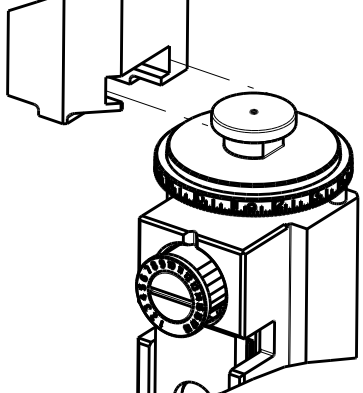
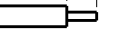


|                                                                                  |                |                          |                          |
|----------------------------------------------------------------------------------|----------------|--------------------------|--------------------------|
| 8                                                                                |                | 7                        |                          |
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| ATLANTIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                              | PART<br>NUMBER | REVISION                 | DESCRIPTION              |
|  | 2151550-2      | F                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151550-5      | F                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151550-6      | F                        | NON-CRIMP HEIGHT ADJUST  |
|                                                                                  | 2151550-7      | F                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 7-2151550-7    | A                        | CRIMP TOOLING KIT        |
|                                                                                  |                |                          |                          |

|                                   |                  |      |
|-----------------------------------|------------------|------|
| APPLICATOR DATA                   |                  |      |
| CRIMP                             | SIZE             | TYPE |
| WIRE                              | 2.79 mm [ .110 ] | F    |
| INSUL                             | 3.56 mm [ .140 ] | 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<br>3.40-4.00 mm [.134-.157 IN]                                  |             |  | INSULATION DIAMETER RANGE<br>Ø2.88-3.04 mm [.113-.120 IN] |
| TERMINAL APPLICATION SPECIFICATION                                                |             | 114-94204                                                                         |                                                           |
|  |             | -                                                                                 | -                                                         |
| TERMINALS APPLIED                                                                 |             |  |                                                           |
| TE TERMINAL                                                                       | TE TERMINAL | TE TERMINAL                                                                       | TE TERMINAL                                               |
| 2-2177838-1                                                                       |             |                                                                                   |                                                           |

|           |                           |                                |
|-----------|---------------------------|--------------------------------|
| WIRE SIZE | CRIMP HEIGHT mm [ INCH ]  | CRIMP HEIGHT REFERENCE SETTING |
| 2.50mm2   | 1.77±0.04 [ .0697±.0016 ] | 7.2                            |

- 
- 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: 8-2151550-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151550-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151550-6
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 ITEMS 99 & 242.  
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.
- 7

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.
- 13

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     |
| -   | 1  | 1  | 1  | 1  | 2119082-4   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -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      | DWN | APVD |  |
|                        | D4  | ECR-15-001216 |         | 25JAN2015 | MR  | JT   |  |
|                        | D5  | ECR-15-003249 |         | 2MAR15    | RS  | LZ   |  |
|                        | E   | ECR-15-015082 |         | 14OCT2015 | DJG | DS   |  |
|                        | F   | ECR-16-002618 |         | 22FEB2016 | KH  | CT   |  |

|     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 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   | 455888-4    | 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      |
| -   | 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   | 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   | 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   | 1-1752356-1 | SUPPORT, TERMINAL                   | 34      |
| -   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33      |
| -   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32      |
| -   | 1   | 1   | 1   | 1   | 1320908-7   | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 1901086-1   | PLATE, STRIP GUIDE                  | 29      |
| -   | 1   | 1   | 1   | 1   | 455888-3    | 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      |
| -   | 1   | 1   | 1   | 1   | 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   | 1-18023-1   | SCR, SKT HD CAP M4 X 10.0           | 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   | 2161316-3   | 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   | 5-238011-2  | BLOCK, CRIMPER SPACER               | 4       |
| 1   | 1   | 1   | 1   | 1   | 1722335-7   | CRIMPER, INSULATION F               | 3       |
| -   | -   | -   | -   | -   | -           | -                                   | 2       |
| 1   | 1   | 1   | 1   | 1   | 2217302-1   | CRIMPER, WIRE, CONICAL BLEND        | 1       |
| -77 | -7  | -6  | -5  | -2  | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                                                                                                |  |  |  |                            |                                           |  |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|----------------------------|-------------------------------------------|--|--|
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| DIMENSIONS: mm                                                                                                                                                                                                 |  |  |  | CHK T. ELBIN 18JAN2012     | NAME Ocean Side Feed Applicator           |  |  |
|                                                                                                                                                                                                                |  |  |  | APVD M. CLIFFORD 18JAN2012 | SIZE CASE CODE DRAWING NO RESTRICTED TO   |  |  |
|                                                                                                                                                                                                                |  |  |  |                            | A1 00779 C=2151550                        |  |  |
| MATERIAL                                                                                                                                                                                                       |  |  |  |                            | Customer Accessible Production Drawing    |  |  |
|                                                                                                                                                                                                                |  |  |  |                            | SCALE 1:2 SHEET 1 OF 4 REV F              |  |  |

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

D

C

B

A

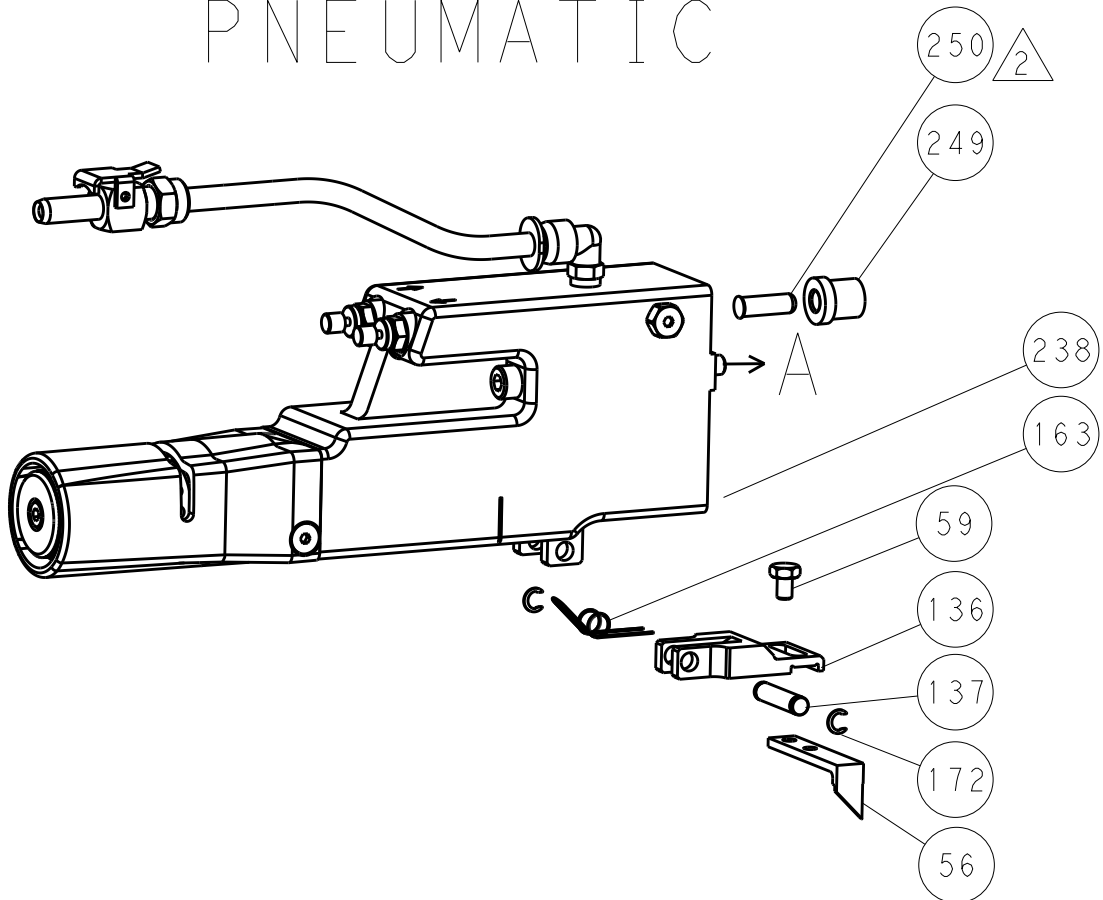
D

C

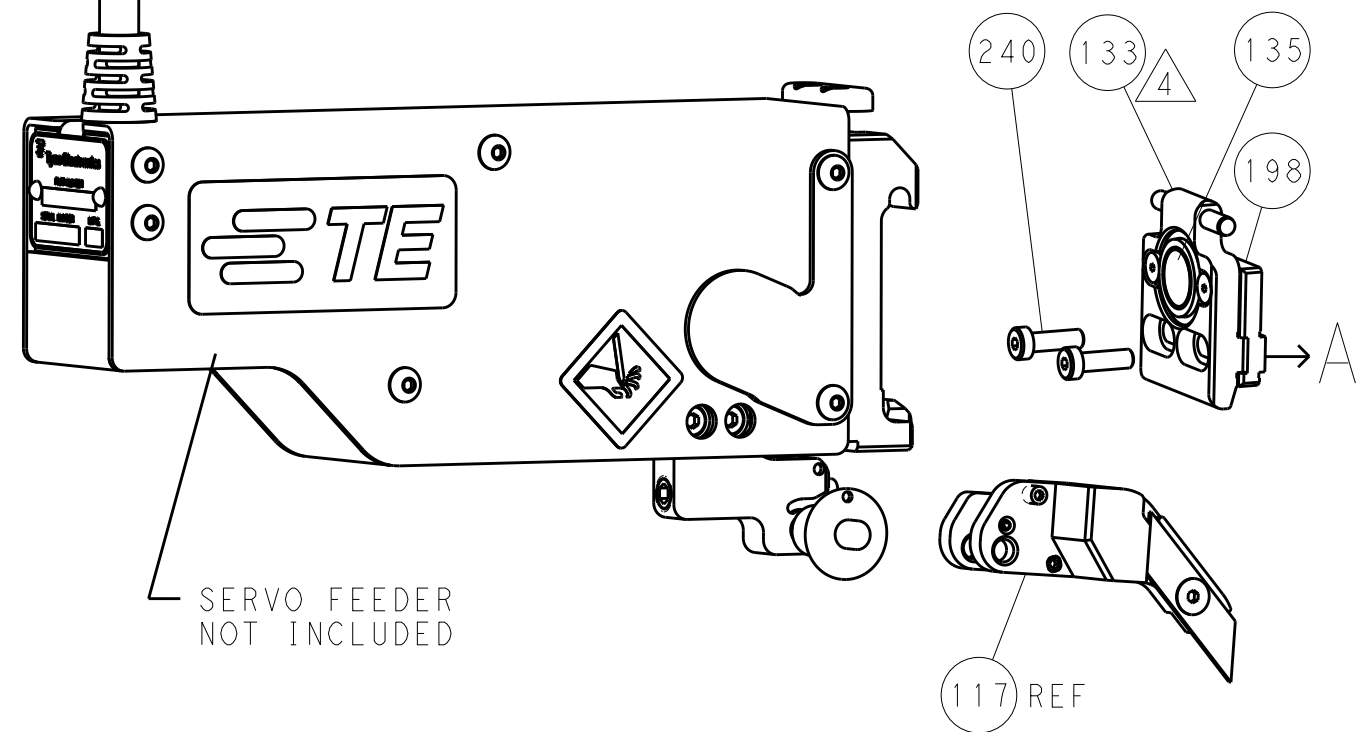
B

A

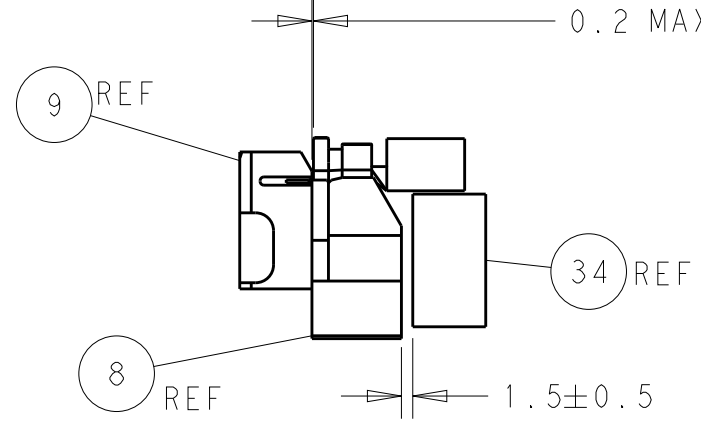
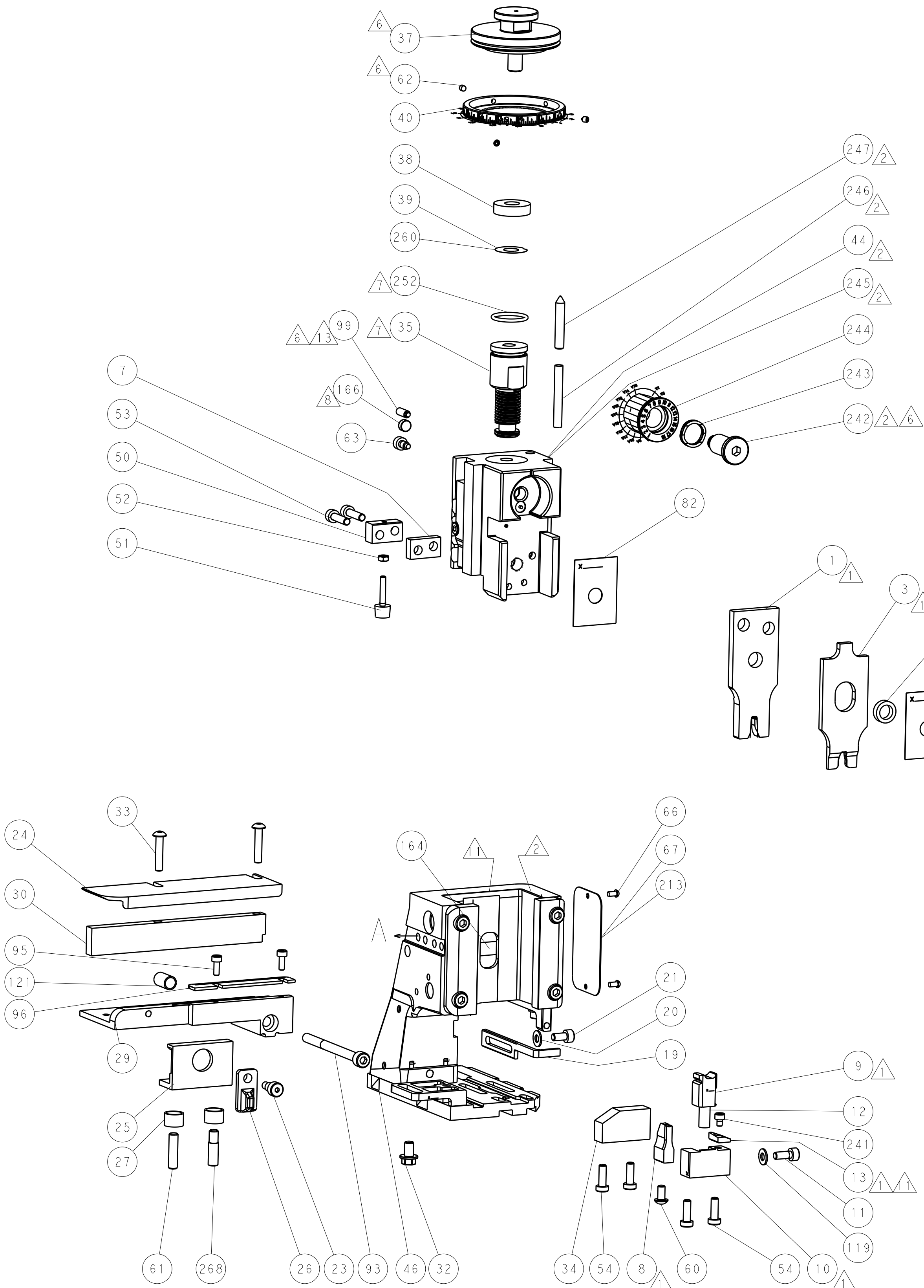
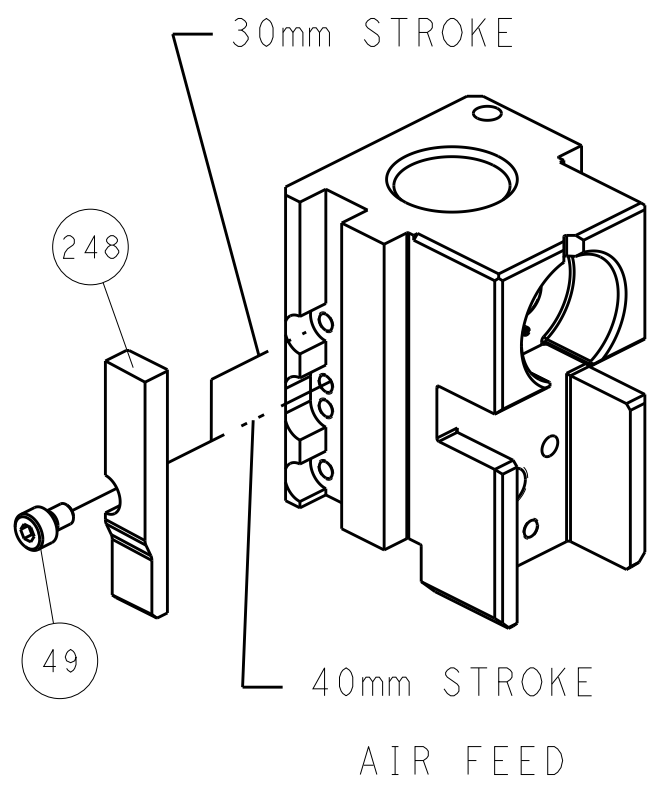
## FEED TYPE PNEUMATIC



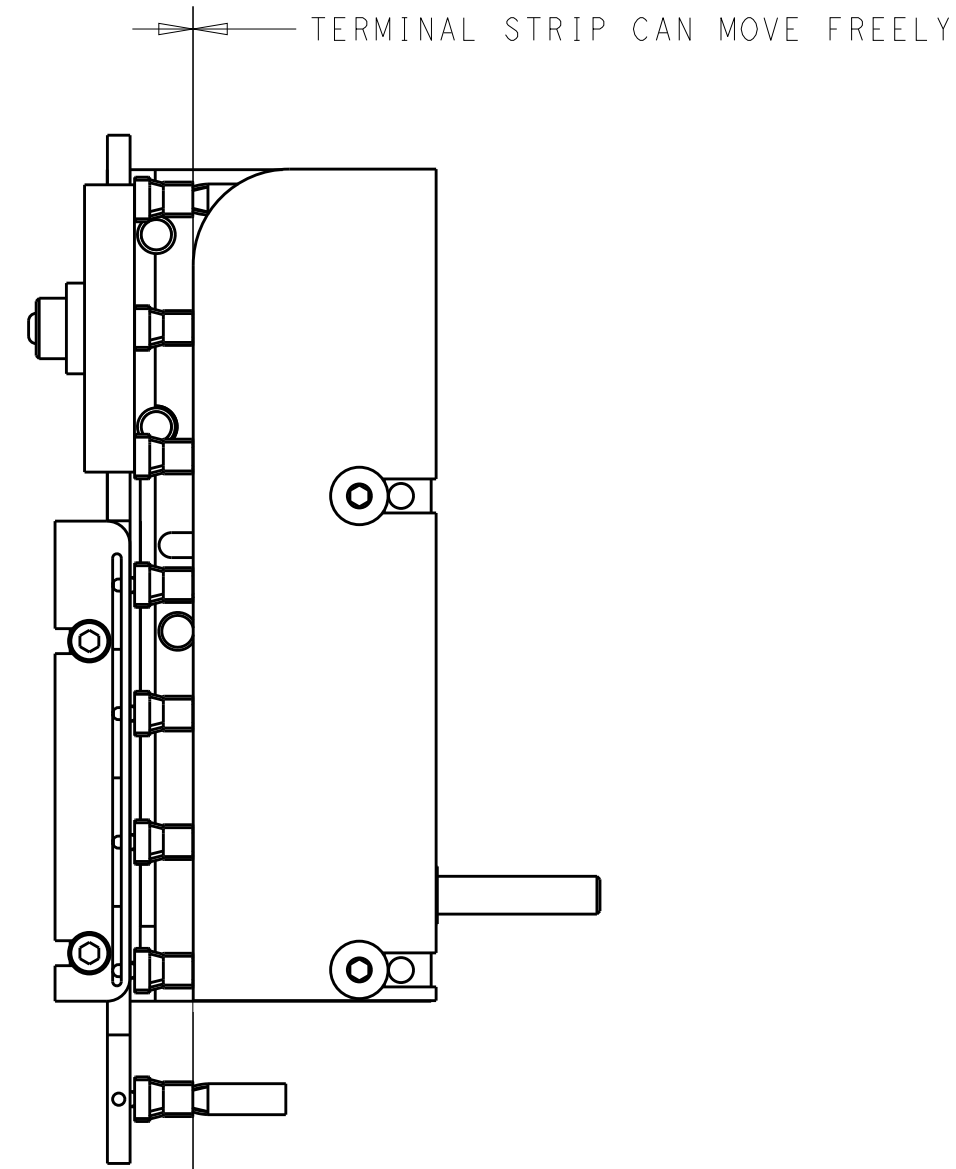
## SERVO LATCH PLATE



## CAM POSITIONS

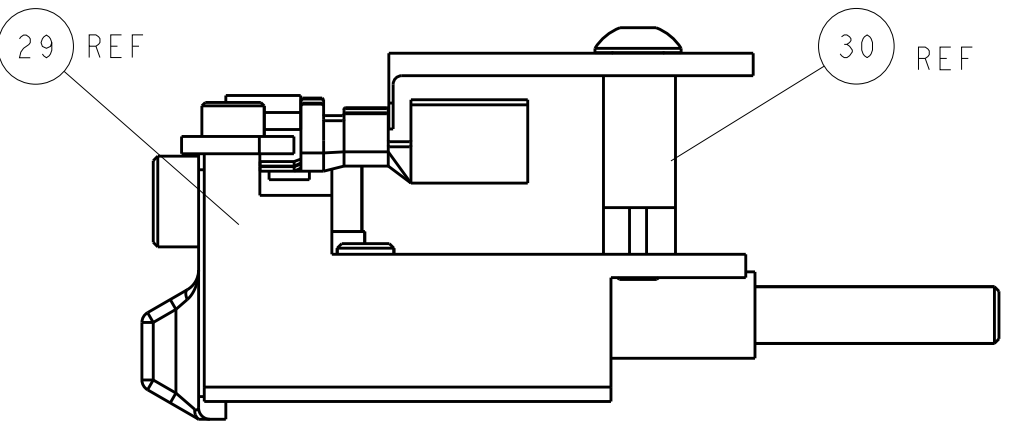


TERMINAL SUPPORT LOCATION



TERMINAL STRIP CAN MOVE FREELY  
WITH A MINIMUM OF SIDE CLEARANCE

ITEM 30 LOCATED AT  
REAR HOLES



FEED TRACK POSITION  
GUIDE BY WIRE BARREL

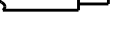
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)

|             |  |                                           |  |                                        |  |                           |  |
|-------------|--|-------------------------------------------|--|----------------------------------------|--|---------------------------|--|
| DIMENSIONS: |  | TOLERANCES UNLESS<br>OTHERWISE SPECIFIED: |  | DWN                                    |  | TE Connectivity           |  |
| mm          |  | 0 PLC ±                                   |  | R. KNEPPER                             |  | Harrisburg, PA 17105-3608 |  |
|             |  | 1 PLC ±                                   |  | 18JAN2012                              |  |                           |  |
|             |  | 2 PLC ±                                   |  | T. ELBIN                               |  |                           |  |
|             |  | 3 PLC ±                                   |  | 18JAN2012                              |  |                           |  |
|             |  | 4 PLC ±                                   |  | M. CLIFFORD                            |  |                           |  |
|             |  | ANGLES ±                                  |  | PRODUCT SPEC                           |  |                           |  |
|             |  | FINISH ±                                  |  | APPLICATION SPEC                       |  |                           |  |
| MATERIAL    |  | WEIGHT                                    |  | SIZE                                   |  | RESTRICTED TO             |  |
|             |  |                                           |  | A1                                     |  |                           |  |
|             |  |                                           |  | 00779                                  |  |                           |  |
|             |  |                                           |  | C=2151550                              |  |                           |  |
|             |  |                                           |  | Customer Accessible Production Drawing |  |                           |  |
|             |  |                                           |  | SCALE                                  |  |                           |  |
|             |  |                                           |  | 1:2                                    |  |                           |  |
|             |  |                                           |  | SHEET                                  |  |                           |  |
|             |  |                                           |  | 2                                      |  |                           |  |
|             |  |                                           |  | OF                                     |  |                           |  |
|             |  |                                           |  | 4                                      |  |                           |  |
|             |  |                                           |  | REV                                    |  |                           |  |
|             |  |                                           |  | F                                      |  |                           |  |

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

| PACIFIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER | PART<br>NUMBER | REVISION | DESCRIPTION              | FEED TYPE                         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|----------------------------------------------------|----------------|----------|--------------------------|-----------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|                                                    |                |          |                          |                                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|                                                    |                |          |                          |                                   |                                   | -                     | -         | -           | -         | -         | -                      |
|                                                    | 2-2151550-2    | F        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                         | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151550-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|                                                    | 2-2151550-5    | F        | FINE CRIMP HEIGHT ADJUST | SERVO<br>LATCH PLATE <sup>4</sup> | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151550-4 | -         | -         | -                      |
|                                                    | 2-2151550-7    | F        | FINE CRIMP HEIGHT ADJUST | NONE                              | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|                                                    | 7-2151550-7    | A        | CRIMP TOOLING KIT        | -                                 | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.79 mm [.110] | F    |
| INSUL                                | 3.56 mm [.140] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

|                                                                                                                      |             |                                                                                   |                                                           |
|----------------------------------------------------------------------------------------------------------------------|-------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                                           |             | TE CRIMP SPECIFICATION                                                            |                                                           |
| TERMINAL NAME: AMP MCP 6.3/4.8 K LITEALUM CONTACT                                                                    |             |                                                                                   |                                                           |
| WIRE STRIP LENGTH<br>3.40-4.00 mm [.134-.157 IN]                                                                     |             |  | INSULATION DIAMETER RANGE<br>Ø2.88-3.04 mm [.113-.120 IN] |
| TERMINAL APPLICATION SPECIFICATION  |             | 114-94204                                                                         | -                                                         |
|                                                                                                                      |             | -                                                                                 | -                                                         |
| TERMINALS APPLIED                   |             |                                                                                   |                                                           |
| TE TERMINAL                                                                                                          | TE TERMINAL | TE TERMINAL                                                                       | TE TERMINAL                                               |
| 2-2177838-1                                                                                                          |             |                                                                                   |                                                           |

|           |  |                           |  |                                   |
|-----------|--|---------------------------|--|-----------------------------------|
| WIRE SIZE |  | CRIMP HEIGHT<br>mm [INCH] |  | CRIMP HEIGHT<br>REFERENCE SETTING |
| 2.50mm2   |  | 1.77±0.04 [.0697±.0016]   |  | 7.2                               |



- <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: 8-2151550-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151550-5
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.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- <sup>8</sup> MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>12</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.
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, MISMUMI           | 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     |
| -   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242     |
| -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<br>2119599-1 | LOC<br>A | DIST<br>66 | REVISIONS |     |             |      |     |
|---------------------------|----------|------------|-----------|-----|-------------|------|-----|
|                           |          |            | P         | LTR | DESCRIPTION | DATE | OWN |
|                           |          |            | -         | -   | SEE SHEET 1 | -    | -   |
|                           |          |            |           |     |             |      |     |
|                           |          |            |           |     |             |      |     |

|                            |     |     |     |             |                                     |         |
|----------------------------|-----|-----|-----|-------------|-------------------------------------|---------|
| -                          | 1   | 1   | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241     |
| -                          | -   | 2   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16       | 240     |
| -                          | -   | -   | 1   | 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     |
| <sup>8</sup>               | 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     |
| <sup>7</sup>               | 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     |
| <sup>7</sup>               | 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     |
| <sup>12</sup> <sup>6</sup> | -   | 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   | 455888-4    | 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      |
| -                          | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
| <sup>6</sup>               | 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   | 1-2119644-2 | RAM WASHER, PRECISION               | 38      |
| -                          | 1   | 1   | 1   | 1-1752356-1 | 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   | 1320908-7   | SPACER, STRIP GUIDE                 | 30      |
| -                          | 1   | 1   | 1   | 1901086-1   | PLATE, STRIP GUIDE                  | 29      |
| -                          | 1   | 1   | 1   | 455888-3    | 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      |
| -                          | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
| -                          | 1   | 1   | 1   | 690472-2    | STRIPPER                            | 19      |
| <sup>1</sup>               | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13      |
| -                          | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12      |
| -                          | 1   | 1   | 1   | 1-18023-1   | SCR, SKT HD CAP M4 X 10.0           | 11      |
| <sup>1</sup>               | -   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
| <sup>1</sup>               | -   | 1   | 1   | 462006-6    | FLOATING SHEAR, FRONT               | 9       |
| <sup>1</sup>               | 1   | 1   | 1   | 2161316-3   | 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   | 5-238011-2  | BLOCK, CRIMPER SPACER               | 4       |
| <sup>1</sup>               | 1   | 1   | 1   | 1722335-7   | CRIMPER, INSULATION F               | 3       |
| -                          | -   | -   | -   | -           | -                                   | 2       |
| <sup>1</sup>               | 1   | 1   | 1   | 2217302-1   | CRIMPER, WIRE, CONICAL BLEND        | 1       |
| -77                        | -27 | -25 | -22 | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                                                                                                                       |  |  |  |                                        |                                              |                 |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|----------------------------------------|----------------------------------------------|-----------------|
| THE PROPERTY OF COMPANY IS HEREBY CERTIFIED TO COMPANY BY THE SIGNATURE OF THE AUTHORIZED REPRESENTATIVE OF THE COMPANY. IT IS SUBJECT TO COMPANY'S POLICY AND THE COMPANY'S ORGANIZATION SHALL BE CONTACTED FOR THE LATEST NOTATION. |  |  |  | OWN<br>CHR.KNEPPER<br>18JAN2012        | TE Connectivity<br>Harrisburg, PA 17105-3608 |                 |
| DIMENSIONS:<br>mm                                                                                                                                                                                                                     |  |  |  | CHK<br>T.ELBIN<br>18JAN2012            |                                              |                 |
|                                                                                                                                                                                                                                       |  |  |  | APVD<br>M.CILFORD<br>18JAN2012         | NAME<br>Ocean Side Feed<br>Applicator        |                 |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.1<br>1 PLC ±.1<br>2 PLC ±.1<br>3 PLC ±.1<br>4 PLC ±.1<br>ANGLES ±.1                                                                                                                 |  |  |  | PRODUCT SPEC<br>-                      | SIZE<br>A1                                   |                 |
| MATERIAL<br>-                                                                                                                                                                                                                         |  |  |  | APPLICATION SPEC<br>-                  | CASE CODE<br>00779                           |                 |
| FINISH<br>-                                                                                                                                                                                                                           |  |  |  | WEIGHT<br>-                            | DRAWING NO<br>C=2151550                      |                 |
|                                                                                                                                                                                                                                       |  |  |  | Customer Accessible Production Drawing | SCALE<br>1:2                                 | SHEET<br>3 OF 4 |
|                                                                                                                                                                                                                                       |  |  |  |                                        | REV<br>F                                     |                 |

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION