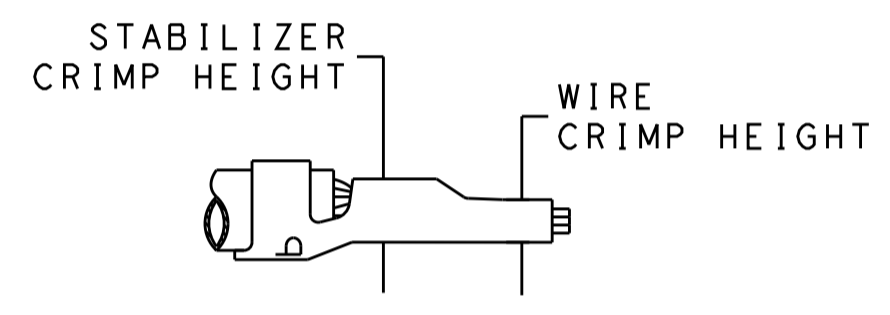


| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|----------|------------------------------|-------------------|-----------------------------------|-----------|-----------------------|-------------|-----------|-------------|------------------------|
| | | | | | CONVERT TO | | PART NUMBERS REQUIRED | | | | |
| | 2151314-1 | C | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151314-5 | 1901094-3 | 2-1752354-6 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151314-4 | - | - | - |
| | 2151314-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151314-5 | 1901094-3 | 2-1752354-6 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151314-4 | - | - | - |
| | 2151314-5 | C | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 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 |
| | 2151314-6 | C | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | - | - | - | - | - | - | - |
| | | | | | - | - | - | - | - | - | - |
| | 2151314-7 | C | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2151314-* | - | SEE CRIMP TOOLING KITS BELOW | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|-----------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.79 mm [.110] | F |
| STABILIZER | 2.79 mm [.110] | O |
| INSULATION | 3.94 mm [.155] | F |

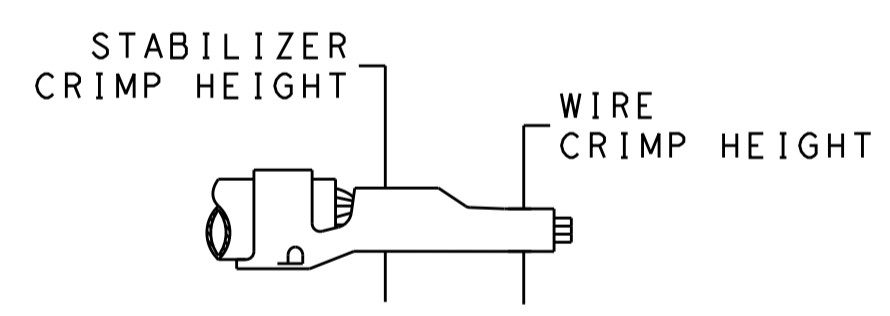
| PART NO | REV | WIRE SIZE | WIRE CRIMPER | STABILIZER CRIMPER | INSULATION CRIMPER | ANVIL |
|-------------|-----|-----------|--------------|--------------------|--------------------|-----------|
| 7-2151314-7 | C | 12 AWG | 7-456408-6 | 815664-2 | 6-2119582-7 | 1633923-5 |
| 7-2151314-8 | C | 14 AWG | 2-456408-5 | 815664-6 | 6-2119582-7 | 1633923-5 |
| 7-2151314-9 | C | 18-16 AWG | 2-456408-6 | 815664-7 | 6-2119582-7 | 1633923-5 |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|------------------------------------|-------------|------------------------------|-------------|
| TERMINAL NAME: AMP-IN | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.83-5.59 mm [.190-.220 IN] | | Ø2.29-3.81 mm [.090-.150 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-1016 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 3-794013-1 | | | |



| WIRE SIZE | WIRE CRIMP HEIGHT mm [INCH] | WIRE CRIMPER PART NUMBER | STABILIZER CRIMP HEIGHT mm [INCH] | STABILIZER CRIMPER PART NUMBER | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------|-----------------------------------|--------------------------------|--------------------------------|
| 12 AWG | 2.16+/-0.05 [.085+/- .002] | 7-456408-6 | 2.79+/-0.05 [.110+/- .002] | 815664-2 | 9.1 |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|------------------------------------|-------------|------------------------------|-------------|
| TERMINAL NAME: AMP-IN | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.83-5.59 mm [.190-.220 IN] | | Ø2.29-3.81 mm [.090-.150 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-1016 | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 3-770060-1 | | | |



| WIRE SIZE | WIRE CRIMP HEIGHT mm [INCH] | WIRE CRIMPER PART NUMBER | STABILIZER CRIMP HEIGHT mm [INCH] | STABILIZER CRIMPER PART NUMBER | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------|-----------------------------------|--------------------------------|--------------------------------|
| 14 AWG | 1.40+/-0.05 [.055+/- .002] | 2-456408-5 | 2.75+/-0.10 [.108+/- .004] | 815664-6 | 7.6 |
| 18-16 AWG | 1.09+/-0.05 [.043+/- .002] | 2-456408-6 | 2.40+/-0.10 [.094+/- .004] | 815664-7 | 7.8 |

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151314-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151314-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151314-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151314-6
- ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
 FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.

- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.72.
- ITEMS 1 & 178 TO BE USED WITH 12 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.
- ITEMS 253 & 254 TO BE USED WITH 14 AWG ONLY. ITEMS TO BE SHIPPED WITH APPLICATOR.
- ITEMS 255 & 256 TO BE USED WITH 18-16 AWG ONLY. APPLICATOR TO BE SET UP WITH THESE ITEMS.
- POSITION ITEM 19 BETWEEN ITEMS 1 AND 178.

***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.

| -79 | -78 | -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |
|-----|-----|-----|----|----|----|----|----|------------|-----------------------|---------|
| - | - | - | - | 1 | - | - | - | 2119957-2 | APPLICATOR SHIM PACK | 260 |
| 1 | - | - | 1 | 1 | 1 | 1 | 1 | 2-456408-6 | CRIMPER, WIRE PREMIUM | 256 |
| 1 | - | - | 1 | 1 | 1 | 1 | 1 | 815664-7 | CRIMPER, WIRE-O | 255 |

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

| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|---------------|-----------|------|
| 2119599-1 | A | 66 | REV | DATE | BY | APPV |
| | | | A | RELEASED | | |
| | | | B | ECR-15-010117 | 13MAR2015 | LG |
| | | | B1 | ECR-15-011816 | 10AUG2015 | JH |
| | | | C | ECR-16-005909 | 09MAY2016 | KH |

| REV | DATE | BY | APPV | DESCRIPTION | ITEM NO | | | | | | |
|-----|------|----|------|-------------|---------|---|---|---|-------------|-------------------------------------|-----|
| - | - | - | - | 1 | 1 | 1 | 1 | 1 | 2-456408-5 | CRIMPER, WIRE PREMIUM | 254 |
| - | - | - | - | 1 | 1 | 1 | 1 | 1 | 815664-6 | CRIMPER, WIRE-O | 253 |
| - | - | - | - | 1 | 1 | 1 | 1 | 1 | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252 |
| - | - | - | - | - | - | - | - | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | - | - | - | - | - | - | 2079988-1 | BUSHING, LCH5-12, MISUMI | 249 |
| - | - | - | - | - | - | - | - | - | 2119641-1 | FEED CAM, AIR FEED | 248 |
| - | - | - | - | - | - | - | - | - | 2119798-1 | DETENT PIN | 247 |
| - | - | - | - | - | - | - | - | - | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | - | - | - | - | - | - | - | - | 2119758-1 | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245 |
| - | - | - | - | - | - | - | - | - | 2119082-6 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | - | - | - | - | - | - | - | - | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | - | - | - | - | - | - | - | - | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | - | - | - | - | - | - | - | - | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | - | - | - | - | - | - | - | - | 2168400-6 | SHCS, LOW HEAD, RoHS, M5 X 16 | 240 |
| - | - | - | - | - | - | - | - | - | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | - | - | - | - | - | - | - | - | 2063440-1 | AIR FEED MODULE | 238 |
| - | - | - | - | - | - | - | - | - | 2119740-2 | TAG, IDENTIFICATION | 213 |
| - | - | - | - | - | - | - | - | - | 1901094-3 | SPACER, FEEDER | 198 |
| - | - | - | - | - | - | - | - | - | 7-456408-6 | CRIMPER, WIRE PREMIUM | 178 |
| - | - | - | - | - | - | - | - | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | - | - | - | - | - | - | - | - | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 |
| - | - | - | - | - | - | - | - | - | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | - | - | - | - | - | - | - | - | 240638-1 | SPRING, FEED FINGER | 163 |
| - | - | - | - | - | - | - | - | - | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
| - | - | - | - | - | - | - | - | - | 2119799-1 | HOLDER, FEED FINGER, AF | 136 |
| - | - | - | - | - | - | - | - | - | REF REF | SEE NOTE 4 | 135 |
| - | - | - | - | - | - | - | - | - | 1633743-1 | SERVO FEED LATCH ASM | 133 |
| - | - | - | - | - | - | - | - | - | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | - | - | - | - | - | - | - | REF REF | - | 117 |
| - | - | - | - | - | - | - | - | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | 117 |
| - | - | - | - | - | - | - | - | - | 455888-5 | SPACER, CRIMPER | 82 |
| - | - | - | - | - | - | - | - | - | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | - | - | - | - | - | - | - | - | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | - | - | - | - | - | - | - | - | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | - | - | - | - | - | - | - | - | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| - | - | - | - | - | - | - | - | - | 992763-5 | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62 |
| - | - | - | - | - | - | - | - | - | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 60 |
| - | - | - | - | - | - | - | - | - | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | - | - | - | - | - | - | - | - | 1338685-1 | PAWL, FEED | 56 |
| - | - | - | - | - | - | - | - | - | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 54 |
| - | - | - | - | - | - | - | - | - | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | - | - | - | - | - | - | - | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | - | - | - | - | - | - | - | - | 2119653-1 | FEED CAM, POST FEED | 47 |
| - | - | - | - | - | - | - | - | - | 2119656-9 | APPLICATOR BASIC ASSEMBLY, SF | 46 |
| - | - | - | - | - | - | - | - | - | 2119370-1 | RAM, AMP STYLE, SIDE FEED | 44 |
| - | - | - | - | - | - | - | - | - | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | - | - | - | - | - | - | - | - | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 |
| - | - | - | - | - | - | - | - | - | 2119957-1 | APPLICATOR SHIM PACK | 39 |
| - | - | - | - | - | - | - | - | - | 2119644-5 | RAM WASHER, PRECISION | 38 |
| - | - | - | - | - | - | - | - | - | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 |
| - | - | - | - | - | - | - | - | - | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| - | - | - | - | - | - | - | - | - | 469465-4 | STOP, WIRE | 34 |
| - | - | - | - | - | - | - | - | - | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | - | - | - | - | - | - | - | - | 2161328-1 | HEX HEAD, FLANGED, M5 X 8mm LONG | 32 |
| - | - | - | - | - | - | - | - | - | 1-1320908-0 | SPACER, STRIP GUIDE | 30 |
| - | - | - | - | - | - | - | - | - | 2119959-1 | ASSEMBLY, STRIP GUIDE | 29 |
| - | - | - | - | - | - | - | - | - | 455888-3 | SPACER, CRIMPER | 28 |
| - | - | - | - | - | - | - | - | - | 1320928-2 | STRIP GUIDE | 24 |
| - | - | - | - | - | - | - | - | - | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | - | - | - | - | - | - | - | - | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | - | - | - | - | - | - | - | - | 2119533-3 | STRIPPER, SIDE FEED | 19 |
| - | - | - | - | - | - | - | - | - | 2119806-1 | INSERT, SHEAR | 13 |
| - | - | - | - | - | - | - | - | - | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | - | - | - | - | - | - | - | - | 1-356885-4 | STOP, SHEAR | 11 |
| - | - | - | - | - | - | - | - | - | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | - | - | - | - | - | - | - | - | 462006-6 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1633923-5 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | - | - | - | - | 6 |
| - | - | - | - | - | - | - | - | - | - | - | 5 |
| - | - | - | - | - | - | - | - | - | - | - | 4 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1 | 6-2119582-7 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | - | - | - | - | - | - | - | - | 455888-7 | SPACER, CRIMPER | 2 |
| - | - | - | - | - | - | - | - | - | 815664-2 | CRIMPER, WIRE-O | 1 |

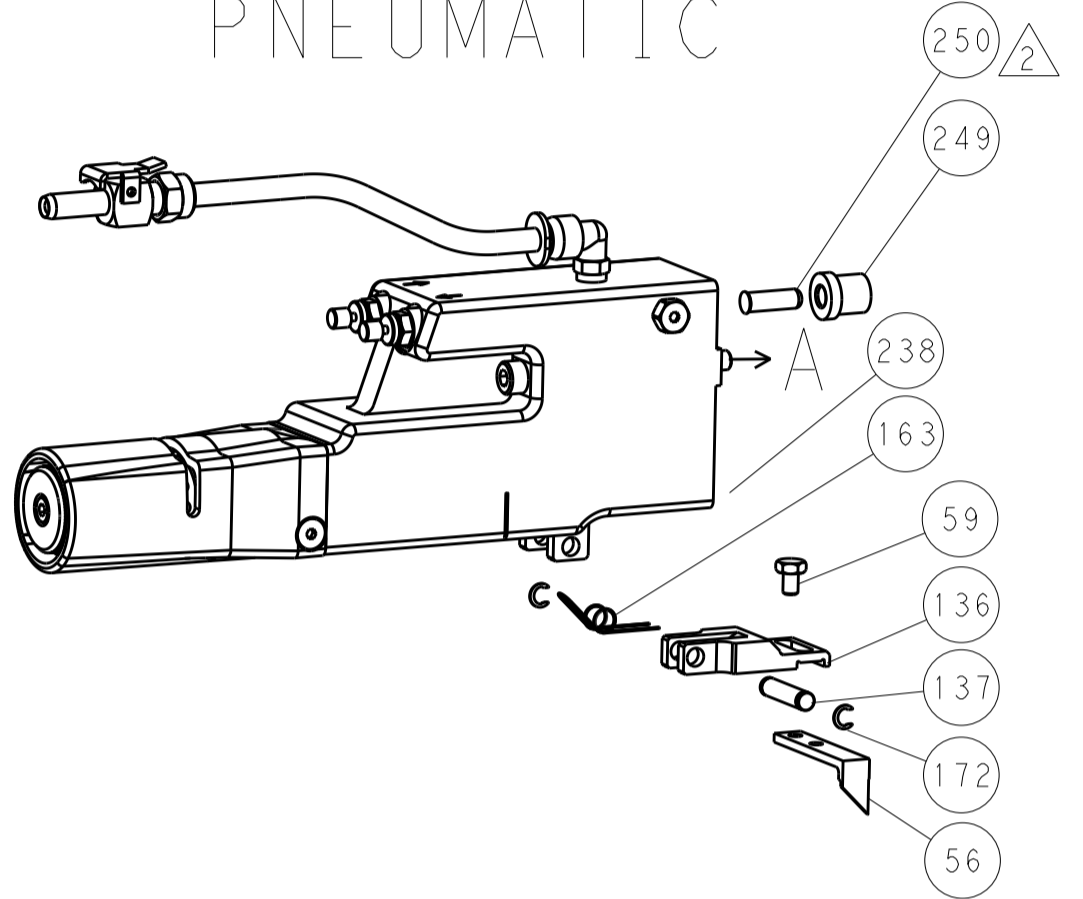
| | | | | | |
|----------------|---|--|---|-----------------|--------|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DATE: 31JAN2013 | |
| 0 PLC | ± | 1 PLC | ± | DATE: 31JAN2013 | REV: 1 |
| 2 PLC | ± | 3 PLC | ± | DATE: 31JAN2013 | REV: 2 |
| 4 PLC | ± | 5 PLC | ± | DATE: 31JAN2013 | REV: 3 |
| 6 PLC | ± | 7 PLC | ± | DATE: 31JAN2013 | REV: 4 |
| 8 PLC | ± | 9 PLC | ± | DATE: 31JAN2013 | REV: 5 |
| 10 PLC | ± | 11 PLC | ± | DATE: 31JAN2013 | REV: 6 |
| 12 PLC | ± | 13 PLC | ± | DATE: 31JAN2013 | REV: 7 |
| 14 PLC | ± | 15 PLC | | | |

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

FEED TYPE MECHANICAL



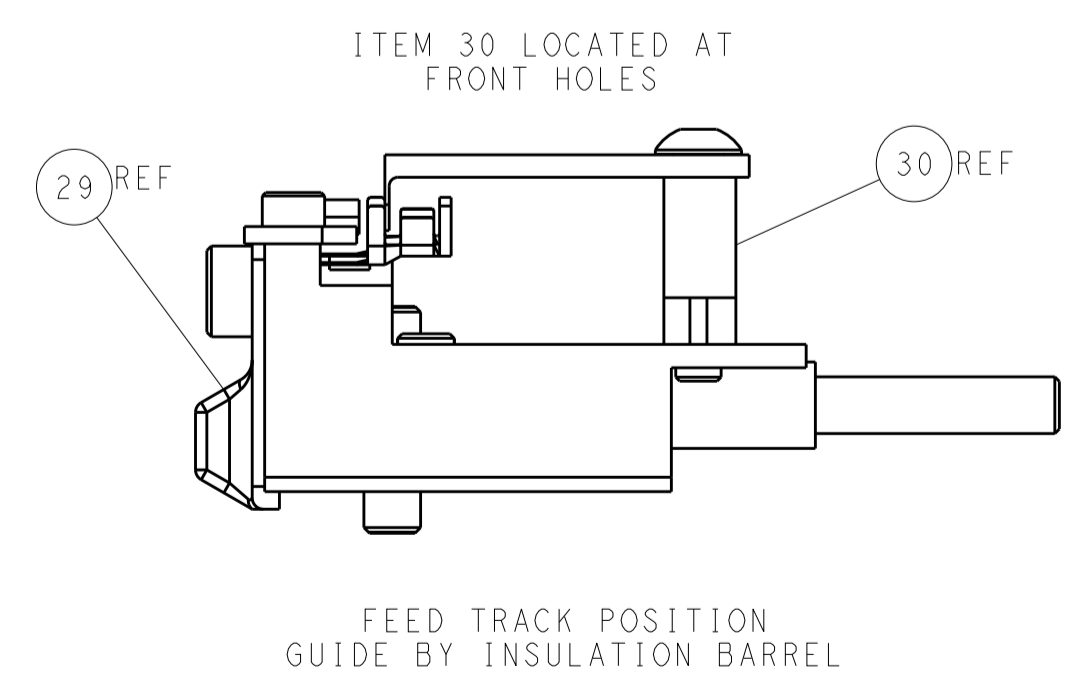
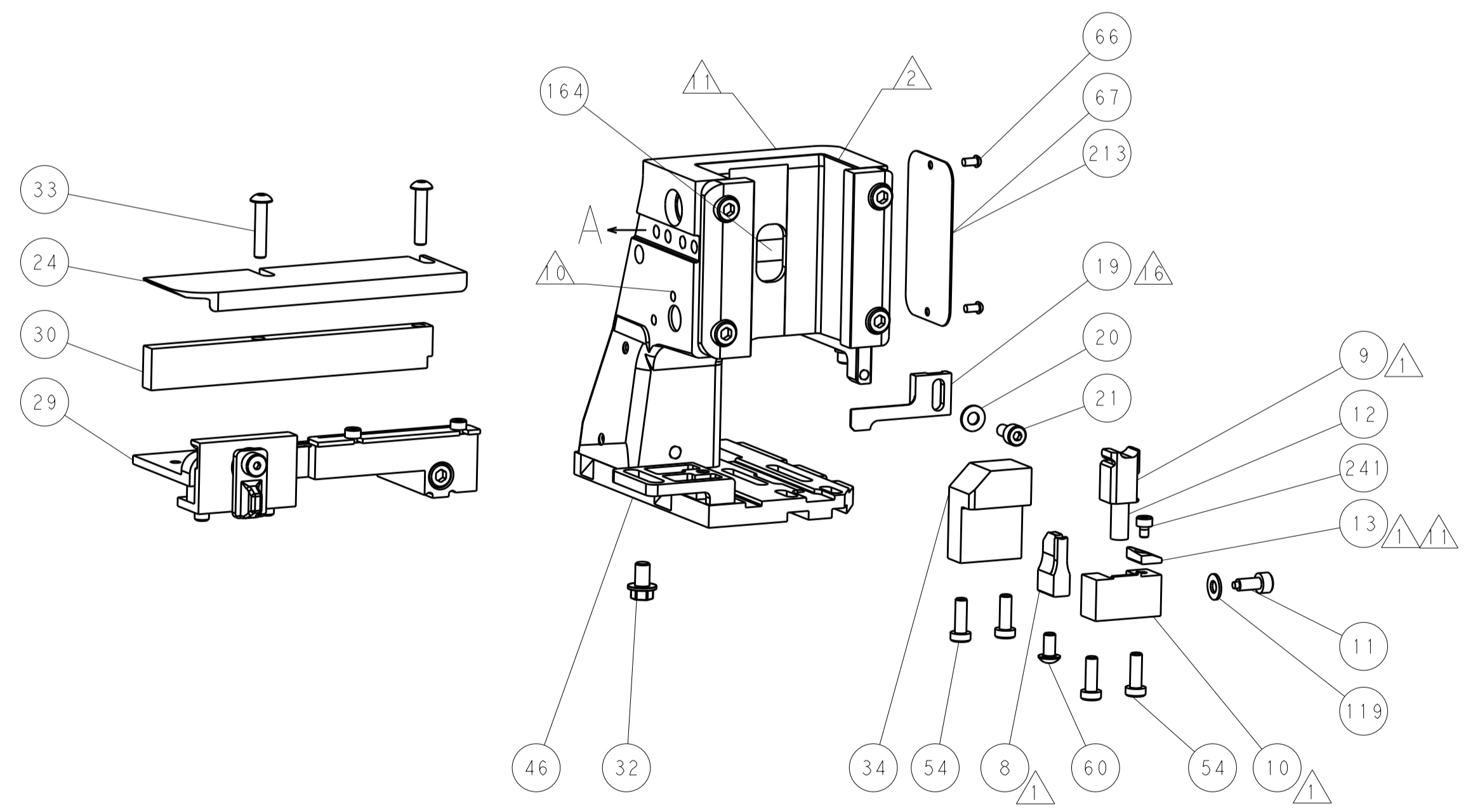
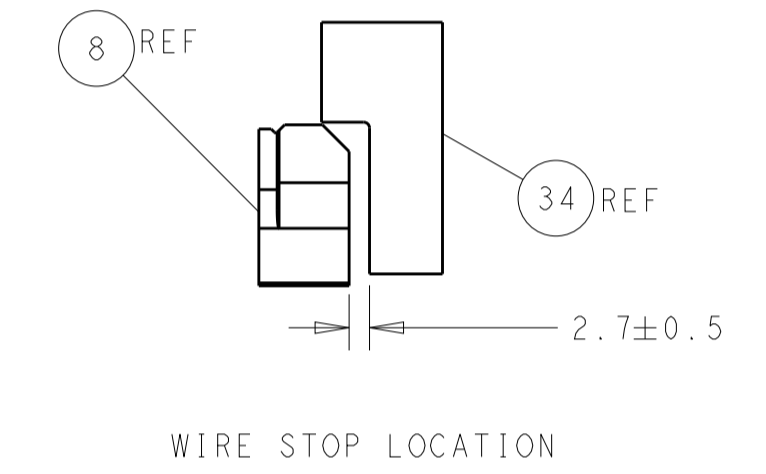
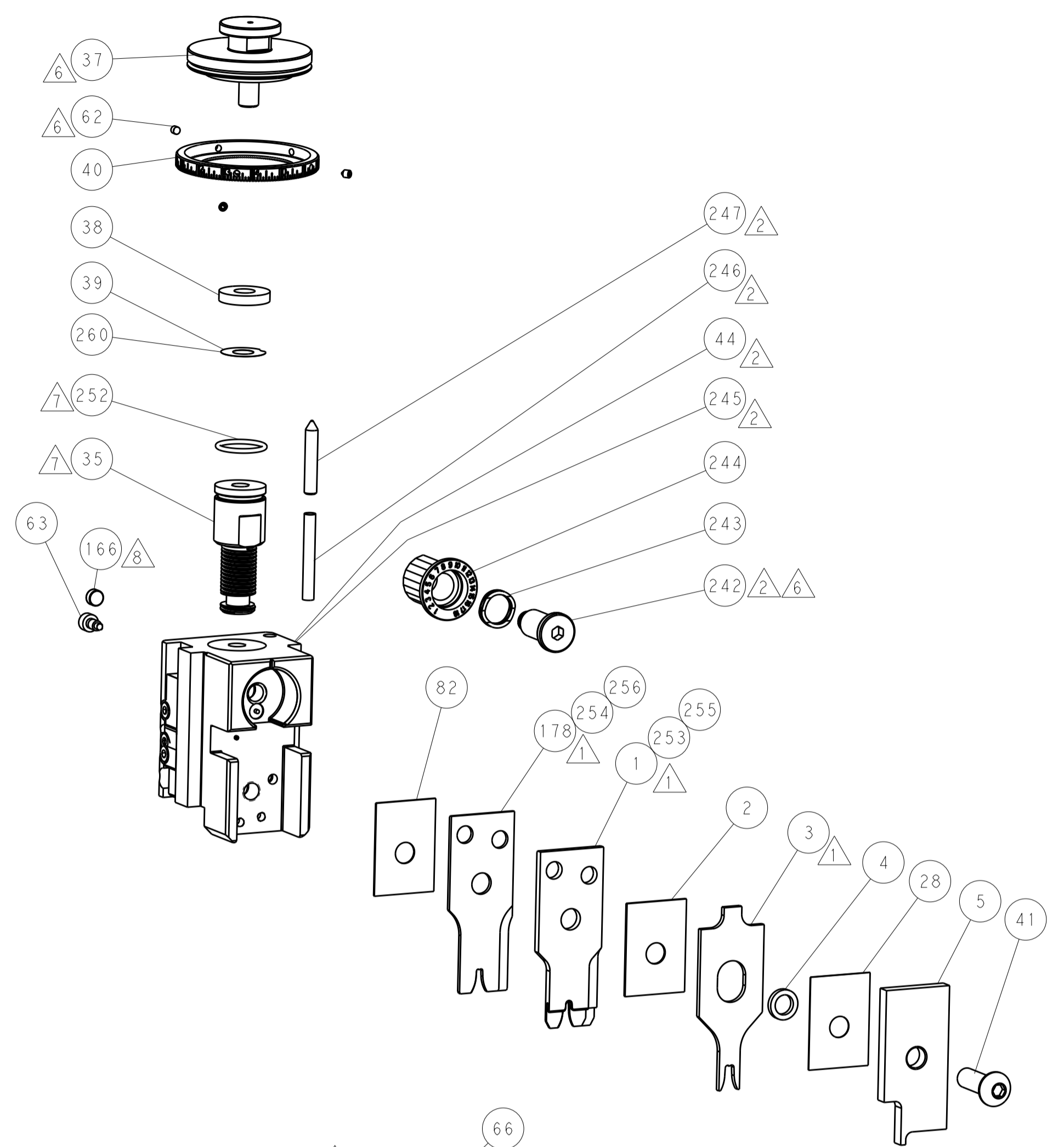
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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

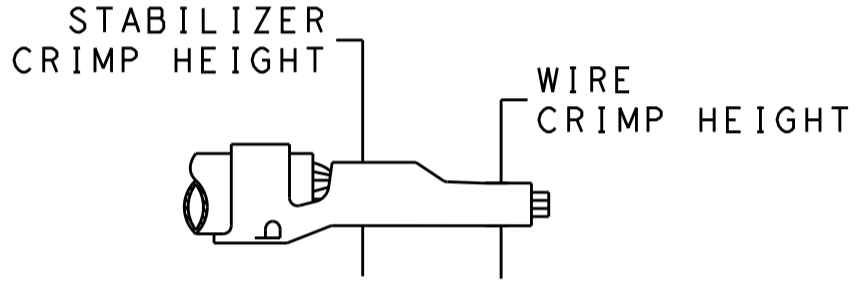
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|-------------|---------|--|---------|--|---------|----------------------------------|---------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN: L. GROSS 31JAN2013 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | Harrisburg, PA 17105-3608 |
| | ANGLES | FINISH | | APVD: M. CLIFFORD 31JAN2013 | | NAME: Ocean Side Feed Applicator | |
| MATERIAL: | | | | PRODUCT SPEC | | RESTRICTED TO | |
| | | | | APPLICATION SPEC | | SIZE: CAGE CODE DRAWING NO | |
| | | | | WEIGHT | | A1 00779 ©=2151314 | |
| | | | | Customer Accessible Production Drawing | | SCALE: 1:2 SHEET 2 OF 4 REV C | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|------------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2151314-1 | C | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151314-5 | 1901094-3 | 2-1752354-6 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151314-4 | - | - | - |
| | 2-2151314-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151314-5 | 1901094-3 | 2-1752354-6 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151314-4 | - | - | - |
| | 2-2151314-5 | C | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 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 |
| | 2-2151314-7 | C | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2151314-* | - | SEE CRIMP TOOLING KITS BELOW | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 2.79 mm [.110] | F |
| STABILIZER | 2.79 mm [.110] | O |
| INSULATION | 3.94 mm [1.55] | F |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

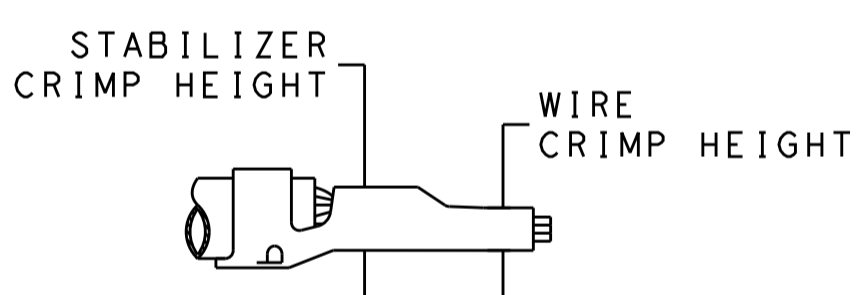
| PART NO | REV | WIRE SIZE | WIRE CRIMPER | STABILIZER CRIMPER | INSULATION CRIMPER | ANVIL |
|-------------|-----|-----------|--------------|--------------------|--------------------|-----------|
| 7-2151314-7 | C | 12 AWG | 7-456408-6 | 815664-2 | 6-2119582-7 | 1633923-5 |
| 7-2151314-8 | C | 14 AWG | 2-456408-5 | 815664-6 | 6-2119582-7 | 1633923-5 |
| 7-2151314-9 | C | 18-16 AWG | 2-456408-6 | 815664-7 | 6-2119582-7 | 1633923-5 |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|------------------------------------|-------------|------------------------------|-------------|
| TERMINAL NAME: AMP-IN | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.83-5.59 mm [.190-.220 IN] | | Ø2.29-3.81 mm [.090-.150 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-1016 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 3-794013-1 | | | |



| WIRE SIZE | CRIMP HEIGHT mm [INCH] | WIRE CRIMPER PART NUMBER | STABILIZER CRIMP HEIGHT mm [INCH] | STABILIZER CRIMPER PART NUMBER | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------|-----------------------------------|--------------------------------|--------------------------------|
| 12 AWG | 2.16+/-0.05 [.085+/-0.002] | 7-456408-6 | 2.79+/-0.05 [.110+/-0.002] | 815664-2 | 9.1 |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|------------------------------------|-------------|------------------------------|-------------|
| TERMINAL NAME: AMP-IN | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.83-5.59 mm [.190-.220 IN] | | Ø2.29-3.81 mm [.090-.150 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-1016 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 3-770060-1 | | | |



| WIRE SIZE | CRIMP HEIGHT mm [INCH] | WIRE CRIMPER PART NUMBER | STABILIZER CRIMP HEIGHT mm [INCH] | STABILIZER CRIMPER PART NUMBER | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------|-----------------------------------|--------------------------------|--------------------------------|
| 14 AWG | 1.40+/-0.05 [.055+/-0.002] | 2-456408-5 | 2.75+/-0.10 [.108+/-0.004] | 815664-6 | 7.6 |
| 18-16 AWG | 1.09+/-0.05 [.043+/-0.002] | 2-456408-6 | 2.40+/-0.10 [.094+/-0.004] | 815664-7 | 7.8 |

- △ RECOMMENDED SPARE PARTS
- △ GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- △ APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151314-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151314-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151314-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- △ APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
- △ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

***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.

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

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

| | | | | | | | | | |
|---|---|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| 1 | - | - | 1 | 1 | 1 | 1 | 2-456408-6 | CRIMPER, WIRE PREMIUM | 256 |
| 1 | - | - | 1 | 1 | 1 | 1 | 815664-7 | CRIMPER, WIRE-O | 255 |
| - | 1 | - | 1 | 1 | 1 | 1 | 2-456408-5 | CRIMPER, WIRE PREMIUM | 254 |
| - | 1 | - | 1 | 1 | 1 | 1 | 815664-6 | CRIMPER, WIRE-O | 253 |
| - | - | - | 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 |
| - | - | - | 1 | 1 | 1 | 1 | 2119082-6 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | - | - | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | - | - | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | - | - | 1 | 1 | 1 | 1 | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | - | - | - | - | - | 2 | 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 | 7-456408-6 | CRIMPER, WIRE PREMIUM | 178 |
| - | - | - | - | - | - | 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 | 2119650-1 | RAM, ASIAN STYLE, SIDE FEED | 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 | 455888-5 | 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 |
| - | - | - | 3 | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62 |
| - | - | - | - | - | - | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | - | - | - | - | - | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | - | - | - | - | - | 1 | 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 | 2119644-5 | RAM WASHER, PRECISION | 38 |
| - | - | - | 1 | 1 | 1 | 1 | 469465-4 | STOP, WIRE | 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 | 1320928-2 | 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 | 2119806-1 | INSERT, SHEAR | 13 |
| - | - | - | 1 | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | - | - | 1 | 1 | 1 | 1 | 1-356885-4 | STOP, SHEAR | 11 |
| - | - | - | 1 | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | - | - | 1 | 1 | 1 | 1 | 462006-6 | FLOATING SHEAR, FRONT | 9 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | 1633923-5 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | - | - | 6 |
| - | - | - | 1 | 1 | 1 | 1 | 1-2119757-2 | DEPRESSOR, SHEAR | 5 |
| - | - | - | 1 | 1 | 1 | 1 | 238011-8 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | 6-2119582-7 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | - | - | 1 | 1 | 1 | 1 | 455888-7 | SPACER, CRIMPER | 2 |
| - | - | - | 1 | 1 | 1 | 1 | 815664-2 | CRIMPER, WIRE-O | 1 |

| ITEM NO | PART NO | DESCRIPTION | ITEM NO |
|---------|---------|-------------|-------------|
| -79 | -77 | -27 | -25 |
| -22 | -21 | PART NO | DESCRIPTION |

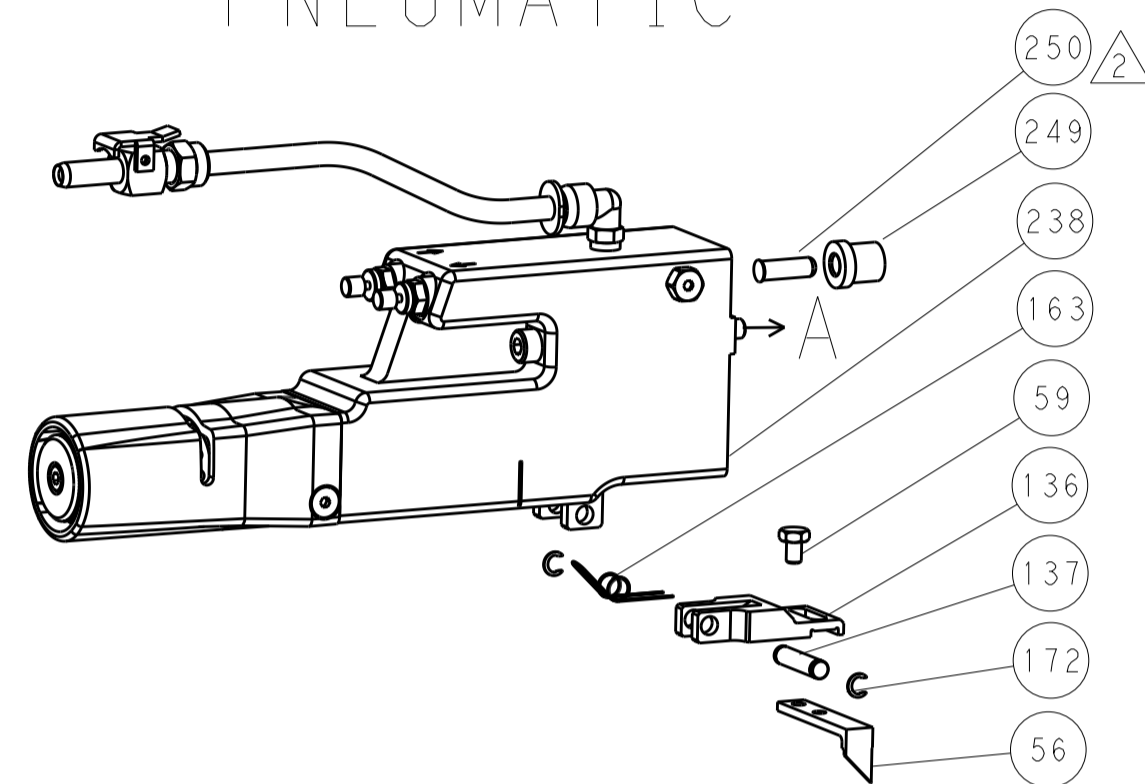
| | | | |
|--|--|--|----------------------------------|
| DATE OF PREVIOUS EDITION | DATE OF PREVIOUS EDITION | DATE OF PREVIOUS EDITION | DATE OF PREVIOUS EDITION |
| 31 JAN 2013 | 31 JAN 2013 | 31 JAN 2013 | 31 JAN 2013 |
| CHK: EL GROSS | CHK: T. ELBIN | APVD: M. CLIFFORD | NAME: Ocean Side Feed Applicator |
| DIMENSIONS: mm | TOLERANCES UNLESS OTHERWISE SPECIFIED: | 0 PLC ± | 1 PLC ± |
| | | 2 PLC ± | 3 PLC ± |
| | | 4 PLC ± | ANGLES ± |
| MATERIAL: | FINISH: | WEIGHT: | SCALE: 1:2 |
| | | | SHEET 3 OF 4 |
| Customer Accessible Production Drawing | | Customer Accessible Production Drawing | REV C |

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

FEED TYPE MECHANICAL



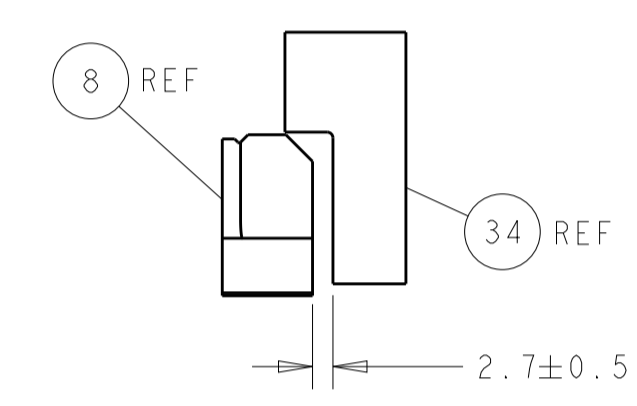
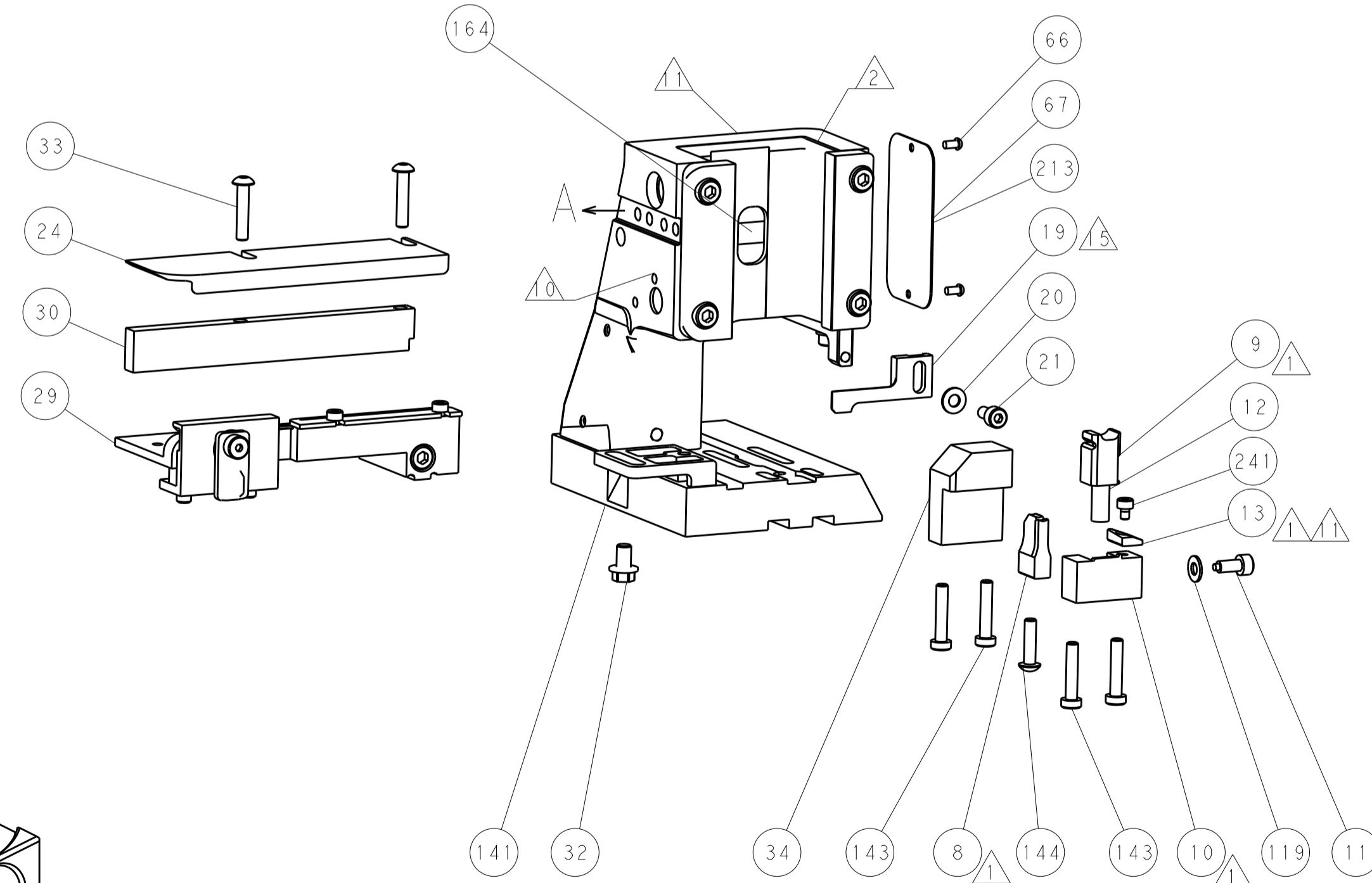
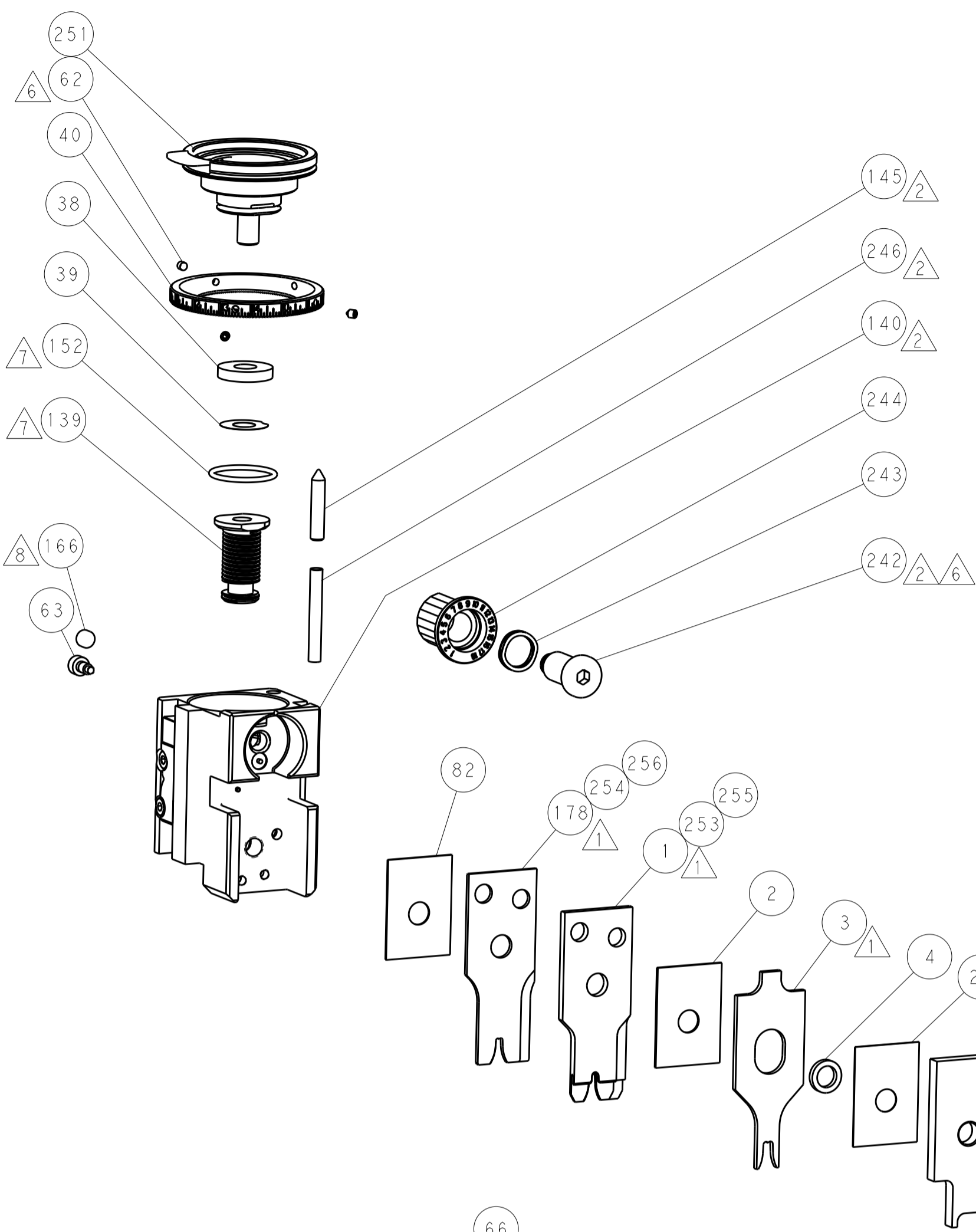
PNEUMATIC



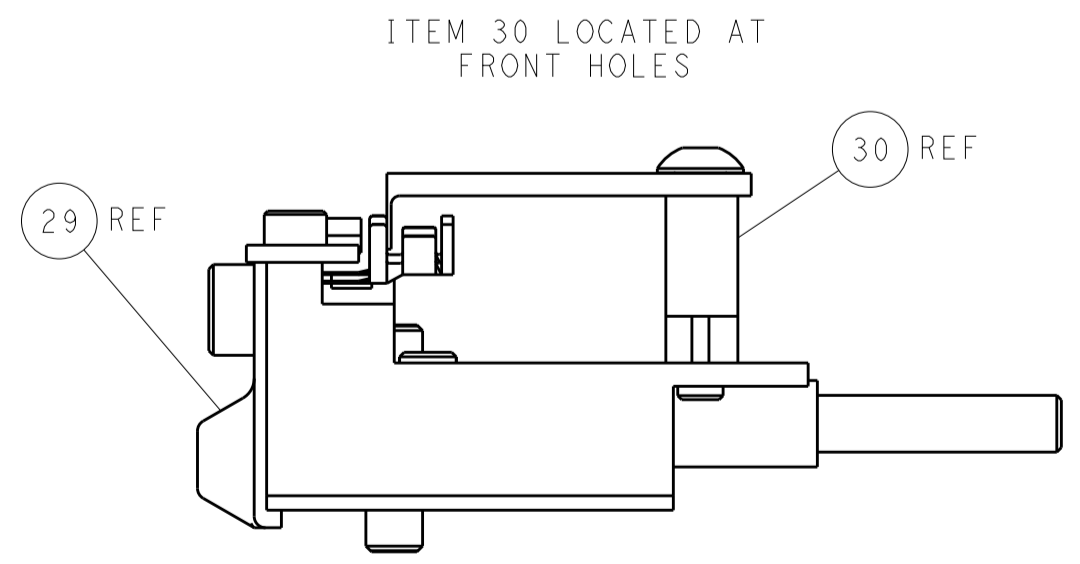
SERVO LATCH PLATE



CAM POSITIONS



WIRE STOP LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

| | | | | | | | |
|-------------|---------|--|---------|--|----------------------------|-----------------|---------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN: EL GROSS 31JAN2013 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | 5 PLC ± | Harrisburg, PA 17105-3608 |
| MATERIAL: | FINISH: | WEIGHT: | SCALE: | APVD: M. CLIFFORD 31JAN2013 | NAME: | RESTRICTED TO: | |
| | | | 1:2 | PRODUCT SPEC: | Ocean Side Feed Applicator | | |
| | | | | APPLICATION SPEC: | | | |
| | | | | SIZE: CAGE CODE: DRAWING NO: | A1 00779 C=2151314 | | |
| | | | | Customer Accessible Production Drawing | | | |