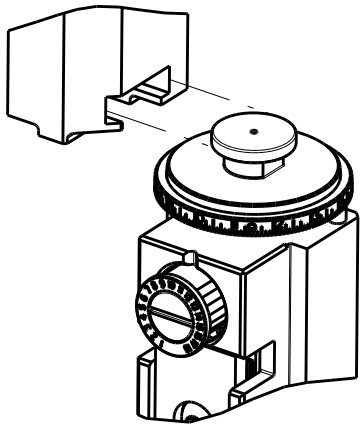
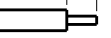


|                                                                                  |                |                          |                          |
|----------------------------------------------------------------------------------|----------------|--------------------------|--------------------------|
| 8                                                                                |                | 7                        |                          |
| THIS DRAWING IS UNPUBLISHED.                                                     |                | RELEASED FOR PUBLICATION |                          |
| © COPYRIGHT 20                                                                   |                | 20                       |                          |
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| ATLANTIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                              | PART<br>NUMBER | REVISION                 | DESCRIPTION              |
|  | 2151427-1      | A                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151427-2      | A                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151427-5      | A                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151427-6      | A                        | NON-CRIMP HEIGHT ADJUST  |
|                                                                                  | 2151427-7      | A                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 7-2151427-7    | A                        | CRIMP TOOLING KIT        |

|                                      |                 |      |
|--------------------------------------|-----------------|------|
| APPLICATOR DATA                      |                 |      |
| CRIMP                                | SIZE            | TYPE |
| WIRE                                 | 1.40 mm [ .055] | F    |
| INSUL                                | 2.03 mm [ .080] | O    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                 |      |

|                                                                                   |                                                                                   |                              |             |
|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|------------------------------|-------------|
| TERMINAL DATA: TE TERMINAL                                                        |                                                                                   | TE CRIMP SPECIFICATION       |             |
| TERMINAL NAME: RECEPTACLE .058 DIA P.C. CONTACT                                   |                                                                                   |                              |             |
| WIRE STRIP LENGTH                                                                 |  | INSULATION DIAMETER RANGE    |             |
| 3.10-3.40 mm [.122-.134 IN]                                                       |                                                                                   | Ø1.15-1.77 mm [.045-.070 IN] |             |
| TERMINAL APPLICATION SPECIFICATION                                                | 114-1008                                                                          | -                            | -           |
|  |                                                                                   | -                            | -           |
| TERMINALS APPLIED                                                                 |                                                                                   |                              |             |
| TE TERMINAL                                                                       | TE TERMINAL                                                                       | TE TERMINAL                  | TE TERMINAL |
| 60598-3                                                                           | 60598-4                                                                           | 60598-7                      | 60598-9     |
| 61622-1                                                                           |                                                                                   |                              |             |

|           |                             |                                |
|-----------|-----------------------------|--------------------------------|
| WIRE SIZE | CRIMP HEIGHT mm [INCH]      | CRIMP HEIGHT REFERENCE SETTING |
| 20 AWG    | 1.04+/-0.05 [ .041+/- .002] | 7.3                            |
| 22 AWG    | 0.94+/-0.05 [ .037+/- .002] | 8.4                            |
| 24 AWG    | 0.86+/-0.05 [ .034+/- .002] | 9.4                            |

- 

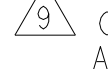
RECOMMENDED SPARE PARTS
- 

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: 8-2151427-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151427-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151427-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151427-6
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 ITEM 50, 62 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 242.
- 

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

\*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  | -  | -  | -  | 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     |
| -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<br>2119599-1 | LOC<br>A | DIST<br>66 | REVISIONS |     |             |           |     |
|                           |          |            | P         | LTR | DESCRIPTION | DATE      | DWN |
|                           |          |            |           | I   | DEVELOPMENT | 09DEC2011 | XZ  |
|                           |          |            |           | A   | RELEASED    | 27AUG2013 | BH  |
|                           |          |            |           |     |             |           |     |

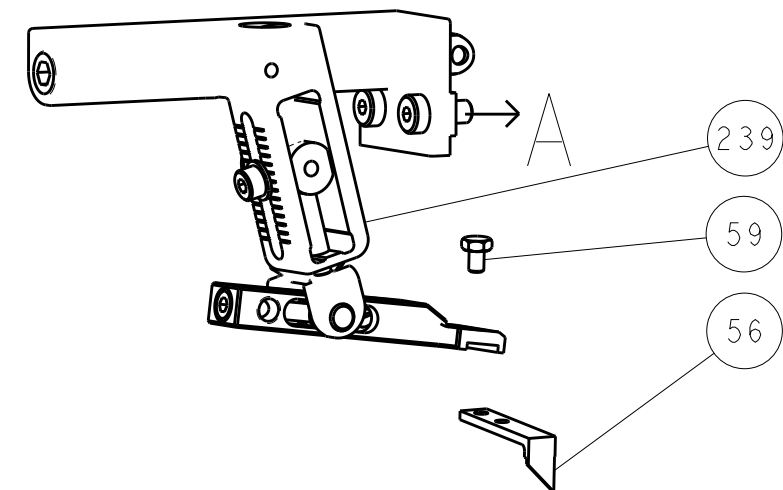
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|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | -   | 1   | 1   | 1   | 2119798-1   | DETENT PIN                          | 247     |
| -   | 1   | -   | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246     |
| -   | -   | 1   | -   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245     |
| -   | 1   | 1   | 1   | 1   | 1   | 2119082-9   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -   | 1   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| -   | 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   | 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   | 1-18028-2   | WASHER, FLAT, REG M4                | 119     |
| -   | -   | REF | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY,SF             | 117     |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-6    | 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      |
| -   | 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   | 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   | 1-1752354-5 | 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   | 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   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40      |
| -   | 1   | -   | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119644-1   | RAM WASHER, PRECISION               | 38      |
| -   | 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   | 1752356-5   | 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   | 1320908-3   | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29      |
| -   | 1   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28      |
| -   | 1   | 1   | 1   | 1   | 1   | 1320928-2   | 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   | 2119533-1   | 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   | 462006-6    | FLOATING SHEAR, FRONT               | 9       |
| 1   | 1   | 1   | 1   | 1   | 1   | 2-1633128-9 | ANVIL, COMBINATION .055             | 8       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 1   | 2-238011-5  | BLOCK, CRIMPER SPACER               | 4       |
| 1   | 1   | 1   | 1   | 1   | 1   | 2-1633965-1 | CRIMPER, INSULATION O PREMIUM       | 3       |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 2       |
| 1   | 1   | 1   | 1   | 1   | 1   | 3-456402-0  | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -7  | -6  | -5  | -2  | -1  | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                                                                                             |  |                                        |           |                                              |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------|-----------|----------------------------------------------|--|
| THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER'S RESPONSIBILITY IS TO OBTAIN THE LATEST REVISIONS OF THIS DRAWING. THE CUSTOMER'S RESPONSIBILITY IS TO OBTAIN THE LATEST REVISIONS OF THIS DRAWING. |  | DWN<br>X.ZHAO                          | 09DEC2011 | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| DIMENSIONS:                                                                                                                                                                                                 |  | CHK<br>T.ELBIN                         | 09DEC2011 | NAME                                         |  |
| mm                                                                                                                                                                                                          |  | APVD<br>S.XI                           | 09DEC2011 | Ocean Side Feed<br>Applicator                |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:                                                                                                                                                                      |  | PRODUCT SPEC                           |           | SIZE                                         |  |
| 0 PLC ±.5                                                                                                                                                                                                   |  | APPLICATION SPEC                       |           | CASE CODE                                    |  |
| 1 PLC ±0.13                                                                                                                                                                                                 |  | WEIGHT                                 |           | DRAWING NO                                   |  |
| 2 PLC ±0.13                                                                                                                                                                                                 |  | Customer Accessible Production Drawing |           | RESTRICTED TO                                |  |
| 3 PLC ±0.013                                                                                                                                                                                                |  | SCALE                                  |           | 1:2                                          |  |
| 4 PLC ±0.0001                                                                                                                                                                                               |  | SHEET                                  |           | 1 OF 4                                       |  |
| ANGLES ±.5                                                                                                                                                                                                  |  | REV                                    |           | A                                            |  |
| FINISH                                                                                                                                                                                                      |  | Customer Accessible Production Drawing |           | SCALE                                        |  |

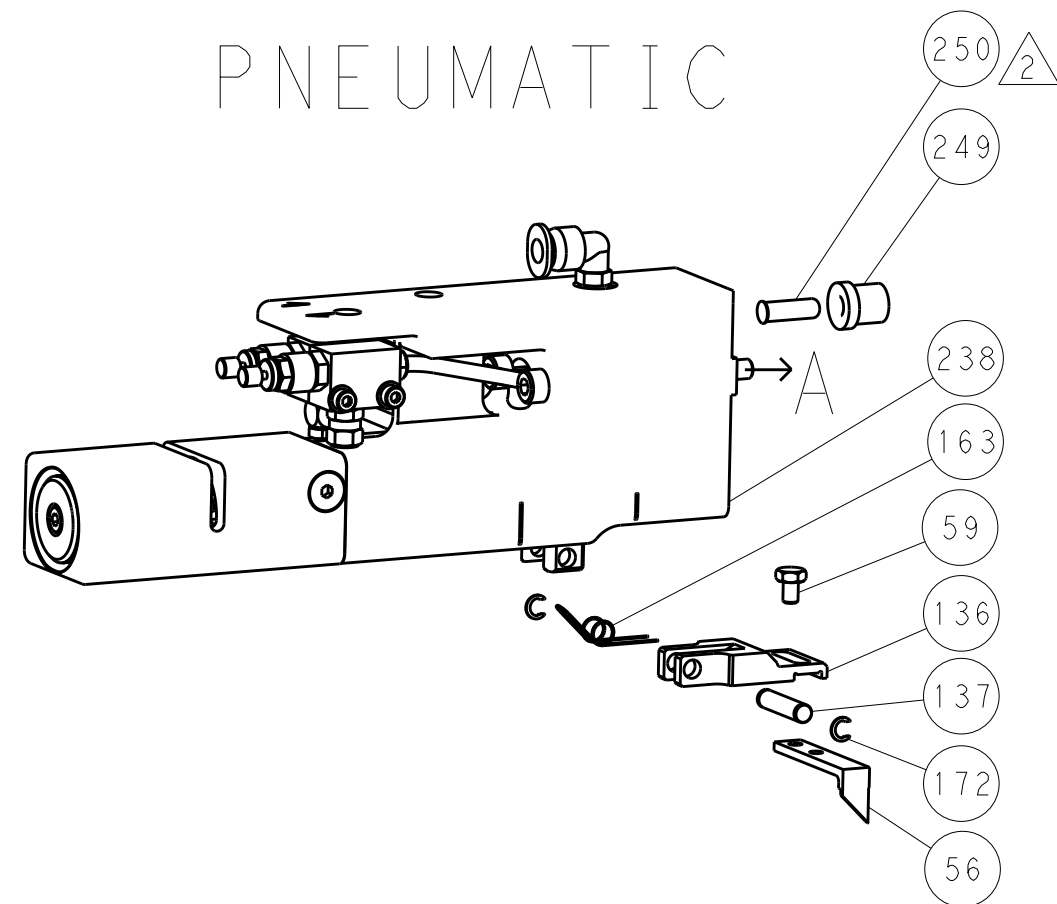


| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTR | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    |     | SEE SHEET 1 | -    | -   | -    |
|     |    |      |     |             |      |     |      |
|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

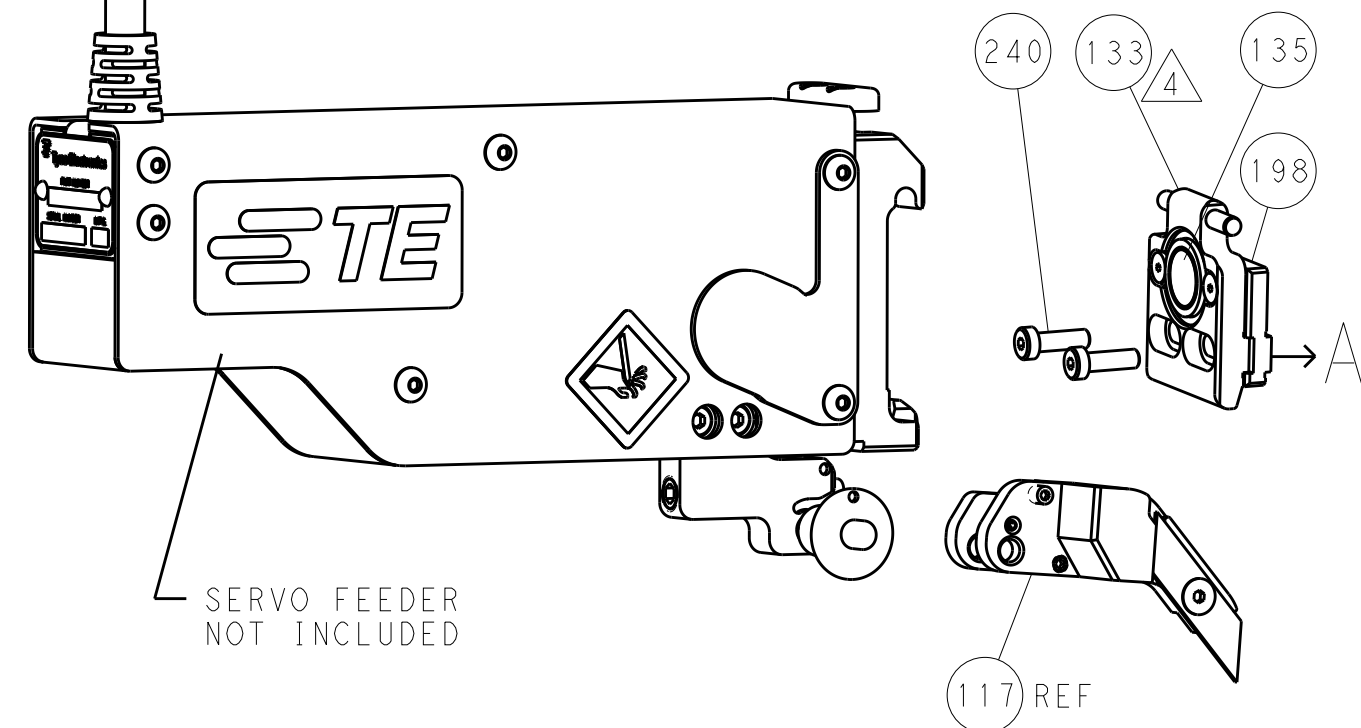
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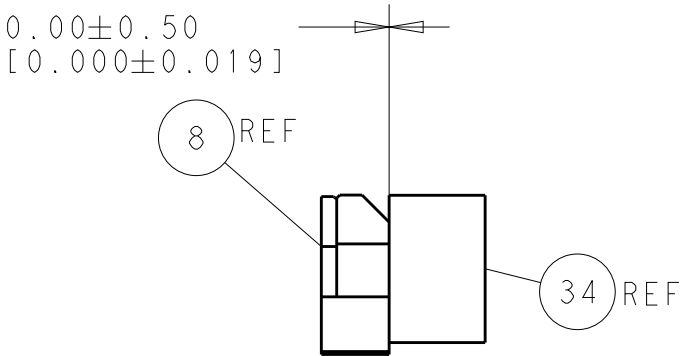
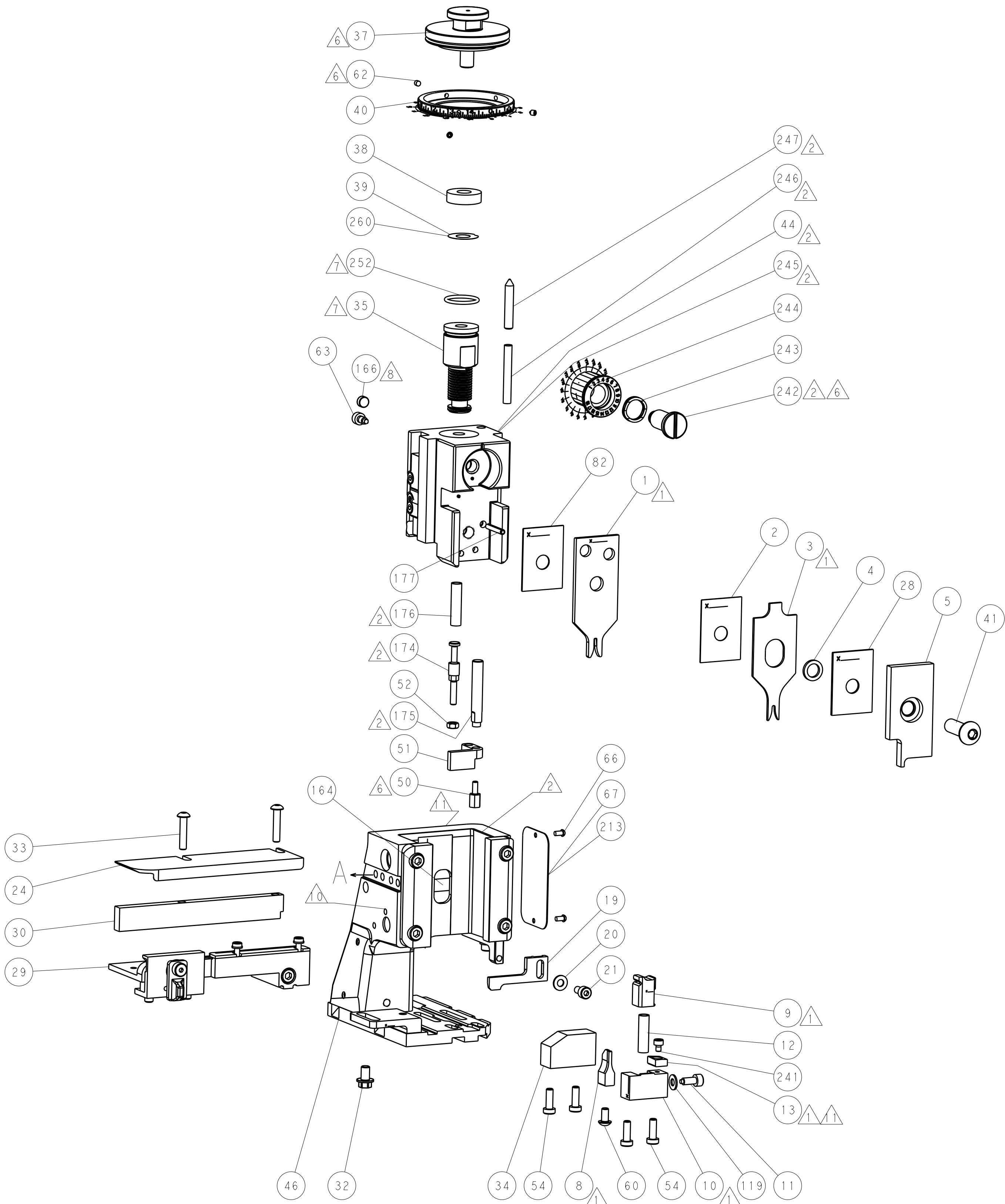
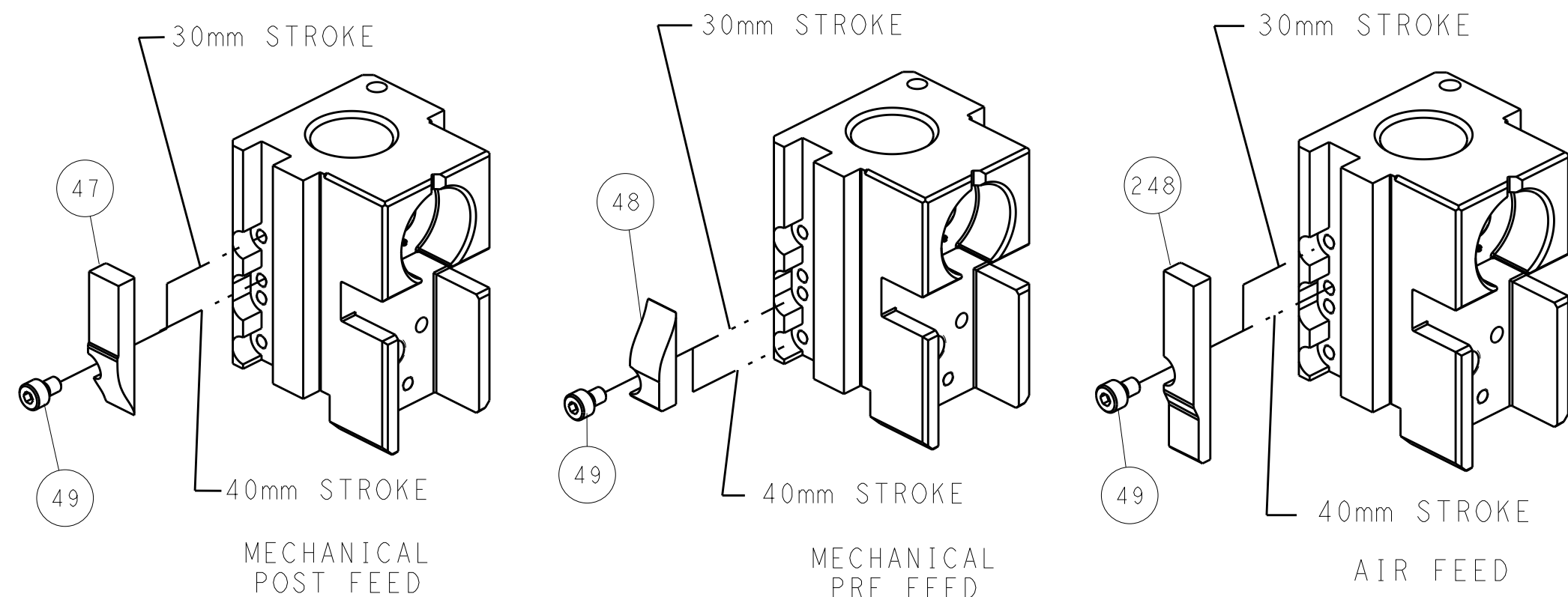
PNEUMATIC



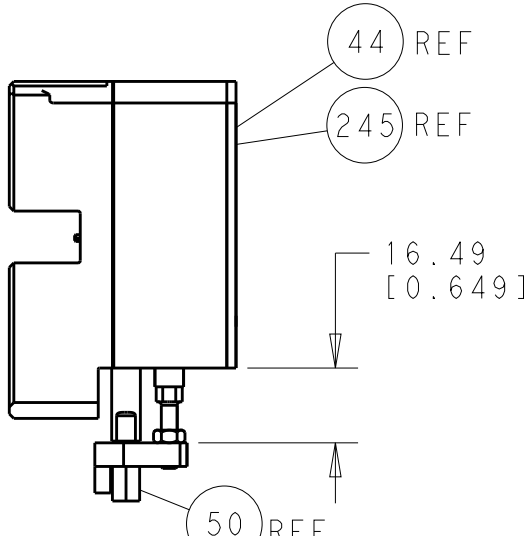
SERVO  
LATCH PLATE



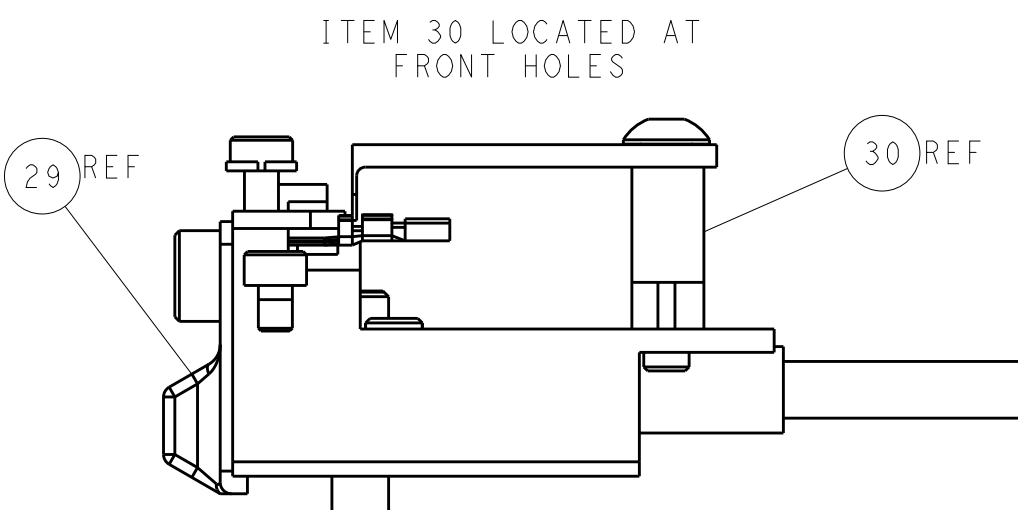
CAM POSITIONS



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)

|             |  |                                        |  |                                        |  |                           |  |
|-------------|--|----------------------------------------|--|----------------------------------------|--|---------------------------|--|
| DIMENSIONS: |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | DWN                                    |  | TE Connectivity           |  |
| mm          |  | 0 PLC ±.5                              |  | X. ZHAO                                |  | Harrisburg, PA 17105-3608 |  |
|             |  | 1 PLC ±0.13                            |  | CH. TELBIN                             |  |                           |  |
|             |  | 2 PLC ±0.13                            |  | APVD                                   |  |                           |  |
|             |  | 3 PLC ±0.013                           |  | S. XI                                  |  |                           |  |
|             |  | 4 PLC ±0.0001                          |  | 09DEC2011                              |  |                           |  |
|             |  | ANGLES                                 |  | PRODUCT SPEC                           |  |                           |  |
|             |  | FINISH                                 |  | APPLICATION SPEC                       |  |                           |  |
|             |  |                                        |  | WEIGHT                                 |  |                           |  |
|             |  |                                        |  | Customer Accessible Production Drawing |  |                           |  |
|             |  |                                        |  | SCALE                                  |  |                           |  |
|             |  |                                        |  | 1:2                                    |  |                           |  |
|             |  |                                        |  | SHEET                                  |  |                           |  |
|             |  |                                        |  | 2 of 4                                 |  |                           |  |
|             |  |                                        |  | REV                                    |  |                           |  |
|             |  |                                        |  | A                                      |  |                           |  |







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

D

C

B

A

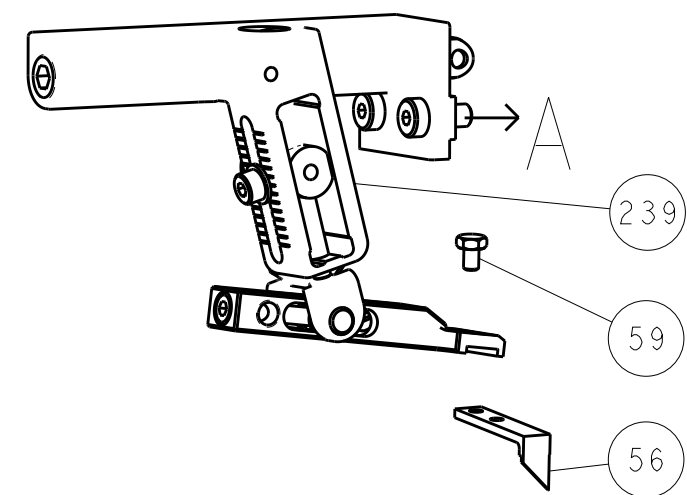
D

C

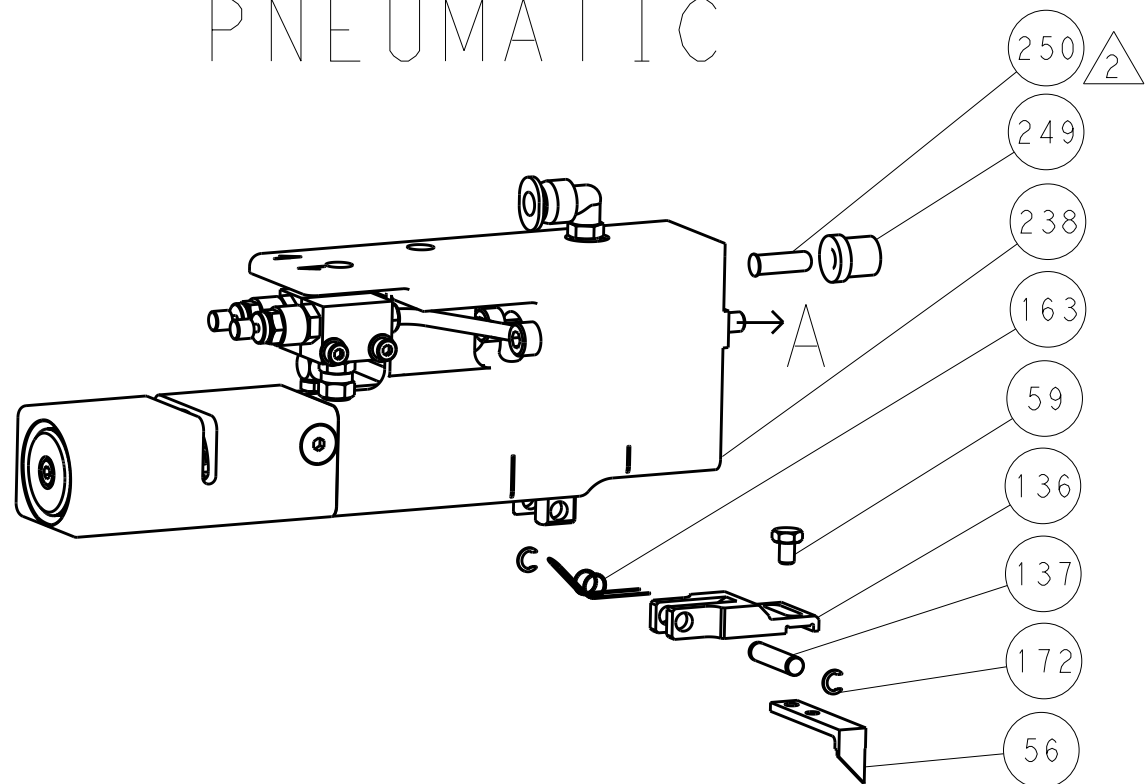
B

A

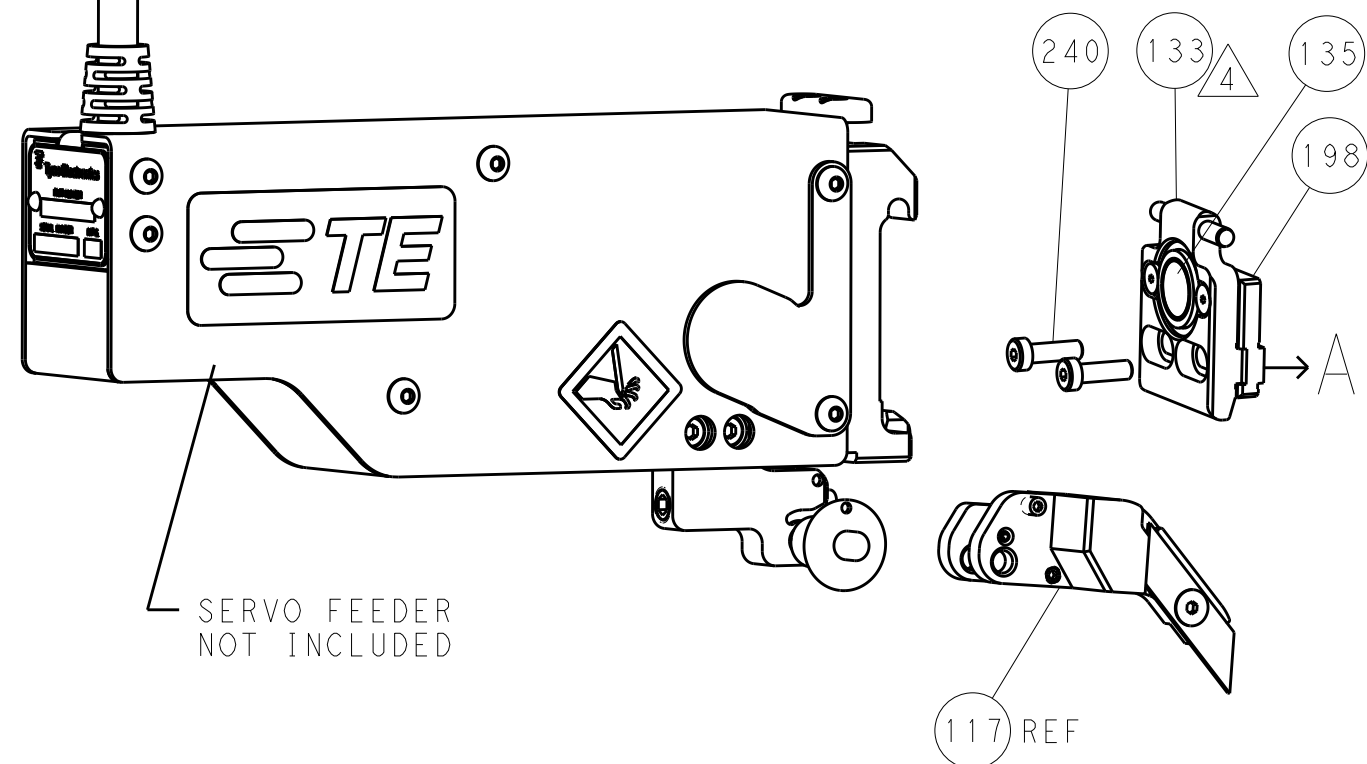
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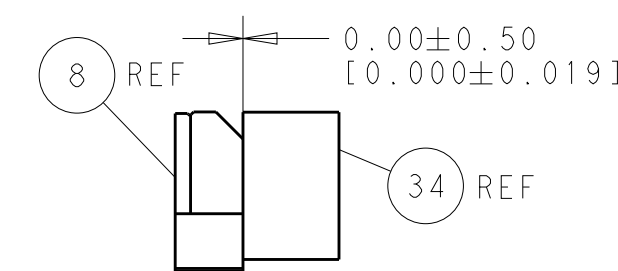
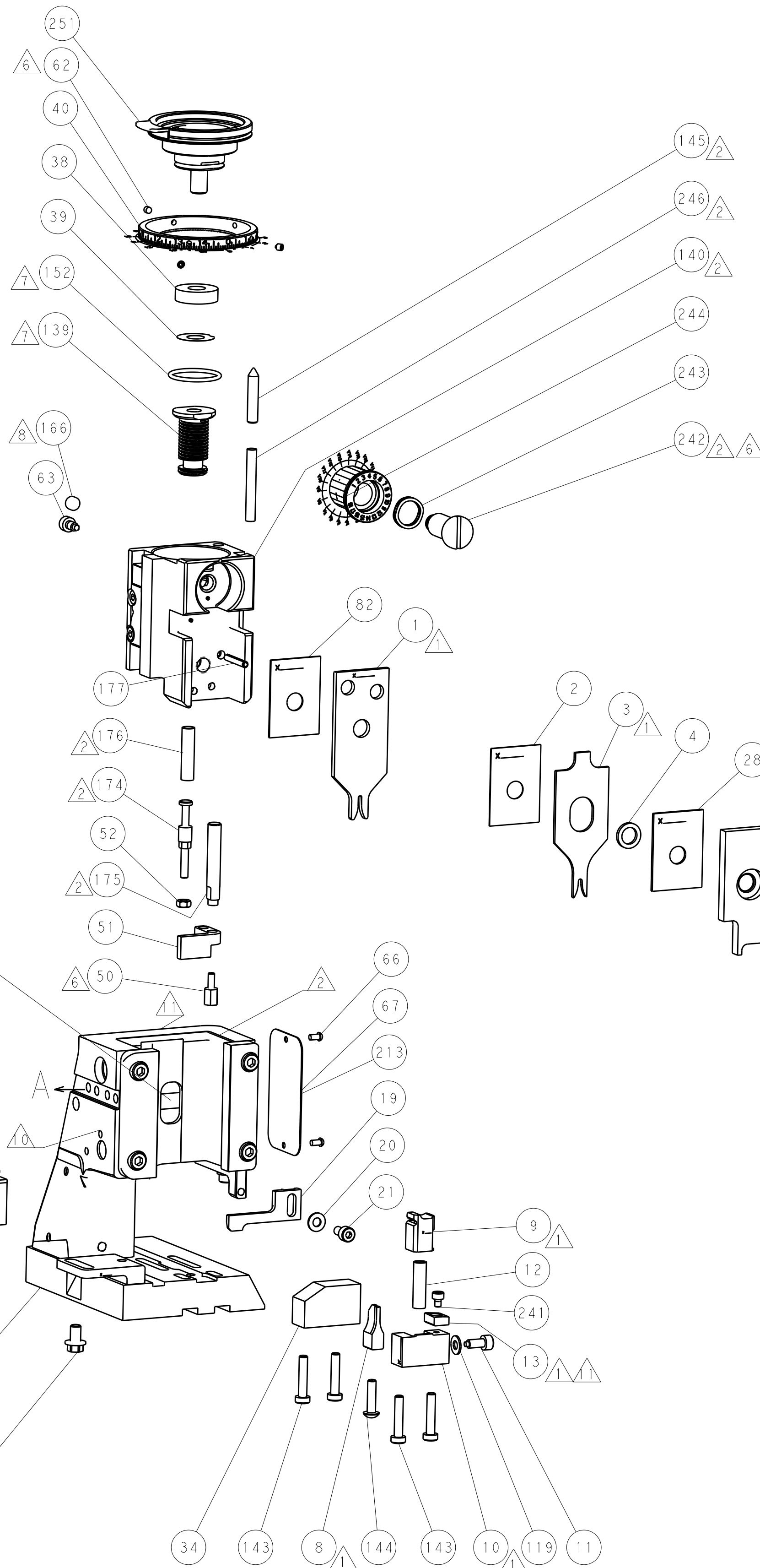
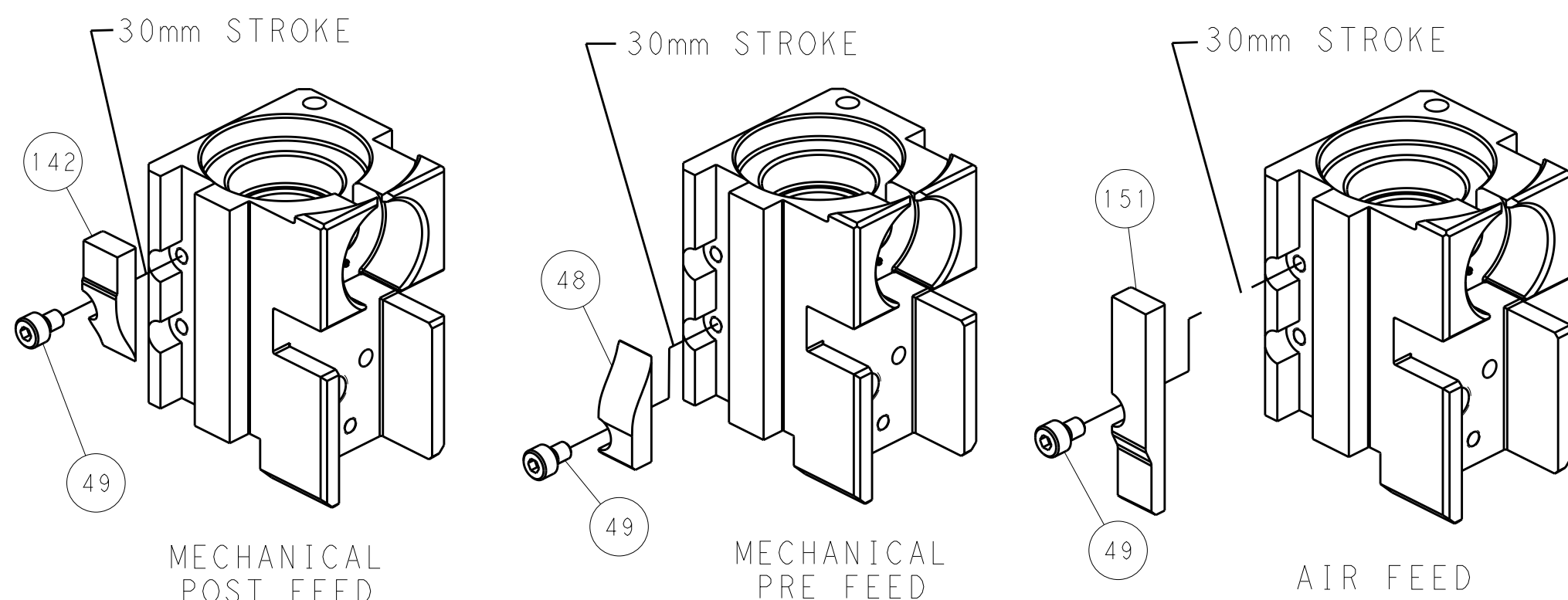
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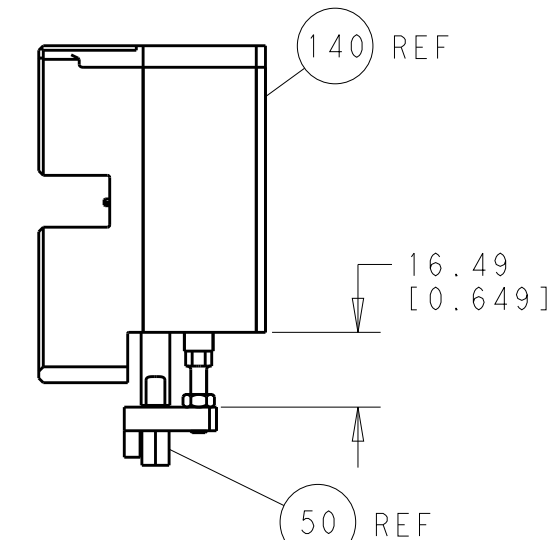
## SERVO LATCH PLATE



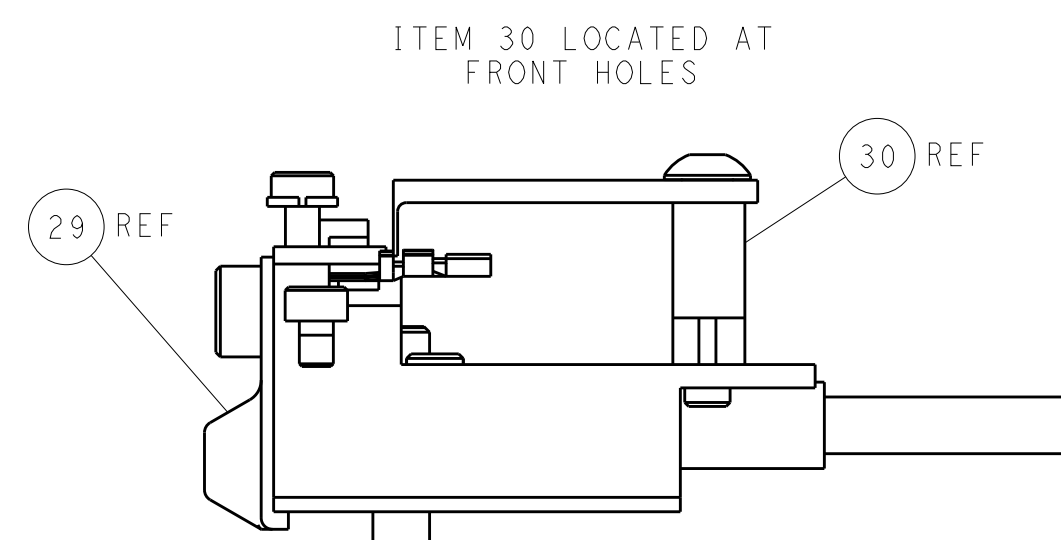
## CAM POSITIONS



TERMINAL SUPPORT LOCATION



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:<br>mm                      |  | TOLERANCES UNLESS<br>OTHERWISE SPECIFIED: |  | DWN<br>X. ZHAO 09DEC2011 |  | CHK<br>T. ELBIN 09DEC2011 |  | APVD<br>S. XI 09DEC2011 |  | NAME<br>Ocean Side Feed<br>Applicator |  |
| 0 PLC ±.5                              |  | 1 PLC ±.5                                 |  | 2 PLC ±.5                |  | 3 PLC ±.5                 |  | 4 PLC ±.5               |  | ANGLES                                |  |
| FINISH                                 |  | MATERIAL                                  |  | WEIGHT                   |  | SCALE                     |  | SHEET                   |  | REV                                   |  |
| Customer Accessible Production Drawing |  | 1:2                                       |  | 4                        |  | A                         |  | 2151427                 |  | A                                     |  |

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION