

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |             |                        |
|---|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
|   |             |          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |             |                        |
|   | 2151811-2   | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | -                                 | -                     | -         | -           | -         | -           |                        |
|   | 2151811-5   | B        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151811-5 | 1901094-3 | 2-1752354-0 | 2168400-6 (QUANTITY 2) |
|   | 2151811-6   | B        | NON-CRIMP HEIGHT ADJUST  | SERVO LATCH PLATE <sup>4</sup> | PNEUMATIC FEED                    | 2119950-1             | 1338683-8 | 5-18022-5   | 2119641-1 | 2119799-1   | 2063440-2              |
|   | 2151811-7   | B        | FINE CRIMP HEIGHT ADJUST | NONE                           | -                                 | -                     | -         | -           | -         | -           | -                      |
|   | 7-2151811-7 | A        | CRIMP TOOLING KIT        | -                              | -                                 | -                     | -         | -           | -         | -           | -                      |

| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 3.56 mm [1.40] | F    |
| INSUL           | 4.57 mm [1.80] | F    |

APPLICATOR INSTRUCTIONS  
408-10389

| TERMINAL DATA: TE TERMINAL             |             | TE CRIMP SPECIFICATION       |             |
|--|-------------|------------------------------|-------------|
| TERMINAL NAME: Ring Tongue Terminal M4 |             |                              |             |
| WIRE STRIP LENGTH                      |             | INSULATION DIAMETER RANGE    |             |
| 5.50-6.00 mm [2.17-.236 IN]            |             | Ø3.10-4.20 mm [1.22-.165 IN] |             |
| TERMINAL APPLICATION SPECIFICATION     | 114-101016  |                              |             |
| TERMINALS APPLIED <sup>10</sup>        |             |                              |             |
| TE TERMINAL                            | TE TERMINAL | TE TERMINAL                  | TE TERMINAL |
| 2050216-1                              | 2050216-3   |                              |             |

| WIRE SIZE           | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|----------------------------|--------------------------------|
| 2.50mm <sup>2</sup> | 2.57+/-0.05 [1.01+/-0.002] | 6.2                            |
| 2.00mm <sup>2</sup> | 2.43+/-0.05 [0.96+/-0.002] | 7.8                            |
| 1.50mm <sup>2</sup> | 2.33+/-0.05 [0.92+/-0.002] | 8.9                            |

- <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: 8-2151811-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151811-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151811-6
- 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  
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.  
 FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
- <sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- <sup>8</sup> MAGNET, ITEM 166 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> 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.
- <sup>12</sup> WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.23.

**\*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  | -  | -  | 2119957-2 | APPLICATOR SHIM PACK                | 260     |
| -   | 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     |
| -   | -  | 1  | -  | 1  | 1-22279-3 | SPRING, COMPRESSION                 | 246     |
| -   | -  | 1  | -  | -  | 2119758-1 | RAM, AMP STYLE, SIDE FEED, 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     |
| -   | 1  | 1  | 1  | 1  | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0            | 241     |
| -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         |     | RELEASED      | 17FEB2013 | KH  | SX   |
|              |  |     |      | B         |     | ECR-14-011976 | 08AUG2014 | KH  | JT   |

|     |     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | -   | 2   | 2   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16       | 240     |
| -   | -   | -   | -   | 1   | 2063440-2   | AIR FEED MODULE                     | 238     |
| -   | 2   | 2   | 2   | 2   | 1-2079383-0 | SCR, BHSC, RoHS (M3 X 6)            | 230     |
| -   | -   | 1   | 1   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213     |
| -   | -   | 1   | 1   | -   | 1901094-3   | SPACER, FEEDER                      | 198     |
| -   | 1   | 1   | 1   | 1   | 2-1752354-0 | STANDOFF, HOLD-DOWN                 | 180     |
| -   | 1   | 1   | 1   | 1   | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0      | 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     |
| -   | REF | -   | -   | 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   | 1-18028-2   | WASHER, FLAT, REG M4                | 119     |
| -   | -   | REF | REF | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| -   | 1   | 1   | 1   | 1   | 1-690438-0  | FRONT STRIP GUIDE                   | 96      |
| -   | 2   | 2   | 2   | 2   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95      |
| -   | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 82      |
| -   | 1   | 1   | 1   | 1   | 1633782-3   | FENCE                               | 78      |
| -   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70      |
| -   | 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   | 1338683-8   | 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      |
| -   | 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   | 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   | 2119644-3   | 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   | 1752356-3   | 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   | 2-1320908-9 | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 1   | 2119959-3   | ASSEMBLY, STRIP GUIDE               | 29      |
| -   | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28      |
| -   | 2   | 2   | 2   | 2   | 22283-1     | 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   | 1320928-2   | STRIP GUIDE                         | 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   | 2119806-1   | INSERT, SHEAR                       | 13      |
| -   | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12      |
| -   | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11      |
| -   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
| -   | 1   | 1   | 1   | 1   | 462006-6    | FLOATING SHEAR, FRONT               | 9       |
| 1   | 1   | 1   | 1   | 1   | 1-1633932-9 | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 1   | 1-2119757-3 | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 1   | 238011-4    | BLOCK, CRIMPER SPACER               | 4       |
| 1   | 1   | 1   | 1   | 1   | 2-1633961-7 | CRIMPER, INSULATION F PREMIUM       | 3       |
| -   | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 2       |
| 1   | 1   | 1   | 1   | 1   | 2-456411-9  | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -7  | -6  | -5  | -2  | PART NO     | DESCRIPTION                         | ITEM NO |

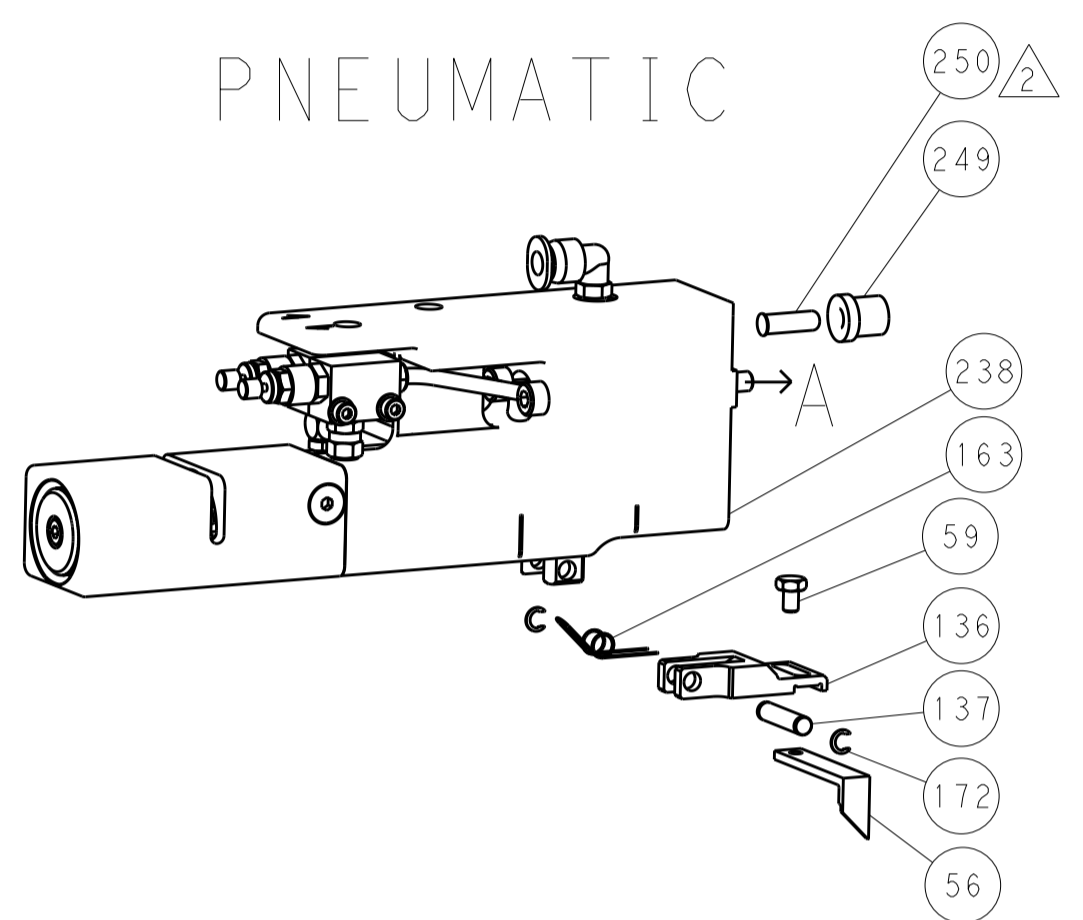
| DIMENSIONS: |               | TOLERANCES UNLESS OTHERWISE SPECIFIED: |           | DRAWING NO |           |
|-------------|---------------|--|-----------|------------|-----------|
| mm          | 0 PLC ±.5     | 1 PLC ±.5                              | 2 PLC ±.5 | 3 PLC ±.5  | 4 PLC ±.5 |
|             | ANGLES ±.0001 |  |           |            |           |
| MATERIAL:   | FINISH:       | WEIGHT:                                | SCALE:    | SHEET:     | REV:      |
|             |               |  | 1:2       | 1 OF 4     | B         |

Customer Accessible Production Drawing

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

### FEED TYPE

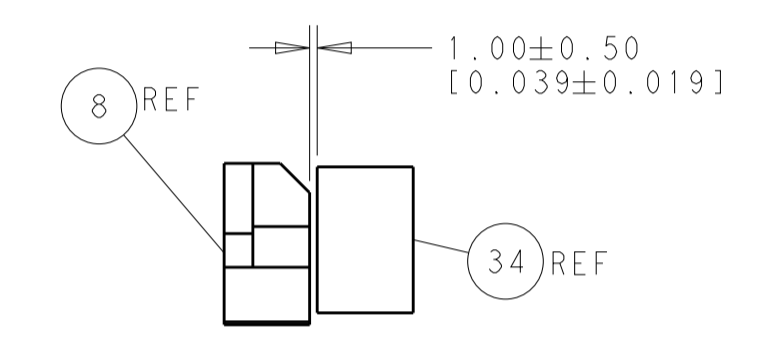
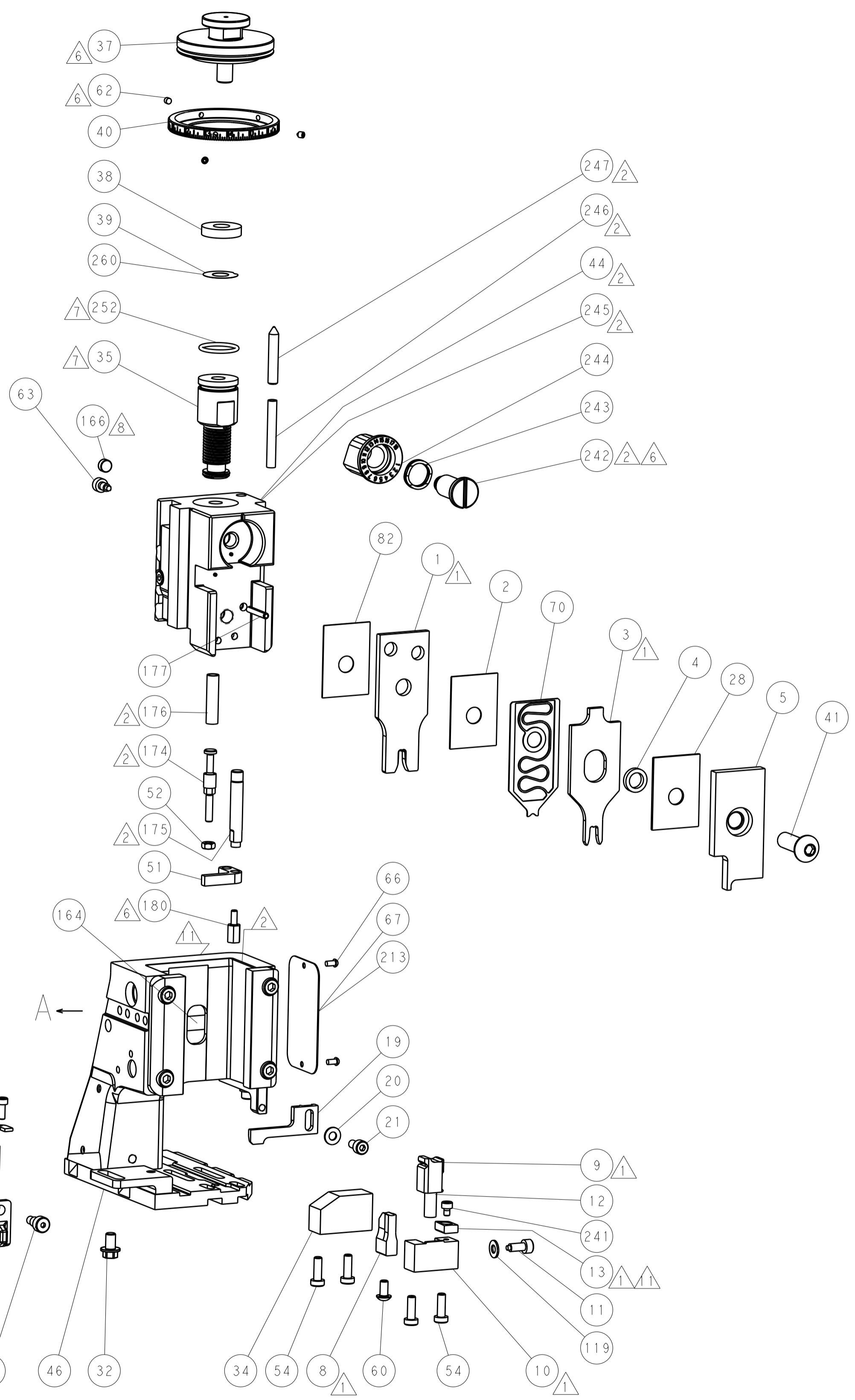
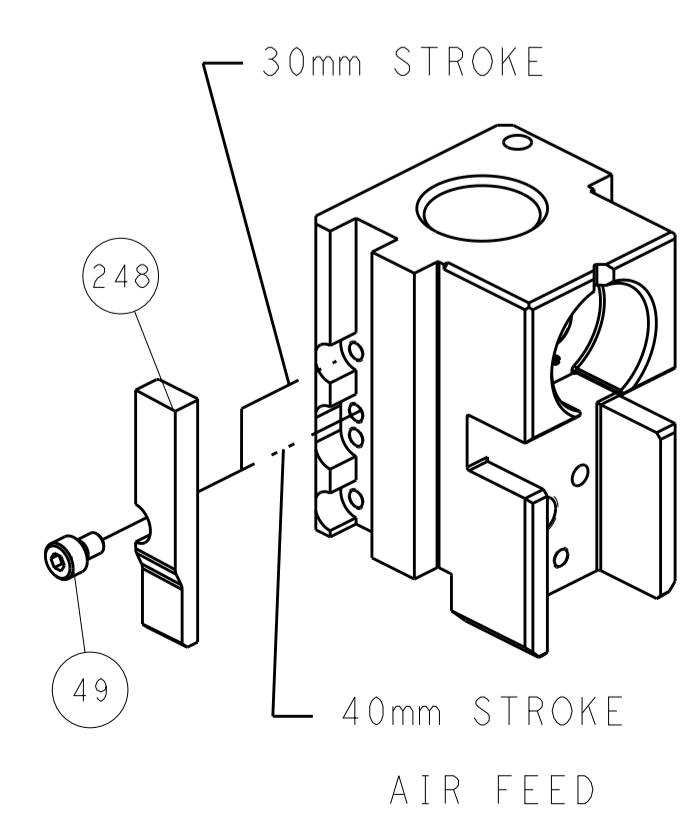
### PNEUMATIC



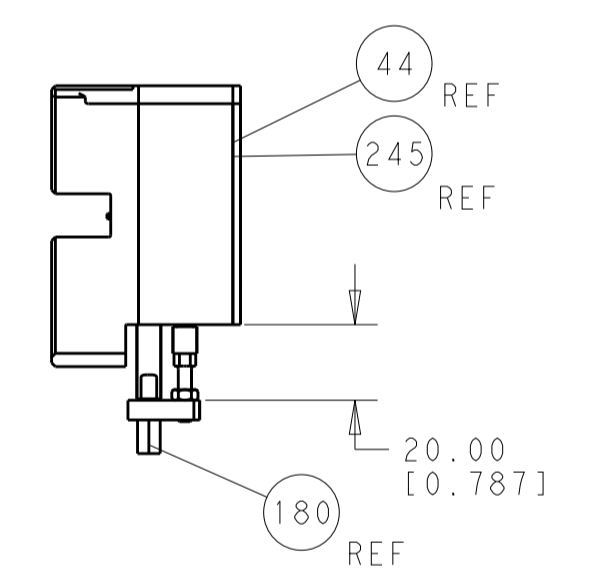
### SERVO LATCH PLATE



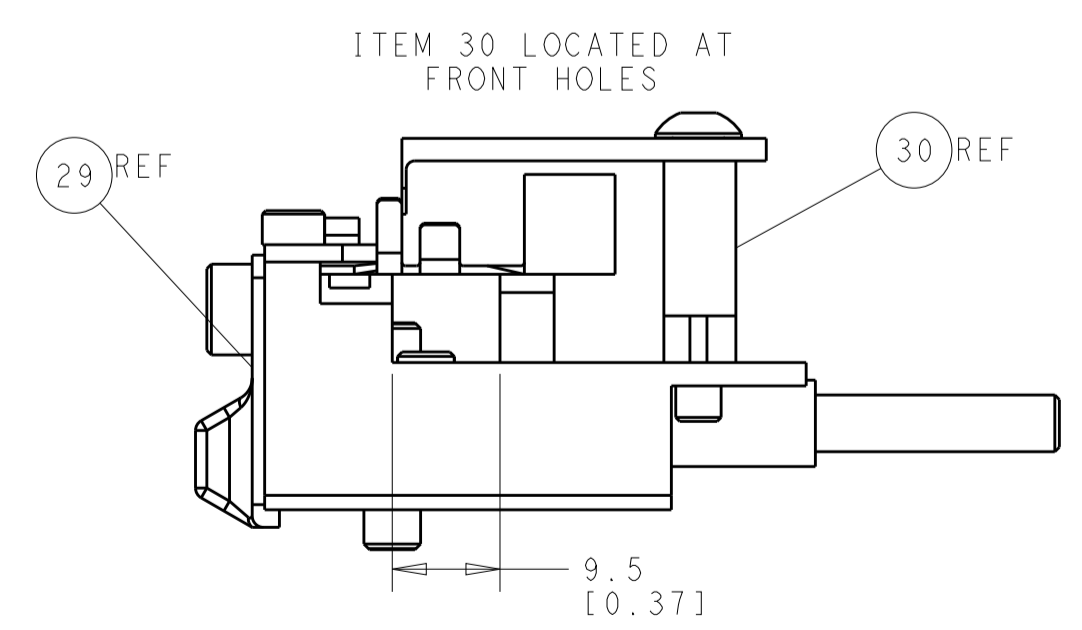
### CAM POSITION



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)

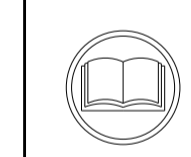
|  |              |  |              |                         |  |
|--|--------------|--|--------------|-------------------------|--|
| DIMENSIONS:                            |              | TOLERANCES UNLESS OTHERWISE SPECIFIED: |              | OWN: H. HUANG 13DEC2012 | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| mm                                     | 0 PLC ±0.5   | 1 PLC ±0.5                             | 2 PLC ±0.13  | CHK: S. XI 13DEC2012    |  |
|  | 3 PLC ±0.013 | 4 PLC ±0.001                           | 5 PLC ±0.001 | APVD: S. XI 13DEC2012   | NAME: Ocean Side Feed Applicator             |
| MATERIAL:                              | FINISH:      | WEIGHT:                                | ANGLES:      | SIZE: A1                | CAGE CODE: 00779                             |
|  |              |  |              | DRAWING NO: C=2151811   | RESTRICTED TO: -                             |
| Customer Accessible Production Drawing |              |  |              | SCALE: 1:2              | SHEET: 2 OF 4                                |

| PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE                      |
|-------------|----------|--------------------------|--------------------------------|
| 2-2151811-2 | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      |
| 2-2151811-5 | B        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> |
| 2-2151811-7 | B        | FINE CRIMP HEIGHT ADJUST | NONE                           |
| 7-2151811-7 | A        | CRIMP TOOLING KIT        | -                              |

| APPLICATOR DATA                      |                 |      |
|--------------------------------------|-----------------|------|
| CRIMP WIRE                           | SIZE            | TYPE |
| INSUL                                | 4.57 mm [1.180] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                 |      |

| TERMINAL DATA: TE TERMINAL                        |                          | TE CRIMP SPECIFICATION                                     |
|---|--------------------------|--|
| TERMINAL NAME: Ring Tongue Terminal M4            |                          |  |
| WIRE STRIP LENGTH<br>5.50-6.00 mm [1.217-.236 IN] |                          | INSULATION DIAMETER RANGE<br>Ø3.10-4.20 mm [1.122-.165 IN] |
| TERMINAL APPLICATION SPECIFICATION<br>114-101016  |                          |  |
| TERMINALS APPLIED <sup>10</sup>                   |                          |  |
| TE TERMINAL<br>2050216-1                          | TE TERMINAL<br>2050216-3 |  |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
|-----------|-------------------------------|---|
| 2.50mm2   | 2.57 +/- 0.05 [1.01 +/- .002] | 6.2   |
| 2.00mm2   | 2.43 +/- 0.05 [0.96 +/- .002] | 7.8   |
| 1.50mm2   | 2.33 +/- 0.05 [0.92 +/- .002] | 8.9   |



- <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: 8-2151811-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151811-5
- 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  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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> 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.

| -77 | -27 | -25 | -22 | PART NO   | DESCRIPTION                         | ITEM NO |
|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 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     |
| -   | 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     |
| -   | 1   | 1   | 1   | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0            | 241     |
| -   | -   | 2   | -   | 2168400-6 | SHCS, LOW HEAD, RoHS, M5 X 16       | 240     |
| -   | -   | -   | 1   | 2063440-2 | AIR FEED MODULE                     | 238     |

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

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

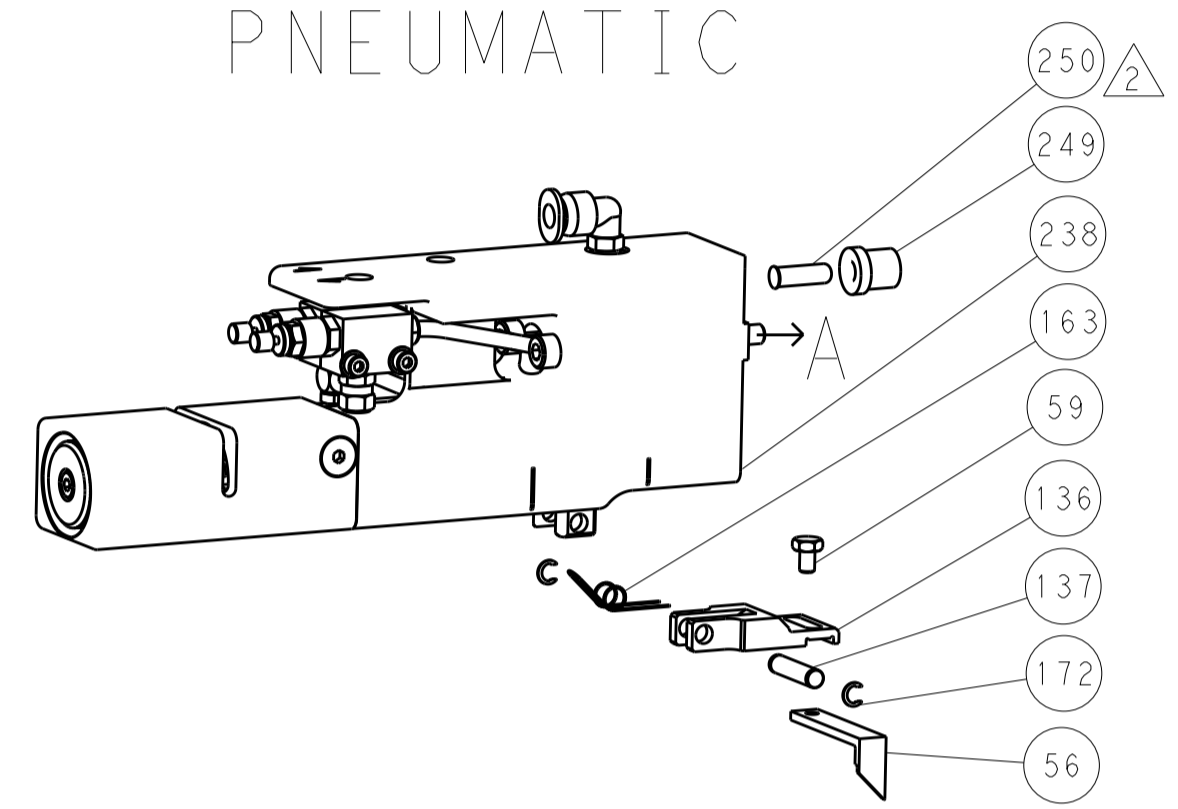
| REV | DATE | BY  | APPV | DESCRIPTION | ITEM NO                             |     |
|-----|------|-----|------|-------------|-------------------------------------|-----|
| -   | 2    | 2   | 2    | 1-2079383-0 | SCR, BHSC, RoHS (M3 X 6)            | 230 |
| -   | -    | 1   | -    | 2119740-2   | TAG, IDENTIFICATION                 | 213 |
| -   | -    | 1   | -    | 1901094-3   | SPACER, FEEDER                      | 198 |
| -   | 1    | 1   | 1    | 2-1752354-0 | STANDOFF, HOLD-DOWN                 | 180 |
| -   | 1    | 1   | 1    | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0      | 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 |
| -   | 1    | 1   | 1    | 1-2119656-0 | 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 |
| -   | -    | -   | 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    | 1-690438-0  | FRONT STRIP GUIDE                   | 96  |
| -   | 2    | 2   | 2    | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 95  |
| -   | 1    | 1   | 1    | 455888-4    | SPACER, CRIMPER                     | 82  |
| -   | 1    | 1   | 1    | 1633782-3   | FENCE                               | 78  |
| -   | 1    | 1   | 1    | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| -   | 1    | 1   | 1    | 2119791-5   | DEPRESSOR, WIRE                     | 70  |
| -   | 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    | 1338683-8   | 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  |
| -   | 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    | 2119644-3   | RAM WASHER, PRECISION               | 38  |
| -   | 1    | 1   | 1    | 1752356-3   | 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    | 2-1320908-9 | SPACER, STRIP GUIDE                 | 30  |
| -   | 1    | 1   | 1    | 2119959-3   | ASSEMBLY, STRIP GUIDE               | 29  |
| -   | 1    | 1   | 1    | 1-455888-0  | SPACER, CRIMPER                     | 28  |
| -   | 2    | 2   | 2    | 22283-1     | SPRING, COMPRESSION                 | 27  |
| -   | 1    | 1   | 1    | 356835-1    | LEVER, DRAG RELEASE                 | 26  |
| -   | 1    | 1   | 1    | 240792-1    | DRAG, TERMINAL                      | 25  |
| -   | 1    | 1   | 1    | 1320928-2   | STRIP GUIDE                         | 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    | 2119806-1   | INSERT, SHEAR                       | 13  |
| -   | 1    | 1   | 1    | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| -   | 1    | 1   | 1    | 1-356885-4  | STOP, SHEAR                         | 11  |
| -   | 1    | 1   | 1    | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| -   | 1    | 1   | 1    | 462006-6    | FLOATING SHEAR, FRONT               | 9   |
| -   | 1    | 1   | 1    | 1-1633932-9 | ANVIL, COMBINATION                  | 8   |
| -   | -    | -   | -    | -           | -                                   | 7   |
| -   | -    | -   | -    | -           | -                                   | 6   |
| -   | 1    | 1   | 1    | 1-2119757-3 | DEPRESSOR, SHEAR                    | 5   |
| -   | 1    | 1   | 1    | 238011-4    | BLOCK, CRIMPER SPACER               | 4   |
| -   | 1    | 1   | 1    | 2-1633961-7 | CRIMPER, INSULATION F PREMIUM       | 3   |
| -   | 1    | 1   | 1    | 455888-5    | SPACER, CRIMPER                     | 2   |
| -   | 1    | 1   | 1    | 2-456411-9  | CRIMPER, WIRE PREMIUM               | 1   |

|  |  |   |  |  |  |
|--|--|---|--|--|--|
| DIMENSIONS:<br>                        |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.05<br>1 PLC ±.05<br>2 PLC ±.05<br>3 PLC ±.05<br>4 PLC ±.05<br>ANGLES ±.0001<br>FINISH |  | DWN<br>H. HUANG<br>CHK<br>S. XI<br>APV<br>S. XI<br>13DEC2012 | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| MATERIAL:                              |  | WEIGHT:   |  | NAME<br>Ocean Side Feed<br>Applicator                        |  |
| CUSTOMER ACCESSIBLE PRODUCTION DRAWING |  | SCALE: 1:2  |  | SHEET 3 OF 4   |  |

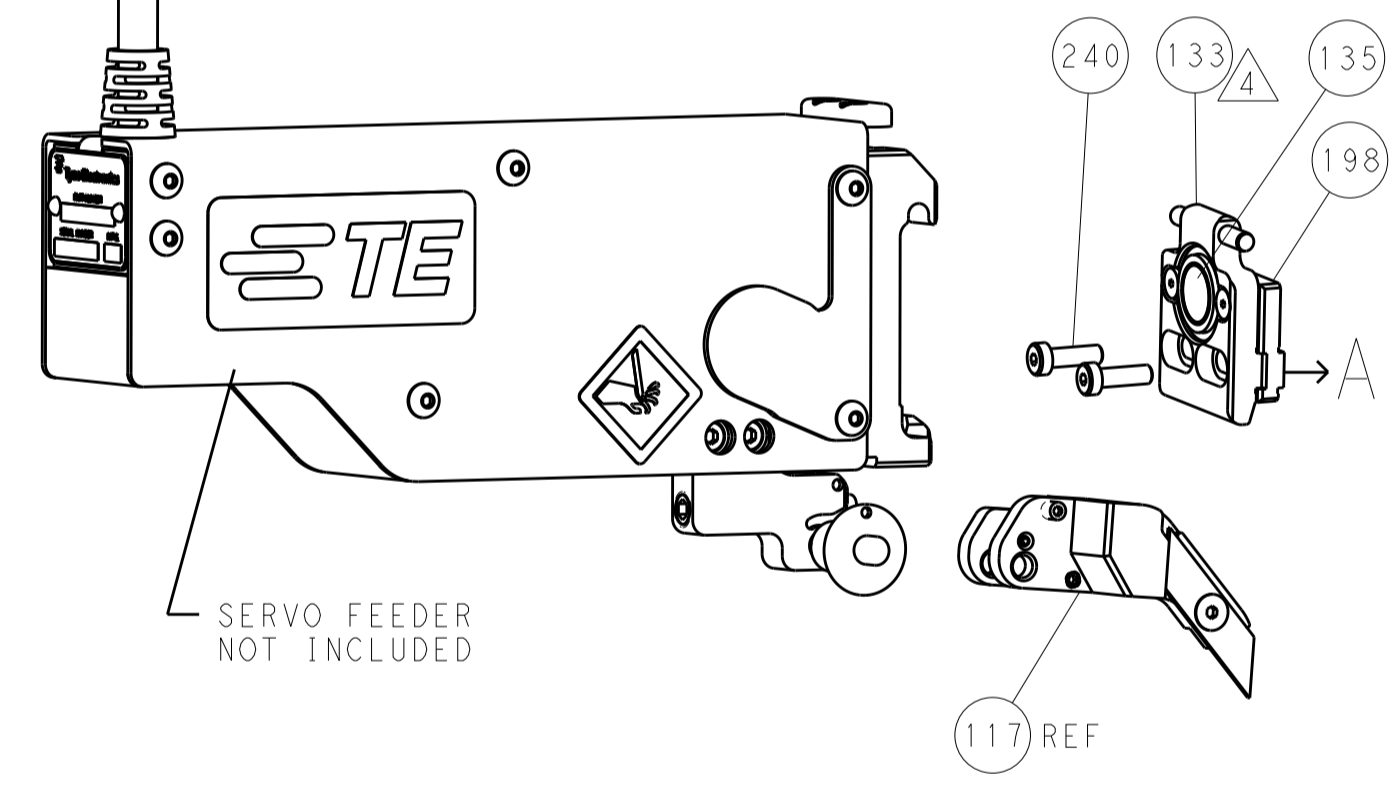
| REVISONS |      | DATE        | DWN | APVD |
|----------|------|-------------|-----|------|
| LOC      | DIST |             |     |      |
| A        | 66   |             |     |      |
| P        | LTM  | DESCRIPTION |     |      |
| -        | -    | SEE SHEET 1 | -   | -    |

### FEED TYPE

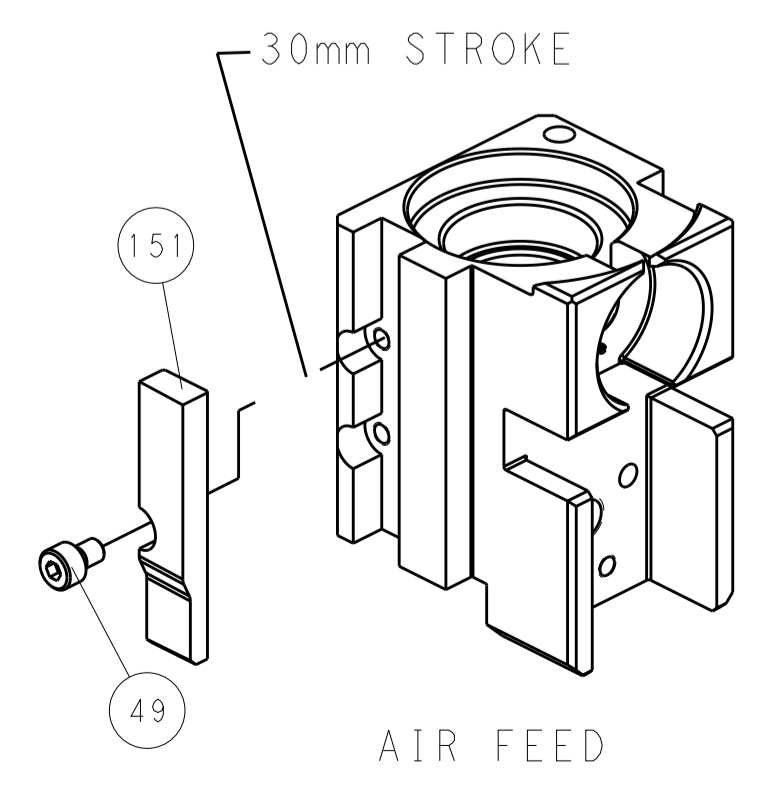
### PNEUMATIC



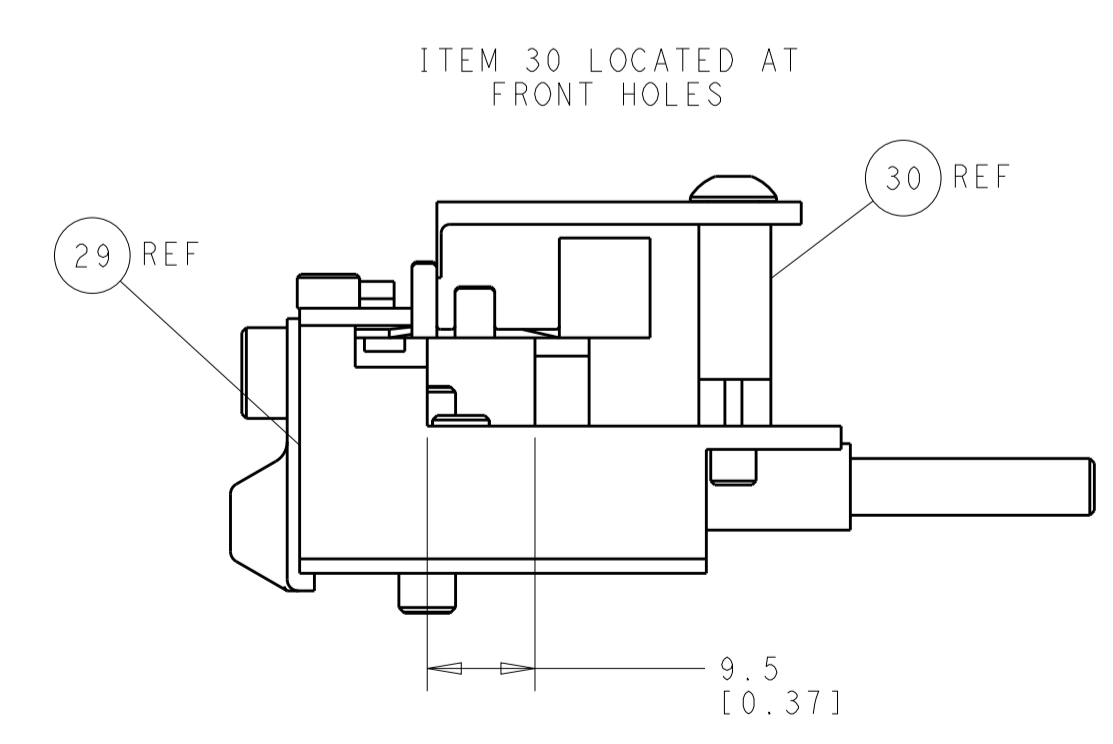
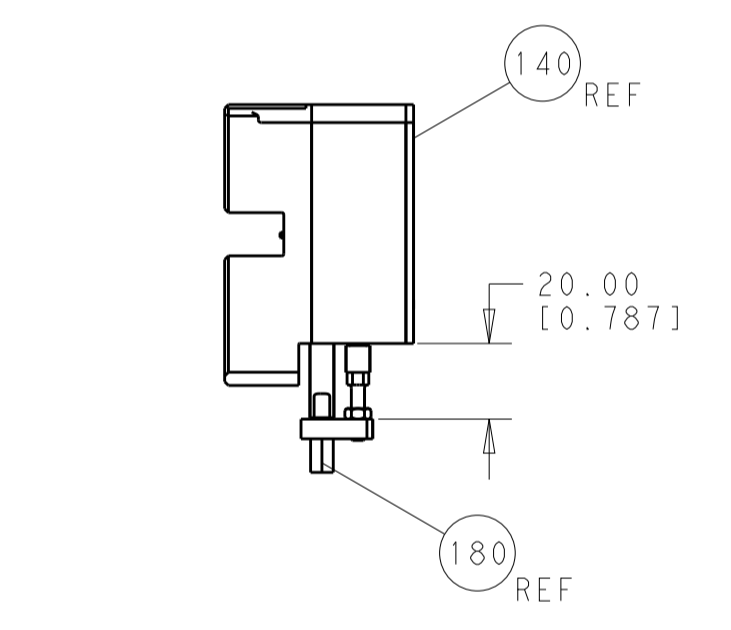
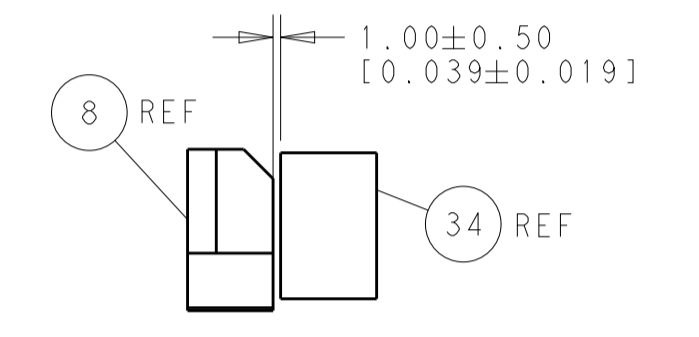
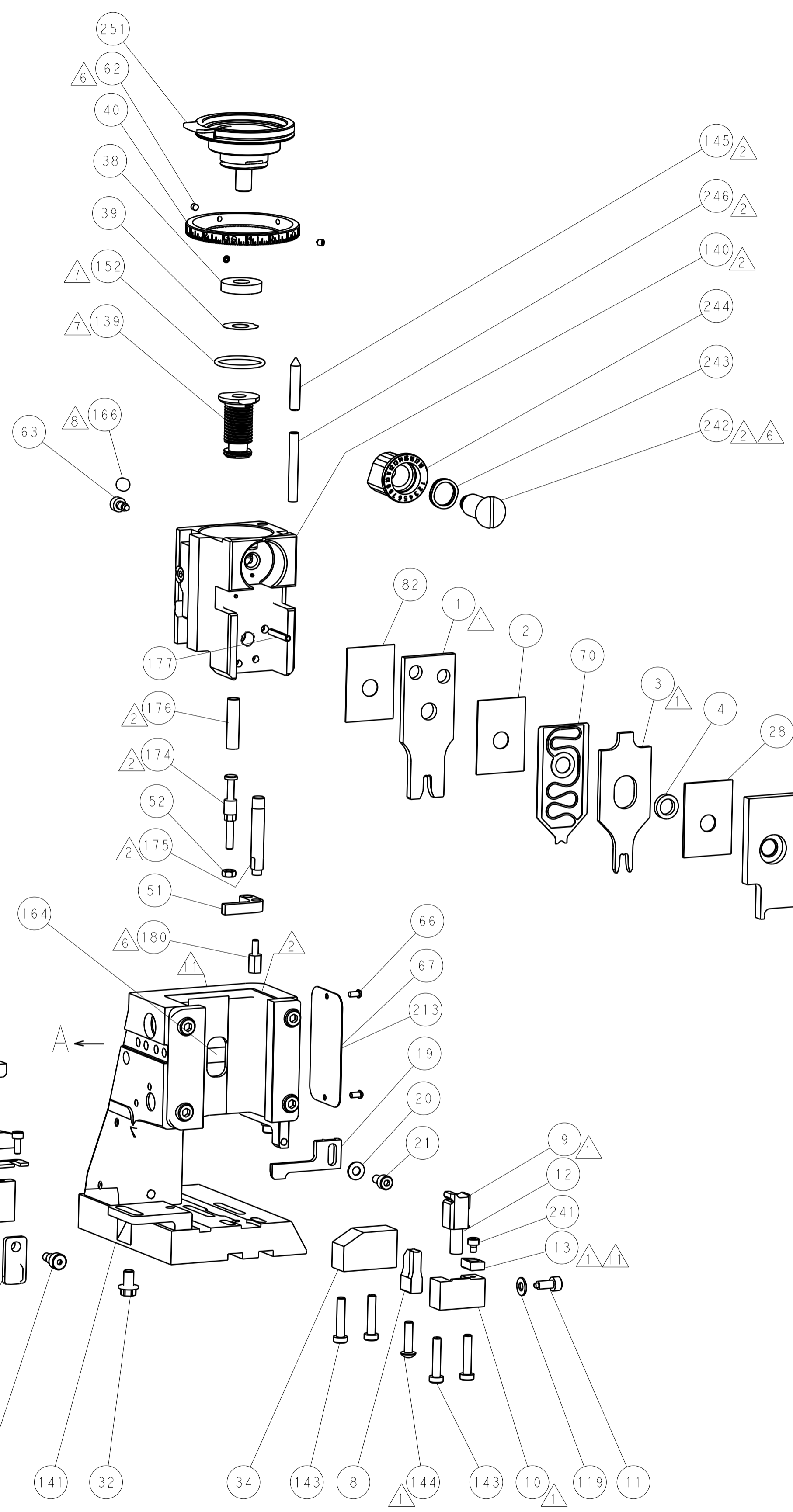
### SERVO LATCH PLATE



### CAM POSITION



### AIR FEED



**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: H. HUANG 13DEC2012 |              | TE Connectivity                            |                           |
| mm                                     | 0 PLC ±0.5 | 1 PLC ±0.5                             | 2 PLC ±0.13 | 3 PLC ±0.013            | 4 PLC ±0.001 | 5 PLC ±0.001                               | Harrisburg, PA 17105-3608 |
| MATERIAL:                              |            | FINISH:                                |             | CHK: S.XI 13DEC2012     |              | NAME: Ocean Side Feed Applicator           |                           |
| APVD: S.XI 13DEC2012                   |            | PRODUCT SPEC:                          |             | APVD: S.XI 13DEC2012    |              | SIZE: CAGE CODE: DRAWING NO: RESTRICTED TO |                           |
| APPLY SPEC:                            |            | WEIGHT:                                |             | A1 00779 ©=2151811      |              | SCALE: 1:2 SHEET 4 OF 4 REV B              |                           |
| Customer Accessible Production Drawing |            | SCALE: 1:2                             |             | SHEET 4 OF 4            |              | REV B                                      |                           |