

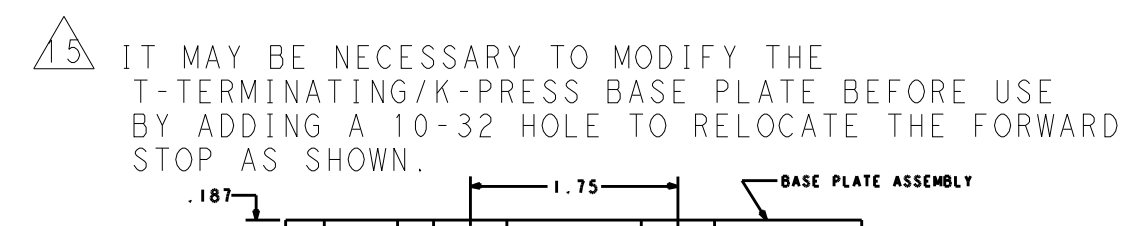
| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |             |           |           |                        |
|---|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-------------|-----------|-----------|------------------------|
|   |             |          |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |             |           |           |                        |
|   | 2151029-2   | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | -                                 | -                     | -           | -         | -         | -                      |
|   | 2151029-5   | B        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 2119951-1                         | 2161540-1             | 8-2151029-5 | 1901094-3 | 1976043-1 | 2168400-6 (QUANTITY 2) |
|   | 2151029-6   | B        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE | 2161326-1                         | -                     | -           | -         | -         | -                      |
|   | 2151029-7   | B        | FINE CRIMP HEIGHT ADJUST | NONE              | -                                 | -                     | -           | -         | -         | -                      |
|   | 7-2151029-7 | A        | CRIMP TOOLING KIT        | -                 | -                                 | -                     | -           | -         | -         | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP WIRE                           | SIZE           | TYPE |
|                                      | .278 [7.06 mm] | D    |
| INSUL                                | -              | -    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

| TERMINAL DATA: TE TERMINAL            |             | TE CRIMP SPECIFICATION    |             |
|---------------------------------------|-------------|---------------------------|-------------|
| TERMINAL NAME: FULLY INSULATED FASTON |             |                           |             |
| WIRE STRIP LENGTH                     |             | INSULATION DIAMETER RANGE |             |
| .296-.328 IN [7.52-8.33 mm]           |             | Ø .320 MAX                |             |
| TERMINAL APPLICATION SPECIFICATION    | 114-2123    |                           |             |
| TERMINALS APPLIED                     |             |                           |             |
| TE TERMINAL                           | TE TERMINAL | TE TERMINAL               | TE TERMINAL |
| 4-520447-2                            | 9-520447-2  | 4-521097-2                |             |

| WIRE SIZE   | CRIMP HEIGHT INCH [mm]      | CRIMP HEIGHT REFERENCE SETTING | Ø SOLDER        |
|-------------|-----------------------------|--------------------------------|-----------------|
| 10          | 0.100+/-0.002 [2.54+/-0.05] | 5.1                            | .25 IN [6.35mm] |
| 12 OR (4)18 | 0.095+/-0.002 [2.41+/-0.05] | 6.3                            | .25 IN [6.35mm] |

- 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:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151029-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151029-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151029-6
- 5 ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 6 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- 7 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 8 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.
- 9 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.
- 10 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
- 1 ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- 2 ITEM 5 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
- 3 FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
- 4 TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø .25 IN [6.35mm]) 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



- 5 IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.
- 6 ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
- 7 ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
- 8 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 9 CONSULT PRODUCT ENGINEERING BEFORE USING 10AWG WIRE
- 10 RECOMMENDED CRIMP HEIGHT FOR (1)12AWG+(1)18AWG IS .095±.002
- 11 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- 12 ITEMS NOT SHOWN.
- 13 ITEM 261 REQUIRED WHEN APPLICATOR IS REMOVED FROM LEADMAKER AND PLACED IN AMP-O-LECTRIC TERMINATING UNIT.

|     |     |     |     |     |           |                                 |         |
|-----|-----|-----|-----|-----|-----------|---------------------------------|---------|
| -   | -   | -   | -   | 1   | 1-18023-1 | SCR, SHC, M4x10                 | 262     |
| -   | -   | -   | -   | 1   | 803931-1  | BRACKET, HOLD DOWN              | 261     |
| -   | -   | -   | -   | 1   | 2119957-2 | APPLICATOR SHIM PACK            | 260     |
| -   | REF | REF | REF | REF | 462992-5  | GUARD ASSY                      | 257     |
| -   | REF | REF | REF | REF | 679532-1  | INSERT, GUARD                   | 256     |
| -   | 1   | 1   | 1   | 1   | 189728-1  | BRACKET, SPACER                 | 255     |
| -   | 1   | 1   | 1   | 1   | 568681-1  | SPACER, BASE PLATE              | 253     |
| -   | 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   | 2119798-1 | DETENT PIN                      | 247     |
| -77 | -7  | -6  | -5  | -2  | 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         | LTN | DESCRIPTION   | DATE      | OWN | APVD |
|              |  | A   |      | A         |     | RELEASED      | 120C2012  | LG  | MC   |
|              |  | B   |      | B         |     | ECR-13-010223 | 25JUN2013 | CC  | TE   |

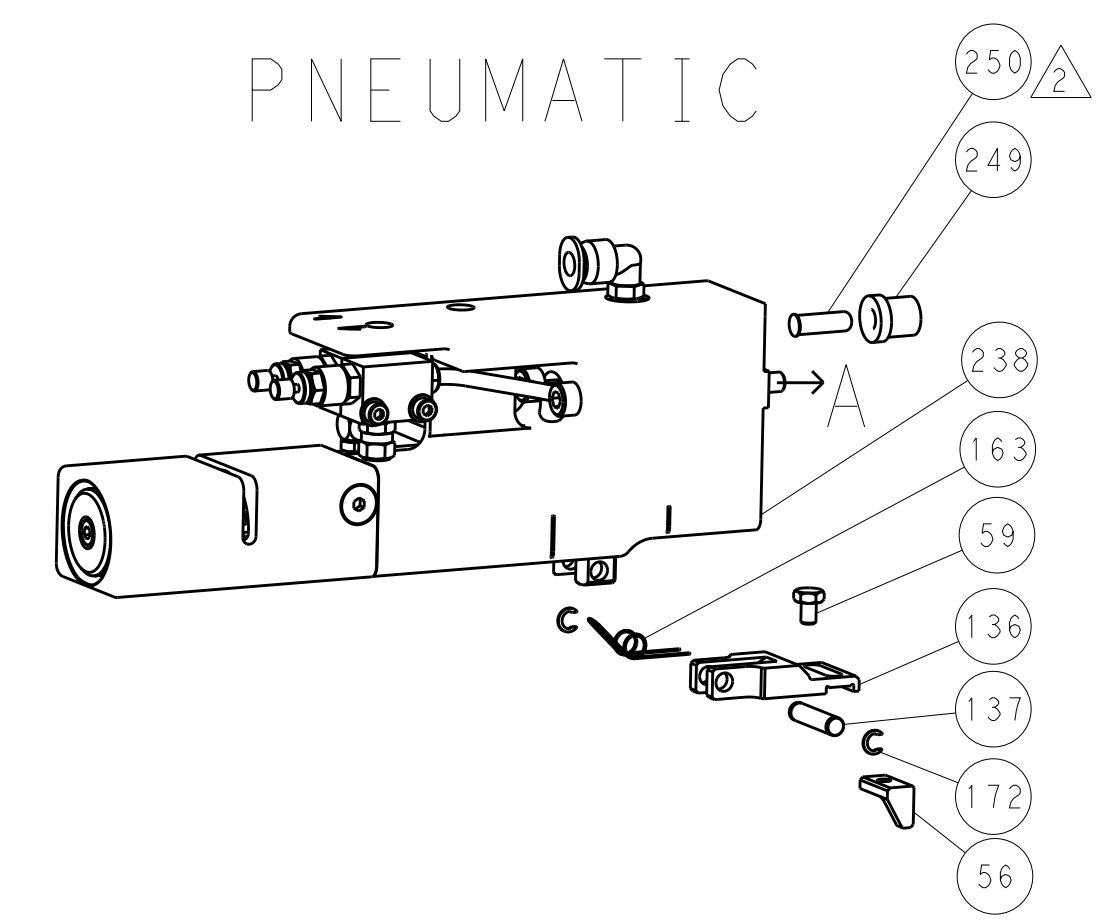
|     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | -   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246     |
| -   | -   | 1   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245     |
| -   | 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     |
| -   | -   | -   | -   | -   | 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   | 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   | 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   | 1-22281-8   | SPRING, COMPRESSION                 | 121     |
| -   | 1   | 1   | 1   | 1   | 1-690438-0  | FRONT STRIP GUIDE                   | 96      |
| -   | 6   | 6   | 6   | 6   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95      |
| -   | 1   | 1   | 1   | 1   | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 65      | 93      |
| -   | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 82      |
| -   | 1   | 1   | 1   | 1   | 240641-6    | SPACER                              | 81      |
| -   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 1   | 1   | 1   | 1   | 2161332-2   | DEPRESSOR, WIRE FUNNEL              | 70      |
| -   | 1   | 1   | 1   | 1   | 2161331-1   | SPACER, WIRE FUNNEL DEPRESSOR       | 69      |
| -   | 2   | 2   | 2   | 2   | 1-18028-4   | WASHER, FLAT, REG M3                | 68      |
| -   | 1   | -   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| -   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66      |
| -   | 1   | -   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
| -   | 3   | -   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62      |
| -   | 2   | 2   | 2   | 2   | 2-18032-5   | SCR, SET, FLT POINT M5 X 20.0       | 61      |
| -   | 1   | 1   | 1   | 1   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 60      |
| -   | -   | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -   | -   | -   | -   | 1   | 462427-2    | FINGER, FEED                        | 56      |
| -   | 4   | 4   | 4   | 4   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54      |
| -   | 2   | 2   | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 53      |
| -   | -   | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
| -   | 1   | 1   | 1   | 1   | 1-2119656-9 | APPLICATOR BASIC ASSEMBLY, SF       | 46      |
| -   | 1   | -   | 1   | 1   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44      |
| -   | 1   | 1   | 1   | 1   | 462433-8    | SUPPORT, INSULATION                 | 42      |
| -   | 1   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41      |
| -   | 1   | -   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40      |
| -   | 1   | -   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39      |
| -   | 1   | 1   | 1   | 1   | 2119644-1   | RAM WASHER, PRECISION               | 38      |
| -   | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37      |
| -   | 1   | -   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35      |
| -   | 2   | 2   | 2   | 2   | 5-22278-1   | SPRING, COMPRESSION                 | 33      |
| -   | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 X 8mm LONG    | 32      |
| -   | 2   | 2   | 2   | 2   | 1-2168083-4 | SCR, SKT HD CAP, RoHS, M4 X 5       | 30      |
| -   | 1   | 1   | 1   | 1   | 2161336-1   | PLATE, REAR STRIP GUIDE             | 29      |
| -   | 2   | 2   | 2   | 2   | 22281-9     | SPRING, COMPRESSION                 | 27      |
| -   | 1   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 26      |
| -   | 1   | 1   | 1   | 1   | 240792-1    | DRAG, TERMINAL                      | 25      |
| -   | 1   | 1   | 1   | 1   | 684042-5    | GUIDE, STRIP, FRONT                 | 24      |
| -   | 1   | 1   | 1   | 1   | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 23      |
| -   | 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   | 2119533-1   | STRIPPER, SIDE FEED                 | 19      |
| -   | 1   | 1   | 1   | 1   | 463460-3    | HOLD DOWN, TERMINAL                 | 18      |
| -   | 1   | 1   | 1   | 1   | 469542-3    | REAR FLOATING SHEAR                 | 17      |
| -   | 2   | 2   | 2   | 2   | 1-2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 6       | 16      |
| -   | 1   | 1   | 1   | 1   | 2161335-2   | SHEAR PLATE, REAR                   | 15      |
| -   | 1   | 1   | 1   | 1   | 2119862-2   | SHEAR HOLDER, REAR                  | 14      |
| -   | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13      |
| -   | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12      |
| -   | 1   | 1   | 1   | 1   | 356885-4    | STOP, SHEAR                         | 11      |
| -   | 1   | 1   | 1   | 1   | 462843-7    | TERMINAL SUPPORT                    | 9       |
| -   | 1   | 1   | 1   | 1   | 464291-5    | ANVIL, SAND-BLASTED 22-18           | 8       |
| -   | 1   | 1   | 1   | 1   | 803925-2    | GUIDE, CARRIER SCRAP                | 7       |
| -   | 1   | 1   | 1   | 1   | 690468-6    | DEPRESSOR SHEAR, REAR               | 6       |
| -   | 1   | 1   | 1   | 1   | 462431-5    | WIRE FUNNEL                         | 5       |
| -   | 1   | 1   | 1   | 1   | 238009-3    | BLOCK, FL CRIMPER SPACER            | 4       |
| -   | 1   | 1   | 1   | 1   | 464290-3    | CRIMPER, SEMI-FLAT 22-18            | 1       |
| -77 | -7  | -6  | -5  | -2  | PART NO     | DESCRIPTION                         | ITEM NO |

| DIMENSIONS: |               | TOLERANCES UNLESS OTHERWISE SPECIFIED: |           | DRAWN     |           | DATE      |           | NAME      |           |
|-------------|---------------|--|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| mm          | 0 PLC ±.5     | 1 PLC ±.5                              | 2 PLC ±.5 | 3 PLC ±.5 | 4 PLC ±.5 | 5 PLC ±.5 | 6 PLC ±.5 | 7 PLC ±.5 | 8 PLC ±.5 |
|             | ANGLES ±.0001 |  |           |           |           |           |           |           |           |
| MATERIAL    | FINISH        | WEIGHT                                 | SCALE     | SHEET     | OF        | REV       |           |           |           |
|             |               |  | 1:1       | 1         | 4         | B         |           |           |           |

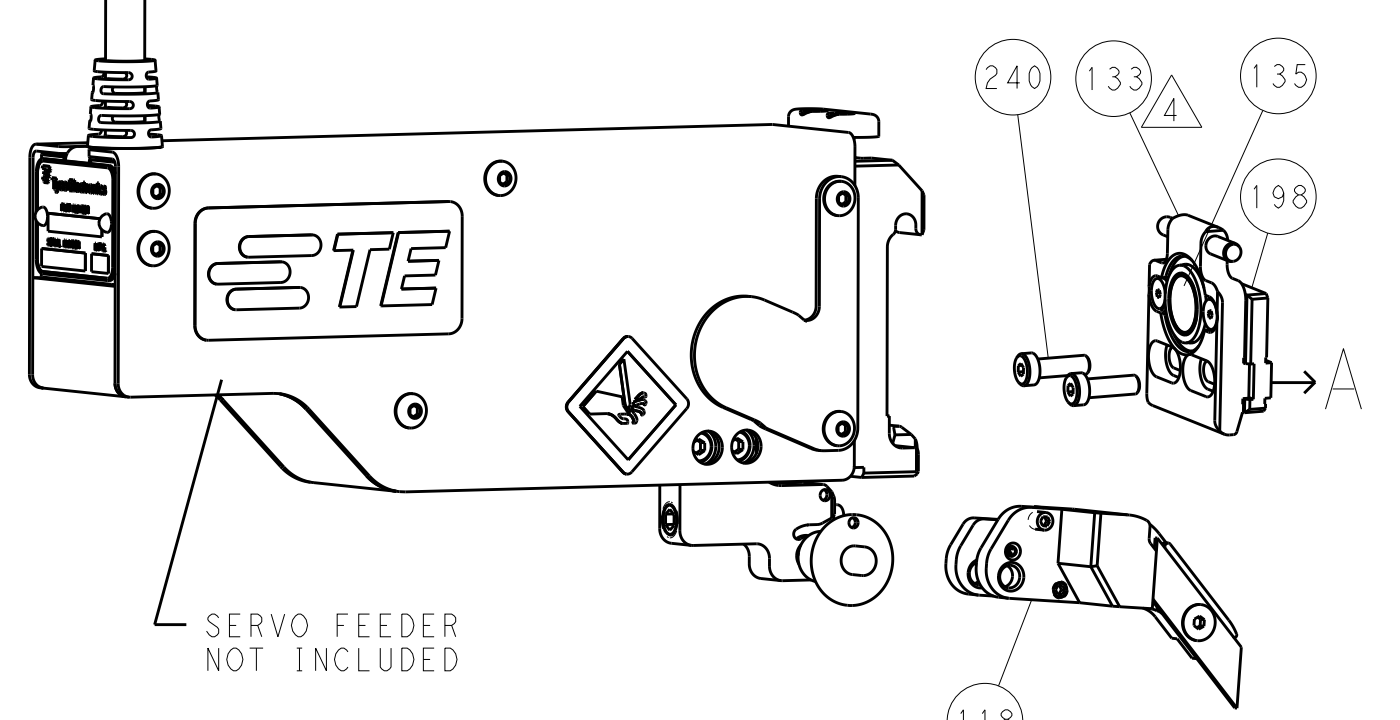
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|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    | -   | SEE SHEET 1 | -    | -   | -    |

### FEED TYPE

### PNEUMATIC

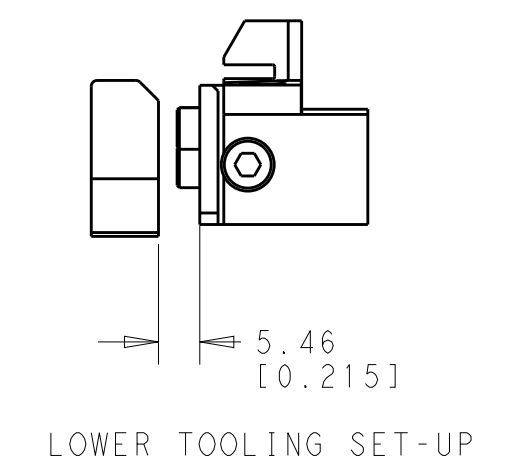
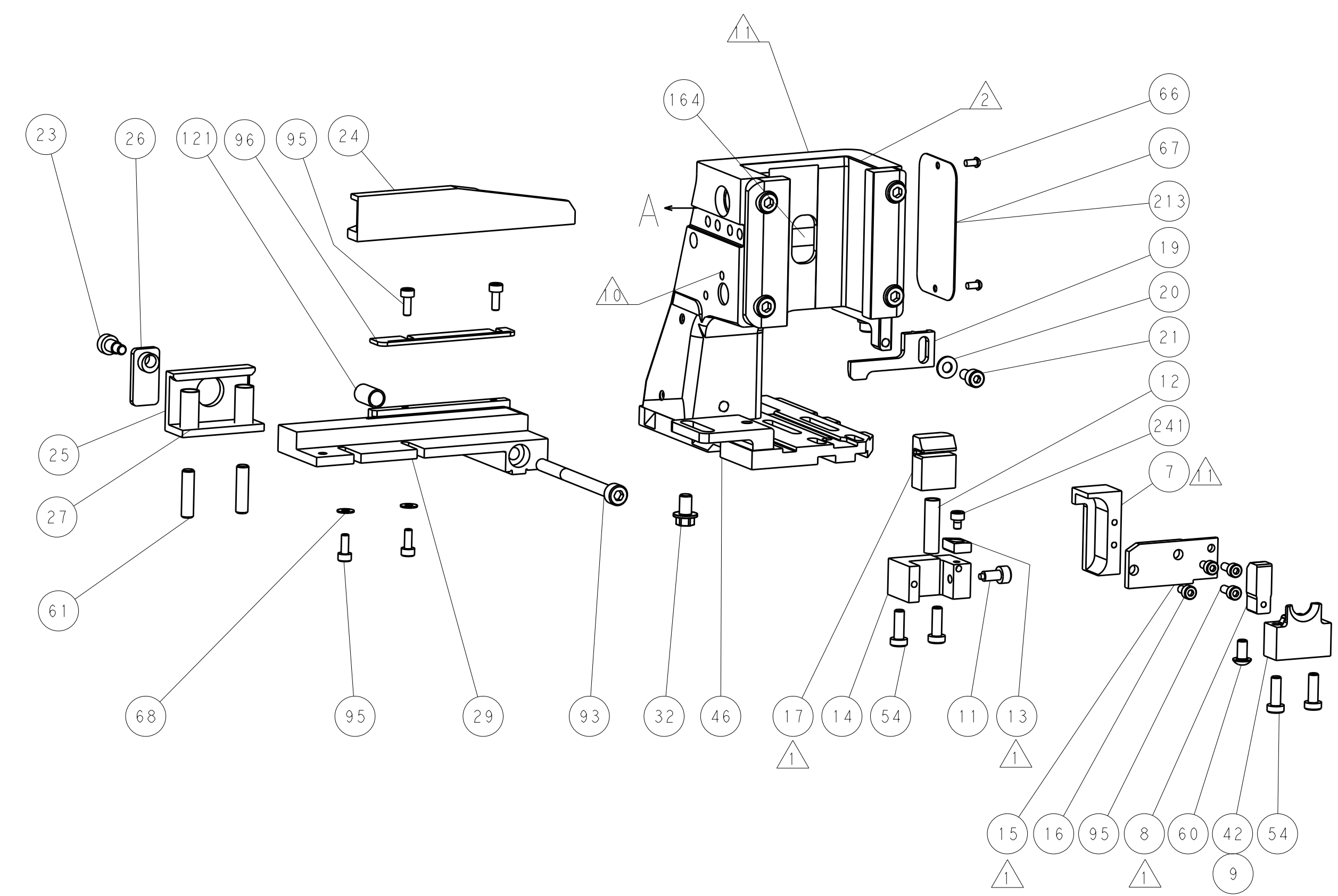
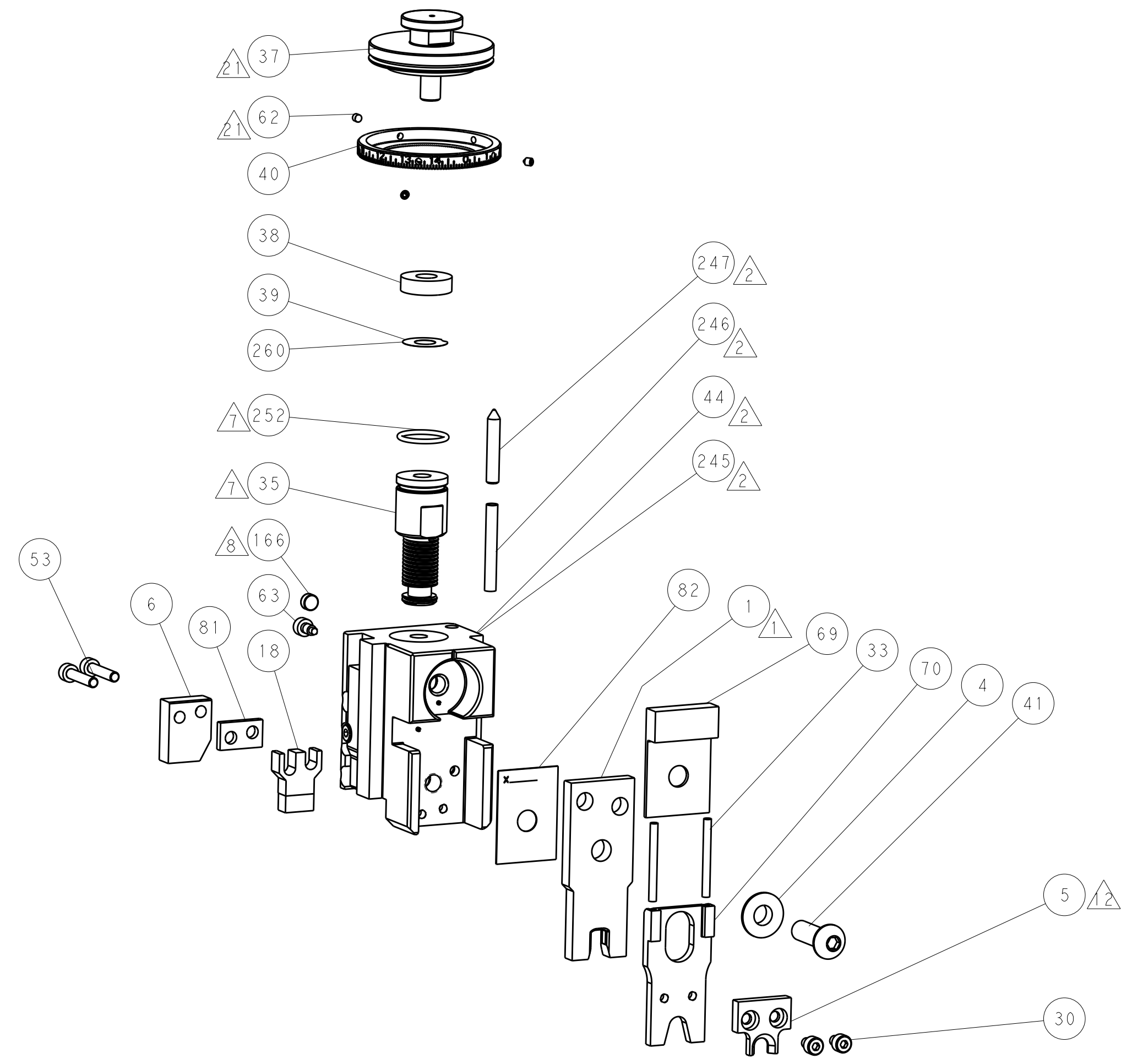
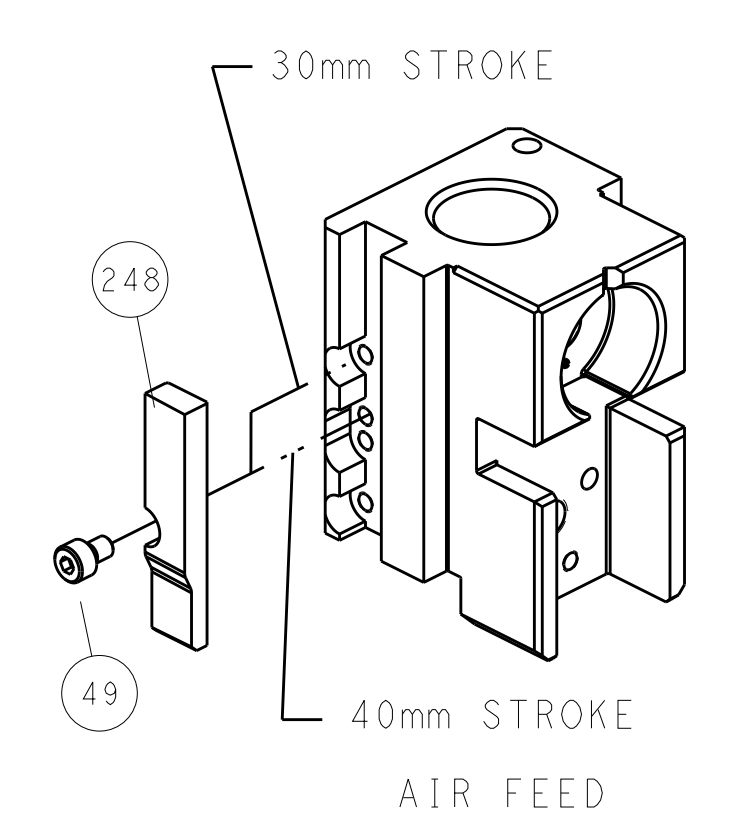


### SERVO LATCH PLATE



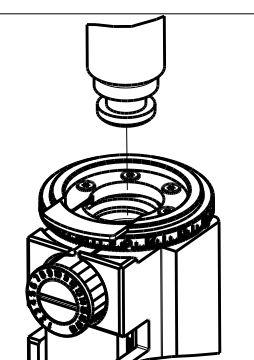
\*\*\*FEED FINGER REPRESENTATION ABOVE MAY DIFFER FROM ACTUAL FEED FINGER THAT IS REQUIRED BY THIS APPLICATOR

### CAM POSITION



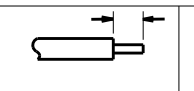

**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

|  |  |  |  |                          |  |   |  |
|--|--|--|--|--------------------------|--|---|--|
| DIMENSIONS: mm                         |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | DWN B. WEAVER 12JUN2012  |  | TE Connectivity Harrisburg, PA 17105-3608 |  |
| 0 PLC ±0.5                             |  | 1 PLC ±0.5                             |  | CHK G. HOFFNER 12JUN2012 |  | NAME Ocean Side Feed Applicator           |  |
| 2 PLC ±0.13                            |  | 3 PLC ±0.013                           |  | APVD T. ELBIN 12JUN2012  |  | PRODUCT SPEC                              |  |
| 4 PLC ±0.001                           |  | ANGLES ±0.001                          |  | APPLICATION SPEC         |  | SIZE CAGE CODE DRAWING NO RESTRICTED TO   |  |
| MATERIAL                               |  | FINISH                                 |  | WEIGHT                   |  | A1 00779 ©=2151029                        |  |
| Customer Accessible Production Drawing |  |  |  | SCALE 1:1                |  | SHEET 2 OF 4 REV B                        |  |


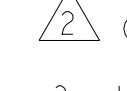

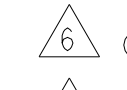



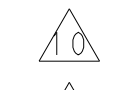

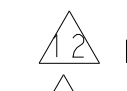

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER                                     | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |             |           |           |                        |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-------------|-----------|-----------|------------------------|
|  |             |          |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |             |           |           |                        |
|  | 2-2151029-2 | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | -                                 | -                     | -           | -         | -         | -                      |
|  | 2-2151029-5 | B        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 2119951-1                         | 2161540-1             | 8-2151029-5 | 1901094-3 | 1976043-1 | 2168400-6 (QUANTITY 2) |
|  | 2-2151029-7 | B        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 2161326-1                         | -                     | -           | -         | -         | -                      |
|  | 7-2151029-7 | A        | CRIMP TOOLING KIT        | NONE              | -                                 | -                     | -           | -         | -         | -                      |


| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP WIRE      | SIZE           | TYPE |
|                 | .278 [7.06 mm] | D    |
| INSUL           | -              | -    |

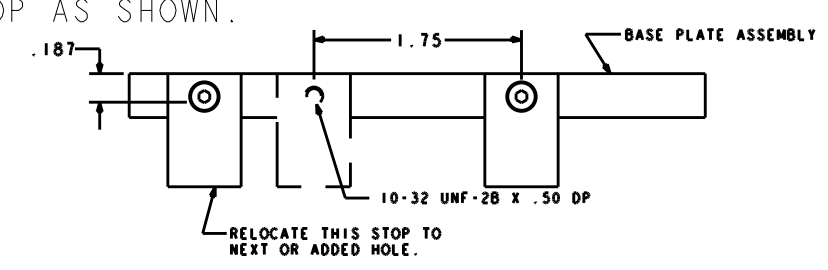
APPLICATOR INSTRUCTIONS  
408-10389

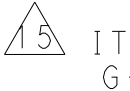
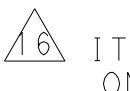



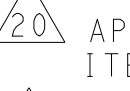

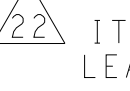
| TERMINAL DATA: TE TERMINAL  |   | TE CRIMP SPECIFICATION    |             |
|---|---|---------------------------|-------------|
| TERMINAL NAME: FULLY INSULATED FASTON   |   |                           |             |
| WIRE STRIP LENGTH   |  | INSULATION DIAMETER RANGE |             |
| .296-.328 IN [7.52-8.33 mm]   |   | Ø .320 MAX                |             |
| TERMINAL APPLICATION SPECIFICATION  | 114-2123  |                           |             |
| TERMINALS APPLIED  |   |                           |             |
| TE TERMINAL   | TE TERMINAL   | TE TERMINAL               | TE TERMINAL |
| 4-520447-2  | 9-520447-2  | 4-521097-2                |             |

| WIRE SIZE   | CRIMP HEIGHT INCH [mm]      | CRIMP HEIGHT REFERENCE SETTING | Ø SOLDER        |
|-------------|-----------------------------|--------------------------------|-----------------|
| 10/18       | 0.100+/-0.002 [2.54+/-0.05] | 5.1                            | .25 IN [6.35mm] |
| 12 OR (4)18 | 0.095+/-0.002 [2.41+/-0.05] | 6.3                            | .25 IN [6.35mm] |




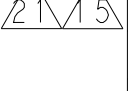


-  RECOMMENDED SPARE PARTS
-  GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
-  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151029-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151029-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151029-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
-  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.
-  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.
-  ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
-  ITEMS 5 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.
-  FEED ADJUSTMENT MAY BE REQUIRED WHEN SWITCHING TERMINALS.
-  TO CHECK CRIMP HEIGHT, CRIMP SOLDER (Ø.25 IN [6.35mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.

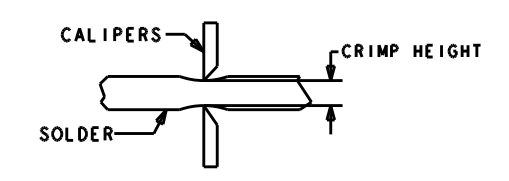
 IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.



-  ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
-  ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
-  TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
-  CONSULT PRODUCT ENGINEERING BEFORE USING 10AWG WIRE
-  RECOMMENDED CRIMP HEIGHT FOR (1)12AWG+(1)18AWG IS .095±.002
-  APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.
-  ITEMS NOT SHOWN.
-  ITEM 261 REQUIRED WHEN APPLICATOR IS REMOVED FROM LEADMAKER AND PLACED IN AMP-O-LECTRIC\* TERMINATING UNIT.

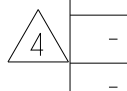
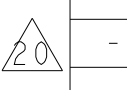
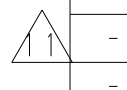

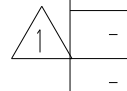
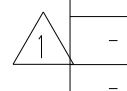
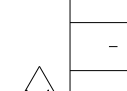





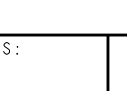


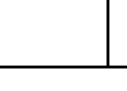

**\*WARNING**  
 ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

|   |     |     |     |     |           |                                     |         |
|---|-----|-----|-----|-----|-----------|-------------------------------------|---------|
|  | -   | -   | -   | 1   | 1-18023-1 | SCR, SHC, M4x10                     | 262     |
|  | -   | -   | -   | 1   | 803931-1  | BRACKET, HOLD DOWN                  | 261     |
|  | -   | REF | REF | REF | 462992-5  | GUARD ASSY                          | 257     |
|  | -   | REF | REF | REF | 679532-1  | INSERT, GUARD                       | 256     |
|  | -   | 1   | 1   | 1   | 189728-1  | BRACKET, SPACER                     | 255     |
|  | -   | 1   | 1   | 1   | 568681-1  | SPACER, BASE PLATE                  | 253     |
|   | -   | 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   | 1-22279-3 | SPRING, COMPRESSION                 | 246     |
|   | -77 | -27 | -25 | -22 | 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)

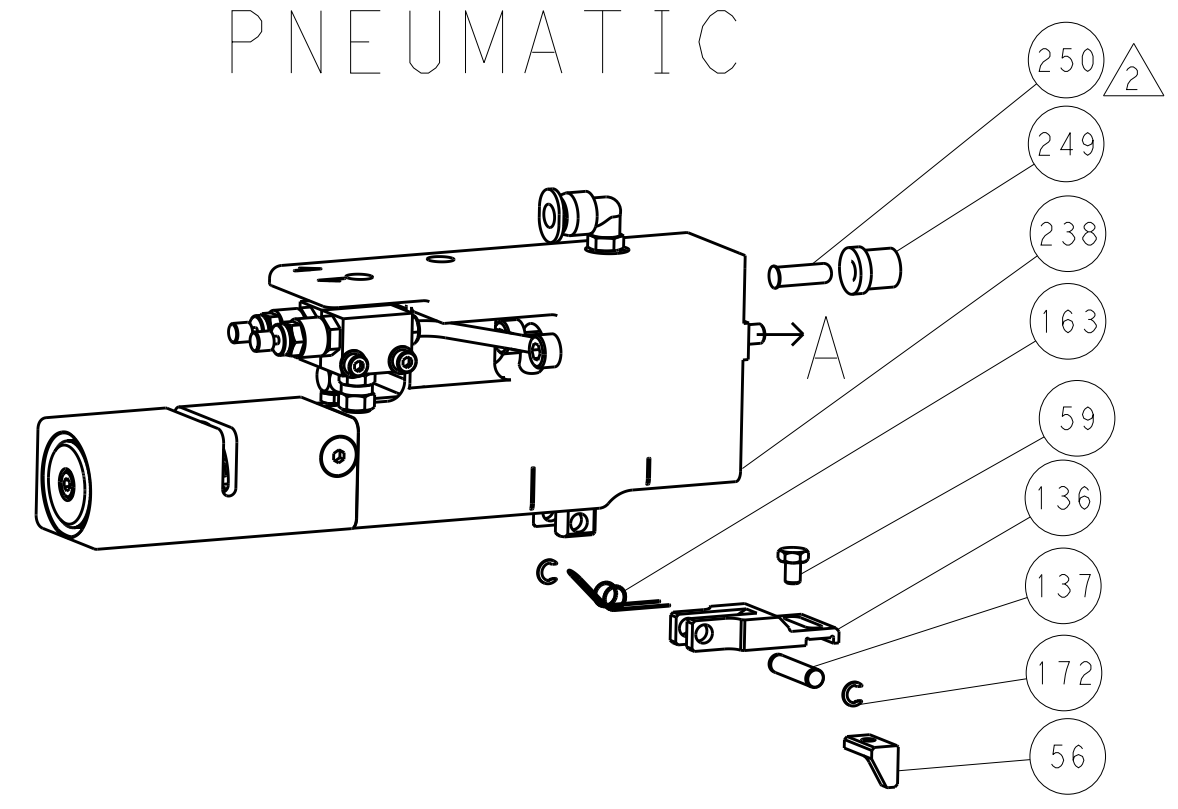
| SET UP GAUGE | LOC | DIST | REVISIONS |     |             |      |     |      |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-1    | A   | 66   | P         | LTN | DESCRIPTION | DATE | OWN | APVD |
|              |     |      | -         | -   | SEE SHEET 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                                 |         |
| -   | -   | -   | -   | 2119580-1   | MECHANICAL FEED ASSEMBLY            | 239                                 |         |
| -   | -   | -   | -   | 2063440-1   | AIR FEED MODULE                     | 238                                 |         |
| -   | -   | 1   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213                                 |         |
| -   | -   | 1   | -   | 1901094-3   | SPACER, FEEDER                      | 198                                 |         |
| -   | -   | -   | 2   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172                                 |         |
| -   | 1   | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166                                 |         |
| -   | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164                                 |         |
| -   | -   | -   | 1   | 240638-1    | SPRING, FEED FINGER                 | 163                                 |         |
| -   | 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   | 2119798-2   | DETENT PIN                          | 145                                 |         |
| -   | 1   | 1   | 1   | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)           | 144                                 |         |
| -   | 4   | 4   | 4   | 2168400-5   | SHCS, LOW HEAD, RoHS, M4 X 20       | 143                                 |         |
| -   | 1   | 1   | 1   | 2-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF       | 141                                 |         |
| -   | 1   | 1   | 1   | 2119650-1   | RAM, ASIAN STYLE, SIDE FEED         | 140                                 |         |
| -   | 1   | 1   | 1   | 2119092-2   | BOLT, ADJUSTMENT                    | 139                                 |         |
| -   | -   | -   | 1   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137                                 |         |
|    | -   | -   | -   | 2119799-1   | HOLDER, FEED FINGER, AF             | 136                                 |         |
| -   | -   | REF | REF | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135                                 |         |
| -   | -   | 1   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133                                 |         |
| -   | 1   | 1   | 1   | 1-22281-8   | SPRING, COMPRESSION                 | 121                                 |         |
| -   | 1   | 1   | 1   | 1-690438-0  | FRONT STRIP GUIDE                   | 96                                  |         |
| -   | 6   | 6   | 6   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95                                  |         |
| -   | 1   | 1   | 1   | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 65      | 93                                  |         |
| -   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 82                                  |         |
| -   | 1   | 1   | 1   | 240641-6    | SPACER                              | 81                                  |         |
| -   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71                                  |         |
| -   | 1   | 1   | 1   | 2161332-2   | DEPRESSOR, WIRE FUNNEL              | 70                                  |         |
| -   | 1   | 1   | 1   | 2161331-1   | SPACER, WIRE FUNNEL DEPRESSOR       | 69                                  |         |
| -   | 2   | 2   | 2   | 1-18028-4   | WASHER, FLAT, REG M3                | 68                                  |         |
| -   | 1   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67                                  |         |
| -   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 X .188    | 66                                  |         |
| -   | 1   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63                                  |         |
|   | -   | 3   | 3   | 3           | 992763-5                            | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62      |
| -   | 2   | 2   | 2   | 2-18032-5   | SCR, SET, FLT POINT M5 X 20.0       | 61                                  |         |
| -   | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59                                  |         |
| -   | -   | -   | 1   | 462427-2    | FINGER, FEED                        | 56                                  |         |
| -   | 2   | 2   | 2   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 53                                  |         |
| -   | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49                                  |         |
|  | -   | 1   | 1   | 1           | 462433-8                            | SUPPORT, INSULATION                 | 42      |
| -   | 1   | 1   | 1   | 2079383-7   | SCR, BHSC, RoHS (M8 X 25)           | 41                                  |         |
| -   | 1   | 1   | 1   | 2119645-1   | DISC, NUMBERED FA WIRE ADJUSTMENT   | 40                                  |         |
| -   | 1   | 1   | 1   | 2119957-1   | APPLICATOR SHIM PACK                | 39                                  |         |
| -   | 1   | 1   | 1   | 2119644-1   | RAM WASHER, PRECISION               | 38                                  |         |
| -   | 2   | 2   | 2   | 5-22278-1   | SPRING, COMPRESSION                 | 33                                  |         |
| -   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 X 8mm LONG    | 32                                  |         |
| -   | 2   | 2   | 2   | 1-2168083-4 | SCR, SKT HD CAP, RoHS, M4 X 5       | 30                                  |         |
| -   | 1   | 1   | 1   | 2161336-1   | PLATE, REAR STRIP GUIDE             | 29                                  |         |
| -   | 2   | 2   | 2   | 22281-9     | SPRING, COMPRESSION                 | 27                                  |         |
| -   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 26                                  |         |
| -   | 1   | 1   | 1   | 240792-1    | DRAG, TERMINAL                      | 25                                  |         |
| -   | 1   | 1   | 1   | 684042-5    | GUIDE, STRIP, FRONT                 | 24                                  |         |
| -   | 1   | 1   | 1   | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 23                                  |         |
| -   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21                                  |         |
| -   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20                                  |         |
| -   | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19                                  |         |
| -   | 1   | 1   | 1   | 463460-3    | HOLD DOWN, TERMINAL                 | 18                                  |         |
|  | -   | 1   | 1   | 1           | 469542-3                            | REAR FLOATING SHEAR                 | 17      |
|  | -   | 2   | 2   | 2           | 1-2168083-1                         | SCR, SKT HD CAP, RoHS, M3 X 6       | 16      |
|  | -   | 1   | 1   | 1           | 2161335-2                           | SHEAR PLATE, REAR                   | 15      |
|  | -   | 1   | 1   | 1           | 2119862-2                           | SHEAR HOLDER, REAR                  | 14      |
|  | -   | 1   | 1   | 1           | 2119806-1                           | INSERT, SHEAR                       | 13      |
|  | -   | 1   | 1   | 1           | 3-22280-3                           | SPRING, COMPRESSION                 | 12      |
|  | -   | 1   | 1   | 1           | 356885-4                            | STOP, SHEAR                         | 11      |
|  | -   | 1   | 1   | 1           | 462843-7                            | TERMINAL SUPPORT                    | 9       |
|  | 1   | 1   | 1   | 1           | 464291-5                            | ANVIL, SAND-BLASTED 22-18           | 8       |
|  | -   | 1   | 1   | 1           | 803925-2                            | GUIDE, CARRIER SCRAP                | 7       |
|  | -   | 1   | 1   | 1           | 690468-6                            | DEPRESSOR SHEAR, REAR               | 6       |
|  | -   | 1   | 1   | 1           | 462431-5                            | WIRE FUNNEL                         | 5       |
|  | -   | 1   | 1   | 1           | 238009-3                            | BLOCK, FL CRIMPER SPACER            | 4       |
|  | 1   | 1   | 1   | 1           | 464290-3                            | CRIMPER, SEMI-FLAT 22-18            | 1       |
|   | -77 | -27 | -25 | -22         | PART NO                             | DESCRIPTION                         | ITEM NO |

| DIMENSIONS: |               | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | DWG          |               | CHK       |           | APVD      |           | NAME                                   |                            |
|-------------|---------------|--|-------------|--------------|---------------|-----------|-----------|-----------|-----------|--|----------------------------|
| mm          | 0 PLC ±.5     | 1 PLC ±0.5                             | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.0001 | 12JUN2012 | 12JUN2012 | 12JUN2012 | 12JUN2012 | TE Connectivity                        | Ocean Side Feed Applicator |
|             | ANGLES ±.0001 | FINISH                                 |             |              |               |           |           |           |           | Harrisburg, PA 17105-3608              |                            |
| MATERIAL    |               |  |             |              |               |           |           |           |           | SIZE                                   | CAGE CODE                  |
|             |               |  |             |              |               |           |           |           |           | A1                                     | 00779                      |
|             |               |  |             |              |               |           |           |           |           | DRAWING NO                             | RESTRICTED TO              |
|             |               |  |             |              |               |           |           |           |           | ©=2151029                              |                            |
|             |               |  |             |              |               |           |           |           |           | Customer Accessible Production Drawing | SCALE                      |
|             |               |  |             |              |               |           |           |           |           | 1:1                                    | SHEET 3 OF 4               |
|             |               |  |             |              |               |           |           |           |           |  | REV B                      |

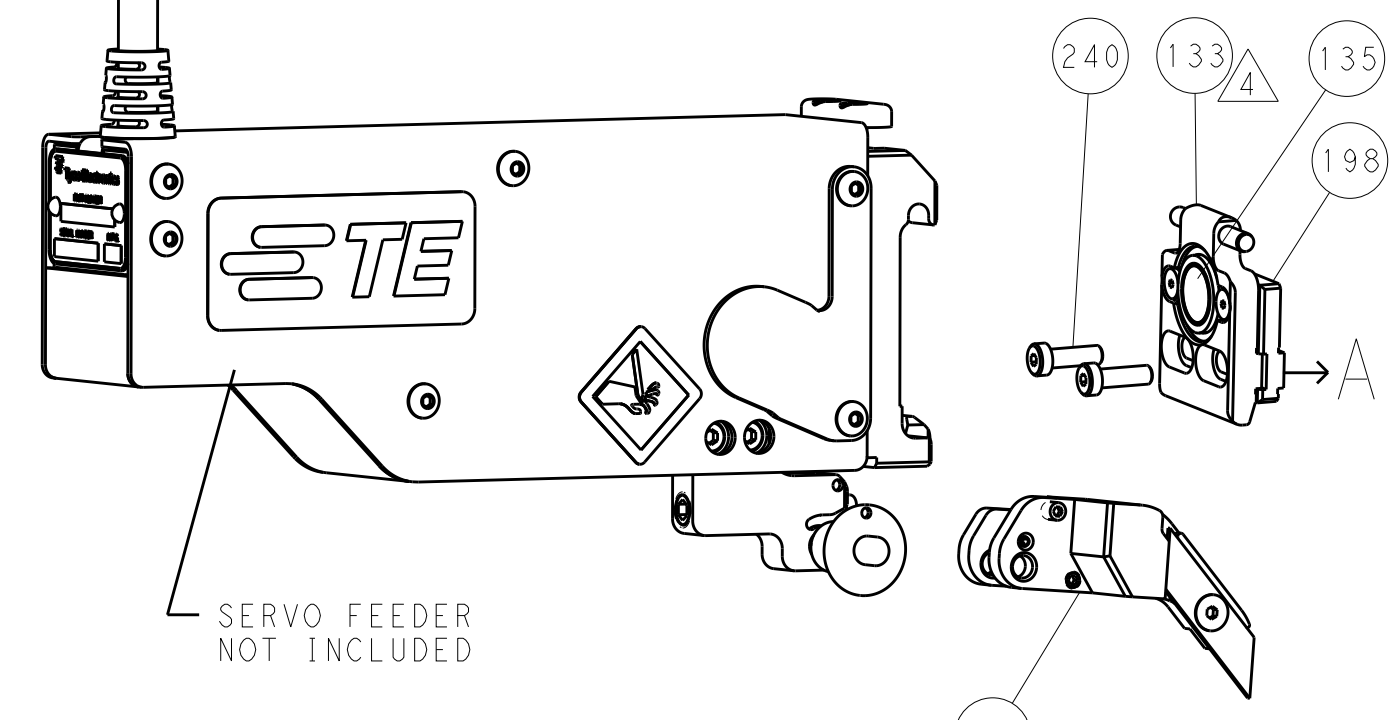
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|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    | -   | SEE SHEET 1 | -    | -   | -    |

### FEED TYPE PNEUMATIC



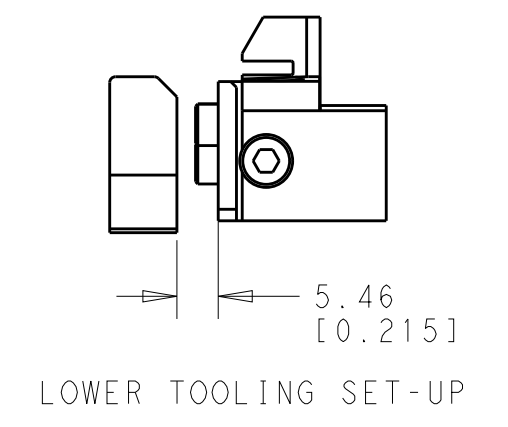
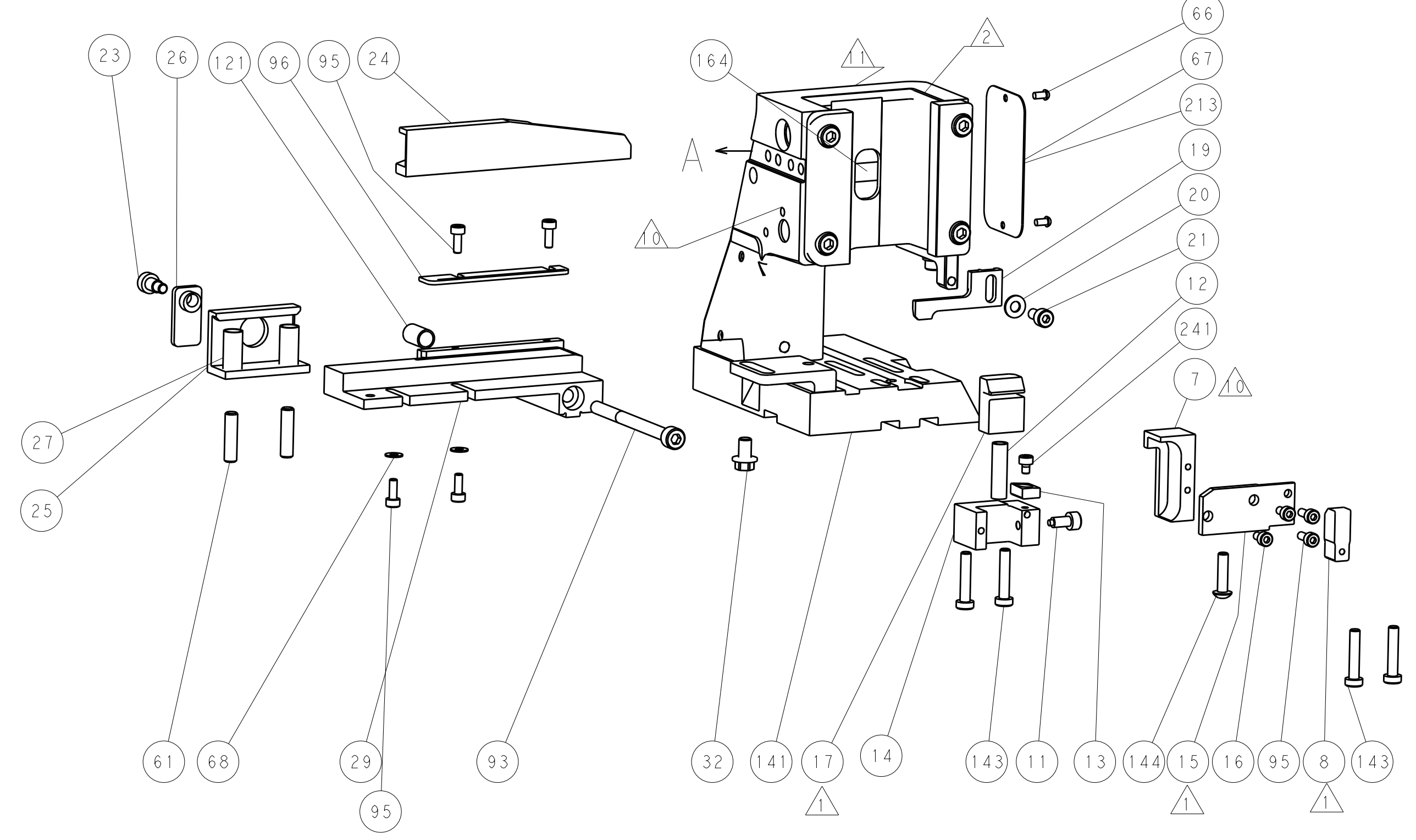
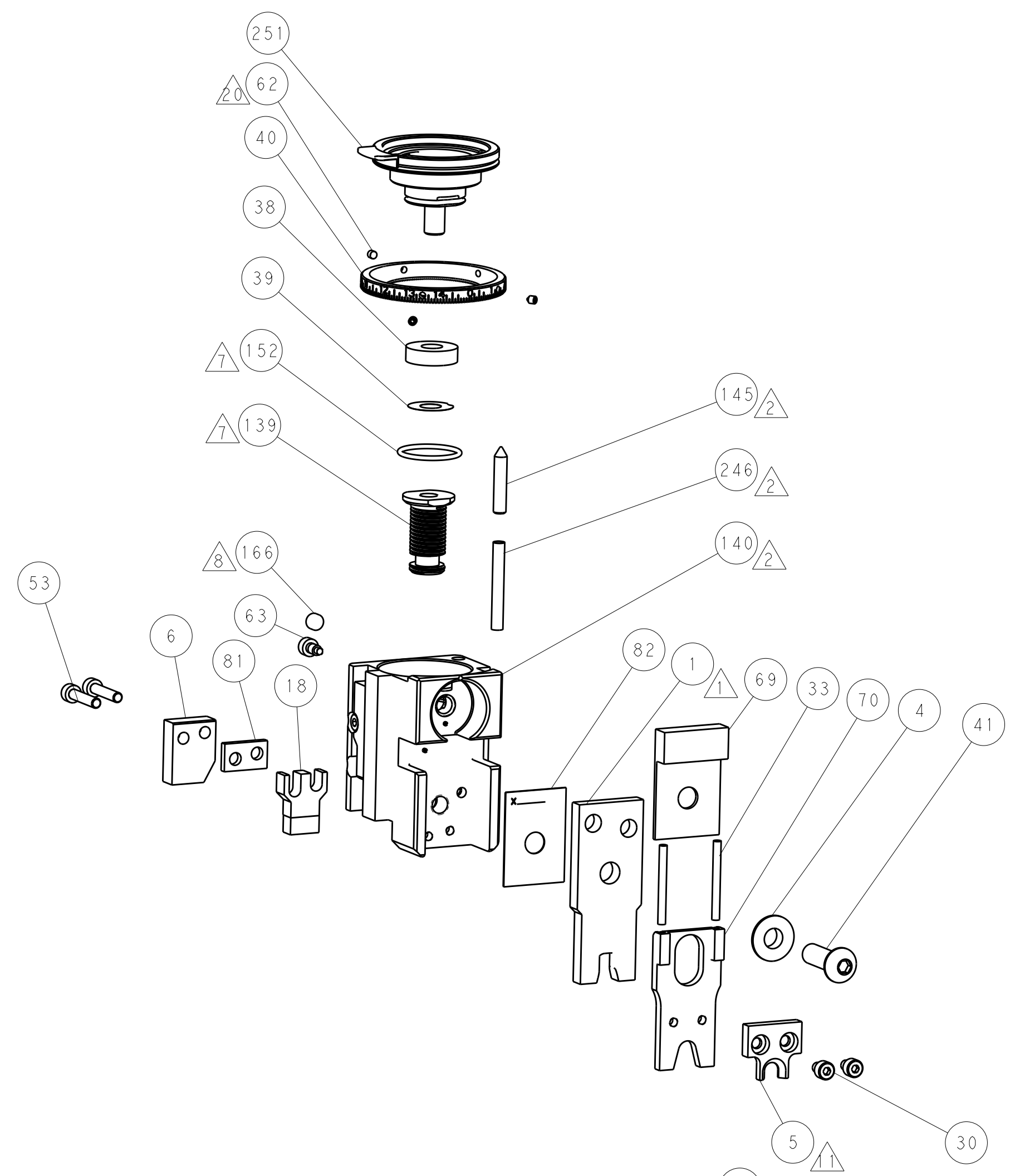
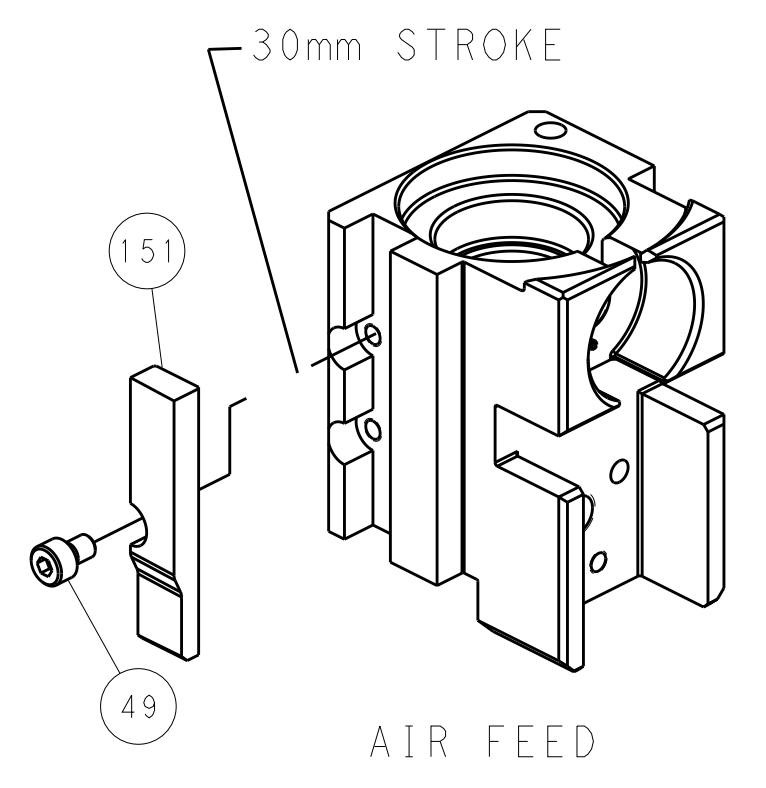
### SERVO LATCH PLATE

SCALE 1:2



\*\*\*FEED FINGER REPRESENTATION ABOVE MAY DIFFER FROM ACTUAL FEED FINGER THAT IS REQUIRED BY THIS APPLICATOR

### CAM POSITION



**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  | B. WEAVER  | 12JUN2012  | STE TE Connectivity<br>Harrisburg, PA 17105-3608 |
| mm          | 0 PLC ±0.5   | 1 PLC ±0.5                             | 2 PLC ±0.13                            | CHK  | G. HOFENER | 12JUN2012  |  |
|             | 3 PLC ±0.013 | 4 PLC ±0.001                           | ANGLES ±0.001                          | APVD | T. ELBIN   | 12JUN2012  | NAME   |
| MATERIAL    | FINISH       | WEIGHT                                 | Customer Accessible Production Drawing | SIZE | CAGE CODE  | DRAWING NO | RESTRICTED TO                                    |
|             |              |  | SCALE                                  | A    | 00779      | ©=2151029  |  |