

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |             |           |   |                        |  |
|---|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-------------|-----------|---|------------------------|--|
|   |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |             |           |   |                        |  |
|   | 2151605-2   | G        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | -                                 | -                     | -           | -         | - | -                      |  |
|   | 2151605-5   | G        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | SERVO LATCH PLATE<br>2119951-1    | -                     | 8-2151605-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |  |
|   | 2151605-6   | G        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | SMART APPLICATOR<br>2161326-1     | -                     | 8-2151605-4 | -         | - | -                      |  |
|   | 2151605-7   | G        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -           | -         | - | -                      |  |
|   | 7-2151605-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -           | -         | - | -                      |  |
|   |             |          |                          |                                |                                   |                       |             |           |   |                        |  |
|   |             |          |                          |                                |                                   |                       |             |           |   |                        |  |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 4.06 mm [.160] | F    |
| INSUL           | 4.83 mm [.190] | F    |

APPLICATOR INSTRUCTIONS  
408-10389

| TERMINAL DATA: TE TERMINAL                        |             | TE CRIMP SPECIFICATION       |             |
|---|-------------|------------------------------|-------------|
| TERMINAL NAME: AMP MCP 6.3/4.8 K LITEALUM CONTACT |             |                              |             |
| WIRE STRIP LENGTH                                 |             | INSULATION DIAMETER RANGE    |             |
| 3.90-4.50 mm [.154-.177 IN]                       |             | Ø4.13-4.38 mm [.163-.172 IN] |             |
| TERMINAL APPLICATION SPECIFICATION                | 114-94204   |                              |             |
| TERMINALS APPLIED <sup>10</sup>                   |             |                              |             |
| TE TERMINAL                                       | TE TERMINAL | TE TERMINAL                  | TE TERMINAL |
| 2-2177840-1                                       |             |                              |             |

| WIRE SIZE           | CRIMP HEIGHT mm [INCH]  | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|-------------------------|--------------------------------|
| 6.00mm <sup>2</sup> | 2.10±0.04 [.0827±.0016] | 6.0                            |

- <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: 8-2151605-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151605-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151605-6
- 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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 99 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.
- <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
- <sup>13</sup> SET THE FINE CRIMP HEIGHT ADJUSTMENT HEAD TO PROPER CRIMP HEIGHT PRIOR TO TIGHTENING/LOCKING THE BRASS TIP SET SCREW, ITEM 99, AGAINST THE ADJUSTMENT BOLT THREADS.
- 14. APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

**\*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  | 2-1722335-1 | THREAD BOLT GEWINDEBOLZEN           | 268     |
| -   | -  | 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     |
| -   | 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 | 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)

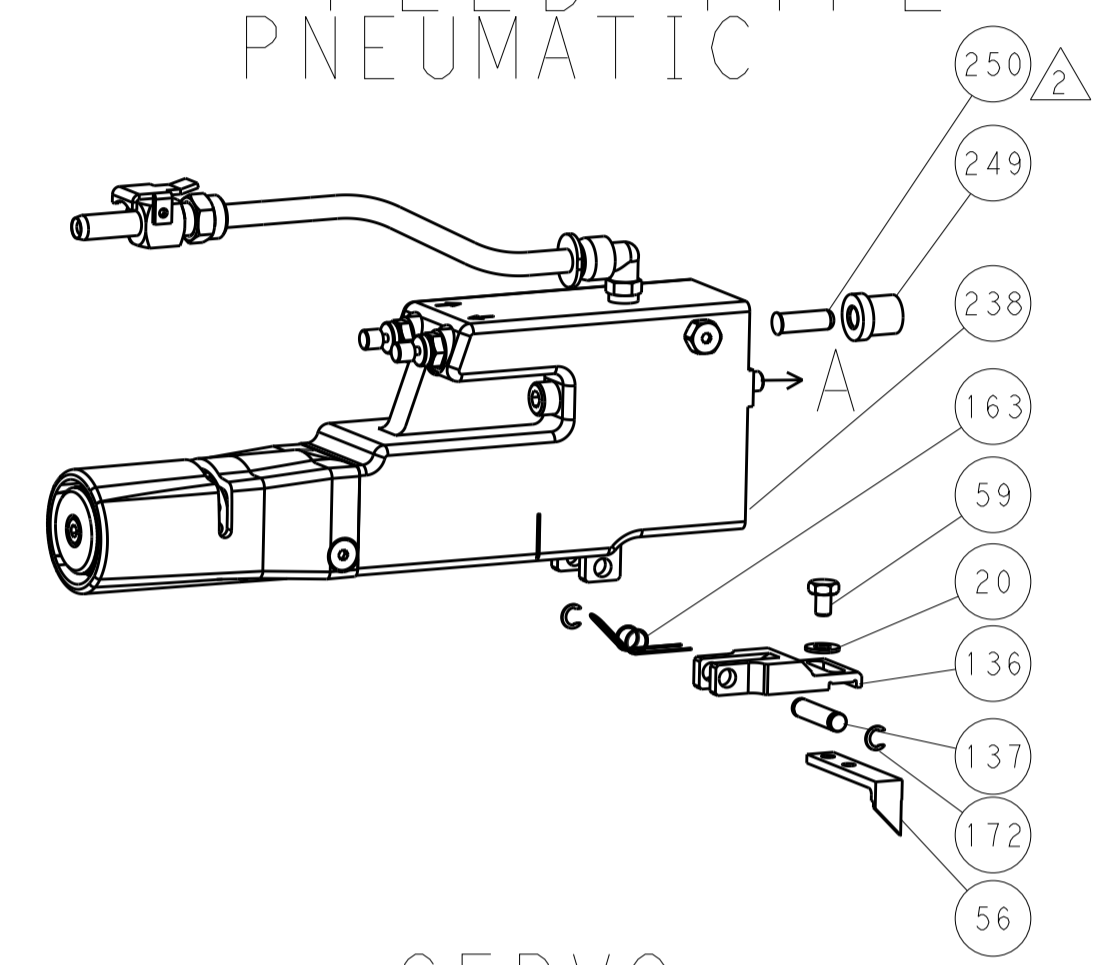
| SET UP GAUGE | LOC | DIST | REVISIONS |     |               |           |     |      |
|--------------|-----|------|-----------|-----|---------------|-----------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION   | DATE      | OWN | APVD |
|              |     |      | E         |     | ECR-16-000265 | 07JAN2016 | MR  | JDG  |
|              |     |      | F         |     | ECR-16-002618 | 23FEB2016 | KH  | CT   |
|              |     |      | G         |     | ECR-16-013599 | 23SEP2016 | JH  | CT   |

|     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1   | 2119082-3   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| -   | 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   | 2   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16       | 240     |
| -   | -   | -   | -   | 1   | 2063440-1   | AIR FEED MODULE                     | 238     |
| -   | -   | 1   | 1   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213     |
| -   | -   | 1   | 1   | -   | 1901094-3   | SPACER, FEEDER                      | 198     |
| -   | -   | -   | -   | 2   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172     |
| -   | 1   | 1   | 1   | 1   | 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   | 1-22281-8   | SPRING, COMPRESSION                 | 121     |
| -   | 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   | 2256587-1   | SCR, SET, SOFT TIP, M4              | 99      |
| -   | 1   | 1   | 1   | 1   | 1-690438-0  | FRONT STRIP GUIDE                   | 96      |
| -   | 2   | 2   | 2   | 2   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95      |
| -   | 1   | 1   | 1   | 1   | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 65      | 93      |
| -   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 1   | -   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| -   | 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   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62      |
| -   | 1   | 1   | 1   | 1   | 2-18032-5   | SCR, SET, FLT POINT M5 X 20.0       | 61      |
| -   | 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   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54      |
| -   | 2   | 2   | 2   | 2   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 53      |
| -   | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52      |
| -   | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51      |
| -   | 1   | 1   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 50      |
| -   | -   | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
| -   | 1   | 1   | 1   | 1   | 2-2119656-3 | 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   | 2119644-2   | RAM WASHER, PRECISION               | 38      |
| -   | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37      |
| -   | 1   | -   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35      |
| -   | 1   | 1   | 1   | 1   | 1-1752356-2 | 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   | 2-1320908-2 | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 1901086-1   | PLATE, STRIP GUIDE                  | 29      |
| -   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28      |
| -   | 2   | 2   | 2   | 2   | 22283-1     | SPRING, COMPRESSION                 | 27      |
| -   | 1   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 26      |
| -   | 1   | 1   | 1   | 1   | 1803142-1   | DRAG, TERMINAL                      | 25      |
| -   | 1   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24      |
| -   | 1   | 1   | 1   | 1   | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 23      |
| -   | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21      |
| -   | 2   | 2   | 2   | 2   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
| -   | 1   | 1   | 1   | 1   | 690472-2    | STRIPPER                            | 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   | 2161316-4   | ANVIL, COMBINATION                  | 8       |
| -   | 1   | 1   | 1   | 1   | 2-240641-9  | SPACER                              | 7       |
| -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 1-1722335-0 | SHEAR DEPRESSOR ASSEMBLY            | 5       |
| -   | 1   | 1   | 1   | 1   | 4-238011-5  | BLOCK, CRIMPER SPACER               | 4       |
| 1   | 1   | 1   | 1   | 1   | 1722335-9   | CRIMPER, INSULATION F               | 3       |
| -   | -   | -   | -   | -   | -           | -                                   | 2       |
| 1   | 1   | 1   | 1   | 1   | 2217303-1   | CRIMPER, WIRE, CONICAL BLEND        | 1       |
| -77 | -7  | -6  | -5  | -2  | PART NO     | DESCRIPTION                         | ITEM NO |

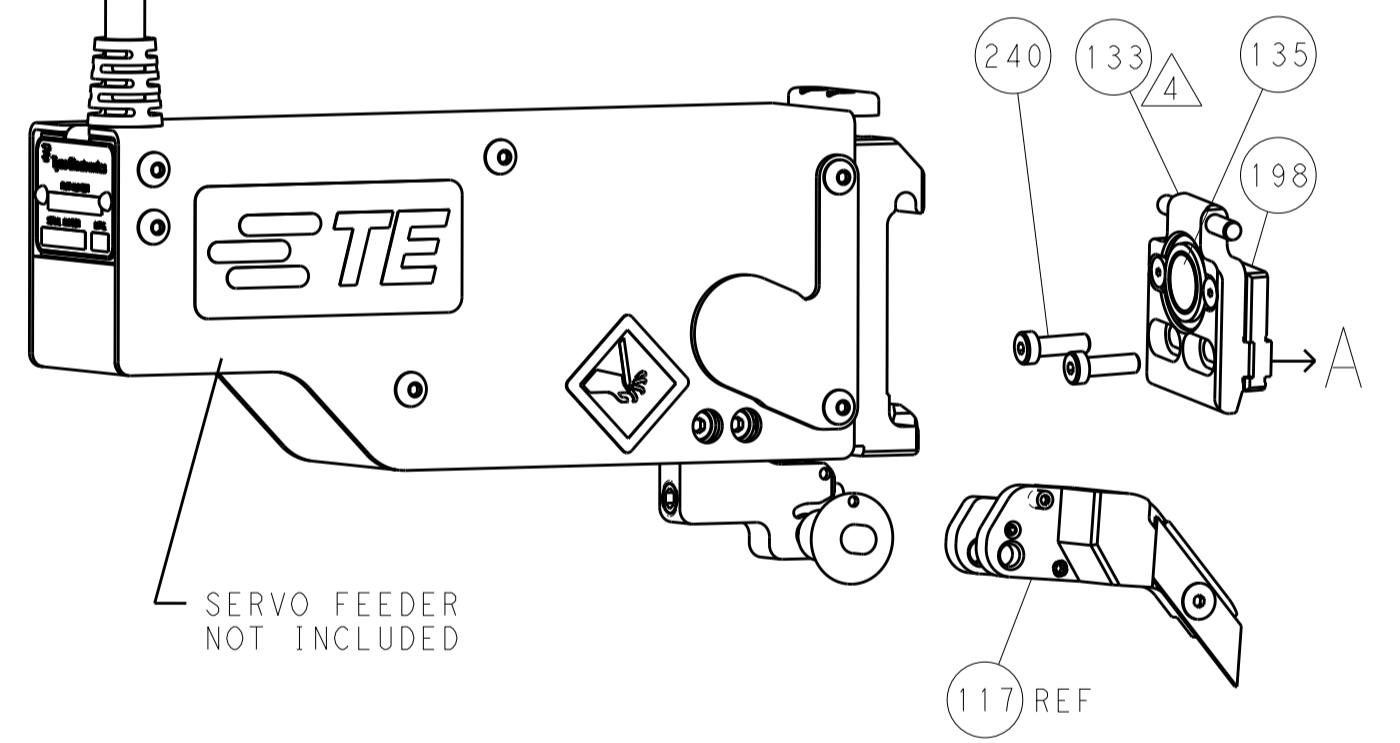
| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | OWN                                    |         | CHK                |         | APVD                  |         |
|-------------|---------|--|---------|--|---------|--------------------|---------|-----------------------|---------|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                                | 4 PLC ± | 5 PLC ±            | 6 PLC ± | 7 PLC ±               | 8 PLC ± |
|             | FINISH  |  |         | R. KNEPPER 18JAN2012                   |         | T. ELBIN 18JAN2012 |         | M. CLIFFORD 18JAN2012 |         |
| MATERIAL    |         |  |         | NAME                                   |         | PRODUCT SPEC       |         | APPLICATION SPEC      |         |
|             |         |  |         | Ocean Side Feed Applicator             |         |                    |         |                       |         |
|             |         |  |         | SIZE                                   |         | CAGE CODE          |         | DRAWING NO            |         |
|             |         |  |         | A1                                     |         | 00779              |         | C=2151605             |         |
|             |         |  |         | WEIGHT                                 |         | RESTRICTED TO      |         |                       |         |
|             |         |  |         | Customer Accessible Production Drawing |         | SCALE              |         | SHEET 1 OF 4 REV G    |         |

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

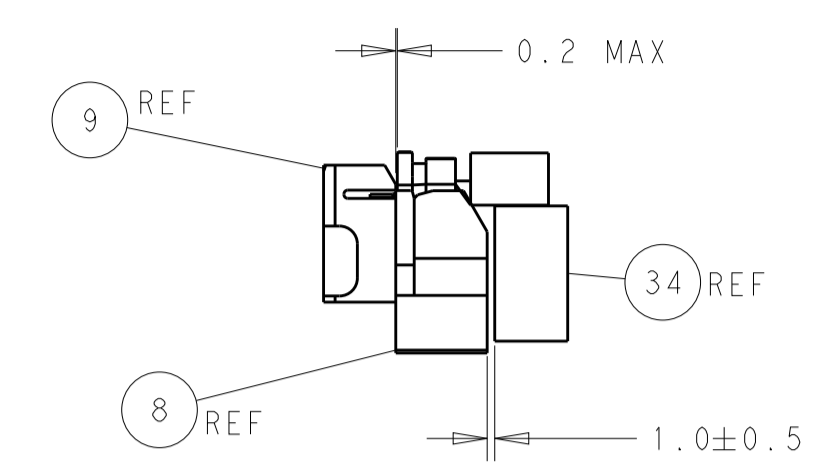
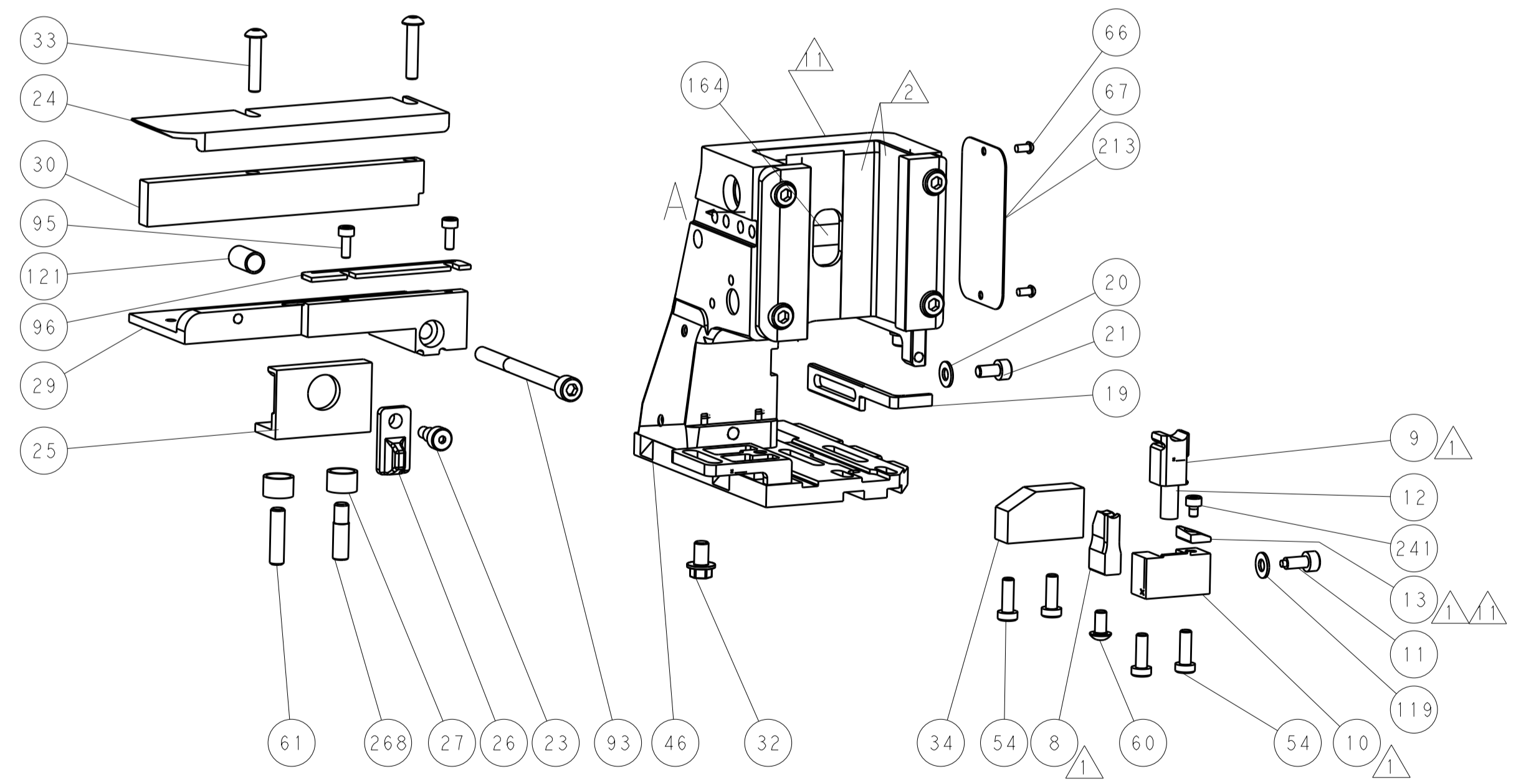
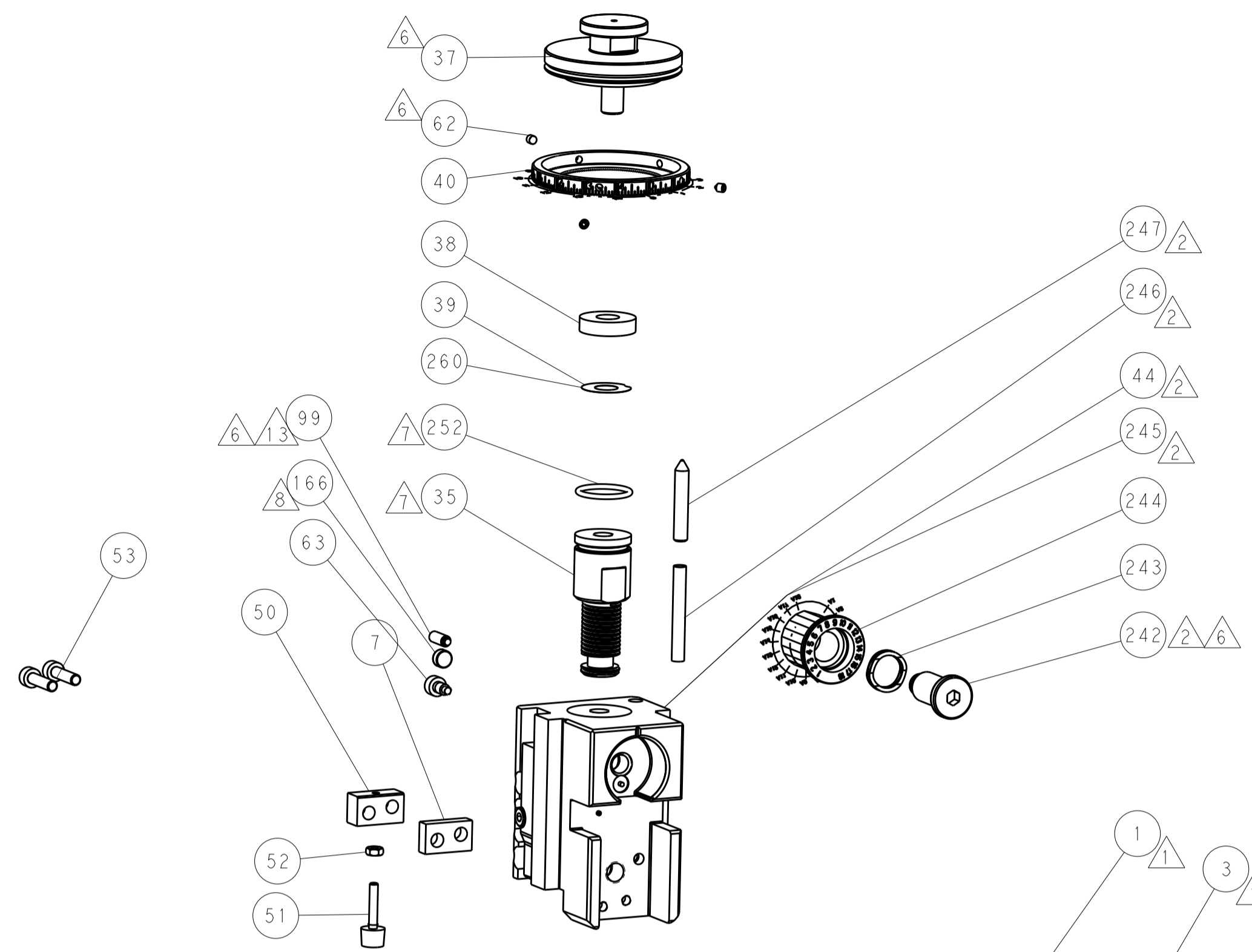
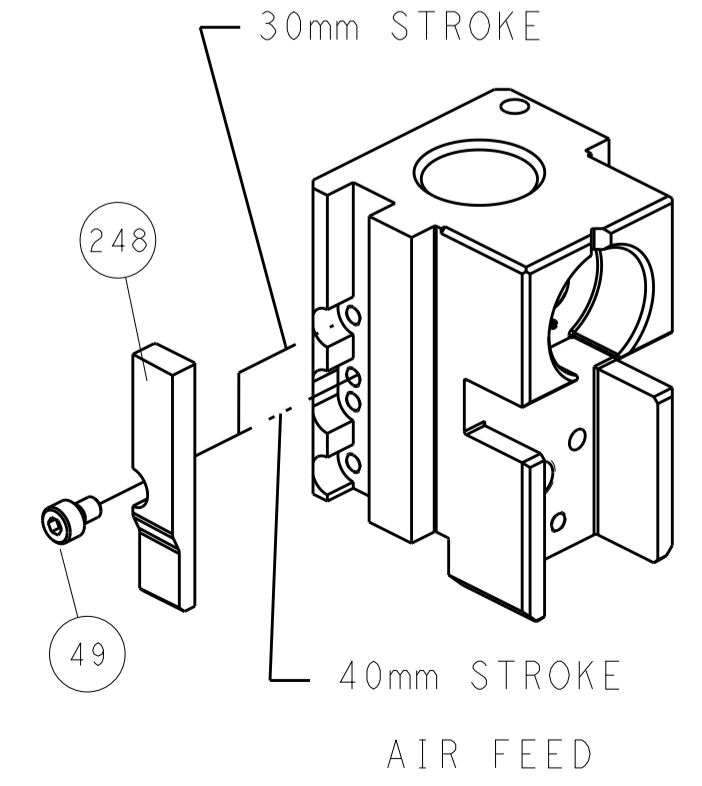
### FEED TYPE PNEUMATIC



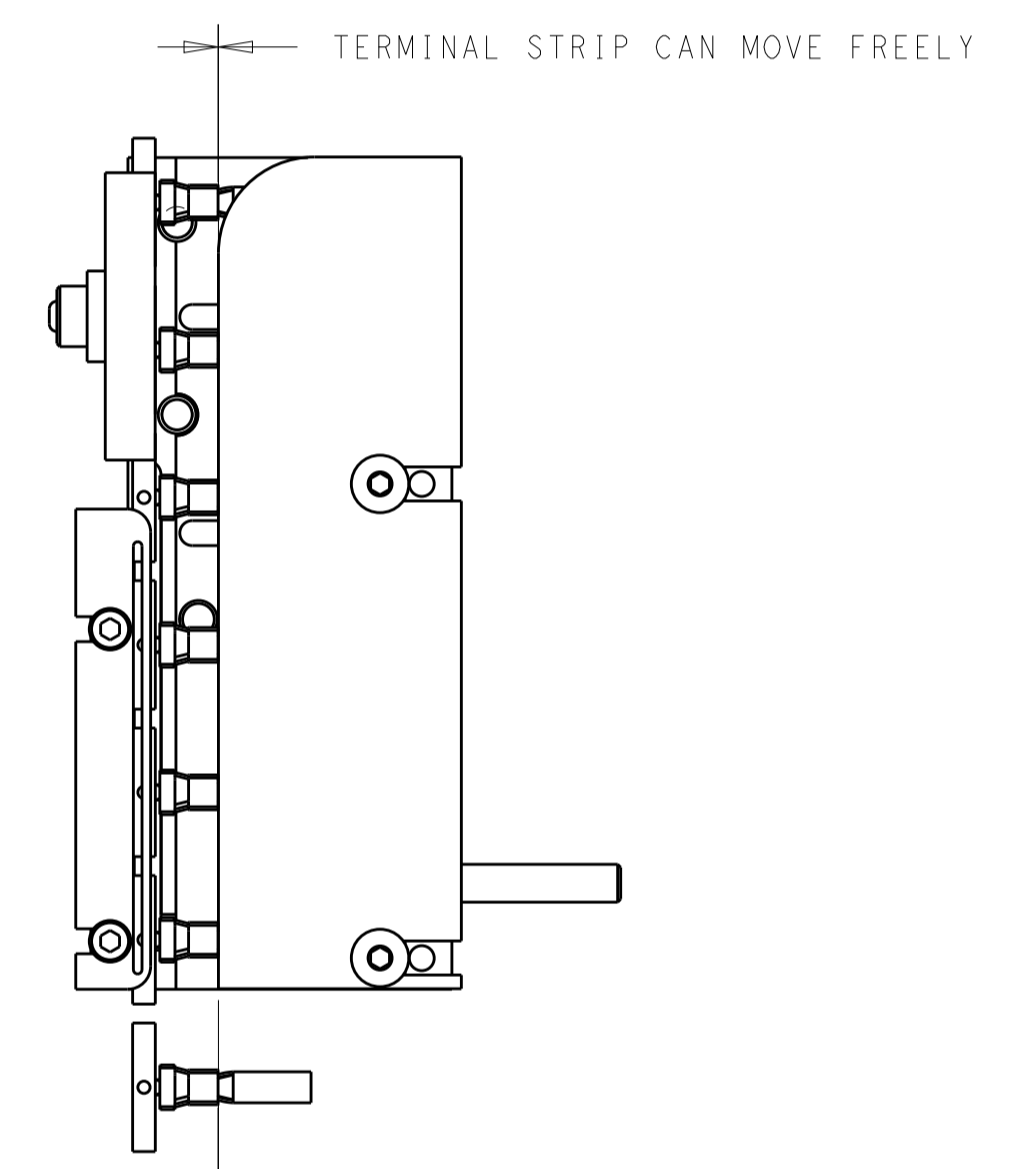
### SERVO LATCH PLATE



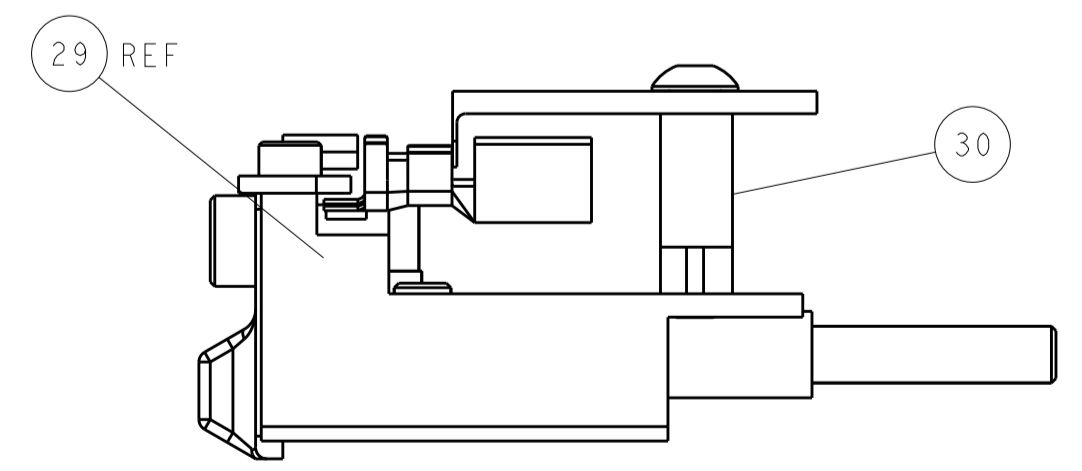
### CAM POSITIONS



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY WIRE 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: |         | OWN: R. KNEPPER 18JAN2012              |         | TE Connectivity                  |  |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                                | 4 PLC ± | Harrisburg, PA 17105-3608        |  |
| MATERIAL:   |         | FINISH:                                |         | CHK: T. ELBIN 18JAN2012                |         | NAME: Ocean Side Feed Applicator |  |
|             |         |  |         | APVD: M. CLIFFORD 18JAN2012            |         | PRODUCT SPEC:                    |  |
|             |         |  |         | APPLICATION SPEC:                      |         | SIZE: CAGE CODE: DRAWING NO:     |  |
|             |         |  |         | WEIGHT:                                |         | RESTRICTED TO:                   |  |
|             |         |  |         | Customer Accessible Production Drawing |         | SCALE: 1:2 SHEET 2 OF 4 REV G    |  |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART  |                       |           |             |           |                        |
|--|-------------|--------------------------|--------------------------|-------------------|------------------------------------|-----------------------|-----------|-------------|-----------|------------------------|
|  |             |                          |                          |                   | CONVERT TO                         | PART NUMBERS REQUIRED |           |             |           |                        |
|  | 2-2151605-2 | G                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | -                                  | -                     | -         | -           | -         | -                      |
|  |             |                          |                          |                   | SERVO LATCH PLATE SMART APPLICATOR | 2119951-1             | -         | 8-2151605-5 | 1901094-3 | 2168400-6 (QUANTITY 2) |
|  | 2-2151605-5 | G                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | -                                  | -                     | -         | -           | -         | -                      |
|  |             |                          |                          |                   | PNEUMATIC FEED                     | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1              |
| 2-2151605-7                                  | G           | FINE CRIMP HEIGHT ADJUST | NONE                     | -                 | -                                  | -                     | -         | -           | -         | -                      |
| 7-2151605-7                                  | A           | CRIMP TOOLING KIT        | -                        | -                 | -                                  | -                     | -         | -           | -         | -                      |

| APPLICATOR DATA                   |                  |      |
|-----------------------------------|------------------|------|
| CRIMP WIRE                        | SIZE             | TYPE |
|                                   | 4.06 mm [ .160 ] | F    |
| INSUL                             | 4.83 mm [ .190 ] | F    |
| APPLICATOR INSTRUCTIONS 408-10389 |                  |      |

| TERMINAL DATA: TE TERMINAL                        |             | TE CRIMP SPECIFICATION         |             |
|---|-------------|--------------------------------|-------------|
| TERMINAL NAME: AMP MCP 6.3/4.8 K LITEALUM CONTACT |             |                                |             |
| WIRE STRIP LENGTH                                 |             | INSULATION DIAMETER RANGE      |             |
| 3.90-4.50 mm [ .154-.177 IN ]                     |             | Ø4.13-4.38 mm [ .163-.172 IN ] |             |
| TERMINAL APPLICATION SPECIFICATION                | 114-94204   | -                              | -           |
| TERMINALS APPLIED                                 |             |                                |             |
| TE TERMINAL                                       | TE TERMINAL | TE TERMINAL                    | TE TERMINAL |
| 2-2177840-1                                       |             |                                |             |

| WIRE SIZE           | CRIMP HEIGHT mm [INCH]    | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|---------------------------|--------------------------------|
| 6.00mm <sup>2</sup> | 2.10±0.04 [ .0827±.0016 ] | 6.0                            |

- 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: 8-2151605-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151605-5
- 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.  
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 99 & 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.
- SET THE FINE CRIMP HEIGHT ADJUSTMENT HEAD TO PROPER CRIMP HEIGHT PRIOR TO TIGHTENING/LOCKING THE BRASS TIP SET SCREW, ITEM 99, AGAINST THE ADJUSTMENT BOLT THREADS.
- 13. APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

**\*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   | 2-1722335-1 | THREAD BOLT GEWINDEBOLZEN           | 268     |
| -   | 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   | 1-22279-3   | SPRING, COMPRESSION                 | 246     |
| -   | 1   | 1   | 1   | 2119082-3   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| -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)

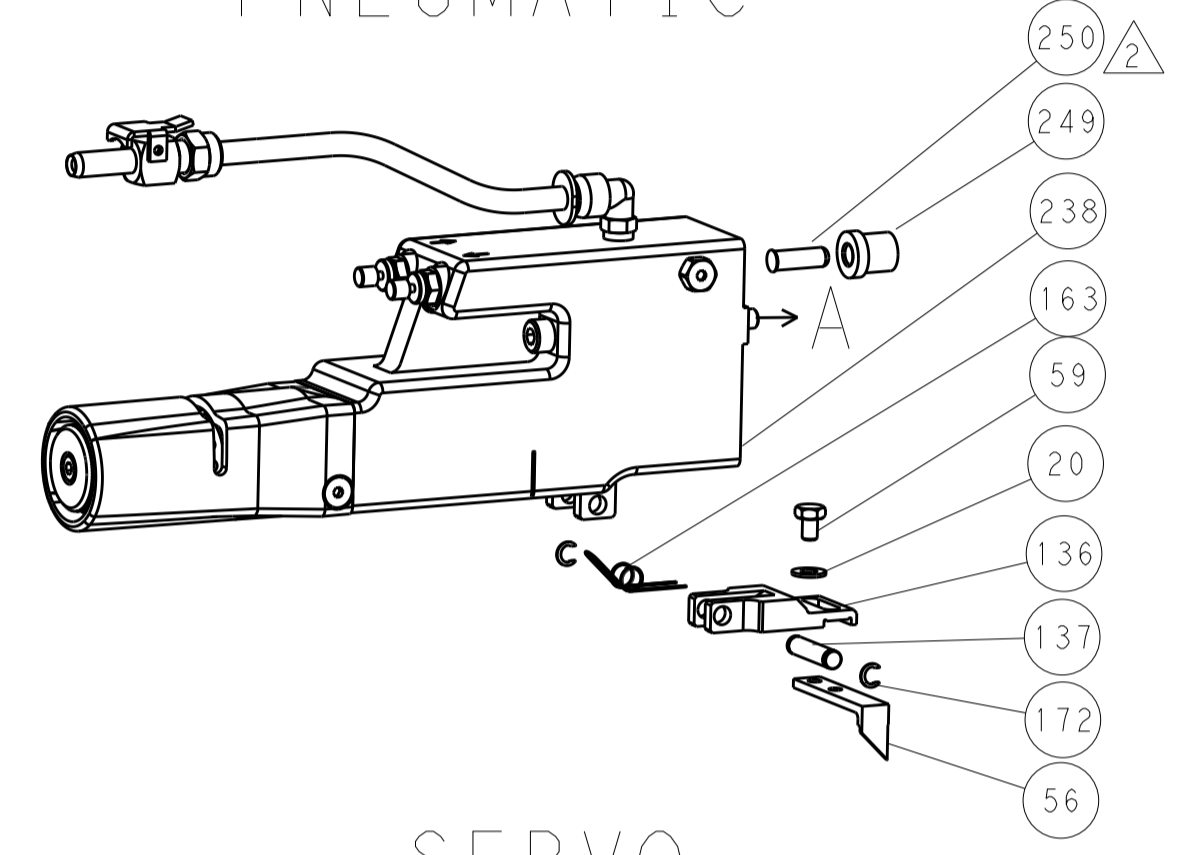
| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |      |     |      |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION | DATE | OWN | APVD |
|              |     |      | -         | -   | SEE SHEET 1 | -    | -   | -    |

|     |     |     |     |         |             |                                     |     |
|-----|-----|-----|-----|---------|-------------|-------------------------------------|-----|
|     | -   | 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 |
|     | -   | -   | -   | 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       | 2-2119656-4 | 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       | 1-22281-8   | SPRING, COMPRESSION                 | 121 |
|     | -   | 1   | 1   | 1       | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
|     | -   | -   | REF | -       | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117 |
|     | -   | 1   | 1   | 1       | 2256587-1   | SCR, SET, SOFT TIP, M4              | 99  |
|     | -   | 1   | 1   | 1       | 1-690438-0  | FRONT STRIP GUIDE                   | 96  |
|     | -   | 2   | 2   | 2       | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95  |
|     | -   | 1   | 1   | 1       | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 65      | 93  |
|     | -   | 1   | 1   | 1       | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
|     | -   | 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   | 1   | 1       | 2-18032-5   | SCR, SET, FLT POINT M5 X 20.0       | 61  |
|     | -   | -   | -   | 1       | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
|     | -   | -   | -   | 1       | 1338685-1   | PAWL, FEED                          | 56  |
|     | -   | 2   | 2   | 2       | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 53  |
|     | -   | 1   | 1   | 1       | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52  |
|     | -   | 1   | 1   | 1       | 811242-5    | BUMPER, HOLD DOWN                   | 51  |
|     | -   | 1   | 1   | 1       | 690753-2    | SPACER, TONKER                      | 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       | 2119644-2   | RAM WASHER, PRECISION               | 38  |
|     | -   | 1   | 1   | 1       | 1-1752356-2 | 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       | 1901086-1   | PLATE, STRIP GUIDE                  | 29  |
|     | -   | 1   | 1   | 1       | 1-455888-0  | SPACER, CRIMPER                     | 28  |
|     | -   | 2   | 2   | 2       | 22283-1     | SPRING, COMPRESSION                 | 27  |
|     | -   | 1   | 1   | 1       | 356835-1    | LEVER, DRAG RELEASE                 | 26  |
|     | -   | 1   | 1   | 1       | 1803142-1   | DRAG, TERMINAL                      | 25  |
|     | -   | 1   | 1   | 1       | 1320928-2   | STRIP GUIDE                         | 24  |
|     | -   | 1   | 1   | 1       | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 23  |
|     | -   | 1   | 1   | 1       | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
|     | -   | 2   | 2   | 2       | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
|     | -   | 1   | 1   | 1       | 690472-2    | STRIPPER                            | 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       | 462006-6    | FLOATING SHEAR, FRONT               | 9   |
|     | 1   | 1   | 1   | 1       | 2161316-4   | ANVIL, COMBINATION                  | 8   |
|     | -   | 1   | 1   | 1       | 2-240641-9  | SPACER                              | 7   |
|     | -   | -   | -   | -       | -           | -                                   | 6   |
|     | -   | 1   | 1   | 1       | 1-1722335-0 | SHEAR DEPRESSOR ASSEMBLY            | 5   |
|     | -   | 1   | 1   | 1       | 4-238011-5  | BLOCK, CRIMPER SPACER               | 4   |
|     | 1   | 1   | 1   | 1       | 1722335-9   | CRIMPER, INSULATION F               | 3   |
|     | -   | -   | -   | -       | -           | -                                   | 2   |
|     | 1   | 1   | 1   | 1       | 2217303-1   | CRIMPER, WIRE, CONICAL BLEND        | 1   |
| -77 | -27 | -25 | -22 | PART NO | DESCRIPTION | ITEM NO                             |     |

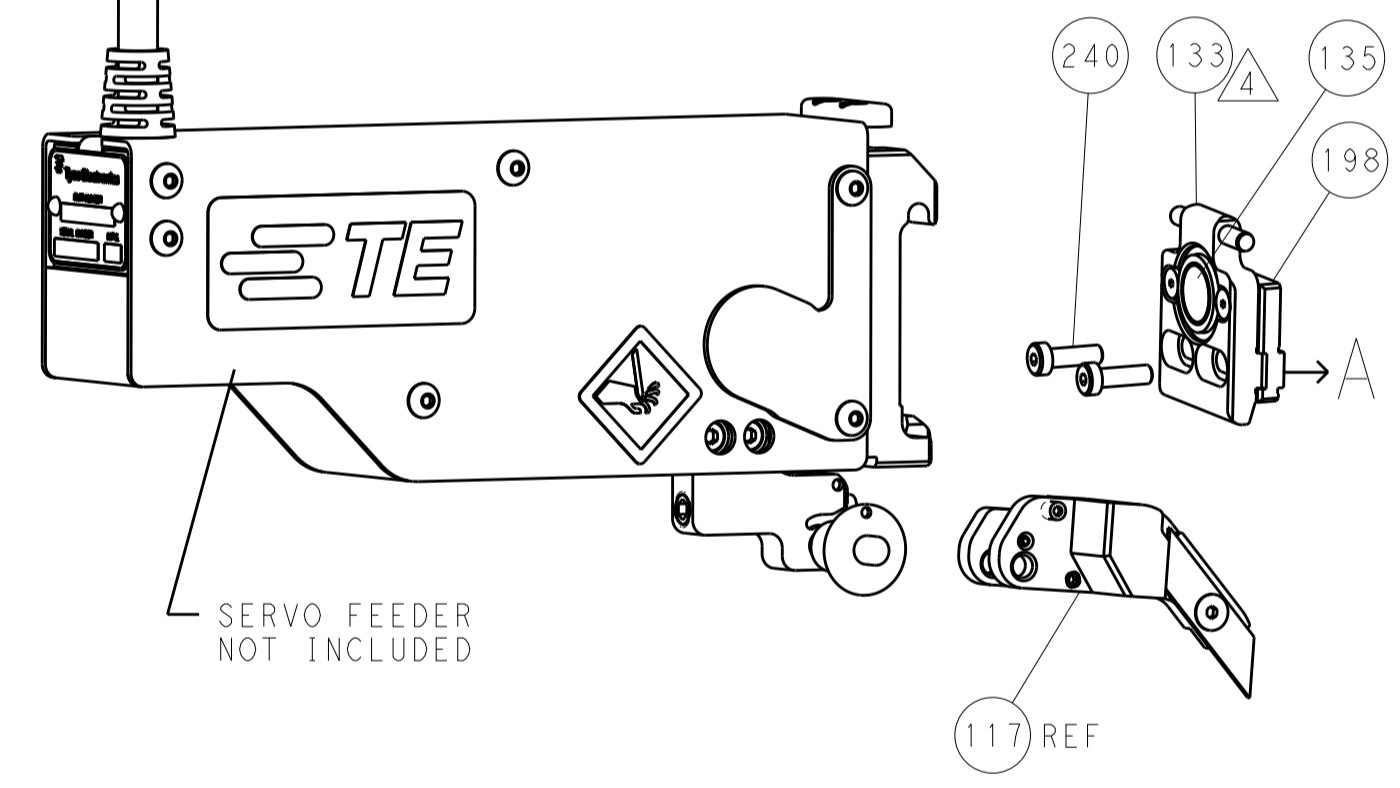
| DIMENSIONS:                            |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | APPROVED: |           | NAME:      |               |
|--|---------|--|---------|-----------|-----------|------------|---------------|
| mm                                     | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±   | 4 PLC ±   | 5 PLC ±    | ANGLES ±      |
|  | FINISH  |  |         |           |           |            |               |
| MATERIAL                               |         | WEIGHT                                 |         | SIZE      | CAGE CODE | DRAWING NO | RESTRICTED TO |
|  |         |  |         | A1        | 00779     | ©=2151605  |               |
| Customer Accessible Production Drawing |         |  |         | SCALE     | 1:2       | SHEET      | 3 OF 4        |

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

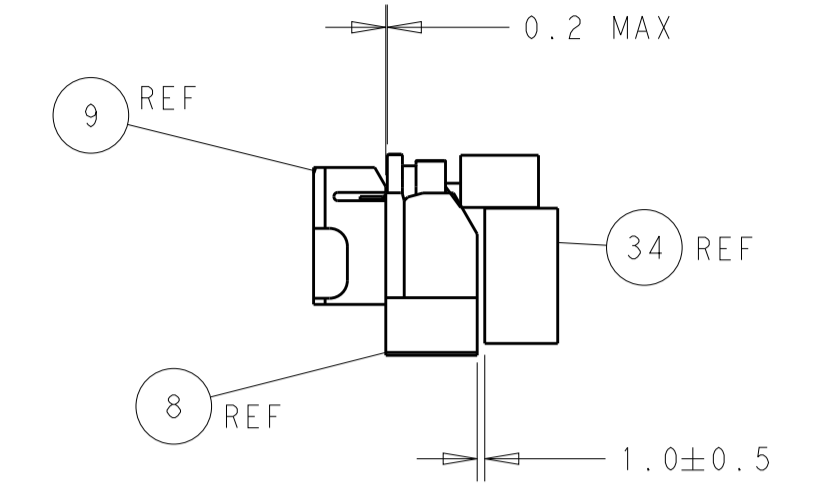
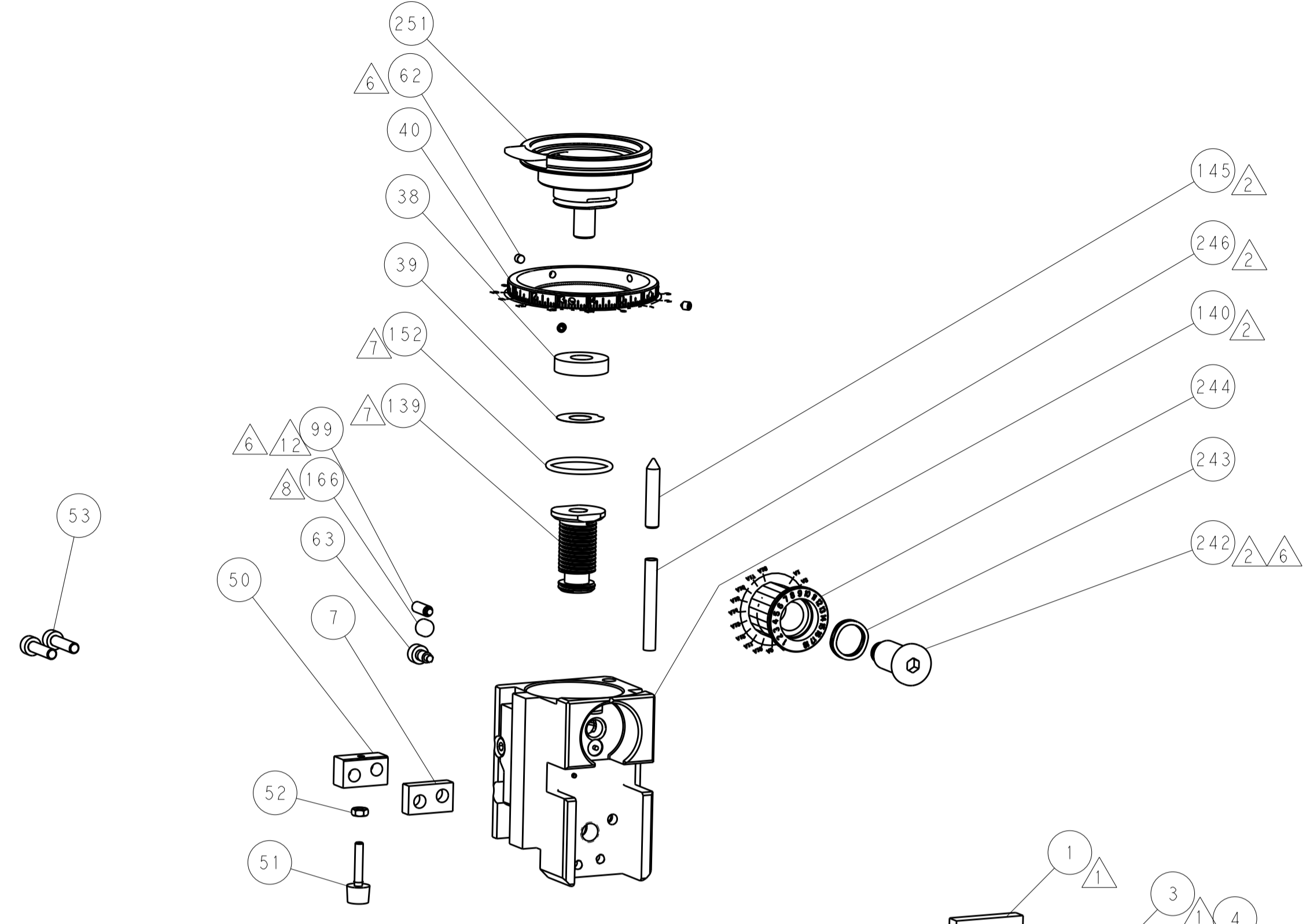
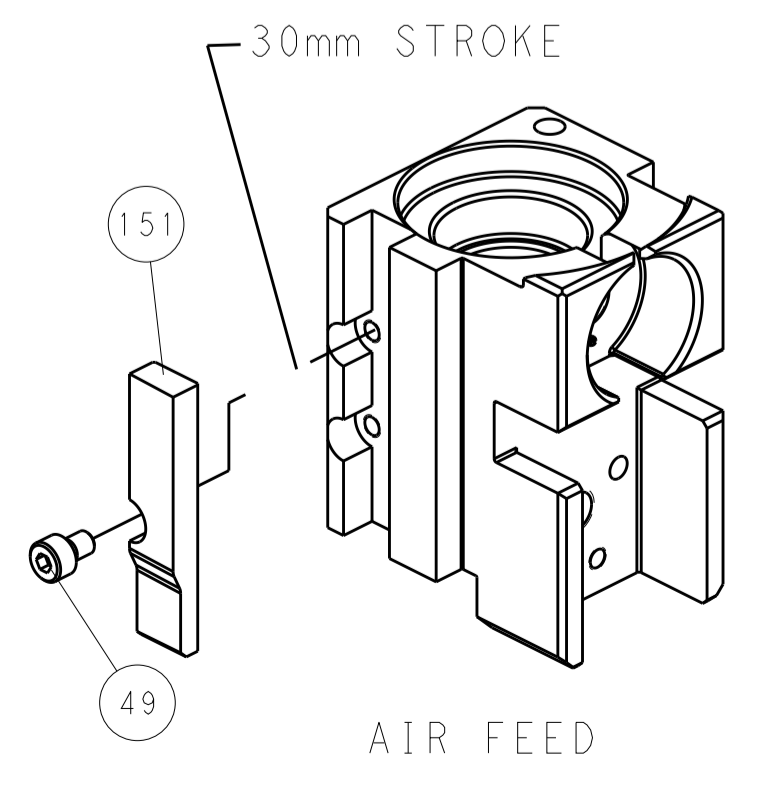
### FEED TYPE PNEUMATIC



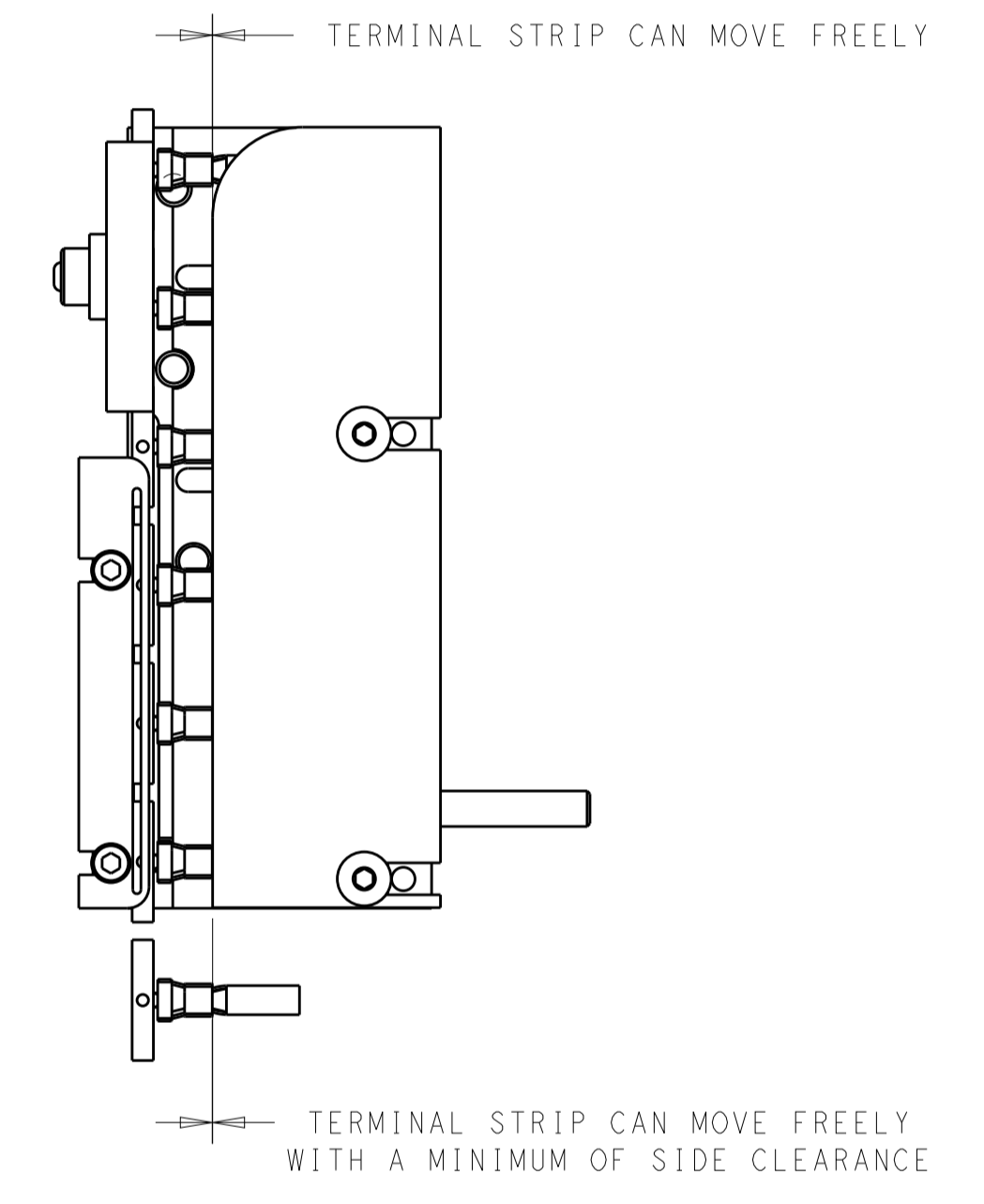
### SERVO LATCH PLATE



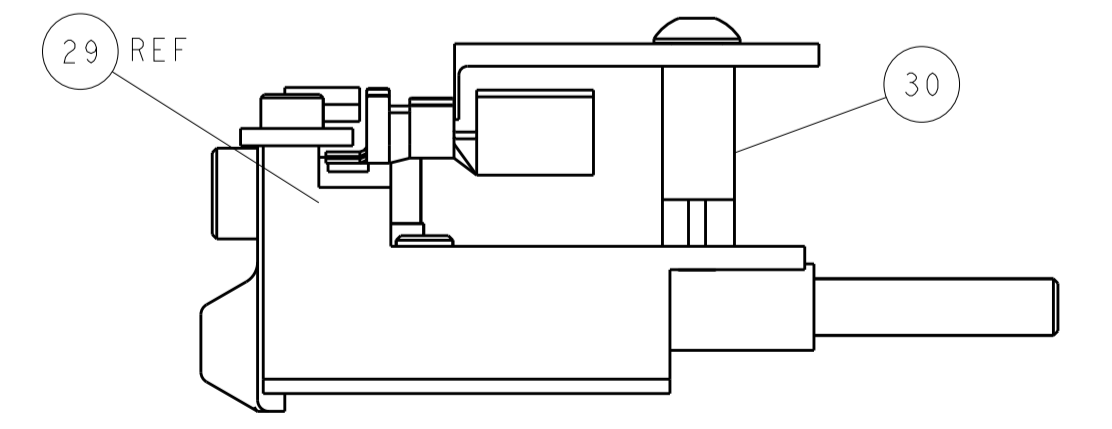
### CAM POSITIONS



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY WIRE 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 UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>  |  | DWN: R. KNEPPER 18JAN2012<br>CHK: T. ELBIN 18JAN2012<br>APVD: M. CLIFFORD 18JAN2012 | NAME: TE Connectivity<br>Harrisburg, PA 17105-3608   |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ± |  | PRODUCT SPEC:<br>APPLICATION SPEC:<br>WEIGHT:<br>MATERIAL:                          | NAME: Ocean Side Feed Applicator<br>SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: 2151605<br>SCALE: 1:2<br>SHEET: 4 OF 4<br>REV: G |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING  |  | RESTRICTED TO:  |  |