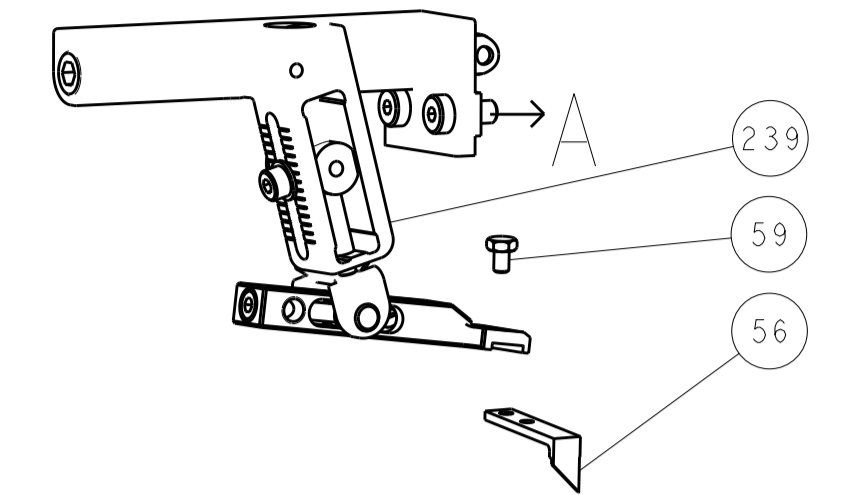


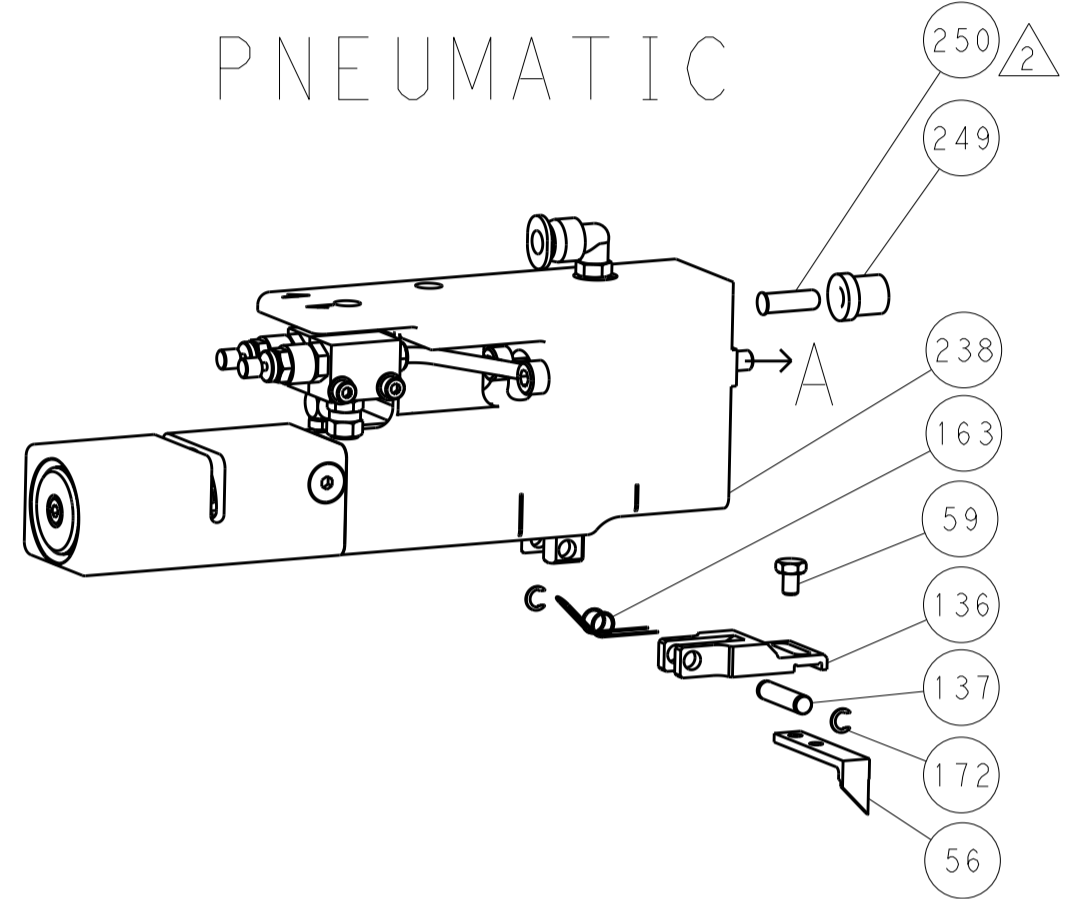


| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | OWN | APVD |
|     |    | -    | -   | SEE SHEET 1 | -    | -   | -    |

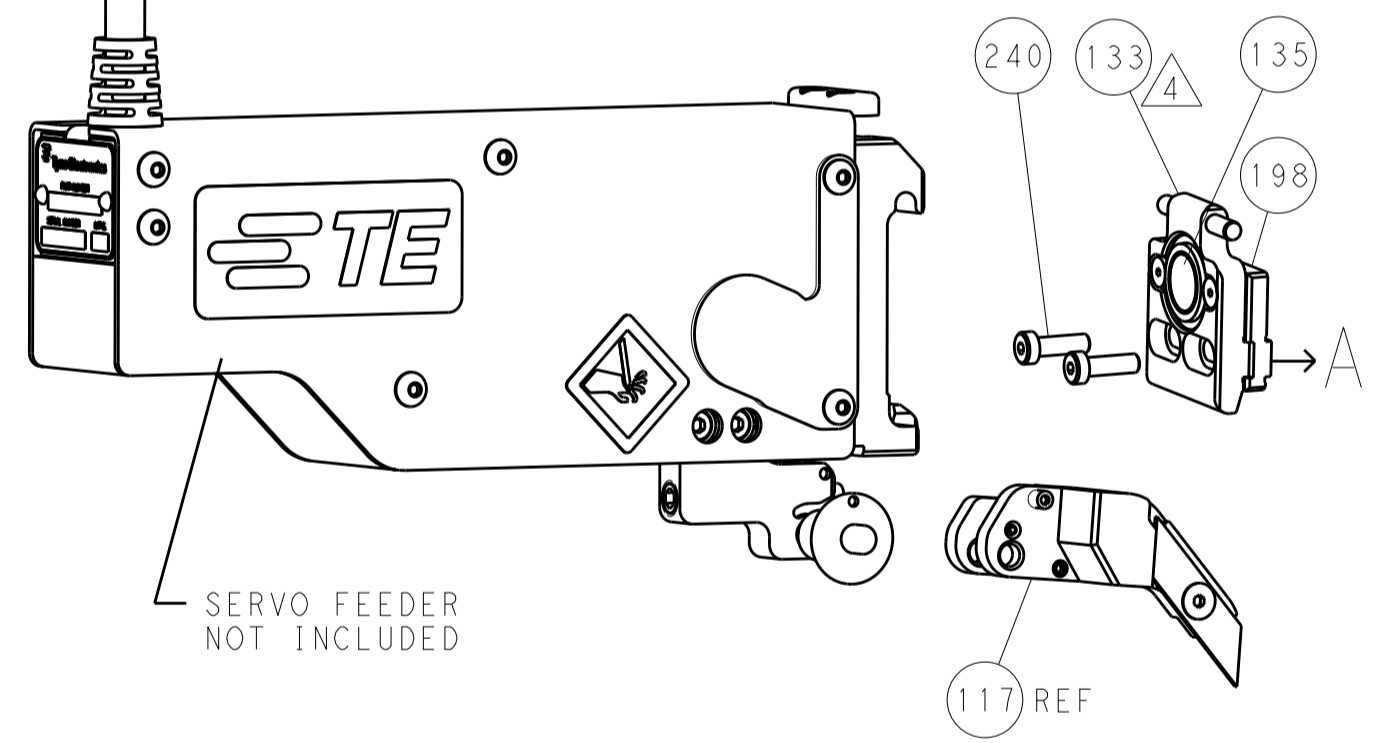
### FEED TYPE MECHANICAL



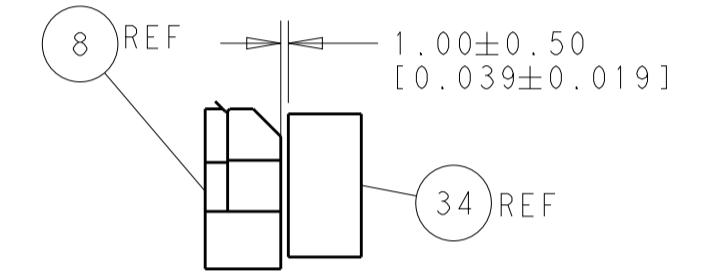
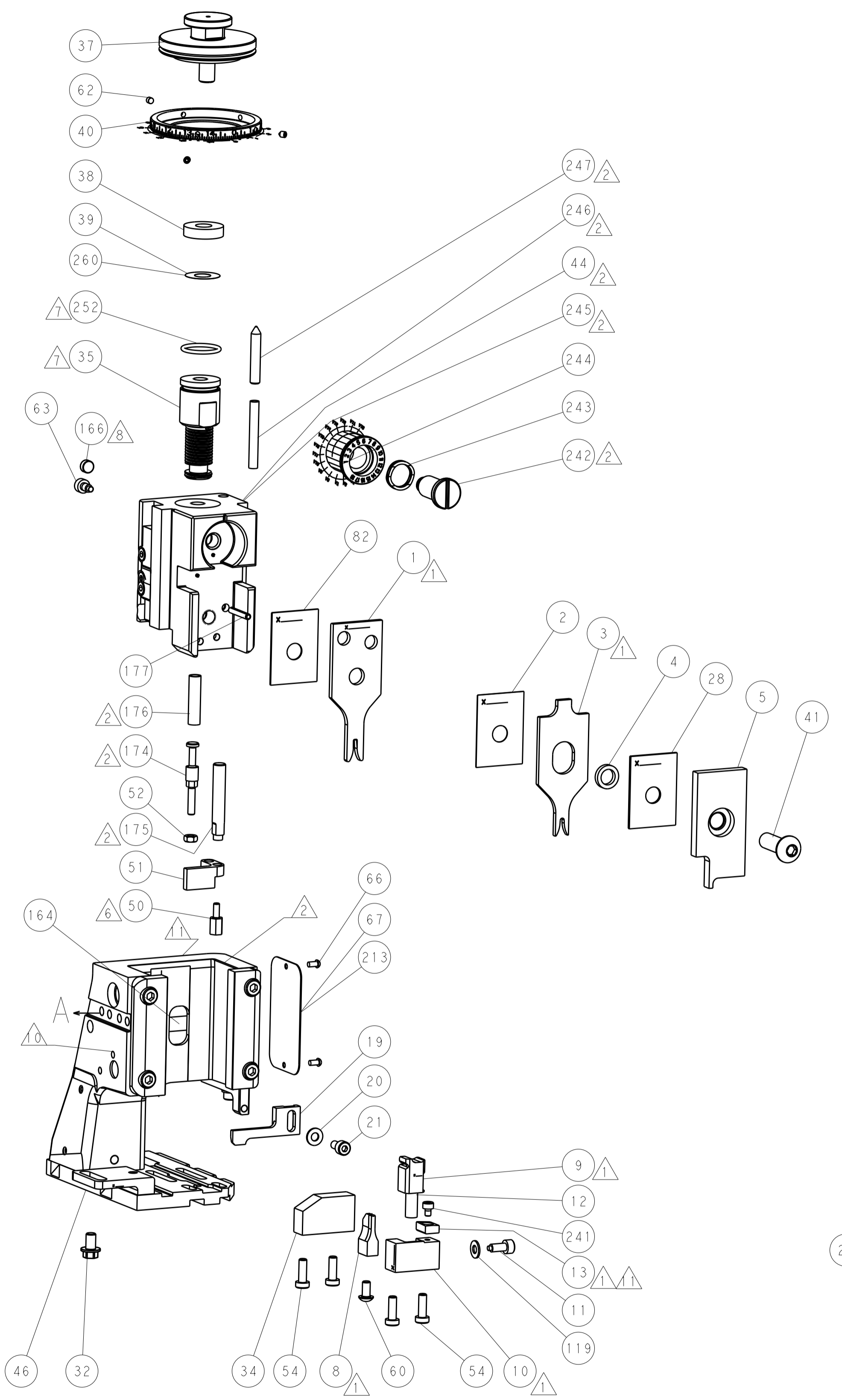
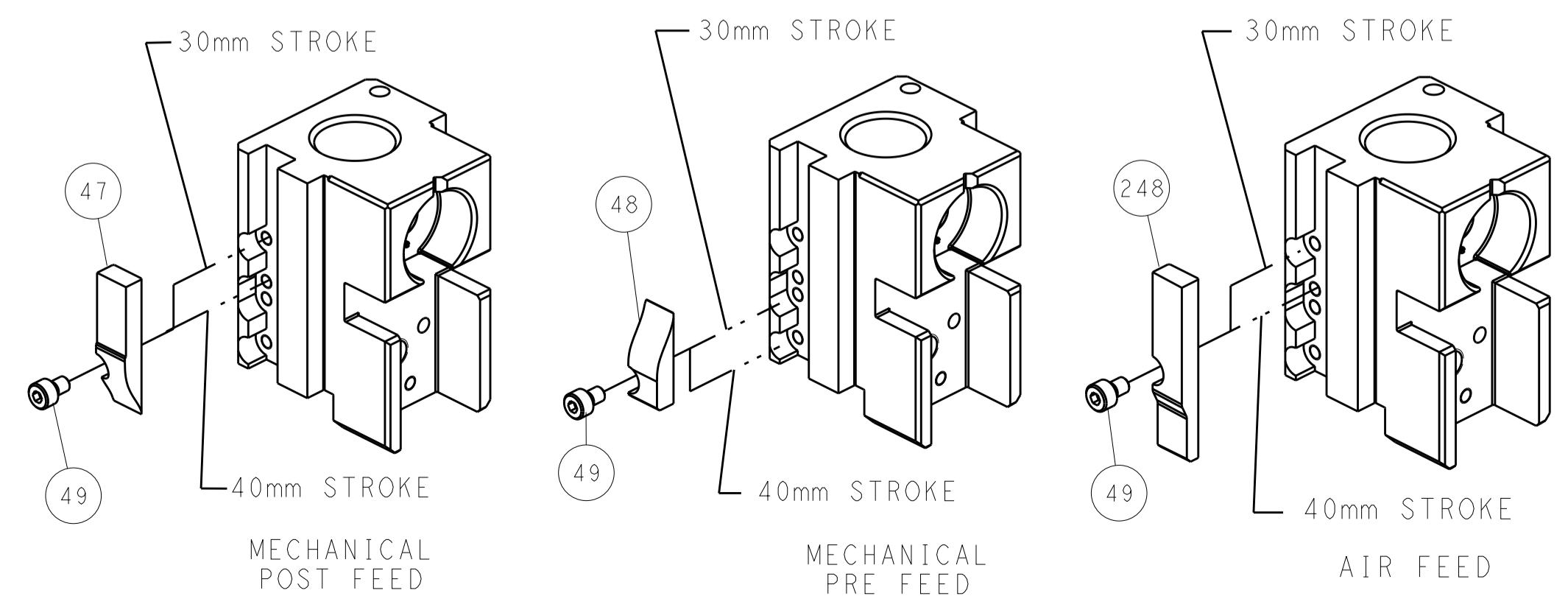
### PNEUMATIC



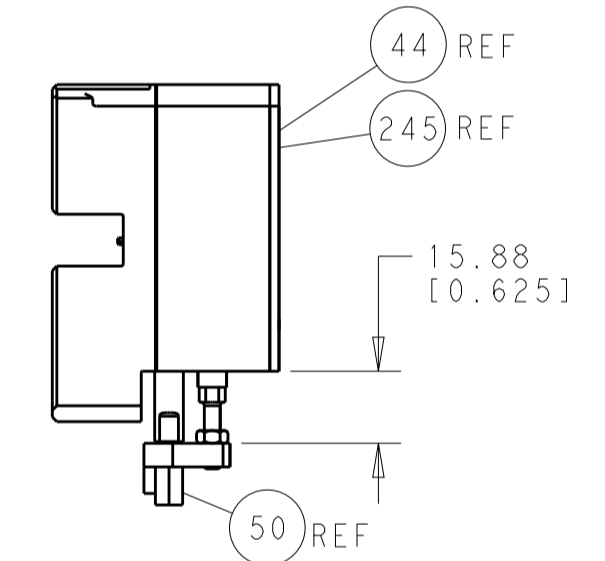
### SERVO LATCH PLATE



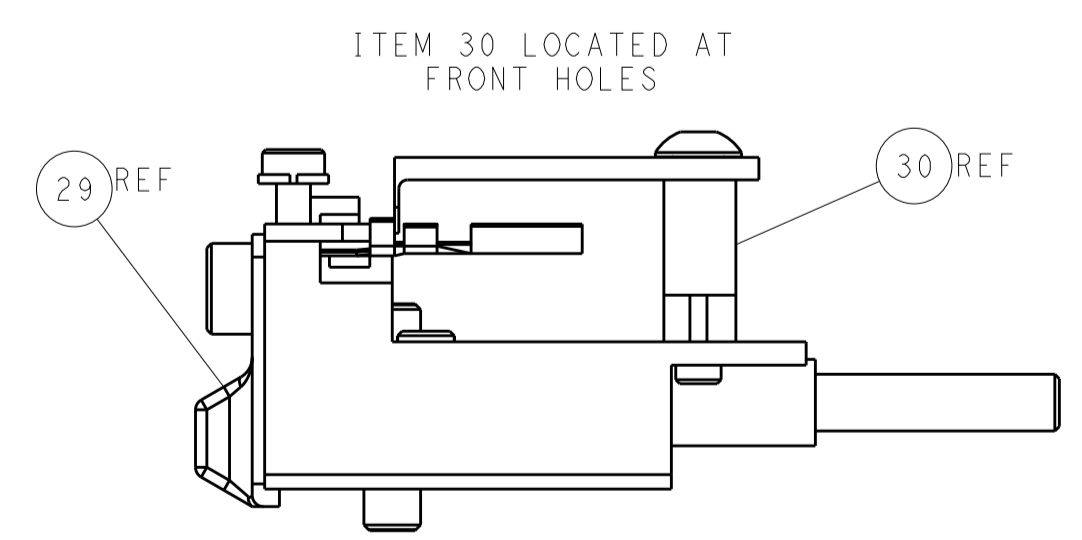
### CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

**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<br>T. YIN 04JUL2012                |               | TE Connectivity<br>Harrisburg, PA 17105-3608    |                                    |
| mm          | 0 PLC ±0.1 | 1 PLC ±0.1                             | 2 PLC ±0.02 | 3 PLC ±0.005                           | 4 PLC ±0.0005 | APVD<br>S. XI 04JUL2012                         | NAME<br>Ocean Side Feed Applicator |
| MATERIAL:   |            | FINISH:                                |             | WEIGHT:                                |               | SIZE CAGE CODE DRAWING NO<br>A1 00779 ©=2151704 |                                    |
|             |            |  |             | Customer Accessible Production Drawing |               | RESTRICTED TO<br>SCALE 1:1 SHEET 2 OF 4 REV A   |                                    |

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

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| PART NUMBER | REVISION    | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |           |             |           |           |                        |
|-------------|-------------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-----------|-------------|-----------|-----------|------------------------|
|             |             |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |           |             |           |           |                        |
|             | 2-2151704-1 | 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 | -         | 8-2151704-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|             |             |                          |                                |                                   | SMART APPLICATOR      | 2161326-1 | -         | 8-2151704-4 | -         | -         | -                      |
|             | 2-2151704-2 | A                        | FINE CRIMP HEIGHT ADJUST       | PNEUMATIC                         | MECHANICAL FEED       | 2119949-1 | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|             |             |                          |                                |                                   | SERVO LATCH PLATE     | 2119951-1 | -         | 8-2151704-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|             |             |                          |                                |                                   | SMART APPLICATOR      | 2161326-1 | -         | 8-2151704-4 | -         | -         | -                      |
| 2-2151704-5 | 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 |                        |
| 2-2151704-7 | A           | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -         | -           | -         | -         |                        |
| 7-2151704-7 | A           | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -         | -           | -         | -         |                        |

| APPLICATOR DATA                      |                  |      |
|--------------------------------------|------------------|------|
| CRIMP SIZE                           |                  | TYPE |
| WIRE                                 | 1.78 mm [ .070 ] | F    |
| INSUL                                | 2.29 mm [ .090 ] | O    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                  |      |

| TERMINAL DATA: TE TERMINAL                         |             | TE CRIMP SPECIFICATION                                      |
|--|-------------|---|
| TERMINAL NAME: MICRO-TIMER 1 WITH SPRING           |             |   |
| WIRE STRIP LENGTH<br>3.50-4.10 mm [ .138-.161 IN ] |             | INSULATION DIAMETER RANGE<br>Ø1.60-1.90 mm [ .063-.075 IN ] |
| TERMINAL APPLICATION SPECIFICATION<br>114-18163    |             |   |
| TERMINALS APPLIED                                  |             |   |
| TE TERMINAL  | TE TERMINAL | TE TERMINAL   |
| 928939-1   | 928939-3    | 928939-5  |
| 928939-2   | 928939-4    | 928939-6  |

| WIRE SIZE | CRIMP HEIGHT mm [ INCH ]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|------------------------------|--------------------------------|
| 0.75mm2   | 1.27+/-0.05 [ .050+/- .002 ] | 12.1                           |
| 0.50mm2   | 1.16+/-0.05 [ .046+/- .002 ] | 13.0                           |
| 0.35mm2   | 1.09+/-0.05 [ .043+/- .002 ] | 14.0                           |



- 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: 8-2151704-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151704-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151704-5
- 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 ITEM 50.
- 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.

|     |     |     |     |     |           |                                     |         |
|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 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     |
| -77 | -27 | -25 | -22 | -21 | 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 |      |      | REVIEWS |    |     |
|--------------|------|------|---------|----|-----|
| LOC          | DIST | DATE | REV     | BY | CHK |
| A            | 66   |      |         |    |     |

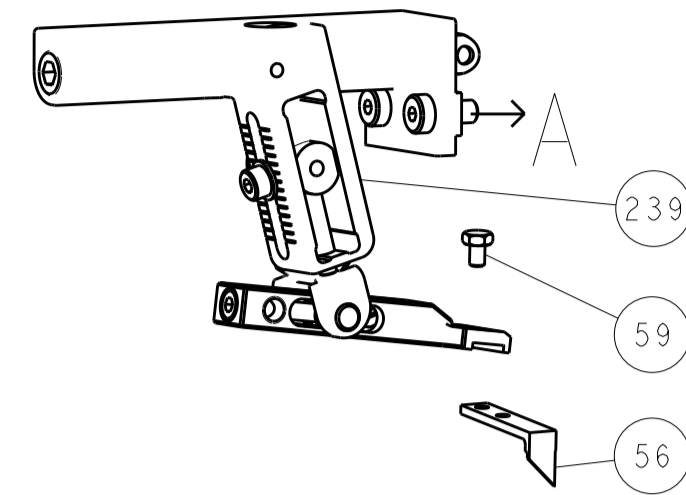
| P | LTN | DESCRIPTION | DATE | QTY | APVD        |
|---|-----|-------------|------|-----|-------------|
| - | -   | SEE SHEET 1 | -    | -   | -           |
| - | 1   | 1           | 1    | 1   | 1-22279-3   |
| - | 1   | 1           | 1    | 1   | 2119082-9   |
| - | 1   | 1           | 1    | 1   | 2079764-1   |
| - | 1   | 1           | 1    | 1   | 2119083-1   |
| - | 1   | 1           | 1    | 1   | 7-18023-7   |
| - | -   | 2           | -    | -   | 2168400-6   |
| - | -   | -           | -    | 1   | 2119580-1   |
| - | -   | -           | 1    | -   | 2063440-1   |
| - | -   | 1           | -    | -   | 2119740-2   |
| - | -   | 1           | -    | -   | 1901094-3   |
| - | 1   | 1           | 1    | 1   | 993111-1    |
| - | 1   | 1           | 1    | 1   | 8-22280-7   |
| - | 1   | 1           | 1    | 1   | 1752353-2   |
| - | 1   | 1           | 1    | 1   | 1901680-2   |
| - | -   | -           | 2    | -   | 21045-3     |
| - | 1   | 1           | 1    | 1   | 994969-1    |
| - | REF | REF         | REF  | -   | 994970-2    |
| - | -   | -           | 1    | -   | 240638-1    |
| - | 1   | 1           | 1    | 1   | 8-21084-1   |
| - | -   | -           | 1    | -   | 2119641-2   |
| - | 1   | 1           | 1    | 1   | 2119798-2   |
| - | 1   | 1           | 1    | 1   | 2079383-8   |
| - | 4   | 4           | 4    | 4   | 2168400-5   |
| - | -   | -           | -    | 1   | 2119653-2   |
| - | 1   | 1           | 1    | 1   | 1-2119656-0 |
| - | 1   | 1           | 1    | 1   | 2119650-1   |
| - | 1   | 1           | 1    | 1   | 2119092-2   |
| - | -   | -           | 1    | -   | 3-23627-7   |
| - | -   | -           | 1    | -   | 2119799-1   |
| - | -   | REF         | -    | -   | SEE NOTE 4  |
| - | -   | 1           | -    | -   | 1633743-1   |
| - | 1   | 1           | 1    | 1   | 1-18028-2   |
| - | -   | REF         | -    | -   | 2119944-1   |
| - | 1   | 1           | 1    | 1   | 455888-6    |
| - | 1   | 1           | 1    | 1   | 2119956-1   |
| - | 1   | -           | 1    | 1   | 2119740-1   |
| - | 2   | 2           | 2    | 2   | 2168078-1   |
| - | 1   | 1           | 1    | 1   | 2119793-1   |
| - | 3   | 3           | 3    | 3   | 992763-5    |
| - | -   | -           | 1    | 1   | 5-18022-5   |
| - | -   | -           | 1    | 1   | 1338685-1   |
| - | 1   | 1           | 1    | 1   | 1-5018030-0 |
| - | 1   | 1           | 1    | 1   | 1901681-1   |
| - | 1   | 1           | 1    | 1   | 1-1752354-8 |
| - | -   | -           | 1    | 2   | 18023-9     |
| - | -   | -           | -    | 1   | 2119652-1   |
| - | 1   | 1           | 1    | 1   | 2079383-7   |
| - | 1   | 1           | 1    | 1   | 2119645-1   |
| - | 1   | 1           | 1    | 1   | 2119957-1   |
| - | 1   | 1           | 1    | 1   | 2119644-2   |
| - | 1   | 1           | 1    | 1   | 3-1752356-3 |
| - | 2   | 2           | 2    | 2   | 2079383-5   |
| - | 1   | 1           | 1    | 1   | 2161328-1   |
| - | 1   | 1           | 1    | 1   | 1320908-3   |
| - | 1   | 1           | 1    | 1   | 2119959-1   |
| - | 1   | 1           | 1    | 1   | 1-455888-0  |
| - | 1   | 1           | 1    | 1   | 1320928-2   |
| - | 1   | 1           | 1    | 1   | 2168083-2   |
| - | 1   | 1           | 1    | 1   | 1-18028-2   |
| - | 1   | 1           | 1    | 1   | 2119533-1   |
| - | 1   | 1           | 1    | 1   | 2119806-1   |
| - | 1   | 1           | 1    | 1   | 3-22280-3   |
| - | 1   | 1           | 1    | 1   | 1-356885-4  |
| - | 1   | 1           | 1    | 1   | 2119805-1   |
| - | 1   | 1           | 1    | 1   | 462006-6    |
| - | 1   | 1           | 1    | 1   | 1633919-5   |
| - | -   | -           | -    | -   | -           |
| - | -   | -           | -    | -   | -           |
| - | 1   | 1           | 1    | 1   | 2119757-8   |
| - | 1   | 1           | 1    | 1   | 238011-4    |
| - | 1   | 1           | 1    | 1   | 1633965-4   |
| - | 1   | 1           | 1    | 1   | 455888-3    |
| - | 1   | 1           | 1    | 1   | 3-456404-0  |

| DIMENSIONS: |              | TOLERANCES UNLESS OTHERWISE SPECIFIED: |             | OWN    | CHK       | DATE                | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
|-------------|--------------|--|-------------|--------|-----------|---------------------|--|--|
| mm          | 0 PLC ±      | 1 PLC ±0.1                             | 2 PLC ±0.02 | S. YIN | G. BAILEY | 04 JUL 2012         | NAME   |  |
|             | 3 PLC ±0.005 | 4 PLC ±0.0005                          | ANGLES ±    | S. XI  | G. BAILEY | 04 JUL 2012         | Ocean Side Feed<br>Applicator                |  |
| MATERIAL    |              | FINISH                                 |             | APVD   |           | SIZE                |  | RESTRICTED TO                          |
| -           |              | -                                      |             | -      |           | A   00779 ©=2151704 |  | Customer Accessible Production Drawing |
|             |              |  |             | SCALE  |           | SHEET 3 of 4        |  | REV A                                  |

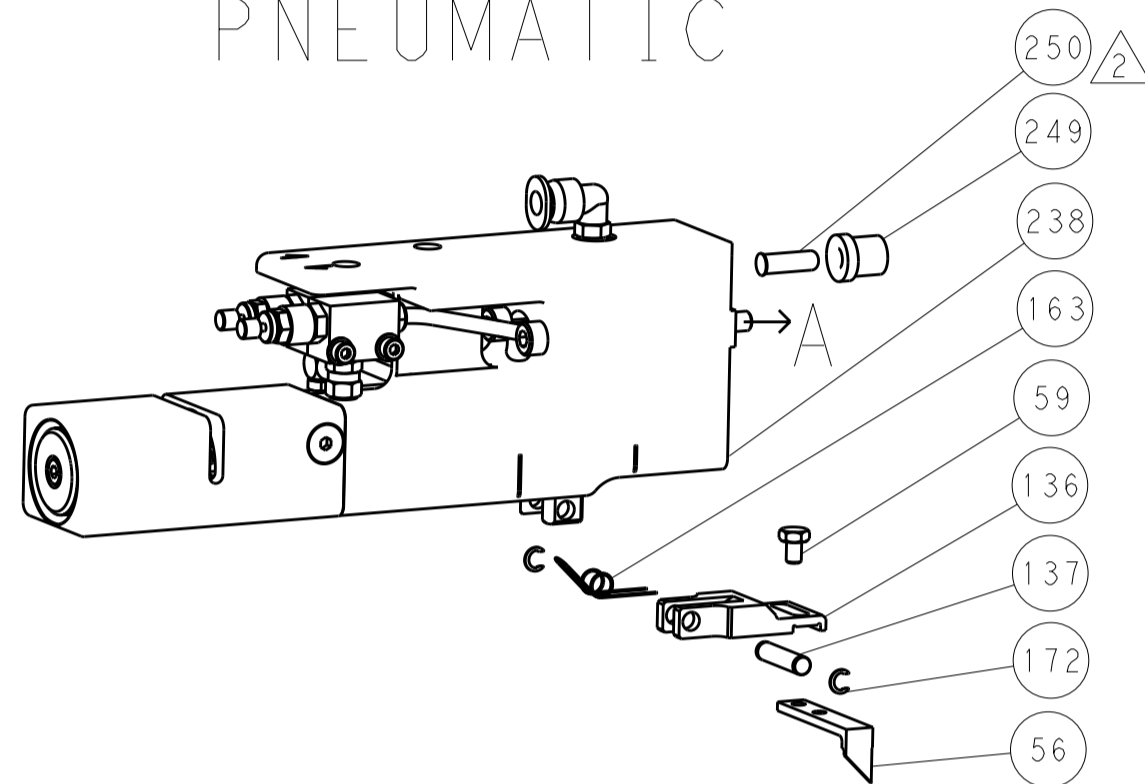
| LOC | DIST | REVISIONS |     |             |      |     |      |
|-----|------|-----------|-----|-------------|------|-----|------|
|     |      | P         | LTN | DESCRIPTION | DATE | OWN | APVD |
| A   | 66   | -         | -   | SEE SHEET 1 | -    | -   | -    |

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

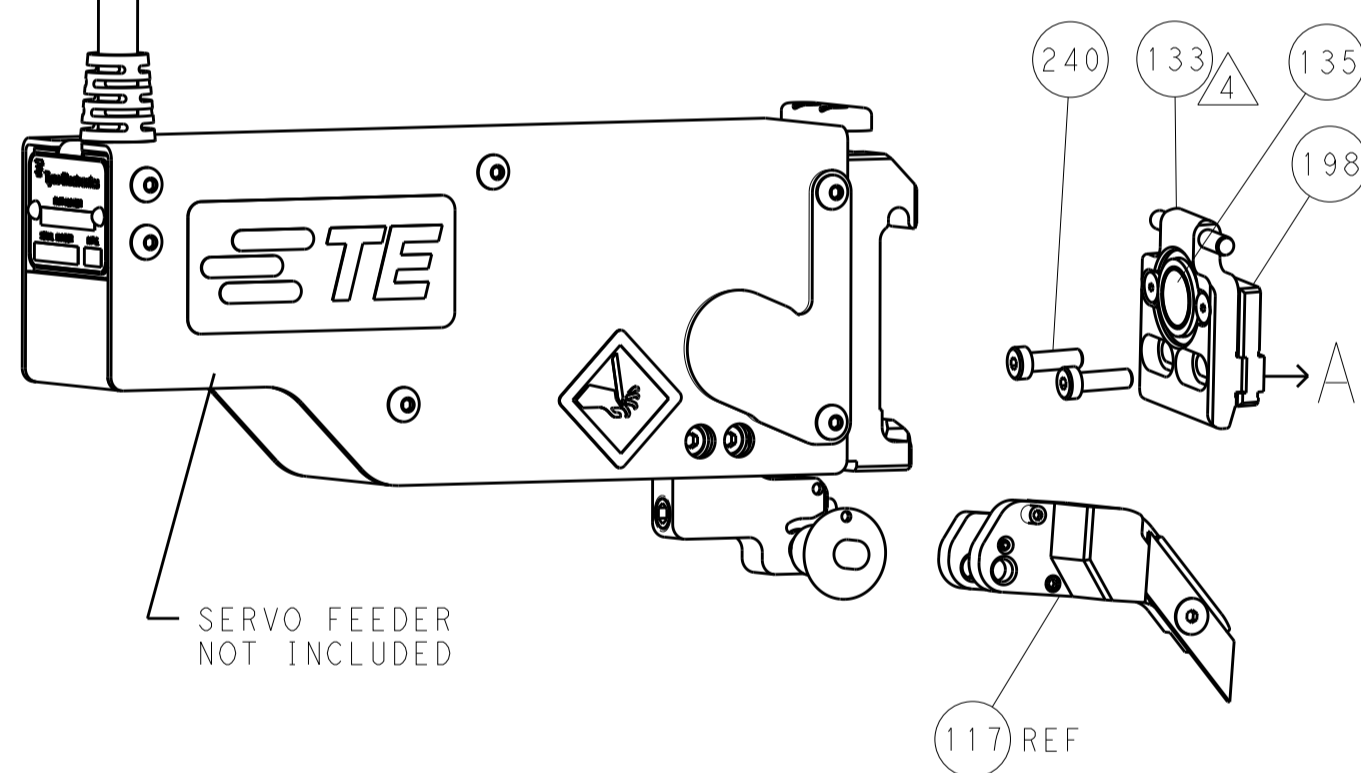
## FEED TYPE MECHANICAL



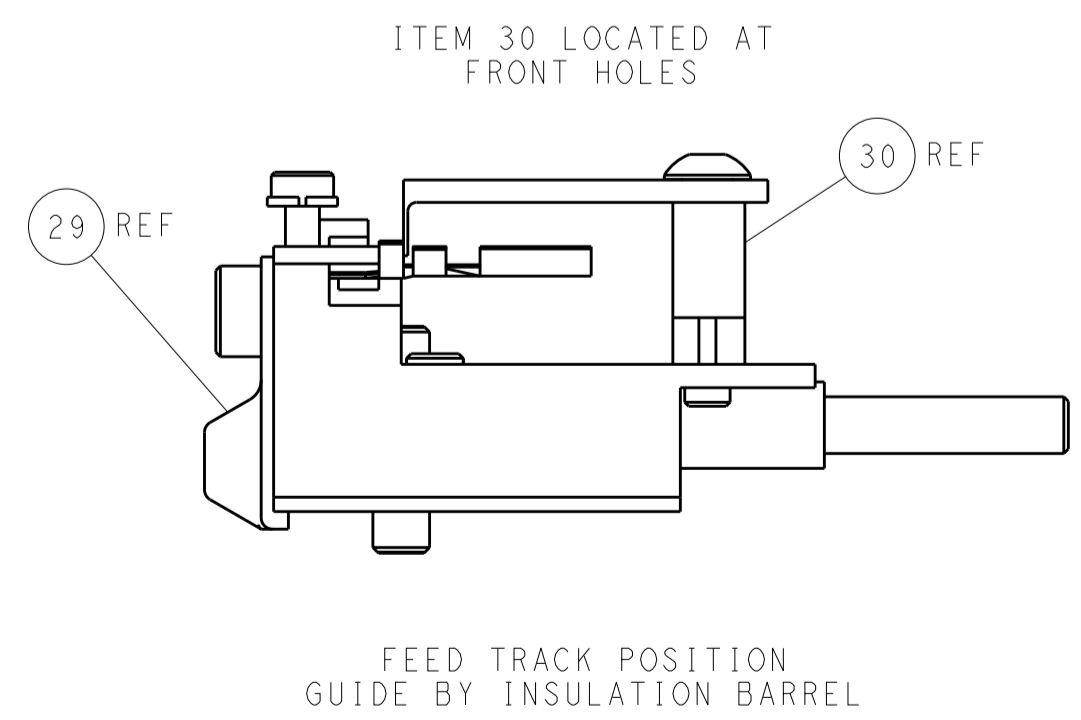
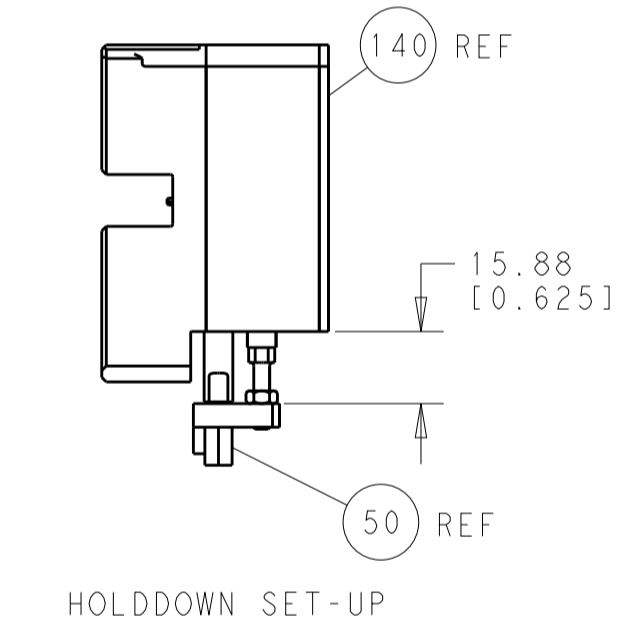
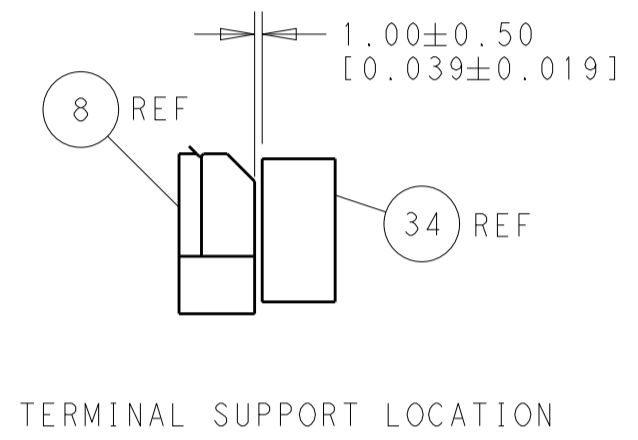
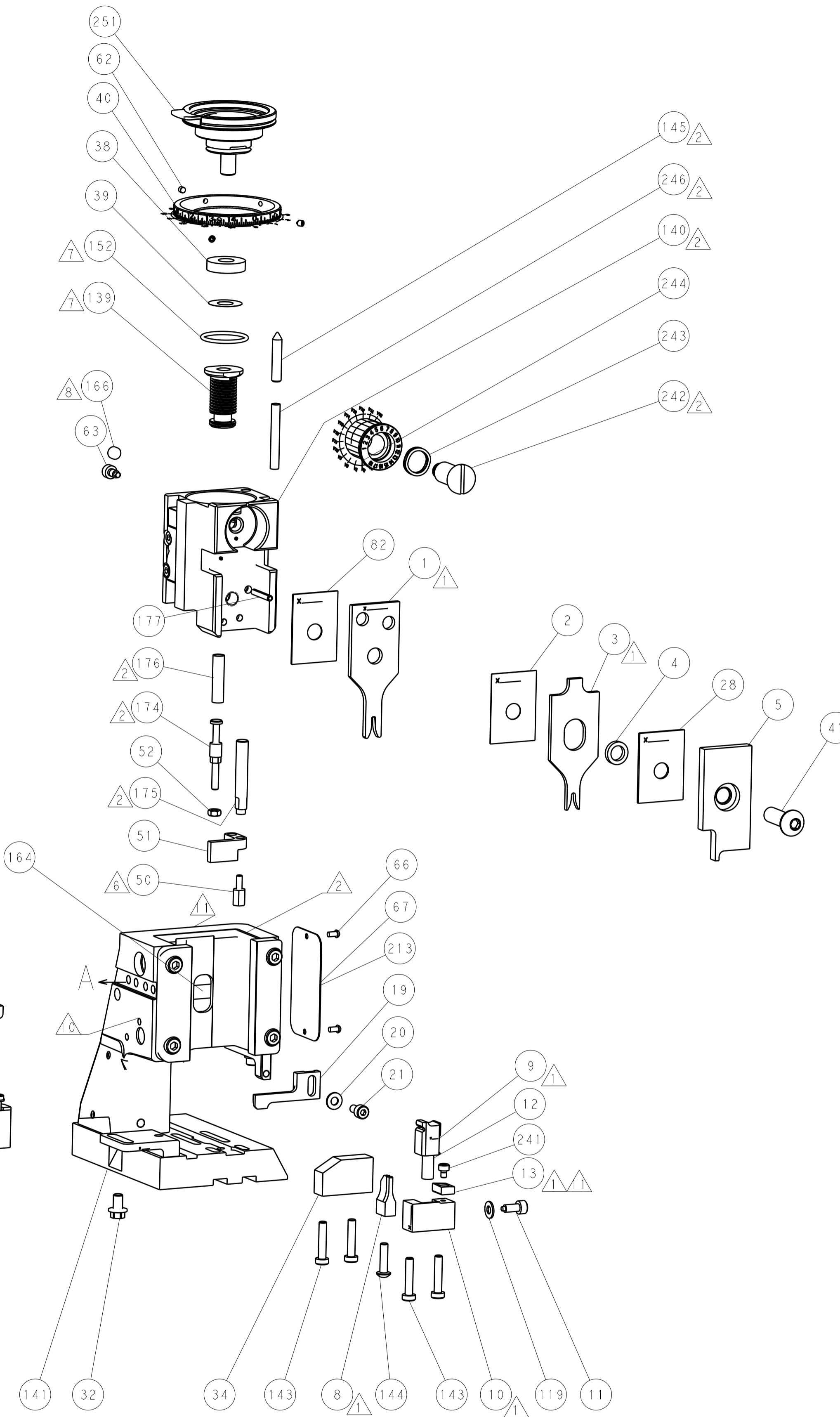
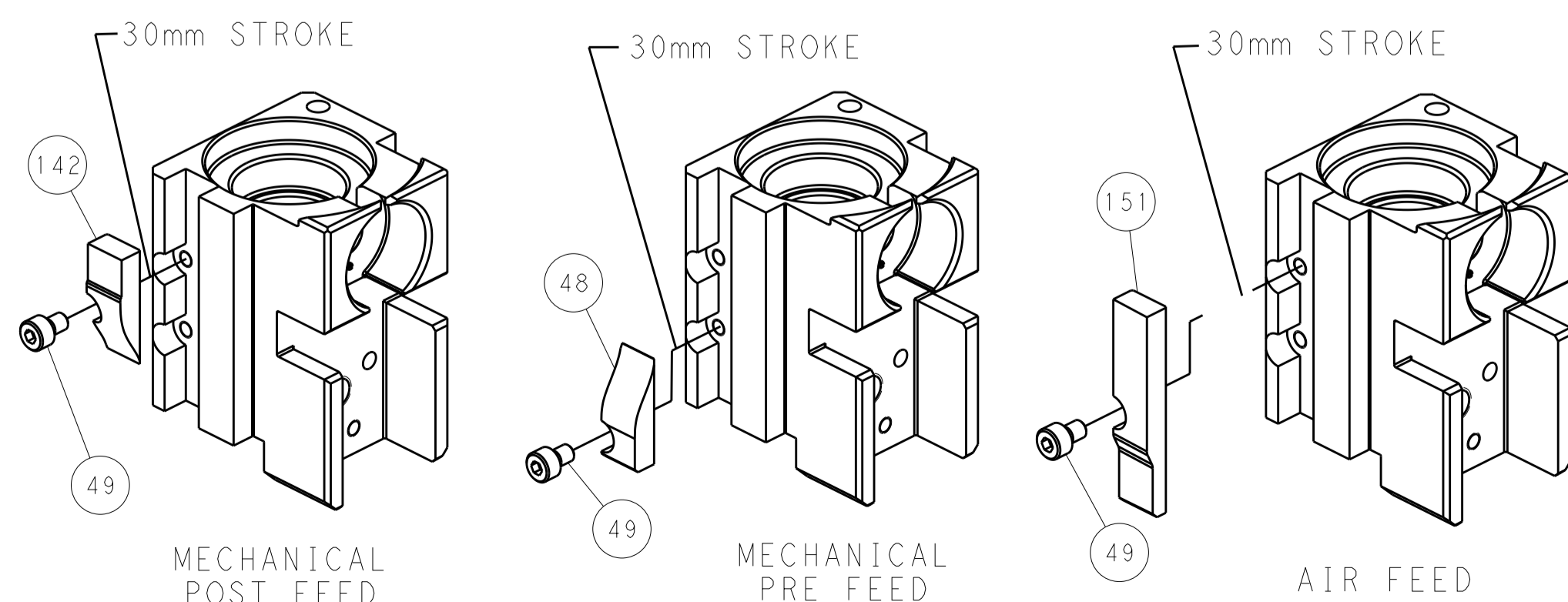
## PNEUMATIC



## 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: |             | DWG: Y. YIN 04JUL2012 |               | TE Connectivity |                           |
| mm                                     | 0 PLC ±0.1 | 1 PLC ±0.1                             | 2 PLC ±0.02 | 3 PLC ±0.005          | 4 PLC ±0.0005 | ANGLES ±        | Harrisburg, PA 17105-3608 |
| MATERIAL:                              | FINISH:    | WEIGHT:                                | SCALE:      | SIZE:                 | CAGE CODE:    | DRAWING NO:     | RESTRICTED TO:            |
| -                                      | -          | -                                      | 1:1         | A1                    | 00779         | 2151704         | -                         |
| Customer Accessible Production Drawing |            |  |             | SHEET 4 OF 4 REV A    |               |                 |                           |