

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |             |                        |
|---|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
|   |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |             |                        |
|   | 2151971-2   | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | -                                 | -                     | 1338685-1 | 5-18022-5   | -         | -           | -                      |
|   | 2151971-5   | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151971-5 | 1901094-3 | 2-1752354-0 | 2168400-6 (QUANTITY 2) |
|   |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151971-4 | -         | -           | -                      |
|   | 2151971-6   | A        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-1 | 2119799-1   | 2063440-2              |
|   |             |          |                          |                                | -                                 | -                     | -         | -           | -         | -           | -                      |
|   | 2151971-7   | A        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | -           | -                      |
|   | 7-2151971-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | -           | -                      |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 3.45 mm [.136] | F    |
| INSUL           | 4.32 mm [.170] | F    |

APPLICATOR INSTRUCTIONS  
408-10389

| TERMINAL DATA: TE TERMINAL                |             | TE CRIMP SPECIFICATION       |             |
|---|-------------|------------------------------|-------------|
| TERMINAL NAME: ASSY, TERMINAL RING TONGUE |             |                              |             |
| WIRE STRIP LENGTH                         |             | INSULATION DIAMETER RANGE    |             |
| 5.50-6.00 mm [.217-.236 IN]               |             | Ø3.10-4.20 mm [1.22-.165 IN] |             |
| TERMINAL APPLICATION SPECIFICATION        | 114-37015   |                              |             |
| TERMINALS APPLIED <sup>10</sup>           |             |                              |             |
| TE TERMINAL                               | TE TERMINAL | TE TERMINAL                  | TE TERMINAL |
| 1599298-1                                 | 1599298-3   | 1599298-4                    | 1599298-5   |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 2.50mm2   | 2.57+/-0.05 [1.01+/-0.002] | 5.7                            |
| 2.00mm2   | 2.43+/-0.05 [0.96+/-0.002] | 7.5                            |
| 1.50mm2   | 2.33+/-0.05 [0.92+/-0.002] | 8.3                            |

- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151971-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151971-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151971-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> 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.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>8</sup> MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> 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.
- <sup>10</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>11</sup> 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.
- <sup>12</sup> WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.23.
- <sup>13</sup> MAXIMUM CMA FOR 2.50mm2 IS 5000 CMA.

**\*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.

|     |    |    |    |    |            |                                 |         |
|-----|----|----|----|----|------------|---------------------------------|---------|
| -   | 2  | 2  | 2  | 2  | 2168083-1  | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 269     |
| -   | 1  | 1  | 1  | 1  | 1-690438-0 | FRONT STRIP GUIDE               | 268     |
| -   | 2  | 2  | 2  | 2  | 22283-1    | SPRING, COMPRESSION             | 267     |
| -   | 2  | 2  | 2  | 2  | 2-18032-5  | SCR, SET, FLT POINT M5 X 20.0   | 266     |
| -   | 1  | 1  | 1  | 1  | 980371-4   | SCR, SKT HD SHLDR 5.0 DIA X 6.0 | 265     |
| -   | 1  | 1  | 1  | 1  | 356835-1   | LEVER, DRAG RELEASE             | 264     |
| -   | 1  | 1  | 1  | 1  | 240792-1   | DRAG, TERMINAL                  | 263     |
| -   | 2  | 2  | 2  | 2  | 2168083-1  | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 262     |
| -   | 1  | 1  | 1  | 1  | 1633782-8  | FENCE                           | 261     |
| -   | -  | 1  | -  | -  | 2119957-2  | APPLICATOR SHIM PACK            | 260     |
| -   | 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  | 2119798-1  | DETENT PIN                      | 247     |
| -77 | -7 | -6 | -5 | -2 | 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   | P         | LTN | DESCRIPTION | DATE      | OWN | APVD |
|              |     |      | A         |     | RELEASED    | 16AUG2013 | LG  | GB   |

|              |     |     |     |     |             |                                     |         |
|--------------|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -            | 1   | -   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246     |
| -            | -   | 1   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245     |
| -            | 1   | 1   | 1   | 1   | 2119082-5   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -            | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| <sup>6</sup> | -   | 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   | 2   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16       | 240     |
| -            | -   | -   | -   | 1   | 2063440-2   | AIR FEED MODULE                     | 238     |
| -            | -   | 1   | 1   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213     |
| -            | -   | 1   | 1   | -   | 1901094-3   | SPACER, FEEDER                      | 198     |
| <sup>6</sup> | -   | 1   | 1   | 1   | 2-1752354-0 | 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   | 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   | 1-18028-2   | WASHER, FLAT, REG M4                | 119     |
| -            | -   | REF | REF | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -            | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82      |
| -            | 1   | 1   | 1   | 1   | 1-22278-0   | SPRING, COMPRESSION                 | 77      |
| -            | 1   | 1   | 1   | 1   | 854769-4    | HOLDER, INS                         | 74      |
| -            | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -            | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70      |
| -            | 1   | -   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| -            | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66      |
| -            | 1   | -   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
| <sup>6</sup> | -   | 3   | -   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62      |
| -            | 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   | 21028-2     | PIN, SLOTTED SPRING .062 X .250     | 58      |
| -            | -   | -   | -   | 1   | 1-1338683-1 | FEED PAWL                           | 56      |
| -            | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54      |
| -            | 1   | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52      |
| -            | 1   | 1   | 1   | 1   | 1901681-2   | HOLDDOWN, TERMINAL                  | 51      |
| -            | -   | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
| -            | 1   | 1   | 1   | 1   | 2119656-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46      |
| -            | 1   | -   | 1   | 1   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44      |
| -            | 1   | 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   | 1   | 1-2119644-3 | RAM WASHER, PRECISION               | 38      |
| <sup>6</sup> | -   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37      |
| -            | 1   | -   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35      |
| -            | 1   | 1   | 1   | 1   | 1752356-6   | SUPPORT, TERMINAL                   | 34      |
| -            | 2   | 2   | 2   | 2   | 1-2079383-3 | SCR, BHSC, RoHS (M4 X 25)           | 33      |
| -            | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 X 8mm LONG    | 32      |
| -            | 1   | 1   | 1   | 1   | 2-1320908-5 | SPACER, STRIP GUIDE                 | 30      |
| -            | 1   | 1   | 1   | 1   | 2119959-3   | ASSEMBLY, STRIP GUIDE               | 29      |
| -            | 1   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 28      |
| -            | 1   | 1   | 1   | 1   | 1320928-8   | 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      |
| <sup>6</sup> | -   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13      |
| -            | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12      |
| -            | 1   | 1   | 1   | 1   | 1-356885-3  | STOP, SHEAR                         | 11      |
| <sup>1</sup> | -   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
| <sup>1</sup> | -   | 1   | 1   | 1   | 454276-5    | FLOATING SHEAR, FRONT               | 9       |
| <sup>1</sup> | 1   | 1   | 1   | 1   | 1-1803057-4 | ANVIL, COMBINATION                  | 8       |
| -            | -   | -   | -   | -   | -           | -                                   | 7       |
| -            | -   | -   | -   | -   | -           | -                                   | 6       |
| -            | 1   | 1   | 1   | 1   | 2119780-9   | DEPRESSOR, SHEAR                    | 5       |
| -            | 1   | 1   | 1   | 1   | 2-238011-1  | BLOCK, CRIMPER SPACER               | 4       |
| <sup>1</sup> | 1   | 1   | 1   | 1   | 3-1633962-7 | CRIMPER, INSULATION F PREMIUM       | 3       |
| -            | 1   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     | 2       |
| <sup>1</sup> | 1   | 1   | 1   | 1   | 4-1633730-6 | CRIMPER, WIRE                       | 1       |
| -77          | -7  | -6  | -5  | -2  | PART NO     | DESCRIPTION                         | ITEM NO |

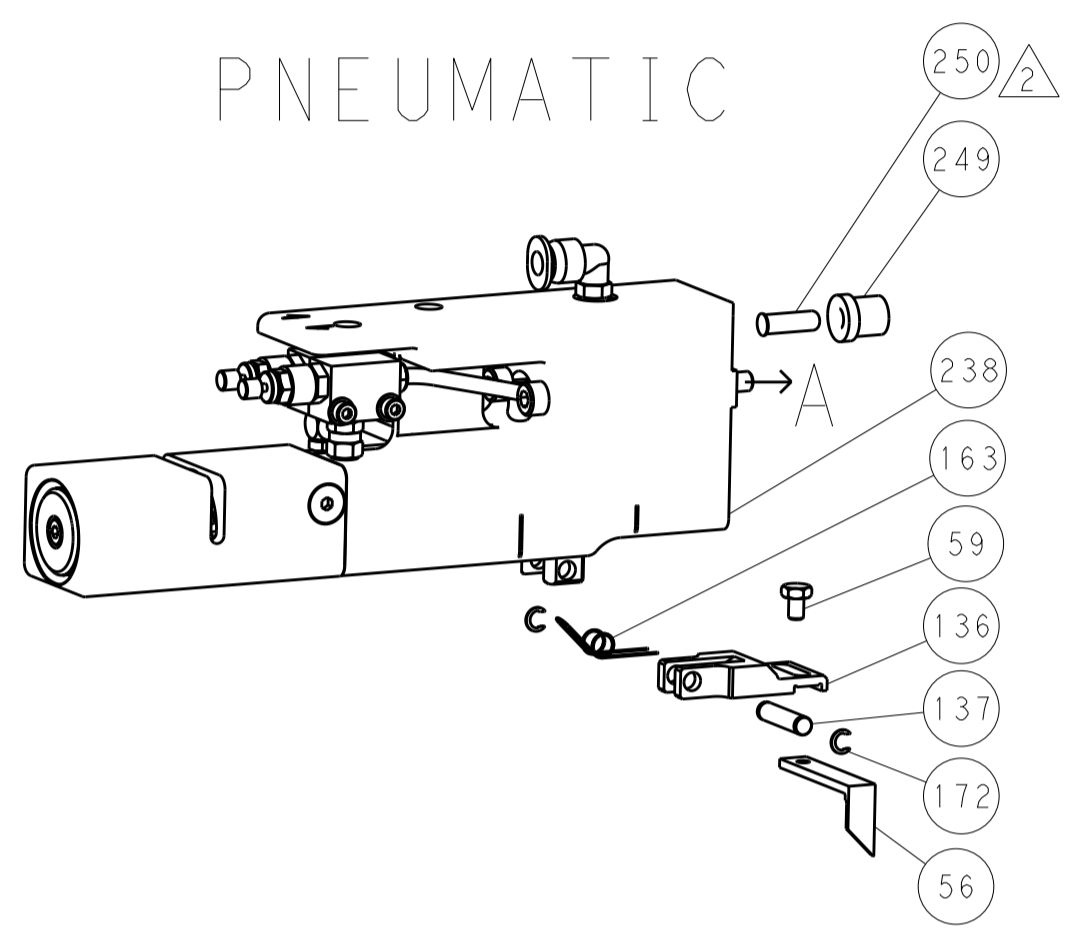
| DIMENSIONS: |               | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | DRAWING NO  |              |
|-------------|---------------|--|-------------|-------------|--------------|
| mm          | 0 PLC ±.5     | 1 PLC ±.13                             | 2 PLC ±.013 | 3 PLC ±.013 | 4 PLC ±.0001 |
|             | ANGLES ±.0001 |  |             |             |              |
| MATERIAL    | FINISH        | WEIGHT                                 | SCALE       | SHEET       | REV          |
|             |               |  | 1:2         | 1 OF 4      | A            |

Customer Accessible Production Drawing

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

### FEED TYPE

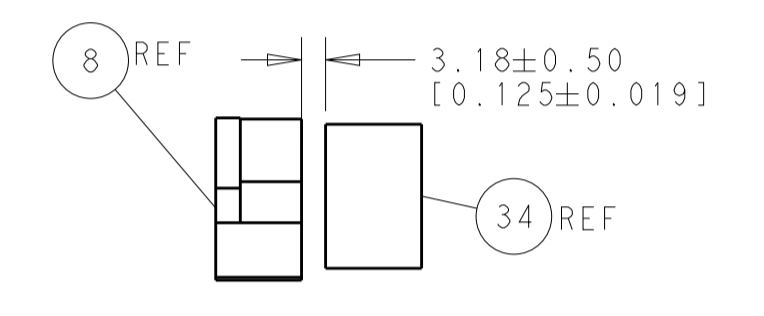
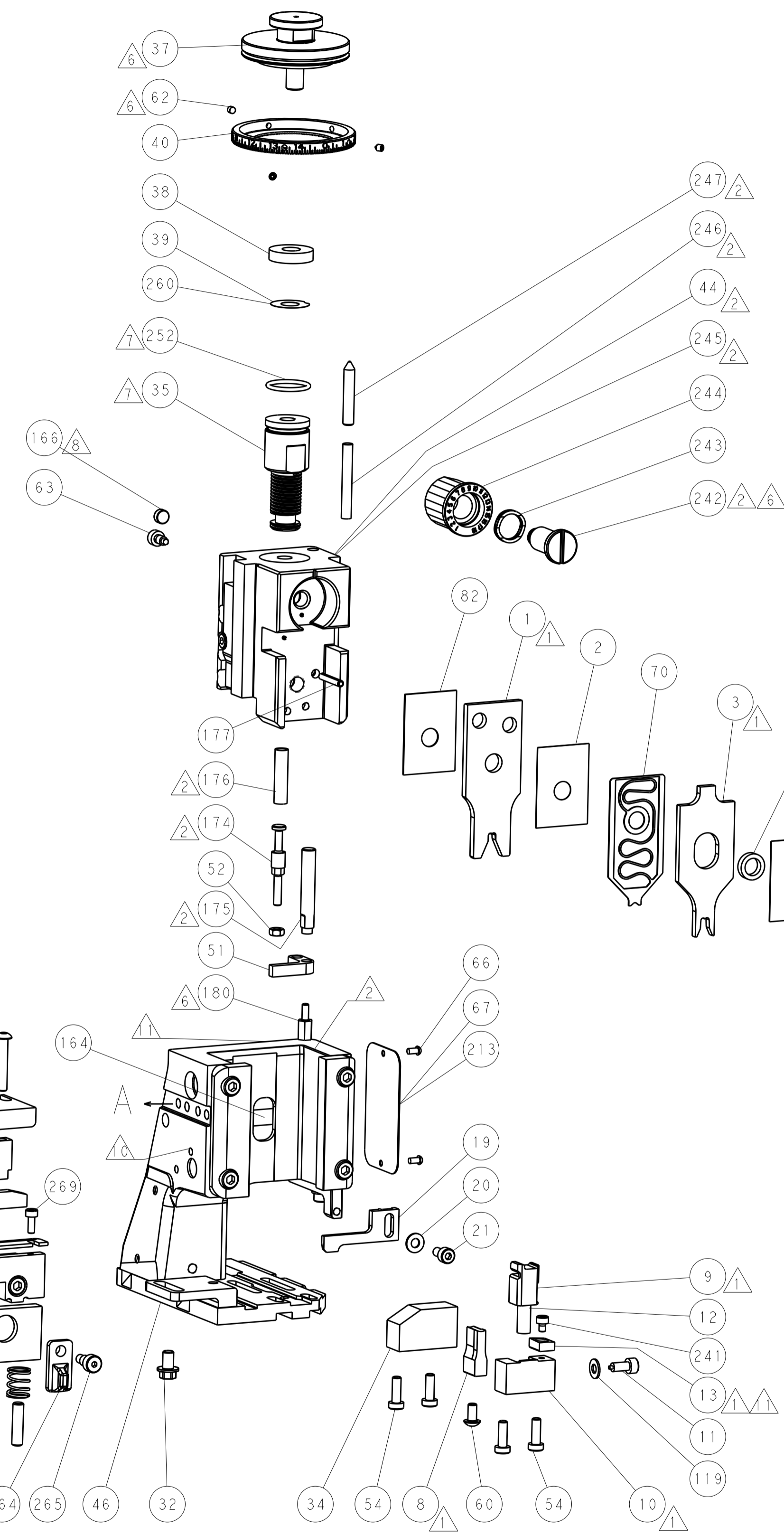
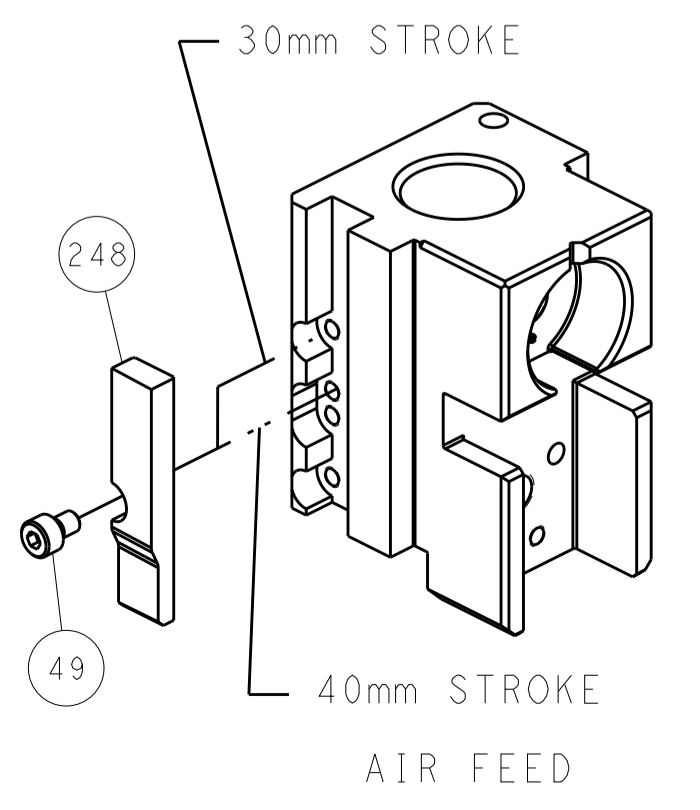
### PNEUMATIC



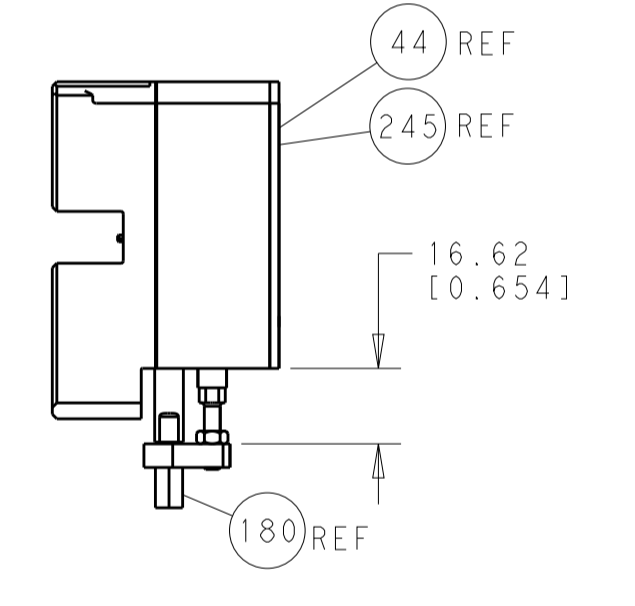
### SERVO LATCH PLATE



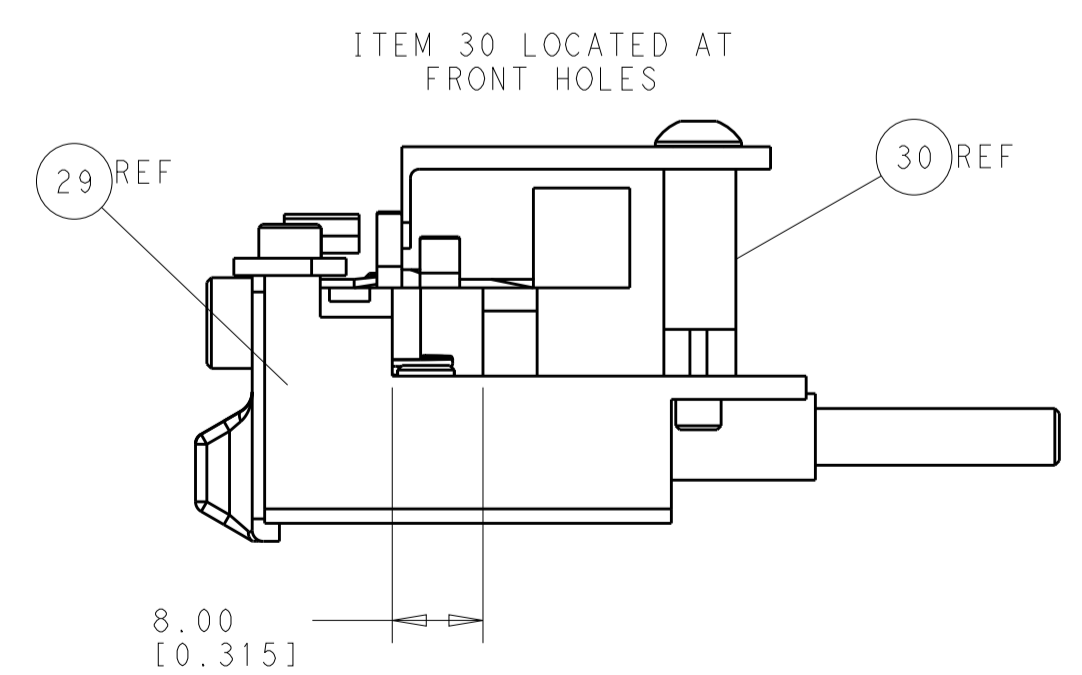
### CAM POSITION



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<br>C. CHEN 09JUN2013 |              | TE Connectivity<br>Harrisburg, PA 17105-3608    |                                    |
| mm                                     | 0 PLC ±0.5 | 1 PLC ±0.5                             | 2 PLC ±0.13 | 3 PLC ±0.013             | 4 PLC ±0.001 | APVD<br>J. CRUZ 09JUN2013                       | NAME<br>Ocean Side Feed Applicator |
| MATERIAL:                              |            | FINISH:                                |             | WEIGHT:                  |              | SIZE CAGE CODE DRAWING NO<br>A1 00779 ©=2151971 |                                    |
| Customer Accessible Production Drawing |            |  |             | SCALE 1:2                |              | 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 |             |           |             |                        |
|  | 2-2151971-2 | A                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | -                                 | 1338685-1             | 5-18022-5   | 2119653-2 | -           | -                      |
|  |             |                          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | 8-2151971-5 | 1901094-3 | 2-1752354-0 | 2168400-6 (QUANTITY 2) |
|  | 2-2151971-5 | A                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | -                                 | 1338685-1             | 5-18022-5   | 2119653-2 | -           | -                      |
|  |             |                          |                          |                                | PNEUMATIC FEED                    | 2119950-1             | 1338685-1   | 5-18022-5 | 2119641-2   | 2119799-1              |
| 2-2151971-7                                  | A           | FINE CRIMP HEIGHT ADJUST | NONE                     | -                              | -                                 | -                     | -           | -         | -           |                        |
| 7-2151971-7                                  | A           | CRIMP TOOLING KIT        | -                        | -                              | -                                 | -                     | -           | -         | -           |                        |

| APPLICATOR DATA                   |                |      |
|-----------------------------------|----------------|------|
| CRIMP                             | SIZE           | TYPE |
| WIRE                              | 3.45 mm [1.36] | F    |
| INSUL                             | 4.32 mm [1.70] | F    |
| APPLICATOR INSTRUCTIONS 408-10389 |                |      |

| TERMINAL DATA: TE TERMINAL                |             | TE CRIMP SPECIFICATION        |             |
|---|-------------|-------------------------------|-------------|
| TERMINAL NAME: ASSY, TERMINAL RING TONGUE |             |                               |             |
| WIRE STRIP LENGTH                         |             | INSULATION DIAMETER RANGE     |             |
| 5.50-6.00 mm [1.217-.236 IN]              |             | Ø3.10-4.20 mm [1.222-.165 IN] |             |
| TERMINAL APPLICATION SPECIFICATION        | 114-37015   | -                             | -           |
| TERMINALS APPLIED <sup>10</sup>           |             |                               |             |
| TE TERMINAL                               | TE TERMINAL | TE TERMINAL                   | TE TERMINAL |
| 1599298-1                                 | 1599298-3   | 1599298-4                     | 1599298-5   |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]    | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
|-----------|---------------------------|---|
| 2.50mm2   | 2.57+/-0.05 [1.01+/-0.02] | 5.7   |
| 2.00mm2   | 2.43+/-0.05 [0.96+/-0.02] | 7.5   |
| 1.50mm2   | 2.33+/-0.05 [0.92+/-0.02] | 8.3   |

- 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:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151971-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151971-5
- 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.
- 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.
- MAXIMUM CMA FOR 2.5mm2 IS 5000 CMA.

**\*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.

|     |     |     |     |            |                                     |         |
|-----|-----|-----|-----|------------|-------------------------------------|---------|
| -   | 2   | 2   | 2   | 2168083-1  | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 269     |
| -   | 1   | 1   | 1   | 1-690438-0 | FRONT STRIP GUIDE                   | 268     |
| -   | 2   | 2   | 2   | 22283-1    | SPRING, COMPRESSION                 | 267     |
| -   | 2   | 2   | 2   | 2-18032-5  | SCR, SET, FLT POINT M5 X 20.0       | 266     |
| -   | 1   | 1   | 1   | 980371-4   | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 265     |
| -   | 1   | 1   | 1   | 356835-1   | LEVER, DRAG RELEASE                 | 264     |
| -   | 1   | 1   | 1   | 240792-1   | DRAG, TERMINAL                      | 263     |
| -   | 2   | 2   | 2   | 2168083-1  | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 262     |
| -   | 1   | 1   | 1   | 1633782-8  | FENCE                               | 261     |
| -   | 1   | 1   | 1   | 2119782-1  | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251     |
| -   | -   | -   | -   | 2119640-1  | PUSH ROD, AIR FEED                  | 250     |
| -   | -   | -   | -   | 2079988-1  | BUSHING, LCH5-12, MISUMI            | 249     |
| -   | 1   | 1   | 1   | 1-22279-3  | SPRING, COMPRESSION                 | 246     |
| -   | 1   | 1   | 1   | 2119082-5  | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -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 |
| -            | -   | -    | 1         | SEE SHEET 1 | -  | -    |

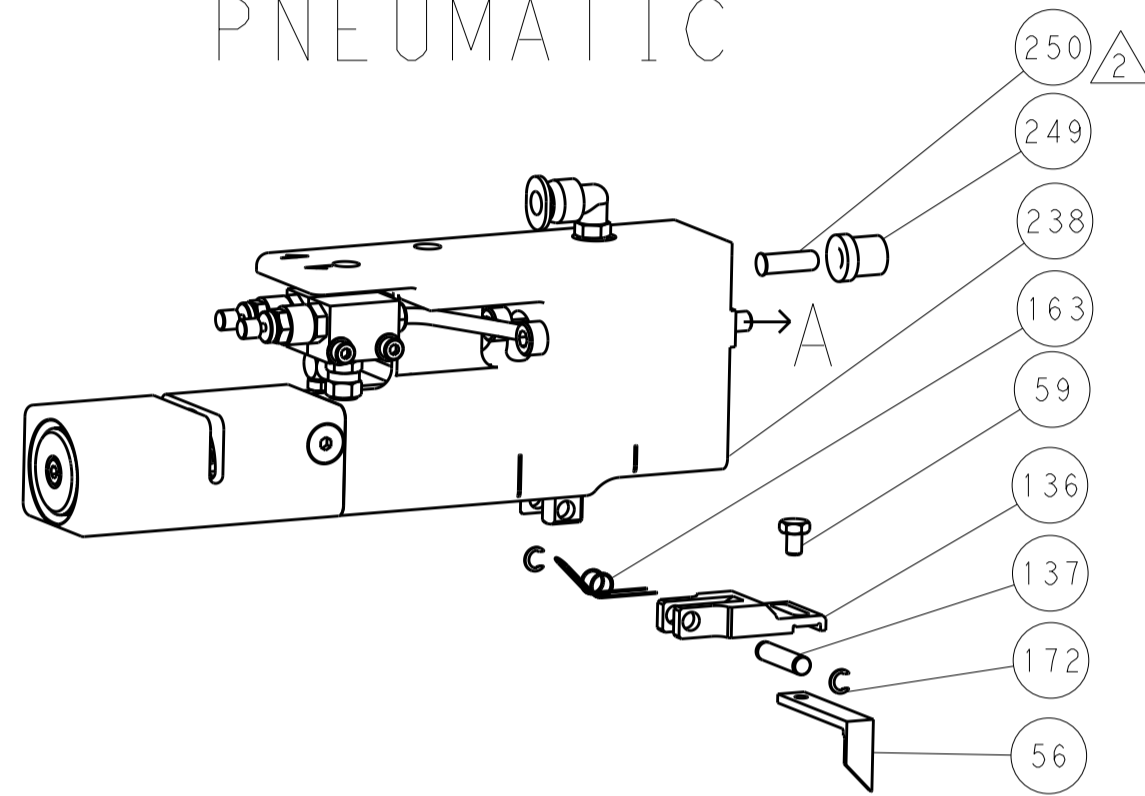
|     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| -   | 1   | 1   | 1   | 2119083-1   | 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   | 2063440-2   | AIR FEED MODULE                     | 238     |
| -   | -   | 1   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213     |
| -   | -   | 1   | -   | 1901094-3   | SPACER, FEEDER                      | 198     |
| -   | 1   | 1   | 1   | 2-1752354-0 | STANDOFF, HOLD-DOWN                 | 180     |
| -   | 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     |
| -   | -   | -   | -   | 2119653-2   | FEED CAM, POST FEED                 | 142     |
| -   | 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   | 455888-5    | SPACER, CRIMPER                     | 82      |
| -   | 1   | 1   | 1   | 1-22278-0   | SPRING, COMPRESSION                 | 77      |
| -   | 1   | 1   | 1   | 854769-4    | HOLDER, INS                         | 74      |
| -   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70      |
| -   | 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 POINT, M3 X 4.0 | 62      |
| -   | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -   | 1   | 1   | 1   | 21028-2     | PIN, SLOTTED SPRING .062 X .250     | 58      |
| -   | -   | -   | 1   | 1-1338683-1 | FEED PAWL                           | 56      |
| -   | 1   | 1   | 1   | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5           | 52      |
| -   | 1   | 1   | 1   | 1901681-2   | HOLDDOWN, TERMINAL                  | 51      |
| -   | -   | -   | 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   | 1-2119644-3 | RAM WASHER, PRECISION               | 38      |
| -   | 1   | 1   | 1   | 1752356-6   | SUPPORT, TERMINAL                   | 34      |
| -   | 2   | 2   | 2   | 1-2079383-3 | SCR, BHSC, RoHS (M4 X 25)           | 33      |
| -   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 X 8mm LONG    | 32      |
| -   | 1   | 1   | 1   | 2-1320908-5 | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 2119959-3   | ASSEMBLY, STRIP GUIDE               | 29      |
| -   | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 28      |
| -   | 1   | 1   | 1   | 1320928-8   | 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   | 1-356885-3  | STOP, SHEAR                         | 11      |
| -   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
| -   | 1   | 1   | 1   | 454276-5    | FLOATING SHEAR, FRONT               | 9       |
| -   | 1   | 1   | 1   | 1-1803057-4 | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 2119780-9   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 2-238011-1  | BLOCK, CRIMPER SPACER               | 4       |
| -   | 1   | 1   | 1   | 3-1633962-7 | CRIMPER, INSULATION F PREMIUM       | 3       |
| -   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     | 2       |
| -   | 1   | 1   | 1   | 4-1633730-6 | CRIMPER, WIRE                       | 1       |
| -77 | -27 | -25 | -22 | PART NO     | DESCRIPTION                         | ITEM NO |

| DIMENSIONS: |              | TOLERANCES UNLESS OTHERWISE SPECIFIED: |               | DATE                                   | BY        | APPV    | NAME                      |
|-------------|--------------|--|---------------|--|-----------|---------|---------------------------|
| mm          | 0 PLC ±.5    | 1 PLC ±0.5                             | 2 PLC ±0.13   | 09JUN2013                              | J.C. CHEN | J. CRUZ | TE Connectivity           |
|             | 3 PLC ±0.013 | 4 PLC ±0.001                           | ANGLES ±.0001 | 09JUN2013                              | U. GUO    |         | Harrisburg, PA 17105-3608 |
| MATERIAL    | FINISH       | WEIGHT                                 | SCALE         | Customer Accessible Production Drawing |           |         |                           |
|             |              |  | 1:2           | SHEET 3 OF 4 REV A                     |           |         |                           |

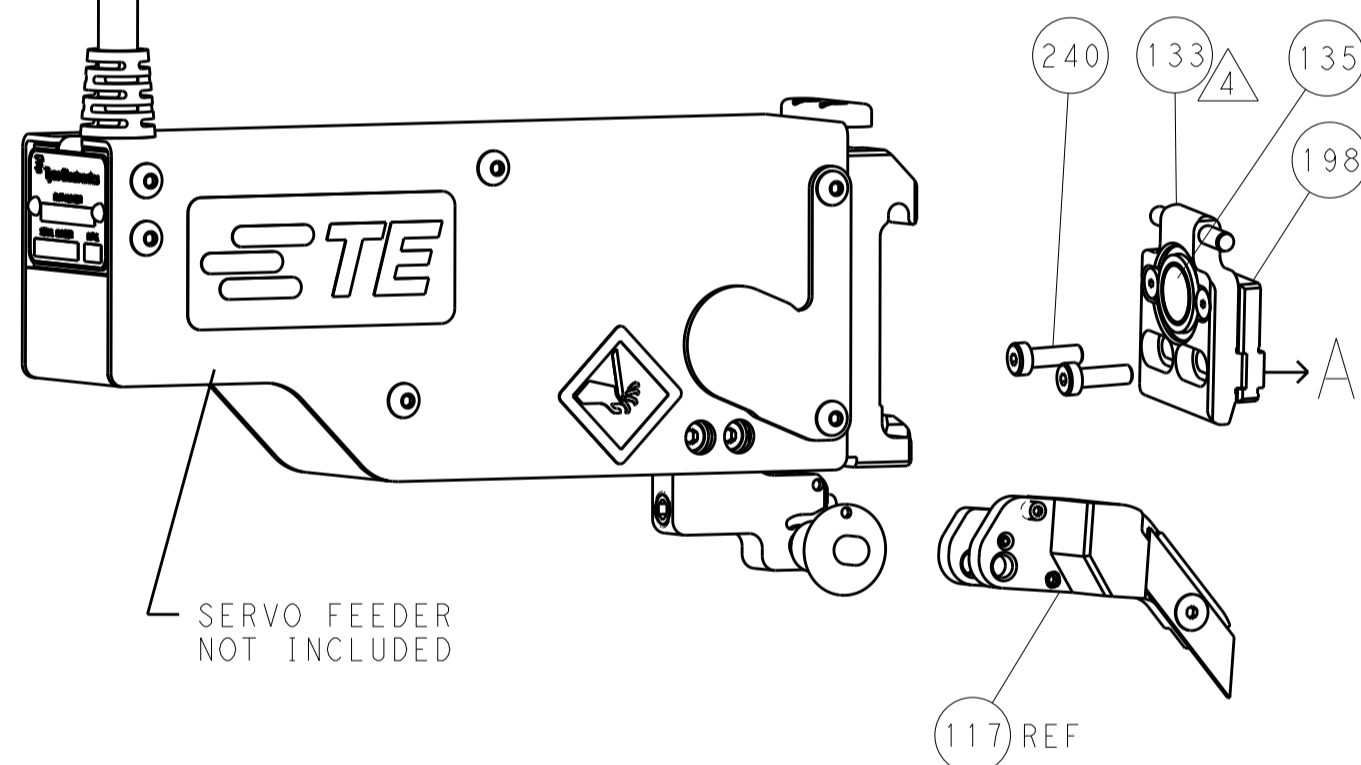
| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTH | DESCRIPTION | DATE | OWN | APVD |
| -   | -  | -    | -   | SEE SHEET 1 | -    | -   | -    |

### FEED TYPE

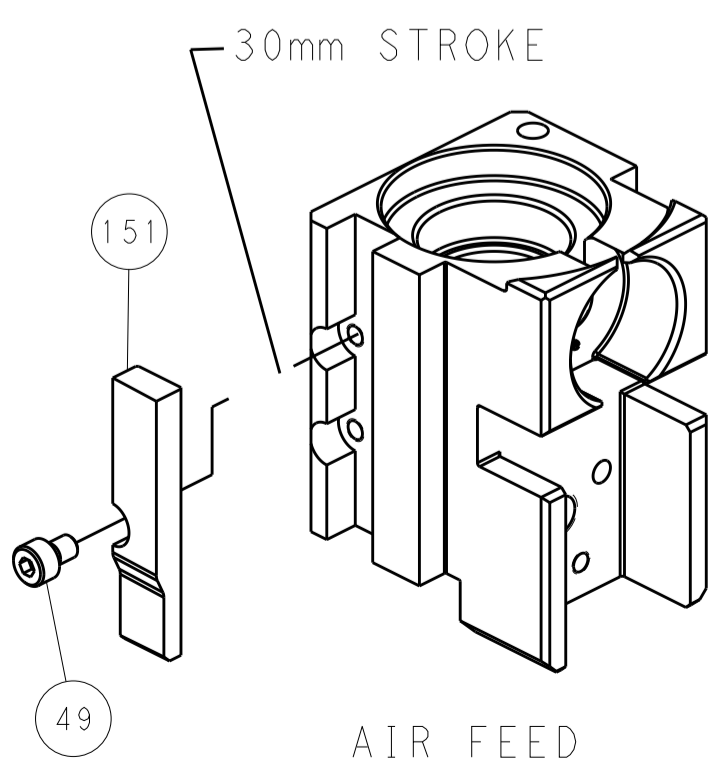
### PNEUMATIC



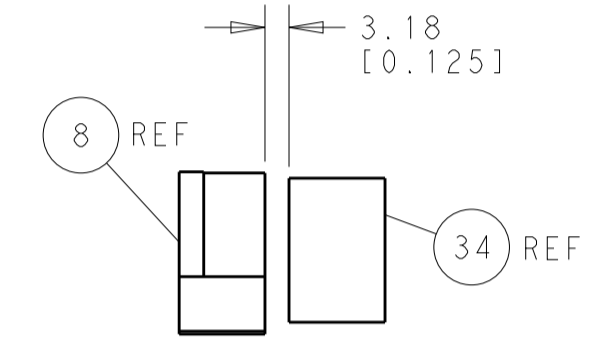
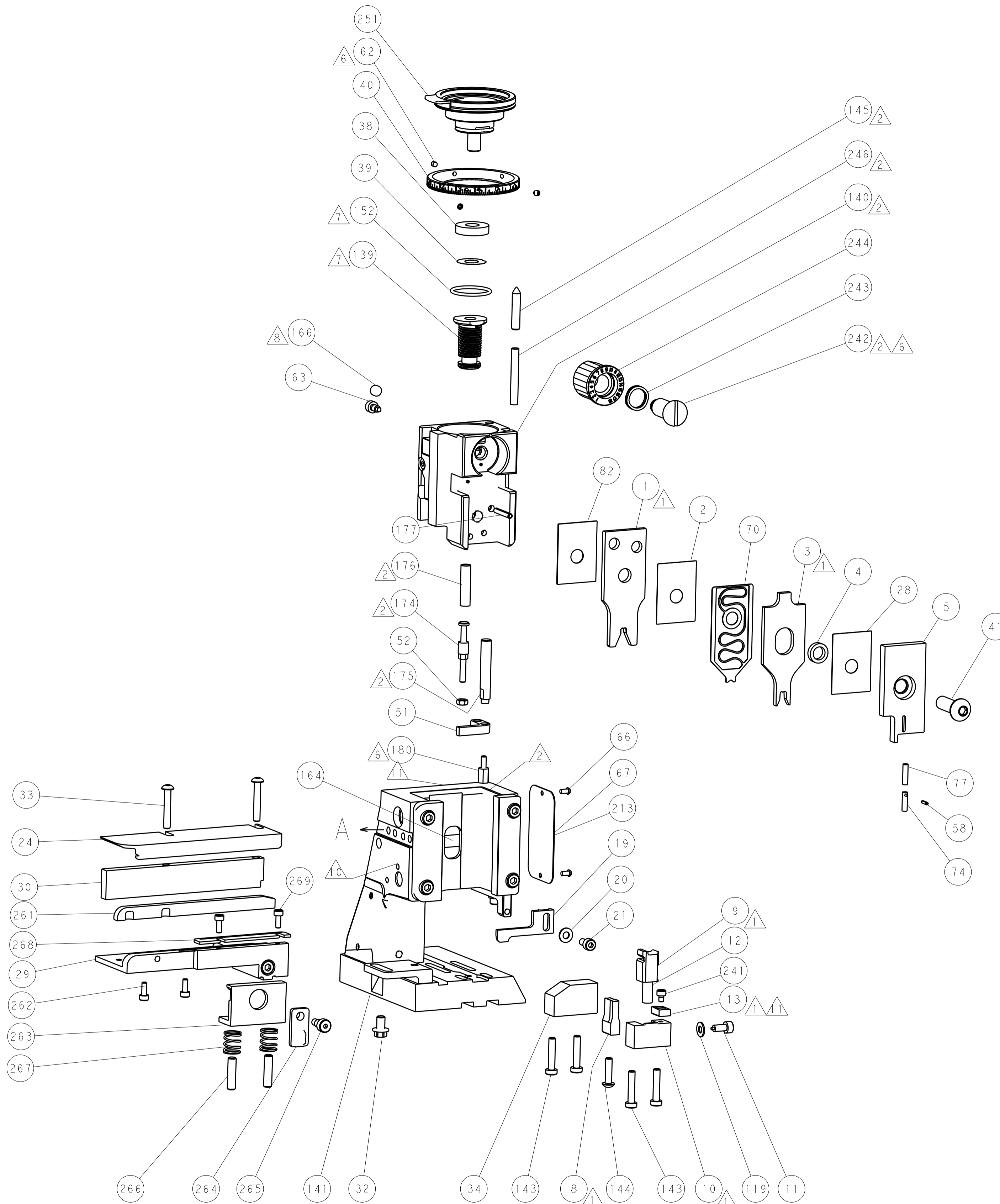
### SERVO LATCH PLATE



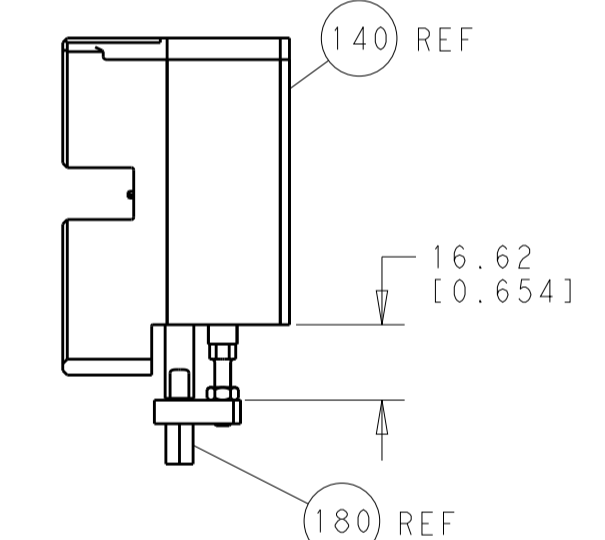
### CAM POSITION



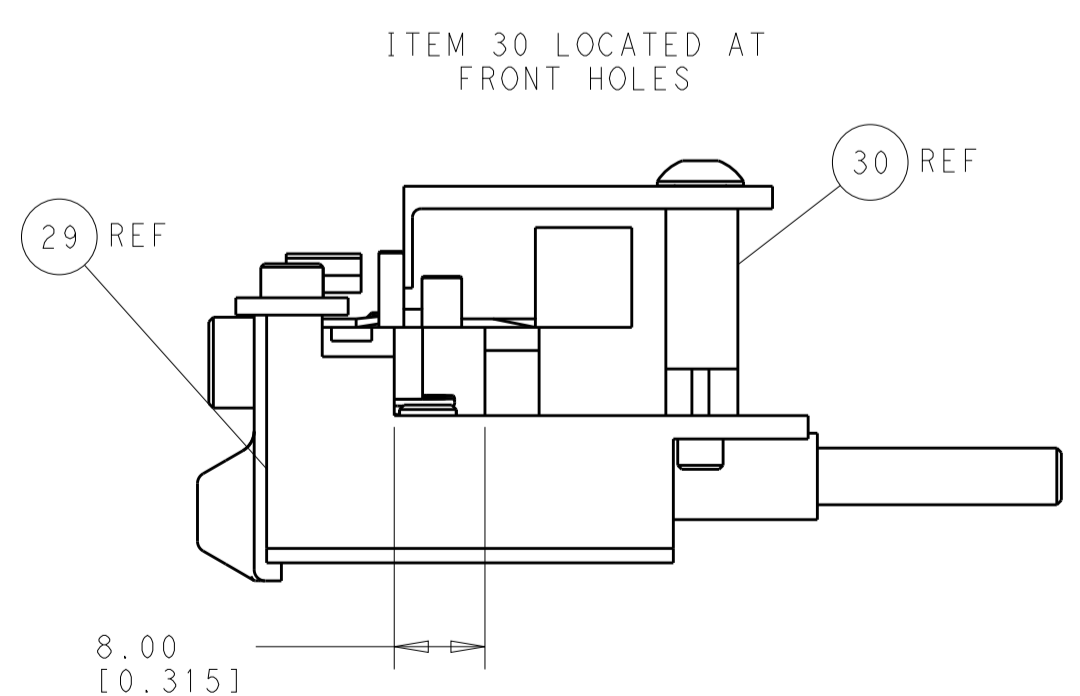
### AIR FEED



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)

|             |            |  |             |  |              |                              |                           |
|-------------|------------|--|-------------|--|--------------|------------------------------|---------------------------|
| DIMENSIONS: |            | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | DWN C. CHEN 09JUN2013                  |              | STE TE Connectivity          |                           |
| mm          | 0 PLC ±0.5 | 1 PLC ±0.5                             | 2 PLC ±0.13 | 3 PLC ±0.013                           | 4 PLC ±0.001 | APVD U. GUO 09JUN2013        | Harrisburg, PA 17105-3608 |
| MATERIAL:   |            | FINISH:                                |             | NAME                                   |              | Ocean Side Feed Applicator   |                           |
|             |            |  |             | SIZE CAGE CODE DRAWING NO              |              | RESTRICTED TO                |                           |
|             |            |  |             | A 00779 C=2151971                      |              | -                            |                           |
|             |            |  |             | Customer Accessible Production Drawing |              | SCALE 1:2 SHEET 4 OF 4 REV A |                           |