

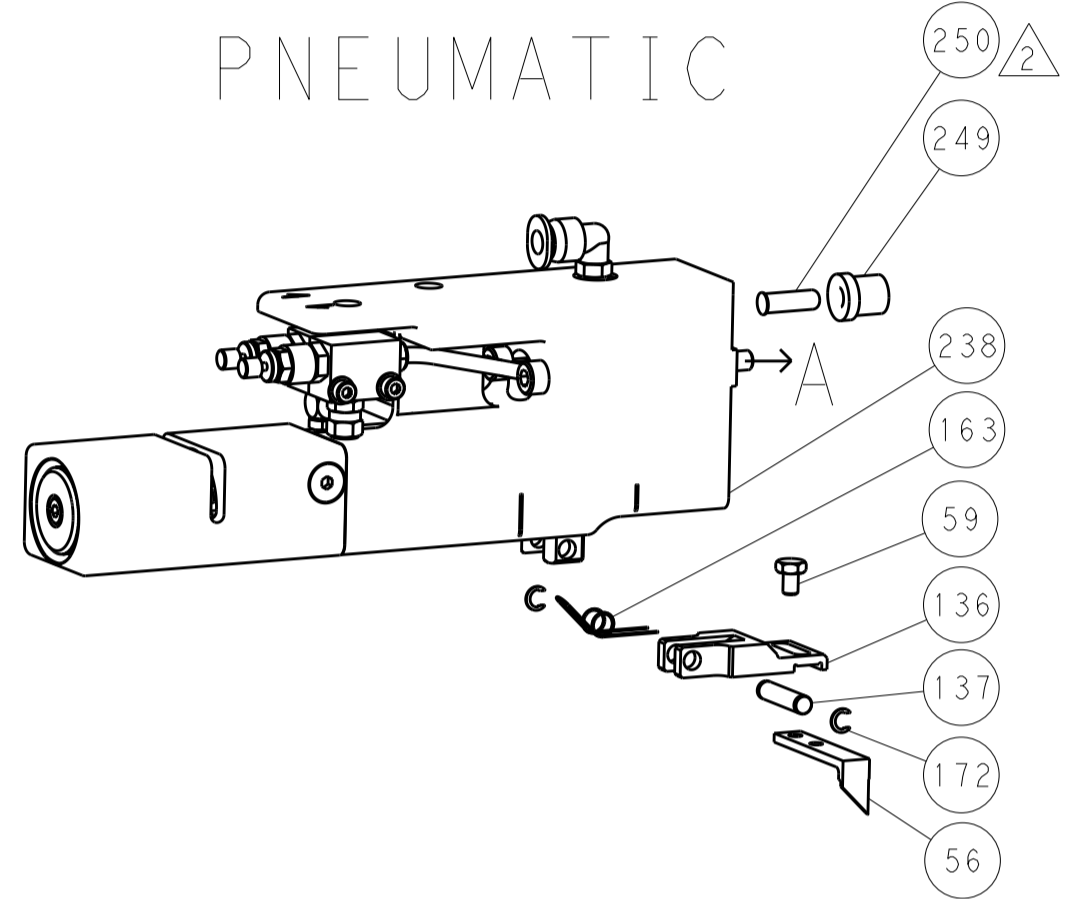


LOC		DIST		REVISIONS			
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1			

### FEED TYPE MECHANICAL



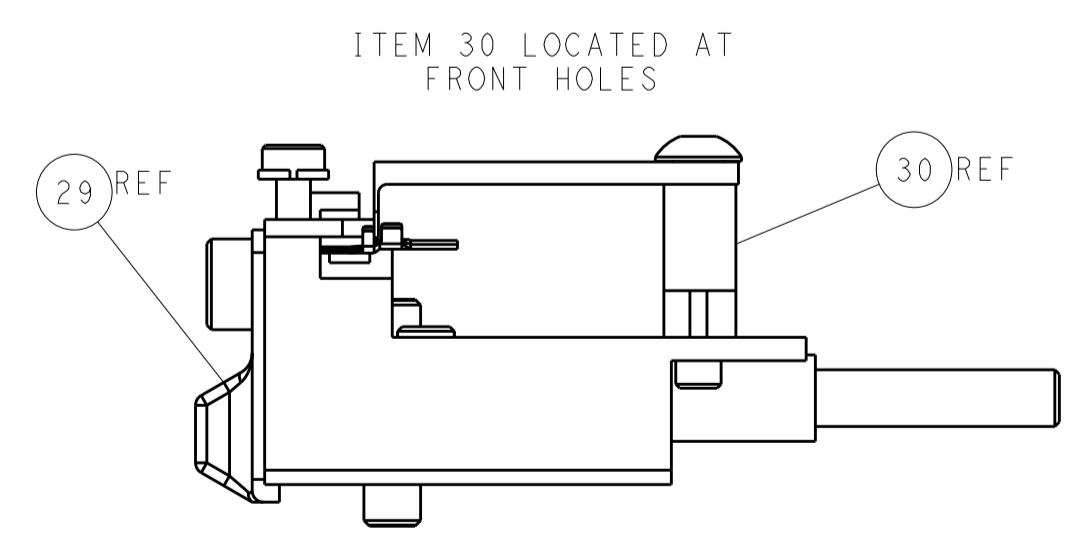
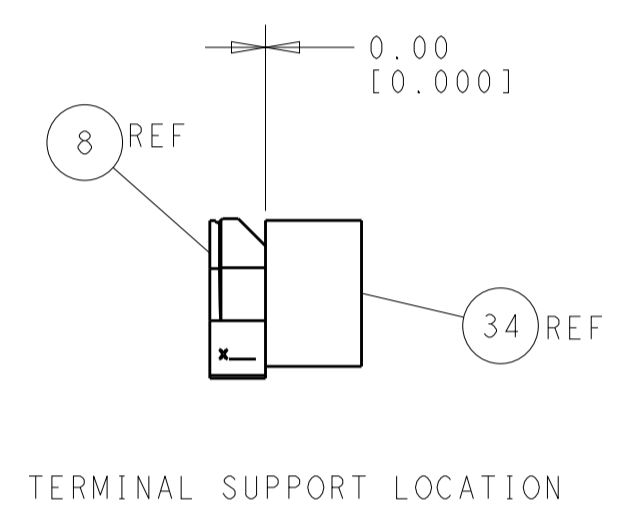
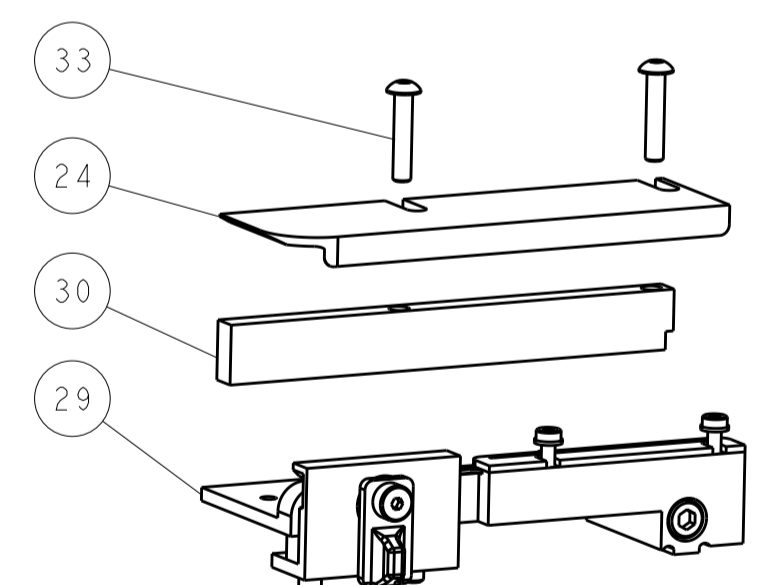
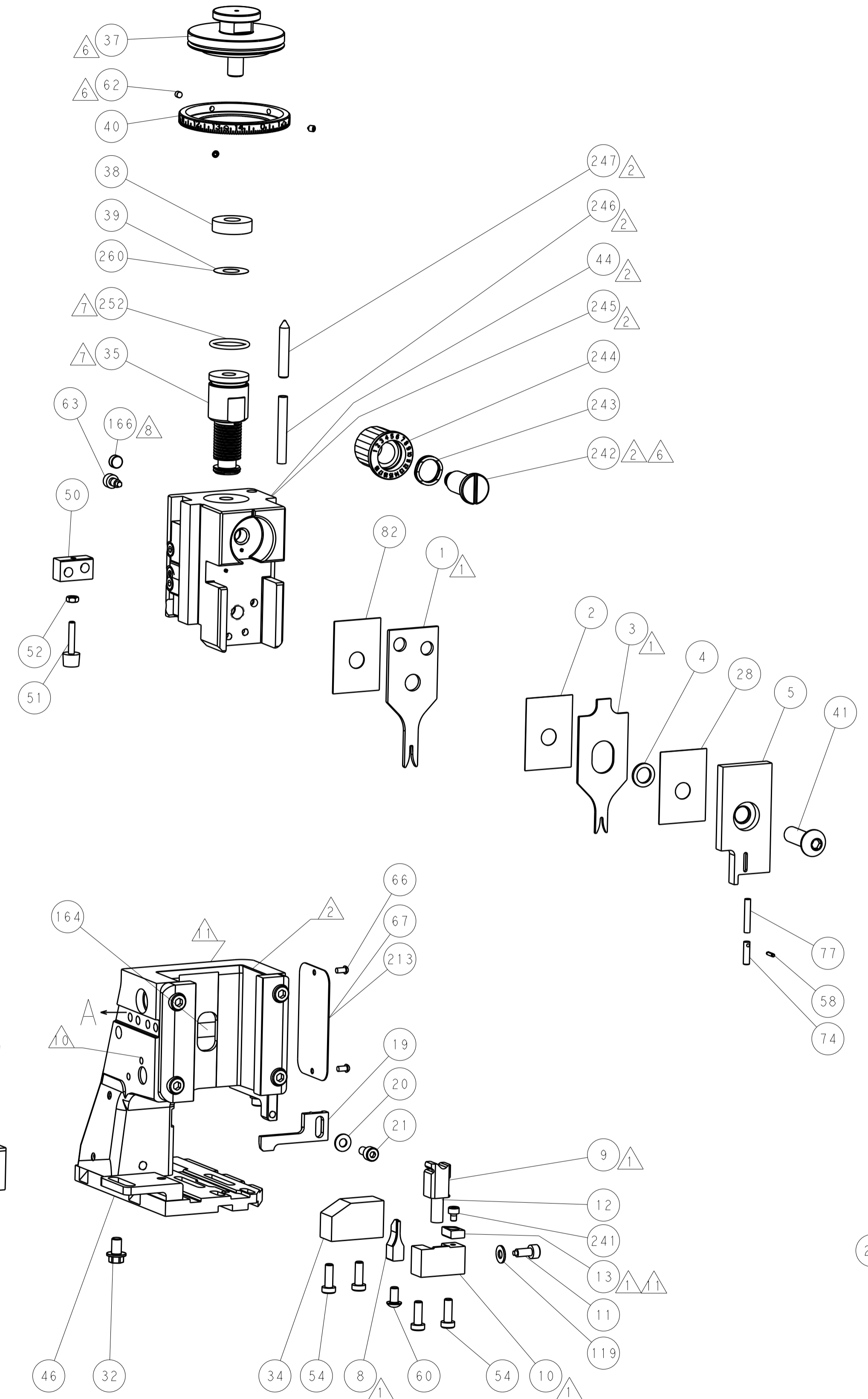
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



**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:		DWG: HOFFNER 12FEB2013		TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	ANGLES ±	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:				FINISH:		NAME: Ocean Side Feed Applicator	
Customer Accessible Production Drawing				SCALE: 1:1		SHEET 2 of 4 REV A	

SET UP GAUGE 2119599-1 LOC A DIST 66 REVISIONS  
REV. LTR. DESCRIPTION DATE DWN. APVD.  
- - SEE SHEET 1 - - - -

APPLICATOR STYLE CONVERSION CHART  
PACIFIC VERSION TERMINATOR INTERFACE ADAPTER  
PART NUMBER REVISION DESCRIPTION FEED TYPE  
CONVERT TO PART NUMBERS REQUIRED  
PNEUMATIC FEED 2119950-1 1338685-1 5-18022-5 2119641-2 2119799-1 2063440-1  
SERVO LATCH PLATE 2119951-1 - 8-2151689-5 1901094-3 - 2168400-6 (QUANTITY 2)  
SMART APPLICATOR 2161326-1 - 8-2151689-4 - - - -

APPLICATOR DATA  
CRIMP SIZE TYPE  
WIRE 1.40 mm [.055] F  
INSUL 1.57 mm [.062] O  
APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION  
TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE  
WIRE STRIP LENGTH 2.12-2.88 mm [.083-.113 IN]  
INSULATION DIAMETER RANGE Ø1.27-1.52 mm [.050-.060 IN]  
TERMINAL APPLICATION SPECIFICATION 114-19051  
TERMINALS APPLIED  
TE TERMINAL TE TERMINAL TE TERMINAL TE TERMINAL  
338097-1 1-338097-1 9-338097-1

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING  
20 AWG 0.76+/-0.05 [.030+/-0.002] 7.8  
22 AWG 0.76+/-0.05 [.030+/-0.002] 7.8  
24 AWG 0.76+/-0.05 [.030+/-0.002] 7.8

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- 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: 8-2151689-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151689-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151689-5
- 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 & 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.

CONVERSION TABLE  
- 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  
-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)

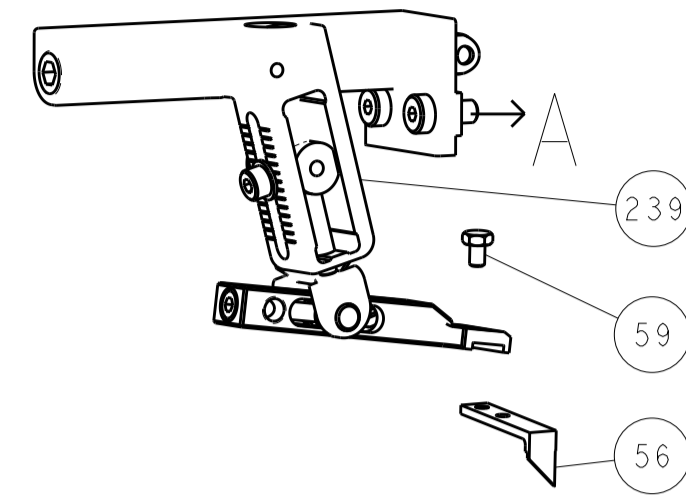
ITEM NO. DESCRIPTION DATE  
1-22279-3 SPRING, COMPRESSION 246  
2119082-9 RING, RETAIN, EXTERN, 3/16 CRESCENT 244  
2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST 243  
2119083-1 RETAINER, INSULATION DIAL 242  
7-18023-7 SCR, SKT HD CAP M3 X 4.0 241  
2168400-6 SHCS, LOW HEAD, RoHS, M5 X 16 240  
2119580-1 MECHANICAL FEED ASSEMBLY 239  
2063440-1 AIR FEED MODULE 238  
2119740-2 TAG, IDENTIFICATION 213  
1901094-3 SPACER, FEEDER 198  
21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT 172  
994969-1 MAGNET, RARE EARTH HIGH ENERGY 166  
994970-2 COUNTER, MAGNETIC 164  
240638-1 SPRING, FEED FINGER 163  
8-21084-1 O-RING, .801 ID, .070 DIA. MAT. 152  
2119641-2 FEED CAM, AIR FEED 151  
2119798-2 DETENT PIN 145  
2079383-8 SCR, BHSC, RoHS (M4 X 16) 144  
2168400-5 SHCS, LOW HEAD, RoHS, M4 X 20 143  
2119653-2 FEED CAM, POST FEED 142  
1-2119656-0 APPLICATOR BASIC ASSEMBLY, SF 141  
2119650-1 RAM, ASIAN STYLE, SIDE FEED 140  
2119092-2 BOLT, ADJUSTMENT 139  
3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854 137  
2119799-1 HOLDER, FEED FINGER, AF 136  
SEE NOTE 4 MEMORY CHIP, PROGRAMMED 135  
1633743-1 SERVO FEED LATCH ASM 133  
1-18028-2 WASHER, FLAT, REG M4 119  
2119944-1 FEED FINGER ASSEMBLY, SF 117  
455888-5 SPACER, CRIMPER 82  
1962431-2 SPRING, COMPRESSION 77  
854769-4 HOLDER, INS 74  
2119956-1 DOCUMENTATION PACKAGE 71  
2119740-1 TAG, IDENTIFICATION 67  
2168078-1 SCREW, DRIVE, RH, RoHS 66  
2119793-1 LIMITER, ADJUSTMENT BOLT 63  
992763-5 SCR, SET, SOC, CONE POINT, M3 x 4.0 62  
5-18022-5 SCR, HEX HD CAP, M4 X 6.0 59  
21028-2 PIN, SLOTTED SPRING .062 X .250 58  
1338685-1 PAWL, FEED 56  
2168083-3 SCR, SKT HD CAP, RoHS, M4 X 12.0 53  
5018030-1 NUT, HEX, REG, RoHS, M3 52  
811242-5 BUMPER, HOLD DOWN 51  
690753-2 SPACER, TONKER 50  
18023-9 SCR, SKT HD CAP M4 X 6.0 49  
2119652-1 FEED CAM, PRE FEED 48  
2079383-7 SCR, BHSC, RoHS (M8 X 25) 41  
2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT 40  
2119957-1 APPLICATOR SHIM PACK 39  
2119644-1 RAM WASHER, PRECISION 38  
1752356-3 SUPPORT, TERMINAL 34  
2079383-5 SCR, BHSC, RoHS (M4 X 20) 33  
2161328-1 HEX HEAD, FLANGED, M5 x 8mm LONG 32  
1320908-2 SPACER, STRIP GUIDE 30  
2119959-1 ASSEMBLY, STRIP GUIDE 29  
455888-3 SPACER, CRIMPER 28  
1320928-2 STRIP GUIDE 24  
2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0 21  
1-18028-2 WASHER, FLAT, REG M4 20  
2119533-1 STRIPPER, SIDE FEED 19  
2119806-1 INSERT, SHEAR 13  
3-22280-3 SPRING, COMPRESSION 12  
1-356885-4 STOP, SHEAR 11  
2119805-1 SHEAR HOLDER, FRONT 10  
1803095-1 FLOATING SHEAR, FRONT 9  
2-1333201-5 ANVIL, COMBINATION 8  
- - - - - 7  
- - - - - 6  
1-2119780-4 DEPRESSOR, SHEAR 5  
2-238011-0 BLOCK, CRIMPER SPACER 4  
2-2119784-1 CRIMPER, INSULATION O PREMIUM 3  
455888-2 SPACER, CRIMPER 2  
1-456402-5 CRIMPER, WIRE PREMIUM 1  
-77 -27 -25 -22 -21 PART NO DESCRIPTION ITEM NO

TE Connectivity  
Ocean Side Feed Applicator  
DIMENSIONS: mm 0 PLC ±.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±.5  
TOLERANCES UNLESS OTHERWISE SPECIFIED:  
MATERIAL FINISH WEIGHT  
DWG: HOFFNER 12FEB2013  
CHK: T. ELBIN 13FEB2013  
APVD: T. ELBIN 13FEB2013  
NAME: Ocean Side Feed Applicator  
SIZE: A1 CASE CODE: 00779 DRAWING NO: C=2151689  
Customer Accessible Production Drawing SCALE: 1:1 SHEET 3 OF 4 REV: A

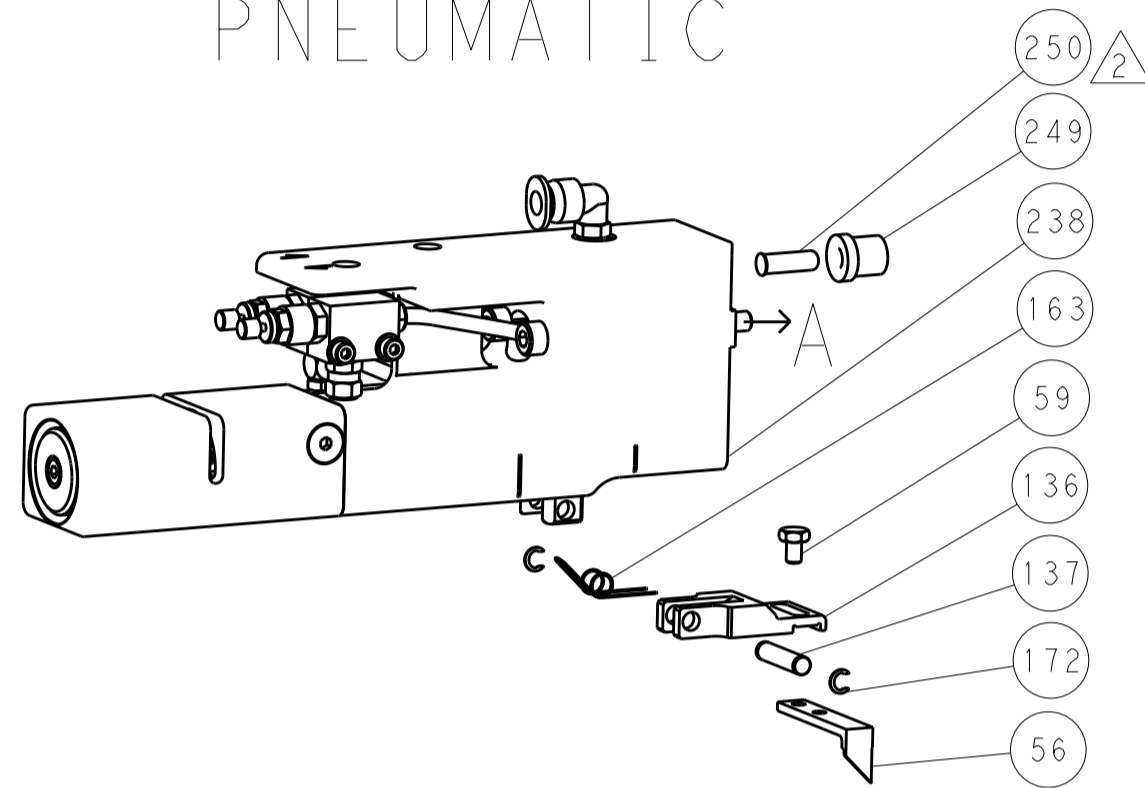
LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS					

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

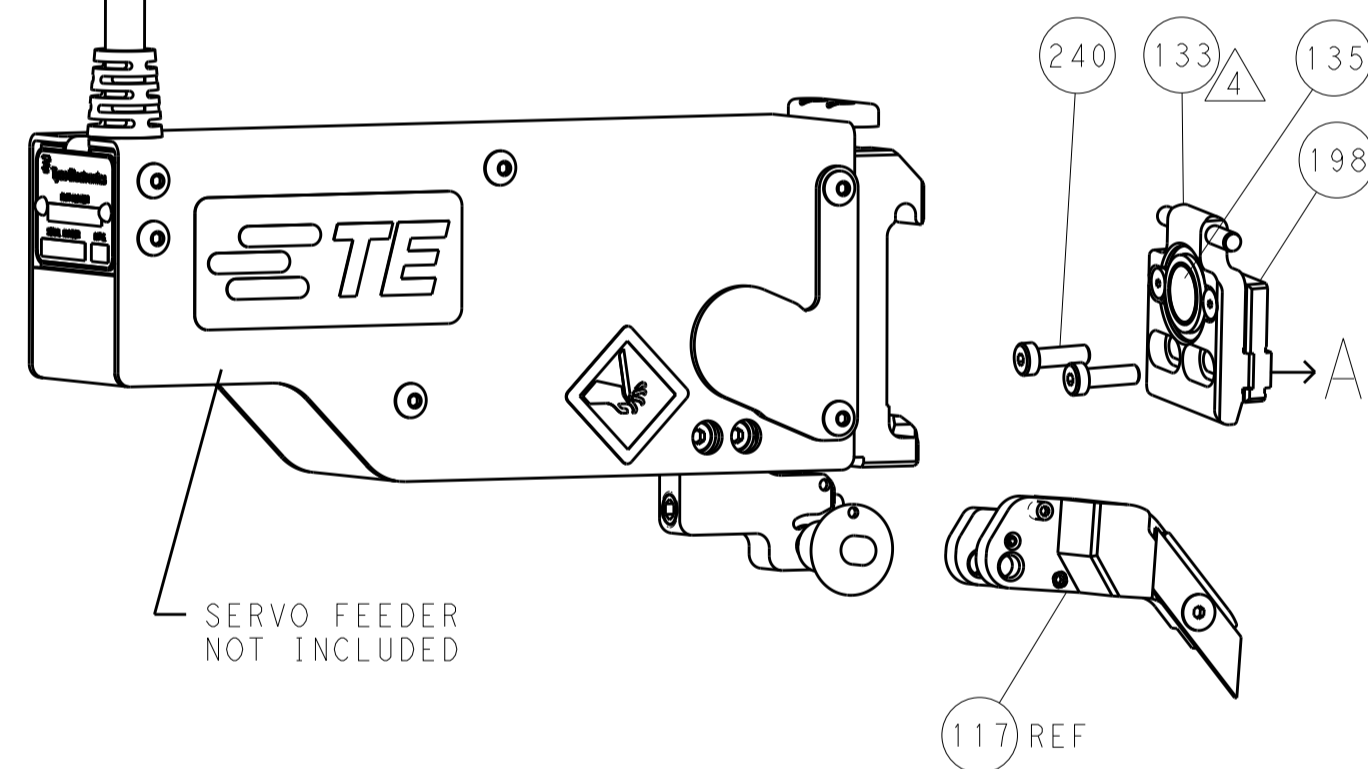
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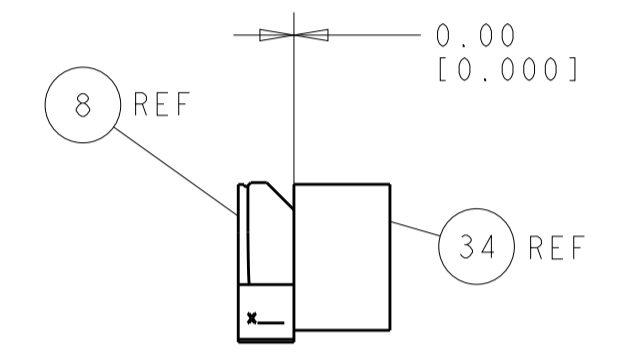
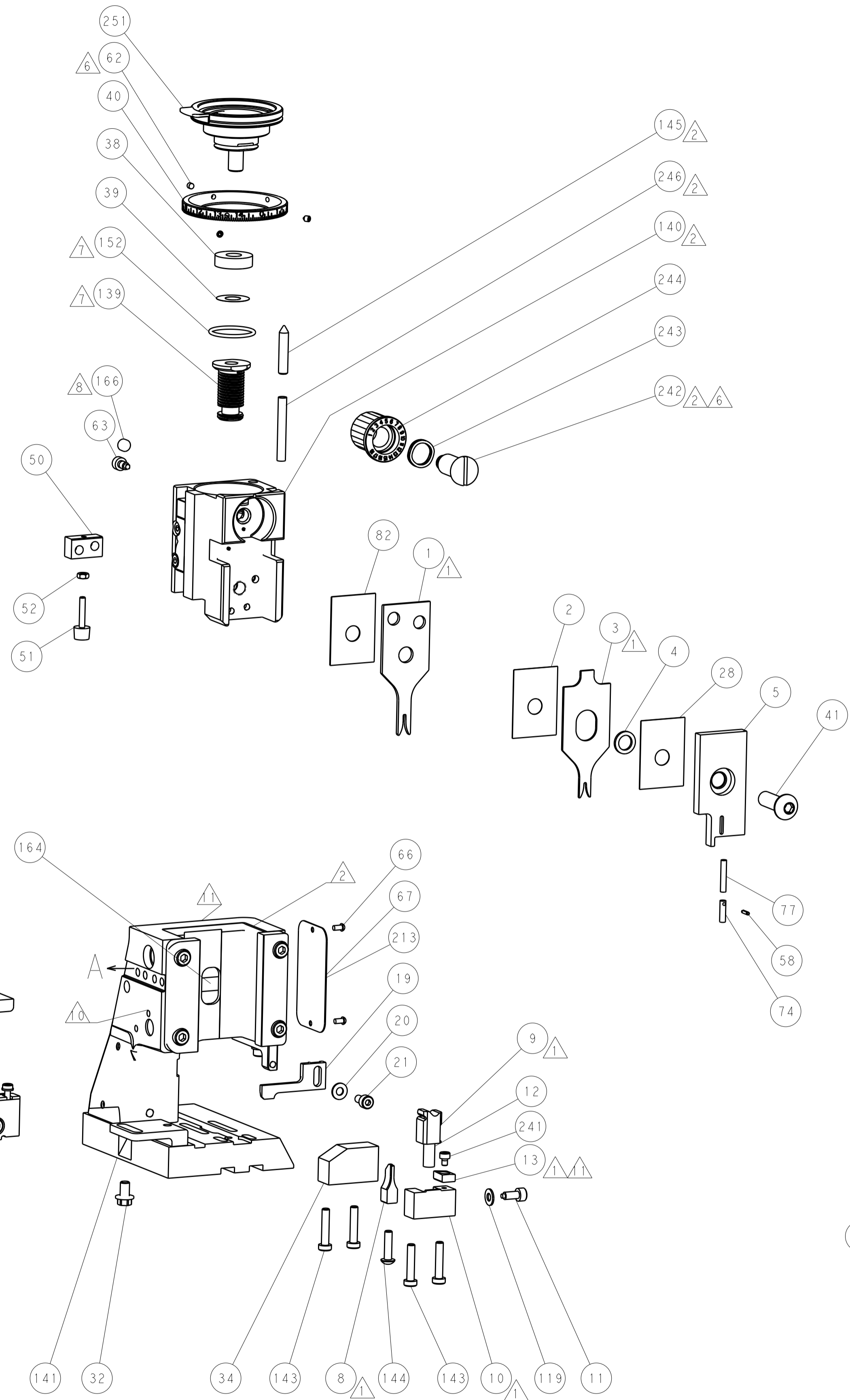
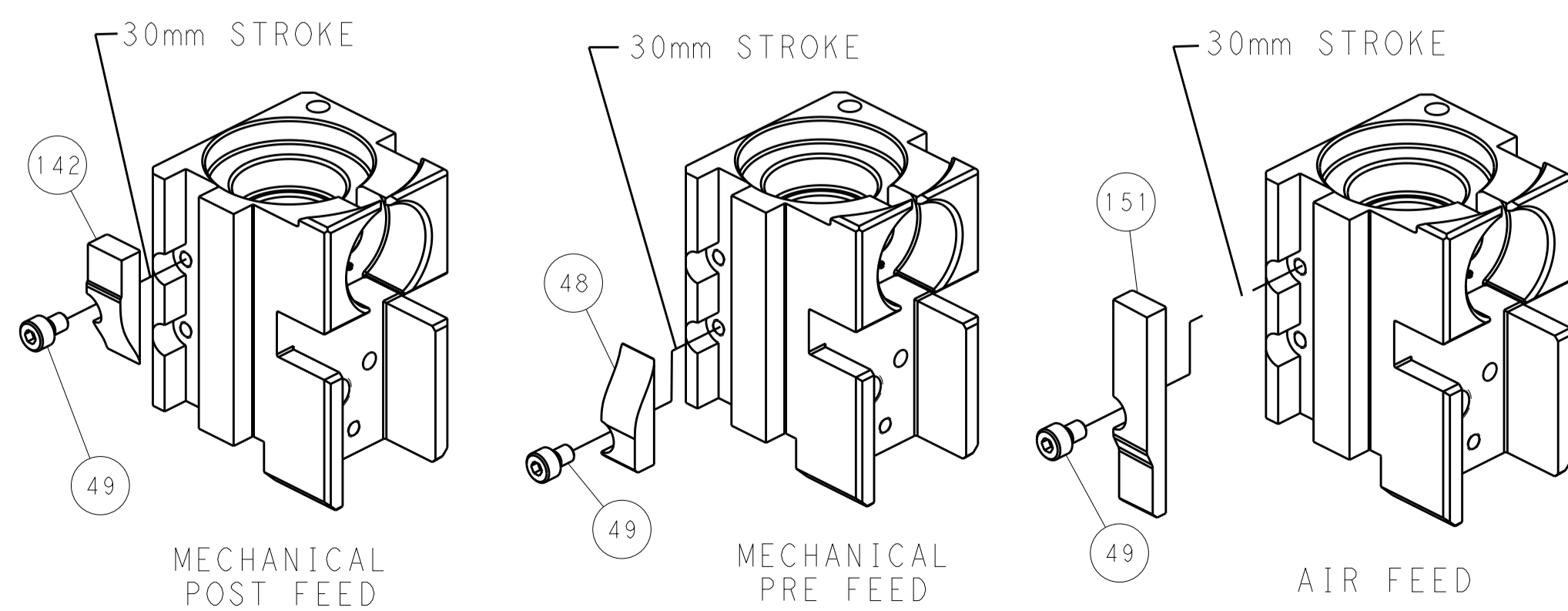
# PNEUMATIC



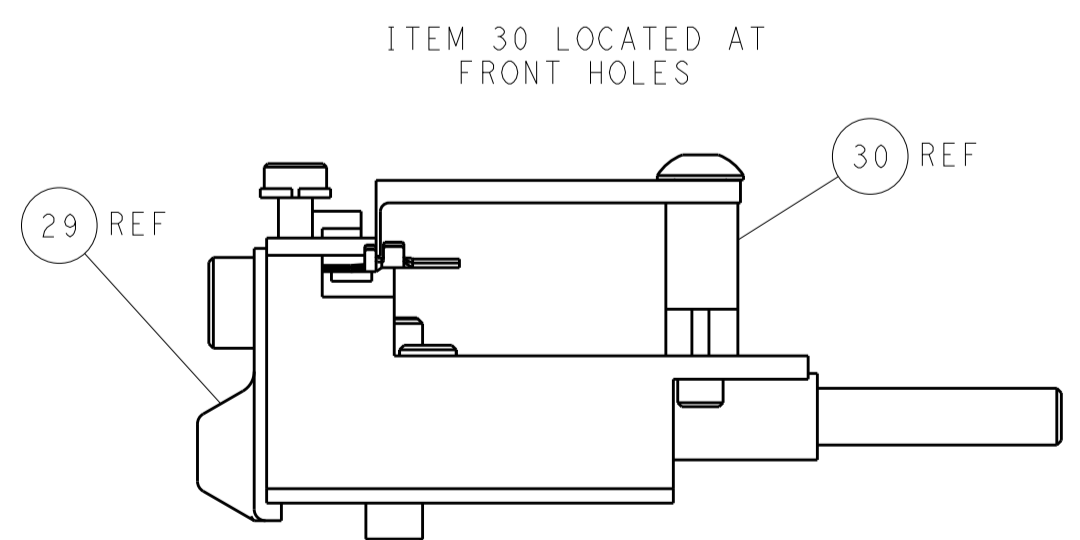
# SERVO LATCH PLATE



# CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PROJECT AND INSTALLATION ORGANIZATION WHICH IT WAS PREPARED FOR. ALL RIGHTS RESERVED.</small>		DWN: HOFFNER 12FEB2013 CHK: TELBIN 13FEB2013 APVD: TELBIN 13FEB2013	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±0.0005		PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO:
MATERIAL: FINISH:		A   00779 ©=2151689 Customer Accessible Production Drawing	SCALE: 1:1 SHEET 4 OF 4 REV A