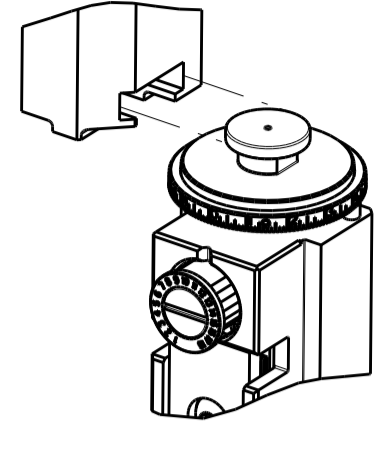

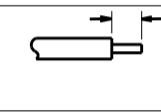

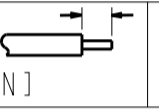



ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151969-1	B	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
					SERVO LATCH PLATE	2119951-1	-	8-2151969-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151969-4	-	-	-
	2151969-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151969-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151969-4	-	-	-
	2151969-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
				PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
2151969-6	B	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	
2151969-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151969-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [ .055 ]	F
INSUL	1.57 mm [ .062 ]	O




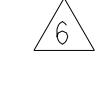






APPLICATOR INSTRUCTIONS 408-10389 

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMPMODU II RECEPTACLE			
WIRE STRIP LENGTH 2.80-3.56 mm [ .110-.140 IN ]		INSULATION DIAMETER RANGE Ø1.02-1.55 mm [ .040-.061 IN ]	
TERMINAL APPLICATION SPECIFICATION 114-20004	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
280530-1	280530-2	280530-3	280530-4
280530-5	280530-6	280708-2	-

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMPMODU II RECEPTACLE			
WIRE STRIP LENGTH 2.80-3.56 mm [ .110-.140 IN ]		INSULATION DIAMETER RANGE Ø0.64-1.27 mm [ .025-.050 IN ]	
TERMINAL APPLICATION SPECIFICATION 114-20004	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
280422-1	280422-2	280422-5	280709-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22-24 AWG	0.69 +/- 0.03 [ .027 +/- .001 ]	6.3
26 AWG	0.64 +/- 0.03 [ .025 +/- .001 ]	6.9

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
28-30 AWG	0.56 +/- 0.03 [ .022 +/- .001 ]	7.9

-  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: 8-2151969-4
  - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151969-4
  - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151969-5
  - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151969-6
- 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 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.
-  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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 5.11.

**\*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	1	2119791-9	DEPRESSOR, WIRE	261
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	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	LOC	DIST	REVISIONS				
2119599-1	A	66	P	L	DATE	OWN	APVD
			A1		ECR-14-016761	11NOV2014	KH UG
			B		ECR-15-016196	05NOV2015	JH JDG

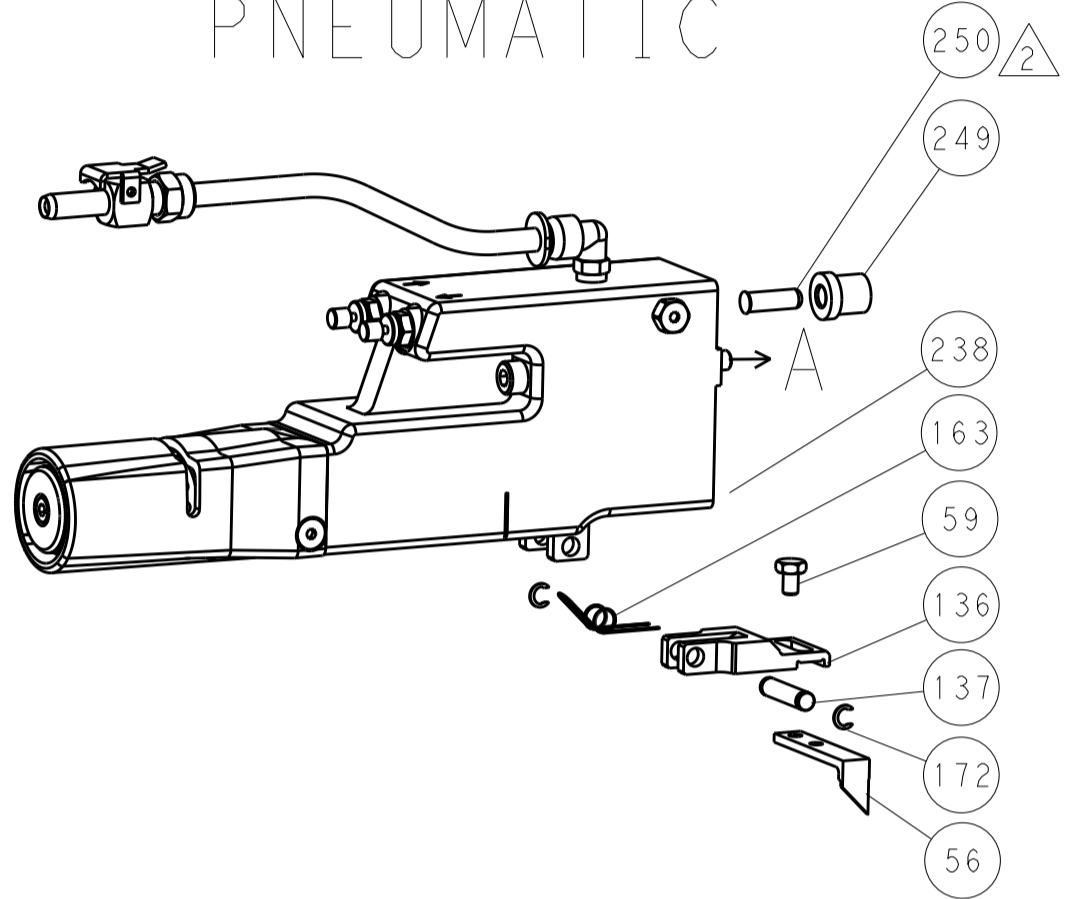
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	2	2	2	2	2	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	2	-	-	2168400-6	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	356885-4	STOP, SHEAR	237
-	-	1	1	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	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	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	6-240641-4	SPACER	81
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	-	-	-	-	1	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	1-2119644-4	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
-	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	1-455888-3	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	690518-2	HOLD DOWN, TERMINAL	18
-	1	1	1	1	1	690463-1	FLOATING SHEAR, REAR	17
-	2	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1	1	1	1-690464-0	SHEAR PLATE, REAR	15
-	1	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	2	2	2	2	2	2119806-1	INSERT, SHEAR	13
-	2	2	2	2	2	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	1803095-3	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1	1333201-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	1	1	1	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
-	1	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-5	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	5-1633965-8	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	-	-	-	-	2
-	1	1	1	1	1	2-456402-3	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

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

### FEED TYPE MECHANICAL



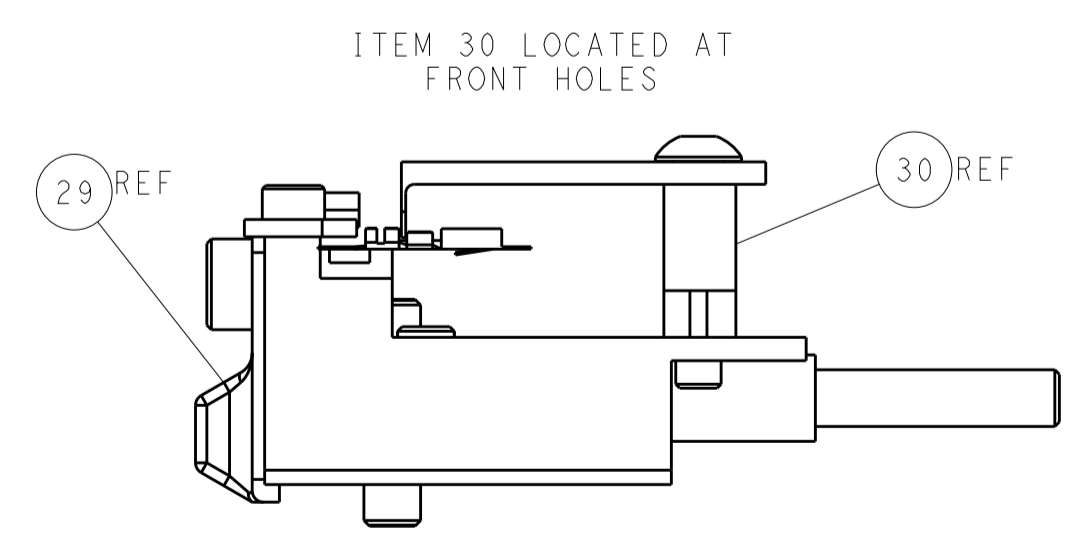
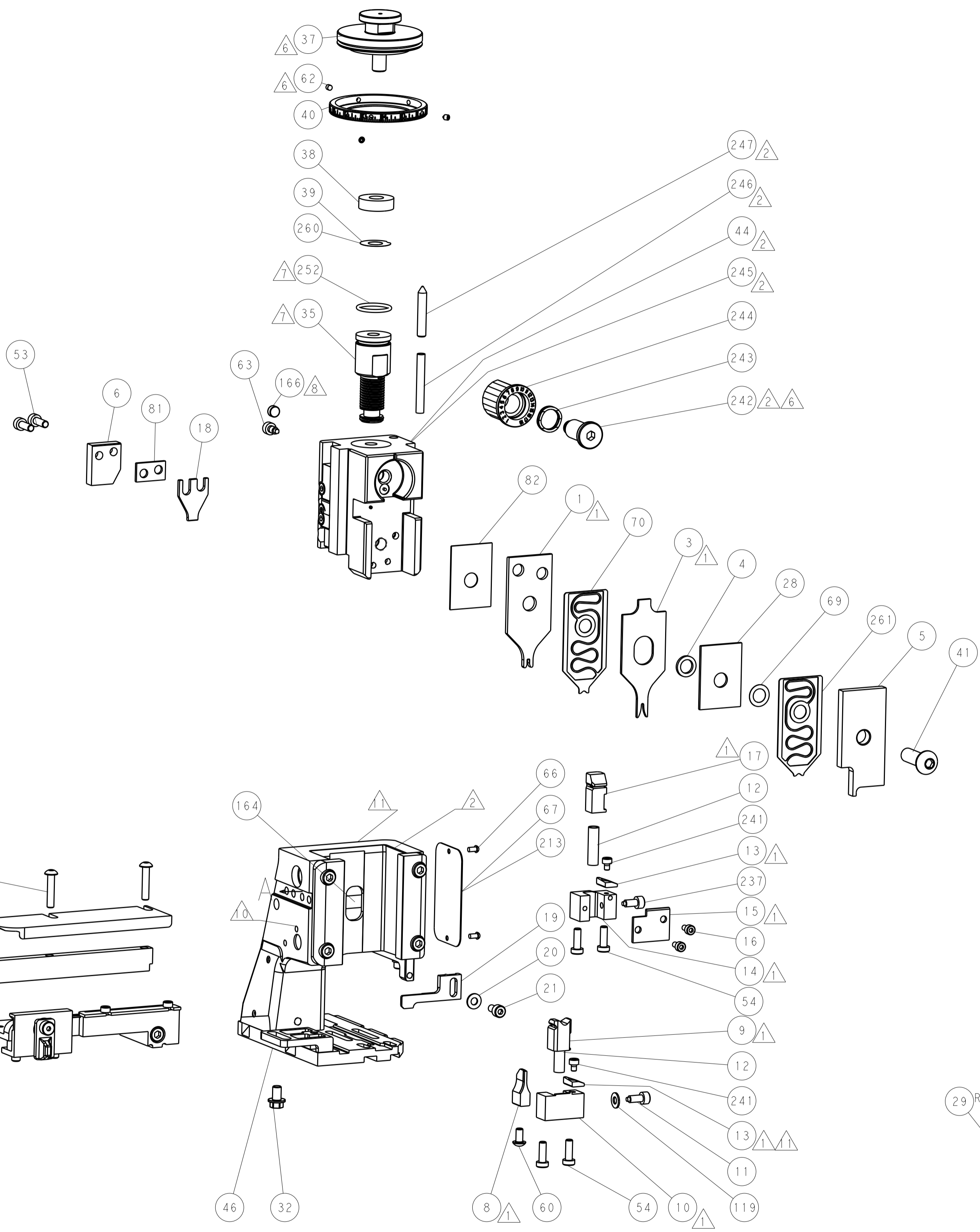
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: C. CHEN 28MAY2013		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	CHK: U. GUO 28MAY2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		APVD: J. CRUZ 28MAY2013		NAME: Ocean Side Feed Applicator	
Customer Accessible Production Drawing		SCALE: 1:2		SHEET 2 of 4		REV B	

APPLICATOR STYLE CONVERSION CHART. Table with columns: CONVERT TO, PART NUMBERS REQUIRED. Rows include PNEUMATIC FEED, SERVO LATCH PLATE, MECHANICAL FEED, SMART APPLICATOR, MECHANICAL FEED, SERVO LATCH PLATE, SMART APPLICATOR, MECHANICAL FEED, SERVO LATCH PLATE, PNEUMATIC FEED.

APPLICATOR DATA. Table with columns: CRIMP, SIZE, TYPE. Includes WIRE (1.40 mm [.055]), INSUL (1.57 mm [.062]).

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table for 22-24 AWG and 26 AWG.

WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Table for 28-30 AWG.

- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY...

\*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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Lists items like DEPRESSOR, WIRE, FINE ADJUST HEAD ASM, PUSH ROD, AIR FEED, BUSHING, LCH5-12, MISUMI, SPRING, COMPRESSION, CAM, SNAIL, INSULATION ADJUSTMENT.

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

REVISIONS. Table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Includes revision 1: SEE SHEET 1.

Large parts list table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Lists numerous components like WASHER, WAVE SPRING, CREST-TO-CREST, RETAINER, INSULATION DIAL, SCR, SKT HD CAP, SHCS, LOW HEAD, RoHS, M5 X 16, MECHANICAL FEED ASSEMBLY, AIR FEED MODULE, STOP, SHEAR, TAG, IDENTIFICATION, SPACER, FEEDER, RING, RETAIN, EXTERN, 3/16 CRESCENT, MAGNET, RARE EARTH HIGH ENERGY, COUNTER, MAGNETIC, SPRING, FEED FINGER, O-RING, .801 ID, .070 DIA. MAT., FEED CAM, AIR FEED, DETENT PIN, SCR, BHSC, RoHS (M4 X 16), SHCS, LOW HEAD, RoHS, M4 X 20, FEED CAM, POST FEED, APPLICATOR BASIC ASSEMBLY, SF, RAM, ASIAN STYLE, SIDE FEED, BOLT, ADJUSTMENT, PIN, RETAIN, GRVD, 3/16 X .854, HOLDER, FEED FINGER, AF, MEMORY CHIP, PROGRAMMED, SERVO FEED LATCH ASM, WASHER, FLAT, REG M4, FEED FINGER ASSEMBLY, SF, SPACER, CRIMPER, SPACER, DOCUMENTATION PACKAGE, DEPRESSOR, WIRE, WASHER, SPACER, TAG, IDENTIFICATION, SCREW, DRIVE, RH, RoHS, 2 X .188, LIMITER, ADJUSTMENT BOLT, SCR, SET, SOC, CONE POINT, M3 X 4.0, SCR, HEX HD CAP, M4 X 6.0, PAWL, FEED, SCR, SKT HD CAP, RoHS, M4 X 12.0, SCR, SKT HD CAP M4 X 6.0, FEED CAM, PRE FEED, SCR, BHSC, RoHS (M8 X 25), DISC, NUMBERED FA WIRE ADJUSTMENT, APPLICATOR SHIM PACK, RAM WASHER, PRECISION, SCR, BHSC, RoHS (M4 X 20), HEX HEAD, FLANGED, M5 X 8mm LONG, SPACER, STRIP GUIDE, ASSEMBLY, STRIP GUIDE, SPACER, CRIMPER, STRIP GUIDE, SCR, SKT HD CAP, RoHS, M4 X 8.0, WASHER, FLAT, REG M4, STRIPPER, SIDE FEED, HOLD DOWN, TERMINAL, FLOATING SHEAR, REAR, SCR, SKT HD CAP, RoHS, M3 X 6, SHEAR PLATE, REAR, SHEAR HOLDER, REAR, INSERT, SHEAR, SPRING, COMPRESSION, STOP, SHEAR, SHEAR HOLDER, FRONT, FLOATING SHEAR, FRONT, ANVIL, COMBINATION, DEPRESSOR SHEAR, REAR, DEPRESSOR, SHEAR, BLOCK, CRIMPER SPACER, CRIMPER, INSULATION O PREMIUM, CRIMPER, WIRE PREMIUM.

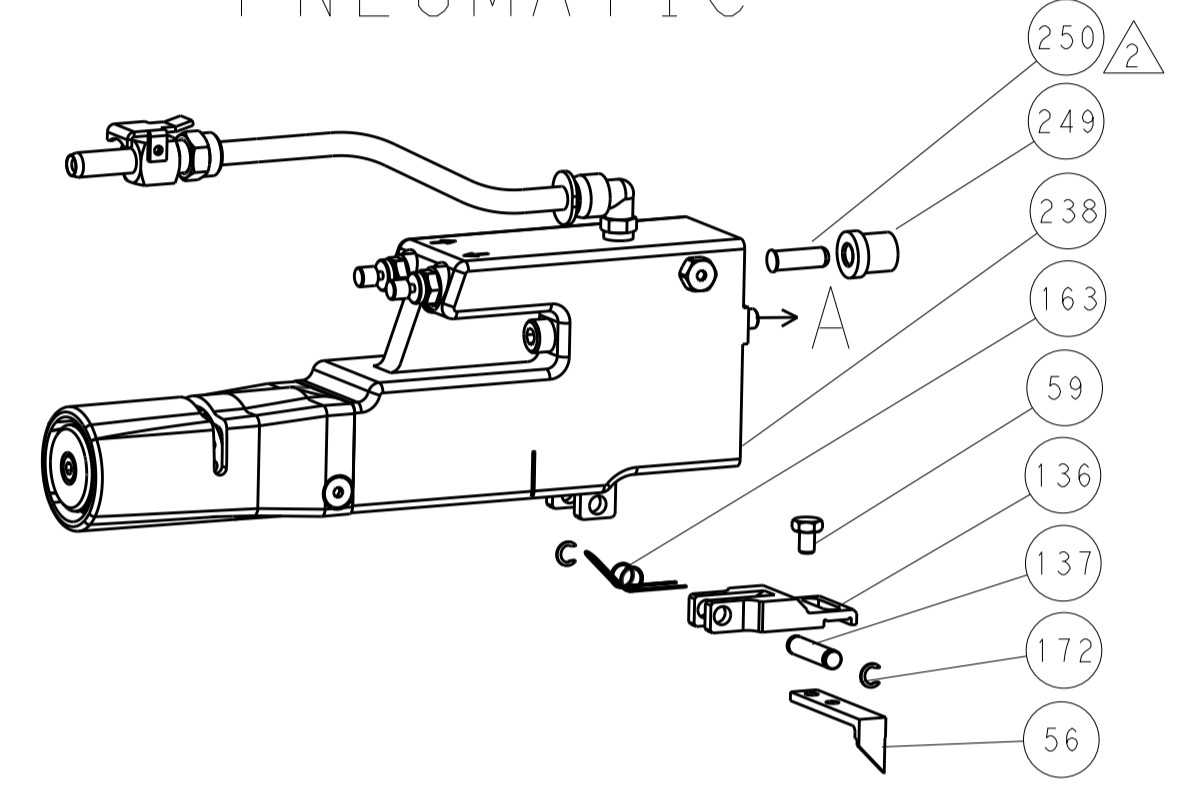
Product information block including dimensions (mm), tolerances (PLC, ANGLES), material, finish, weight, and customer accessible production drawing details.

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

# FEED TYPE MECHANICAL



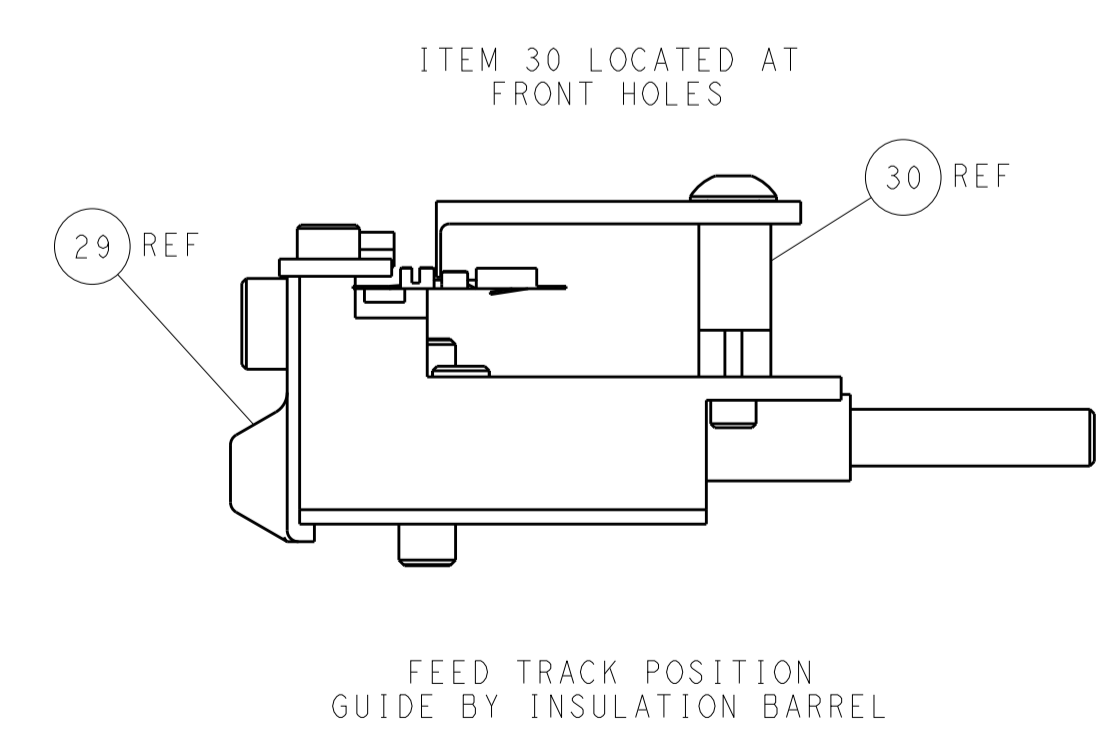
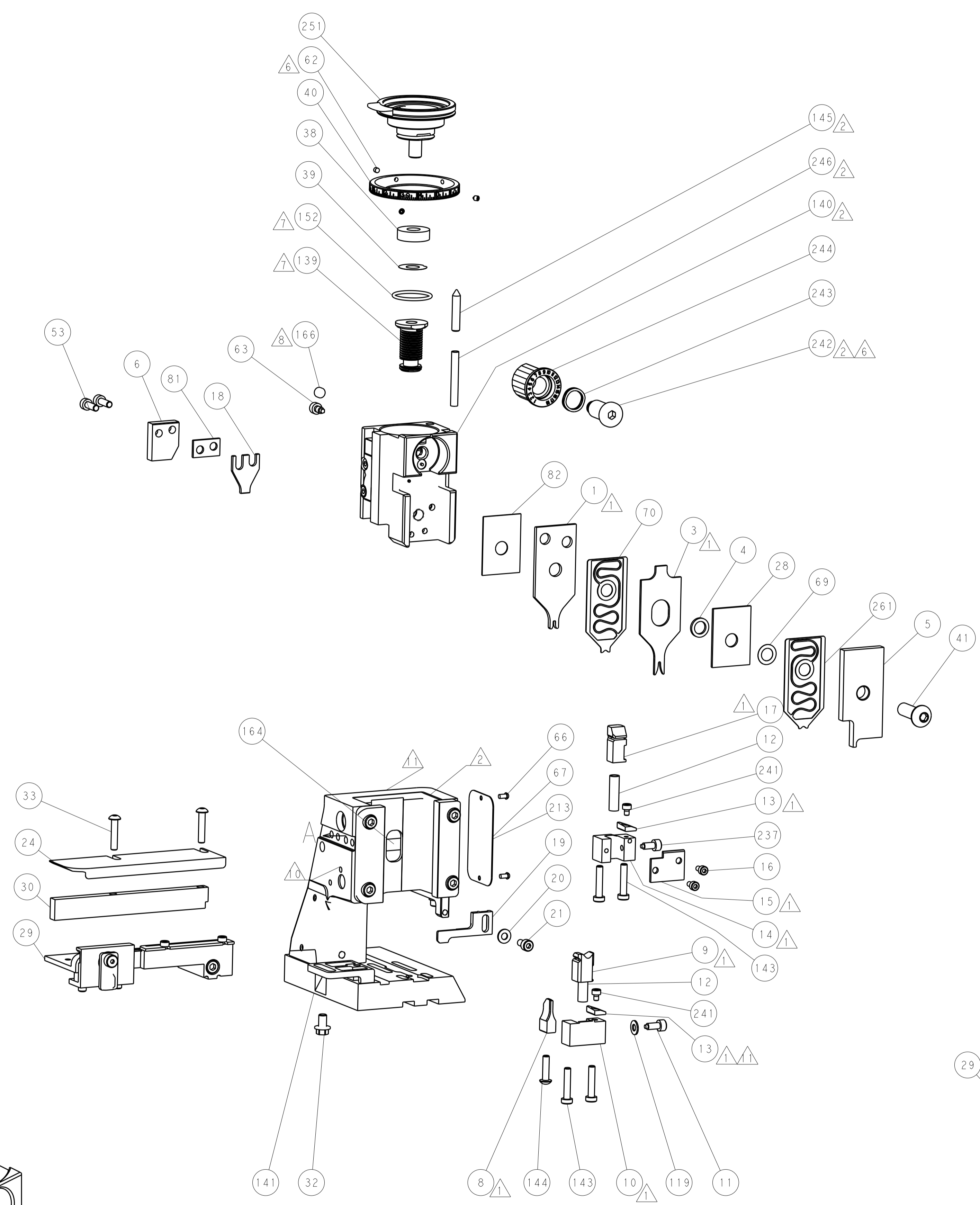
# PNEUMATIC



# SERVO LATCH PLATE



# CAM POSITIONS



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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS TO BE USED ONLY FOR THE PURPOSES AND APPLICATIONS SPECIFIED HEREIN. IT IS SUBJECT TO CHANGE AND WITHOUT WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE. CONTACT TYCO ELECTRONICS CORPORATION FOR THE LATEST REVISION.</small>		DWN: C. CHEN 28MAY2013 CHK: U. GUO 28MAY2013 APVD: J. CRUZ 28MAY2013	NAME: TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1		PRODUCT SPEC: APPLICATION SPEC: WEIGHT: A11 00779 SCALE: 1:2	OCEAN SIDE FEED APPLICATOR SIZE: CAGE CODE DRAWING NO: 2151969 SHEET 4 OF 4 REV B
MATERIAL: FINISH:		RESTRICTED TO:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING