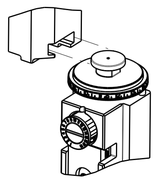
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|---|---|---|---|---|
|  | 2151619-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| | 2151619-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| | 2151619-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE 4 |
| | 2151619-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE 4 12 |
| | 2151619-7 | A | FINE CRIMP HEIGHT ADJUST | NONE |
| | 7-2151619-7 | A | CRIMP TOOLING KIT | - |

APPLICATOR STYLE CONVERSION CHART

| CONVERT TO | PART NUMBERS REQUIRED | | | | | |
|---|---|---|---|---|---|---|
| PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 |
| SERVO LATCH PLATE | 2119951-1 | - | 8-2151619-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| SMART APPLICATOR | 2161326-1 | - | 8-2151619-4 | - | - | - |
| MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - |
| SERVO LATCH PLATE | 2119951-1 | - | 8-2151619-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| SMART APPLICATOR | 2161326-1 | - | 8-2151619-4 | - | - | - |
| MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - |
| PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 |
| - | - | - | - | - | - | - |
| - | - | - | - | - | - | - |
| - | - | - | - | - | - | - |
| - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|---|---|---|
| CRIMP | SIZE | TYPE |
| WIRE | 2.54 mm [.100] | F |
| INSUL | 3.94 mm [.155] | O |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION |
|---|---|---|
| TERMINAL NAME: 2.8 mm RECEPTACLE | | |
| WIRE STRIP LENGTH 4.78-5.59 mm [.188-.220 IN] | | INSULATION DIAMETER RANGE ∅1.88-2.35 mm [.074-.093 IN] |
| TERMINAL APPLICATION SPECIFICATION | 114-13013 | - |
| | - | - |

| TERMINALS APPLIED | | | |
|---|---|---|---|
| TE TERMINAL | TE TERMINAL | TE SEAL | TE SEAL |
| 1-1326032-0 | 1326031-9 | 1949064-1 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING 9 |
|---|---|---|
| 16 AWG | 1.49+/-0.05 [.059+/-.002] | 11.4 |

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:
- MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151619-4
- PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151619-4
- SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151619-5
- SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151619-6

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 50, 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.

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 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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 -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

14 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

*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.

| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |
|---|---|---|---|---|---|---|---|---|
| - | 1 | 1 | 1 | 1 | 1 | 455888-1 | SPACER, CRIMPER | 261 |
| - | - | 1 | - | - | - | 2119957-2 | APPLICATOR SHIM PACK | 260 |
| - | 1 | - | 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 | 1 | 2119798-1 | DETENT PIN | 247 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-1 | SPACER, CRIMPER | 246 |
| - | - | 1 | - | - | - | 2161312-1 | RAM, STEPPED, ASIAN STYLE, SIDE FEED | 245 |
| - | 1 | 1 | 1 | 1 | 1 | 2119082-8 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| 6 | 1 | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 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 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | - | - | - | 1 | - | 2063440-1 | AIR FEED MODULE | 238 |
| - | - | 1 | 1 | - | - | 2119740-2 | TAG,IDENTIFICATION | 213 |
| - | - | 1 | 1 | - | - | 1901094-3 | SPACER, FEEDER | 198 |
| - | 1 | 1 | 1 | 1 | 1 | 6-993111-6 | PIN, SLOTTED SPRING 3.0 X 14.0 | 177 |
| - | 1 | 1 | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 |
| - | 1 | 1 | 1 | 1 | 1 | 1752353-2 | GUIDE PIN,HOLDDOWN | 175 |
| - | 1 | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN,HOLDDOWN | 174 |
| - | - | - | - | 2 | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | 1 | 1 | 1 | 1 | 1 | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 |
| - | REF | 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 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | REF | REF | - | - | 2119944-1 | FEED FINGER ASSEMBLY,SF | 117 |
| - | 1 | 1 | 1 | 1 | 1 | 2-455888-9 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | - | - | 1 | 1 | 2119740-1 | TAG,IDENTIFICATION | 67 |
| - | 2 | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | - | 1 | 1 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| 6 | 3 | - | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62 |
| - | 1 | 1 | 1 | 1 | 1 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 60 |
| - | - | - | - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1 | 1 | 1 | 1 | 985575-3 | SCR, FLT SKT HD CAP M3 X 10.0 | 57 |
| - | - | - | - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 4 | 4 | 4 | 4 | 4 | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 54 |
| - | 1 | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 |
| - | 1 | 1 | 1 | 1 | 1 | 1901681-1 | HOLDDOWN, TERMINAL | 51 |
| 6 | 1 | 1 | 1 | 1 | 1 | 2-1752354-0 | STANDOFF,HOLD-DOWN | 50 |
| - | - | - | - | 1 | 2 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | - | - | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | - | - | - | - | 1 | 2119653-1 | FEED CAM, POST FEED | 47 |
| - | 1 | 1 | 1 | 1 | 1 | 2119656-9 | APPLICATOR BASIC ASSEMBLY, SF | 46 |
| - | 1 | - | 1 | 1 | 1 | 2161311-1 | RAM, STEPPED, AMP STYLE, SIDE FEED | 44 |
| - | 1 | 1 | 1 | 1 | 1 | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 1 | - | 1 | 1 | 1 | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 |
| - | 1 | - | 1 | 1 | 1 | 2119957-1 | APPLICATOR SHIM PACK | 39 |
| - | 1 | 1 | 1 | 1 | 1 | 2119644-2 | RAM WASHER, PRECISION | 38 |
| 6 | 1 | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 |
| - | 1 | - | 1 | 1 | 1 | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| - | 1 | 1 | 1 | 1 | 1 | 1752356-3 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 1 | 1 | 1 | 1 | 1 | 2161328-1 | HEX HEAD, FLANGED, M5 x 8mm LONG | 32 |
| - | 1 | 1 | 1 | 1 | 1 | 1-1320908-0 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1 | 2119959-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 28 |
| - | 1 | 1 | 1 | 1 | 1 | 1320928-6 | STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1 | 1 | 1 | 1 | 2119533-3 | STRIPPER, SIDE FEED | 19 |
| 1 | 1 | 1 | 1 | 1 | 1 | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 1 | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1 | 1 | 1 | 1 | 1-356885-4 | STOP, SHEAR | 11 |
| 1 | 1 | 1 | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| 1 | 1 | 1 | 1 | 1 | 1 | 318707-1 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1633922-5 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 2119781-1 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 3-238011-3 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 1 | 1 | 1 | 2-1633965-9 | CRIMPER, INSULATION O PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 2-455888-5 | SPACER, CRIMPER | 2 |
| 1 | 1 | 1 | 1 | 1 | 1 | 856313-9 | CRIMPER, WIRE | 1 |
| -77 | -7 | -6 | -5 | -2 | -1 | 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)

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

| SET UP GAUGE 2119599-1 | LOC A | DIST 66 |
|---|---|---|

REVISIONS

| P | LTR | DESCRIPTION | DATE | DWN | APVD |
|---|---|---|---|---|---|
| | A | RELEASED | 07MAY2012 | CC | SX |
| | A1 | REVISED ECR-13-009037 | 03JUN2013 | KH | TE |

| DWN | HOFFNER 12MARCH2012 |
|---|---|
| CHK | T.ELBIN 13MARCH2012 |
| APVD | T.ELBIN 13MARCH2012 |
| PRODUCT SPEC | - |
| APPLICATION SPEC | - |
| WEIGHT | - |

TE Connectivity
Harrisburg, PA 17105-3608

NAME Ocean Side Feed Applicator -

| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|---|---|---|---|
| A1 | 00779 | C-2151619 | - |

Customer Accessible Production Drawing | SCALE 1:1 | SHEET 1 OF 4 | REV A1

DIMENSIONS: mm
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±- ; 1 PLC ±0.1 ; 2 PLC ±0.02 ; 3 PLC ±0.005 ; 4 PLC ±0.0005 ; ANGLES ±-
MATERIAL -
FINISH -

THIS DRAWING IS CONTROLLED DOCUMENT OF TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE. CONTACT THE ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

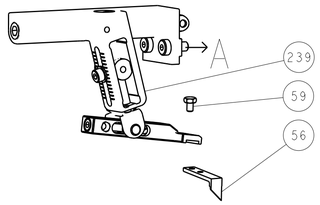
| LOC | DIST |
|---|---|
| A | 66 |

REVISIONS

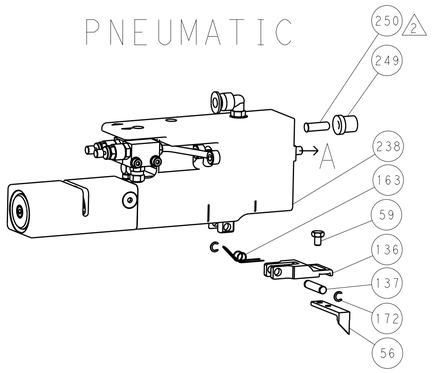
| P | LTR | DESCRIPTION | DATE | DWN | APVD |
|---|---|---|---|---|---|
| | - | SEE SHEET 1 | - | - | - |

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009

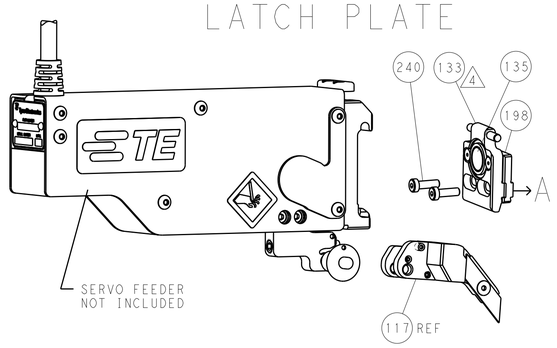
## FEED TYPE MECHANICAL



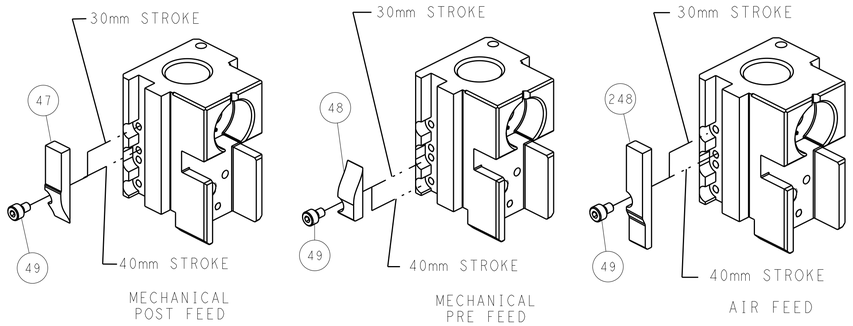

## PNEUMATIC

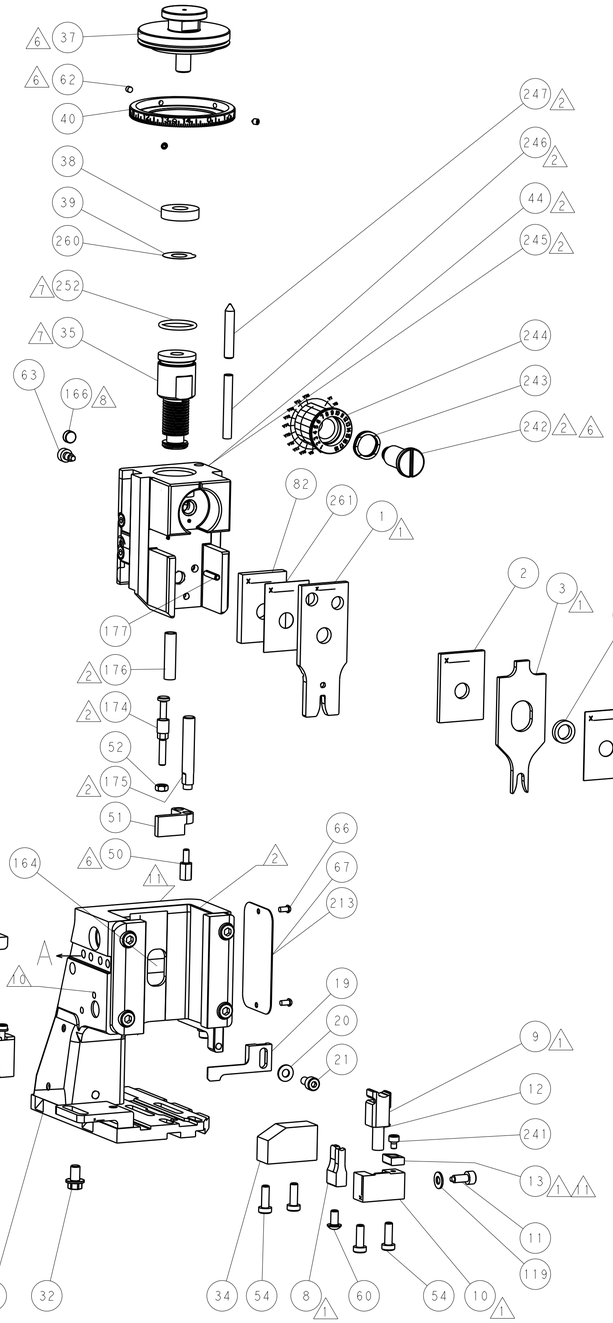


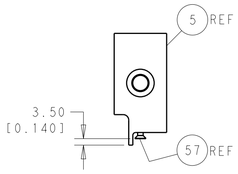

## SERVO LATCH PLATE



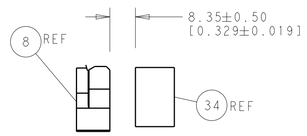

## CAM POSITIONS



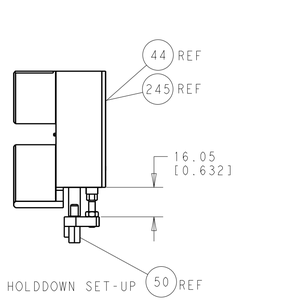



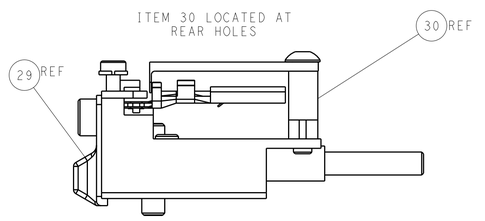

SHEAR DEPRESSOR DETAIL




TERMINAL SUPPORT LOCATION




HOLDDOWN SET-UP




FEED TRACK POSITION GUIDE BY INSULATION BARREL

## ATLANTIC VERSION

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

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND ITS CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±.
1 PLC ±0.1
2 PLC ±0.02
3 PLC ±0.005
4 PLC ±0.0005
ANGLES ±.

MATERIAL -
FINISH -

| | | |
|---|---|---|
| DWN | HOFFNER | 12MARCH2012 |
| CHK | T ELBIN | 13MARCH2012 |
| APVD | T ELBIN | 13MARCH2012 |
| PRODUCT SPEC | - | |
| APPLICATION SPEC | - | |
| WEIGHT | - | |

TE Connectivity
Harrisburg, PA 17105-3608

NAME: Ocean Side Feed Applicator -

SIZE A1 | CAGE CODE 00779 | DRAWING NO C-2151619 | RESTRICTED TO -

Customer Accessible Production Drawing | SCALE 1:1 | SHEET 2 OF 4 | REV A1

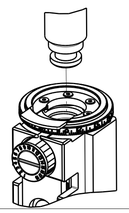
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

| SET UP GAUGE | LOC | DIST |
|---|---|---|
| 2119599-1 | A | 66 |

REVISIONS

| P | LTR | DESCRIPTION | DATE | DWN | APVD |
|---|---|---|---|---|---|
| | - | SEE SHEET 1 | - | - | - |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE |
|---|---|---|---|---|
|  | 2-2151619-1 | A | FINE CRIMP HEIGHT ADJUST | MECHANICAL |
| | 2-2151619-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| | 2-2151619-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE 4 |
| | 2-2151619-7 | A | FINE CRIMP HEIGHT ADJUST | NONE |
| | 7-2151619-7 | A | CRIMP TOOLING KIT | - |

APPLICATOR STYLE CONVERSION CHART

| 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 | - | 8-2151619-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| SMART APPLICATOR | 2161326-1 | - | 8-2151619-4 | - | - | - |
| MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| SERVO LATCH PLATE | 2119951-1 | - | 8-2151619-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| SMART APPLICATOR | 2161326-1 | - | 8-2151619-4 | - | - | - |
| MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 |
| - | - | - | - | - | - | - |
| - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|---|---|---|
| CRIMP | SIZE | TYPE |
| WIRE | 2.54 mm [.100] | F |
| INSUL | 3.94 mm [.155] | O |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION |
|---|---|---|
| TERMINAL NAME: 2.8 mm RECEPTACLE | | |
| WIRE STRIP LENGTH 4.78-5.59 mm [.188-.220 IN] | | INSULATION DIAMETER RANGE ∅1.88-2.35 mm [.074-.093 IN] |
| TERMINAL APPLICATION SPECIFICATION | 114-13013 | - |
| | - | - |

TERMINALS APPLIED

| TE TERMINAL | TE TERMINAL | TE SEAL | TE SEAL |
|---|---|---|---|
| 1-1326032-0 | 1326031-9 | 1949064-1 | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING 9 |
|---|---|---|
| 16 AWG | 1.49+/-0.05 [.059+/-.002] | 11.4 |

*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. 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:
   MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151619-4
   PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151619-4
   SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151619-5
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 50, 62 & 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. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
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. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
13. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| - | 1 | 1 | 1 | 1 | 455888-1 | SPACER, CRIMPER | 261 |
| - | 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 |
| - | 1 | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| -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)

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| - | 1 | 1 | 1 | 1 | 2119082-8 | 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 |
| - | 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 | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | - | - | 1 | - | 2063440-1 | AIR FEED MODULE | 238 |
| - | - | 1 | - | - | 2119740-2 | TAG,IDENTIFICATION | 213 |
| - | - | 1 | - | - | 1901094-3 | SPACER, FEEDER | 198 |
| - | 1 | 1 | 1 | 1 | 6-993111-6 | PIN, SLOTTED SPRING 3.0 X 14.0 | 177 |
| - | 1 | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 |
| - | 1 | 1 | 1 | 1 | 1752353-2 | GUIDE PIN,HOLDDOWN | 175 |
| - | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN,HOLDDOWN | 174 |
| - | - | - | 2 | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | 1 | 1 | 1 | 1 | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 |
| - | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | - | - | 1 | - | 240638-1 | SPRING, FEED FINGER | 163 |
| - | 1 | 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 | 1 | 2119798-2 | DETENT PIN | 145 |
| - | 1 | 1 | 1 | 1 | 2079383-8 | SCR, BHSC, RoHS (M4 X 16) | 144 |
| - | 4 | 4 | 4 | 4 | 2168400-5 | SHCS, LOW HEAD, RoHS, M4 X 20 | 143 |
| - | - | - | - | 1 | 2119653-2 | FEED CAM, POST FEED | 142 |
| - | 1 | 1 | 1 | 1 | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF | 141 |
| - | 1 | 1 | 1 | 1 | 2161314-1 | RAM, STEPPED, ATLANTIC, SF, NON-ADJ | 140 |
| - | 1 | 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 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | REF | - | - | 2119944-1 | FEED FINGER ASSEMBLY,SF | 117 |
| - | 1 | 1 | 1 | 1 | 2-455888-9 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | - | 1 | 1 | 2119740-1 | TAG,IDENTIFICATION | 67 |
| - | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | 1 | 1 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| 6 - | 3 | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62 |
| - | - | - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1 | 1 | 1 | 985575-3 | SCR, FLT SKT HD CAP M3 X 10.0 | 57 |
| - | - | - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 |
| - | 1 | 1 | 1 | 1 | 1901681-1 | HOLDDOWN, TERMINAL | 51 |
| 6 - | 1 | 1 | 1 | 1 | 2-1752354-0 | STANDOFF,HOLD-DOWN | 50 |
| - | - | - | 1 | 2 | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | - | - | 1 | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | 1 | 1 | 1 | 1 | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 1 | 1 | 1 | 1 | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 |
| - | 1 | 1 | 1 | 1 | 2119957-1 | APPLICATOR SHIM PACK | 39 |
| - | 1 | 1 | 1 | 1 | 2119644-2 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1 | 1752356-3 | 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 | 1-1320908-0 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 2119959-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 28 |
| - | 1 | 1 | 1 | 1 | 1320928-6 | STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1 | 1 | 1 | 2119533-3 | STRIPPER, SIDE FEED | 19 |
| 1 - | 1 | 1 | 1 | 1 | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1 | 1 | 1 | 1-356885-4 | STOP, SHEAR | 11 |
| 1 - | 1 | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| 1 - | 1 | 1 | 1 | 1 | 318707-1 | FLOATING SHEAR, FRONT | 9 |
| 1 1 | 1 | 1 | 1 | 1 | 1633922-5 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 2119781-1 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 3-238011-3 | BLOCK, CRIMPER SPACER | 4 |
| 1 1 | 1 | 1 | 1 | 1 | 2-1633965-9 | CRIMPER, INSULATION O PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 2-455888-5 | SPACER, CRIMPER | 2 |
| 1 1 | 1 | 1 | 1 | 1 | 856313-9 | CRIMPER, WIRE | 1 |
| | -77 | -27 | -25 | -22 | -21 PART NO | DESCRIPTION | ITEM NO |

| | | | |
|---|---|---|---|
| DWN | HOFFNER | 12MARCH2012 | TE Connectivity Harrisburg, PA 17105-3608 |
| CHK | T.ELBIN | 13MARCH2012 | |
| APVD | T.ELBIN | 13MARCH2012 | NAME Ocean Side Feed Applicator - |
| PRODUCT SPEC | - | | |
| APPLICATION SPEC | - | | SIZE A1 · CAGE CODE 00779 · DRAWING NO C-2151619 · RESTRICTED TO - |
| WEIGHT | - | | SHEET 3 OF 4 · REV A1 |
| DIMENSIONS: mm | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±- 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±- | | Customer Accessible Production Drawing · SCALE 1:1 |
| MATERIAL - - | FINISH - - | | |

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE. CONTACT TYCO ELECTRONICS CORPORATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009

THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20
© COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

| LOC | DIST |
|---|---|
| A | 66 |

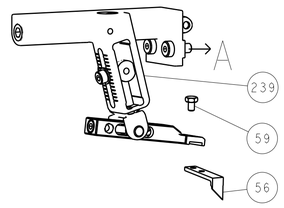
REVISIONS

| P | LTR | DESCRIPTION | DATE | DWN | APVD |
|---|---|---|---|---|---|
| | - | SEE SHEET 1 | - | - | - |

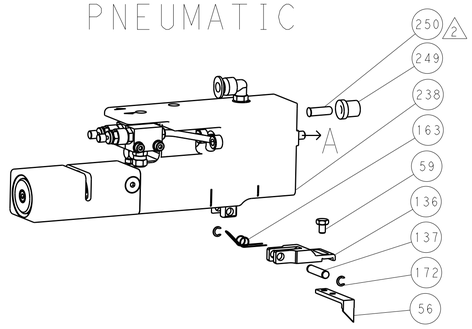
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009

# FEED TYPE

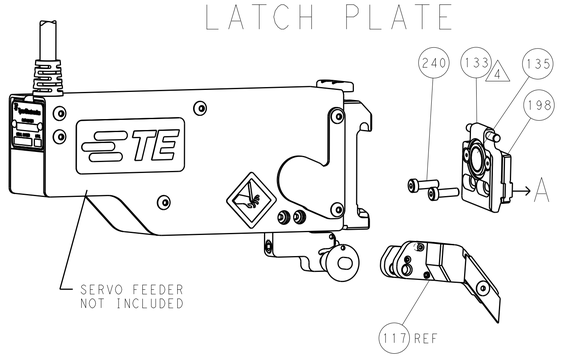
## MECHANICAL

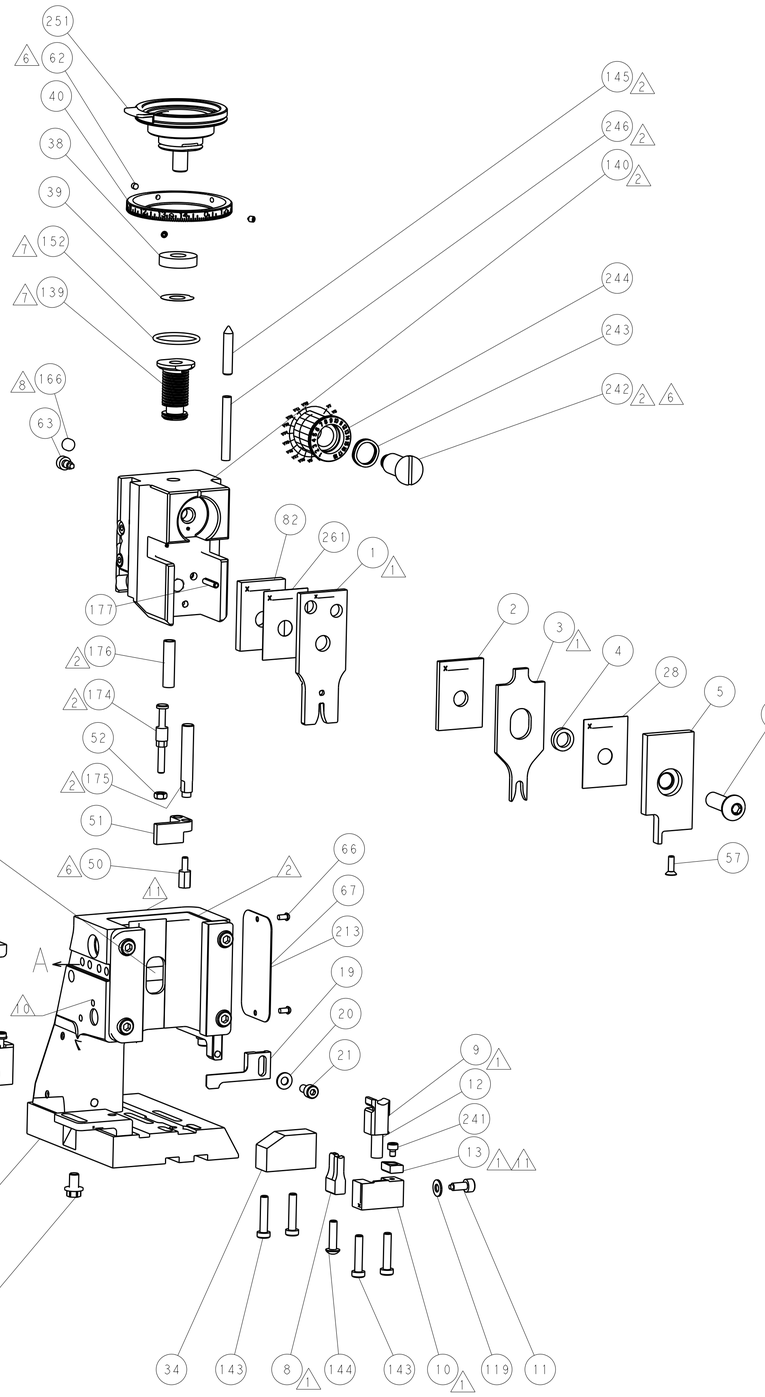


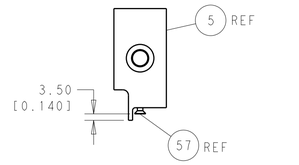

## PNEUMATIC



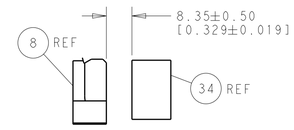

## SERVO LATCH PLATE



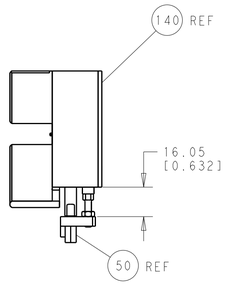




SHEAR DEPRESSOR DETAIL

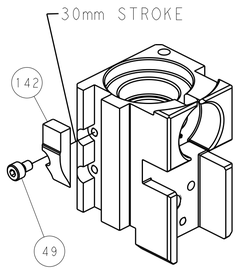



TERMINAL SUPPORT LOCATION

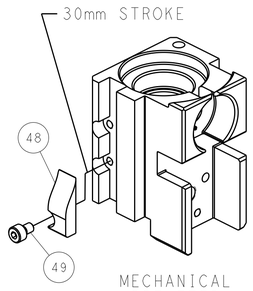



HOLDDOWN SET-UP

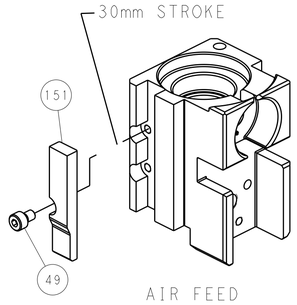
## CAM POSITIONS




MECHANICAL
POST FEED

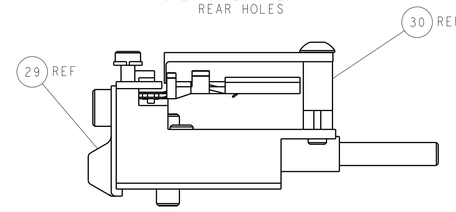



MECHANICAL
PRE FEED




AIR FEED

ITEM 30 LOCATED AT
REAR HOLES




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)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±-
1 PLC ±0.1
2 PLC ±0.02
3 PLC ±0.005
4 PLC ±0.0005
ANGLES ±-

MATERIAL -
FINISH -

| | | |
|---|---|---|
| DWN | HOFFNER | 12MARCH2012 |
| CHK | T. ELBIN | 13MARCH2012 |
| APVD | T. ELBIN | 13MARCH2012 |
| PRODUCT SPEC | - | |
| APPLICATION SPEC | - | |
| WEIGHT | - | |

TE Connectivity
Harrisburg, PA 17105-3608

NAME: Ocean Side Feed Applicator -

| SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|---|---|---|---|
| A1 | 00779 | C-2151619 | - |

Customer Accessible Production Drawing | SCALE 1:1 | SHEET 4 OF 4 | REV A1

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION