

|                                                                                  |                |                          |                          |
|----------------------------------------------------------------------------------|----------------|--------------------------|--------------------------|
| 8                                                                                |                | 7                        |                          |
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| ATLANTIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                              | PART<br>NUMBER | REVISION                 | DESCRIPTION              |
|  | 2151737-1      | D                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151737-2      | D                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151737-5      | D                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 2151737-6      | D                        | NON-CRIMP HEIGHT ADJUST  |
|                                                                                  | 2151737-7      | D                        | FINE CRIMP HEIGHT ADJUST |
|                                                                                  | 7-2151737-7    | C                        | CRIMP TOOLING KIT        |

|                                      |                 |      |
|--------------------------------------|-----------------|------|
| APPLICATOR DATA                      |                 |      |
| CRIMP                                | SIZE            | TYPE |
| WIRE                                 | 1.40 mm [ .055] | F    |
| INSUL                                | 1.50 mm [ .059] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                 |      |

|                                                           |                 |                                                             |                 |
|-----------------------------------------------------------|-----------------|-------------------------------------------------------------|-----------------|
| TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION |                 |                                                             |                 |
| TERMINAL NAME: DF59 SERIES TERMINAL                       |                 |                                                             |                 |
| WIRE STRIP LENGTH<br>1.64-1.65 mm [ .065- .065 IN]        |                 | INSULATION DIAMETER RANGE<br>Ø1.20-1.45 mm [ .047- .057 IN] |                 |
| TERMINAL APPLICATION SPECIFICATION                        | HIROSE Rev A    | -                                                           | -               |
| TERMINALS APPLIED                                         |                 |                                                             |                 |
| TE TERMINAL                                               | HIROSE TERMINAL | TE TERMINAL                                                 | HIROSE TERMINAL |
| 2113294-1                                                 | DF59-22-PCFA    |                                                             |                 |

|           |                              |                                |
|-----------|------------------------------|--------------------------------|
| WIRE SIZE | CRIMP HEIGHT mm [INCH]       | CRIMP HEIGHT REFERENCE SETTING |
| 22 AWG    | 0.67+/-0.025 [ .027+/- .001] | 9.4                            |



- 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: 8-2151737-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151737-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151737-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151737-6
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. 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 37,50.
- 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

\*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     |
| -   | 1  | -  | 1  | 1  | 1  | 2119798-1 | DETENT PIN                      | 247     |
| -   | 1  | -  | 1  | 1  | 1  | 1-22279-3 | SPRING, COMPRESSION             | 246     |
| -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      |
|                           |          |            |           | B   | ECR-12-019820 | 15NOV2012 |
|                           |          |            |           | C   | ECR-15-016803 | 17NOV2015 |
|                           |          |            |           | D   | ECR-16-011714 | 16AUG2016 |
|                           |          |            |           |     |               |           |

|     |     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | -   | 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   | 1   | 1   | 1   | 1-1976053-0 | LOCATER BLOCK, TERMINAL             | 230     |
| -   | -   | 1   | 1   | -   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213     |
| -   | -   | 1   | 1   | -   | -   | 1901094-3   | SPACER, FEEDER                      | 198     |
| -   | 2   | 2   | 2   | 2   | 2   | 1-2079383-0 | SCR, BHSC, RoHS (M3 X 6)            | 179     |
| -   | 1   | 1   | 1   | 1   | 1   | 9931111-1   | 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   | 455888-4    | 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   | 1-1901681-5 | HOLDDOWN, TERMINAL                  | 51      |
| -   | 1   | 1   | 1   | 1   | 1   | 1-1752354-4 | 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   | 2-1752356-4 | 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   | 1320908-2   | 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   | 2119533-3   | 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   | 1803335-1   | ANVIL, COMBINATION                  | 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   | 1803327-2   | CRIMPER, INSULATION F PREMIUM       | 3       |
| -   | 1   | 1   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     | 2       |
| 1   | 1   | 1   | 1   | 1   | 1   | 1-1803325-0 | CRIMPER, WIRE                       | 1       |
| -77 | -7  | -6  | -5  | -2  | -1  | PART NO     | DESCRIPTION                         | ITEM NO |

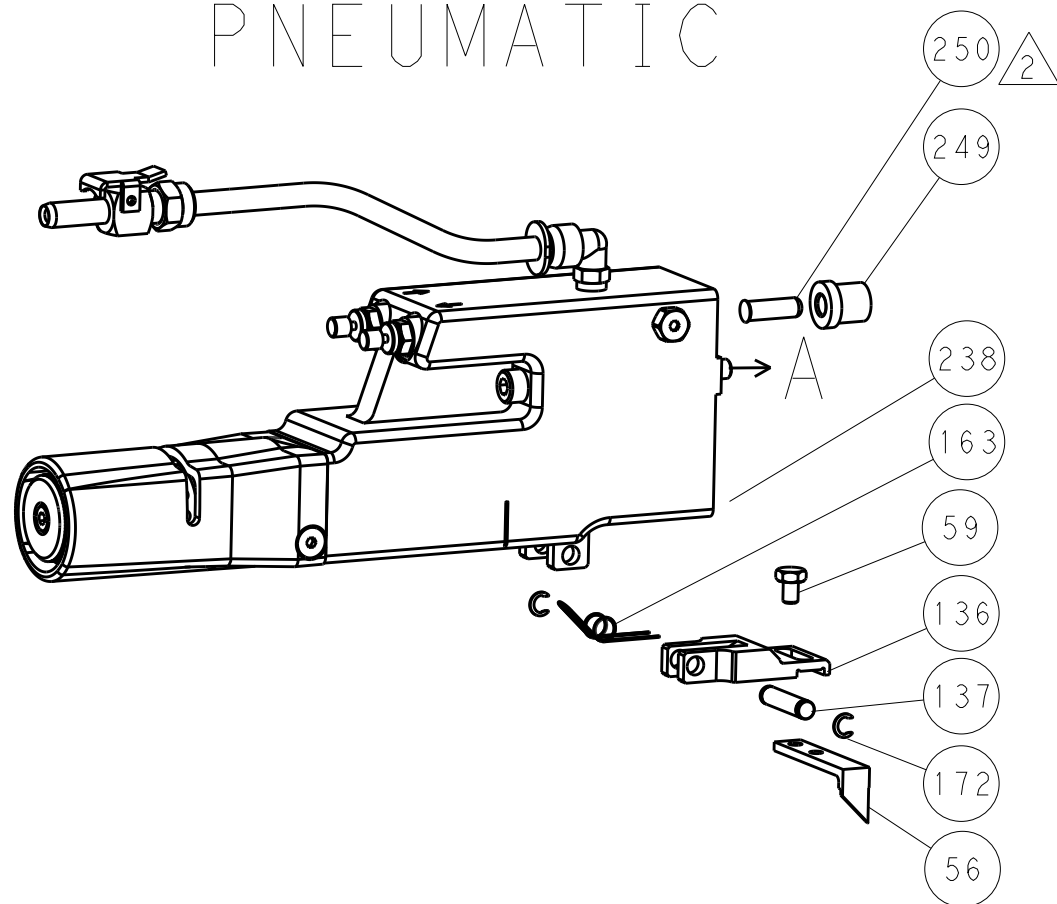
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|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------|--|----------------------------------------------------------|-------------------------------------|----------------------------------------------|--|
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| DIMENSIONS:<br>mm                                                                                                                                                                                               |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | NAME<br>Ocean Side Feed<br>Applicator                    |                                     | SIZE<br>CAGE CODE<br>DRAWING NO              |  |
| 0 PLC<br>1 PLC<br>2 PLC<br>3 PLC<br>4 PLC<br>ANGLES                                                                                                                                                             |  | ±<br>±<br>±<br>±<br>±<br>±             |  | PRODUCT SPEC                                             |                                     | RESTRICTED TO                                |  |
| MATERIAL                                                                                                                                                                                                        |  | FINISH                                 |  | APPLICATION SPEC                                         |                                     | A1 00779 ©=2151737                           |  |
| -                                                                                                                                                                                                               |  | -                                      |  | WEIGHT                                                   |                                     | Customer Accessible Production Drawing       |  |
| -                                                                                                                                                                                                               |  | -                                      |  | SCALE                                                    |                                     | 1:2                                          |  |
| -                                                                                                                                                                                                               |  | -                                      |  | SHEET                                                    |                                     | 1 OF 4                                       |  |
| -                                                                                                                                                                                                               |  | -                                      |  | REV                                                      |                                     | D                                            |  |

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

FEED TYPE  
MECHANICAL



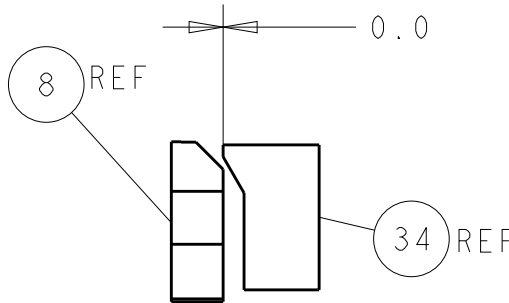
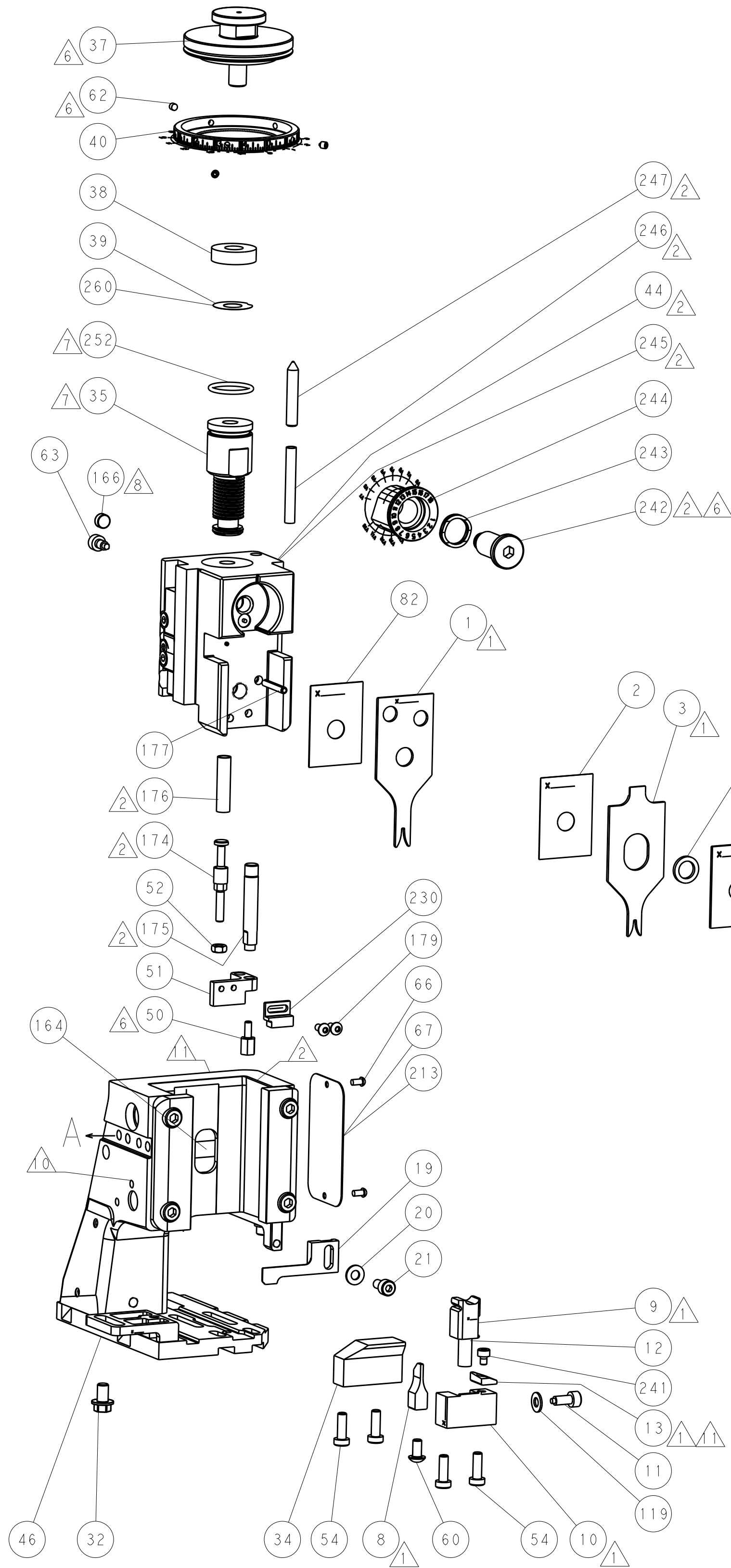
PNEUMATIC



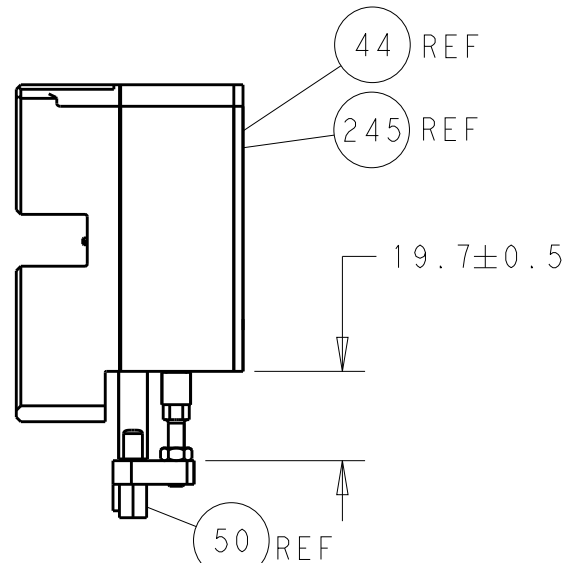
SERVO  
LATCH PLATE



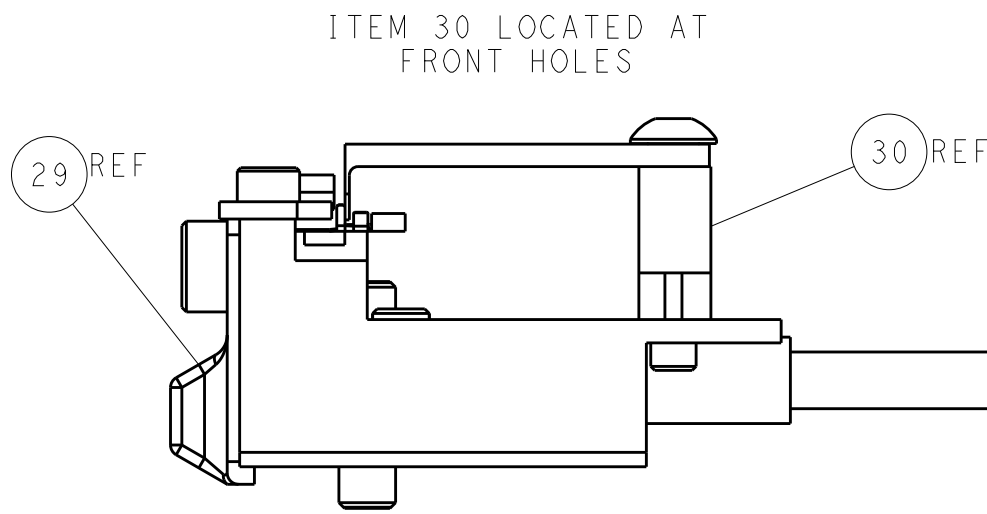
CAM POSITIONS



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)

|                                                                                                                                              |  |  |  |                                                                                    |  |  |  |                                              |  |  |  |
|----------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|------------------------------------------------------------------------------------|--|--|--|----------------------------------------------|--|--|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION. |  |  |  | OWN: BOB HIGMAN 10AUG2012<br>CHK: G. BAILEY 10AUG2012<br>APVD: G. BAILEY 10AUG2012 |  |  |  | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |  |  |
| DIMENSIONS:                                                                                                                                  |  |  |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                                             |  |  |  | NAME: Ocean Side Feed Applicator             |  |  |  |
| mm                                                                                                                                           |  |  |  | 0 PLC ±.1<br>1 PLC ±.1<br>2 PLC ±.1<br>3 PLC ±.1<br>4 PLC ±.1                      |  |  |  | SIZE: A1                                     |  |  |  |
| MATERIAL: -                                                                                                                                  |  |  |  | FINISH: -                                                                          |  |  |  | CAGE CODE: 00779                             |  |  |  |
|                                                                                                                                              |  |  |  |                                                                                    |  |  |  | DRAWING NO: C=2151737                        |  |  |  |
|                                                                                                                                              |  |  |  |                                                                                    |  |  |  | RESTRICTED TO: -                             |  |  |  |
|                                                                                                                                              |  |  |  |                                                                                    |  |  |  | Customer Accessible Production Drawing       |  |  |  |
|                                                                                                                                              |  |  |  |                                                                                    |  |  |  | SCALE: 1:1                                   |  |  |  |
|                                                                                                                                              |  |  |  |                                                                                    |  |  |  | SHEET: 1 of 4                                |  |  |  |
|                                                                                                                                              |  |  |  |                                                                                    |  |  |  | REV: D                                       |  |  |  |

|  | PART<br>NUMBER | REVISION | DESCRIPTION              | FEED TYPE                         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |   |
|----------------------------------------------------------------------------------|----------------|----------|--------------------------|-----------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|---|
|                                                                                  |                |          |                          |                                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |   |
|                                                                                  |                |          |                          |                                   |                                   |                       |           |             |           |           |                        |   |
|                                                                                  | 2-2151737-1    | D        | 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             | -         | 8-2151737-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |   |
|                                                                                  |                |          |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151737-4 | -         | -         | -                      |   |
|                                                                                  | 2-2151737-2    | D        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                         | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |   |
|                                                                                  |                |          |                          |                                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151737-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |   |
|                                                                                  |                |          |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151737-4 | -         | -         | -                      |   |
|                                                                                  | 2-2151737-5    | D        | FINE CRIMP HEIGHT ADJUST | SERVO<br>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              |   |
|                                                                                  | 2-2151737-7    | D        | FINE CRIMP HEIGHT ADJUST | NONE                              | -                                 | -                     | -         | -           | -         | -         | -                      | - |
|                                                                                  | 7-2151737-7    | C        | CRIMP TOOLING KIT        | -                                 | -                                 | -                     | -         | -           | -         | -         | -                      | - |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 1.40 mm [.055] | F    |
| INSUL                                | 1.50 mm [.059] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

|                                                           |                 |                                                           |                 |
|-----------------------------------------------------------|-----------------|-----------------------------------------------------------|-----------------|
| TERMINAL DATA: HIROSE TERMINAL HIROSE CRIMP SPECIFICATION |                 |                                                           |                 |
| TERMINAL NAME: DF59 SERIES TERMINAL                       |                 |                                                           |                 |
| WIRE STRIP LENGTH<br>1.64-1.65 mm [.065-.065 IN]          |                 | INSULATION DIAMETER RANGE<br>Ø1.20-1.45 mm [.047-.057 IN] |                 |
| TERMINAL APPLICATION SPECIFICATION                        | HIROSE Rev A    | -                                                         | -               |
| TERMINALS APPLIED                                         |                 |                                                           |                 |
| TE TERMINAL                                               | HIROSE TERMINAL | TE TERMINAL                                               | HIROSE TERMINAL |
| 2113294-1                                                 | DF59-22-PCFA    |                                                           |                 |

|           |  |                             |  |                                   |
|-----------|--|-----------------------------|--|-----------------------------------|
| WIRE SIZE |  | CRIMP HEIGHT<br>mm [INCH]   |  | CRIMP HEIGHT<br>REFERENCE SETTING |
| 22 AWG    |  | 0.67+/-0.025 [.027+/- .001] |  | 9.4                               |



- <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: 8-2151737-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151737-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151737-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50 & 62.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.

\*WARNING  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

|     |     |     |     |     |           |                                     |         |
|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1   | 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   | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| -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)

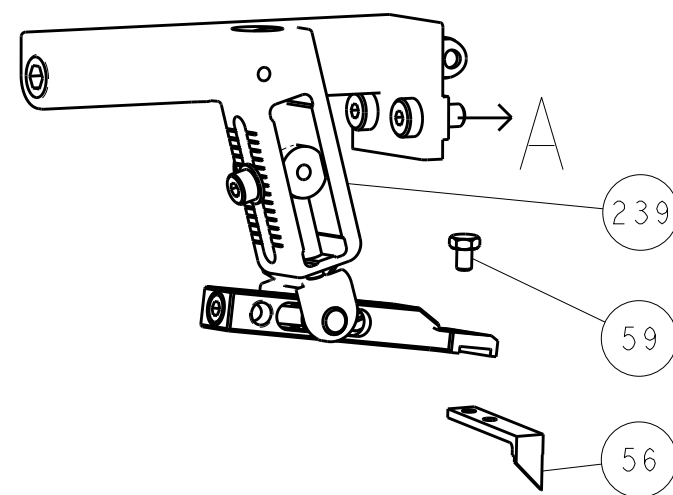
|                           |  |          |             |           |      |     |      |
|---------------------------|--|----------|-------------|-----------|------|-----|------|
| SET UP GAUGE<br>2119599-1 |  | LOC<br>A | DIST<br>66  | REVISIONS |      |     |      |
| P                         |  | LYR      | DESCRIPTION |           | DATE | OWN | APVD |
|                           |  | -        | SEE SHEET 1 |           | -    | -   | -    |
|                           |  |          |             |           |      |     |      |
|                           |  |          |             |           |      |     |      |

|              |     |     |     |     |     |             |                                     |         |
|--------------|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| <sup>6</sup> | -   | 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   | 1   | 1   | 1   | 1-1976053-0 | LOCATER BLOCK, TERMINAL             | 230     |
|              | -   | -   | 1   | -   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213     |
|              | -   | -   | 1   | -   | -   | 1901094-3   | SPACER, FEEDER                      | 198     |
|              | -   | 2   | 2   | 2   | 2   | 1-2079383-0 | SCR, BHSC, RoHS (M3 X 6)            | 179     |
|              | -   | 1   | 1   | 1   | 1   | 9931111-1   | PIN, SLOTTED SPRING 3.0 X 20.0      | 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   | 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   | 455888-4    | 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   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
|              | -   | -   | -   | 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   | 1-1901681-5 | HOLDDOWN, TERMINAL                  | 51      |
|              | -   | 1   | 1   | 1   | 1   | 1-1752354-4 | 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   | 2119644-1   | RAM WASHER, PRECISION               | 38      |
|              | -   | 1   | 1   | 1   | 1   | 2-1752356-4 | SUPPORT, TERMINAL                   | 34      |
|              | -   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33      |
|              | -   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32      |
|              | -   | 1   | 1   | 1   | 1   | 1320908-2   | SPACER, STRIP GUIDE                 | 30      |
|              | -   | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29      |
|              | -   | 1   | 1   | 1   | 1   | 1-455888-0  | 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      |
| <sup>1</sup> | -   | 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   | 1803335-1   | ANVIL, COMBINATION                  | 8       |
|              | -   | -   | -   | -   | -   | -           | -                                   | 7       |
|              | -   | -   | -   | -   | -   | -           | -                                   | 6       |
|              | -   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5       |
|              | -   | 1   | 1   | 1   | 1   | 2-238011-5  | BLOCK, CRIMPER SPACER               | 4       |
| <sup>1</sup> | 1   | 1   | 1   | 1   | 1   | 1803327-2   | CRIMPER, INSULATION F PREMIUM       | 3       |
|              | -   | 1   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     | 2       |
|              | 1   | 1   | 1   | 1   | 1   | 1-1803325-0 | CRIMPER, WIRE                       | 1       |
|              | -77 | -27 | -25 | -22 | -21 | PART NO     | DESCRIPTION                         | ITEM NO |

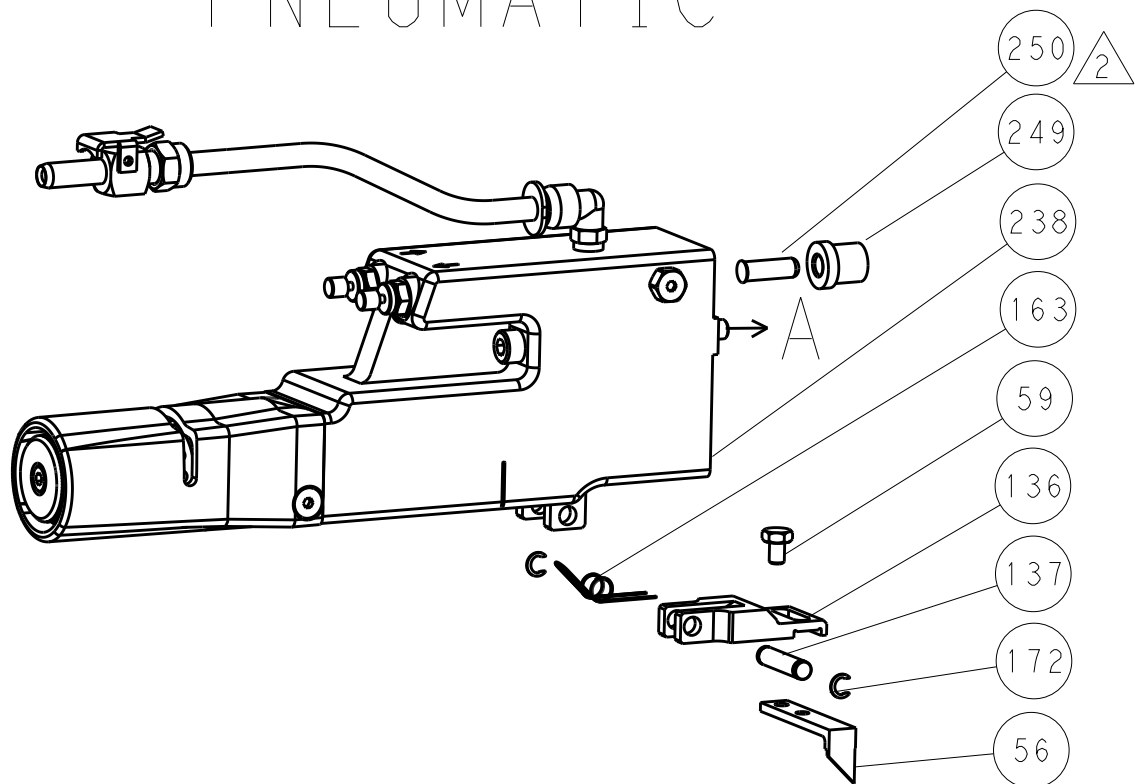
|                                                                                                                                                              |  |                                                                                   |  |                                                            |                                     |                                              |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------|--|------------------------------------------------------------|-------------------------------------|----------------------------------------------|--|
| THIS DOCUMENT IS CONTROLLED DOCUMENT. IT IS SUBJECT TO CHANGE AND TO THE CONTROL AND IDENTIFICATION ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION. |  |                                                                                   |  | OWN<br>BOB HIGMAN<br>CHK<br>G. BAILEY<br>APVD<br>G. BAILEY | 10AUG2012<br>10AUG2012<br>10AUG2012 | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| DIMENSIONS:<br>mm                                                                                                                                            |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                                            |  | NAME<br>Ocean Side Feed<br>Applicator                      |                                     | RESTRICTED TO                                |  |
|                                                                                                                                                              |  | 0 PLC ±.01<br>1 PLC ±.01<br>2 PLC ±.01<br>3 PLC ±.01<br>4 PLC ±.01<br>ANGLES ±.01 |  | PRODUCT SPEC                                               |                                     | SIZE CASE CODE DRAWING NO                    |  |
| MATERIAL                                                                                                                                                     |  | FINISH                                                                            |  | APPLICATION SPEC                                           |                                     | 100779 ©=2151737                             |  |
|                                                                                                                                                              |  |                                                                                   |  | WEIGHT                                                     |                                     | Customer Accessible Production Drawing       |  |
|                                                                                                                                                              |  |                                                                                   |  | SCALE                                                      |                                     | 1:1                                          |  |
|                                                                                                                                                              |  |                                                                                   |  | SHEET                                                      |                                     | 1 OF 4                                       |  |
|                                                                                                                                                              |  |                                                                                   |  | REV                                                        |                                     | D                                            |  |

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

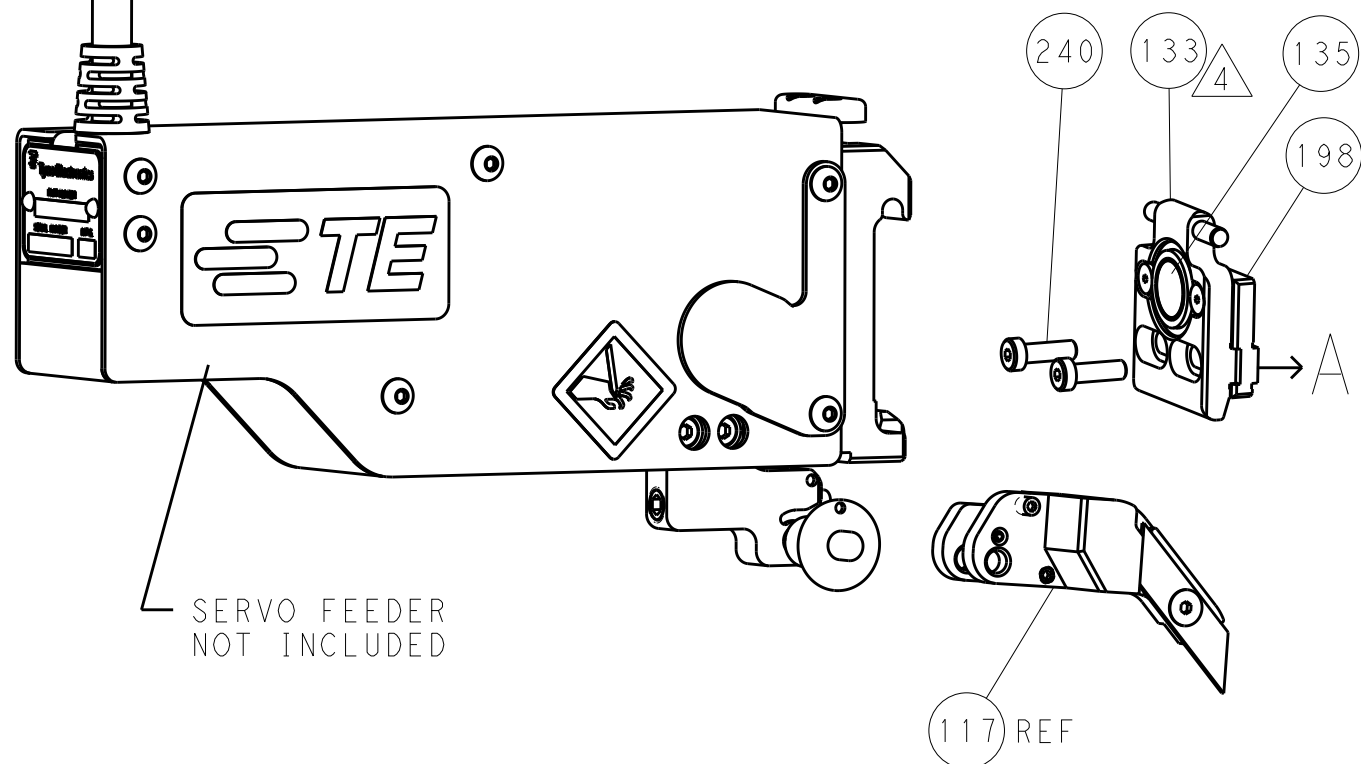
# FEED TYPE MECHANICAL



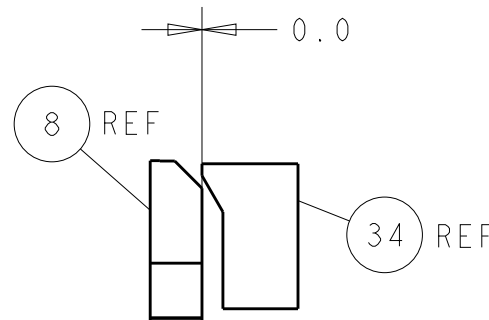
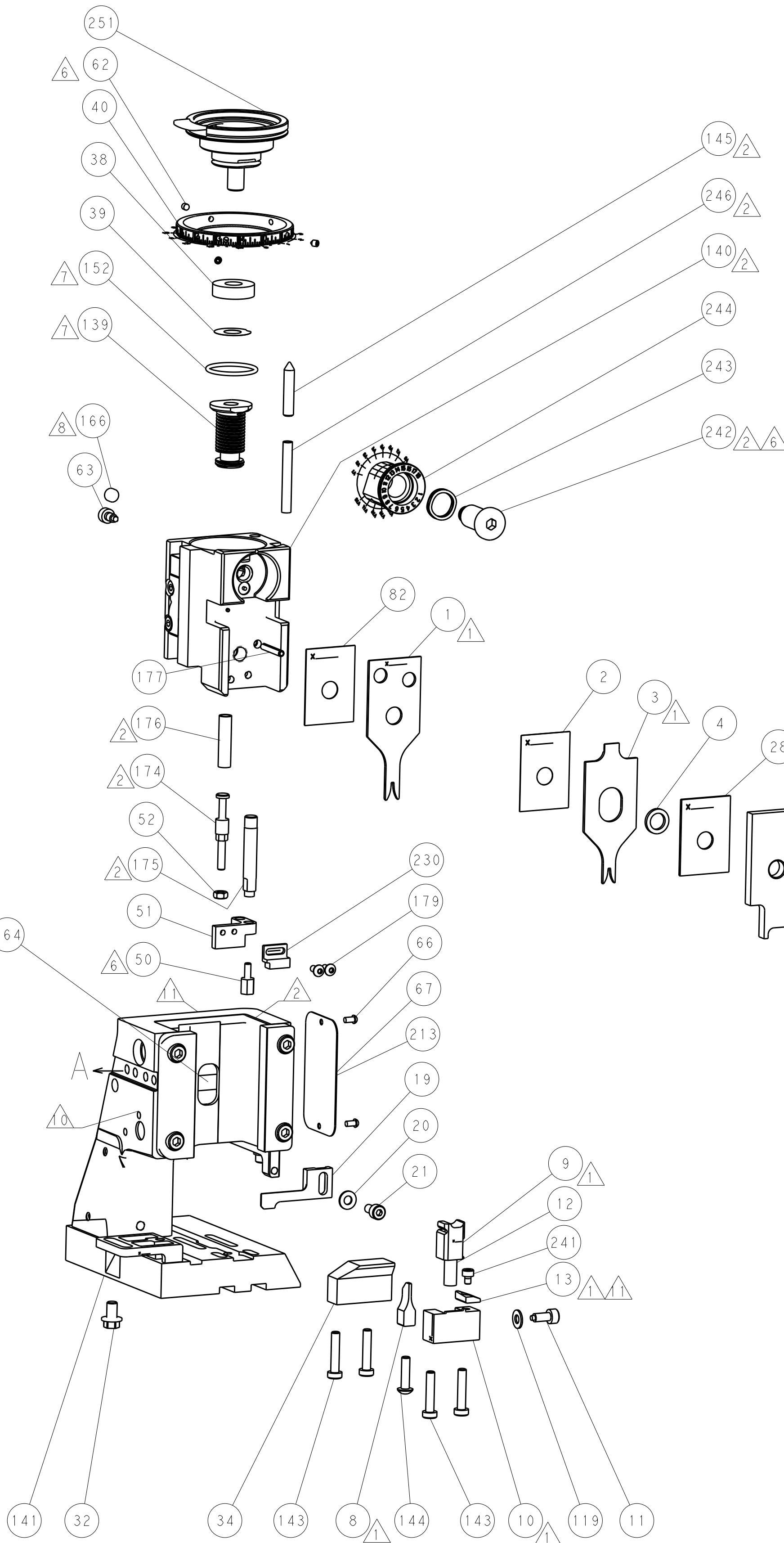
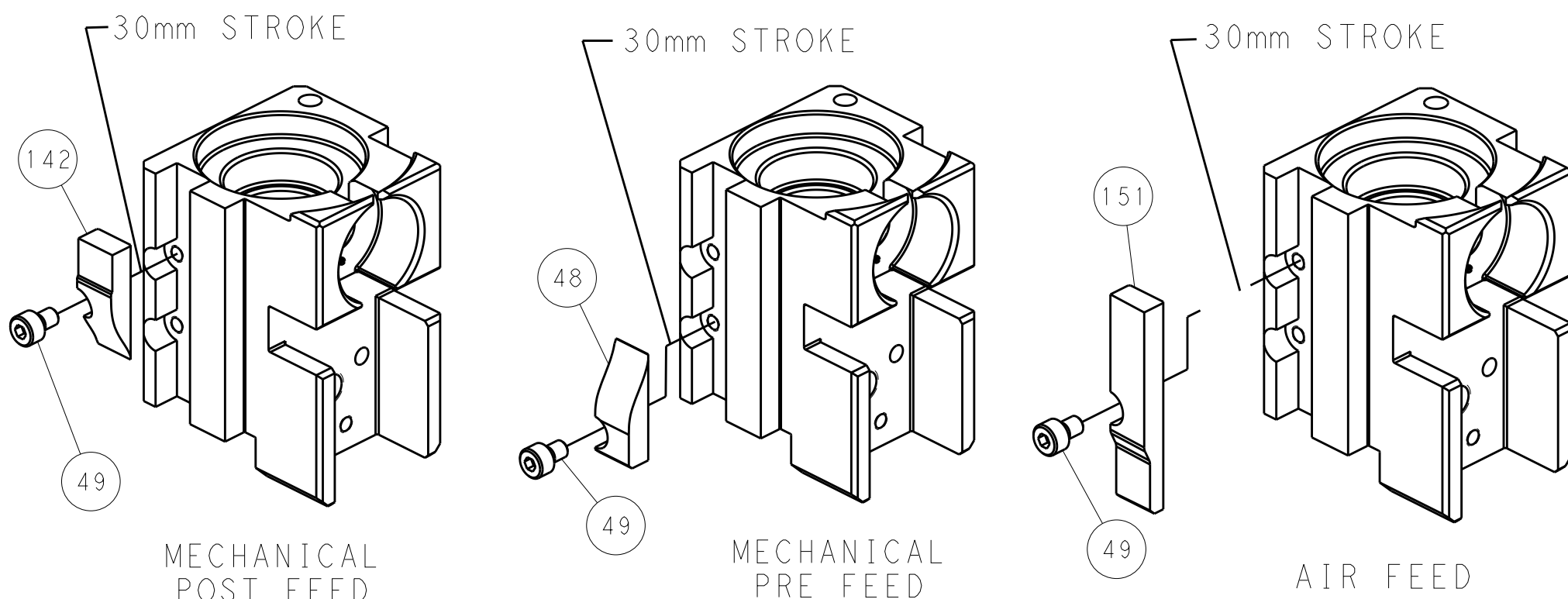
# PNEUMATIC



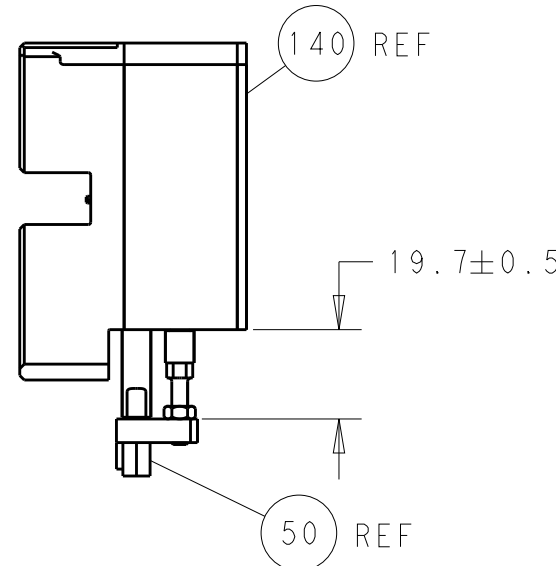
# SERVO LATCH PLATE



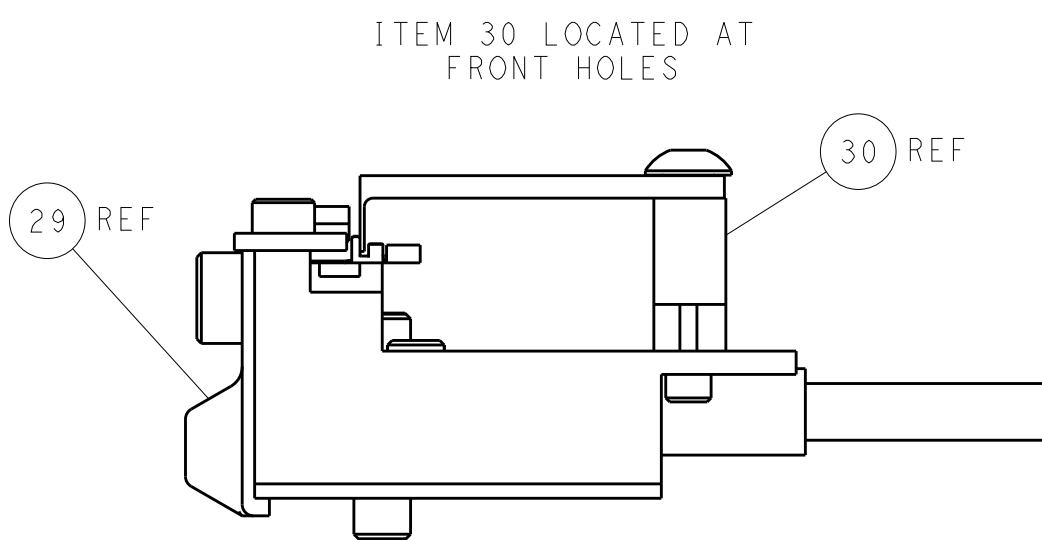
# CAM POSITIONS



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>BOB HIGMAN 10AUG2012 |  | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| 0 PLC ±                                |  | 1 PLC ±                                   |  | CHK<br>G. BAILEY 10AUG2012  |  | NAME<br>Ocean Side Feed<br>Applicator        |  |
| 2 PLC ±                                |  | 3 PLC ±                                   |  | APVD<br>G. BAILEY 10AUG2012 |  | SIZE<br>A1                                   |  |
| 4 PLC ±                                |  | ANGLES<br>FINISH                          |  | PRODUCT SPEC                |  | CAGE CODE<br>00779                           |  |
| MATERIAL                               |  | WEIGHT                                    |  | APPLICATION SPEC            |  | DRAWING NO<br>2151737                        |  |
| Customer Accessible Production Drawing |  | SCALE<br>1:1                              |  | SHEET<br>1                  |  | REV<br>D                                     |  |