

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE         | CONVERT TO        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|---|-------------|--------------------------|--------------------------|-------------------|-------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|   | 2151439-1   | A                        | FINE CRIMP HEIGHT ADJUST | MECHANICAL        | PNEUMATIC FEED    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-1 | 2119799-1 | 2063440-1              |
|   | 2151439-2   | A                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | SERVO LATCH PLATE | 2119951-1             | -         | 8-2151439-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                   | SMART APPLICATOR  | 2161326-1             | -         | 8-2151439-4 | -         | -         |                        |
|   |             |                          |                          |                   | MECHANICAL FEED   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-1 | -         | -                      |
|   | 2151439-5   | A                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | SERVO LATCH PLATE | 2119951-1             | -         | 8-2151439-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|   |             |                          |                          |                   | SMART APPLICATOR  | 2161326-1             | -         | 8-2151439-4 | -         | -         |                        |
|   | 2151439-6   | A                        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE | MECHANICAL FEED   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-1 | -         | -                      |
| 2151439-7                                     | A           | FINE CRIMP HEIGHT ADJUST | NONE                     | -                 | -                 | -                     | -         | -           | -         | -         |                        |
| 7-2151439-7                                   | A           | CRIMP TOOLING KIT        | -                        | -                 | -                 | -                     | -         | -           | -         | -         |                        |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 1.78 mm [.070] | F    |
| INSUL           | -              | -    |

APPLICATOR INSTRUCTIONS  
408-10389

| TERMINAL DATA: TE TERMINAL                       | TE CRIMP SPECIFICATION                                    |
|--|---|
| TERMINAL NAME: MOTOR TERMINAL 2                  |   |
| WIRE STRIP LENGTH<br>2.75-3.25 mm [.108-.128 IN] | INSULATION DIAMETER RANGE<br>Ø1.50-2.50 mm [.059-.098 IN] |
| TERMINAL APPLICATION SPECIFICATION<br>114-17006  |   |
| TERMINALS APPLIED                                |   |
| TE TERMINAL                                      | TE TERMINAL   |
| 279328-1   |   |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 0.50mm2   | 1.12 +/- 0.05 [.044 +/- .002] | 5.9                            |
| 0.40mm2   | 1.07 +/- 0.05 [.042 +/- .002] | 6.3                            |
| 0.30mm2   | 1.02 +/- 0.05 [.040 +/- .002] | 6.9                            |
| 0.20mm2   | 0.97 +/- 0.05 [.038 +/- .002] | 7.4                            |

- 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: 8-2151439-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151439-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151439-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151439-6
- 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 FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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 -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.

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

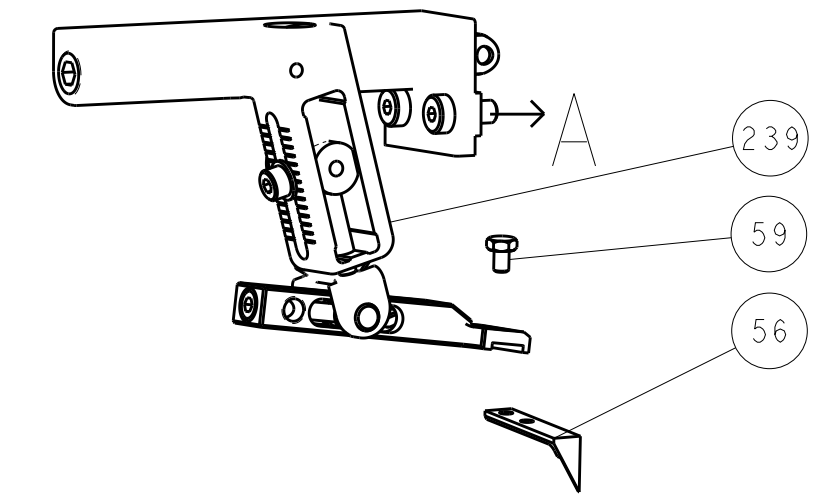
| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |           |     |      |
|--------------|-----|------|-----------|-----|-------------|-----------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION | DATE      | OWN | APVD |
|              |     |      | A         |     | RELEASED    | 07JAN2014 | KH  | UG   |

|     |     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | -   | 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     |
| -   | -   | 1   | -   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245     |
| -   | 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     |
| -   | -   | -   | -   | 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   | 1338685-3   | PAWL, FEED                          | 56      |
| -   | 2   | 2   | 2   | 2   | 2   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54      |
| -   | 2   | 2   | 2   | 2   | 2   | 2168083-5   | SCR, SKT HD CAP, RoHS, M4 X 6.0     | 53      |
| -   | -   | -   | -   | 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      |
| -   | 2   | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33      |
| -   | 1   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32      |
| -   | 1   | 1   | 1   | 1   | 1   | 1320908-6   | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 1   | 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      |
| -   | 3   | 3   | 3   | 3   | 3   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
| -   | 1   | 1   | 1   | 1   | 1   | 2119533-3   | STRIPPER, SIDE FEED                 | 19      |
| -   | 1   | 1   | 1   | 1   | 1   | 3-690518-9  | HOLD DOWN, TERMINAL                 | 18      |
| -   | 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   | 1633861-4   | SHEAR, FLOATING                     | 9       |
| -   | 1   | 1   | 1   | 1   | 1   | 7-1633139-4 | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 1   | 2119757-8   | DEPRESSOR, SHEAR                    | 5       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 4       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 3       |
| -   | -   | -   | -   | -   | -   | -           | -                                   | 2       |
| -   | 1   | 1   | 1   | 1   | 1   | 3-456404-2  | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -7  | -6  | -5  | -2  | -1  | PART NO     | DESCRIPTION                         | ITEM NO |

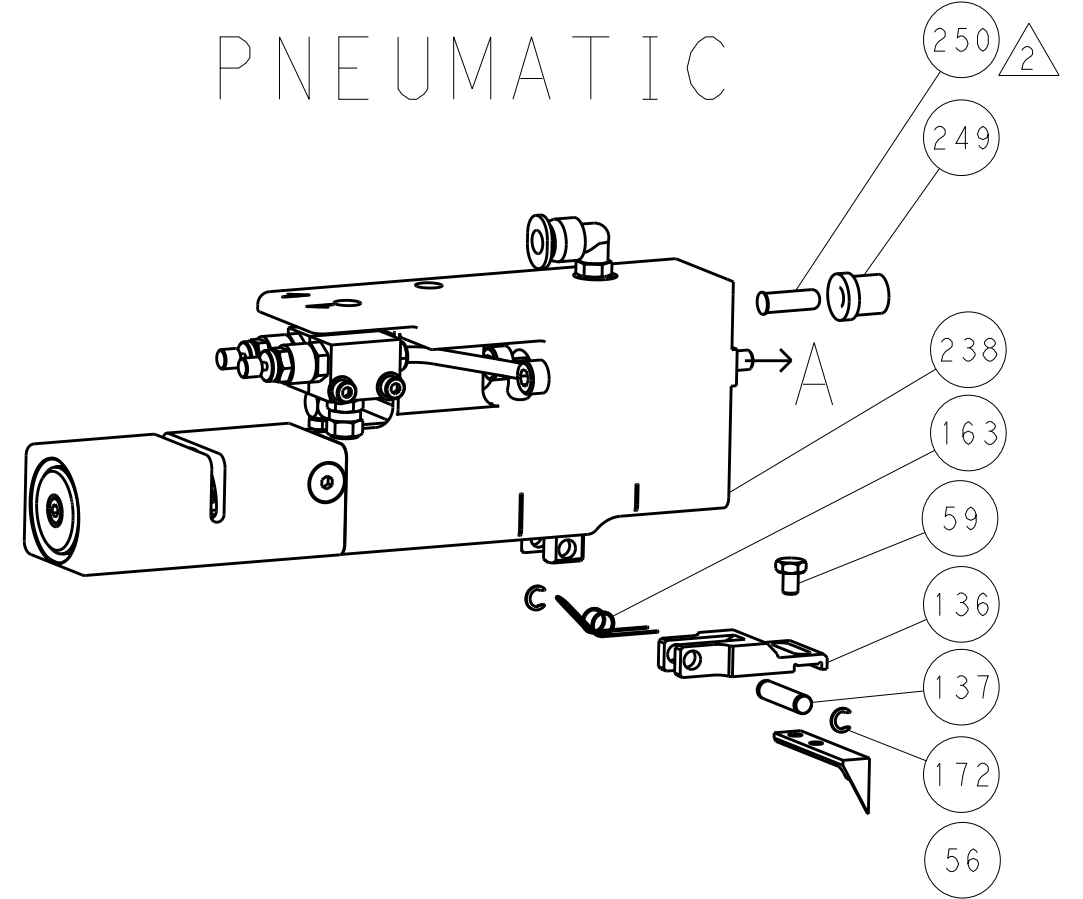
| DIMENSIONS:                            |             | TOLERANCES UNLESS OTHERWISE SPECIFIED: |               | OWN      | CHK     | DATE      | TE Connectivity            |            |     |
|--|-------------|--|---------------|----------|---------|-----------|----------------------------|------------|-----|
| mm                                     | 0 PLC ±.5   | 1 PLC ±.5                              | 2 PLC ±.13    | H. HUANG | S. XI   | 14DEC2011 | Harrisburg, PA 17105-3608  |            |     |
|  | 3 PLC ±.013 | 4 PLC ±.0001                           | ANGLES ±.0001 | APVD     | I. CRUZ | 14DEC2011 | NAME                       |            |     |
|  |             |  |               |          |         |           | Ocean Side Feed Applicator |            |     |
| MATERIAL                               |             | FINISH                                 |               | WEIGHT   |         | SIZE      | CAGE CODE                  | DRAWING NO |     |
|  |             |  |               |          |         | A1        | 00779                      | ©=2151439  |     |
| Customer Accessible Production Drawing |             |  |               |          |         |           | SCALE                      | SHEET      | REV |
|  |             |  |               |          |         |           | 1:2                        | 1 OF 4     | A   |

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

### FEED TYPE MECHANICAL



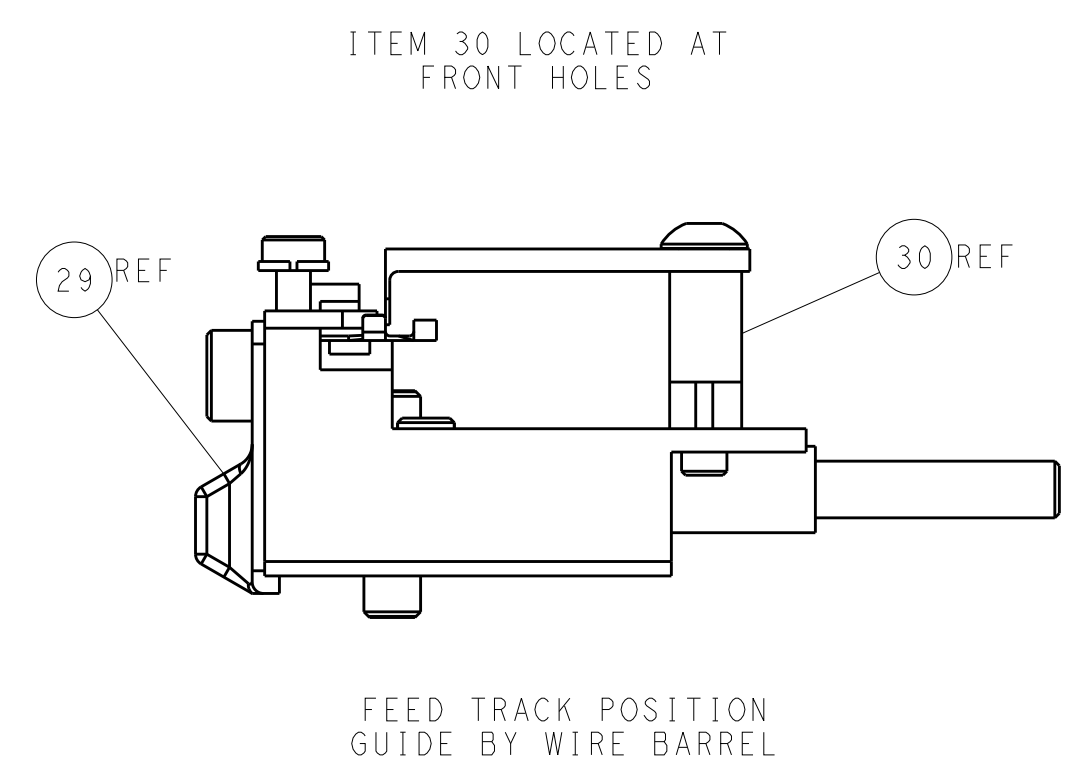
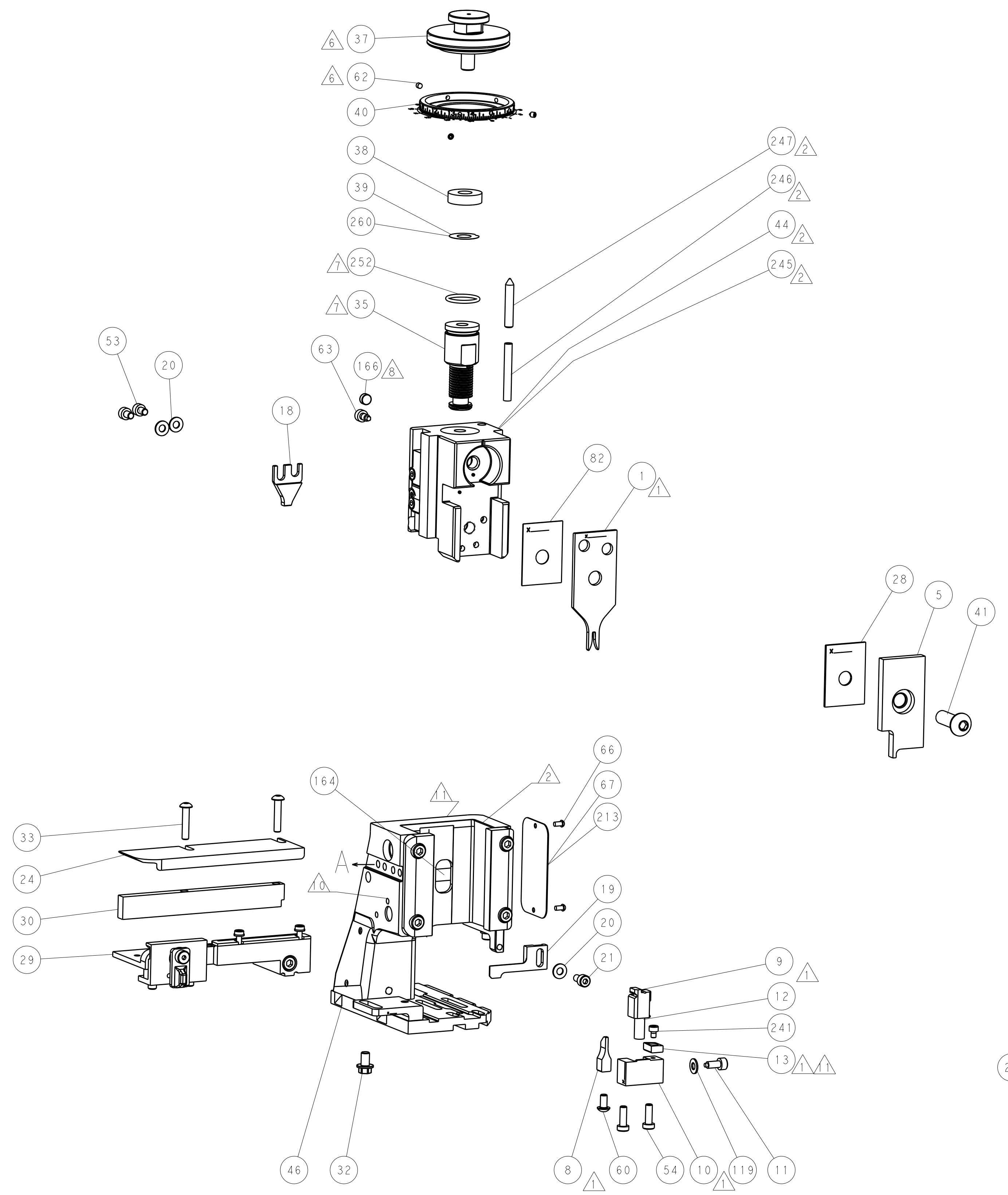
### PNEUMATIC



### 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: R. HUANG 14DEC2011          |               | TE Connectivity       |                           |
| mm          | 0 PLC ±0.5 | 1 PLC ±0.5                             | 2 PLC ±0.13 | 3 PLC ±0.013                     | 4 PLC ±0.0013 | APVD: S. XI 14DEC2011 | Harrisburg, PA 17105-3608 |
| MATERIAL:   |            | FINISH:                                |             | NAME: Ocean Side Feed Applicator |               | RESTRICTED TO:        |                           |
|             |            |  |             | SIZE: A1                         |               | CAGE CODE: 00779      |                           |
|             |            |  |             | DRAWING NO: 2151439              |               | SCALE: 1:2            |                           |
|             |            |  |             | SHEET: 2 of 4                    |               | REV: A                |                           |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|  |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|  | 2-2151439-1 | A        | 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             | -         | 8-2151439-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151439-4 | -         | -         | -                      |
|  | 2-2151439-2 | A        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151439-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                                | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151439-4 | -         | -         | -                      |
|  | 2-2151439-5 | A        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|  |             |          |                          |                                | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|  | 2-2151439-7 | A        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | -         | -                      |
|  | 7-2151439-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA                      |                  |      |
|--------------------------------------|------------------|------|
| CRIMP                                | SIZE             | TYPE |
| WIRE                                 | 1.78 mm [ .070 ] | F    |
| INSUL                                | -                | -    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                  |      |

| TERMINAL DATA: TE TERMINAL                         |             | TE CRIMP SPECIFICATION                                      |
|--|-------------|---|
| TERMINAL NAME: MOTOR TERMINAL 2                    |             |   |
| WIRE STRIP LENGTH<br>2.75-3.25 mm [ .108-.128 IN ] |             | INSULATION DIAMETER RANGE<br>Ø1.50-2.50 mm [ .059-.098 IN ] |
| TERMINAL APPLICATION SPECIFICATION<br>114-17006    | -           | -   |
| TERMINALS APPLIED                                  |             |   |
| TE TERMINAL  | TE TERMINAL | TE TERMINAL   |
| 279328-1   |             |   |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]          | CRIMP HEIGHT REFERENCE SETTING |
|-----------|---------------------------------|--------------------------------|
| 0.50mm2   | 1.12 +/- 0.05 [ .044 +/- .002 ] | 5.9                            |
| 0.40mm2   | 1.07 +/- 0.05 [ .042 +/- .002 ] | 6.3                            |
| 0.30mm2   | 1.02 +/- 0.05 [ .040 +/- .002 ] | 6.9                            |
| 0.20mm2   | 0.97 +/- 0.05 [ .038 +/- .002 ] | 7.4                            |

- 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: 8-2151439-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151439-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151439-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET 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 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.

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

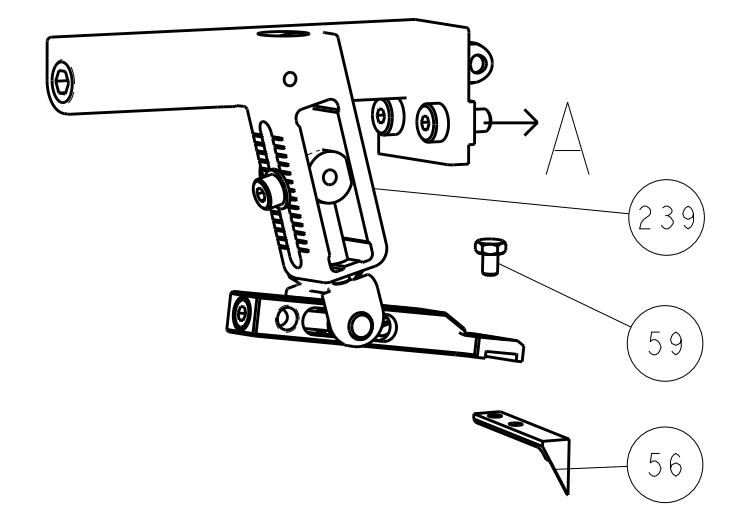
| SET UP GAUGE | LOC | DIST | REVISIONS |             |    |      |
|--------------|-----|------|-----------|-------------|----|------|
| 2119599-1    | A   | 66   | REV       | DATE        | BY | APPV |
|              |     |      | -         | SEE SHEET 1 | -  | -    |

|   |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 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   | 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 |
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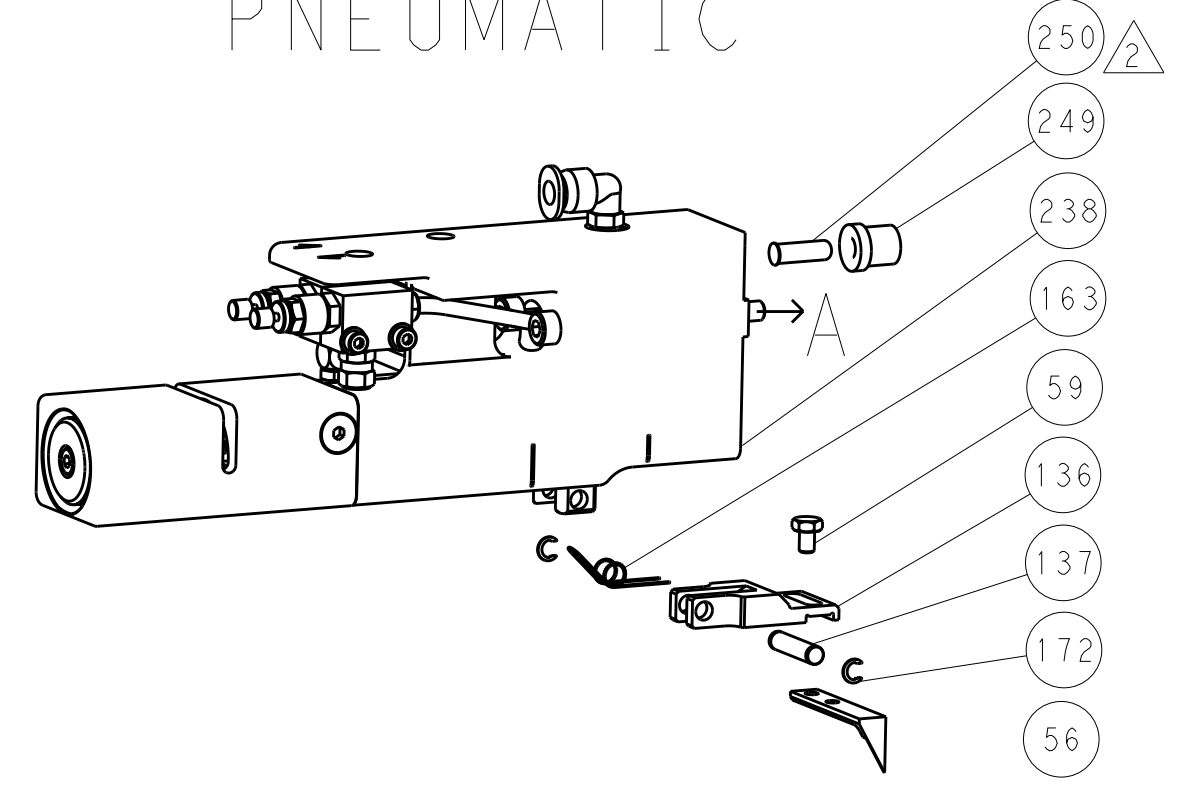
| DIMENSIONS: |              | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | CHK                                    | DATE      | NAME    |       |
|-------------|--------------|--|-------------|--|-----------|---------|-------|
| mm          | 0 PLC ±.5    | 1 PLC ±0.5                             | 2 PLC ±0.13 | H. HUANG                               | 14DEC2011 | S. XI   |       |
|             | 3 PLC ±0.013 | 4 PLC ±0.001                           | ANGLES ±.1  | I. CRUZ                                | 14DEC2011 | I. CRUZ |       |
| MATERIAL    | FINISH       | WEIGHT                                 | SCALE       | Customer Accessible Production Drawing |           | 3       | REV A |

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

# FEED TYPE MECHANICAL



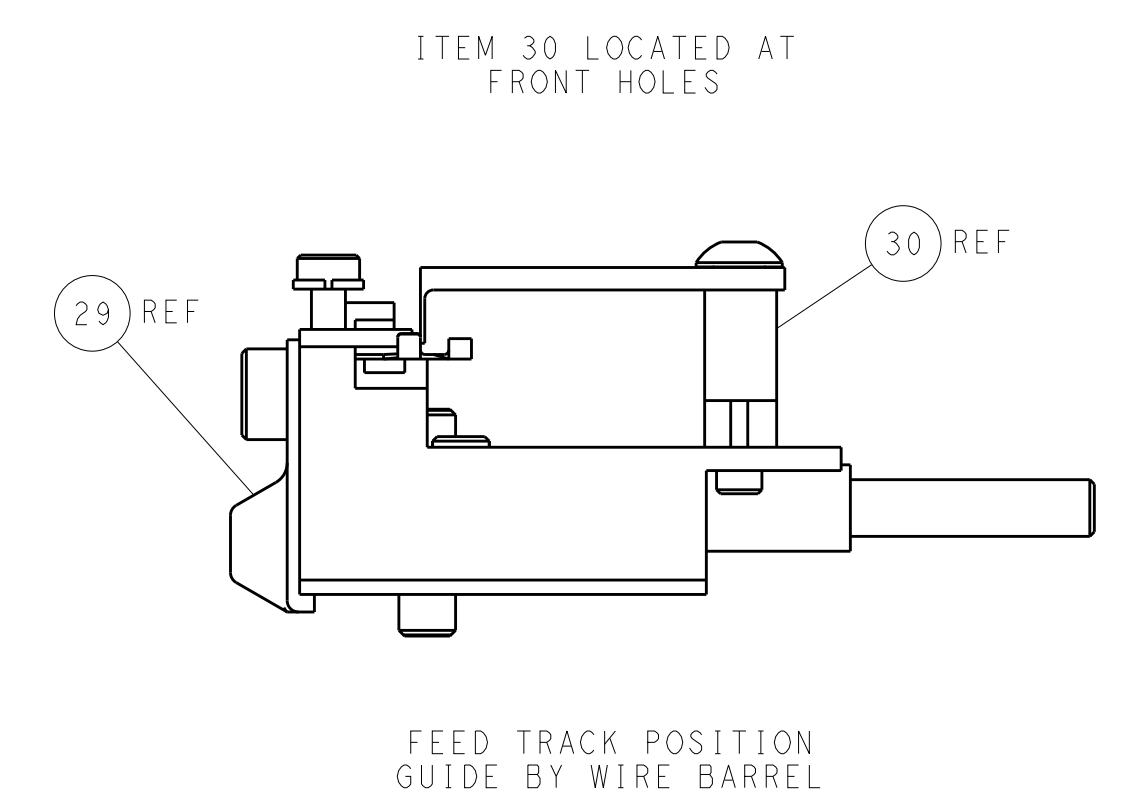
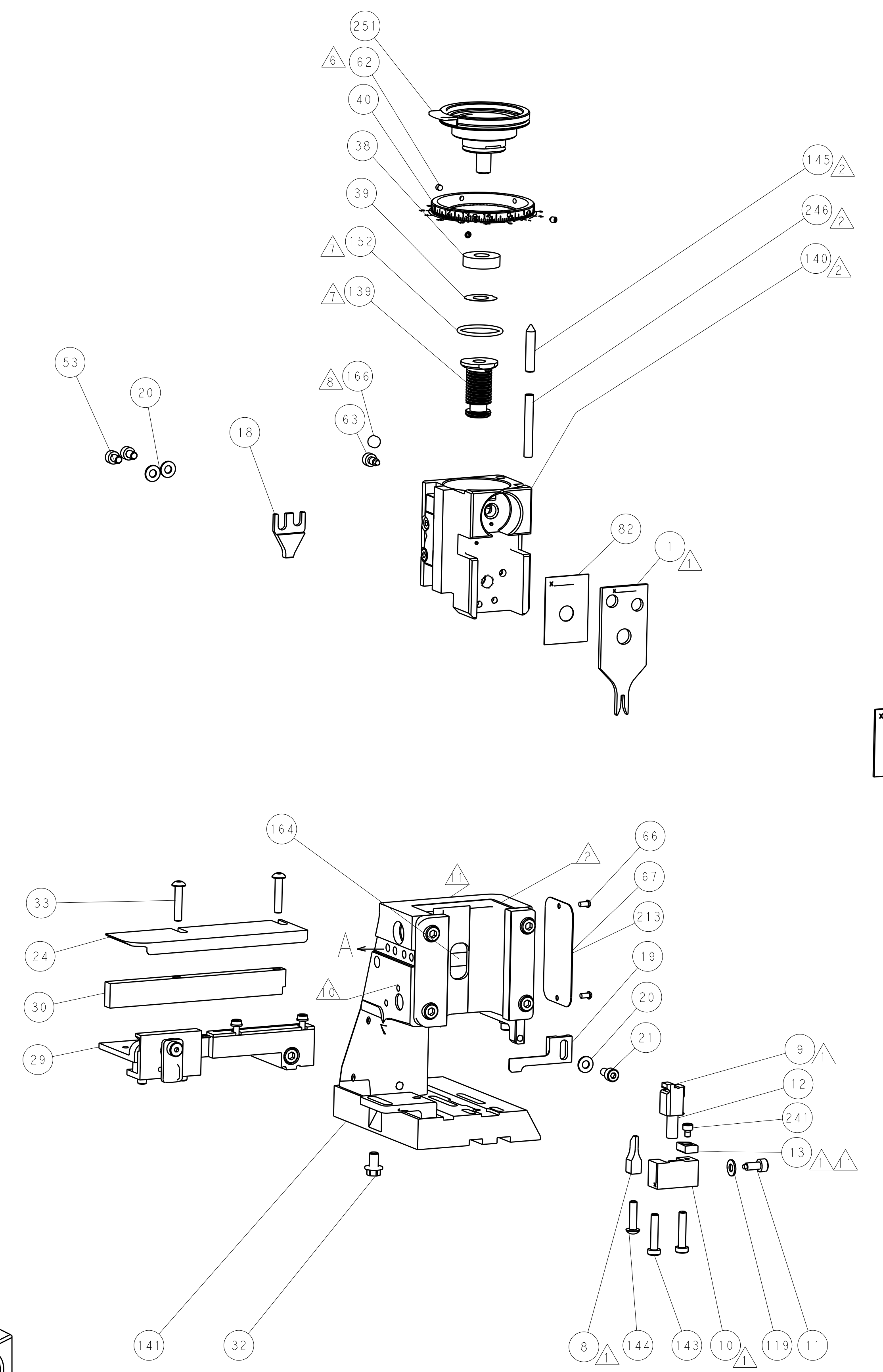
# PNEUMATIC



# 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)

|  |              |  |             |                       |           |  |
|--|--------------|--|-------------|-----------------------|-----------|--|
| DIMENSIONS:                            |              | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | DWN                   | 14DEC2011 | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| mm                                     | 0 PLC ±.5    | 1 PLC ±0.5                             | 2 PLC ±0.13 | CHK                   | 14DEC2011 |  |
|  | 3 PLC ±0.013 | 4 PLC ±0.001                           | ANGLES ±.1  | APVD                  | 14DEC2011 | NAME   |
| MATERIAL                               | FINISH       | WEIGHT                                 | SCALE       | A   00779   ©=2151439 |           | RESTRICTED TO                                |
| Customer Accessible Production Drawing |              |  | SCALE 1:2   | SHEET 4 OF 4          |           | REV A  |