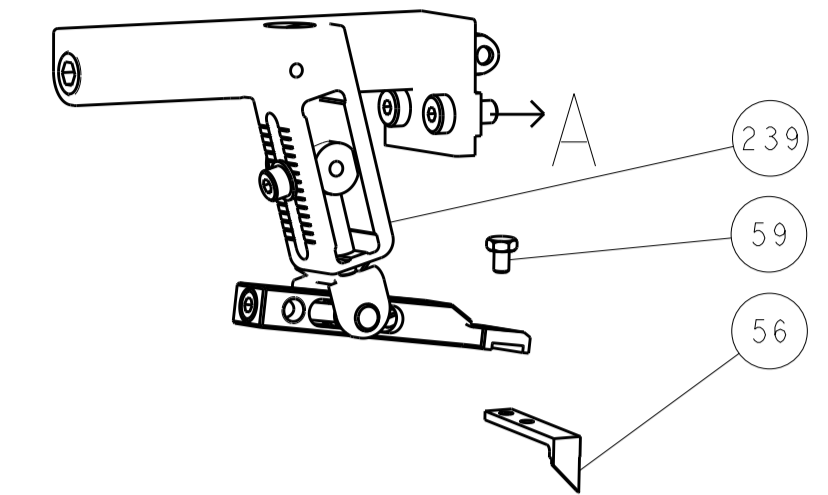


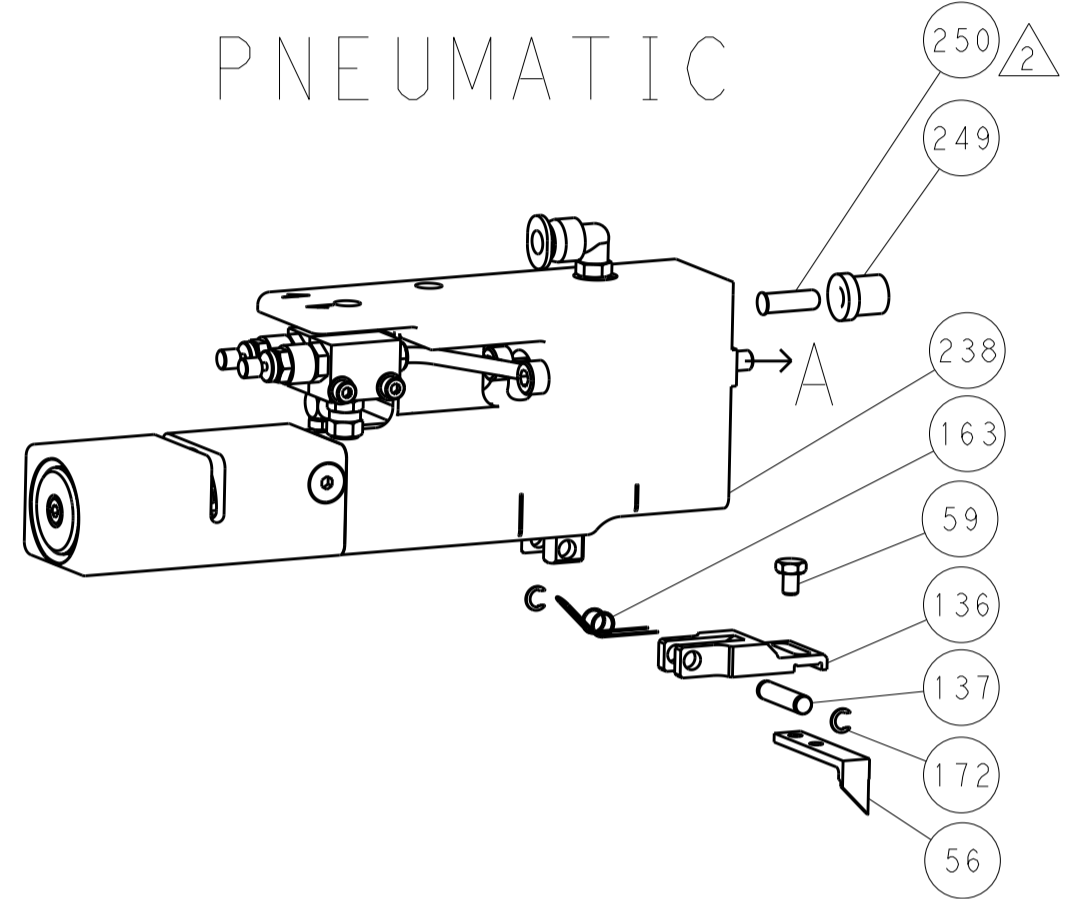


LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

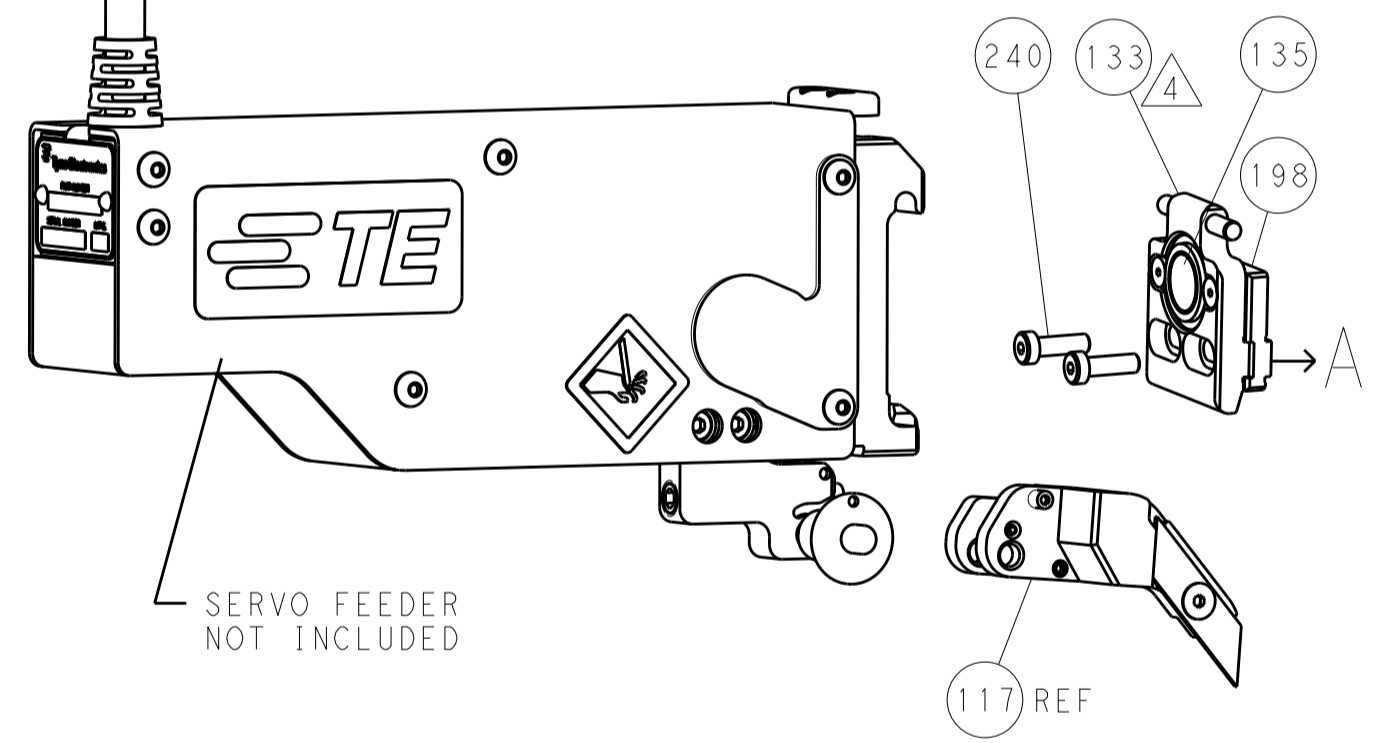
### FEED TYPE MECHANICAL



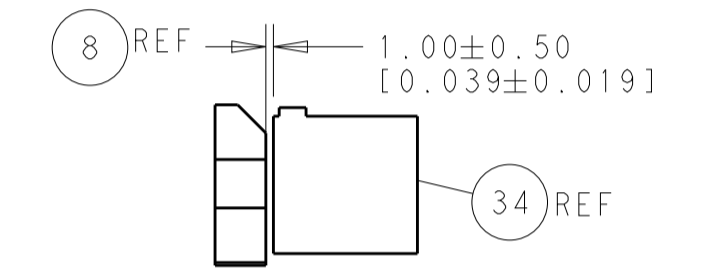
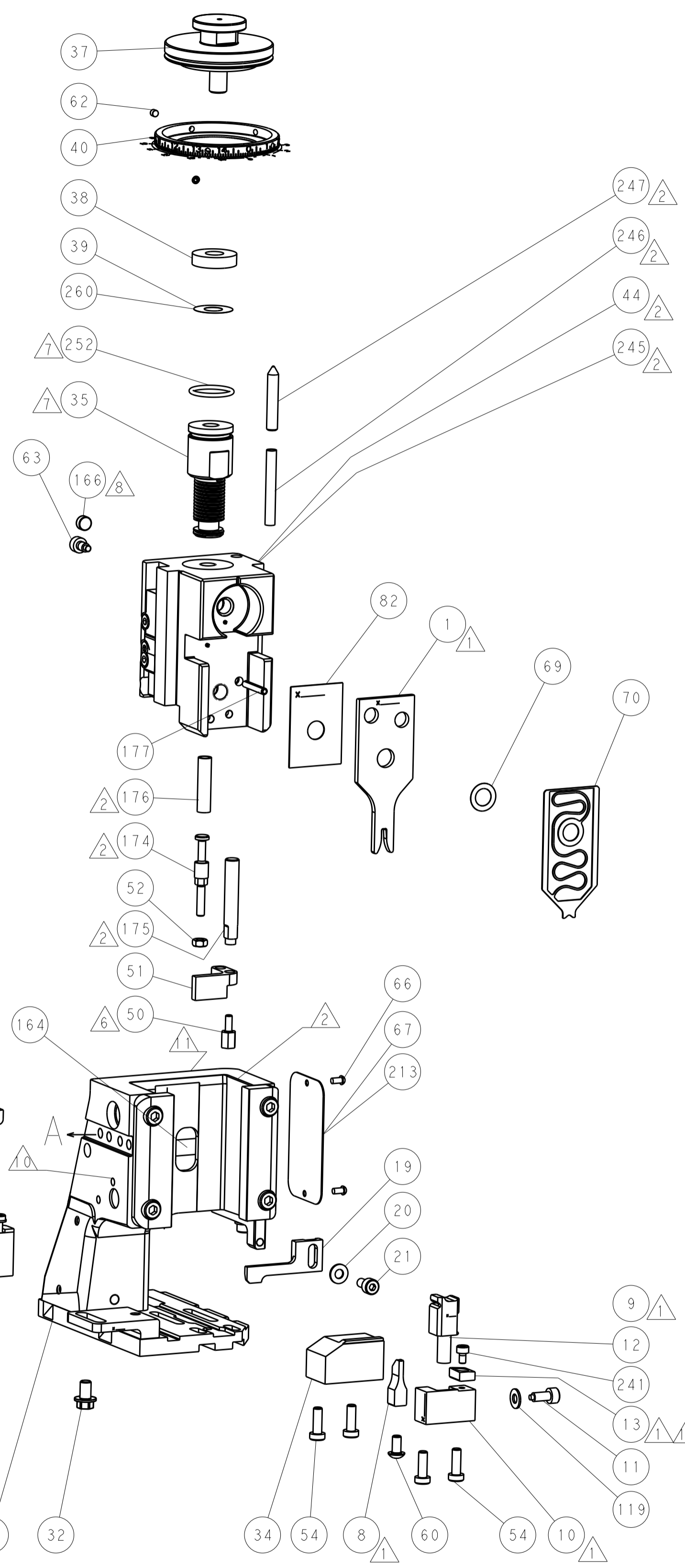
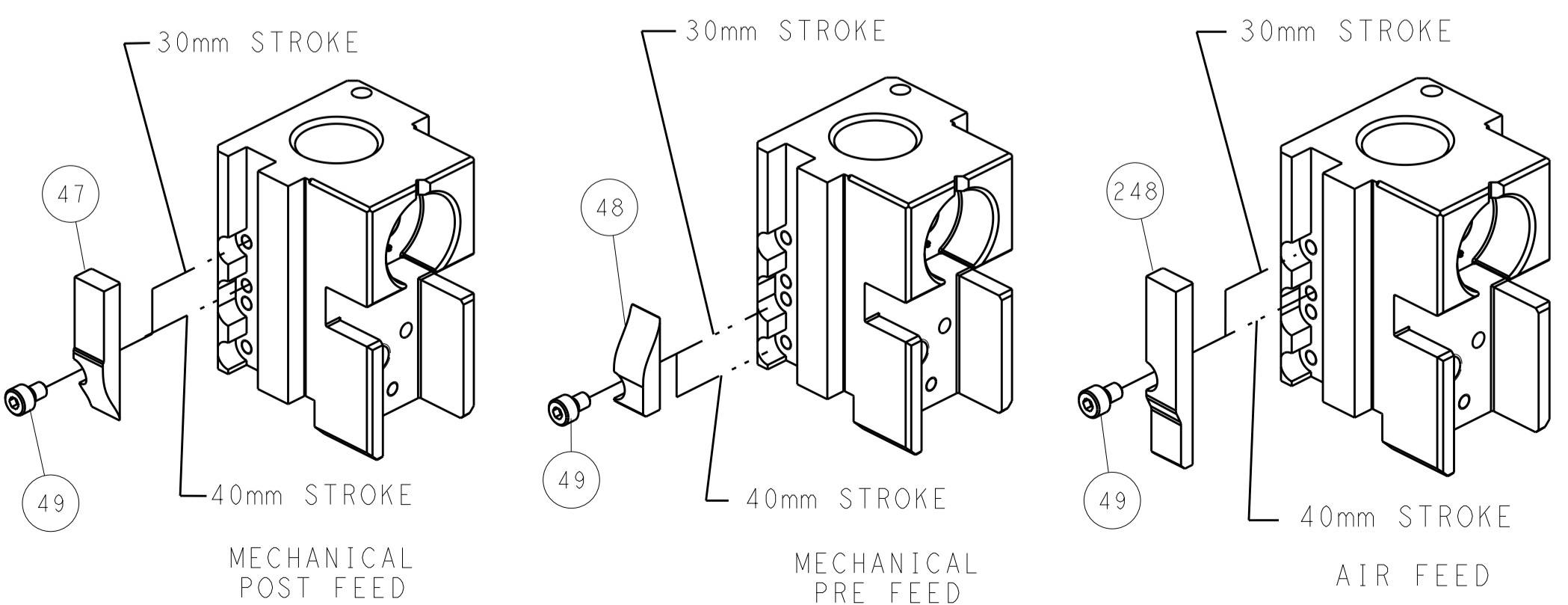
### PNEUMATIC



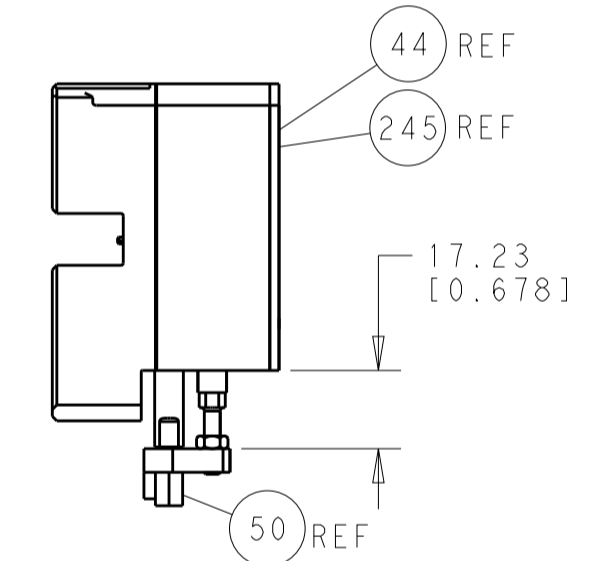
### SERVO LATCH PLATE



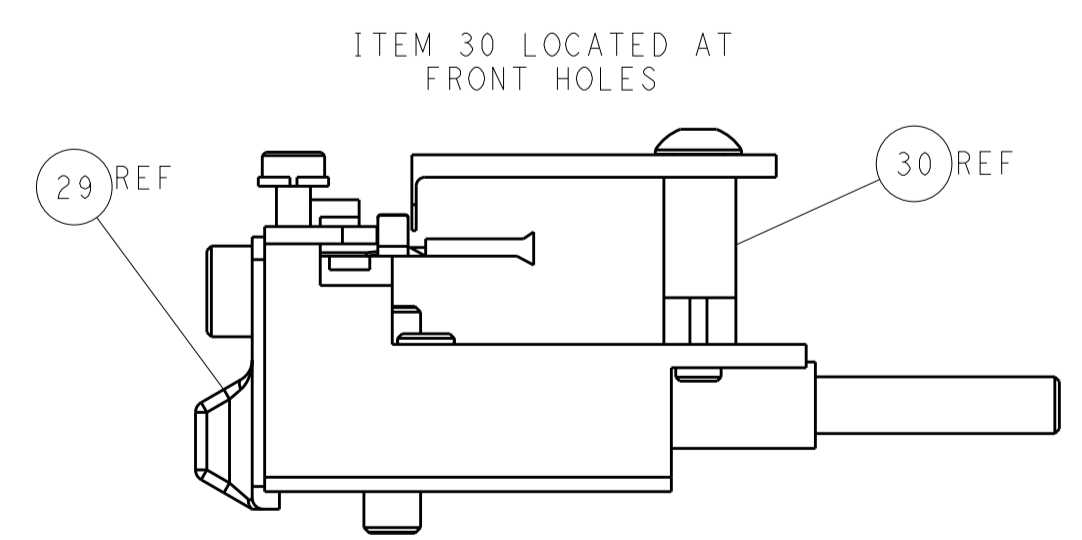
### CAM POSITIONS



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 STAKEM 04APRIL2012		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		APVD T. ELBIN 10APRIL2012		NAME	
				PRODUCT SPEC		OCEAN SIDE FEED APPLICATOR	
				APPLICATION SPEC		OCEAN SIDE FEED APPLICATOR	
				WEIGHT		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				Customer Accessible Production Drawing		A1 00779 ©=2151644	
				SCALE 1:1		SHEET 2 OF 4 REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151644-1	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	-	8-2151644-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151644-4	-	-	-
	2-2151644-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151644-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151644-4	-	-	-
	2-2151644-5	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
	2-2151644-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151644-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.29mm [.090]	F
INSUL	0.00mm [0.000]	-
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: MAXI-SEAL TERMINAL TE CRIMP SPECIFICATION			
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH .171-.186 IN [4.34-4.72 mm]		INSULATION DIAMETER RANGE Ø.120-.125 IN [3.05-3.18 mm]	
TERMINAL APPLICATION SPECIFICATION NONE		-	-
TERMINALS APPLIED			
TE TERMINAL 2113267-1	MAXI-SEAL TERMINAL T188	TE TERMINAL	MAXI-SEAL TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING <sup>9</sup>
14 AWG	1.75+/-0.05 [0.069+/-0.002]	8.1
16 AWG	1.50+/-0.05 [0.059+/-0.002]	10.7
18 AWG	1.35+/-0.05 [0.053+/-0.002]	12.5

- 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: 8-2151644-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151644-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151644-5
- 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
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	18023-1	SCR, SKT HD CAP M3 X 5.0	241
-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	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
-	-	-	SEE SHEET 1	-	-	-

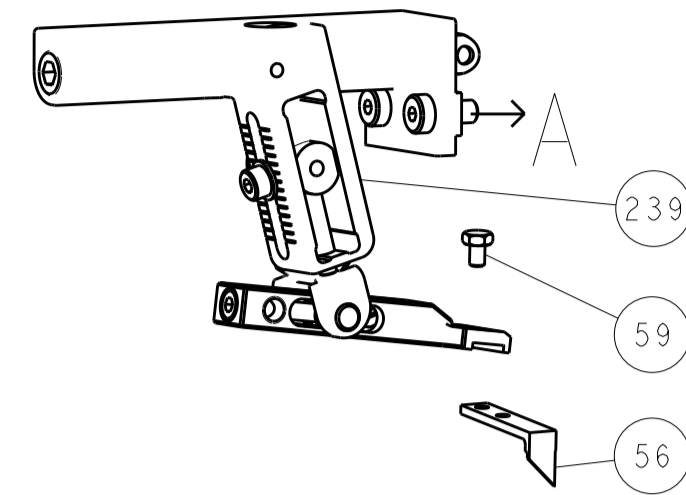
-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240	
-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	-	-	-	1	2063440-1	AIR FEED MODULE	238	
-	-	1	-	-	2119740-2	TAG, IDENTIFICATION	213	
-	-	1	-	-	1901094-3	SPACER, FEEDER	198	
-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177	
-	1	1	1	1	8-22280-7	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	
-	-	-	1	-	240638-1	SPRING, FEED FINGER	163	
-	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	2119798-2	DETENT PIN	145	
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144	
-	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	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141	
-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140	
-	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	1-18028-2	WASHER, FLAT, REG M4	119	
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
-	1	1	1	1	455888-4	SPACER, CRIMPER	82	
-	1	1	1	1	22281-8	SPRING, COMPRESSION	77	
-	1	1	1	1	854769-4	HOLDER, INS	74	
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70	
-	1	1	1	1	2119943-1	WASHER, SPACER	69	
-	1	-	1	1	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	66	
-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
-	2	2	2	2	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	21028-2	PIN, SLOTTED SPRING .062 X .250	58	
-	-	-	1	1	1338685-1	PAWL, FEED	56	
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52	
-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51	
-	1	1	1	1	1-1752354-4	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	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39	
-	1	1	1	1	2119644-2	RAM WASHER, PRECISION	38	
-	1	1	1	1	2-1752356-2	SUPPORT, TERMINAL	34	
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32	
-	1	1	1	1	1-1320908-0	SPACER, STRIP GUIDE	30	
-	1	1	1	1	2119959-1	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	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	1633933-4	ANVIL, COMBINATION	8	
-	-	-	-	-	-	-	7	
-	-	-	-	-	-	-	6	
-	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5	
-	-	-	-	-	-	-	4	
-	-	-	-	-	-	-	3	
-	-	-	-	-	-	-	2	
-	1	1	1	1	1	4-456406-1	CRIMPER, WIRE PREMIUM	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO	

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		DATE: APRIL 2012 CHK: STAKEM G. BAILEY DATE: APRIL 2012 APVD: T. ELBIN DATE: APRIL 2012	NAME: <b>STE</b> TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:		WEIGHT:		SIZE: A1 CASE CODE: 00779 DRAWING NO: C=2151644	
Customer Accessible Production Drawing				SCALE: 1:1 SHEET 3 OF 4 REV A	

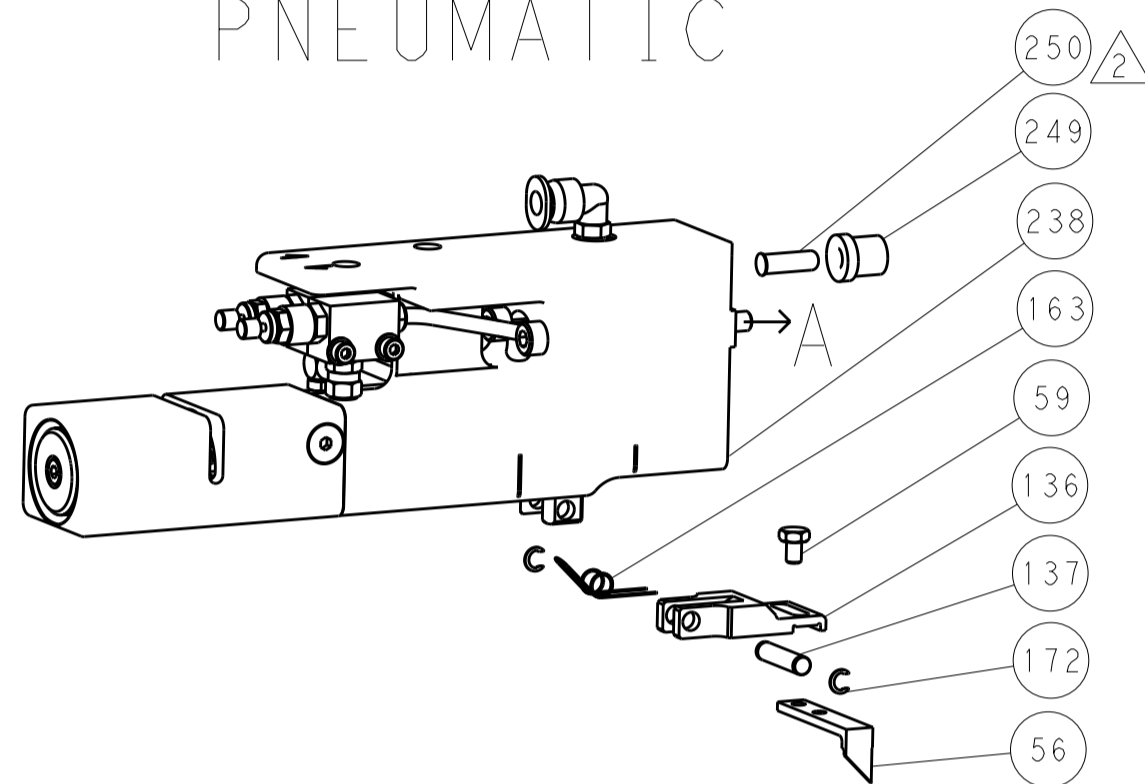
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

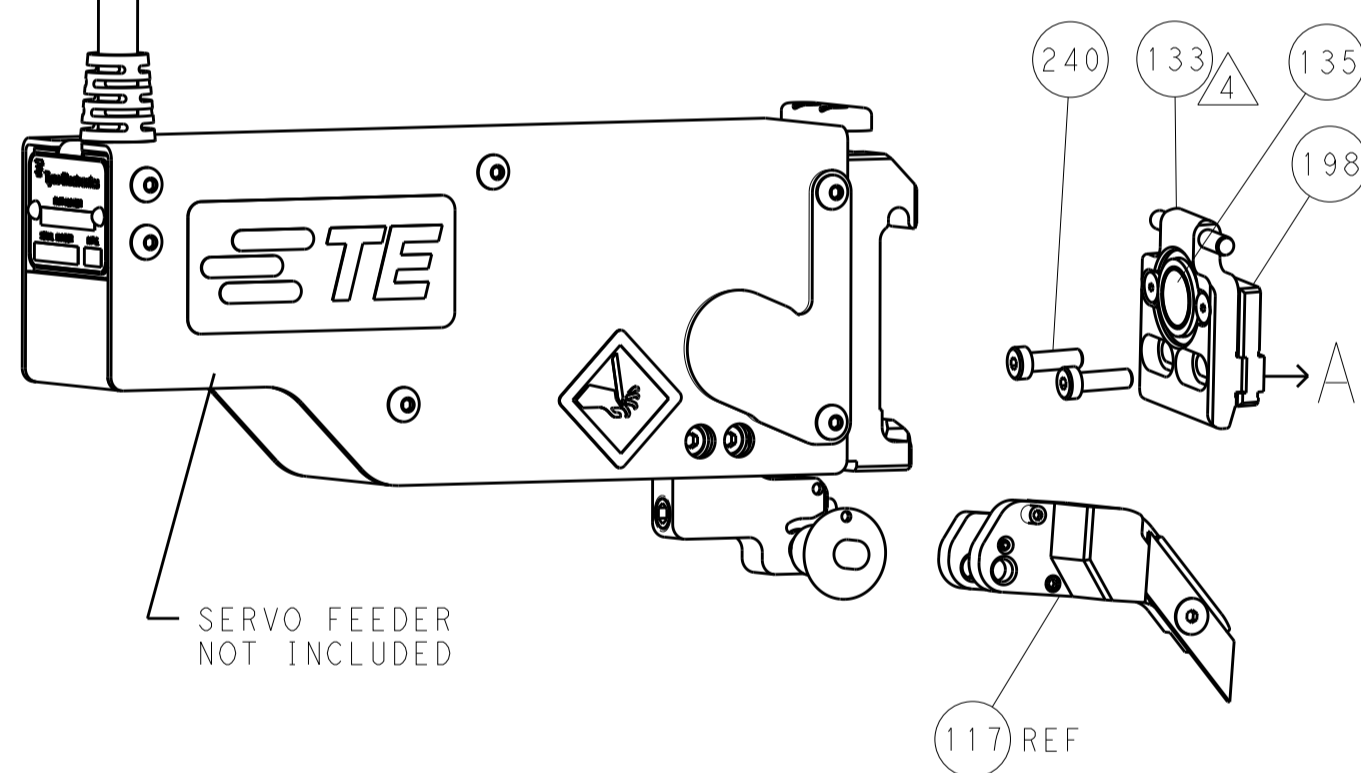
### FEED TYPE MECHANICAL



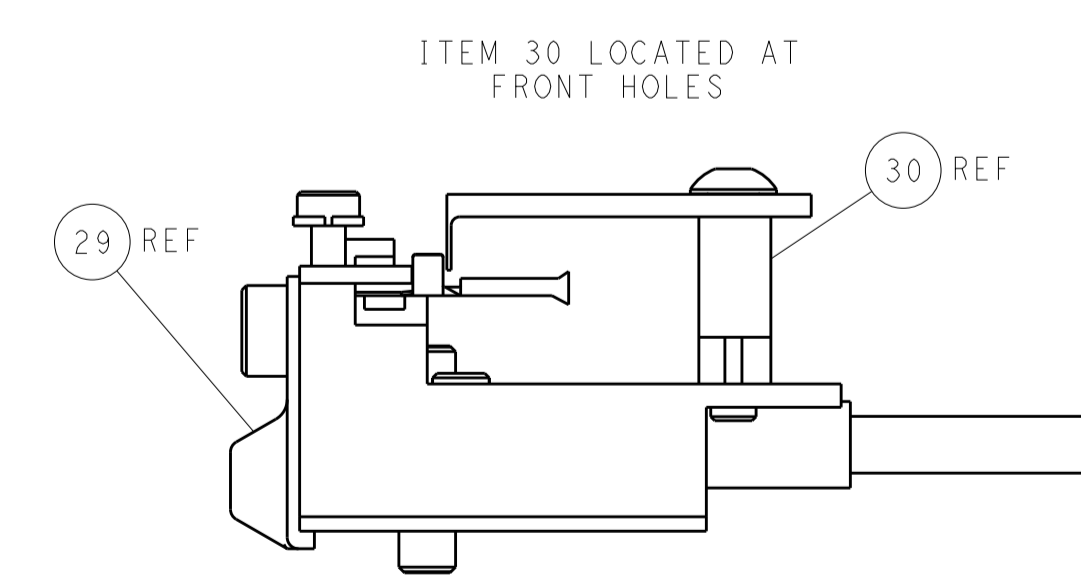
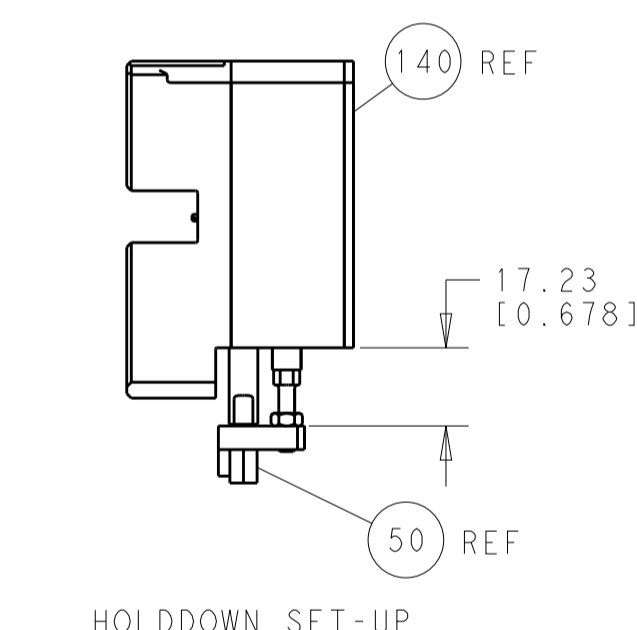
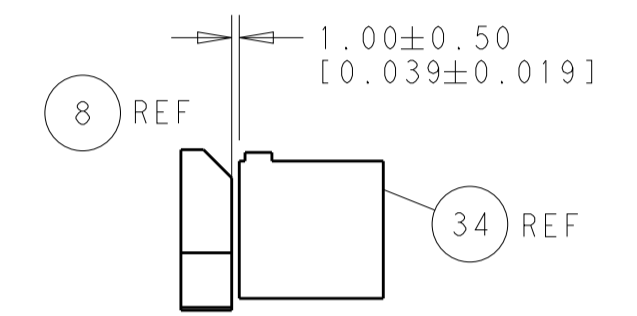
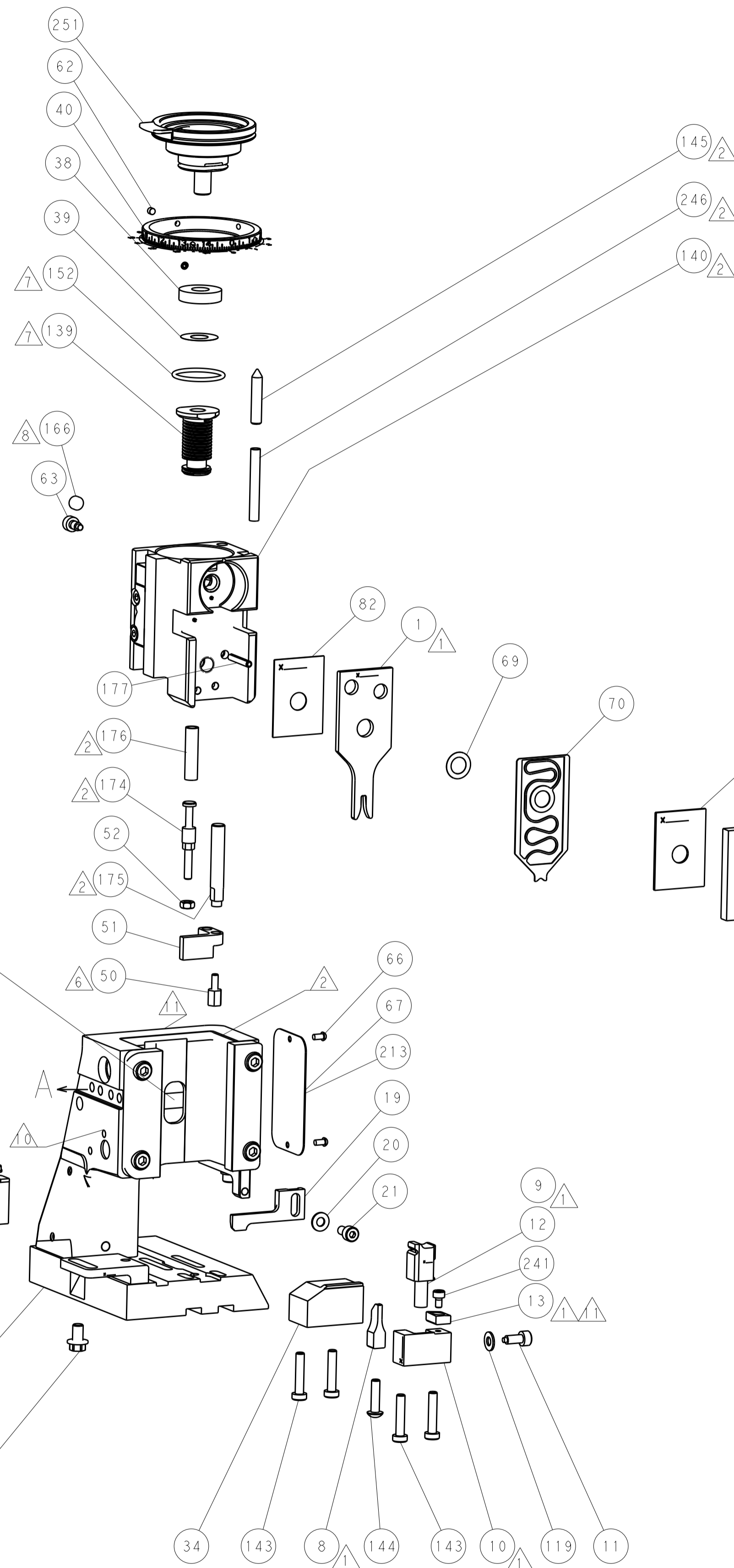
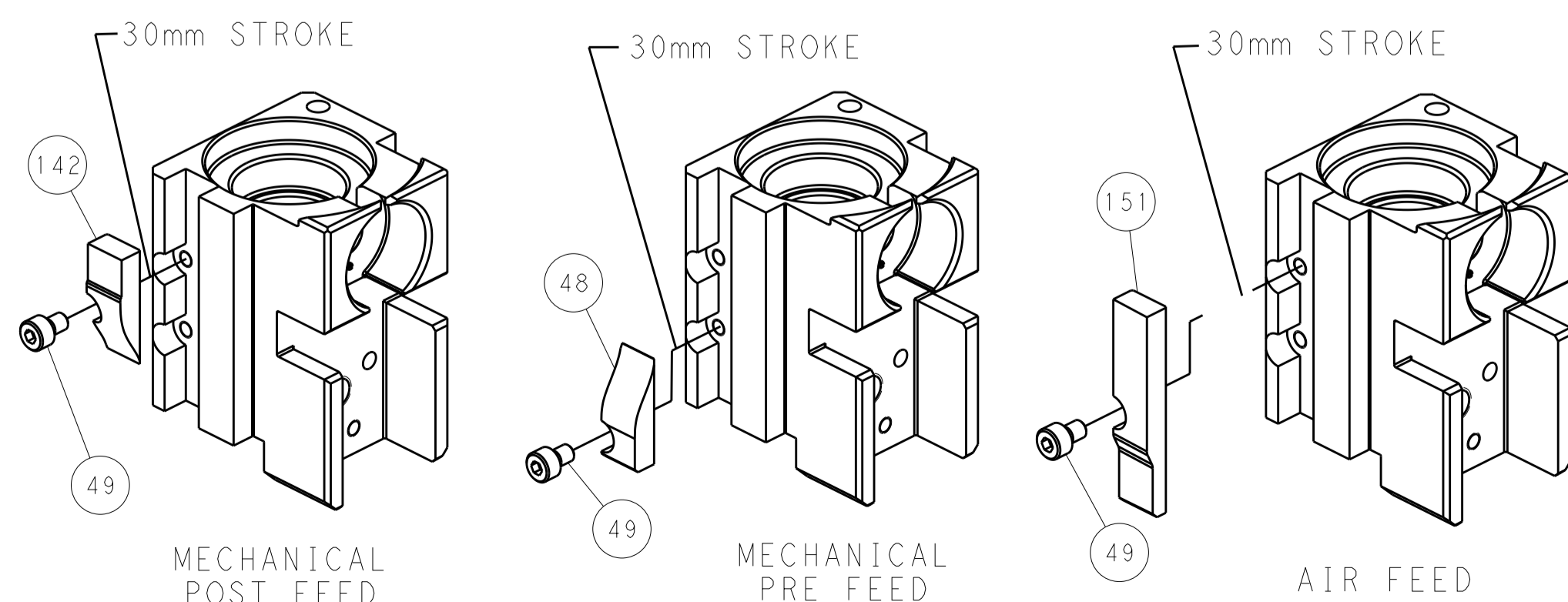
### PNEUMATIC



### 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)

<small>THE INFORMATION CONTAINED HEREON IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS TO BE CONTROLLED TO PREVENT UNAUTHORIZED DISSEMINATION. SHOULD BE CONTROLLED FOR THE LATEST POSITION.</small>		DWN: STAKEM CHK: G. BAILEY APVD: T. ELBIN	DATE: 04APRIL2012 DATE: 10APRIL2012 DATE: 10APRIL2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±		NAME: OCEAN SIDE FEED APPLICATOR OCEAN SIDE FEED APPLICATOR		
MATERIAL: FINISH:		WEIGHT:	SIZE: CAGE CODE DRAWING NO: 00779 ©=2151644 SCALE: 1:1 SHEET 4 OF 4 REV A	