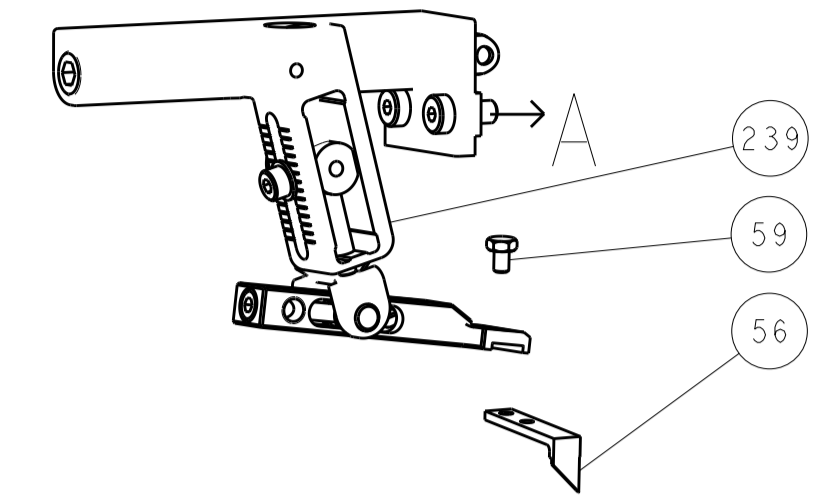


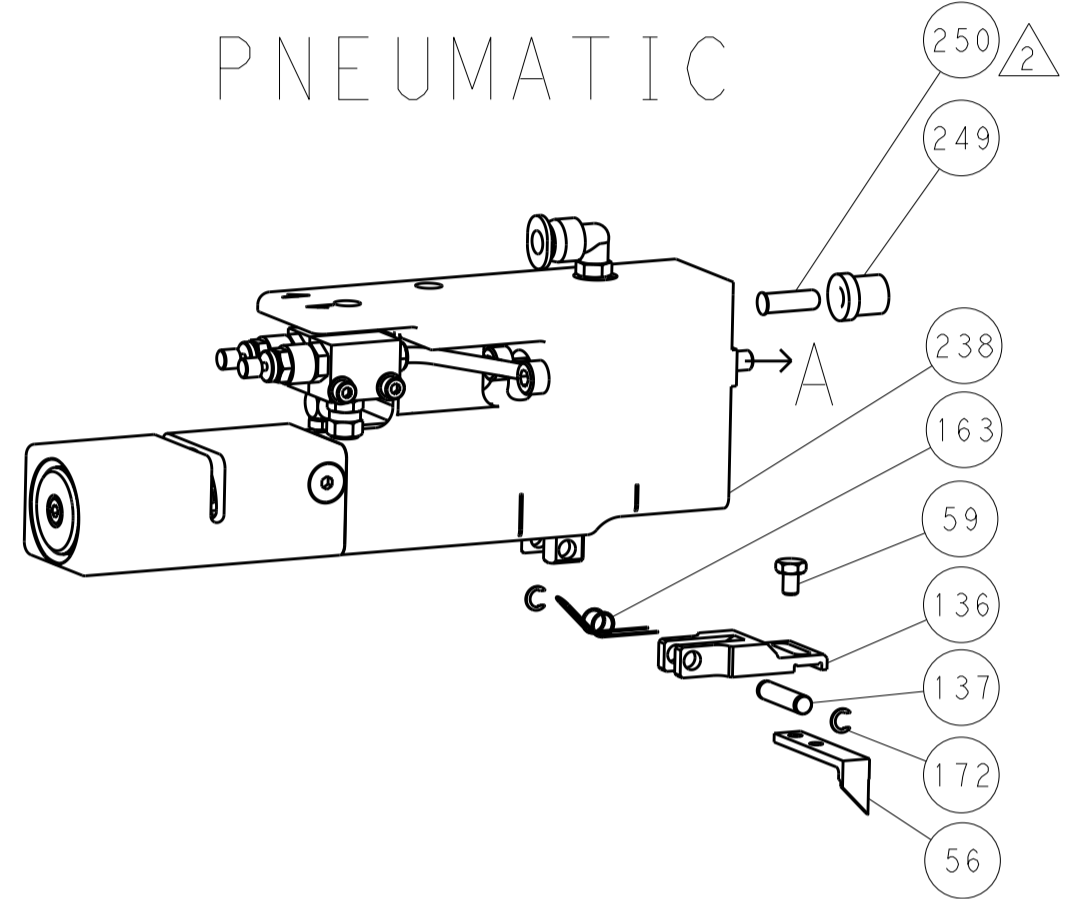


LOC	DIST	REV	DATE	BY	APPV
A	66				

### FEED TYPE MECHANICAL



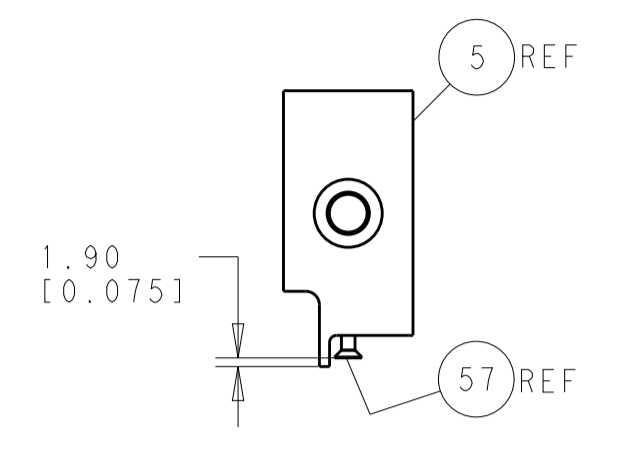
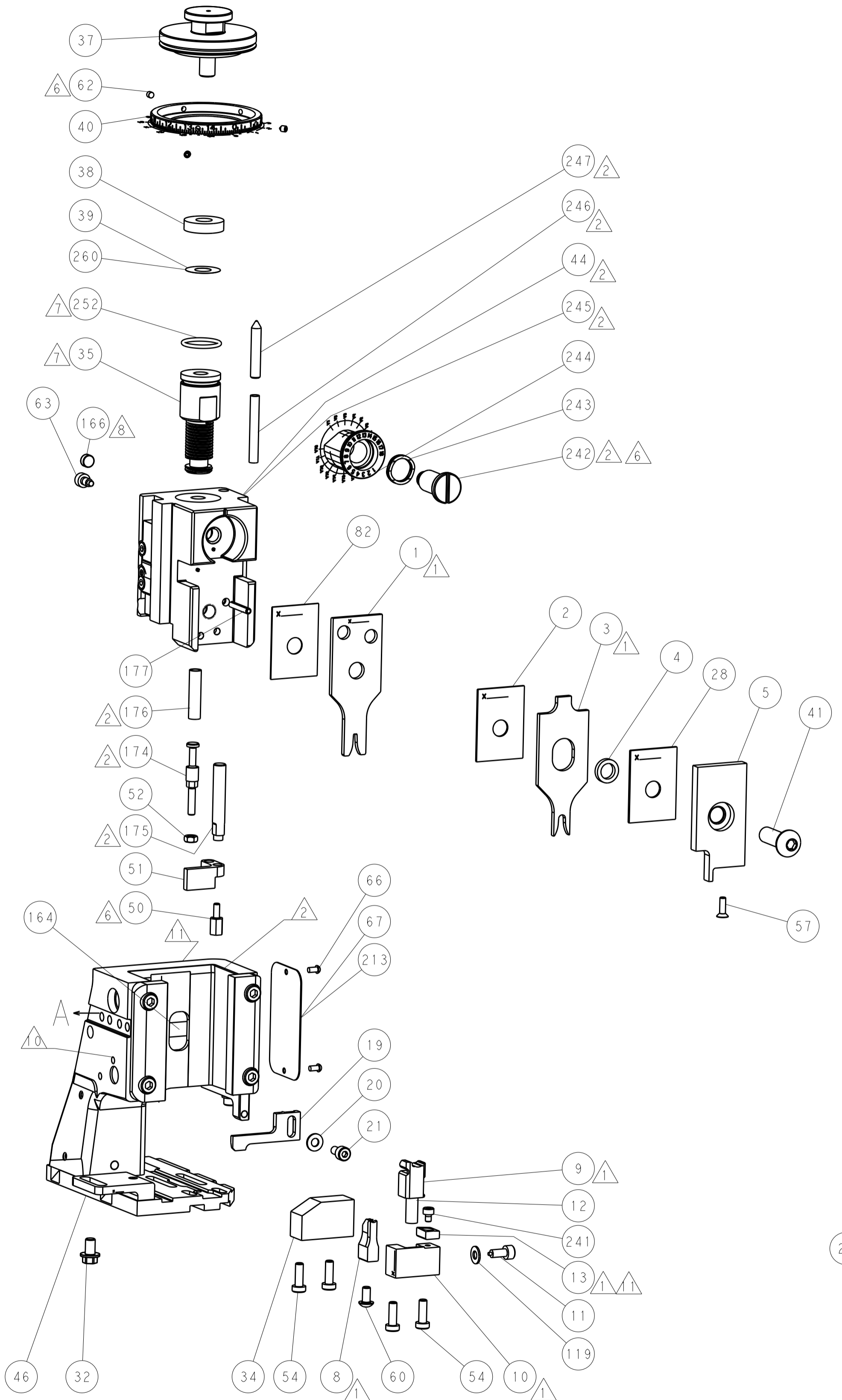
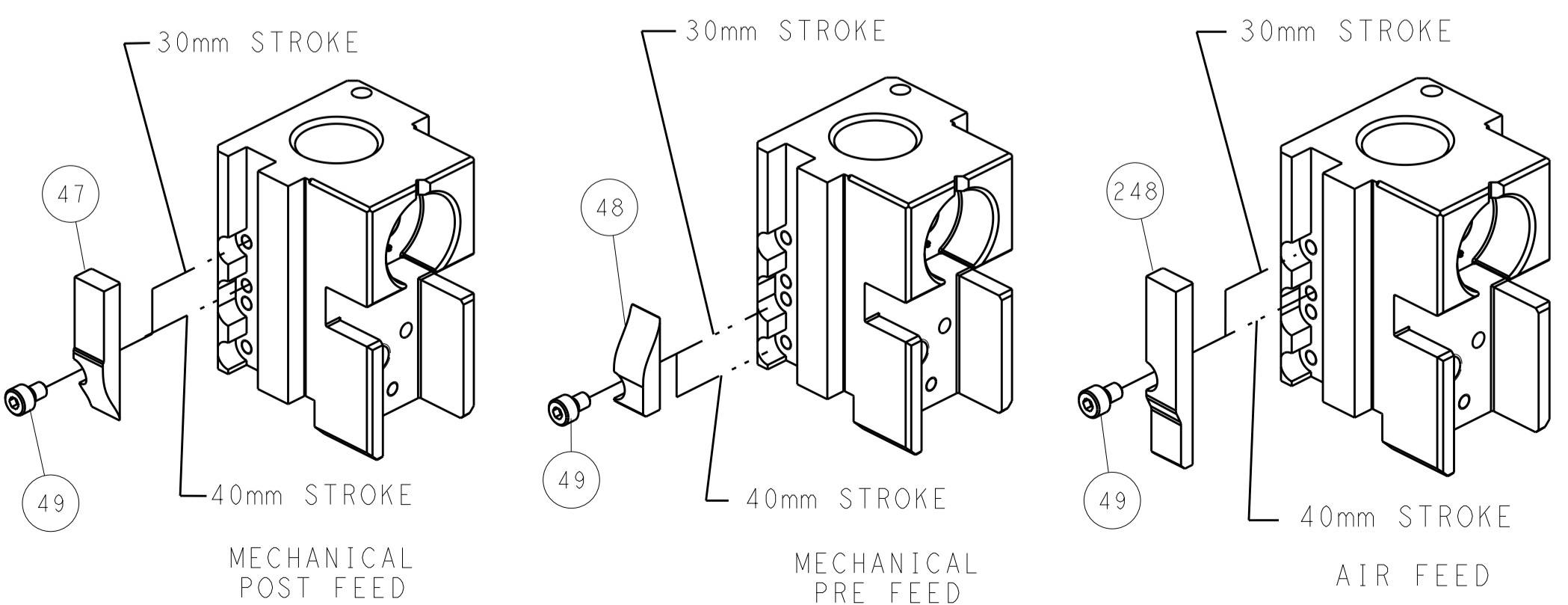
### PNEUMATIC



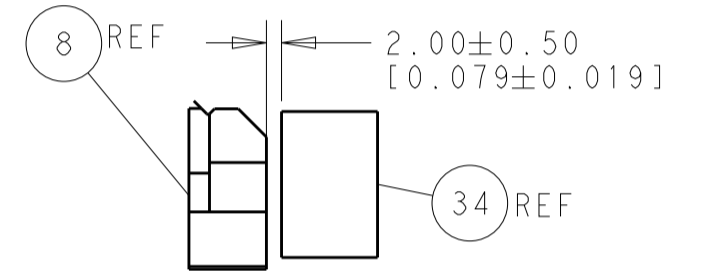
### SERVO LATCH PLATE



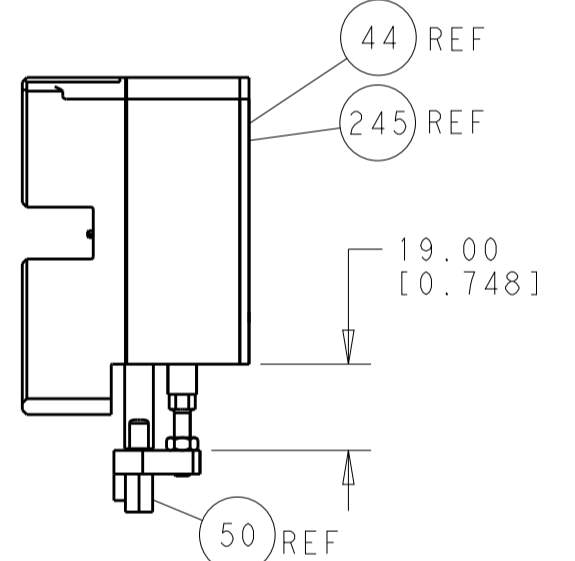
### CAM POSITIONS



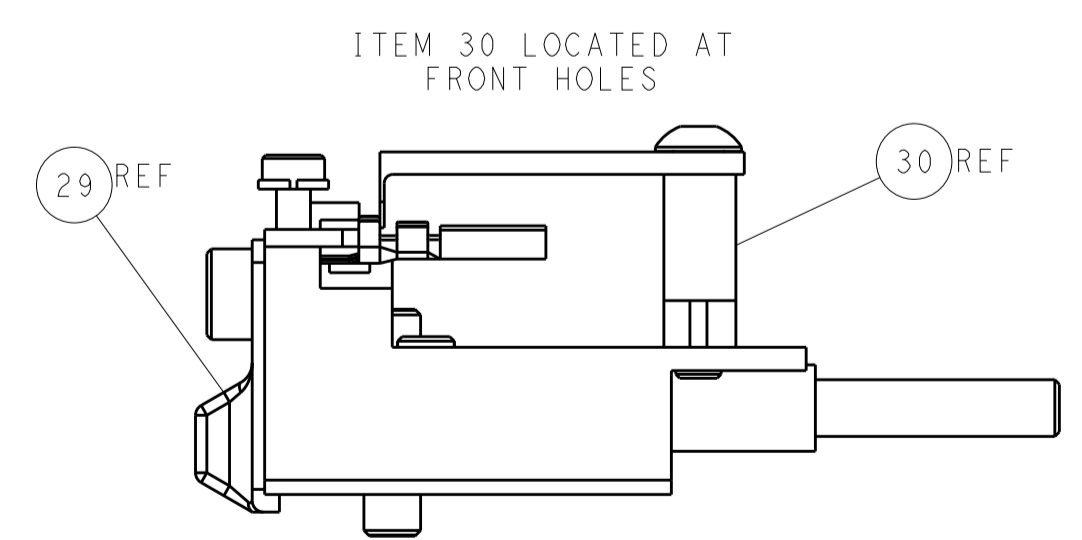
SHEAR DEPRESSOR DETAIL



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: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±.1		DWN BOB HIGMAN 01AUG2012 CHK G. BAILEY 01AUG2012 APVD G. BAILEY 01AUG2012 NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO. A11 00779 ©=2151735 RESTRICTED TO: -	
MATERIAL: -		FINISH: -		WEIGHT: - SCALE: 1:1 SHEET: 2 of 4 REV: A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER				APPLICATOR STYLE CONVERSION CHART							
PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	CONVERT TO PART NUMBERS REQUIRED							
				CONVERT TO	PART NUMBERS REQUIRED						
2-2151735-1	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	-	8-2151735-5	1901094-3	-	2168400-6 (QUANTITY 2)	
				SMART APPLICATOR	2161326-1	-	8-2151735-4	-	-	-	
2-2151735-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	-
				SERVO LATCH PLATE	2119951-1	-	8-2151735-5	1901094-3	-	2168400-6 (QUANTITY 2)	
				SMART APPLICATOR	2161326-1	-	8-2151735-4	-	-	-	
2-2151735-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	-	
2-2151735-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151735-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP SIZE		TYPE
WIRE	2.12 mm [.083]	F
INSUL	3.94 mm [.155]	Ø
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: SECO TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: 070 TYPE FEMALE TERMINAL			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.47-3.49 mm [.137-.137 IN]	Ø0.00-2.00 mm [.000-.079 IN]		
TERMINAL APPLICATION SPECIFICATION			
TERMINALS APPLIED			
TE TERMINAL	SECO TERMINAL	TE SEAL	LARKIS SEAL
2113289-1	625207	2113290-1	LAR-1381

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG OR 0.85mm2	1.29+/-0.05 [1.051+/-0.02]	4.4
20 AWG OR 0.50mm2	1.16+/-0.05 [1.046+/-0.02]	5.7

- 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: 8-2151735-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151735-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151735-5
- 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 ITEMS 50, 62 & 242.
- 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.
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- 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.

**\*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 -21	PART NO	DESCRIPTION	ITEM NO
- 1 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
- 1 1 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)

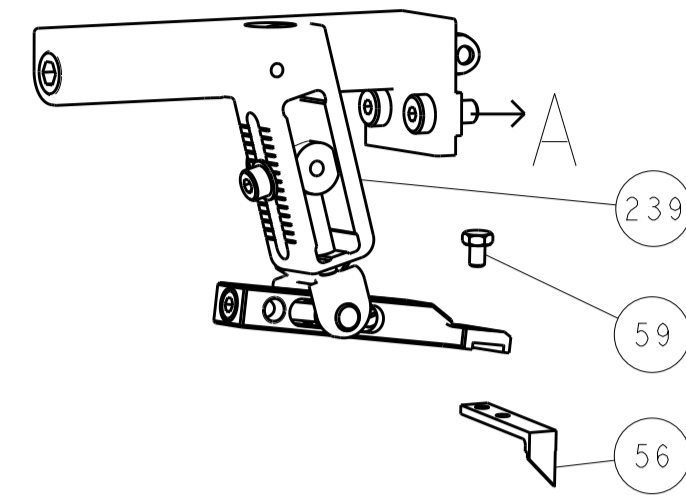
SET UP GAUGE	LOC	DIST	REVISIONS				
2119599-1	A	66	P LTR	DESCRIPTION	DATE	OWN	APVD
			-	SEE SHEET 1	-	-	-

- 1 1 1 1 1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
- 1 1 1 1 1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
- 1 1 1 1 1	2119083-1	RETAINER, INSULATION DIAL	242
- 1 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
- - - - 1	2119580-1	MECHANICAL FEED ASSEMBLY	239
- - - - 1	2063440-1	AIR FEED MODULE	238
- - 1 - -	2119740-2	TAG, IDENTIFICATION	213
- - 1 - -	1901094-3	SPACER, FEEDER	198
- 1 1 1 1 1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
- 1 1 1 1 1	8-22280-7	SPRING, COMPRESSION	176
- 1 1 1 1 1	1752353-2	GUIDE PIN, HOLDDOWN	175
- 1 1 1 1 1	1901680-2	GUIDE PIN, HOLDDOWN	174
- - - 2 -	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
- 1 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 1 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 1 1	2119798-2	DETENT PIN	145
- 1 1 1 1 1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
- 4 4 4 4 4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
- - - - 1	2119653-2	FEED CAM, POST FEED	142
- 1 1 1 1 1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
- 1 1 1 1 1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
- 1 1 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 1	1-18028-2	WASHER, FLAT, REG M4	119
- - REF - -	2119944-1	FEED FINGER ASSEMBLY, SF	117
- 1 1 1 1 1	455888-5	SPACER, CRIMPER	82
- 1 1 1 1 1	2119956-1	DOCUMENTATION PACKAGE	71
- 1 - 1 1 1	2119740-1	TAG, IDENTIFICATION	67
- 2 2 2 2 2	2168078-1	SCREW, DRIVE, RH, RoHS	66
- 1 1 1 1 1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
- 3 3 3 3 3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
- - - 1 1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
- 1 1 1 1 1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
- - - 1 1	1338685-1	PAWL, FEED	56
- 1 1 1 1 1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
- 1 1 1 1 1	1901681-1	HOLDDOWN, TERMINAL	51
- 1 1 1 1 1	1-1752354-8	STANDOFF, HOLD-DOWN	50
- - - 1 2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
- - - - 1	2119652-1	FEED CAM, PRE FEED	48
- 1 1 1 1 1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
- 1 1 1 1 1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
- 1 1 1 1 1	2119957-1	APPLICATOR SHIM PACK	39
- 1 1 1 1 1	2119644-2	RAM WASHER, PRECISION	38
- 1 1 1 1 1	1752356-3	SUPPORT, TERMINAL	34
- 2 2 2 2 2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
- 1 1 1 1 1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
- 1 1 1 1 1	1-1320908-2	SPACER, STRIP GUIDE	30
- 1 1 1 1 1	2119959-1	ASSEMBLY, STRIP GUIDE	29
- 1 1 1 1 1	1-455888-0	SPACER, CRIMPER	28
- 1 1 1 1 1	1320928-2	STRIP GUIDE	24
- 1 1 1 1 1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
- 1 1 1 1 1	1-18028-2	WASHER, FLAT, REG M4	20
- 1 1 1 1 1	2119533-1	STRIPPER, SIDE FEED	19
- 1 1 1 1 1	2119806-1	INSERT, SHEAR	13
- 1 1 1 1 1	3-22280-3	SPRING, COMPRESSION	12
- 1 1 1 1 1	1-356885-3	STOP, SHEAR	11
- 1 1 1 1 1	2119805-1	SHEAR HOLDER, FRONT	10
- 1 1 1 1 1	318707-4	FLOATING SHEAR, FRONT	9
- 1 1 1 1 1	1-1633927-9	ANVIL, COMBINATION	8
- - - - -	-	-	7
- - - - -	-	-	6
- 1 1 1 1 1	2119781-1	DEPRESSOR, SHEAR	5
- 1 1 1 1 1	238011-4	BLOCK, CRIMPER SPACER	4
- 1 1 1 1 1	2-2119784-9	CRIMPER, INSULATION O PREMIUM	3
- 1 1 1 1 1	455888-8	SPACER, CRIMPER	2
- 1 1 1 1 1	1633664-6	CRIMPER, WIRE	1

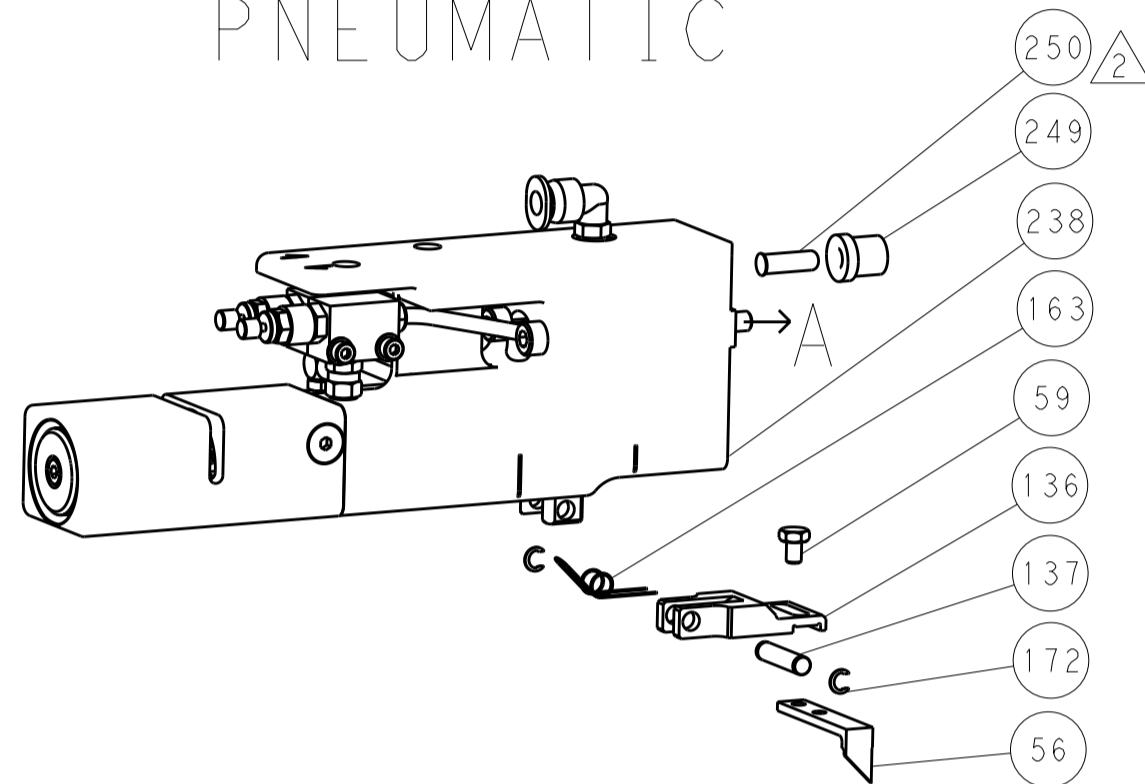
STANDARD	UNLESS OTHERWISE SPECIFIED:	NAME	PRODUCT SPEC	APPLICATION SPEC
DIMENSIONS: mm	0 PLC ±.1 1 PLC ±0.1 2 PLC ±0.2 3 PLC ±0.005 4 PLC ±0.0005 ANGLES .1	BOB HIGMAN 01AUG2012 G. BAILEY 01AUG2012 G. BAILEY 01AUG2012		
MATERIAL	FINISH	Customer Accessible Production Drawing	SCALE 1:1	SHEET 3 OF 4 REV A

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

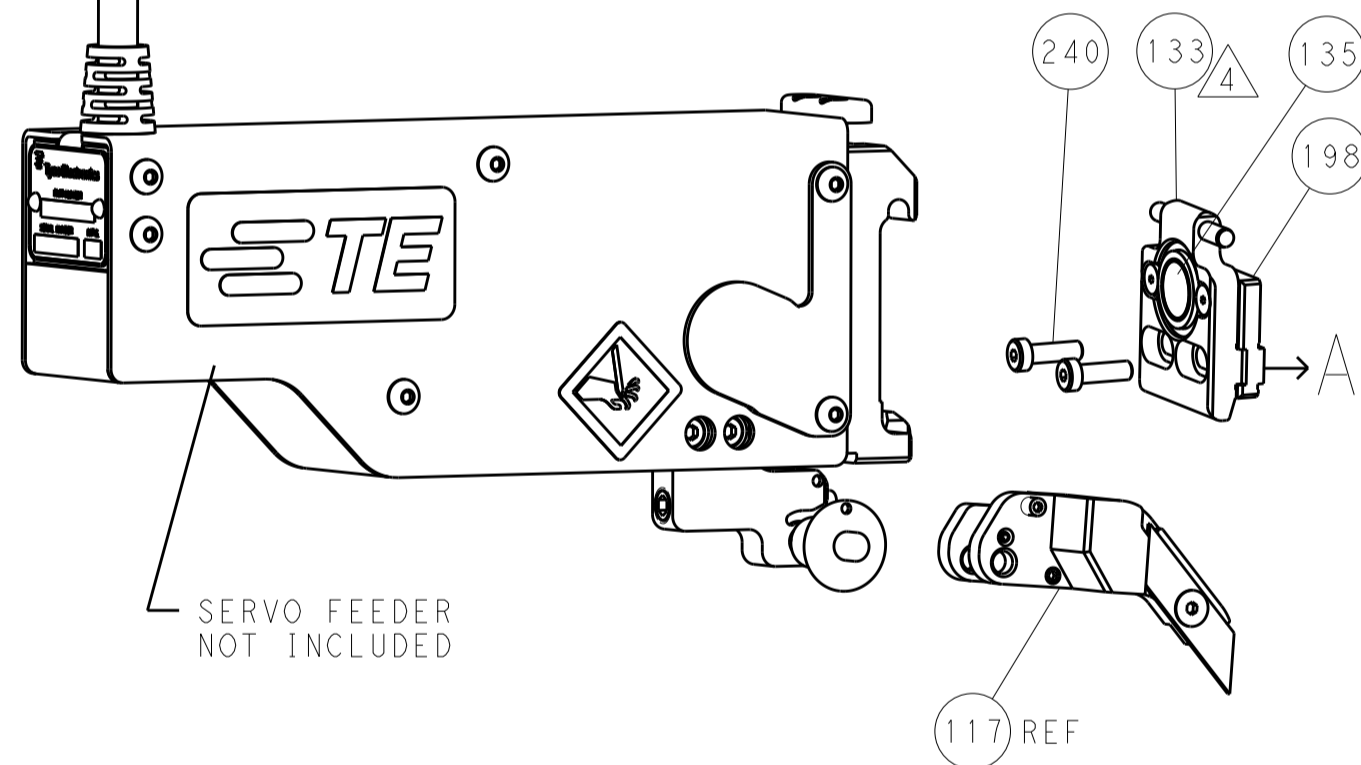
# FEED TYPE MECHANICAL



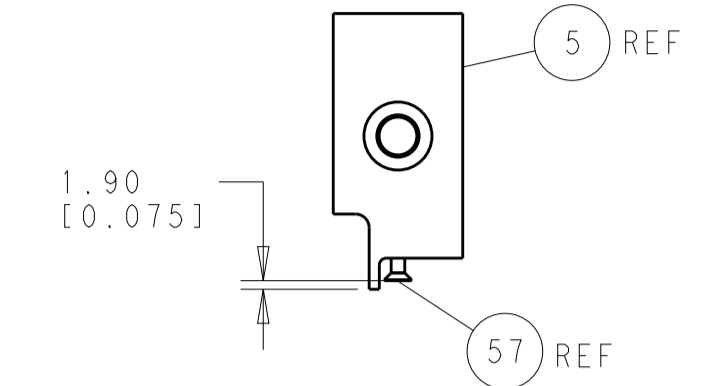
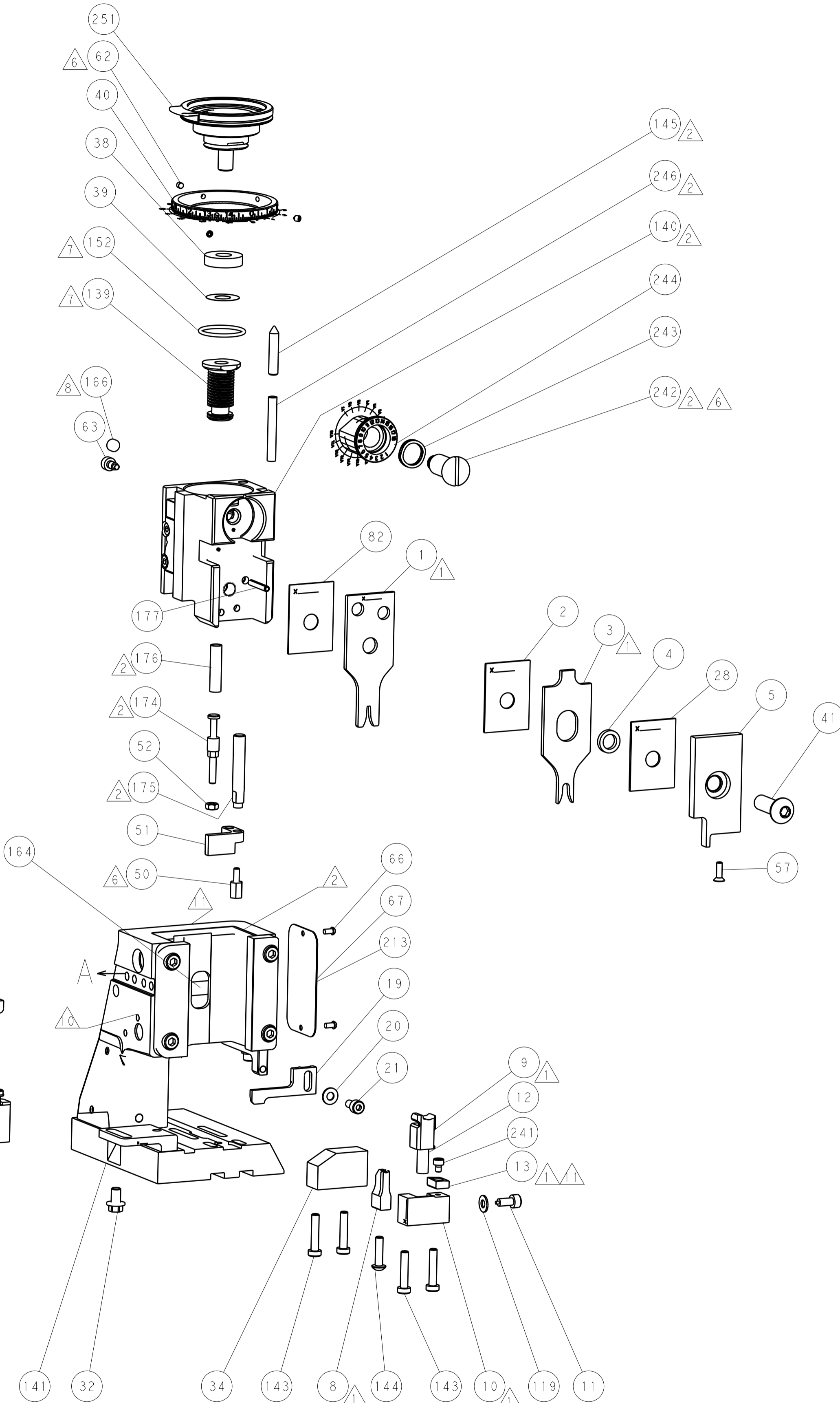
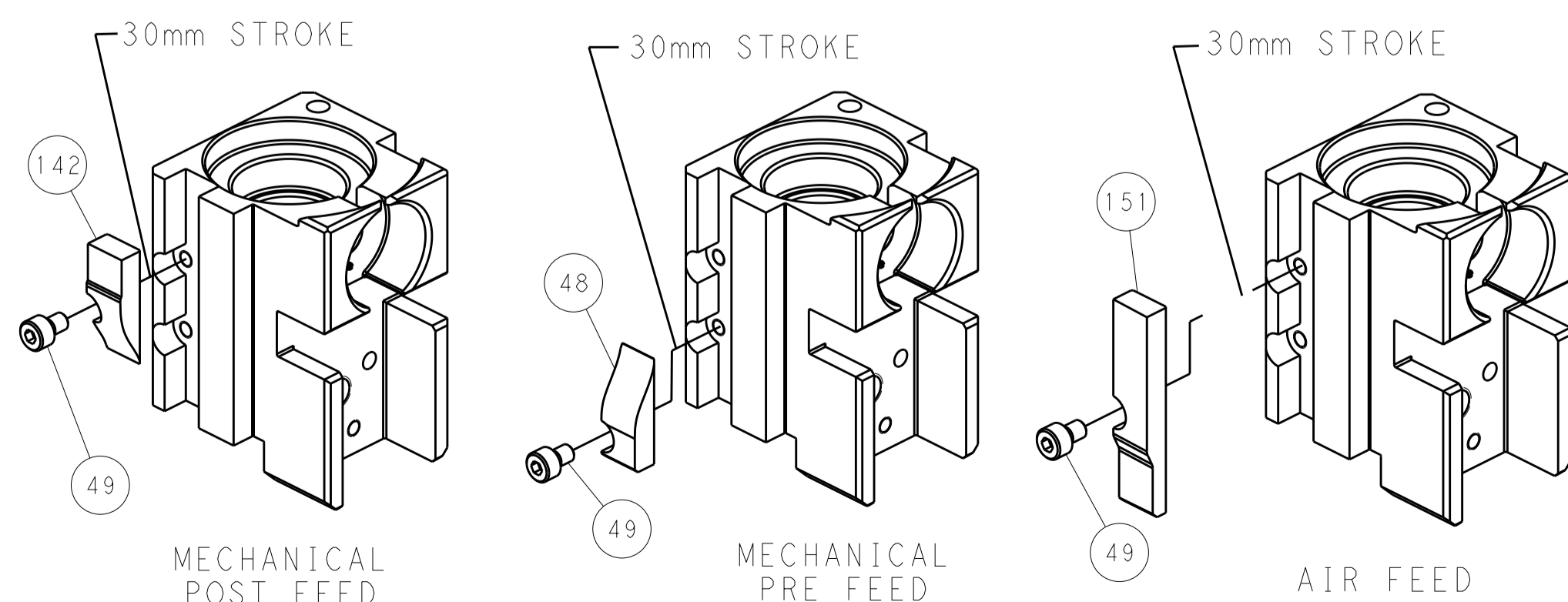
# PNEUMATIC



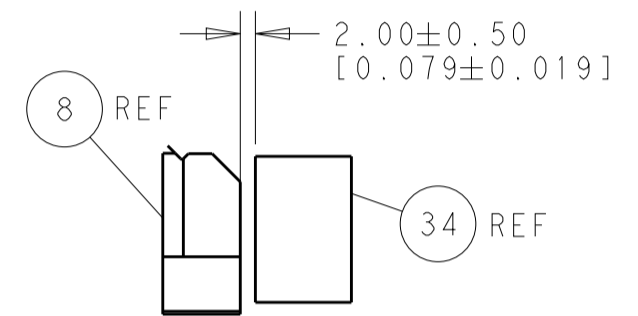
# SERVO LATCH PLATE



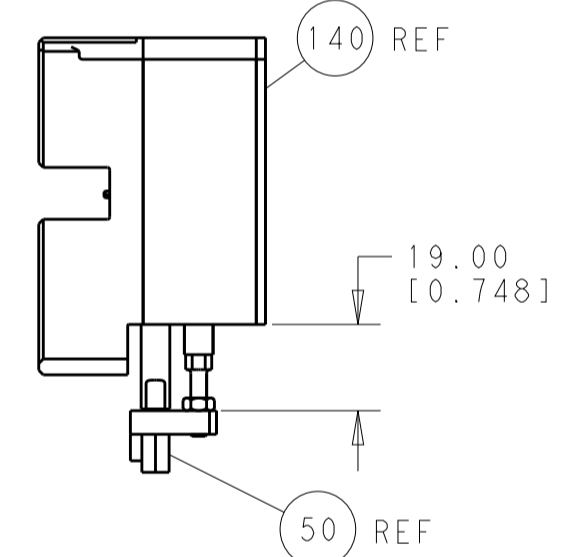
# CAM POSITIONS



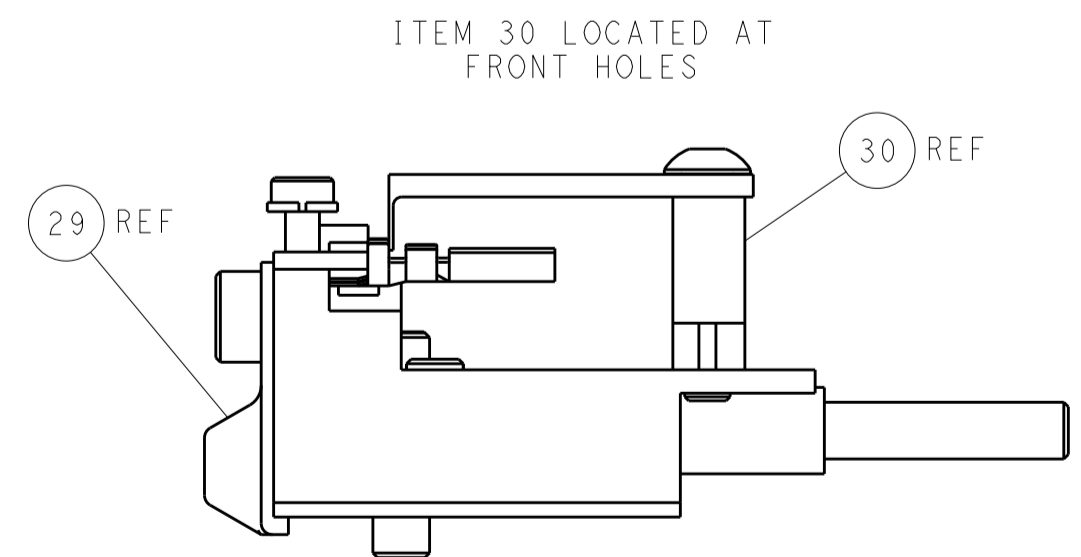
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB_HIGMAN 01AUG2012		TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	ANGLES ±0.0005	Harrisburg, PA 17105-3608
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SIZE:	CAGE CODE:	DRAWING NO:	RESTRICTED TO:
			1:1	A1	00779	2151735	
Customer Accessible Production Drawing				SHEET 4 OF 4 REV A			