

8

7

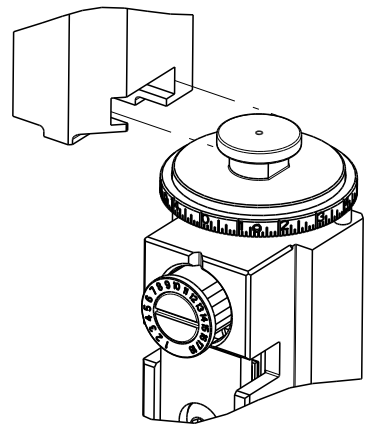
THIS DRAWING IS UNPUBLISHED.

RELEASED FOR PUBLICATION

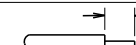
20

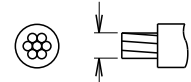
 COPYRIGHT 20

BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

|  | PART NUMBER | REVISION | DESCRIPTION              |
|----------------------------------------------------------------------------------|-------------|----------|--------------------------|
|                                                                                  | 2151316-2   | A        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151316-5   | A        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151316-6   | A        | NON-CRIMP HEIGHT ADJUST  |
|                                                                                  | 2151316-7   | A        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 7-2151316-7 | A        | CRIMP TOOLING KIT        |

|                                   |                 |      |
|-----------------------------------|-----------------|------|
| APPLICATOR DATA                   |                 |      |
| CRIMP                             | SIZE            | TYPE |
| WIRE                              | 3.56 mm [1.40]  | F    |
| INSUL                             | 5.59 mm [1.220] | O    |
| APPLICATOR INSTRUCTIONS 408-10389 |                 |      |

|                                                                                                     |                                                                                   |                               |             |
|-----------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-------------------------------|-------------|
| TERMINAL DATA: TE TERMINAL                                                                          |                                                                                   | TE CRIMP SPECIFICATION        |             |
| TERMINAL NAME: POWER RING                                                                           |                                                                                   |                               |             |
|  WIRE STRIP LENGTH   |  | INSULATION DIAMETER RANGE     |             |
| 5.95-6.75 mm [1.234-.266 IN]                                                                        |                                                                                   | Ø2.79-4.06 mm [1.110-.160 IN] |             |
| TERMINAL APPLICATION SPECIFICATION                                                                  | 114-2087                                                                          | -                             | -           |
| TERMINALS APPLIED  |                                                                                   |                               |             |
| TE TERMINAL                                                                                         | TE TERMINAL                                                                       | TE TERMINAL                   | TE TERMINAL |
| 63166-1                                                                                             | 63166-2                                                                           | 63166-4                       | 63166-5     |
| 521843-1                                                                                            | 521844-1                                                                          |                               |             |

|            |                                                                                     |                             |                                                                                     |                                |
|------------|-------------------------------------------------------------------------------------|-----------------------------|-------------------------------------------------------------------------------------|--------------------------------|
| WIRE SIZE  |  | CRIMP HEIGHT mm [INCH]      |  | CRIMP HEIGHT REFERENCE SETTING |
| (2) 14 AWG |                                                                                     | 3.07+/-0.05 [1.21+/- .002]  |                                                                                     | 3.7                            |
| 12 AWG     |                                                                                     | 2.90+/-0.05 [1.14+/- .002]  |                                                                                     | 5.1                            |
| 14 AWG     |                                                                                     | 2.64+/-0.05 [1.04+/- .002]  |                                                                                     | 8.0                            |
| 16 AWG     |                                                                                     | 2.46+/-0.05 [1.097+/- .002] |                                                                                     | 10.4                           |



- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
4. APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151316-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151316-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151316-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
6. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
8. MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
9. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
10. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
11. TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
12. WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 2.73.
13. WIRE STRIP LENGTHS LISTED ARE FOR AWG WIRE. WIRE STRIP LENGTHS FOR HOUSEHOLD WIRE IS: 18.65-19.45 mm [1.734-.766 IN].
14. CUT TO LENGTH AT ASSEMBLY.

\*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  | 1  | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20  | 283     |
|   | -   | 1  | 1  | 1  | 1  | 1803315-1   | LOWER SHEAR, RIGHT              | 282     |
|   | -   | 1  | 1  | 1  | 1  | 1-18028-3   | WASHER, FLAT, REG M5            | 281     |
|   | -   | 1  | 1  | 1  | 1  | 1803196-1   | STUD, ADJUSTMENT SCREW          | 280     |
|   | -   | 1  | 1  | 1  | 1  | 23238-1     | INSERT, COUPLING                | 278     |
|   | -   | 1  | 1  | 1  | 1  | 2030758-3   | TUBING, POLYURETHANE            | 277     |
|   | -   | 1  | 1  | 1  | 1  | 5018030-2   | NUT, HEX, REG, RoHS, M4         | 276     |
|   | -   | 1  | 1  | 1  | 1  | 986220-2    | CLAMP, CABLE, BLACK             | 275     |
|   | -   | 1  | 1  | 1  | 1  | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10  | 274     |
|   | -   | 1  | 1  | 1  | 1  | 1803319-1   | SUPPORT, AIR BLAST              | 273     |
|   | -   | 2  | 2  | 2  | 2  | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8    | 269     |
|   | -   | 1  | 1  | 1  | 1  | 3-18031-6   | SCR, SET, CUP POINT M2.5 X 3.0  | 266     |
|   | -   | 2  | 2  | 2  | 2  | 2168083-5   | SCR, SKT HD CAP, RoHS, M4 X 6.0 | 265     |
| 1 | -   | 1  | 1  | 1  | 1  | 1803313-1   | SLUG BLADE                      | 264     |
|   | -   | 1  | 1  | 1  | 1  | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10  | 263     |
|   | -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 2119599-1 | LOC A | DIST 66 | REVISIONS |     |               |           |
|                        |       |         | P         | LTR | DESCRIPTION   | DATE      |
|                        |       |         |           | A1  | ECR-16-008694 | 15JUN2016 |
|                        |       |         |           |     |               |           |
|                        |       |         |           |     |               |           |
|                        |       |         |           |     |               |           |

|    |     |     |     |     |     |             |                                     |         |
|----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| 1  | -   | 1   | 1   | 1   | 1   | 1803312-1   | LOWER SHEAR, LEFT                   | 262     |
|    | -   | 1   | 1   | 1   | 1   | 9-240641-0  | SPACER                              | 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     |
|    | -   | 1   | -   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246     |
|    | -   | -   | 1   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245     |
|    | -   | 1   | 1   | 1   | 1   | 2119082-4   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
|    | -   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| 6  | -   | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242     |
|    | -   | -   | 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   | 1-22281-6   | SPRING, COMPRESSION                 | 121     |
|    | -   | -   | REF | REF | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
|    | -   | 1   | 1   | 1   | 1   | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         | 113     |
|    | -   | 1   | 1   | 1   | 1   | 1803310-1   | STRIP GUIDE, FRONT                  | 96      |
|    | -   | 2   | 2   | 2   | 2   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95      |
|    | -   | 1   | 1   | 1   | 1   | 2168083-7   | SCR, SKT HD CAP, RoHS, M3 X 30      | 93      |
|    | -   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 82      |
|    | -   | 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      |
| 6  | -   | 1   | -   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
|    | -   | 3   | -   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62      |
|    | -   | 2   | 2   | 2   | 2   | 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   | 1338683-9   | FEED PAWL                           | 56      |
| 14 | -   | 2   | 2   | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 53      |
|    | -   | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52      |
|    | -   | 1   | 1   | 1   | 1   | 811242-6    | BUMPER, HOLD DOWN                   | 51      |
|    | -   | 1   | 1   | 1   | 1   | 1803311-1   | HOLDER, SLUG BLADE                  | 50      |
|    | -   | -   | -   | -   | 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   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44      |
|    | -   | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41      |
|    | -   | 1   | -   | -   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40      |
|    | -   | 1   | -   | -   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39      |
|    | -   | 1   | 1   | 1   | 1   | 2119644-3   | RAM WASHER, PRECISION               | 38      |
| 6  | -   | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37      |
|    | -   | 1   | -   | -   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35      |
|    | -   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32      |
|    | -   | 1   | 1   | 1   | 1   | 1803309-1   | PLATE, STRIP GUIDE                  | 29      |
|    | -   | 2   | 2   | 2   | 2   | 22283-1     | SPRING, COMPRESSION                 | 27      |
|    | -   | 1   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 26      |
|    | -   | 1   | 1   | 1   | 1   | 3-690754-8  | DRAG, SPECIAL                       | 25      |
|    | -   | 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      |
|    | -   | 5   | 5   | 5   | 5   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
|    | -   | 1   | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19      |
|    | -   | -   | -   | -   | -   | -           | -                                   | 10      |
|    | -   | -   | -   | -   | -   | -           | -                                   | 9       |
| 1  | 1   | 1   | 1   | 1   | 1   | 1803316-1   | ANVIL, COMBINATION                  | 8       |
|    | -   | -   | -   | -   | -   | -           | -                                   | 7       |
|    | -   | -   | -   | -   | -   | -           | -                                   | 6       |
|    | -   | -   | -   | -   | -   | -           | -                                   | 5       |
|    | -   | 1   | 1   | 1   | 1   | 238009-3    | BLOCK, FL CRIMPER SPACER            | 4       |
| 1  | 1   | 1   | 1   | 1   | 1   | 1-1633966-1 | CRIMPER, INSULATION O               | 3       |
|    | -   | 1   | 1   | 1   | 1   | 1-455888-3  | SPACER, CRIMPER                     | 2       |
| 1  | 1   | 1   | 1   | 1   | 1   | 3-456411-0  | CRIMPER, WIRE PREMIUM               | 1       |
|    | -77 | -7  | -6  | -5  | -2  | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                            |  |                           |                                 |  |
|----------------------------------------------------------------------------------------------------------------------------|--|---------------------------|---------------------------------|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST EDITION. |  | OWN R. KNEPPER 21-Oct-15  | TE Connectivity                 |  |
| CHK G. BAILEY 21-Oct-15                                                                                                    |  | Harrisburg, PA 17105-3608 |                                 |  |
| DIMENSIONS: mm                                                                                                             |  | APVD T. ELBIN 21-Oct-15   | NAME Ocean Side Feed Applicator |  |
|                                       |  | PRODUCT SPEC              | SIZE CAGE CODE DRAWING NO       |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±. FINISH                       |  | APPLICATION SPEC          | RESTRICTED TO                   |  |
| MATERIAL                                                                                                                   |  | WEIGHT                    | A1 00779 ©=2151316              |  |
| Customer Accessible Production Drawing                                                                                     |  | SCALE 1:2                 | SHEET 1 OF 4 REV A1             |  |



8

7

6

5

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

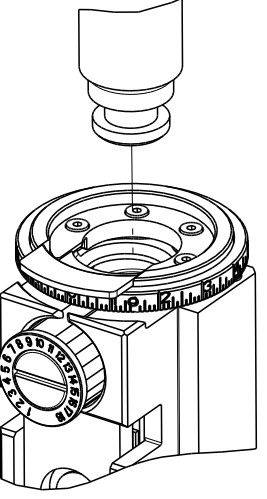
RELEASED FOR PUBLICATION

20

© COPYRIGHT 20

BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

PACIFIC VERSION  
TERMINATOR  
INTERFACE ADAPTER



PART  
NUMBER

2-2151316-2

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

PNEUMATIC

APPLICATOR STYLE CONVERSION CHART

CONVERT TO

PART NUMBERS REQUIRED

-

-

-

-

-

-

SERVO LATCH PLATE

2119951-1

-

8-2151316-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151316-4

-

-

-

-

-

-

-

-

-

PNEUMATIC FEED

2119950-1

1338683-9

5-18022-5

2119641-2

2119799-1

2063440-1

-

-

-

-

-

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

3.56 mm [.140]

F

INSUL

5.59 mm [.220]

O

APPLICATOR INSTRUCTIONS

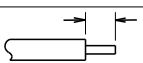
408-10389



TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: POWER RING



WIRE STRIP LENGTH

5.95-6.75 mm [.234-.266 IN]



INSULATION DIAMETER RANGE

Ø2.79-4.06 mm [.110-.160 IN]



TERMINAL APPLICATION SPECIFICATION

114-2087

-

-

TERMINALS APPLIED



TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

63166-1

63166-2

63166-4

63166-5

521843-1

521844-1

| WIRE SIZE  |  | CRIMP HEIGHT mm [INCH]     |  | CRIMP HEIGHT REFERENCE SETTING |
|------------|-------------------------------------------------------------------------------------|----------------------------|-------------------------------------------------------------------------------------|--------------------------------|
| (2) 14 AWG |                                                                                     | 3.07+/-0.05 [.121+/- .002] |                                                                                     | 3.7                            |
| 12 AWG     |                                                                                     | 2.90+/-0.05 [.114+/- .002] |                                                                                     | 5.1                            |
| 14 AWG     |                                                                                     | 2.64+/-0.05 [.104+/- .002] |                                                                                     | 8.0                            |
| 16 AWG     |                                                                                     | 2.46+/-0.05 [.097+/- .002] |                                                                                     | 10.4                           |



- 1

RECOMMENDED SPARE PARTS
- 2

GREASE BEARING SURFACES LIGHTLY
3.

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- 4

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151316-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151316-5
5.

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- 7

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- 8

MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 9

CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- 10

TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 11

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 12

WIRE STRIP LENGTHS LISTED ARE FOR AWG WIRE.  
WIRE STRIP LENGTHS FOR HOUSEHOLD WIRE IS:  
18.65-19.45 mm [.734-.766 IN].
- 13

CUT TO LENGTH AT ASSEMBLY.

\*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   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20  | 283     |
|   | -   | 1   | 1   | 1   | 1803315-1   | LOWER SHEAR, RIGHT              | 282     |
|   | -   | 1   | 1   | 1   | 1-18028-3   | WASHER, FLAT, REG M5            | 281     |
|   | -   | 1   | 1   | 1   | 1803196-1   | STUD, ADJUSTMENT SCREW          | 280     |
|   | -   | 1   | 1   | 1   | 23238-1     | INSERT, COUPLING                | 278     |
|   | -   | 1   | 1   | 1   | 2030758-3   | TUBING, POLYURETHANE            | 277     |
|   | -   | 1   | 1   | 1   | 5018030-2   | NUT, HEX, REG, RoHS, M4         | 276     |
|   | -   | 1   | 1   | 1   | 986220-2    | CLAMP, CABLE, BLACK             | 275     |
|   | -   | 1   | 1   | 1   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10  | 274     |
|   | -   | 1   | 1   | 1   | 1803319-1   | SUPPORT, AIR BLAST              | 273     |
|   | -   | 2   | 2   | 2   | 2168400-4   | SHCS, LOW HEAD, RoHS, M4 X 8    | 269     |
|   | -   | 1   | 1   | 1   | 3-18031-6   | SCR, SET, CUP POINT M2.5 X 3.0  | 266     |
|   | -   | 2   | 2   | 2   | 2168083-5   | SCR, SKT HD CAP, RoHS, M4 X 6.0 | 265     |
|   | -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)

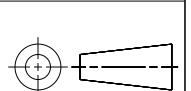
| SET UP GAUGE |  | LOC | DIST | REVISIONS |     |             |      |     |      |
|--------------|--|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-1    |  | A   | 66   | P         | LTR | DESCRIPTION | DATE | DWN | APVD |
|              |  |     |      |           | -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

|     |     |     |     |         |             |                                     |     |
|-----|-----|-----|-----|---------|-------------|-------------------------------------|-----|
| 1   | -   | 1   | 1   | 1       | 1803313-1   | SLUG BLADE                          | 264 |
|     | -   | 1   | 1   | 1       | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 263 |
| 1   | -   | 1   | 1   | 1       | 1803312-1   | LOWER SHEAR, LEFT                   | 262 |
|     | -   | 1   | 1   | 1       | 9-240641-0  | SPACER                              | 261 |
|     | -   | 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       | 2119082-4   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
|     | -   | 1   | 1   | 1       | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| 6   | -   | 1   | 1   | 1       | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
|     | -   | -   | 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 |
|     | -   | 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       | 1-22281-6   | SPRING, COMPRESSION                 | 121 |
|     | -   | -   | REF | -       | 2119944-1   | FEED FINGER ASSEMBLY,SF             | 117 |
|     | -   | 1   | 1   | 1       | 2119955-1   | ASSY, LUBRICATOR, SIDE FEED         | 113 |
|     | -   | 1   | 1   | 1       | 1803310-1   | STRIP GUIDE, FRONT                  | 96  |
|     | -   | 2   | 2   | 2       | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95  |
|     | -   | 1   | 1   | 1       | 2168083-7   | SCR, SKT HD CAP, RoHS, M3 X 30      | 93  |
|     | -   | 1   | 1   | 1       | 1-455888-0  | SPACER, CRIMPER                     | 82  |
|     | -   | 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  |
| 6   | -   | 1   | 1   | 1       | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63  |
|     | -   | 3   | 3   | 3       | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62  |
|     | -   | 2   | 2   | 2       | 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       | 1338683-9   | FEED PAWL                           | 56  |
| 3   | -   | 2   | 2   | 2       | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 53  |
|     | -   | 1   | 1   | 1       | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52  |
|     | -   | 1   | 1   | 1       | 811242-6    | BUMPER, HOLD DOWN                   | 51  |
|     | -   | 1   | 1   | 1       | 1803311-1   | HOLDER, SLUG BLADE                  | 50  |
|     | -   | -   | -   | 1       | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
|     | -   | 1   | 1   | 1       | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
|     | -   | 1   | 1   | 1       | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40  |
|     | -   | 1   | 1   | 1       | 2119957-1   | APPLICATOR SHIM PACK                | 39  |
|     | -   | 1   | 1   | 1       | 2119644-3   | RAM WASHER, PRECISION               | 38  |
|     | -   | 1   | 1   | 1       | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32  |
|     | -   | 1   | 1   | 1       | 1803309-1   | PLATE, STRIP GUIDE                  | 29  |
|     | -   | 2   | 2   | 2       | 22283-1     | SPRING, COMPRESSION                 | 27  |
|     | -   | 1   | 1   | 1       | 356835-1    | LEVER, DRAG RELEASE                 | 26  |
|     | -   | 1   | 1   | 1       | 3-690754-8  | DRAG, SPECIAL                       | 25  |
|     | -   | 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  |
|     | -   | 5   | 5   | 5       | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
|     | -   | 1   | 1   | 1       | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
|     | -   | -   | -   | -       | -           | -                                   | 10  |
|     | -   | -   | -   | -       | -           | -                                   | 9   |
| 1   | 1   | 1   | 1   | 1       | 1803316-1   | ANVIL, COMBINATION                  | 8   |
|     | -   | -   | -   | -       | -           | -                                   | 7   |
|     | -   | -   | -   | -       | -           | -                                   | 6   |
|     | -   | -   | -   | -       | -           | -                                   | 5   |
|     | -   | 1   | 1   | 1       | 238009-3    | BLOCK, FL CRIMPER SPACER            | 4   |
| 1   | 1   | 1   | 1   | 1       | 1-1633966-1 | CRIMPER, INSULATION O               | 3   |
|     | -   | 1   | 1   | 1       | 1-455888-3  | SPACER, CRIMPER                     | 2   |
| 1   | 1   | 1   | 1   | 1       | 3-456411-0  | CRIMPER, WIRE PREMIUM               | 1   |
| -77 | -27 | -25 | -22 | PART NO | DESCRIPTION | ITEM NO                             |     |

THIS DOCUMENT IS CONTROLLED DOCUMENT AND THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED UNLESS INDICATED OTHERWISE. FOR MORE INFORMATION, CONTACT THE ORGANIZATION TO WHICH THIS DOCUMENT IS REFERENCED.

OWN: R.KNEPPER 21-Oct-15  
CHK: G.BAILEY 21-Oct-15  
APVD: T.ELBIN 21-Oct-15

DIMENSIONS:  
mm



TOLERANCES UNLESS OTHERWISE SPECIFIED:  
0 PLC ±.1  
1 PLC ±.1  
2 PLC ±.1  
3 PLC ±.1  
4 PLC ±.1  
ANGLES ±.1  
FINISH

NAME: Ocean Side Feed Applicator

SIZE: A1

CAGE CODE: 00779

DRAWING NO: C=2151316

RESTRICTED TO: -

Customer Accessible Production Drawing

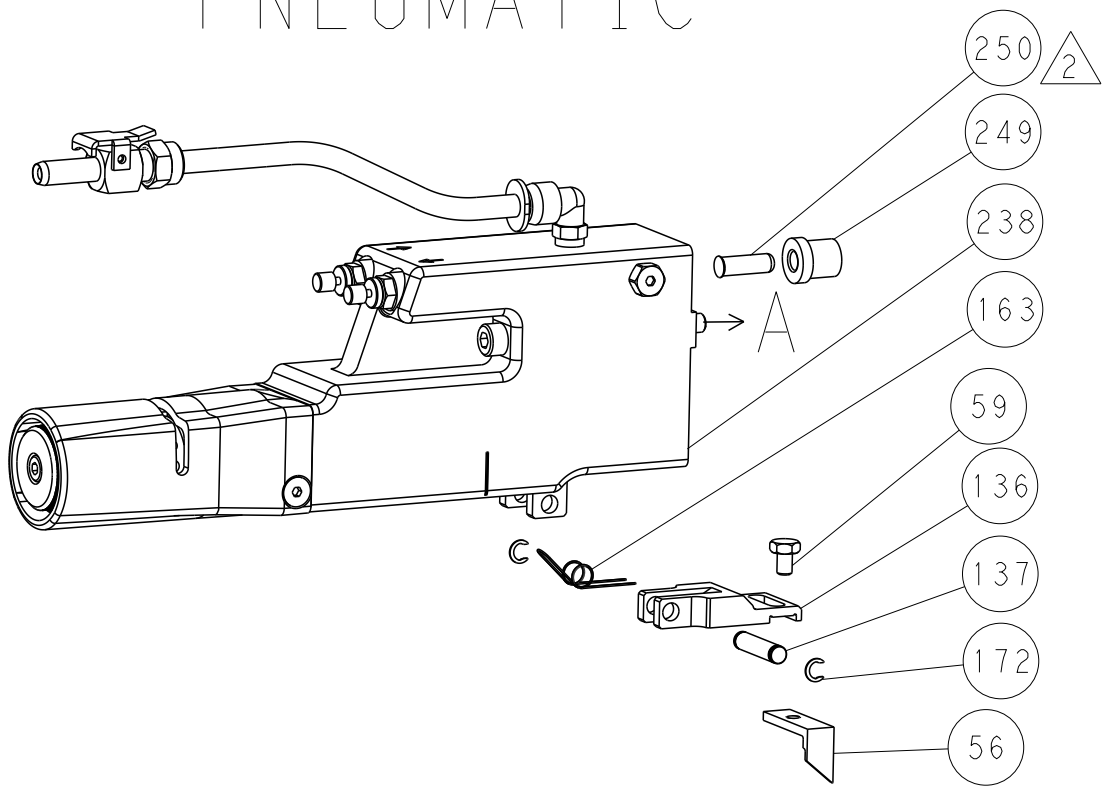
SCALE: 1:2

SHEET: 3 of 4

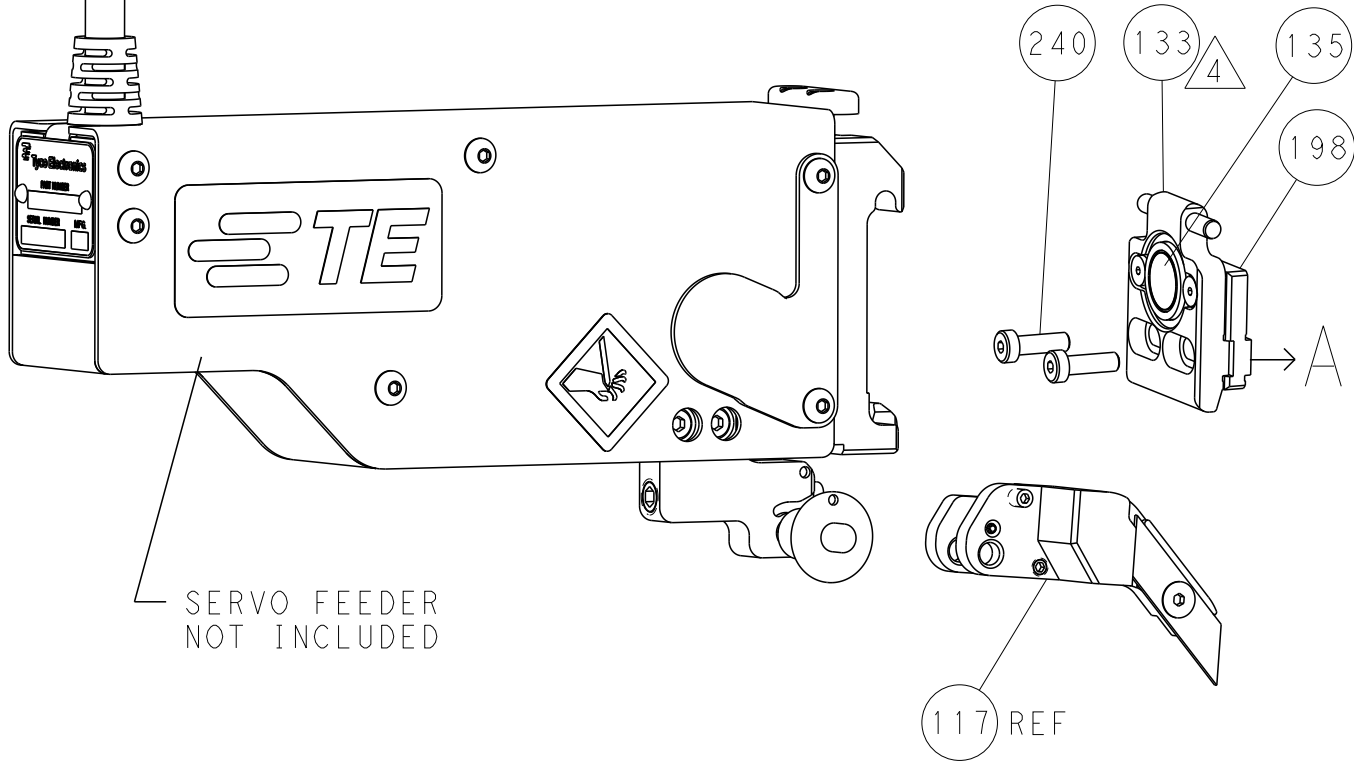
REV: A1

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

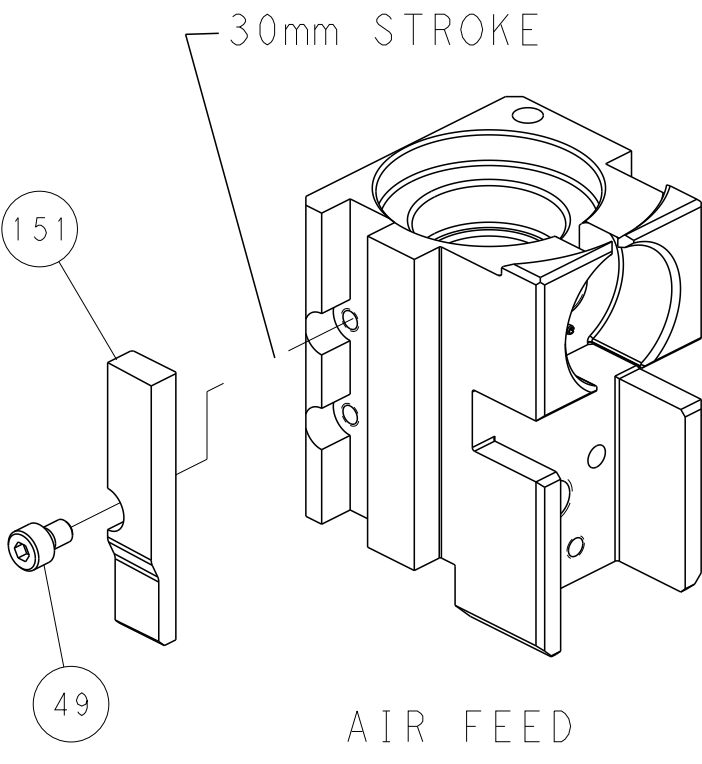
FEED TYPE  
PNEUMATIC



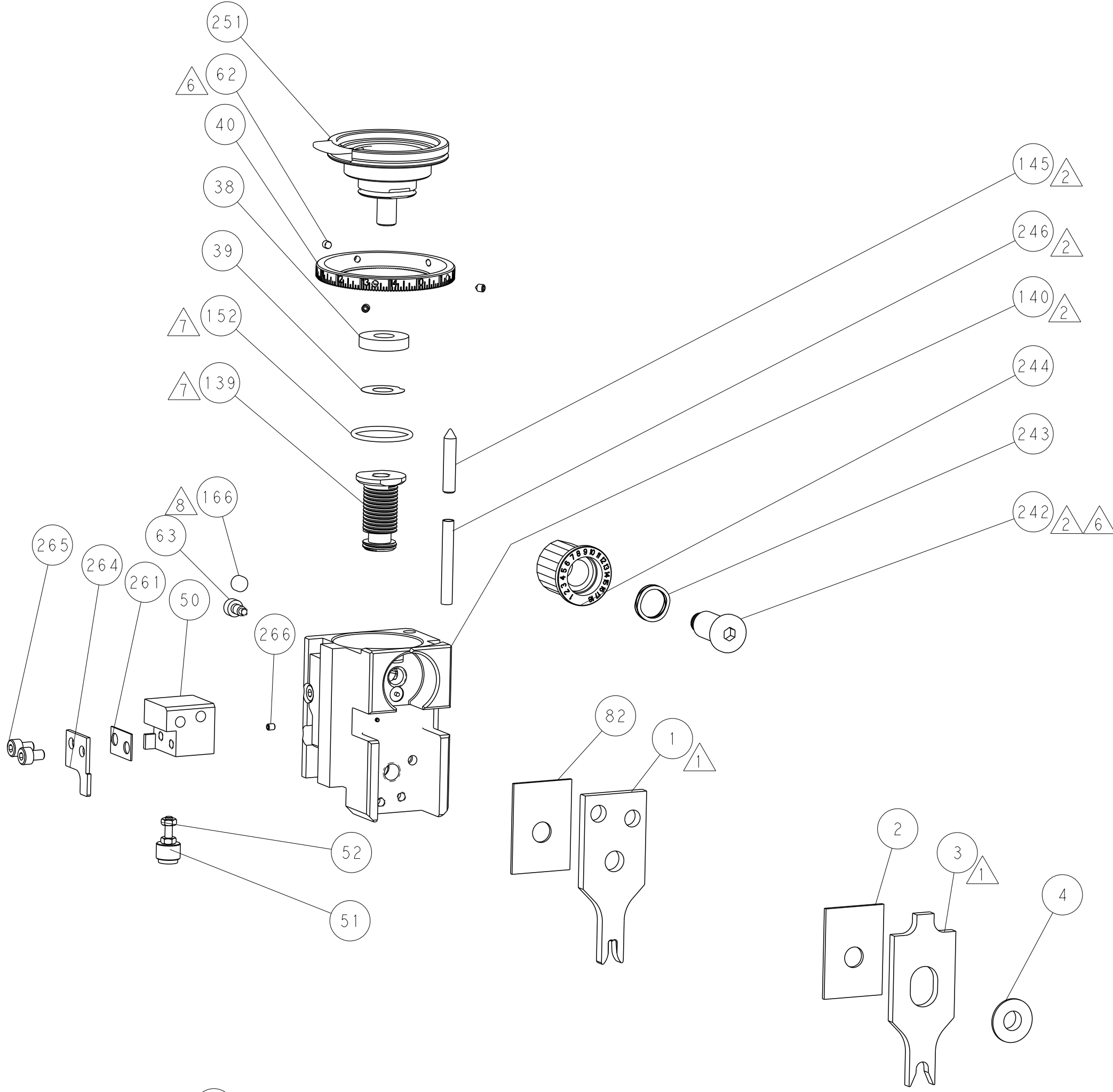
SERVO  
LATCH PLATE



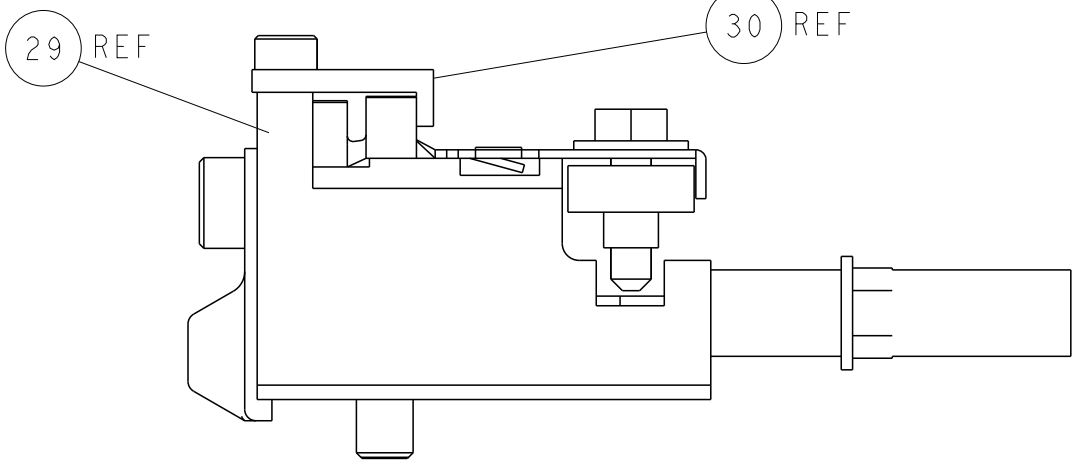
CAM POSITION



AIR FEED



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



FEED TRACK POSITION  
GUIDE BY WIRE BARREL

|                                                                                                                                                                                                     |  |                                           |                                              |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------|----------------------------------------------|--|
| THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION<br>IT IS SUBJECT TO COMPANY'S POLICY ON CONTROL AND DISTRIBUTION ORGANIZATION<br>SHOULD BE CONTACTED FOR THE LATEST VERSION. |  | DWN<br>R. KNEPPER<br>21-Oct-15            | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| CHK<br>G. BAILEY<br>21-Oct-15                                                                                                                                                                       |  | NAME<br>Ocean Side Feed<br>Applicator     | SIZE<br>A1                                   |  |
| APVD<br>T. ELBIN<br>21-Oct-15                                                                                                                                                                       |  | PRODUCT SPEC                              | CAGE CODE<br>00779                           |  |
| APPLICATION SPEC                                                                                                                                                                                    |  | WEIGHT                                    | DRAWING NO<br>2151316                        |  |
| MATERIAL                                                                                                                                                                                            |  | Customer Accessible Production Drawing    | SCALE<br>1:2                                 |  |
| DIMENSIONS:<br>mm                                                                                                                                                                                   |  | TOLERANCES UNLESS<br>OTHERWISE SPECIFIED: | SHEET<br>4                                   |  |
| 0 PLC ±                                                                                                                                                                                             |  | 1 PLC ±                                   | OF<br>4                                      |  |
| 2 PLC ±                                                                                                                                                                                             |  | 3 PLC ±                                   | REV<br>A1                                    |  |
| 4 PLC ±                                                                                                                                                                                             |  | 5 PLC ±                                   |                                              |  |
| ANGLES                                                                                                                                                                                              |  | FINISH                                    |                                              |  |
|                                                                                                                                                                                                     |  |                                           |                                              |  |