

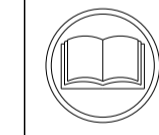
APPLICATOR STYLE CONVERSION CHART. Table with columns: CONVERT TO, PART NUMBERS REQUIRED. Includes rows for PNEUMATIC FEED, SERVO LATCH PLATE, SMART APPLICATOR, MECHANICAL FEED, and PNEUMATIC FEED with various part numbers like 2119950-1, 1338685-1, etc.

APPLICATOR DATA. Table with columns: CRIMP SIZE, WIRE, INSUL. Includes values like 1.40 mm [0.055], 2.90 mm [0.114].

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

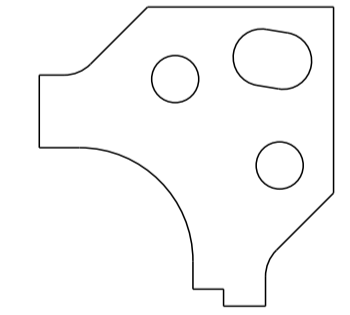
TERMINALS APPLIED. Table with columns: TE TERMINAL, TE SEAL, CABLE DIAMETER. Lists various terminal and seal combinations with their corresponding cable diameters.

WIRE SIZE, CRIMP HEIGHT, CRIMP HEIGHT REFERENCE SETTING. Table mapping wire sizes (0.50mm to 0.20mm) to crimp heights and reference settings.



- 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...
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 ITEM 62...
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...
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...
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

- 13. THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
14. APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION...
15. POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1, FOR ALL TERMINALS LISTED IN THE 'TERMINAL APPLIED' TABLE...
NOTE ORIENTATION 2 OF ITEM 18 IS NOT TO BE USE FOR THIS APPLICATION.



\*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)

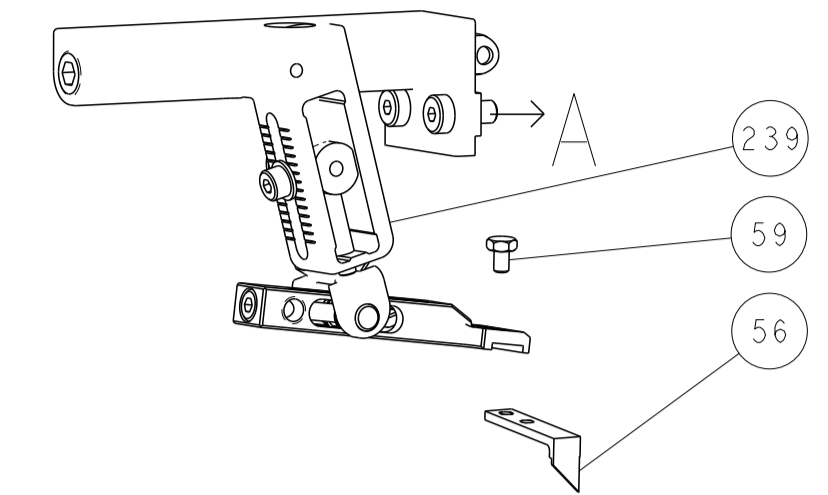
SET UP GAUGE 2119599-1. Table with columns: P, LTM, DESCRIPTION, DATE, DWN, APVD. Includes row for ECR-16-004882.

Large table listing various components and their quantities. Columns include part numbers, descriptions, and quantities. Includes items like APPLICATOR SHIM PACK, O-RING, PUSH ROD, BUSHING, FEED CAM, SPRING, etc.

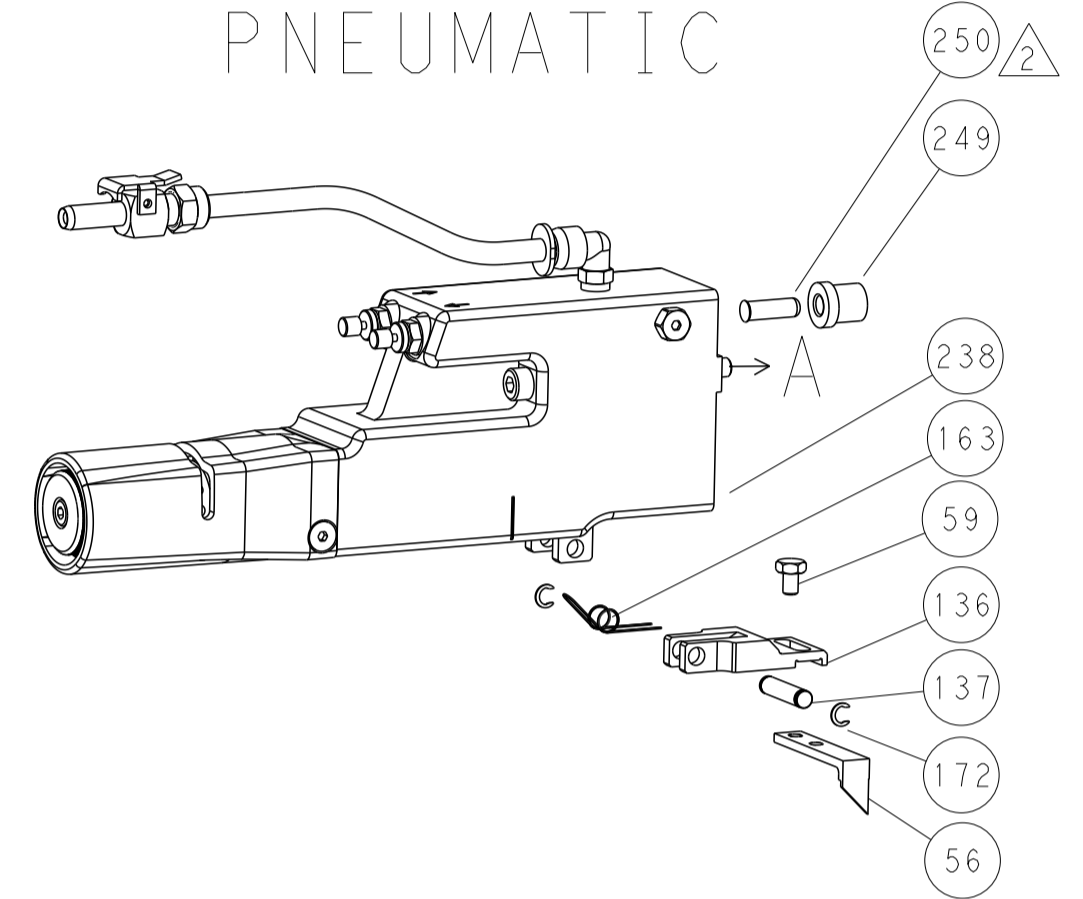
Technical drawing header and footer. Includes dimensions, tolerances, material, weight, and customer accessible production drawing information.

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

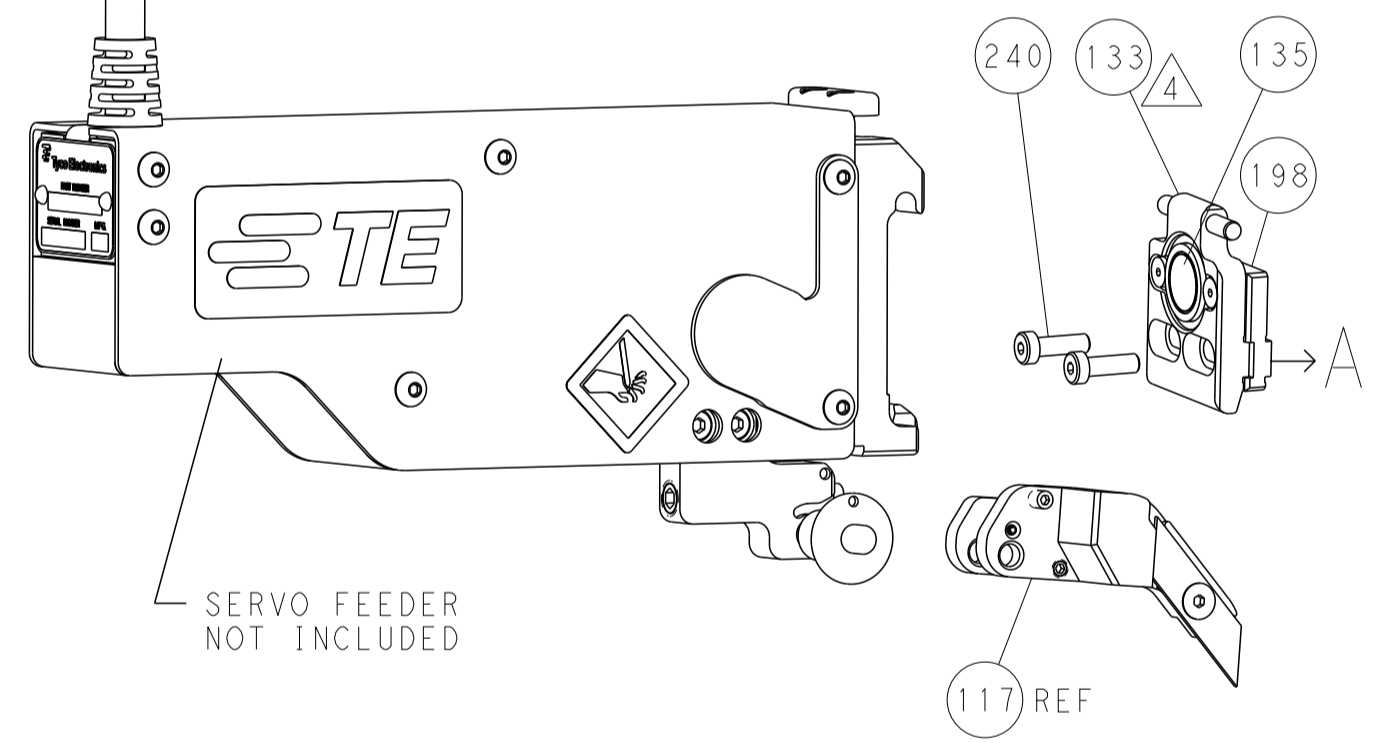
### FEED TYPE MECHANICAL



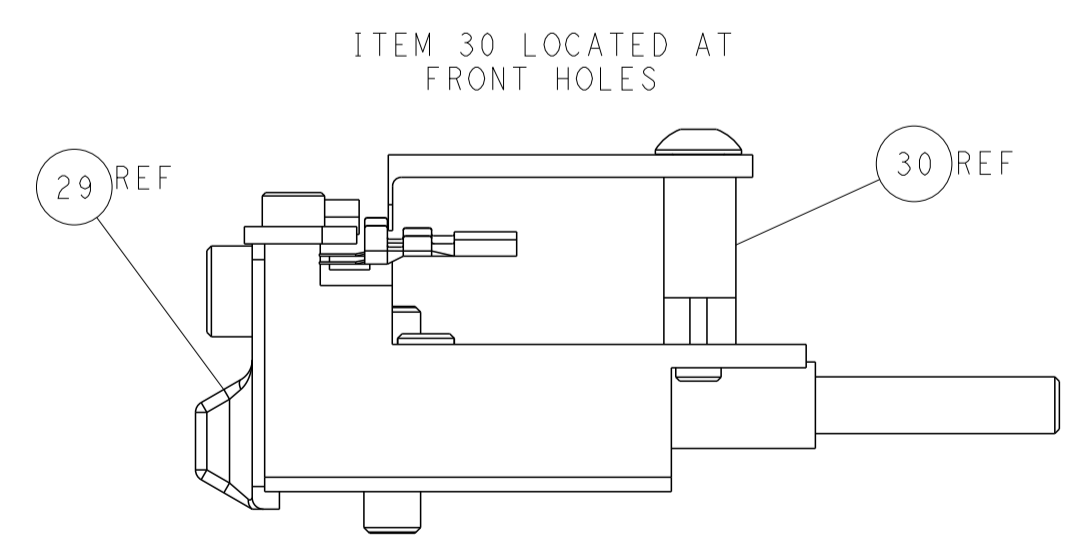
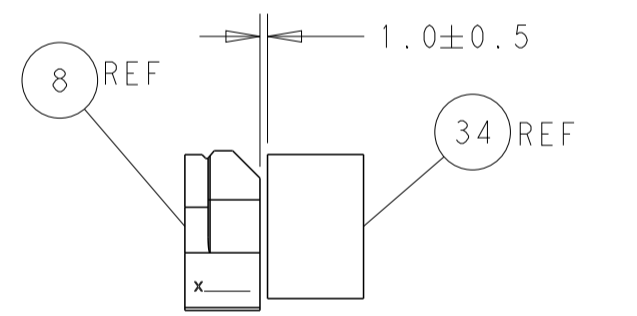
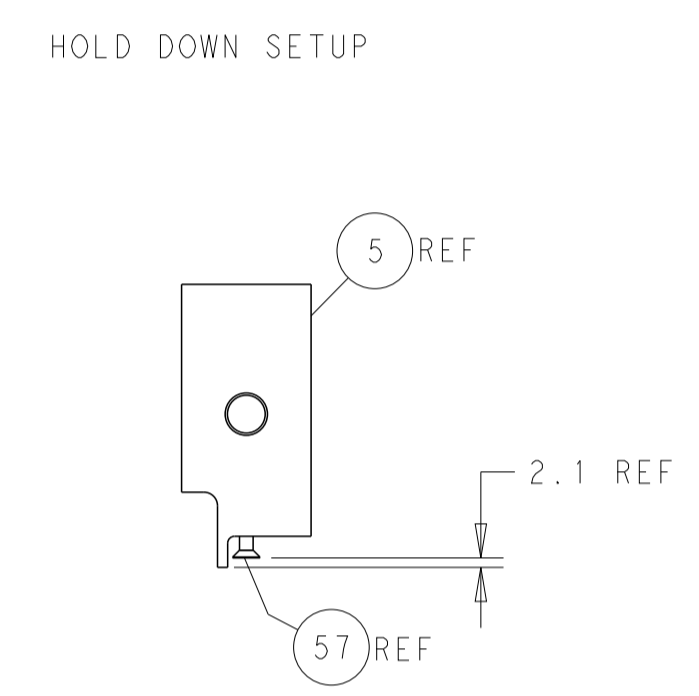
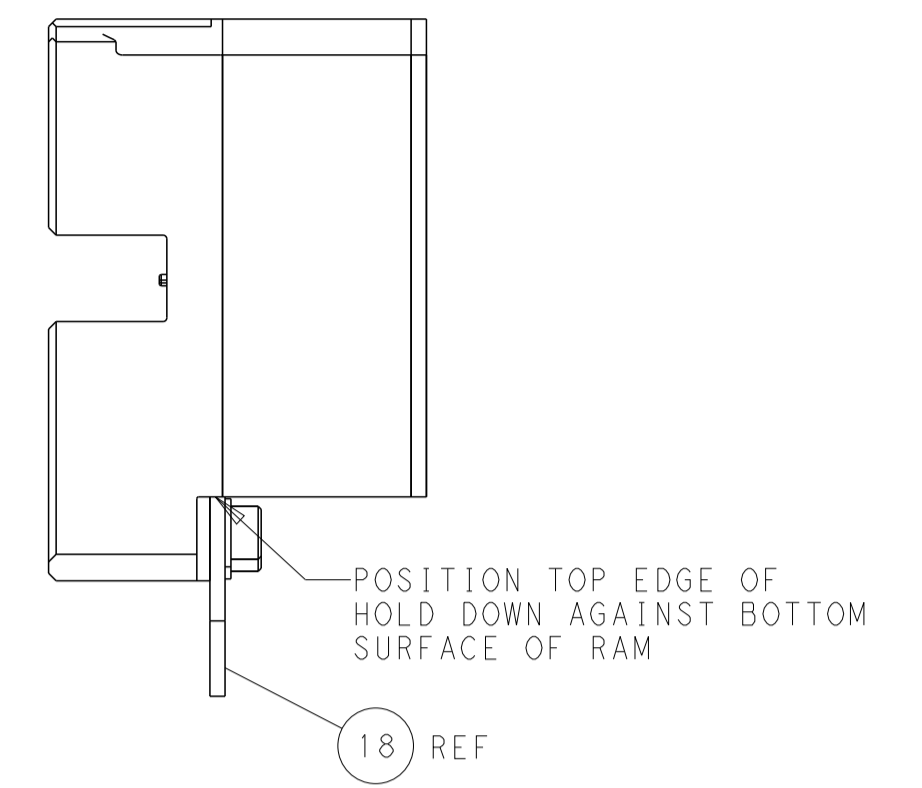
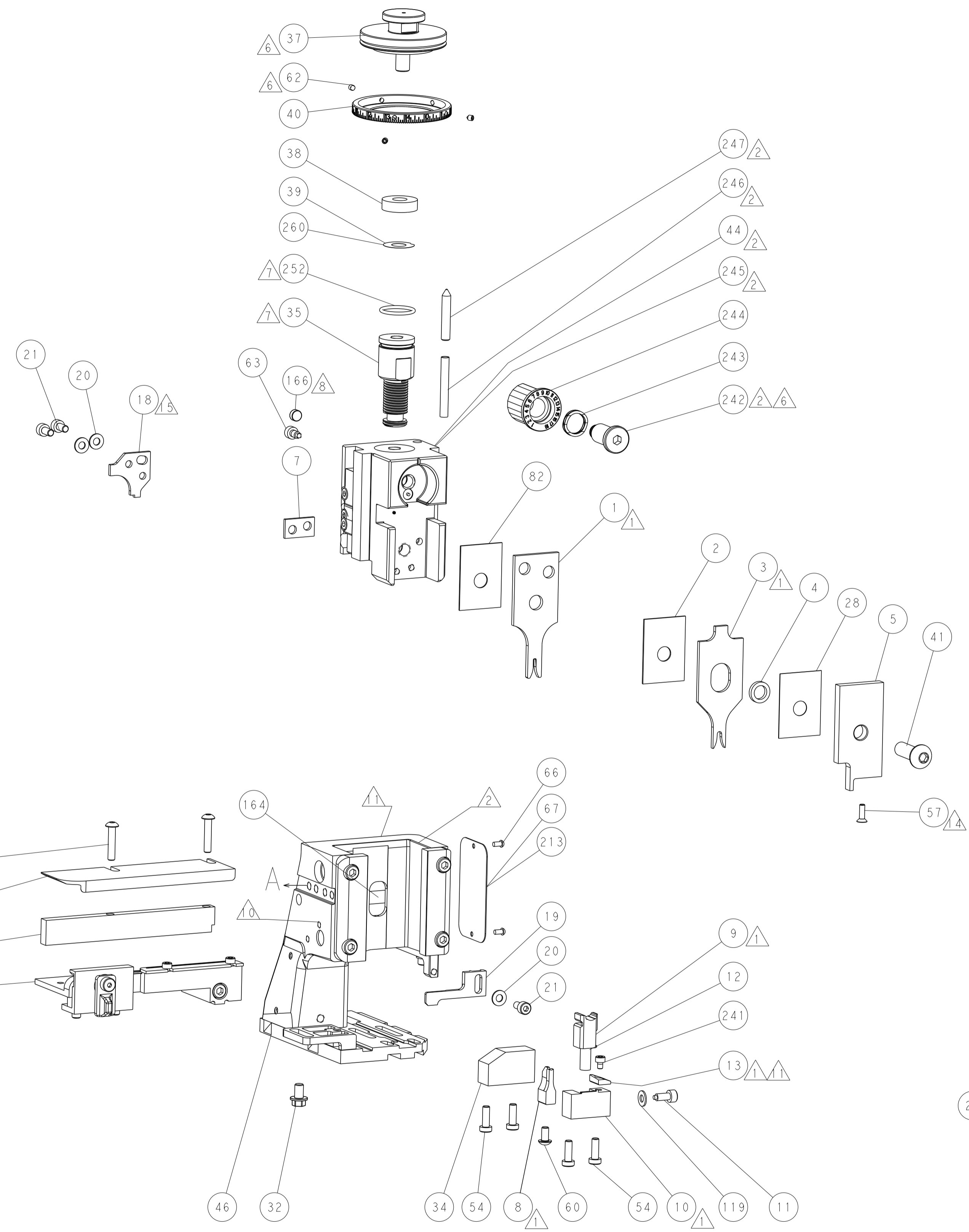
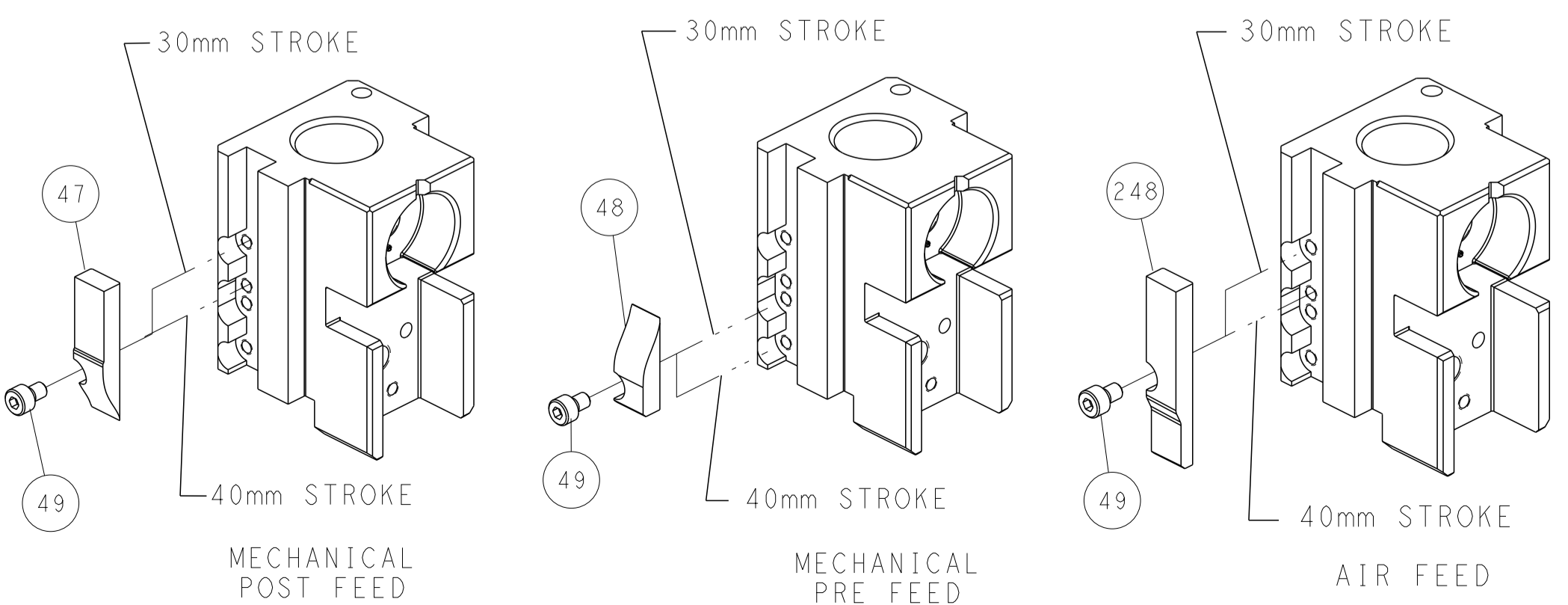
### PNEUMATIC



### 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: STAKEM 06OCT2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: G. BAILEY 06OCT2011		NAME: Ocean Side Feed Applicator	
				APVD: T. ELBIN 06OCT2011		SIZE: CAGE CODE: DRAWING NO: A1 00779 ©=2151104	
				PRODUCT SPEC:		RESTRICTED TO:	
				APPLICATION SPEC:		SCALE: 1:2 SHEET 2 OF 4 REV F1	
				WEIGHT:		CUSTOMER ACCESSIBLE PRODUCTION DRAWING	

Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Includes a diagram of the applicator head.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Includes APPLICATOR INSTRUCTIONS: 408-10389.

Terminal data and crimp specification table. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED table.

Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

- 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...

- 12 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
13 APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
14 POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1. FOR ALL TERMINALS LISTED IN THE 'TERMINAL APPLIED' TABLE...

\*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)

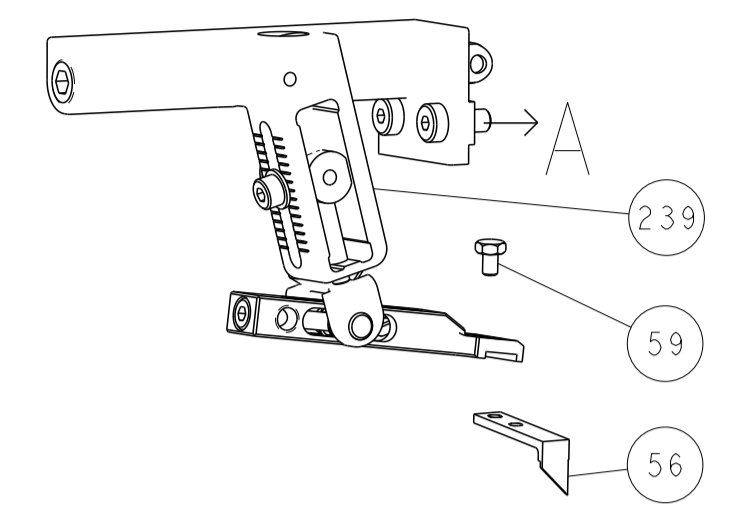
Table with columns: REVISIONS, P, LTM, DESCRIPTION, DATE, DWN, APVD. Includes SET UP GAUGE 2119599-1.

Main parts list table with columns: P, LTM, DESCRIPTION, DATE, DWN, APVD. Lists various components like FINE ADJUST HEAD ASM, PUSH ROD, BUSHING, SPRING, etc.

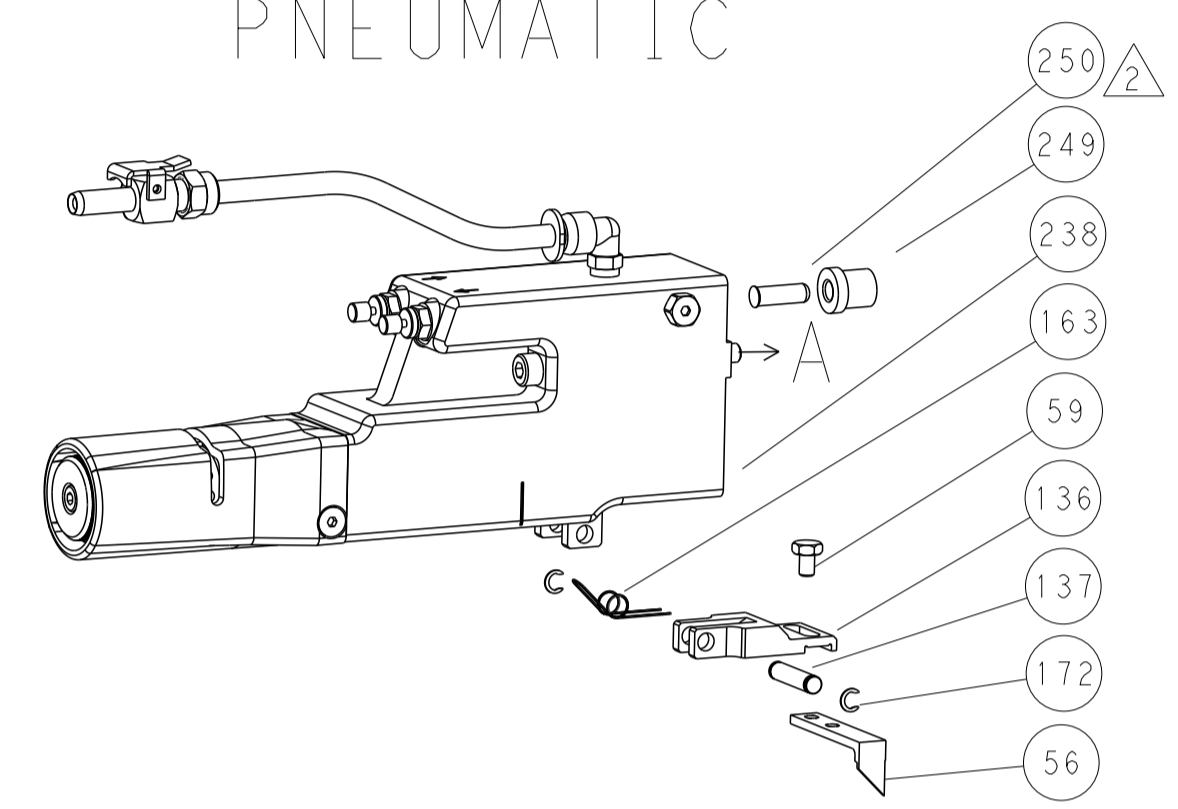
Technical drawing information table including DIMENSIONS, TOLERANCES, MATERIAL, FINISH, WEIGHT, SCALE, SHEET, REV.

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

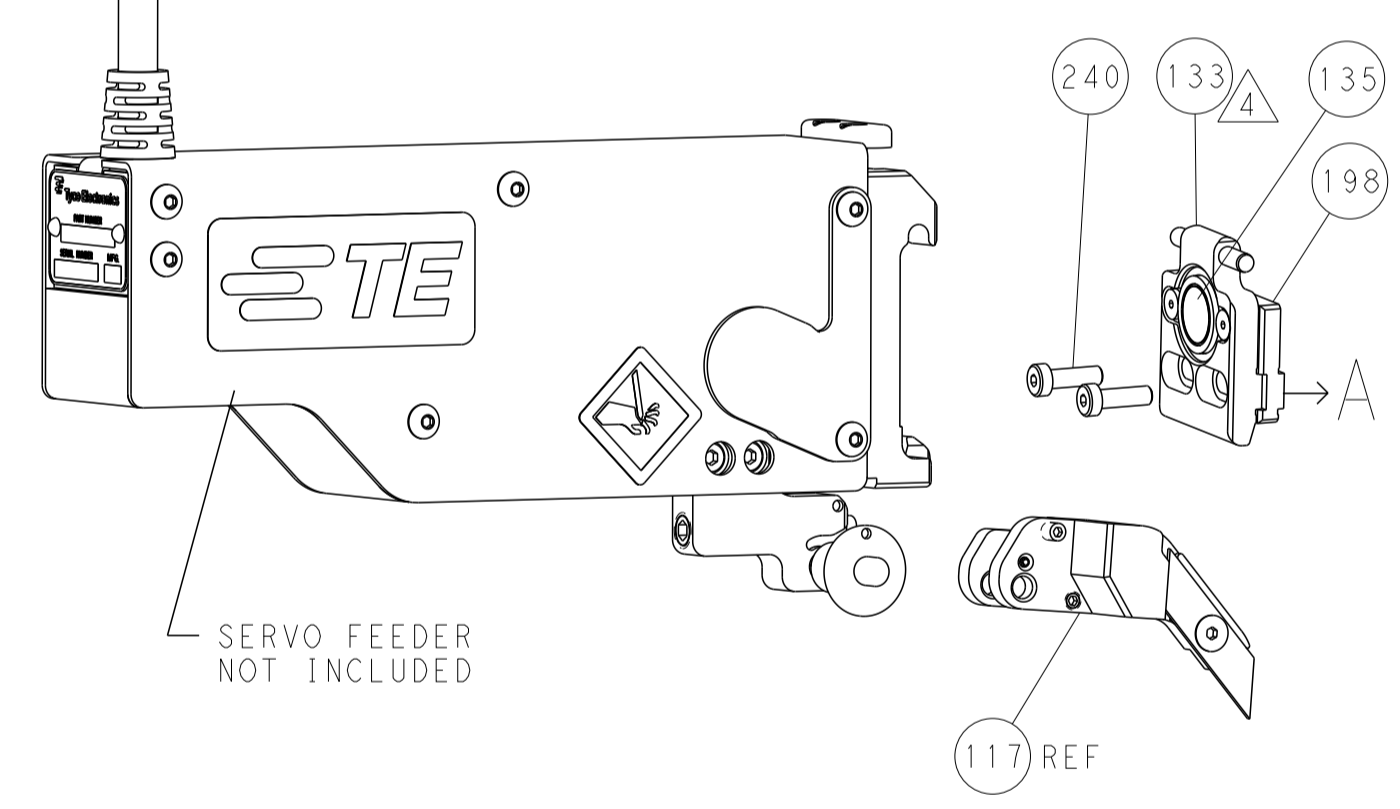
# FEED TYPE MECHANICAL



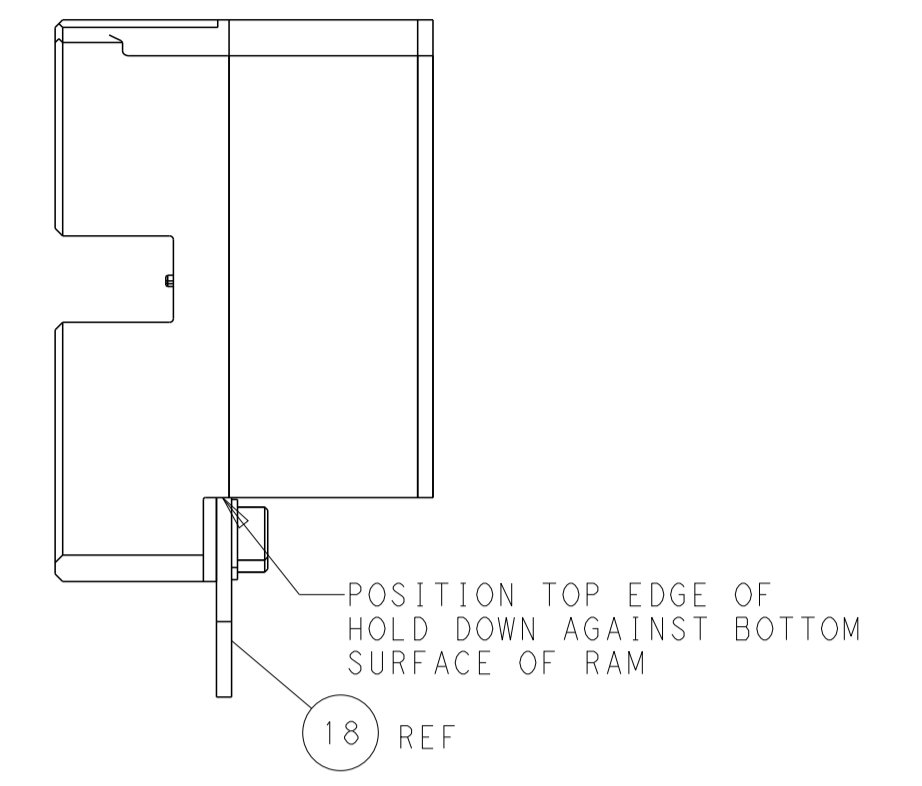
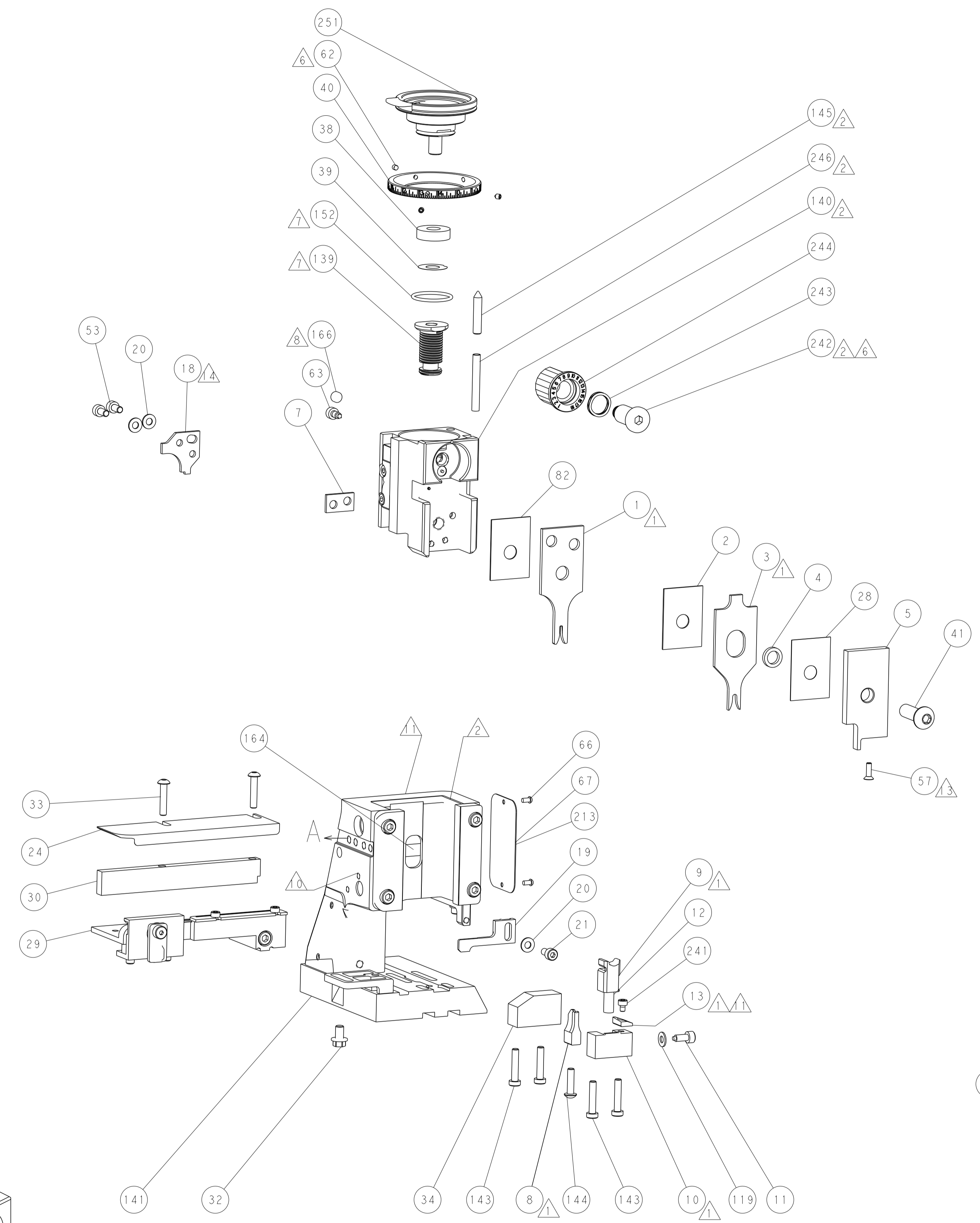
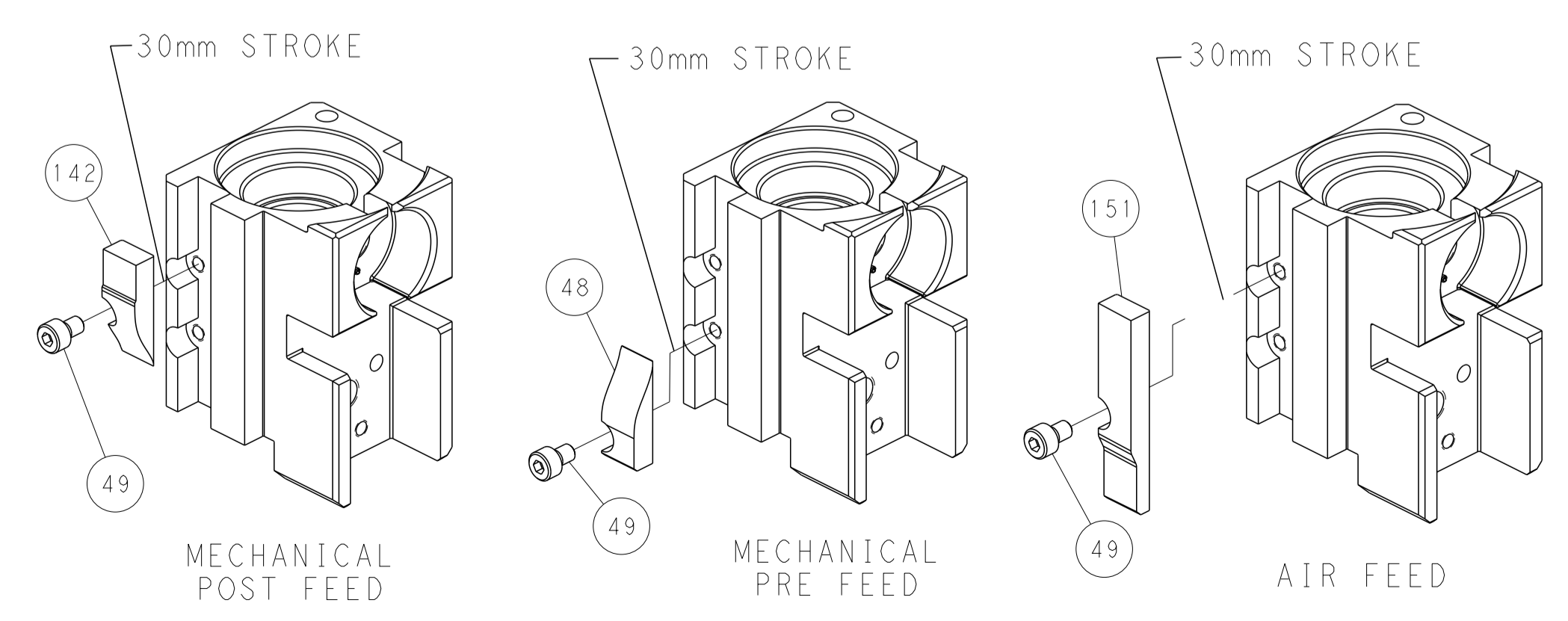
# PNEUMATIC



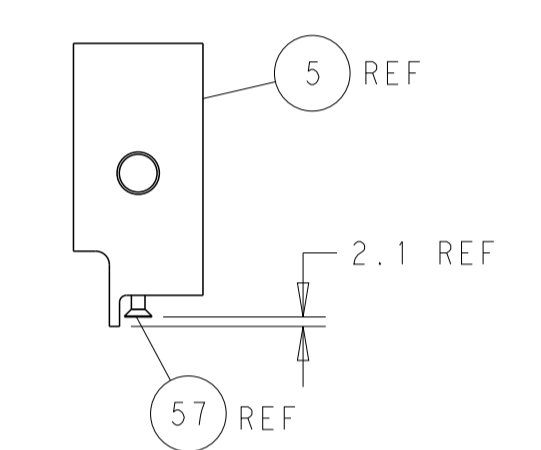
# SERVO LATCH PLATE



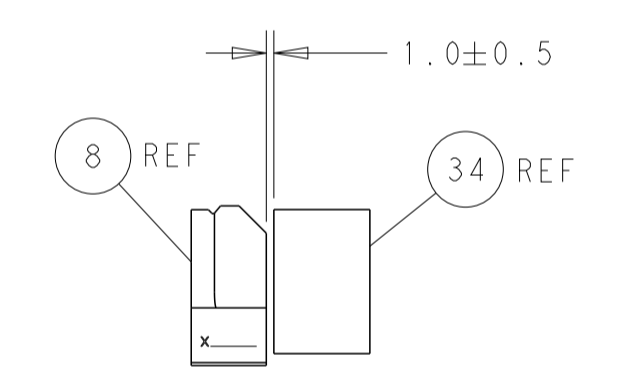
# CAM POSITIONS



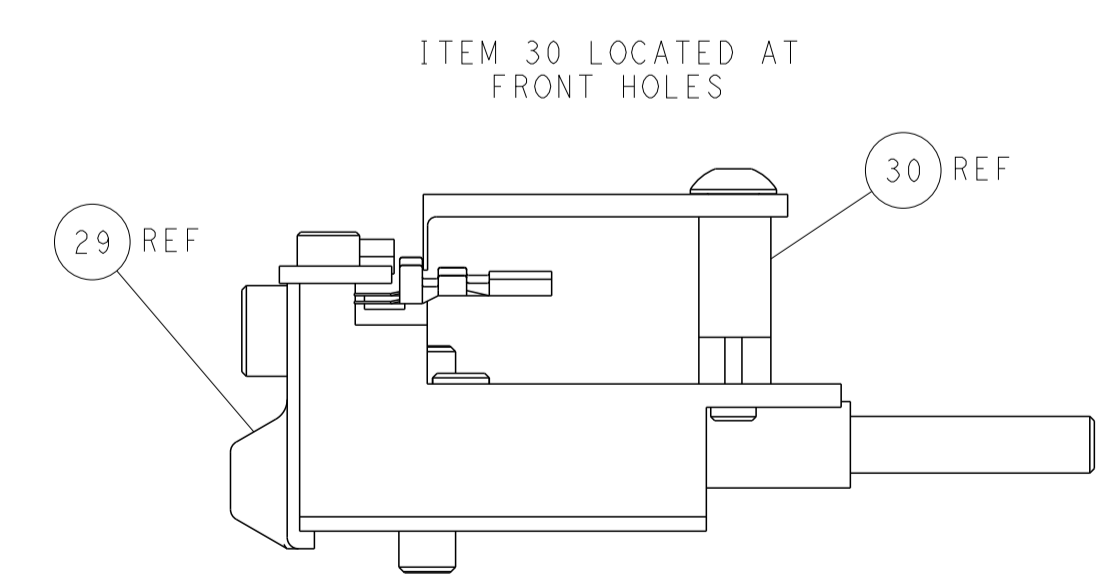
HOLD DOWN SETUP



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



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)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE QUANTITIES SPECIFIED BY THE PURCHASING ORGANIZATION. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION IF NOT SO USED.</small>		DWN: R. STAKEM 06OCT2011 CHK: G. BAILEY 06OCT2011 APVD: T. ELBIN 06OCT2011	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH ±		NAME: Ocean Side Feed Applicator APPLICATION SPEC:	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151104 RESTRICTED TO:
MATERIAL:		WEIGHT:	CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE: 1:2 SHEET: 4 OF 4 REV: 1