

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151539-1	N	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151539-2	N	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151539-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151539-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	2151539-5	N	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	SERVO LATCH PLATE	2119951-1	-	8-2151539-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151539-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151539-6	N	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	-	-	-	-	-	-	-	
2151539-7	N	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151539-7	L	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	1.73 mm [.068]	SP

APPLICATOR INSTRUCTIONS  
408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GET 0.64mm PIN AND SOCKET CONTACTS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40 mm [.173 IN]		Ø1.40-2.06 mm [.055-.081 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13060	-	-
TERMINALS APPLIED <sup>3</sup>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1393366-1	1393365-1	1438299-3	1438299-4
1393366-2	1393365-2	1438299-6	1-1438299-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.12+/-0.04 [.044+/- .0016]	7.0
0.75mm2	1.10+/-0.04 [.043+/- .0016]	7.1
0.50mm2	1.02+/-0.04 [.040+/- .0016]	8.1
20 AWG	1.02+/-0.04 [.040+/- .0016]	8.1

- <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:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151539-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151539-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151539-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151539-6
- 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 ITEM 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37 & 50.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>8</sup> MAGNET, ITEM 166 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> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <sup>11</sup> 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.
- <sup>12</sup> 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
- <sup>13</sup> REAR STRIP GUIDE MUST BE ADJUSTED WHEN SWITCHING TERMINALS.
- <sup>14</sup> USE ITEM 34, WHEN CRIMPING MALE TERMINALS.
- <sup>15</sup> USE ITEM 261, WHEN CRIMPING FEMALE TERMINALS.

**\*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.

<sup>5</sup>	-	1	1	1	1	1	1-1752356-8	SUPPORT, TERMINAL	261
	-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
<sup>7</sup>	-	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	1-22279-3	SPRING, COMPRESSION	246
	-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
	-	1	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
<sup>6</sup>	-	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
	-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)

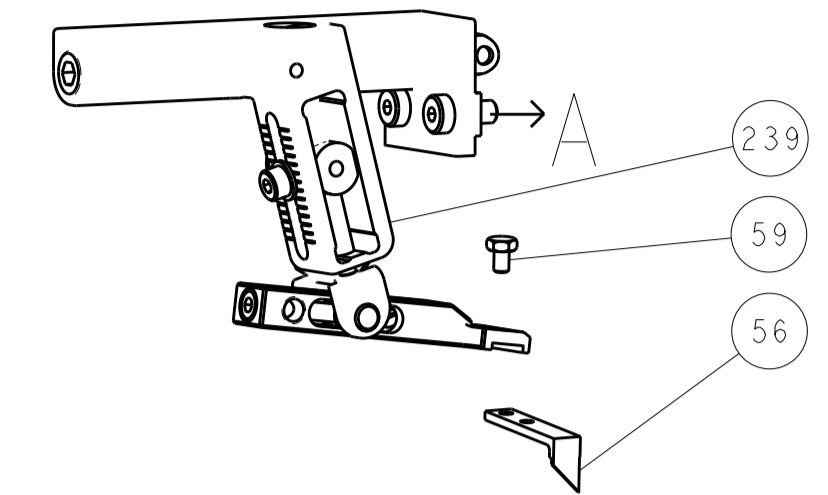
SET UP GAUGE		LOC	DIST	REVISIONS					
2119599-1		A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
				L		ECR-16-008691	15JUN2016	MR	JDG
				L1		ECR-16-010290	15JUL2016	MEH	JDG
				M		ECR-16-015082	25OCT2016	YY	CT
				N		ECR-16-015962	11NOV2016	MZ	KZ

-	-	-	-	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	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	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	-	1-22281-8	SPRING, COMPRESSION	121
-	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	-	2-690438-2	FRONT STRIP GUIDE	96
-	2	2	2	2	2	-	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1	-	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	1	1	-	455888-8	SPACER, CRIMPER	82
-	1	1	1	1	1	-	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	-	2119791-9	DEPRESSOR, WIRE	70
-	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	-	2119793-1	LIMITER, ADJUSTMENT BOLT	63
-	3	-	3	3	3	-	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	2	2	2	2	2	-	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	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	-	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	-	1901681-5	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1	-	1-1752354-6	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	-	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	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	-	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1	-	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	-	1	1	-	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	-	1752356-6	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	-	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	-	1901086-5	PLATE, STRIP GUIDE	29
-	2	2	2	2	2	-	22281-8	SPRING, COMPRESSION	27
-	1	1	1	1	1	-	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	-	217233-1	DRAG, STOCK	25
-	1	1	1	1	1	-	1320928-6	STRIP GUIDE	24
-	1	1	1	1	1	-	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	-	2119533-1	STRIPPER, SIDE FEED	19
-	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	-	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	-	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1	-	1333231-1	ANVIL, COMBINATION, SPECIAL	8
-	-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	-	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	-	3-238011-5	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	-	2-1633989-1	CRIMPER, INSULATION, SPECIAL	3
-	1	1	1	1	1	-	455888-1	SPACER, CRIMPER	2
-	1	1	1	1	1	-	5-562108-2	CRIMPER, WIRE, F	1
-77	-7	-6	-5	-2	-1	-	PART NO	DESCRIPTION	ITEM NO

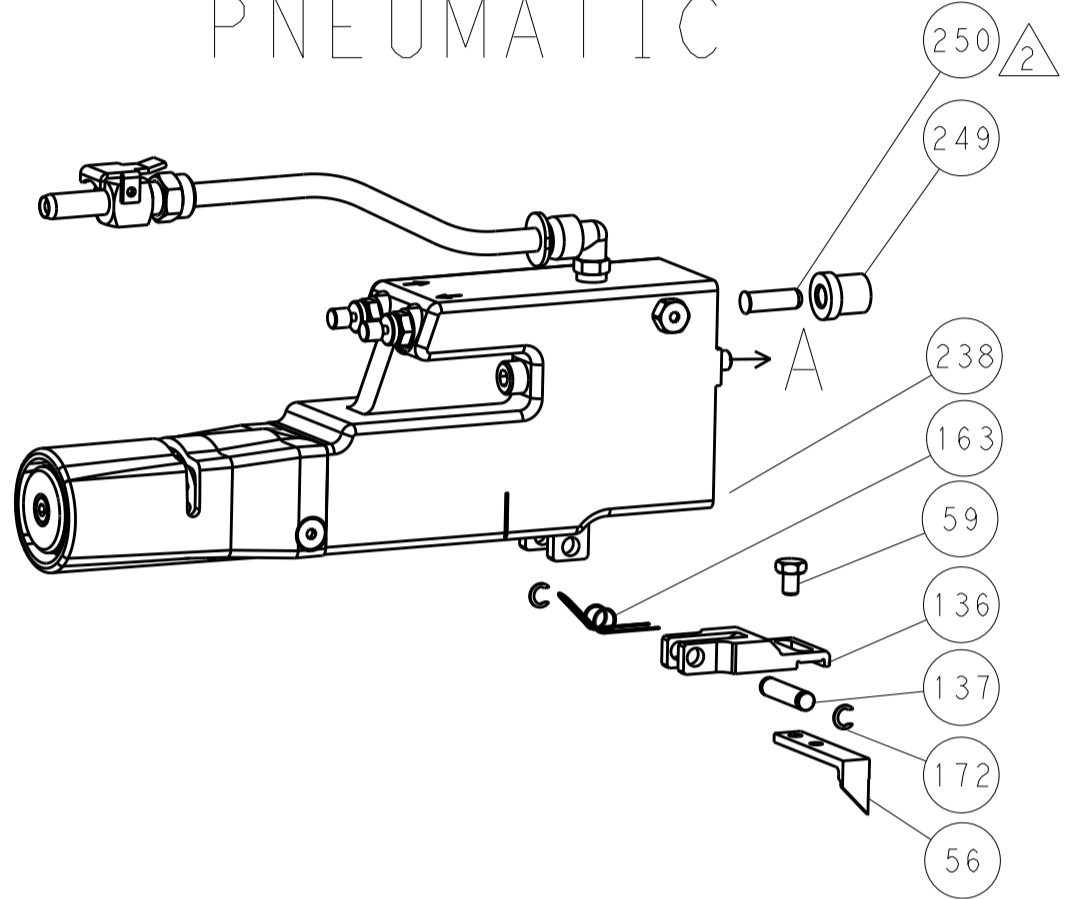
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:		SCALE:	
mm	0 PLC	±									
	1 PLC	±									
	2 PLC	±									
	3 PLC	±									
	4 PLC	±									

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

### FEED TYPE MECHANICAL



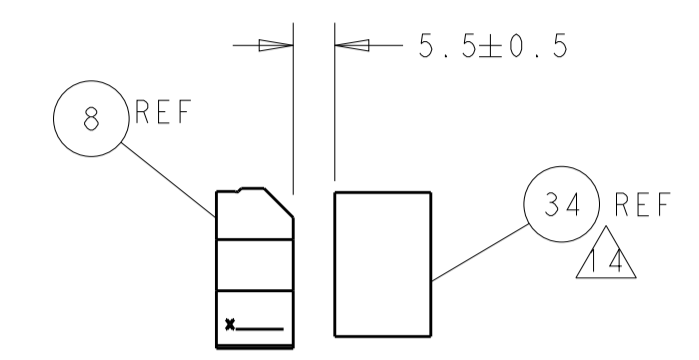
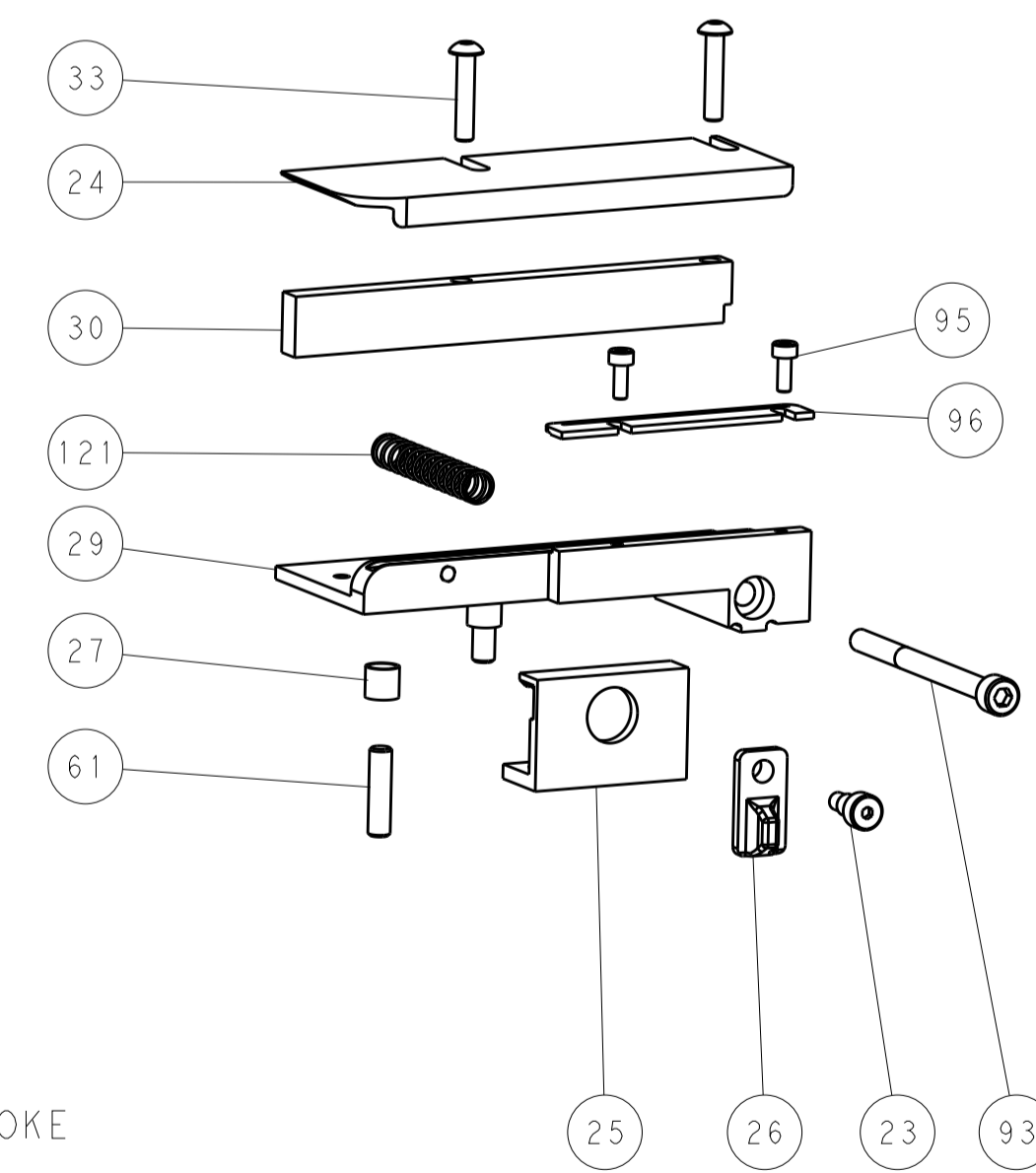
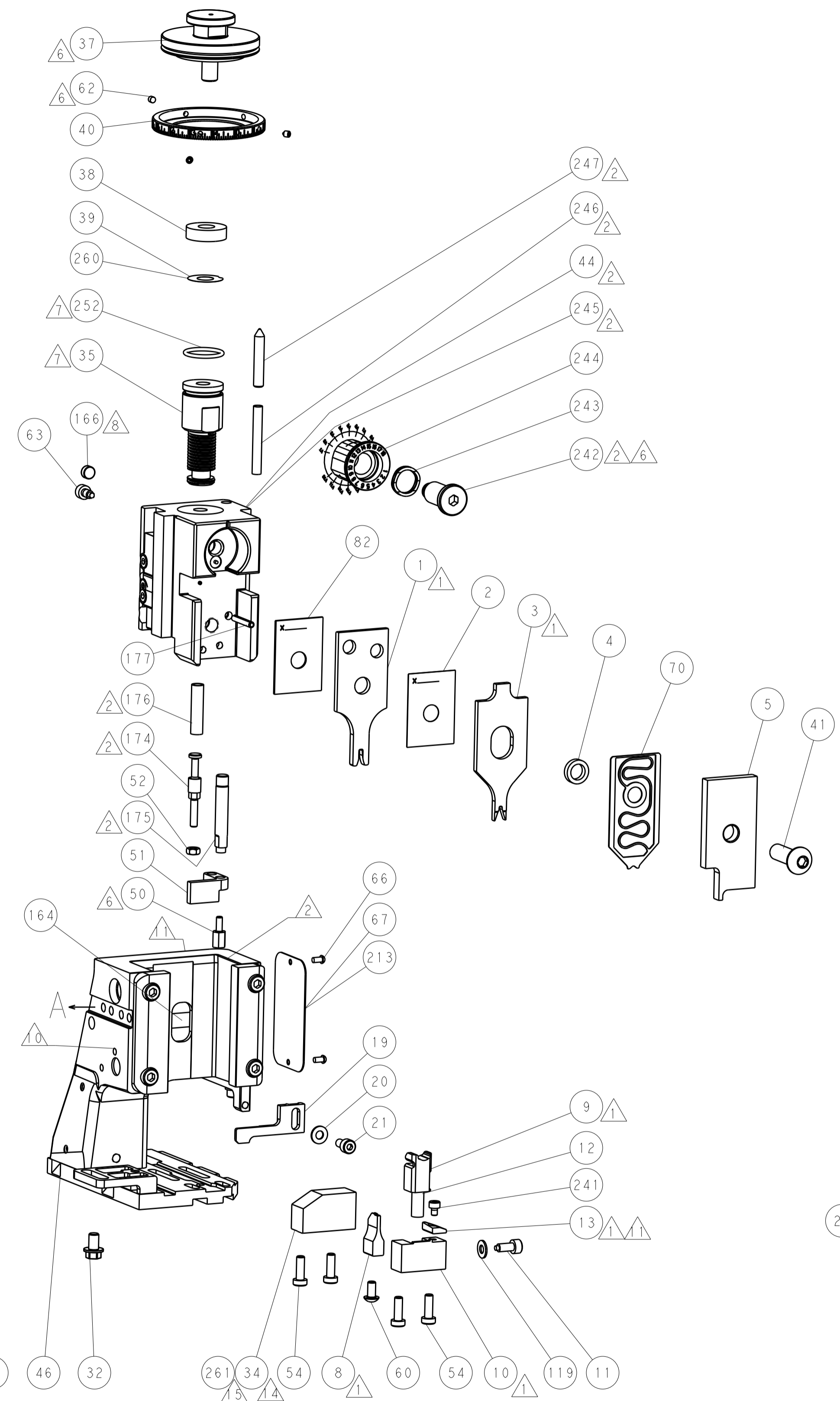
### PNEUMATIC



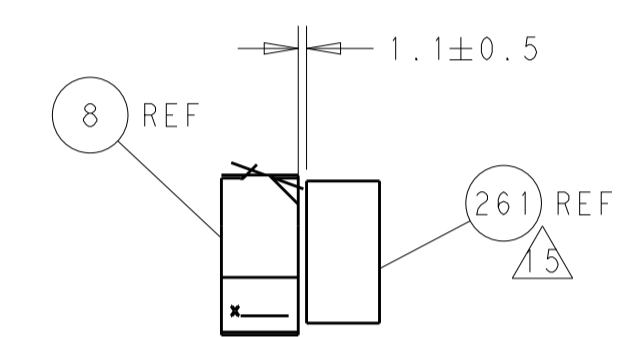
### SERVO LATCH PLATE



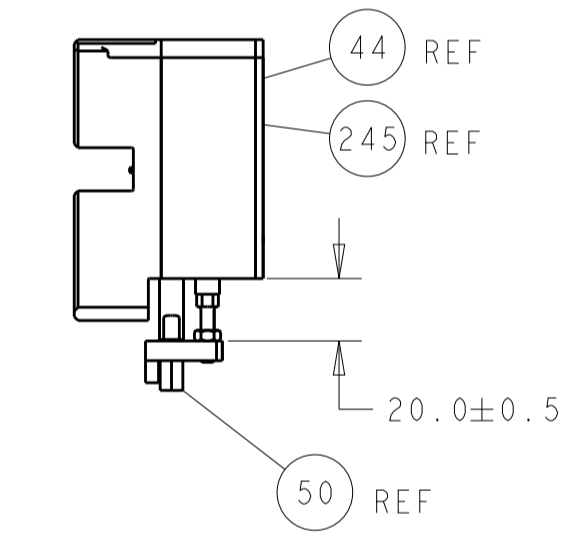
### CAM POSITIONS



TERMINAL SUPPORT LOCATION FOR MALE TERMINAL

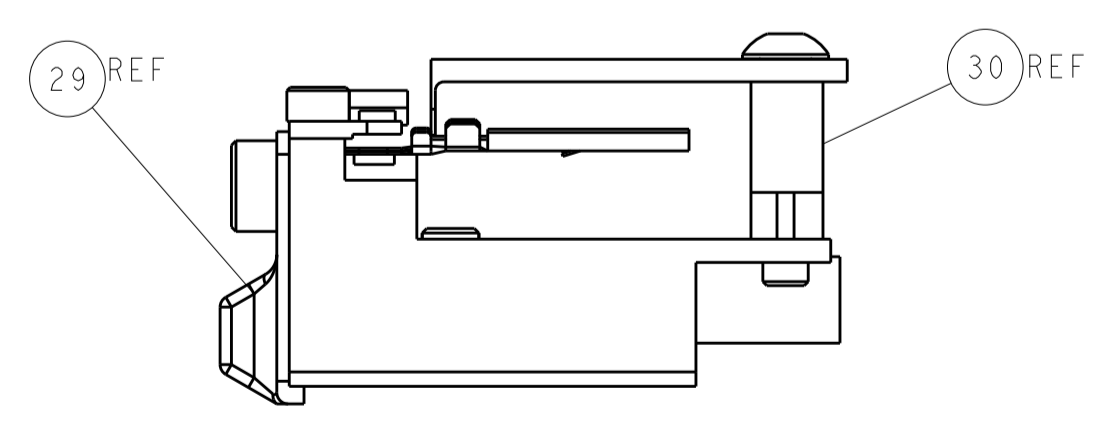


TERMINAL SUPPORT LOCATION FOR FEMALE TERMINAL



HOLDDOWN SET-UP

ITEM 30 LOCATED AT REAR HOLES



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. MOYER Z0DEC2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD T. ELBIN Z0DEC2012		NAME Ocean Side Feed Applicator	
				WEIGHT		SIZE CAGE CODE DRAWING NO. RESTRICTED TO	
				A1 00779 ©=2151539		Customer Accessible Production Drawing SCALE 1:2 SHEET 2 of 4 REV N	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151539-1	N	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	-	8-2151539-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151539-4	-	-	-
	2-2151539-2	N	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151539-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151539-4	-	-	-
	2-2151539-5	N	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	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
	2-2151539-7	N	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151539-7	L	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	1.73 mm [.068]	SP
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: GET 0.64mm PIN AND SOCKET CONTACTS			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.40 mm [.173 IN]		Ø1.40-2.06 mm [.055-.081 IN]	
TERMINAL APPLICATION SPECIFICATION	114-13060	-	-
TERMINALS APPLIED <sup>12</sup>			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1393366-1	1393365-1	1438299-3	1438299-4
1393366-2	1393365-2	1438299-6	1-1438299-1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING <sup>9</sup>
18 AWG	1.12 +/- 0.04 [.044 +/- .0016]	7.0
0.75mm <sup>2</sup>	1.10 +/- 0.04 [.043 +/- .0016]	7.1
0.50mm <sup>2</sup>	1.02 +/- 0.04 [.040 +/- .0016]	8.1
20 AWG	1.02 +/- 0.04 [.040 +/- .0016]	8.1

- <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:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151539-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151539-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151539-5
- 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 ITEM 50 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <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> REAR STRIP GUIDE MUST BE ADJUSTED WHEN SWITCHING TERMINALS.
- <sup>13</sup> USE ITEM 34, WHEN CRIMPING MALE TERMINALS.
- <sup>14</sup> USE ITEM 261, WHEN CRIMPING FEMALE TERMINALS.

**\*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.

<sup>4</sup>	-	1	1	1	1	1-1752356-8	SUPPORT, TERMINAL	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
	-	1	1	1	1	2119082-7	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
<sup>6</sup>	-	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
	-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)

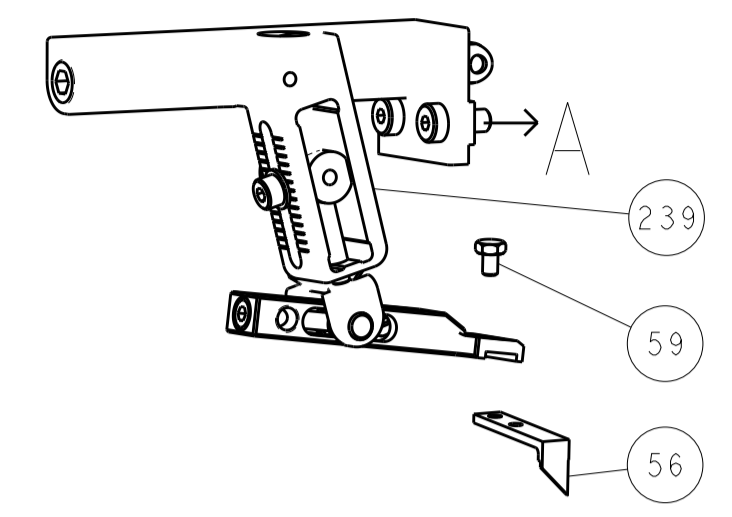
SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	-	1	-	-	1901094-3	SPACER, FEEDER	198	
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-	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	
<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	2119653-2	FEED CAM, POST FEED	142	
	-	1	1	1	1-2119656-0	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	
	-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
	-	1	1	1	2-690438-2	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 6.5	93	
	-	1	1	1	455888-8	SPACER, CRIMPER	82	
	-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
	-	1	1	1	2119791-9	DEPRESSOR, WIRE	70	
	-	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	
	-	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61	
	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
	-	-	-	1	1338685-1	PAWL, FEED	56	
	-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
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<sup>6</sup>	-	1	1	1	1-1752354-6	STANDOFF, HOLD-DOWN	50	
	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48	
	-	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	
<sup>7</sup>	-	1	1	1	2119644-1	RAM WASHER, PRECISION	38	
	-	1	1	1	1752356-6	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	
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	-	1	1	1	1320928-6	STRIP GUIDE	24	
	-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23	
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	-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19	
<sup>7</sup>	-	1	1	1	2119806-1	INSERT, SHEAR	13	
	-	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
	-	1	1	1	1-356885-4	STOP, SHEAR	11	
<sup>7</sup>	-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
<sup>7</sup>	-	1	1	1	318707-1	FLOATING SHEAR, FRONT	9	
<sup>7</sup>	1	1	1	1	1333231-1	ANVIL, COMBINATION, SPECIAL	8	
	-	-	-	-	-	-	7	
	-	-	-	-	-	-	6	
	-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
	-	1	1	1	3-238011-5	BLOCK, CRIMPER SPACER	4	
<sup>7</sup>	1	1	1	1	2-1633989-1	CRIMPER, INSULATION, SPECIAL	3	
	-	1	1	1	455888-1	SPACER, CRIMPER	2	
<sup>7</sup>	1	1	1	1	5-562108-2	CRIMPER, WIRE, F	1	
	-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

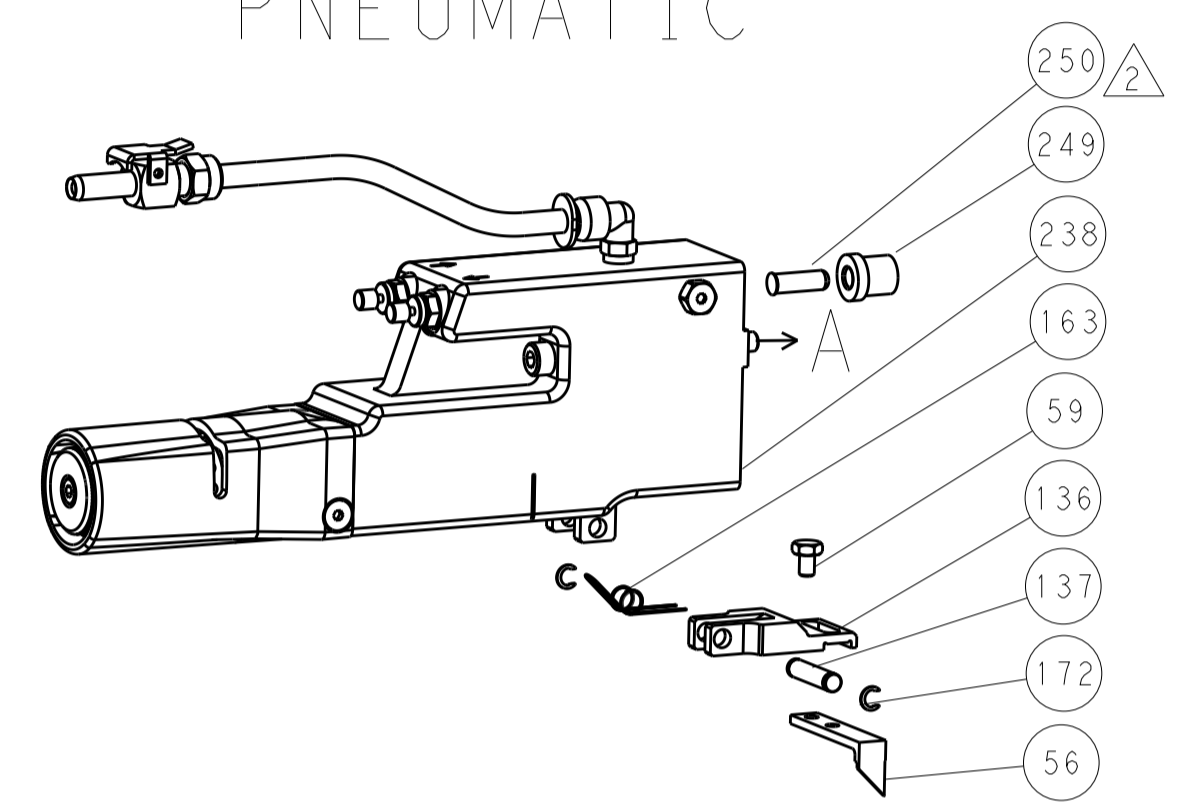
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±
ANGLES	±	±	±	±	±
MATERIAL	FINISH	WEIGHT	SCALE	SHEET	REV
			1:2	3 OF 4	N

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

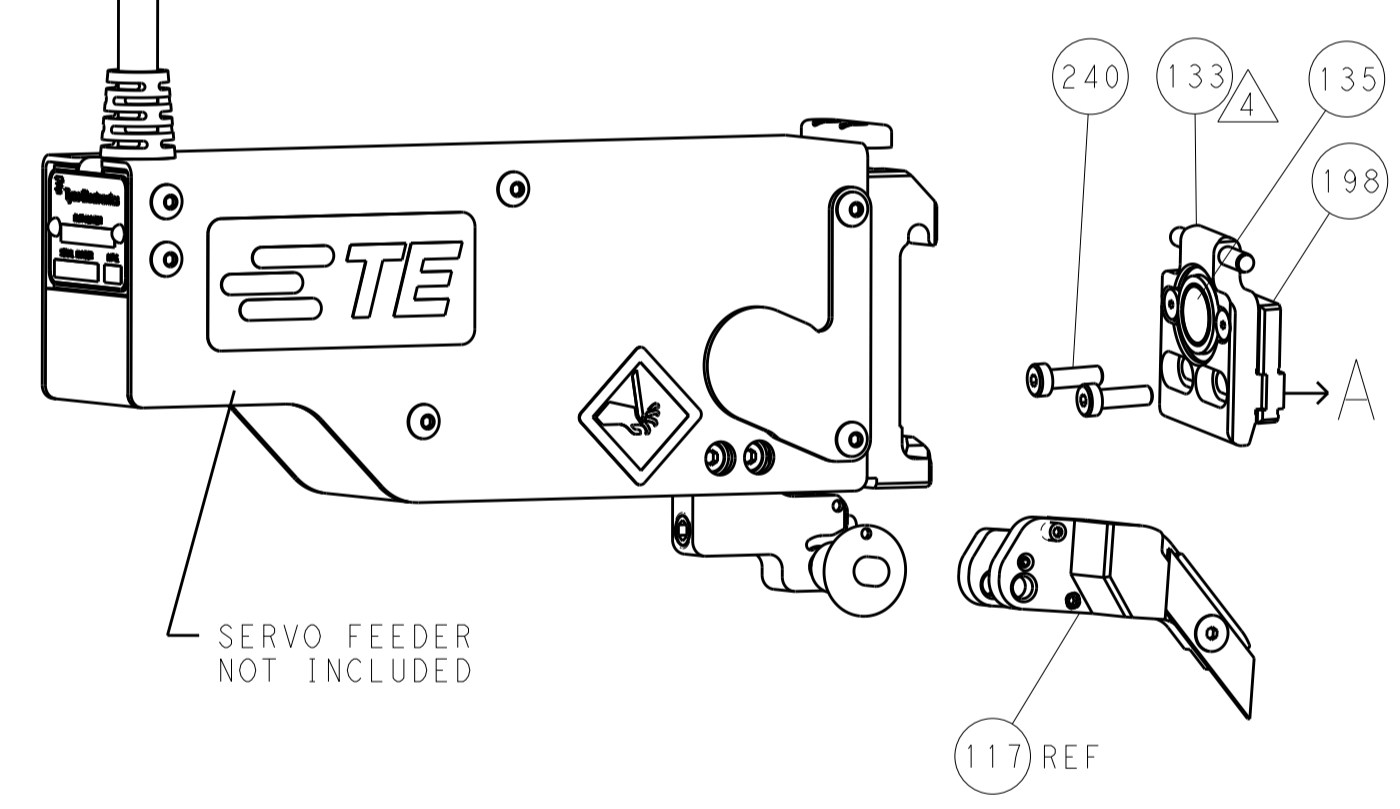
### FEED TYPE MECHANICAL



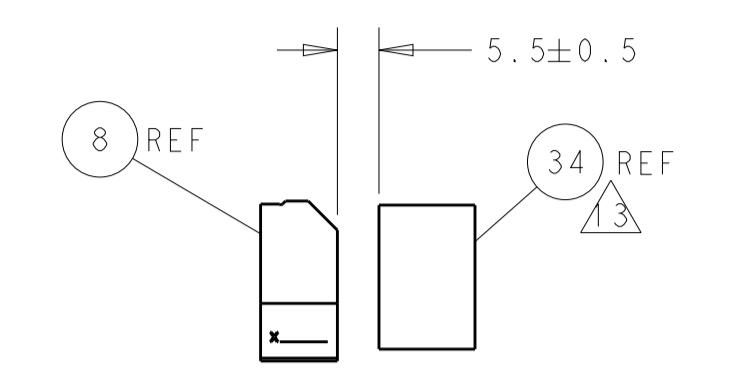
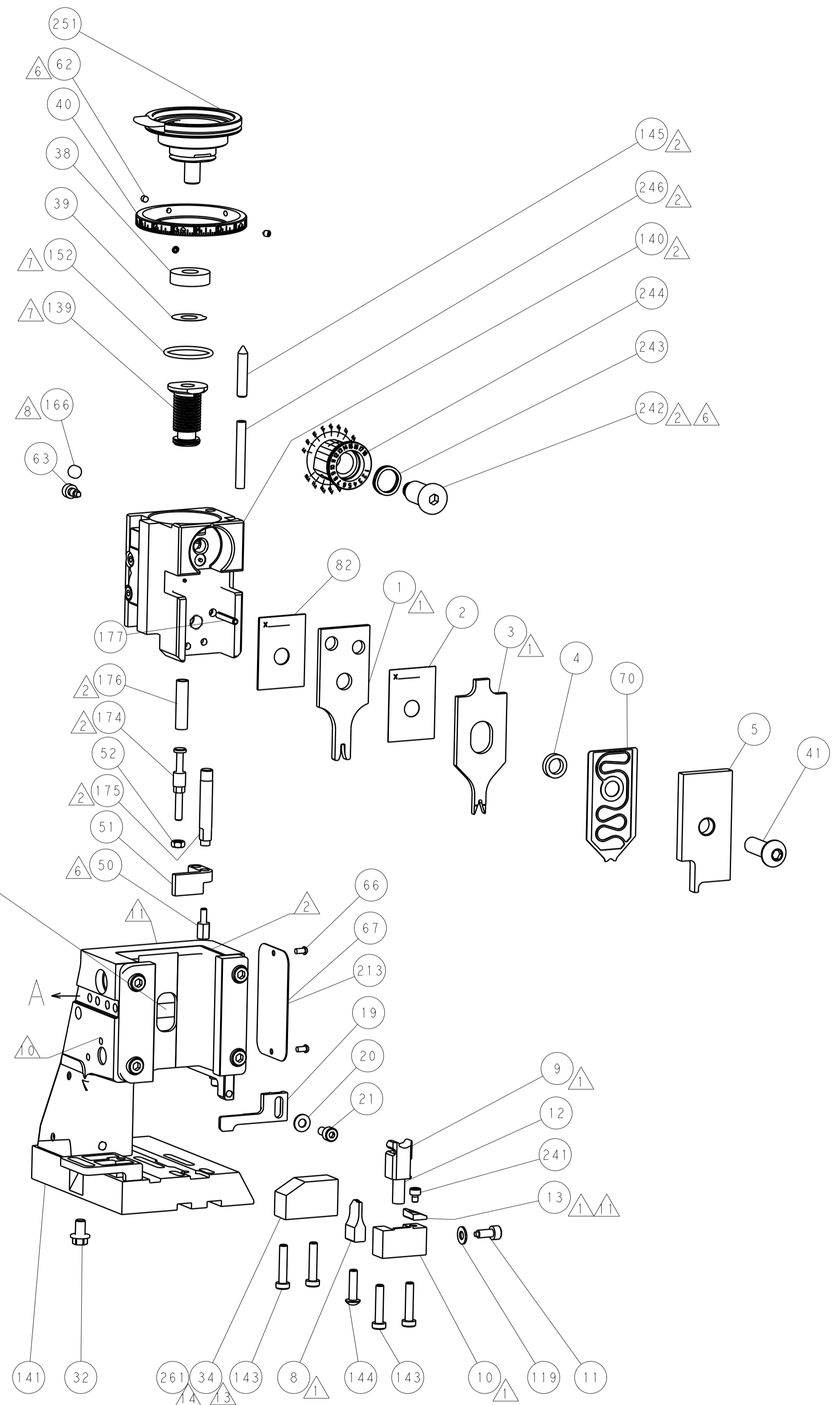
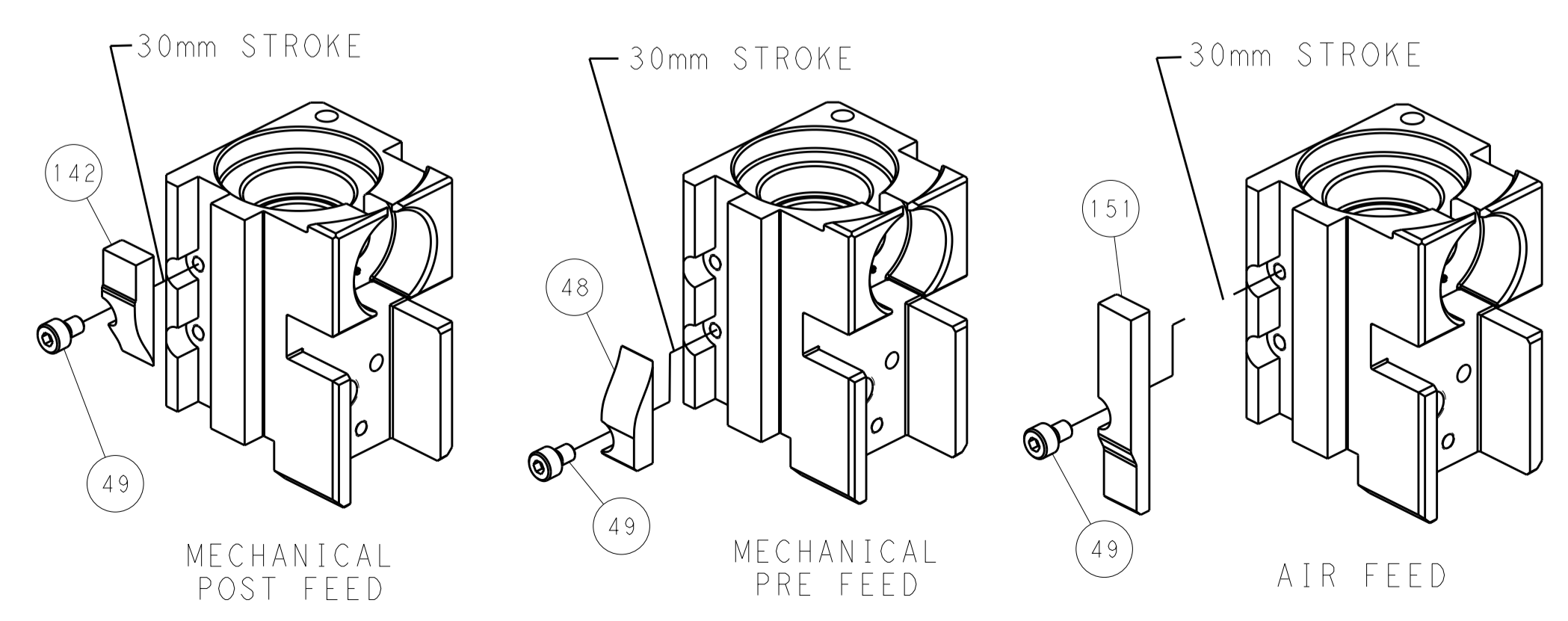
### PNEUMATIC



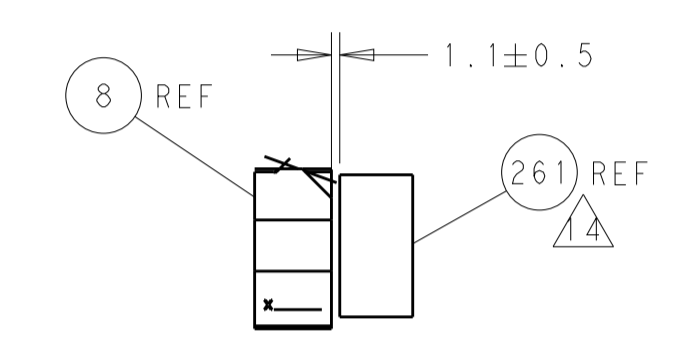
### SERVO LATCH PLATE



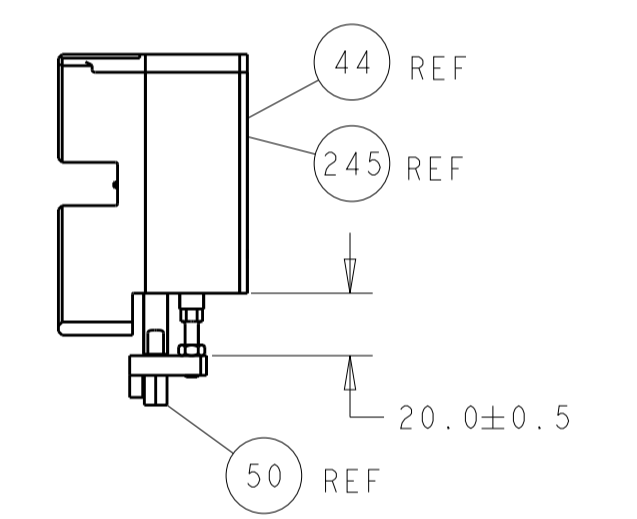
### CAM POSITIONS



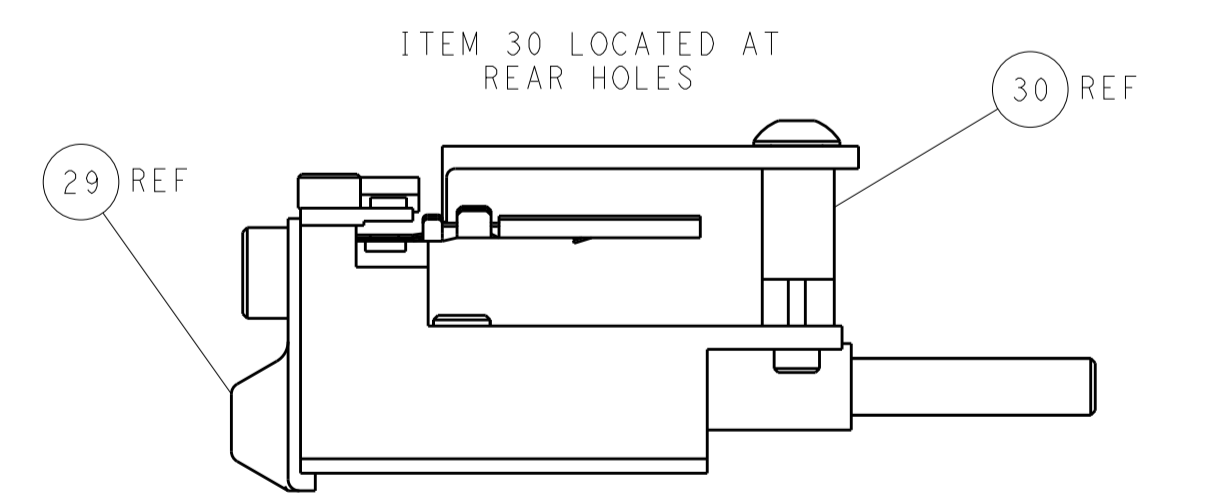
TERMINAL SUPPORT LOCATION FOR MALE TERMINAL



TERMINAL SUPPORT LOCATION FOR FEMALE TERMINAL



HOLDDOWN SET-UP



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 C. MOYER Z0DEC2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:	FINISH:	WEIGHT:	SCALE:	APVD T. ELBIN Z0DEC2012	NAME:	Ocean Side Feed Applicator	
Customer Accessible Production Drawing				SCALE: 1:2	SHEET 4 OF 4	REV N	