

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|-------------------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | | | | | | | | | | | |
| | 2151890-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151890-5 | 1901094-3 | 1-1752354-3 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151890-4 | - | - | - |
| | 2151890-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151890-5 | 1901094-3 | 1-1752354-3 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151890-4 | - | - | - |
| | 2151890-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | 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 |
| | 2151890-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | - | - | - | - | - | - | - |
| | | | | | - | - | - | - | - | - | - |
| | 2151890-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | | | | | - | - | - | - | - | - | - |
| 7-2151890-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------------------------|----------------|------|
| CRIMP WIRE | SIZE | TYPE |
| | 1.57 mm [.062] | F |
| INSUL | 1.78 mm [.070] | F |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: JAE TERMINAL | | JAE CRIMP SPECIFICATION | |
|------------------------------------|---------------|------------------------------|--------------|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 2.00-2.60 mm [.079-.102 IN] | | Ø0.90-1.60 mm [.035-.063 IN] | |
| TERMINAL APPLICATION SPECIFICATION | T703470 Rev - | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | JAE TERMINAL | TE TERMINAL | JAE TERMINAL |
| 2113324-1 | ES5P09K4F2 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------------------|-------------------------------|--------------------------------|
| 22 AWG OR 0.35mm ² | 0.80 +/- 0.05 [.031 +/- .002] | 8.4 |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. 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: 8-2151890-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151890-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151890-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151890-6
- 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, 180 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 242.
- 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 5.00.

***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 |
| -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)

| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|----------|----|-----------------|
| 2119599-1 | A | 66 | REV | DATE | BY | APPV |
| | | | A | RELEASED | | 11APR2013 KS TE |

| | | | | | | | | | |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----------------------------------|----|
| - | 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 | |
| - | 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 | 1-1752354-0 | 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 | 455888-6 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1 | 1 | 1 | 5-547505-2 | SPRING, COMPRESSION | 77 | |
| - | 1 | 1 | 1 | 1 | 1 | 854769-4 | HOLDER, INS | 74 | |
| - | 1 | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 | |
| - | 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 | |
| - | 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 | 1 | 1 | 1 | 1 | 21028-2 | PIN, SLOTTED SPRING .062 X .250 | 58 | |
| - | - | - | - | - | 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 | 1901681-1 | 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 | 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 | 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 | 1 | 2119644-1 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 |
| - | 1 | - | - | 1 | 1 | 1 | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-1752356-9 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2161328-1 | HEX HEAD, FLANGED, M5 X 8mm LONG | 32 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1320908-6 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119959-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 28 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119533-1 | STRIPPER, SIDE FEED | 19 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-356885-4 | STOP, SHEAR | 11 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 462006-6 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-1633918-2 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119780-5 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 5-238011-3 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2-1803016-1 | CRIMPER, INSULATION F | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 455888-1 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 7-1633609-3 | CRIMPER, WIRE | 1 |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO | |

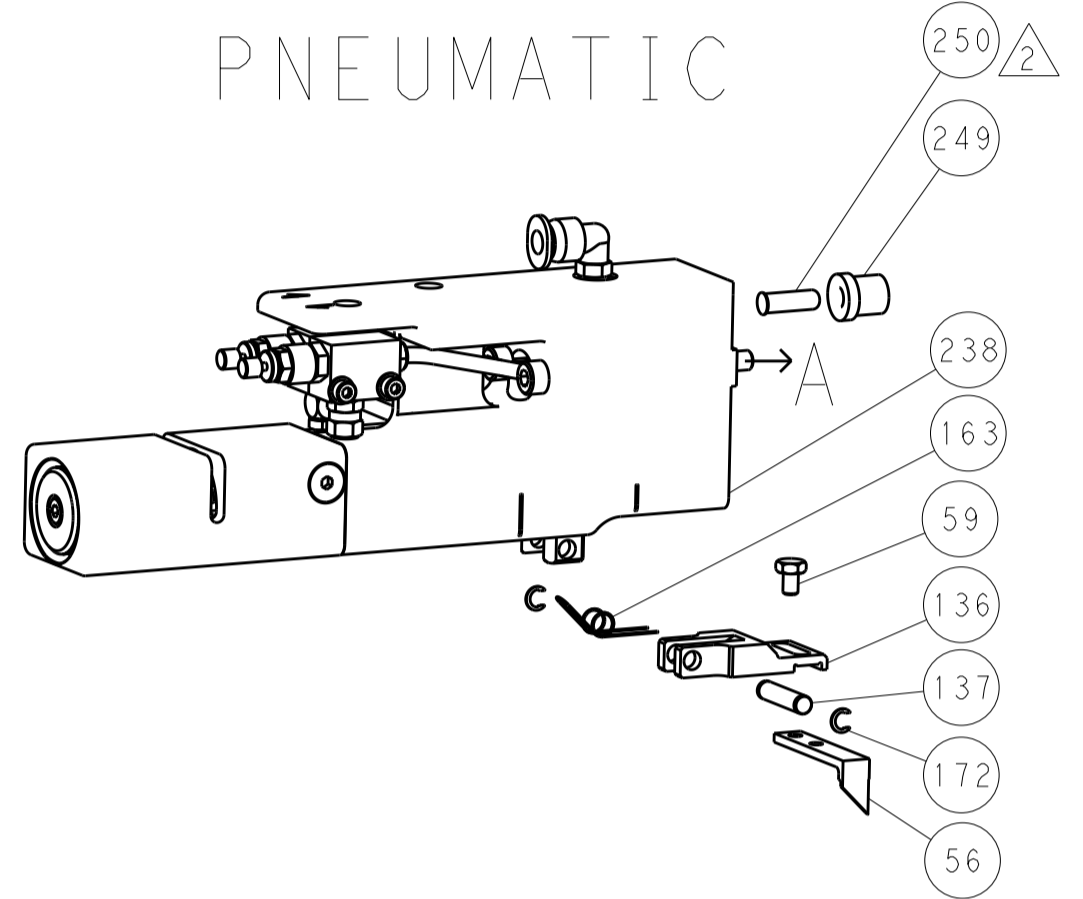
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DATE | |
|--|---------------|--|------------|-------------|--------------|
| mm | 0 PLC ±.1 | 1 PLC ±.01 | 2 PLC ±.02 | 3 PLC ±.005 | 4 PLC ±.0005 |
| | ANGLES ±.0005 | FINISH | | | |
| MATERIAL | | FINISH | | | |
| Customer Accessible Production Drawing | | SCALE | 1:1 | SHEET | 1 of 4 |

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

FEED TYPE MECHANICAL



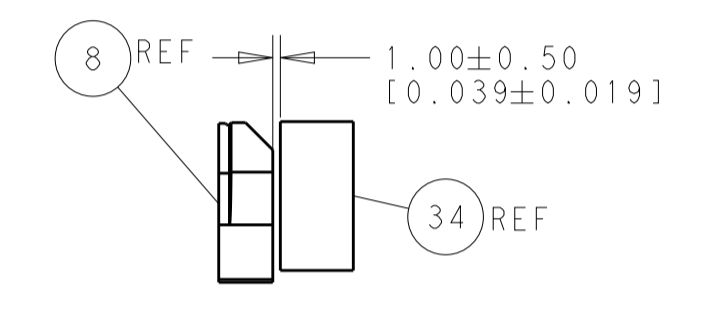
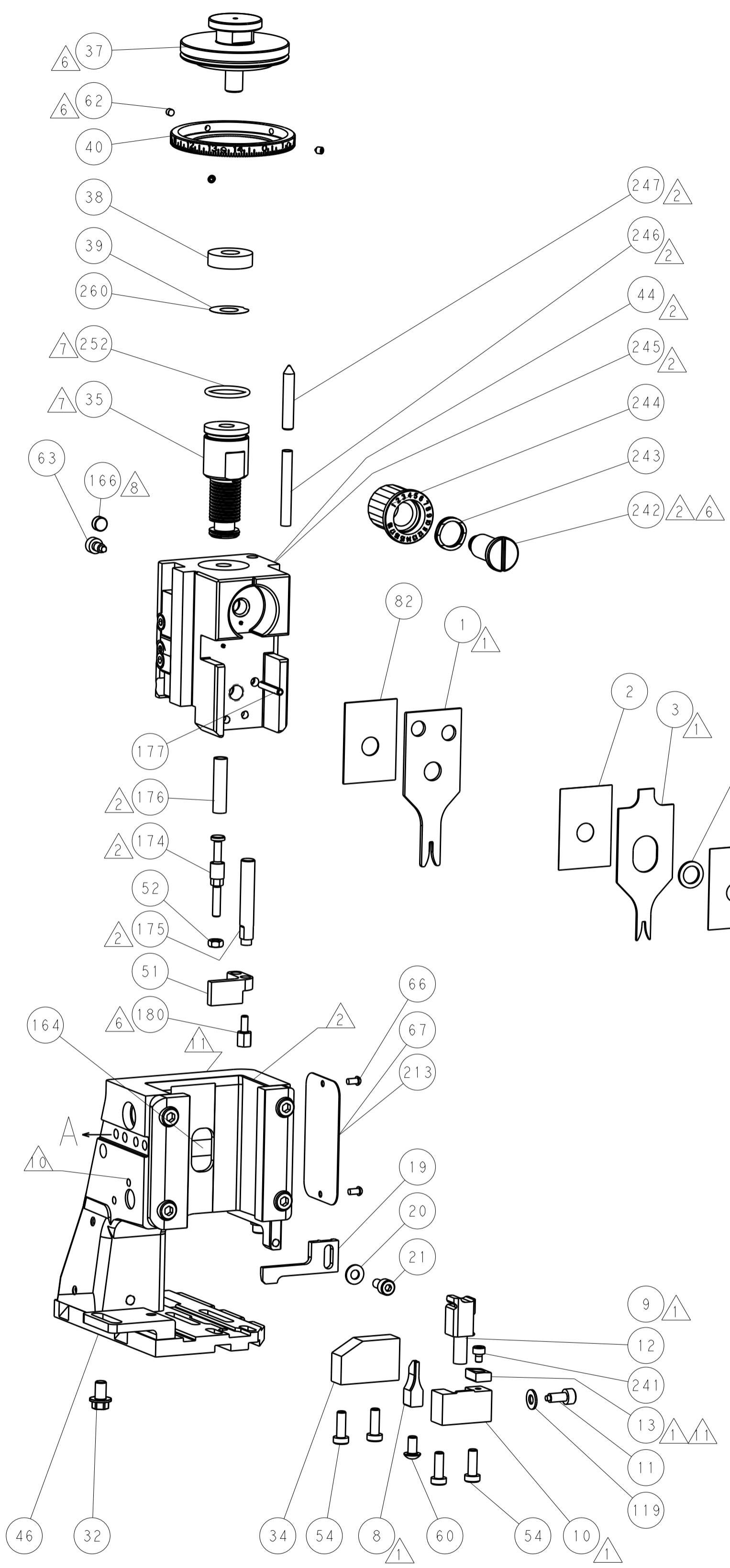
PNEUMATIC



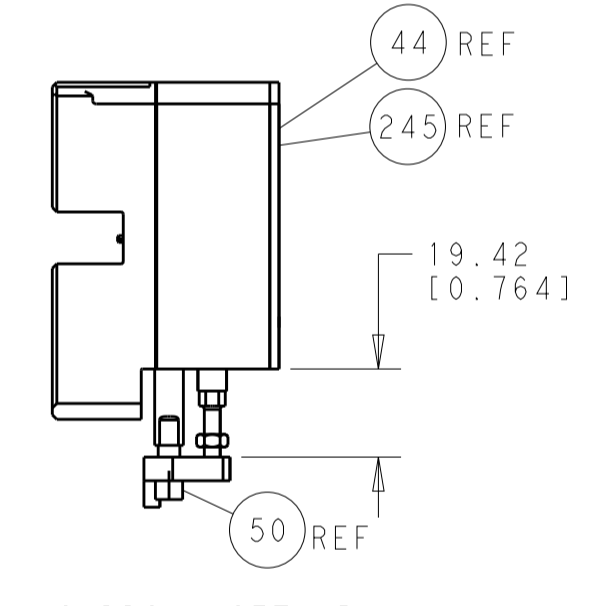
SERVO LATCH PLATE



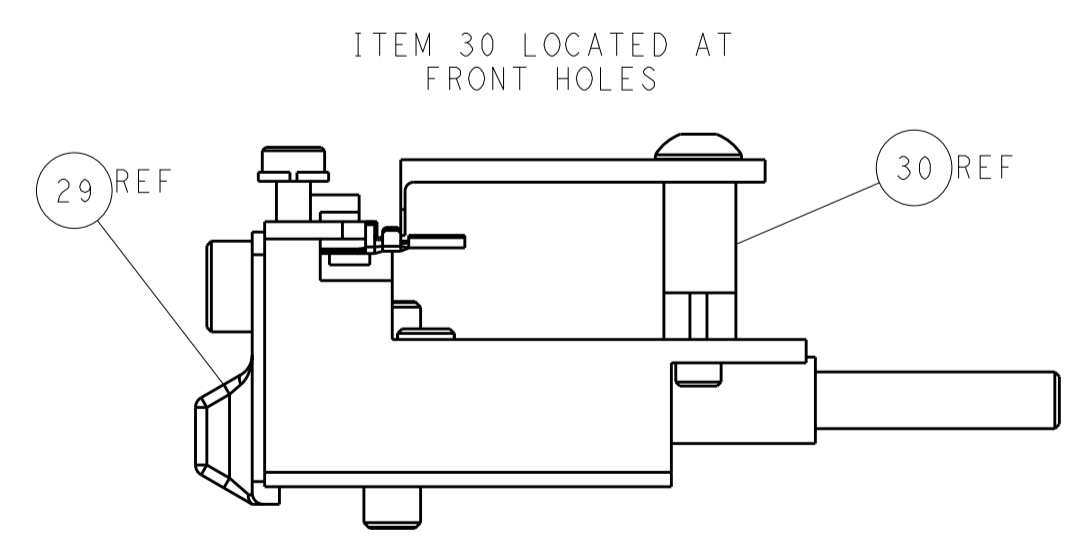
CAM POSITIONS



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 STAKEM 26FEB2013 | | TE Connectivity | |
| mm | 0 PLC ±0.1 | 1 PLC ±0.1 | 2 PLC ±0.02 | 3 PLC ±0.005 | 4 PLC ±0.0005 | APVD T. ELBIN 26FEB2013 | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | NAME Ocean Side Feed Applicator | | RESTRICTED TO | |
| Customer Accessible Production Drawing | | SCALE 1:1 | | SHEET 2 of 4 | | REV A | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2151890-1 | 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 | - | 8-2151890-5 | 1901094-3 | 1-1752354-3 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151890-4 | - | - | - |
| | 2-2151890-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151890-5 | 1901094-3 | 1-1752354-3 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151890-4 | - | - | - |
| | 2-2151890-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE 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 |
| | 2-2151890-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2151890-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|-----------------------------------|----------------|------|
| CRIMP WIRE | SIZE | TYPE |
| INSUL | 1.57 mm [.062] | F |
| | 1.78 mm [.070] | F |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: JAE TERMINAL | | JAE CRIMP SPECIFICATION | |
|------------------------------------|---------------|------------------------------|--------------|
| TERMINAL NAME: TERMINAL | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 2.00-2.60 mm [.079-.102 IN] | | Ø0.90-1.60 mm [.035-.063 IN] | |
| TERMINAL APPLICATION SPECIFICATION | T703470 Rev - | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | JAE TERMINAL | TE TERMINAL | JAE TERMINAL |
| 2113324-1 | ES5P09K4F2 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------------------|-------------------------------|--------------------------------|
| 22 AWG OR 0.35mm ² | 0.80 +/- 0.05 [.031 +/- .002] | 8.4 |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 3. 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: 8-2151890-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151890-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151890-5
- 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, 180 & 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.
- 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 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 |
| - | 1 | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | 1 | 1 | 1 | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| -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 | REV | DATE | BY | APPD |
| | | | - | SEE SHEET 1 | - | - |

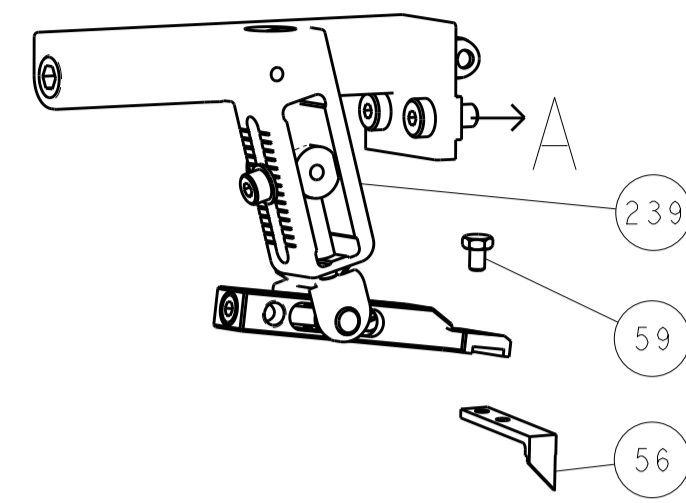
| | | | | | | | |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 1 | 1 | 1 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | - | 2 | - | - | 2168400-6 | SHCS, LOW HEAD, RoHS, 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 | 1-1752354-0 | STANDOFF, HOLD-DOWN | 180 |
| - | 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 |
| - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | - | - | 1 | - | 240638-1 | SPRING, FEED FINGER | 163 |
| - | 1 | 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 | 1 | 2119798-2 | DETENT PIN | 145 |
| - | 1 | 1 | 1 | 1 | 2079383-8 | SCR, BHSC, RoHS (M4 X 16) | 144 |
| - | 4 | 4 | 4 | 4 | 2168400-5 | SHCS, LOW HEAD, RoHS, M4 X 20 | 143 |
| - | - | - | - | 1 | 2119653-2 | FEED CAM, POST FEED | 142 |
| - | 1 | 1 | 1 | 1 | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF | 141 |
| - | 1 | 1 | 1 | 1 | 2119650-1 | RAM, ASIAN STYLE, SIDE FEED | 140 |
| - | 1 | 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 | 135 |
| - | - | 1 | - | - | 1633743-1 | SERVO FEED LATCH ASM | 133 |
| - | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | REF | - | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | 117 |
| - | 1 | 1 | 1 | 1 | 455888-6 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 5-547505-2 | SPRING, COMPRESSION | 77 |
| - | 1 | 1 | 1 | 1 | 854769-4 | HOLDER, INS | 74 |
| - | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | - | 1 | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS | 66 |
| - | 1 | 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 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1 | 1 | 1 | 21028-2 | PIN, SLOTTED SPRING .062 X .250 | 58 |
| - | - | - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 |
| - | 1 | 1 | 1 | 1 | 1901681-1 | 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 | 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 | 2119644-1 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1 | 1-1752356-9 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 1 | 1 | 1 | 1 | 2161328-1 | HEX HEAD, FLANGED, M5 X 8mm LONG | 32 |
| - | 1 | 1 | 1 | 1 | 1320908-6 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 2119959-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 28 |
| - | 1 | 1 | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1 | 1 | 1 | 2119533-1 | STRIPPER, SIDE FEED | 19 |
| - | 1 | 1 | 1 | 1 | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1 | 1 | 1 | 1-356885-4 | 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 | 1-1633918-2 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 2119780-5 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 5-238011-3 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 2-1803016-1 | CRIMPER, INSULATION F | 3 |
| - | 1 | 1 | 1 | 1 | 455888-1 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 7-1633609-3 | CRIMPER, WIRE | 1 |
| -77 | -27 | -25 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |

| | | | | | |
|--|--|--|--------------|---------------------------|----------------------------------|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | CHK: STAKEM 26FEB2013 | NAME: Ocean Side Feed Applicator |
| | | 0 PLC ±.1 | 1 PLC ±0.1 | APVD: G. BAILEY 26FEB2013 | SIZE: A1 |
| | | 2 PLC ±0.02 | 3 PLC ±0.005 | PRODUCT SPEC: - | CAGE CODE: 00779 |
| | | 4 PLC ±0.0005 | ANGLES ±.01 | APPLICATION SPEC: - | DRAWING NO: C=2151890 |
| MATERIAL: - | | FINISH: - | | WEIGHT: - | RESTRICTED TO: - |
| Customer Accessible Production Drawing | | | | SCALE: 1:1 | SHEET 3 OF 4 REV A |

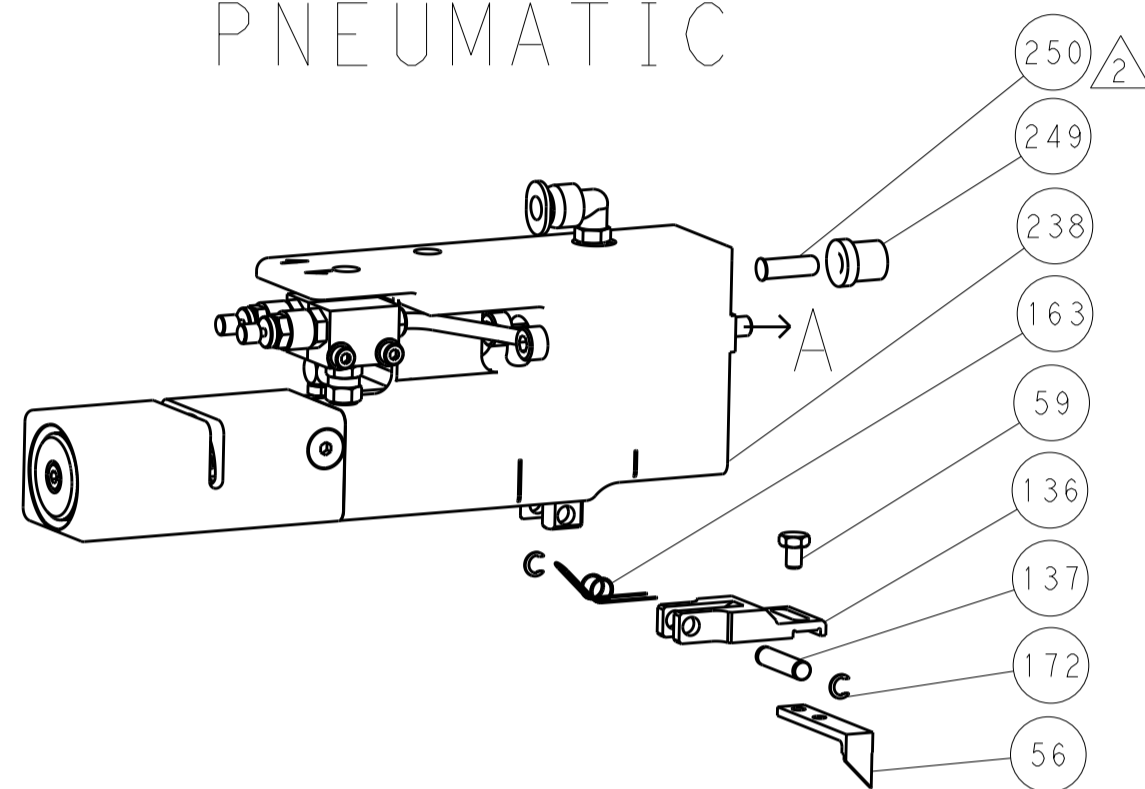
| LOC | | DIST | | REVISIONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LTM | DESCRIPTION | DATE | OWN | APVD |
| | | - | - | SEE SHEET 1 | - | - | - |

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

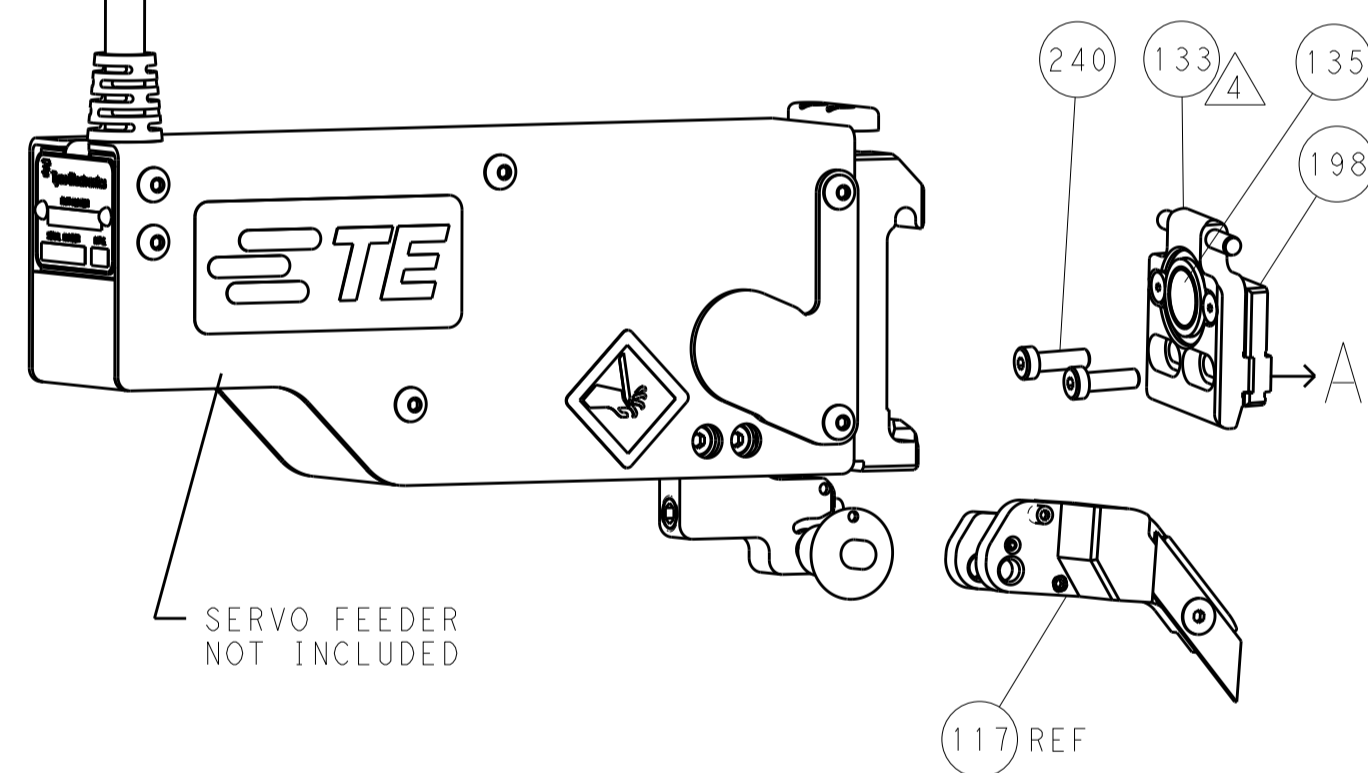
FEED TYPE MECHANICAL



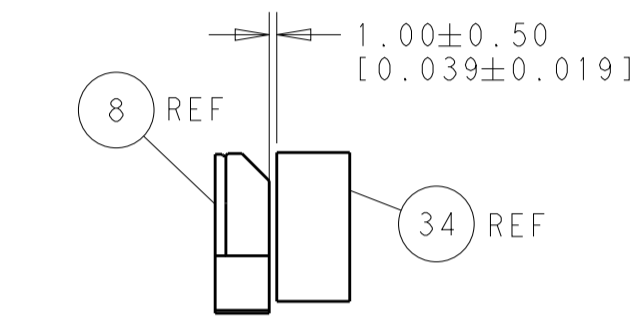
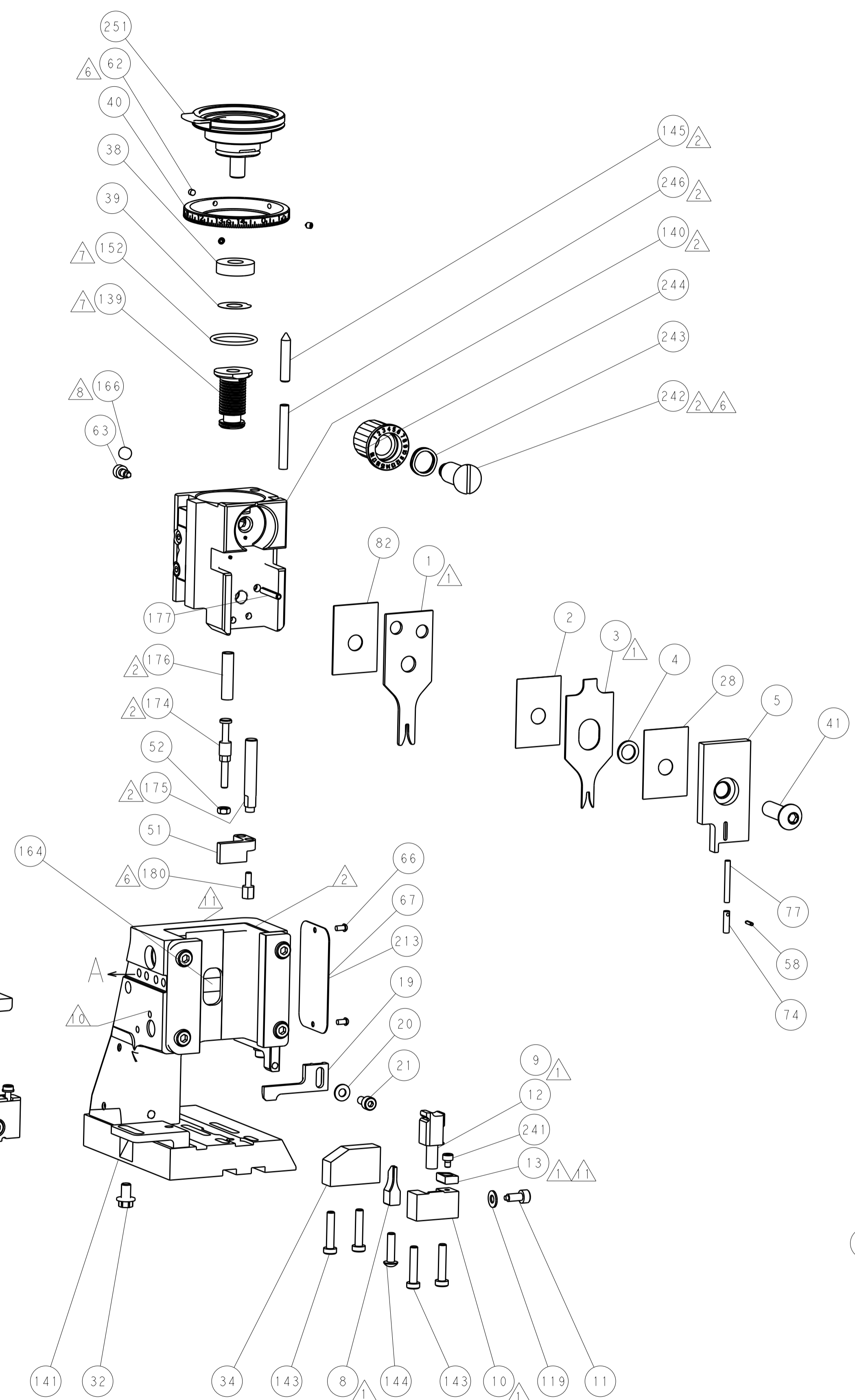
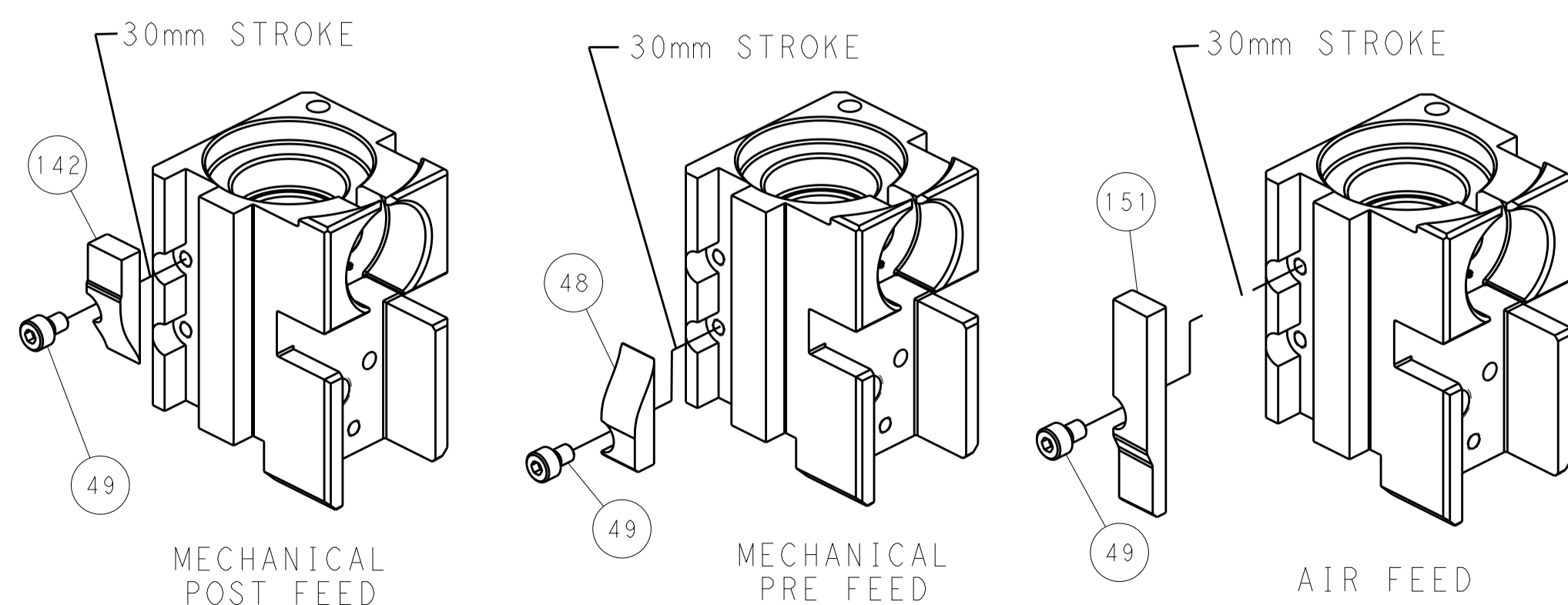
PNEUMATIC



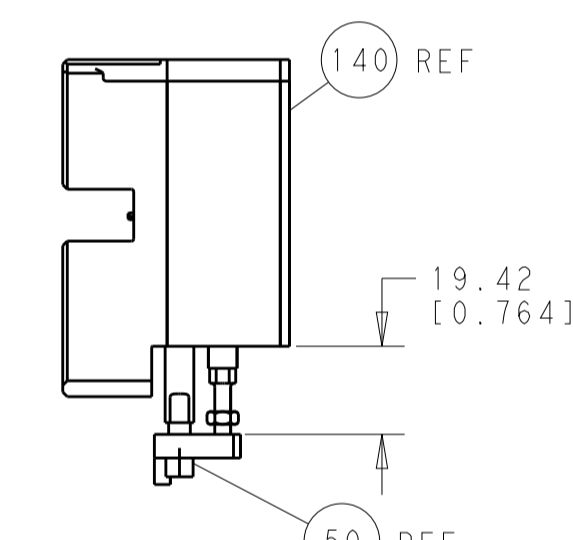
SERVO LATCH PLATE



CAM POSITIONS

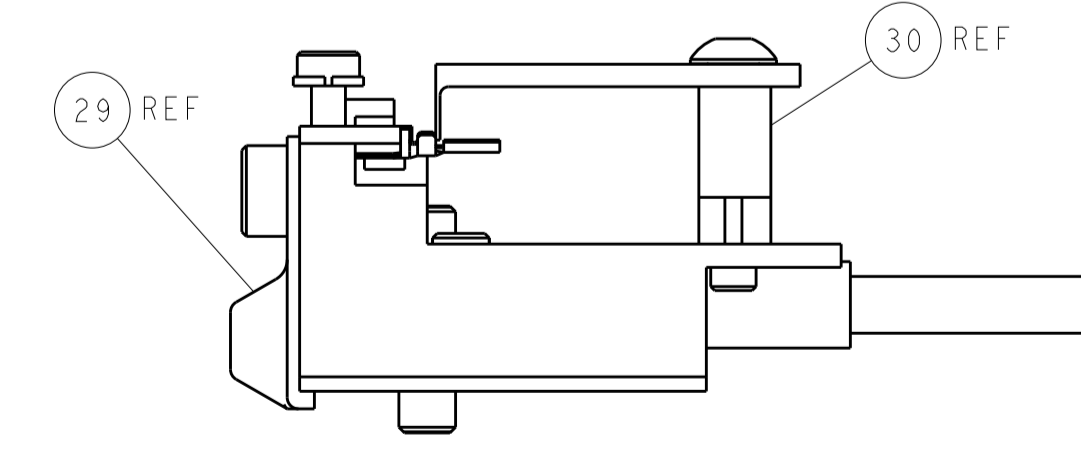


TERMINAL SUPPORT LOCATION



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: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±.1 | | DWN: R. STAKEM 26FEB2013 CHK: G. BAILEY 26FEB2013 APVD: T. ERLIN 26FEB2013 | | NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151890 | | RESTRICTED TO: - SCALE: 1:1 SHEET: 4 OF: 4 REV: A | |
| MATERIAL: - FINISH: - | | | | WEIGHT: - Customer Accessible Production Drawing | | TE Connectivity Harrisburg, PA 17105-3608 | | SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION | |