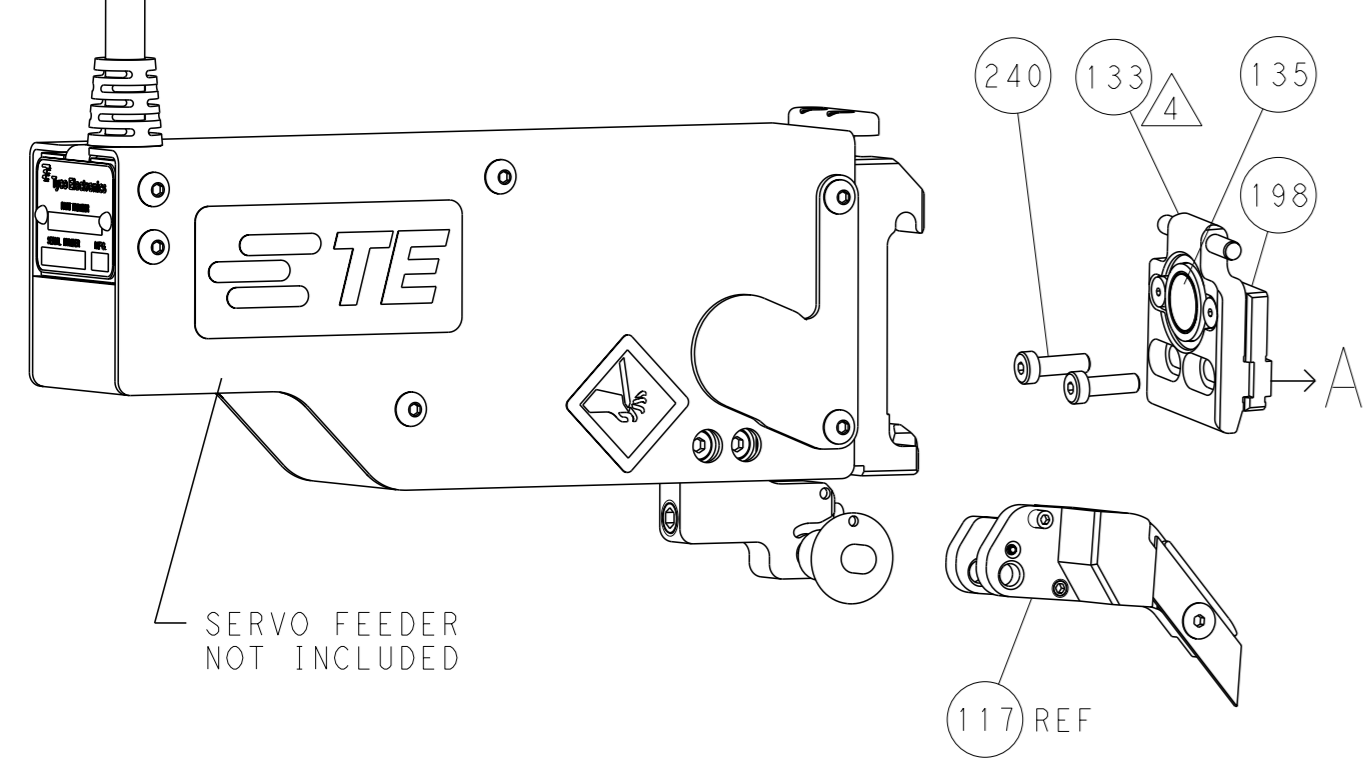
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|-----|------|-------------|------|-----|------|
| A | 66 | REV | DATE | OWN | APVD |
| - | - | SEE SHEET 1 | - | - | - |

FEED TYPE

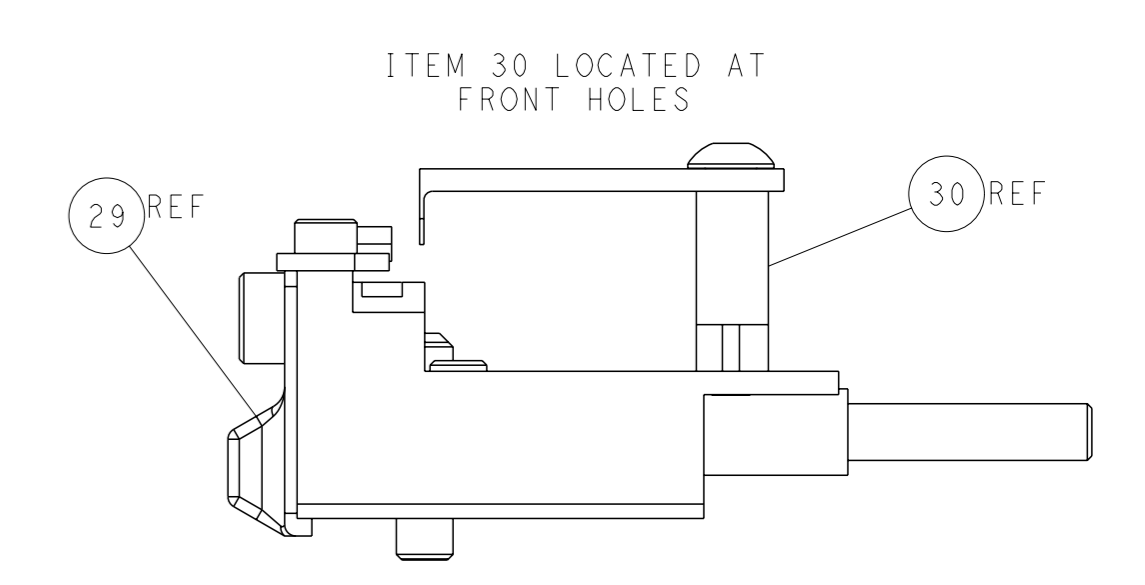
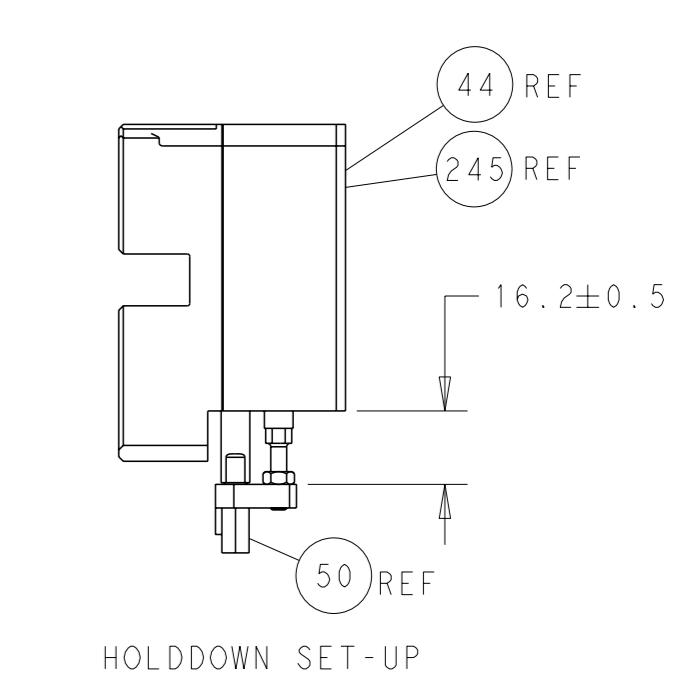
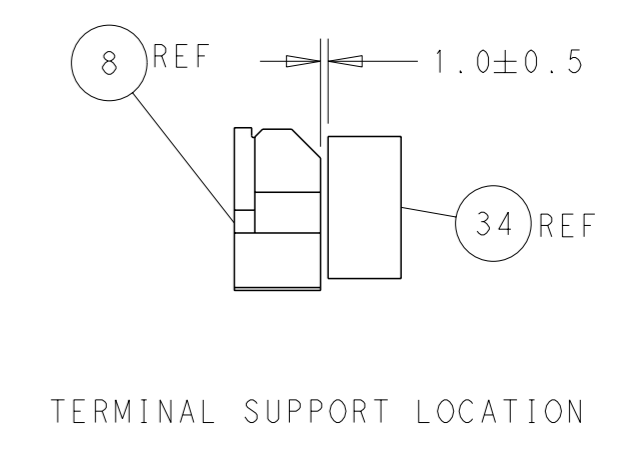
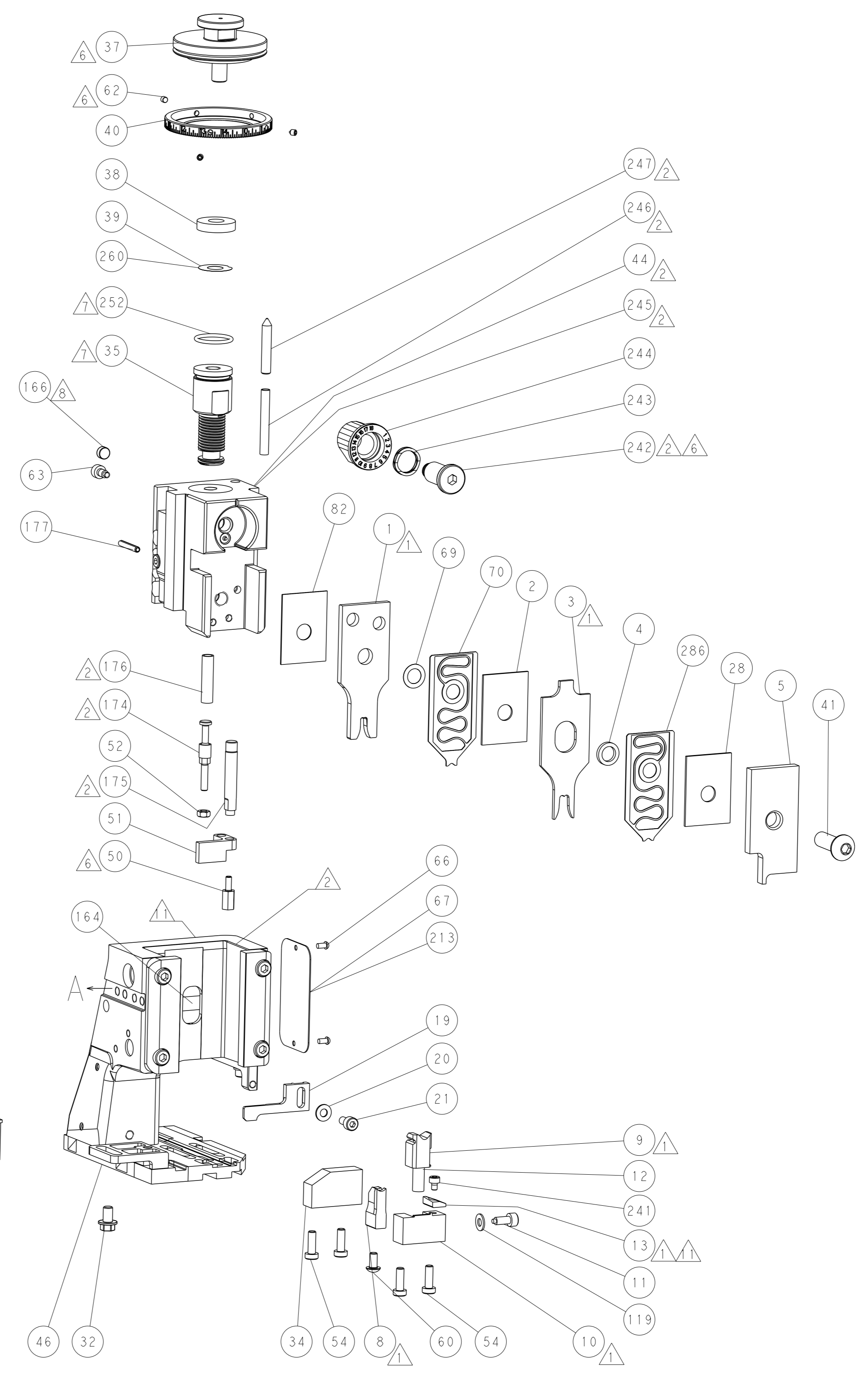
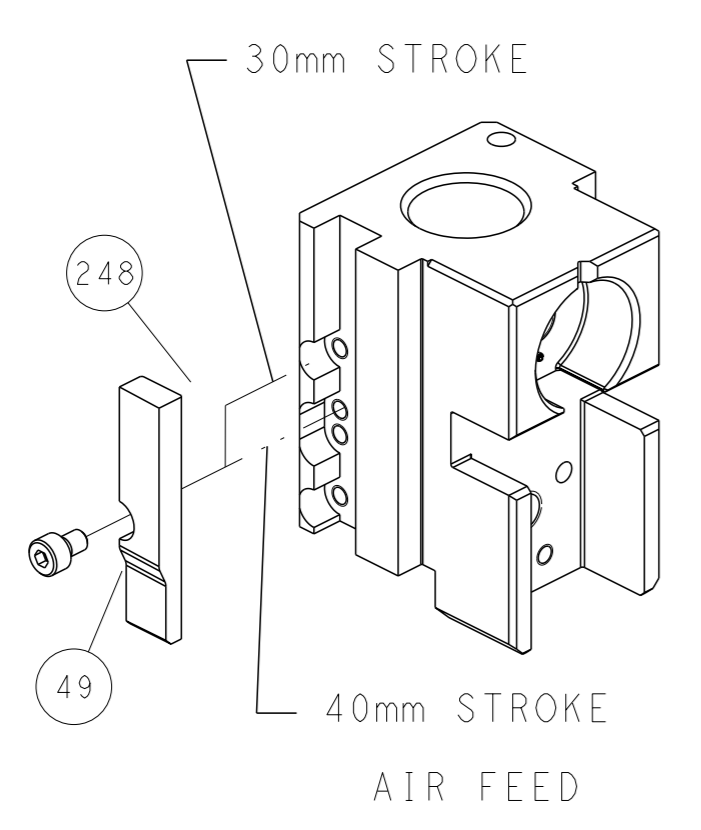
PNEUMATIC



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)

| | | | |
|--|--|---|--|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE AND THE CONTROLLER'S SIGNATURE SHOULD BE CONTACTED FOR THE LATEST REVISION.</small> | | DWN: C. CHEN 16 JUL 2012 CHK: S. XI 16 JUL 2012 APVD: J. CRUZ 16 JUL 2012 | 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: C=2151724 WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: C | RESTRICTED TO: |
| MATERIAL: - FINISH: - | | CUSTOMER ACCESSIBLE PRODUCTION DRAWING | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2151724-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SERVO LATCH PLATE | 2119951-1 | - | 8-2151724-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | 2-2151724-5 | C | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 |
| | 2-2151724-7 | C | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2151724-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 3.56 mm (.140) | F |
| INSUL | 5.59 mm (.220) | F |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|---|-------------|------------------------------|-------------|
| TERMINAL NAME: POSITIVE LOCK RECEPTACLE | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 5.00-6.00 mm (.197-.236 IN) | | Ø3.80-5.10 mm (.150-.201 IN) | |
| TERMINAL APPLICATION SPECIFICATION | 114-5032 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 170234-1 | 170234-2 | 170234-3 | 170234-4 |
| 170234-5 | 170234-6 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|--------------------------------|--------------------------------|
| 10 AWG | 2.52 +/- 0.05 [0.099 +/- .002] | 7.4 |
| 12 AWG | 2.10 +/- 0.05 [0.083 +/- .002] | 11.8 |

- 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: 8-2151724-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151724-5
- 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. 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12. 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.

| | | | | | | |
|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| - | 1 | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 286 |
| - | 1 | 1 | 1 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | - | - | 1 | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | 1 | 1803259-1 | BUSHING, FLANGED | 249 |
| -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)

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

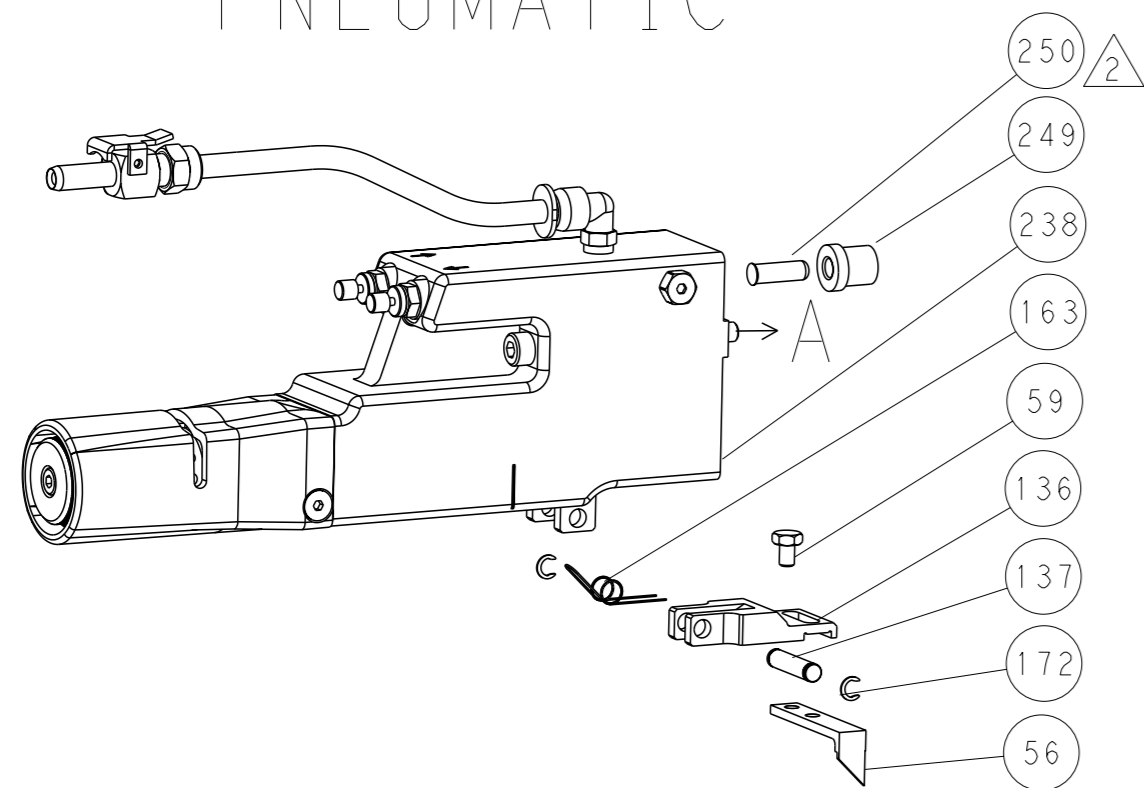
| | | | | | | |
|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | 1 | 1 | 1 | 2119082-9 | CAM, SMALL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 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 |
| - | 1 | 1 | 1 | 993111-1 | PIN, SLOTTED SPRING 3.0 X 20.0 | 177 |
| - | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 |
| - | 1 | 1 | 1 | 1752353-2 | GUIDE PIN, HOLDDOWN | 175 |
| - | 1 | 1 | 1 | 1901680-2 | GUIDE PIN, HOLDDOWN | 174 |
| - | - | - | 2 | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | 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 |
| - | 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 | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF | 141 |
| - | 1 | 1 | 1 | 2119650-1 | RAM, ASIAN STYLE, SIDE FEED | 140 |
| - | 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 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | REF | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | 117 |
| - | 1 | 1 | 1 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 |
| - | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 1 | 2119791-5 | DEPRESSOR, WIRE | 70 |
| - | 1 | 1 | 1 | 2119943-1 | WASHER, SPACER | 69 |
| - | 1 | - | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 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 | 992763-5 | SCR, SET, SOC, CONE PNT, M3 X 4.0 | 62 |
| - | - | - | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | - | - | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 |
| - | 1 | 1 | 1 | 1901681-9 | HOLDDOWN, TERMINAL | 51 |
| - | 1 | 1 | 1 | 2-1752354-4 | STANDOFF, HOLD-DOWN | 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 | 2119644-3 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1-1752356-8 | 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 | 2-1320908-2 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 2119959-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | 1 | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 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 | 2119533-1 | STRIPPER, SIDE FEED | 19 |
| - | 1 | 1 | 1 | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1 | 1 | 1-356885-4 | STOP, SHEAR | 11 |
| - | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1 | 1 | 1803095-3 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 1 | 1 | 1633926-1 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 2-238011-2 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 1 | 5-2119582-4 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 1 | 455888-9 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 1 | 456411-3 | CRIMPER, WIRE PREMIUM | 1 |
| -77 | -27 | -25 | -22 | PART NO | DESCRIPTION | ITEM NO |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DRAWN | | DATE | |
|--|---------|--|----------|----------------------------|-------------|------------|---------------|
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | C. CHEN | 16 JUL 2012 | C. CHEN | 16 JUL 2012 |
| | 3 PLC ± | 4 PLC ± | ANGLES ± | S. XI | 16 JUL 2012 | S. XI | 16 JUL 2012 |
| | FINISH | | | J. CRUZ | 16 JUL 2012 | J. CRUZ | 16 JUL 2012 |
| MATERIAL | | WEIGHT | | NAME | | | |
| | | | | Ocean Side Feed Applicator | | | |
| | | | | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
| | | | | A1 | 00779 | 2151724 | |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING | | | | SCALE | 1:2 | SHEET | 3 of 4 |

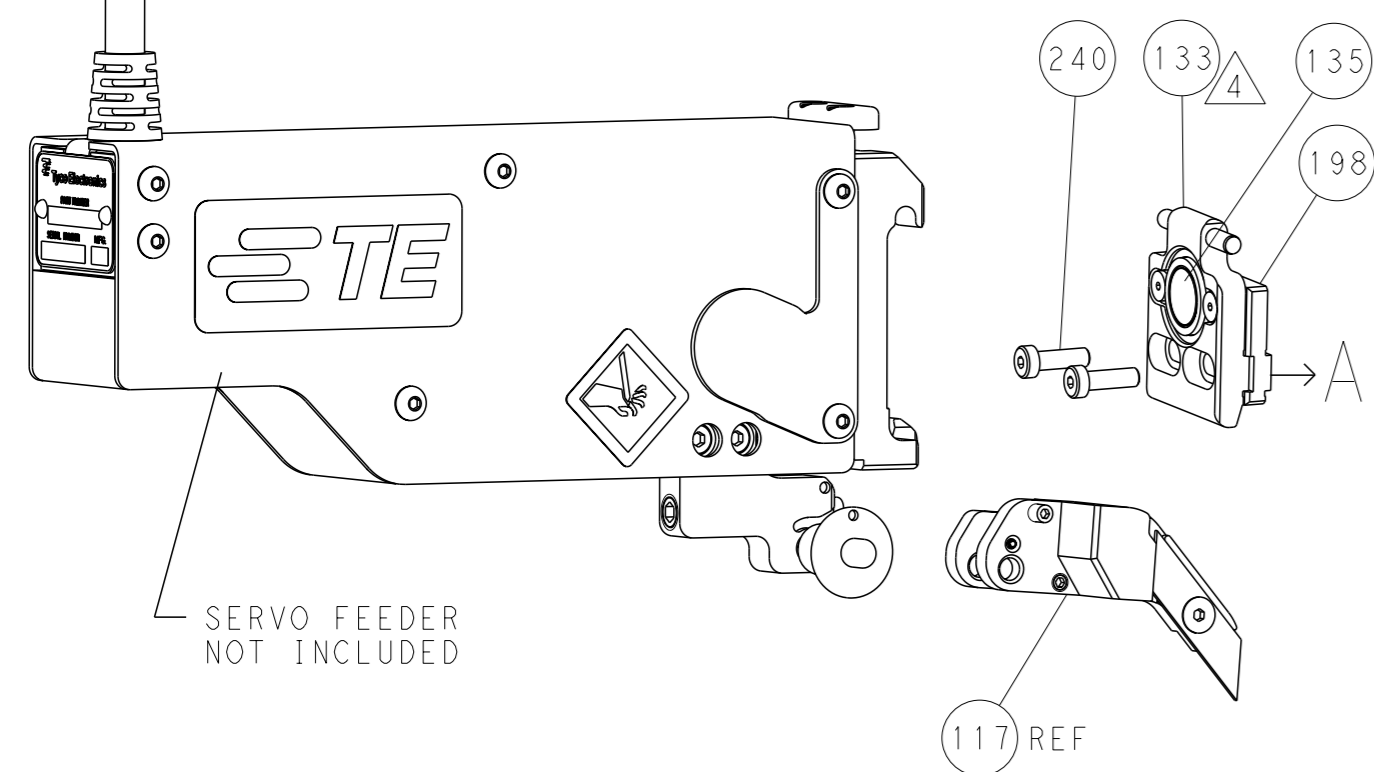
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|-----|-------------|-----------|------|-----|------|
| A | 66 | REV | DATE | OWN | APVD |
| - | SEE SHEET 1 | - | - | - | - |

FEED TYPE

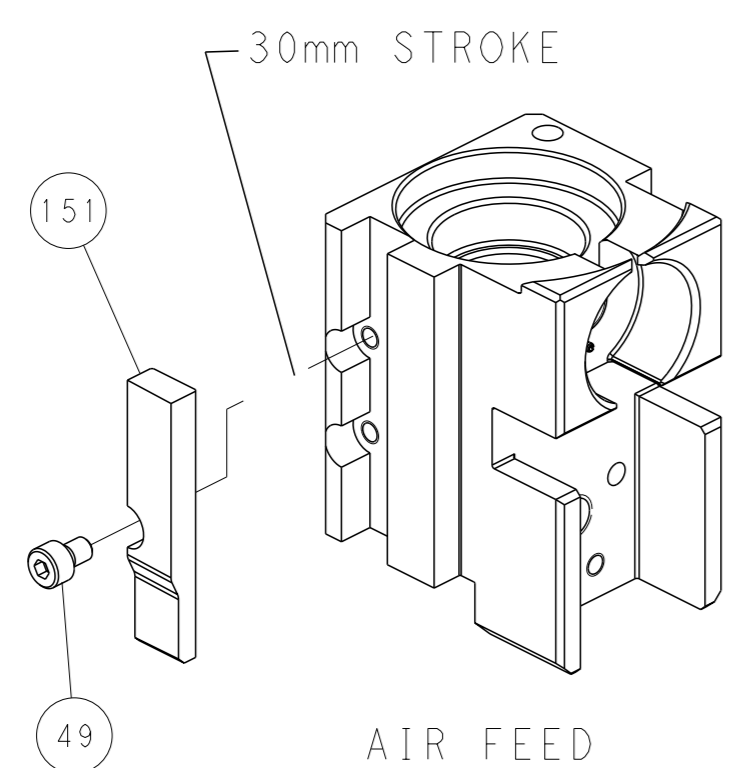
PNEUMATIC



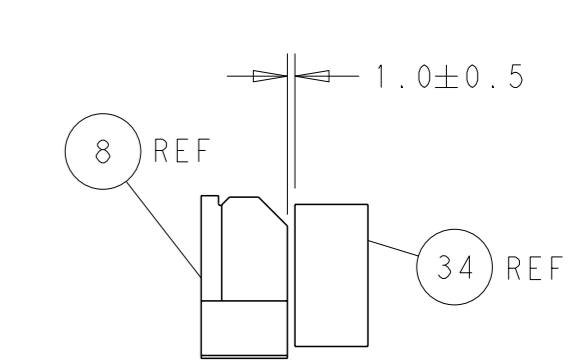
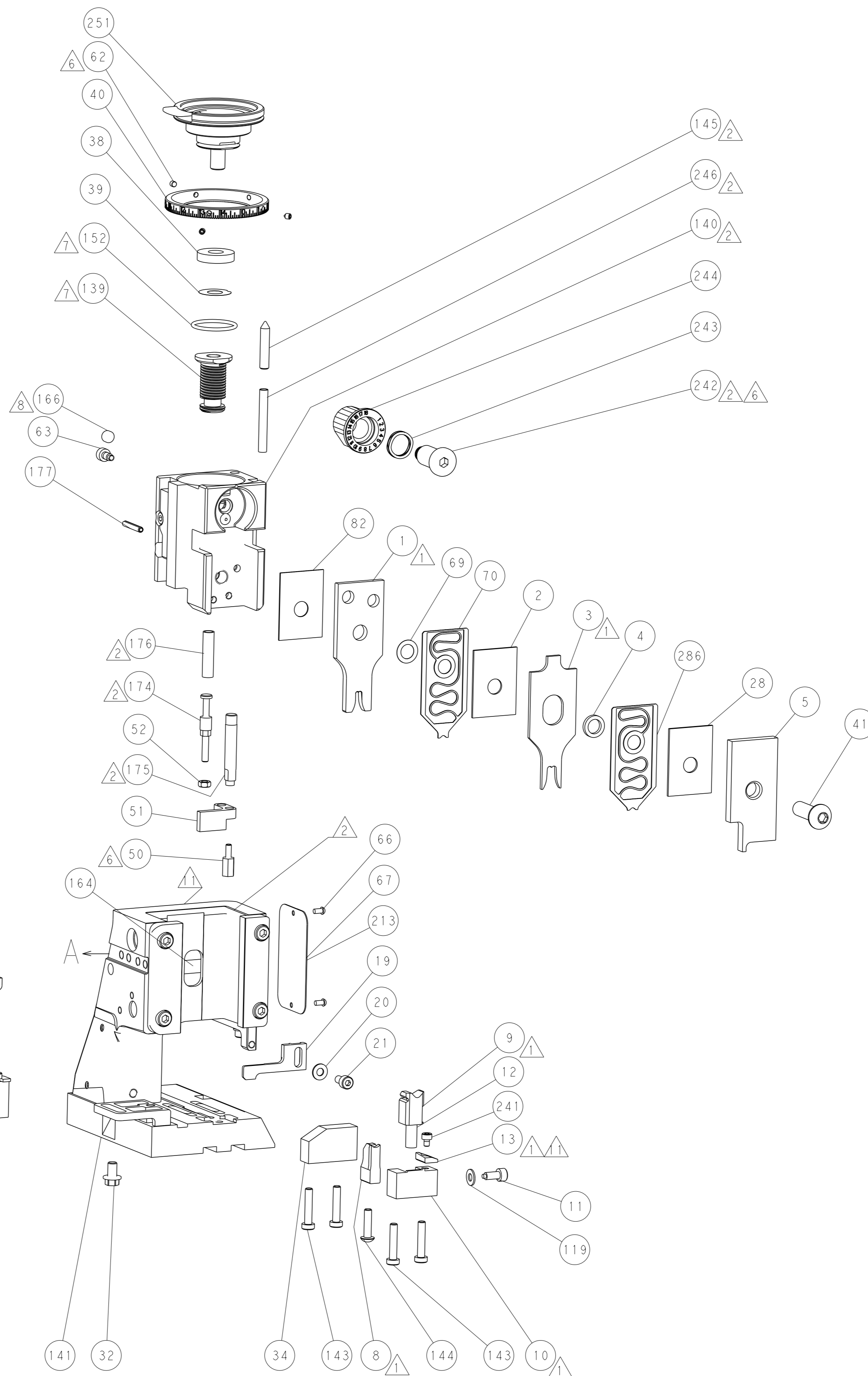
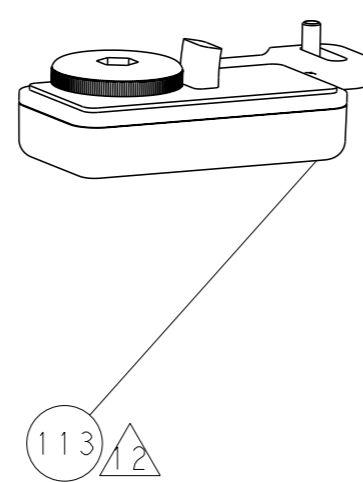
SERVO LATCH PLATE



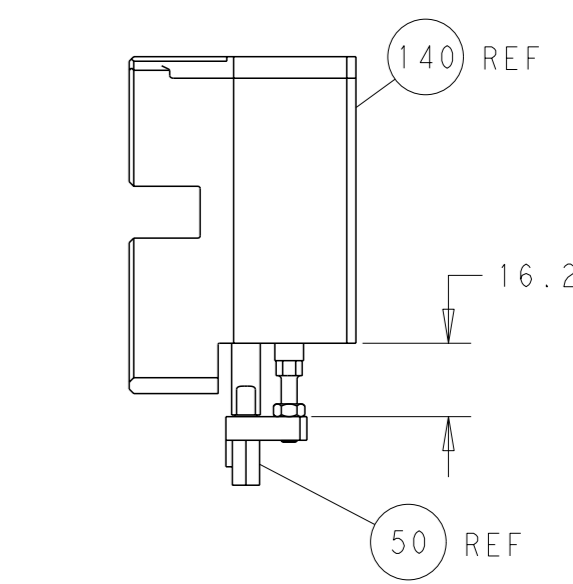
CAM POSITION



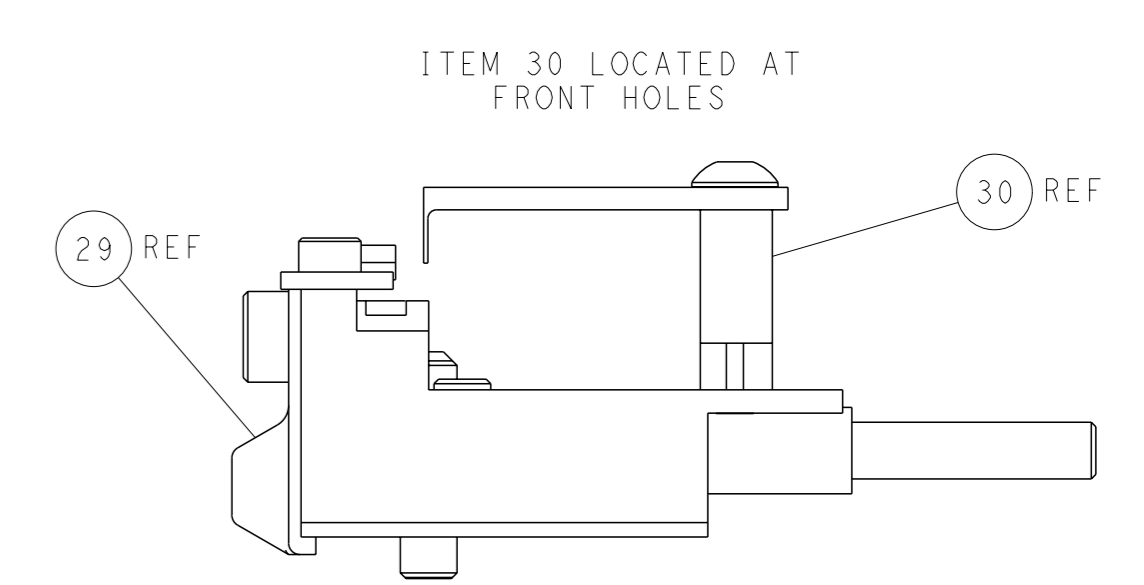
AIR FEED



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: C. CHEN 16 JUL 2012 CHK: S. XI 16 JUL 2012 APVD: J. CRUZ 16 JUL 2012 | TE Connectivity Harrisburg, PA 17105-3608 |
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| MATERIAL: | | WEIGHT: | CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:2 SHEET: 4 of 4 REV: C |