

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151824-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	
	2151824-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE $\Delta$ 4	SERVO LATCH PLATE	2119951-1	-	8-2151824-5	1901094-3	2-1752354-8	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151824-4	-	-	-
	2151824-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE $\Delta$ 4	-	-	-	-	-	-	
	2151824-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
	7-2151824-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
WIRE	5.40 mm [.213]	F
INSUL	9.75 mm [.384]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: LEAR TERMINAL		LEAR CRIMP SPECIFICATION	
TERMINAL NAME: FLAT CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
8.69-9.47 mm [.342-.373 IN]		$\varnothing$ 4.70-5.10 mm [1.85-.201 IN]	
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED $\Delta$ 0			
TE TERMINAL	LEAR TERMINAL	TE SEAL	VW SEAL
1572974-1	28459306189	1949052-1	0211172A

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
10.00mm2	3.30 +/- 0.10 [.130 +/- .004]	6.3
6.00mm2	3.00 +/- 0.05 [.118 +/- .002]	9.3



- $\Delta$  RECOMMENDED SPARE PARTS
- $\Delta$  GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- $\Delta$  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151824-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151824-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151824-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- $\Delta$  APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62, 180 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 242.
- $\Delta$  GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- $\Delta$  MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- $\Delta$  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.
- $\Delta$  10 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- $\Delta$  11 THE APPLICATOR IS A NON-CARRIER CUTTING STYLE.
- $\Delta$  12 WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.07.
- $\Delta$  13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INDULSTION DIAMETER OF SEAL IS 4.0-4.3mm.
- $\Delta$  14 APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- $\Delta$  15 CUT TO LENGTH 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.

- 2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	265	
- 1	1	1	1	1633782-3	FENCE	264	
- 2	2	2	2	22281-8	SPRING, COMPRESSION	263	
- 1	1	1	1	240792-1	DRAG, TERMINAL	262	
- 1	1	1	1	2-690438-2	FRONT STRIP GUIDE	261	
- -	-	-	-	2119957-2	APPLICATOR SHIM PACK	260	
- 1	-	-	-	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252	
- -	-	-	-	2119640-1	PUSH ROD, AIR FEED	250	
- -	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249	
- -	-	-	-	2119641-1	FEED CAM, AIR FEED	248	
-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 LTR	DESCRIPTION	DATE	OWN	APVD
			A	RELEASED	03APR2013	CC	TE

- 1	- 1	1	1	2119798-1	DETENT PIN	247	
- 1	- 1	1	1	1-22279-3	SPRING, COMPRESSION	246	
- -	- 1	-	-	2161314-1	RAM, STEPPED, ATLANTIC, SF, NON-ADJ	245	
- 1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
- 1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
- 1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
- -	- 2	- 2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240	
- -	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
- -	-	-	-	2063440-3	AIR FEED MODULE	238	
- -	- 1	- 1	-	2119740-2	TAG, IDENTIFICATION	213	
- -	- 1	- 1	-	1901094-3	SPACER, FEEDER	198	
- 1	1	1	1	2-1752354-7	STANDOFF, HOLD-DOWN	180	
- 1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
- 1	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
- 1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
- 1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
- -	-	-	- 2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172	
- 1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166	
- REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164	
- -	-	-	- 1	240638-1	SPRING, FEED FINGER	163	
- -	-	-	- 1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
- -	-	-	- 1	2119799-1	HOLDER, FEED FINGER, AF	136	
- -	-	-	- 1	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135	
- -	- 1	- 1	-	1633743-1	SERVO FEED LATCH ASM	133	
- 1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
- -	-	-	- 1	2119944-1	FEED FINGER ASSEMBLY, SF	117	
- 1	1	1	1	455888-7	SPACER, CRIMPER	82	
- 1	1	1	1	1803096-1	EXTENSION PLATE	78	
- 1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
- 1	-	-	- 1	2119740-1	TAG, IDENTIFICATION	67	
- 2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	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	
- 3	3	3	3	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60	
- -	-	-	- 1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
- 1	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57	
- 1	1	1	1	1-1338683-1	FEED PAWL	56	
- 4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54	
- 1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
- 1	1	1	1	1901681-2	HOLDDOWN, TERMINAL	51	
- -	-	-	- 1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
- -	-	-	-	2119652-1	FEED CAM, PRE FEED	48	
- -	-	-	-	2119653-1	FEED CAM, POST FEED	47	
- 1	1	1	1	1-2119656-7	APPLICATOR BASIC ASSEMBLY, SF	46	
- 1	-	- 1	1	2161311-1	RAM, STEPPED, AMP STYLE, SIDE FEED	44	
- 1	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	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	
- 1	1	1	1	1752356-7	SUPPORT, TERMINAL	34	
- 2	2	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33	
- 1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32	
- 1	1	1	1	2-1320908-3	SPACER, STRIP GUIDE	30	
- 1	1	1	1	2119959-5	ASSEMBLY, STRIP GUIDE	29	
- 1	1	1	1	1-455888-0	SPACER, CRIMPER	28	
- 1	1	1	1	1320928-2	STRIP GUIDE	24	
- 1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21	
- 1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20	
- 1	1	1	1	1803013-1	STRIPPER, SIDE FEED	19	
- 1	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
- 1	1	1	1	1-356885-4	STOP, SHEAR	11	
- 1	1	1	1	1-2119805-2	SHEAR HOLDER, FRONT	10	
- 1	1	1	1	1-318059-0	FLOATING SHEAR, FRONT	9	
1	1	1	1	1-1633930-5	ANVIL, COMBINATION	8	
- -	-	-	-	-	-	7	
- -	-	-	-	-	-	6	
- 1	1	1	1	1803080-1	DEPRESSOR, SHEAR	5	
- 1	1	1	1	238011-3	BLOCK, CRIMPER SPACER	4	
1	1	1	1	4-1633965-7	CRIMPER, INSULATION O PREMIUM	3	
- 1	1	1	1	1-455888-8	SPACER, CRIMPER	2	
1	1	1	1	6-1633609-9	CRIMPER, WIRE	1	
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

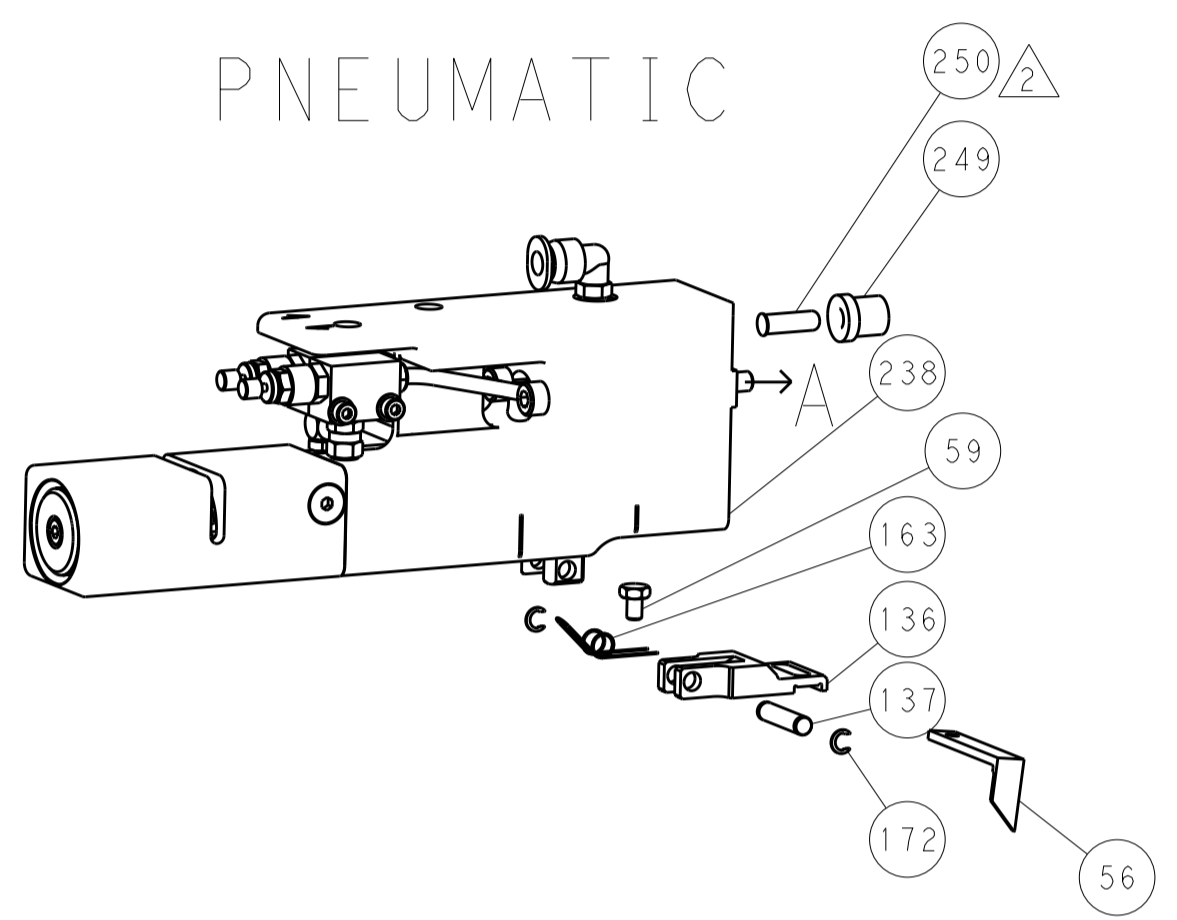
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								1	CRUZ
								18DEC2012	18DEC2012
MATERIAL		FINISH		WEIGHT		SCALE		SHEET	
						A1		00779	
						Customer Accessible Production Drawing		SCALE 1:1 SHEET 1 of 4 REV A	

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

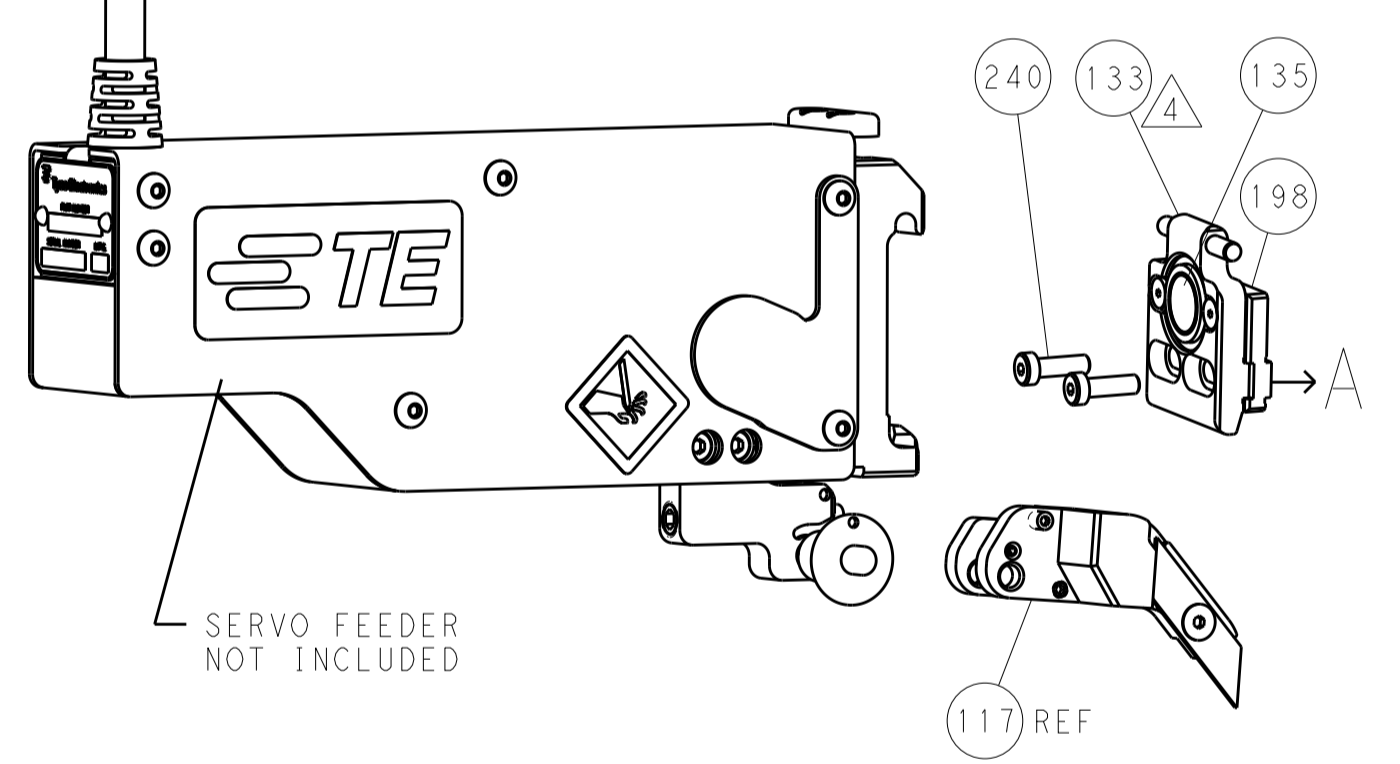
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

### FEED TYPE

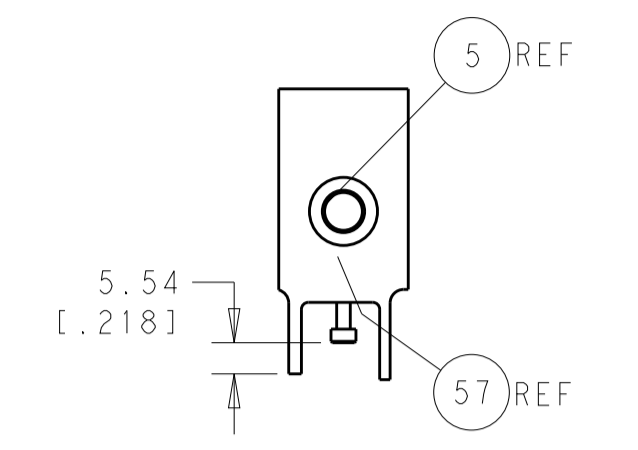
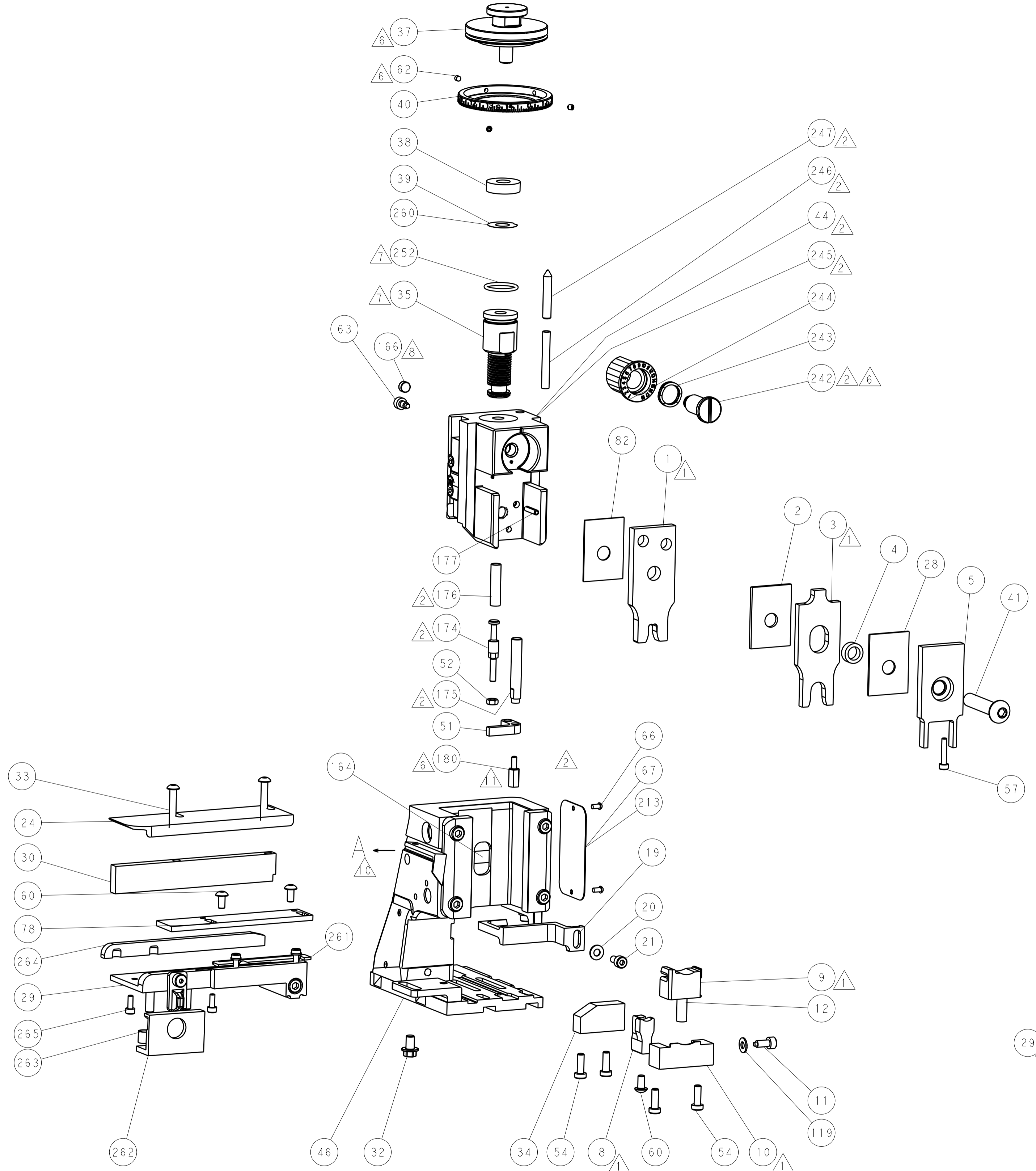
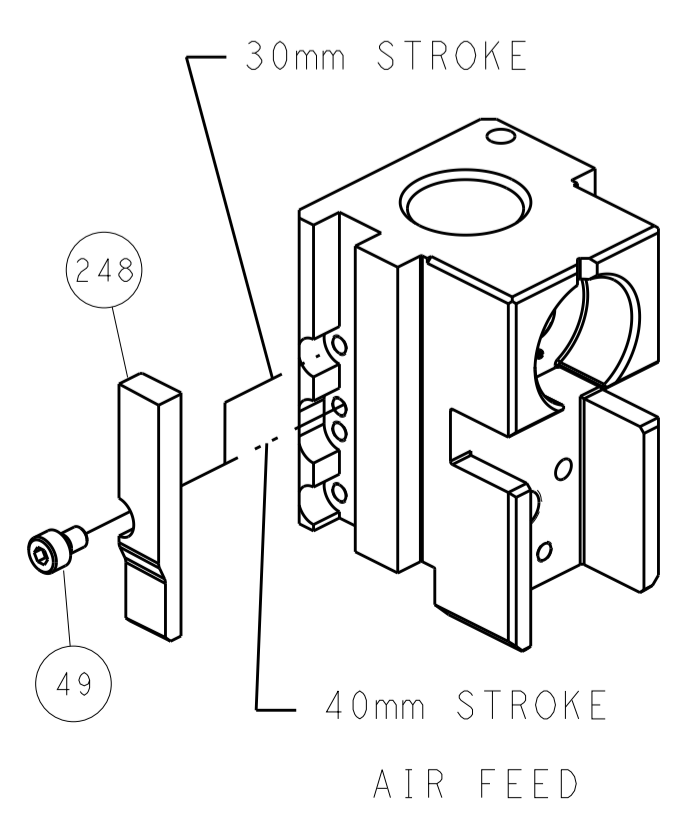
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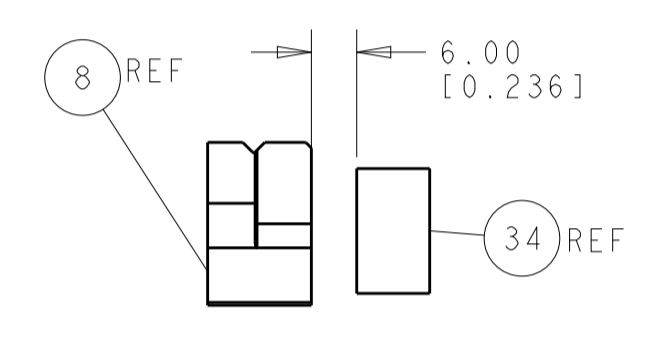
### SERVO LATCH PLATE



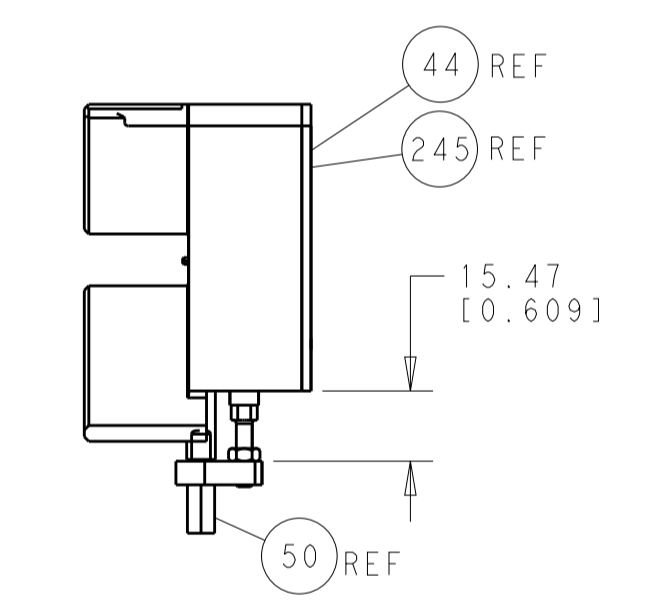
### CAM POSITION



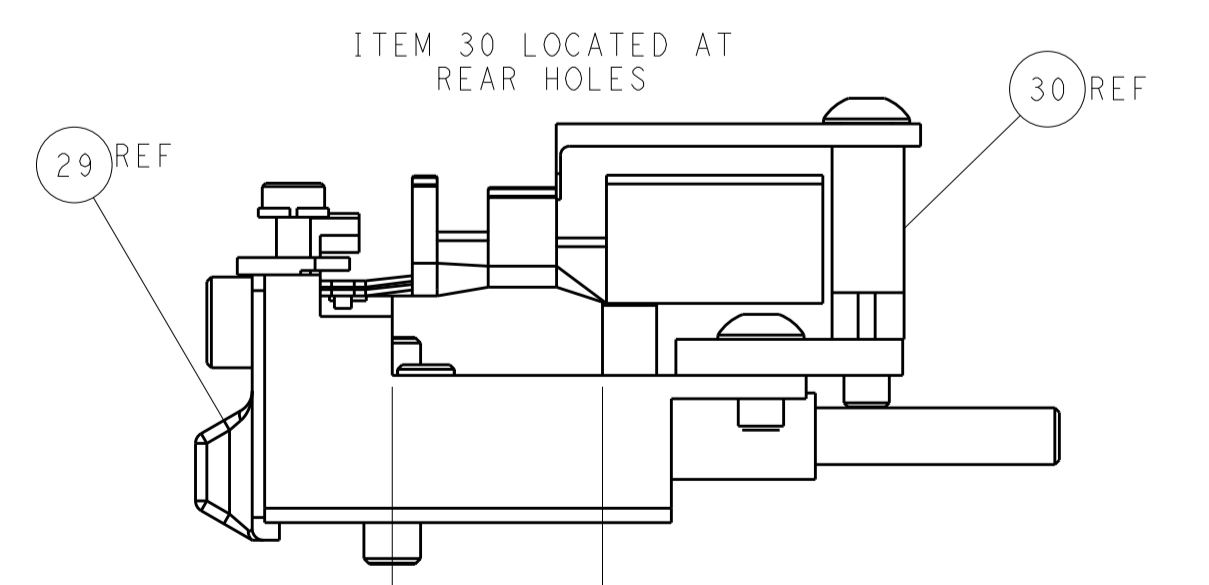
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY WIRE BARREL

**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 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 PROJECT AND FOR THE CUSTOMER'S USE. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION WHEN NO LONGER REQUIRED. ANY REPRODUCTION OR DISTRIBUTION OF THIS DRAWING WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION IS STRICTLY PROHIBITED.</small>		DWN: C. CHEN 18DEC2012 CHK: S. XI 18DEC2012 APVD: J. CRUZ 18DEC2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.1 1 PLC ±0.02 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±0.0005		NAME: Ocean Side Feed Applicator PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - SCALE: 1:1	SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151824 SHEET 2 OF 4 REV A
MATERIAL: - FINISH: -		RESTRICTED TO: - Customer Accessible Production Drawing	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2151824-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2151824-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>
	2-2151824-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2151824-7	A	CRIMP TOOLING KIT	-

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
INSUL	9.75 mm [.384]	0
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: LEAR TERMINAL LEAR CRIMP SPECIFICATION			
TERMINAL NAME: FLAT CONTACT			
WIRE STRIP LENGTH 8.69-9.47 mm [.342-.373 IN]	INSULATION DIAMETER RANGE Ø4.70-5.10 mm [.185-.201 IN]		
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED <sup>10</sup>			
TE TERMINAL	LEAR TERMINAL	TE SEAL	LEAR SEAL
1572974-1	28459306189	1949052-1	0211172A

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING <sup>9</sup>
10.00mm <sup>2</sup>	3.30 +/- 0.10 [.130 +/- .004]	6.3
6.00mm <sup>2</sup>	3.00 +/- 0.05 [.118 +/- .002]	9.3



- <sup>1</sup> RECOMMENDED SPARE PARTS
- <sup>2</sup> GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- <sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151824-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151824-5
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- <sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62, 180 & 242.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- <sup>8</sup> MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- <sup>9</sup> CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- <sup>10</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- <sup>11</sup> THE APPLICATOR IS A NON-CARRIER CUTTING STYLE.
- <sup>12</sup> THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION DIAMETER SEAL IS 4.0-4.3mm.
- <sup>13</sup> APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- <sup>14</sup> CUT TO LENGTH 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.

-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	265
-	1	1	1	1633782-3	FENCE	264
-	2	2	2	22281-8	SPRING, COMPRESSION	263
-	1	1	1	240792-1	DRAG, TERMINAL	262
-	1	1	1	2-690438-2	FRONT STRIP GUIDE	261
-	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

**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	-	-	-

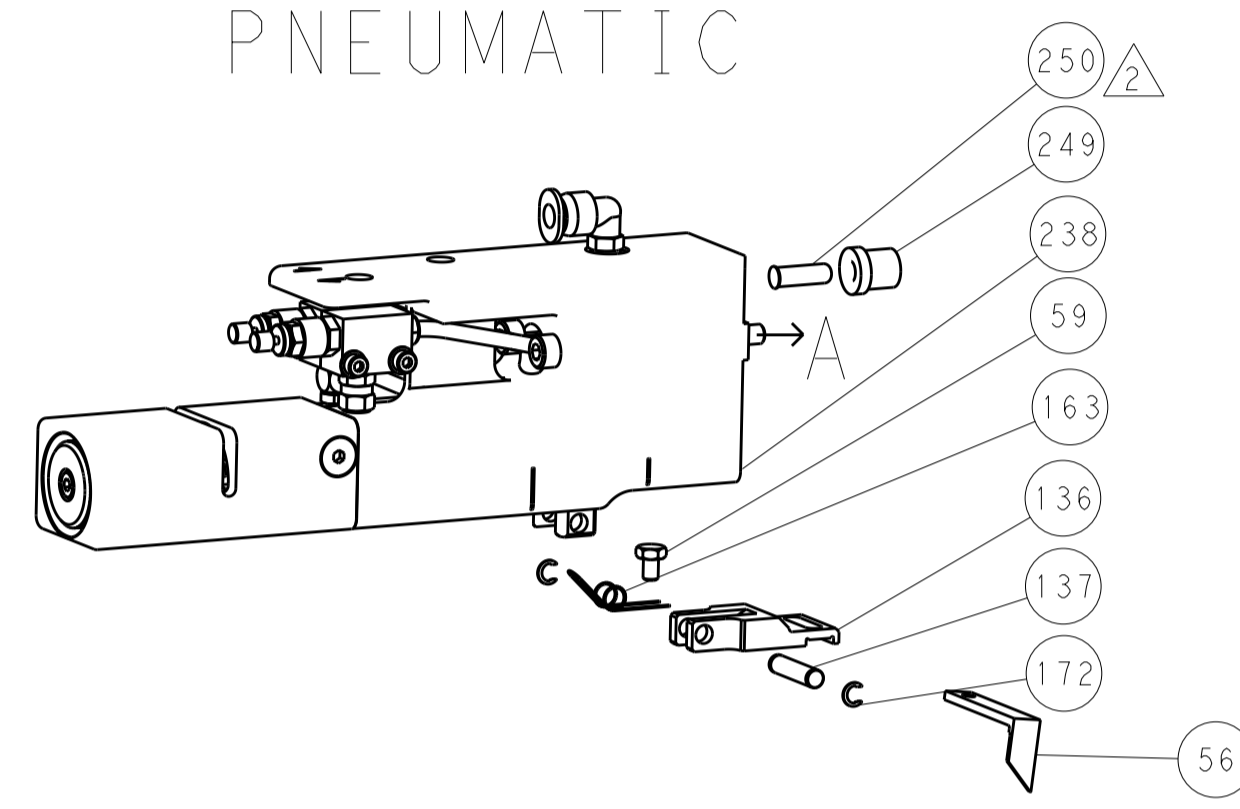
<sup>6</sup>	-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240	
-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	-	-	1	2063440-3	AIR FEED MODULE	238	
-	-	1	-	2119740-2	TAG IDENTIFICATION	213	
<sup>6</sup>	-	-	1	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	2-1752354-7	STANDOFF, HOLD-DOWN	180	
-	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177	
-	1	1	1	8-22280-7	SPRING, COMPRESSION	176	
-	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175	
-	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174	
-	-	-	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	
-	-	-	-	2119653-2	FEED CAM, POST FEED	142	
-	1	1	1	1-2119656-8	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1	1	2161312-1	RAM, STEPPED, 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	
-	-	-	1	2119799-1	HOLDER, FEED FINGER, AF	136	
-	-	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135	
-	-	1	-	1633743-1	SERVO FEED LATCH ASM	133	
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
-	1	1	1	455888-7	SPACER, CRIMPER	82	
-	1	1	1	1803096-1	EXTENSION PLATE	78	
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	-	1	2119740-1	TAG IDENTIFICATION	67	
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	66	
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
<sup>6</sup>	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
<sup>14</sup>	-	2	2	2	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	1	1	1	1-2168083-3	SCR, SKT HD CAP, RoHS, M3 X 16	57	
-	1	1	1	1-1338683-1	FEED PAWL	56	
-	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1	1901681-2	HOLDDOWN, TERMINAL	51	
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	-	-	2119652-1	FEED CAM, PRE FEED	48	
-	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)	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	
-	1	1	1	1752356-7	SUPPORT, TERMINAL	34	
-	2	2	2	1-2079383-3	SCR, BHSC, RoHS (M4 X 25)	33	
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32	
-	1	1	1	2-1320908-3	SPACER, STRIP GUIDE	30	
-	1	1	1	2119959-5	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	1-455888-0	SPACER, CRIMPER	28	
-	1	1	1	1320928-2	STRIP GUIDE	24	
-	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	
<sup>1</sup>	-	1	1	1	1803013-1	STRIPPER, SIDE FEED	19
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
<sup>1</sup>	-	1	1	1	1-356885-4	STOP, SHEAR	11
<sup>1</sup>	-	1	1	1	1-2119805-2	SHEAR HOLDER, FRONT	10
<sup>1</sup>	-	1	1	1	1-318059-0	FLOATING SHEAR, FRONT	9
<sup>1</sup>	1	1	1	1	1-1633930-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	6
-	1	1	1	1	1803080-1	DEPRESSOR, SHEAR	5
-	1	1	1	238011-3	BLOCK, CRIMPER SPACER	4	
<sup>1</sup>	1	1	1	1	4-1633965-7	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1-455888-8	SPACER, CRIMPER	2
<sup>1</sup>	1	1	1	1	6-1633609-9	CRIMPER, WIRE	1

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DATE		NAME	
mm	0 PLC ±.1	1 PLC ±.01	2 PLC ±.02	3 PLC ±.005	4 PLC ±.0005	18DEC2012	TE Connectivity
	ANGLES	FINISH				18DEC2012	Harrisburg, PA 17105-3608
MATERIAL						APVD	Ocean Side Feed Applicator
						PRODUCT SPEC	
						APPLICATION SPEC	
						WEIGHT	SIZE CASE CODE DRAWING NO
							A1 00779 ©=2151824
							RESTRICTED TO
							Customer Accessible Production Drawing
							SCALE 1:1 SHEET 3 OF 4 REV A

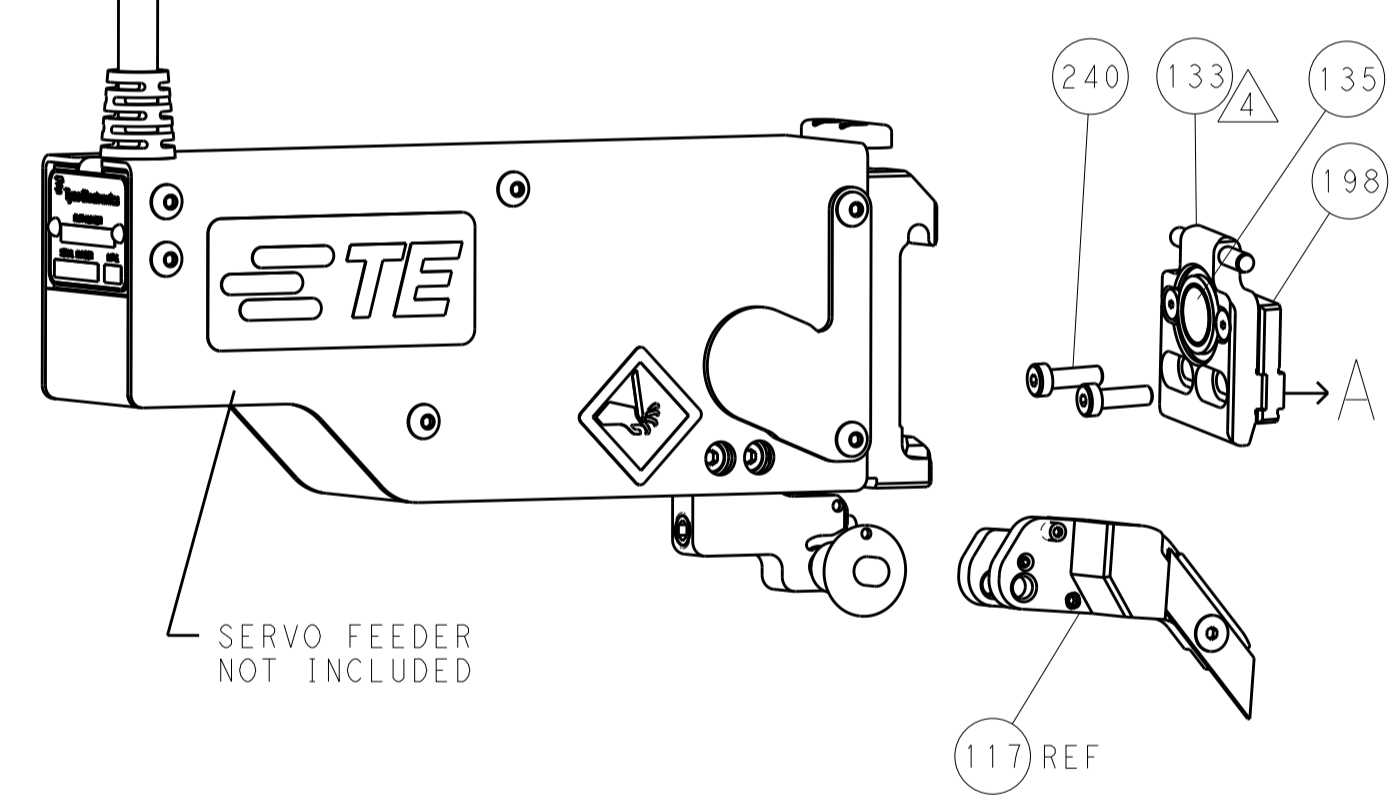
LOC	DIST	REV	DATE	BY	APPV
A	66				

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

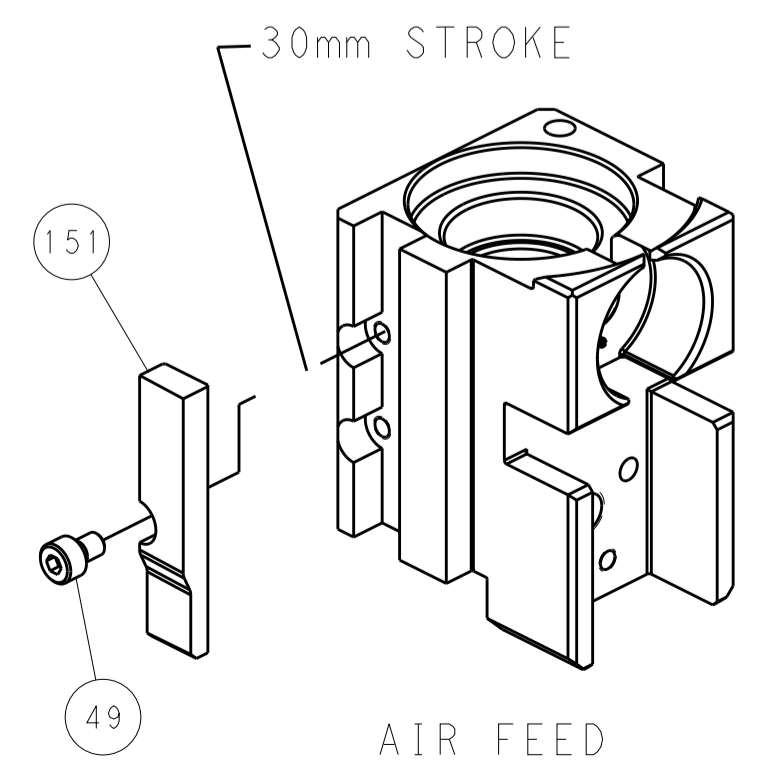
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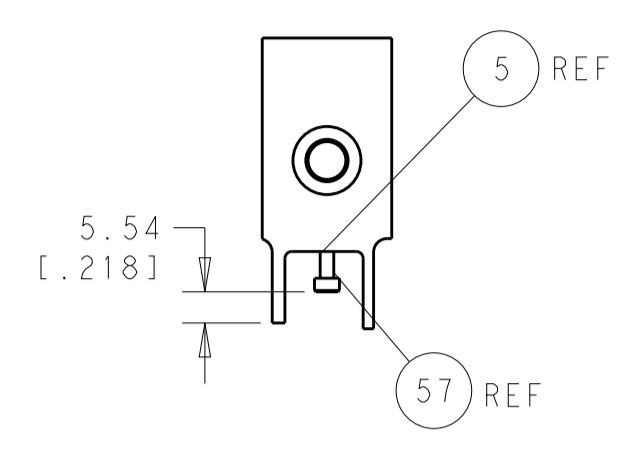
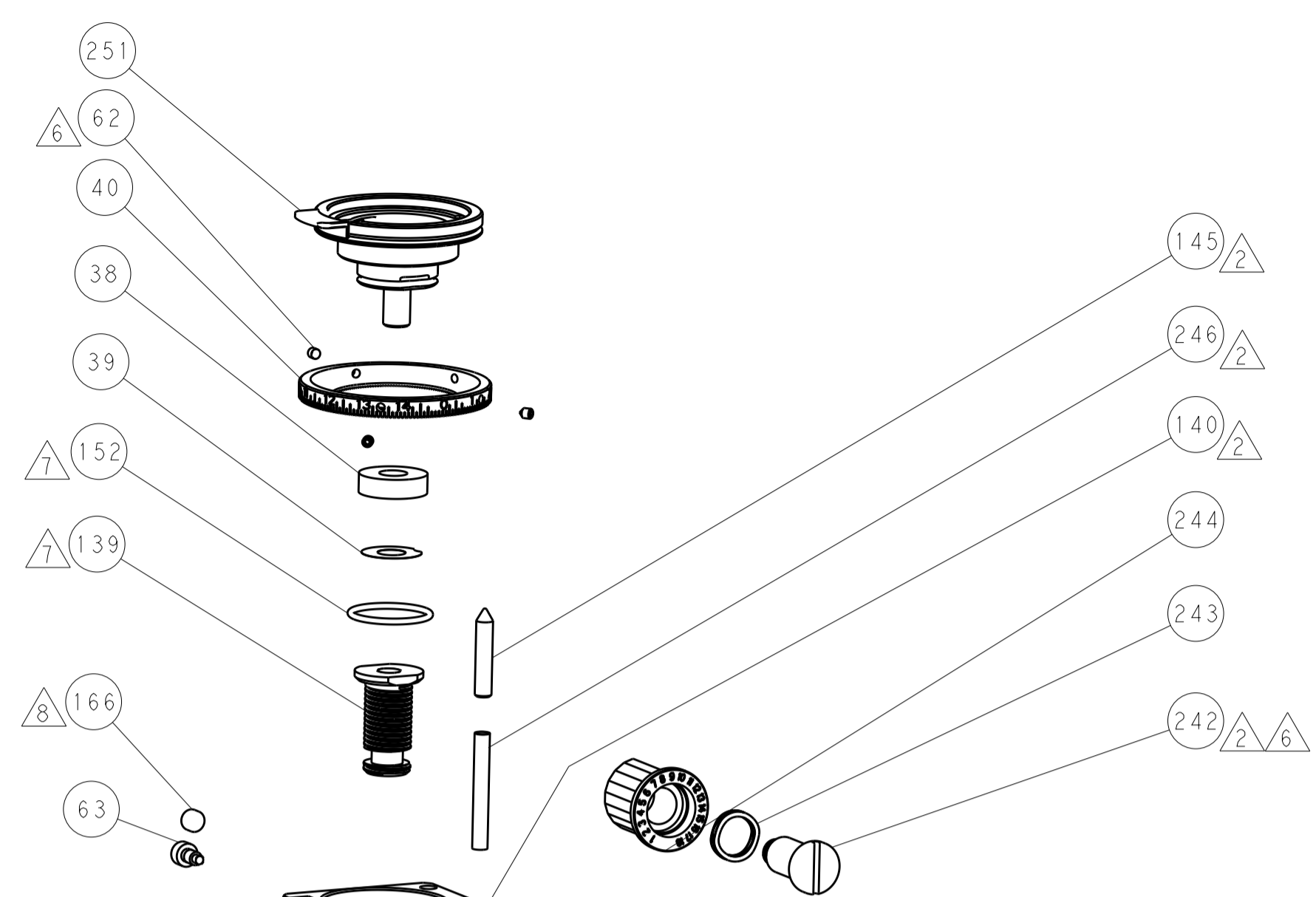
### SERVO LATCH PLATE



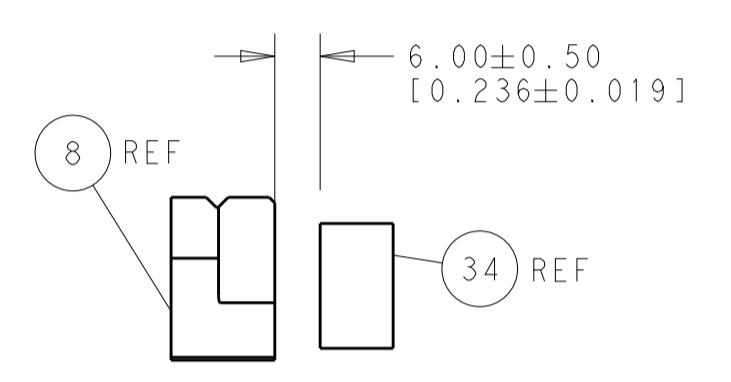
### CAM POSITION



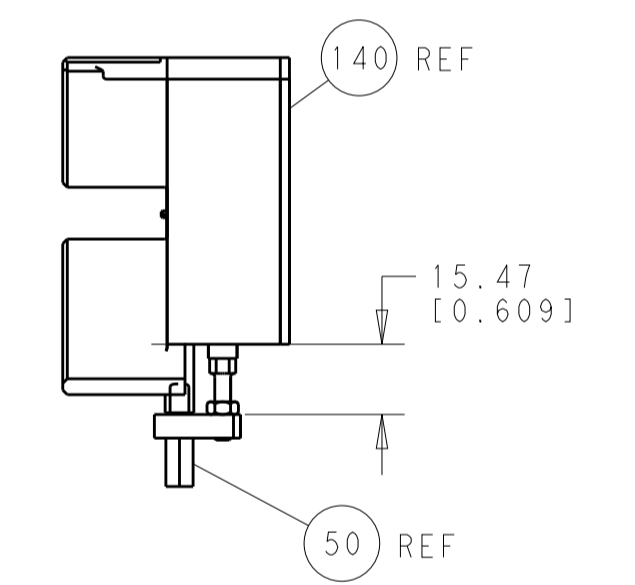
AIR FEED



SHEAR DEPRESSOR DETAIL

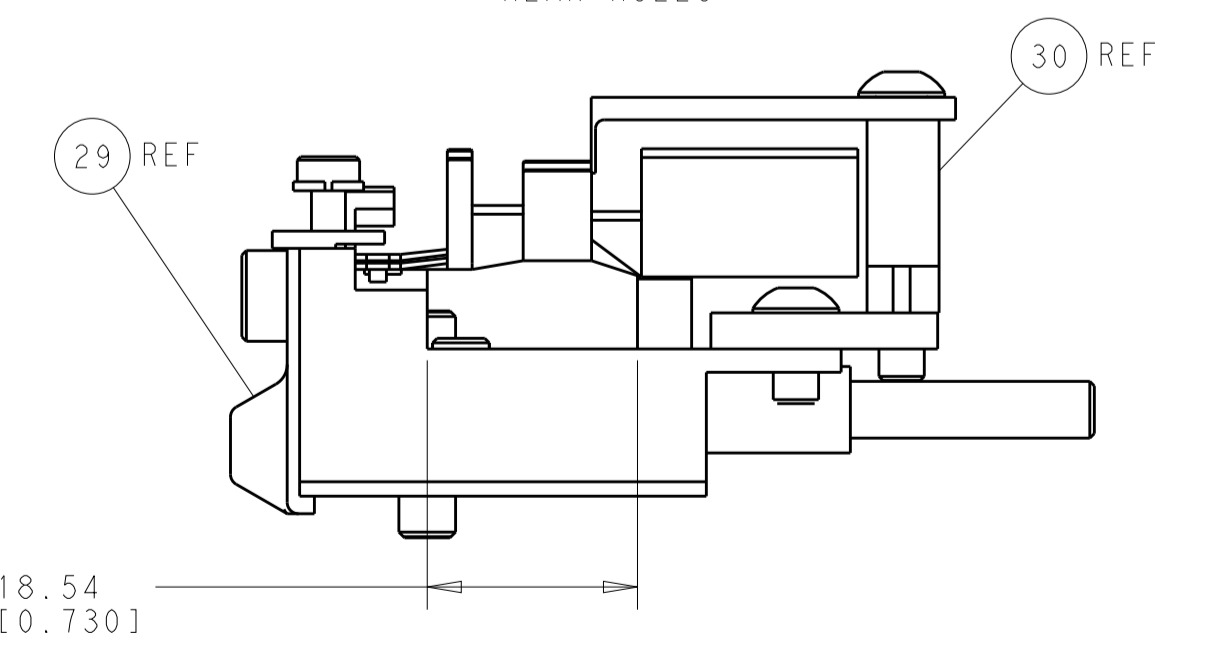


TERMINAL SUPPORT LOCATION

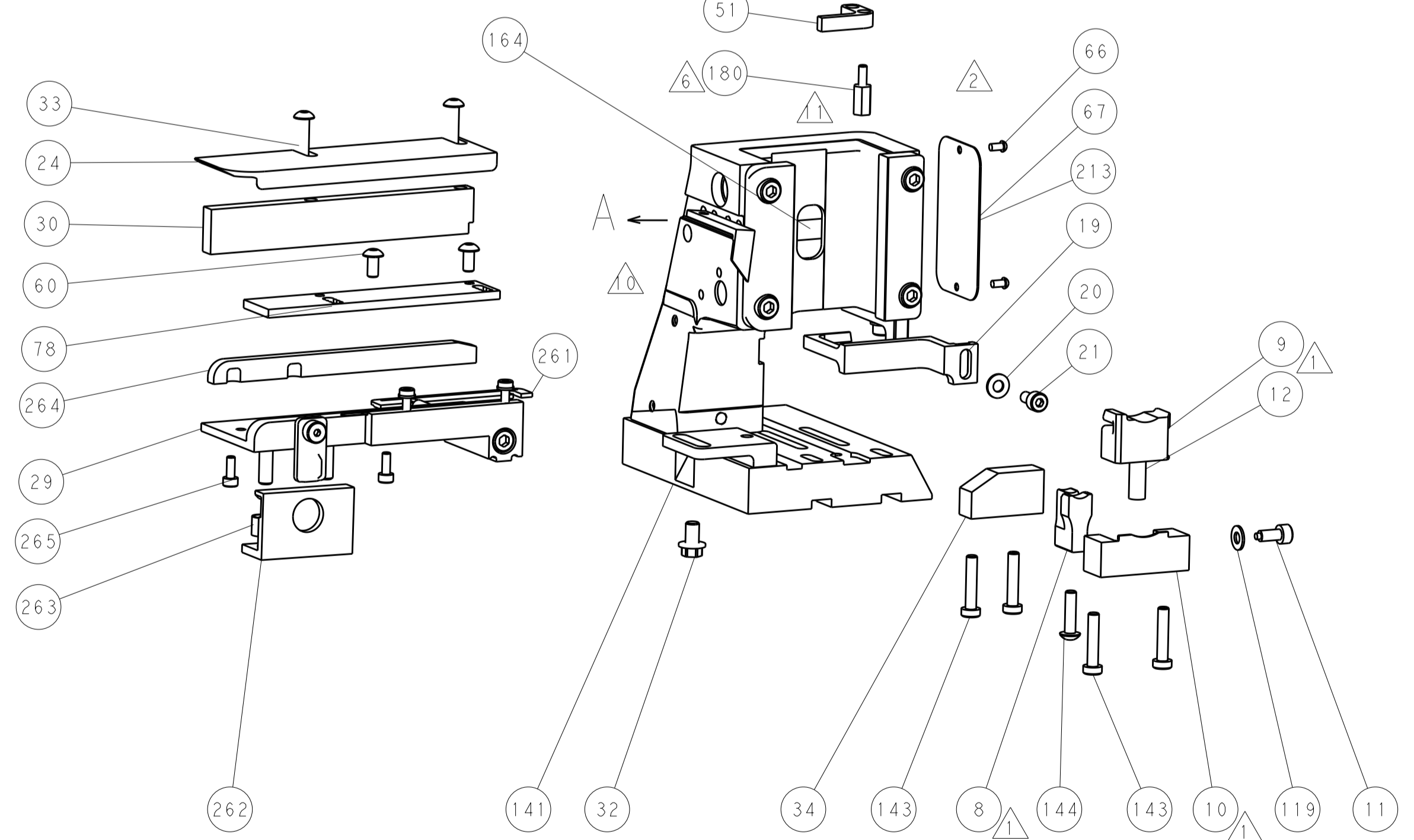


HOLDDOWN SET-UP

ITEM 30 LOCATED AT REAR HOLES



FEED TRACK POSITION GUIDE BY WIRE BARREL



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

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DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±0.0005	PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - MATERIAL: - FINISH: -	SCALE: 1:1 SHEET: 4 of 4 REV: A	CUSTOMER ACCESSIBLE PRODUCTION DRAWING