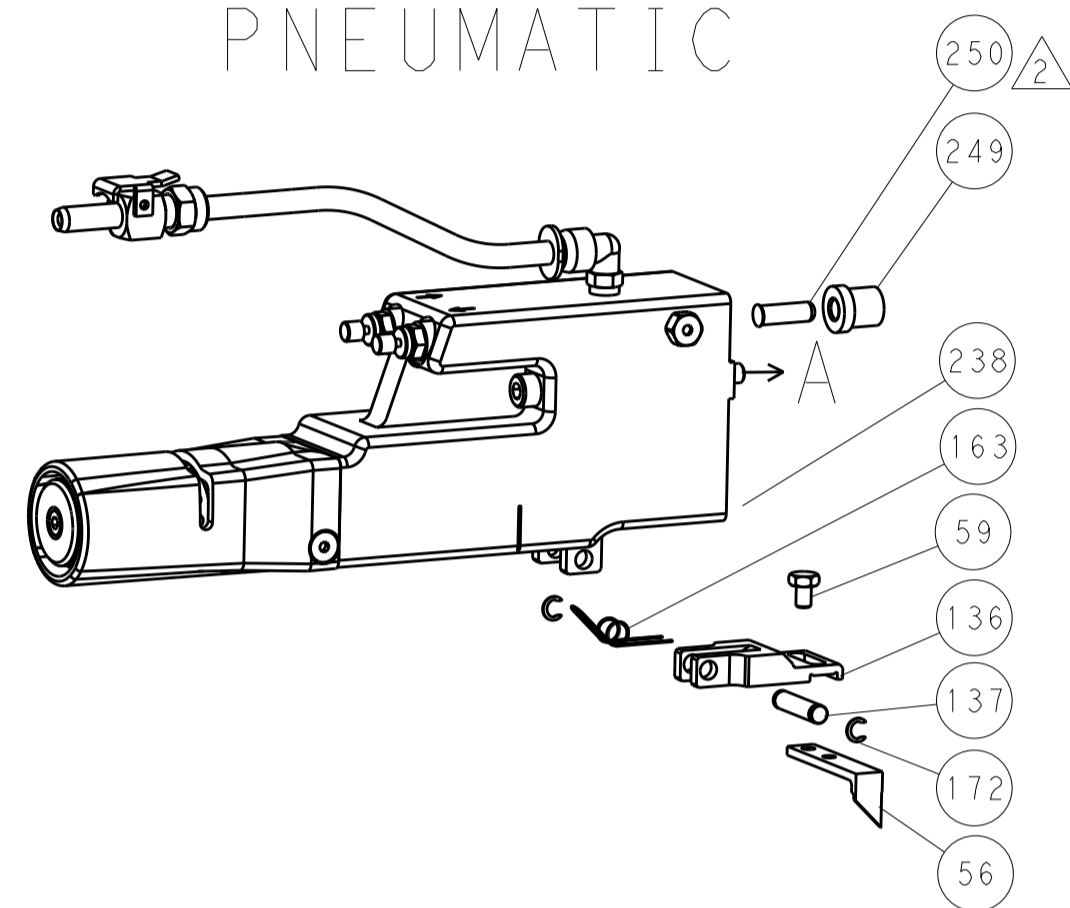




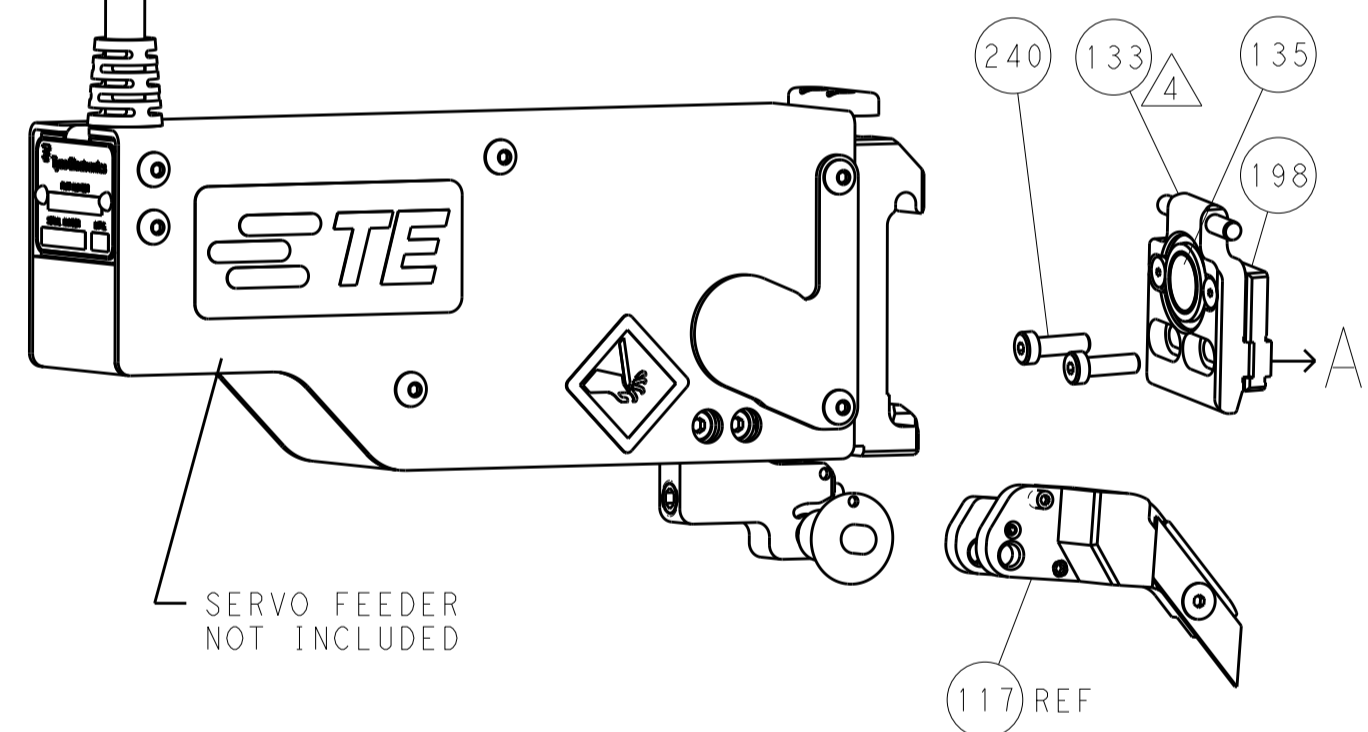
LOC		DIST		REVISIONS			
A	66	P	LTH	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

# FEED TYPE

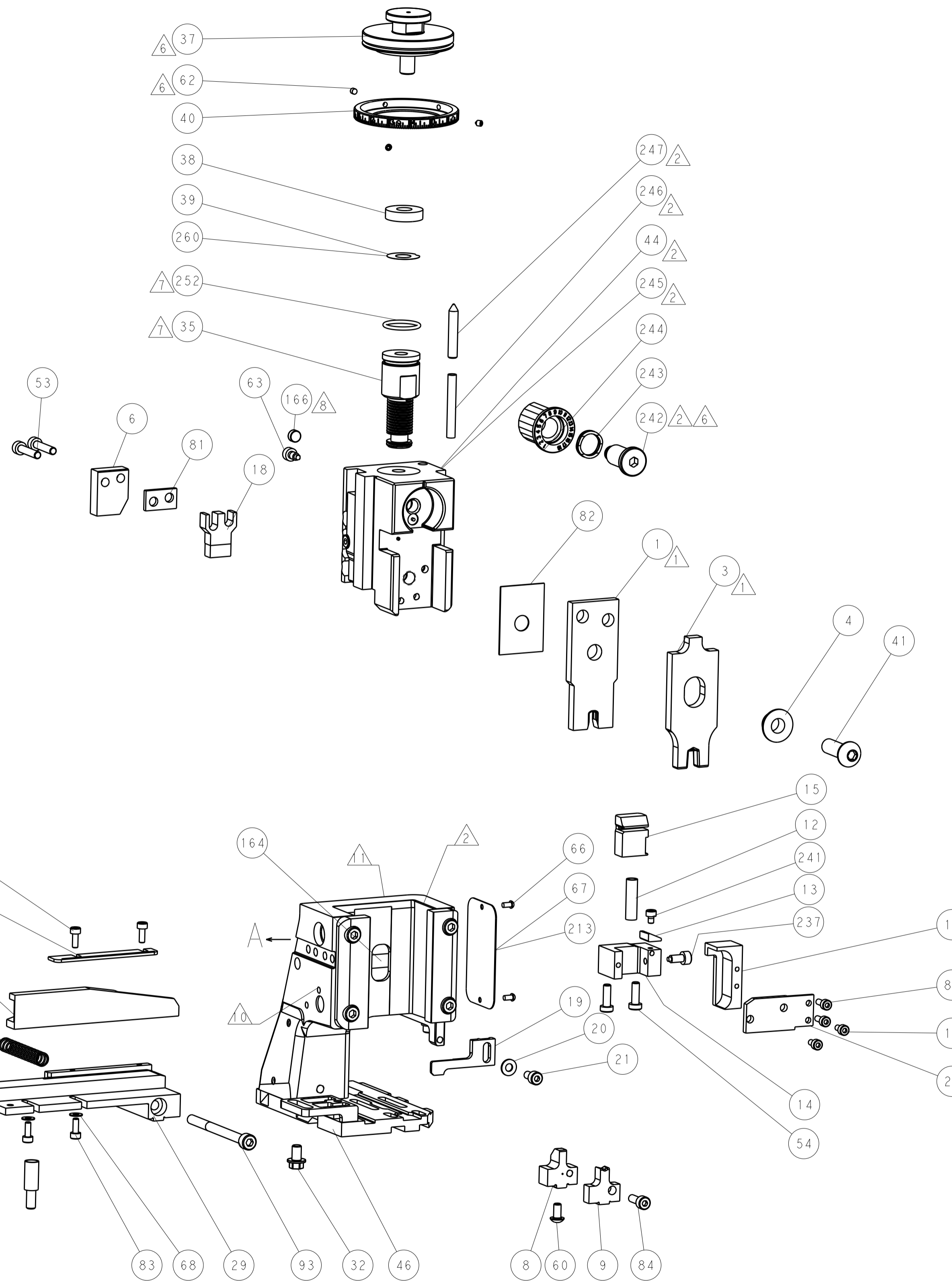
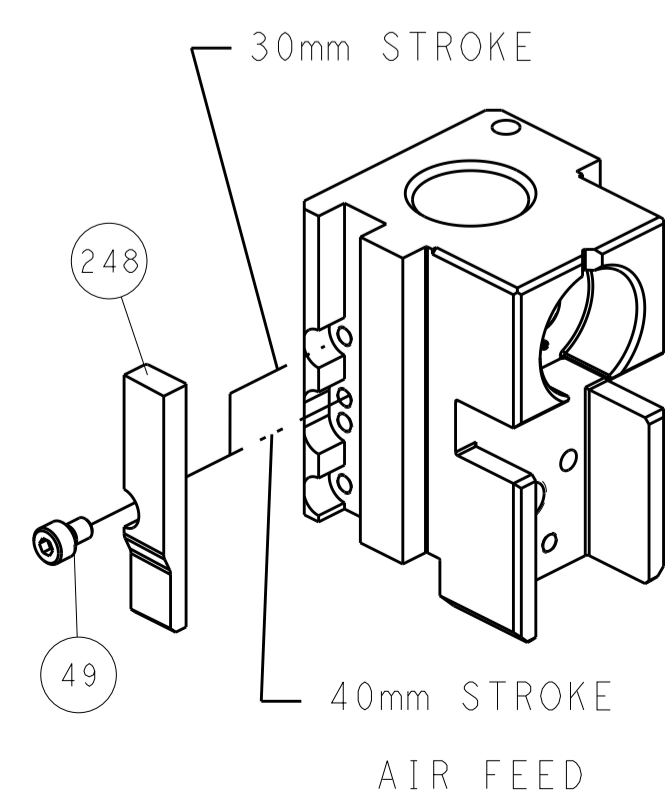
## PNEUMATIC



## SERVO LATCH PLATE



## CAM POSITION



**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THIS DRAWING IS UNPUBLISHED.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 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: BOB HIGMAN 18OCT2013 CHK: G. BAILEY 18OCT2013 APVD: M. CLIFFORD 18OCT2013	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 PRODUCT SPEC: APPLICATION SPEC: WEIGHT: A1 00779 SCALE: 1:2	RESTRICTED TO: CUSTOMER ACCESSIBLE PRODUCTION DRAWING SHEET 2 OF 4 REV B

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2266077-2	B	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2266077-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2266077-4	-	-	-
	2-2266077-5	B	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE <sup>4</sup>	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2266077-7	B	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2266077-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	4.47 mm [1.76]	F
INSUL	5.54 mm [2.18]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA:	TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME:	ULTRA FAST PLUS FULLY INSULATED FASTON	
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE
6.73-7.54 mm [1.265-.297 IN]		∅ 1.52-3.43 mm [1.060-.135 IN]
TERMINAL APPLICATION SPECIFICATION	114-2123	-
TERMINALS APPLIED <sup>13</sup>		
TE TERMINAL	TE TERMINAL	TE TERMINAL
2-520405-2	2-521360-2	2-521055-2
2-520403-2	2-520401-2	2-521361-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING <sup>9</sup>	∅ SOLDER <sup>12</sup>
18 AWG	1.78 +/- 0.05 [1.070 +/- .002]	6.1	6.4
20 OR 22	1.65 +/- 0.05 [1.065 +/- .002]	7.5	7.6

- <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: 8-2266077-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266077-5
- 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.  
 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> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- <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.
- <sup>12</sup> TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅ .12 IN [3.05mm]) 60/40 SOLID CORE AND MEASURE AT CENTER OF SLUG.
- <sup>13</sup> TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

\*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.

-	-	-	-	189728-1	BRACKET, SPACER	255
-	-	-	-	568681-1	SPACER, BASE PLATE	253
-	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
-77	-27	-25	-22	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	P	LTN	DESCRIPTION	DATE	OWN	APVD
			-	-	SEE SHEET 1	-	-	-

-	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	2063440-1	AIR FEED MODULE	238
-	1	1	1	356885-4	STOP, SHEAR	237
-	-	1	-	2119740-2	TAG IDENTIFICATION	213
-	-	1	-	1901094-3	SPACER, FEEDER	198
-	-	-	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
-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	1	1	1	2-2119656-0	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	1-22281-8	SPRING, COMPRESSION	121
-	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	84
-	6	6	6	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	83
-	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	240641-9	SPACER	81
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	2	2	2	1-18028-4	WASHER, FLAT, REG M3	68
-	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	462427-2	FINGER, FEED	56
-	2	2	2	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	53
-	-	-	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	2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	2161336-1	PLATE, REAR STRIP GUIDE	29
-	2	2	2	22281-9	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	684042-4	GUIDE, STRIP, FRONT	24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	2161335-2	SHEAR PLATE, REAR	22
-	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	463460-3	HOLD DOWN, TERMINAL	18
-	1	1	1	803925-2	GUIDE, CARRIER SCRAP	17
-	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1	469542-3	REAR FLOATING SHEAR	15
-	1	1	1	2119862-2	SHEAR HOLDER, REAR	14
-	1	1	1	2280441-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	-	-	-	-	-	10
-	1	1	1	1-454766-4	ANVIL, INSULATION	9
1	1	1	1	808025-3	ANVIL, SAND-BLASTED 16-14	8
-	1	1	1	690468-6	DEPRESSOR SHEAR, REAR	6
-	-	-	-	-	-	5
-	1	1	1	3-238009-6	BLOCK, FL CRIMPER SPACER	4
1	1	1	1	1803130-1	CRIMPER, INSULATION FASTON	3
-	-	-	-	-	-	2
1	1	1	1	808830-2	CRIMPER, SEMI FLAT 16-14	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

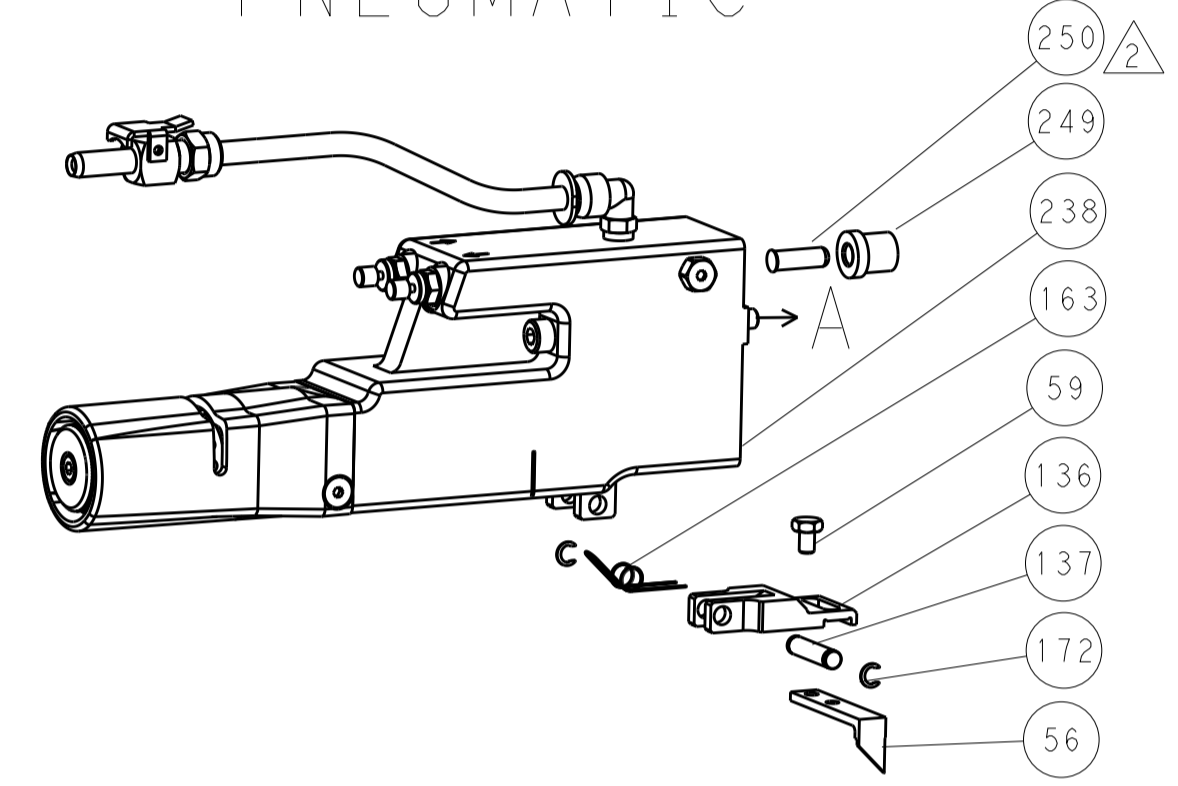
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: BOB HIGMAN 18OCT2013		CHK: G. BAILLEY 18OCT2013		APVD: M. CLIFFORD 18OCT2013		NAME: Ocean Side Feed Applicator	
mm		0 PLC ±		PRODUCT SPEC		APPLICATION SPEC		SIZE: A1		CAGE CODE: 00779	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2		SHEET: 3 OF 4		REV: B	

Customer Accessible Production Drawing

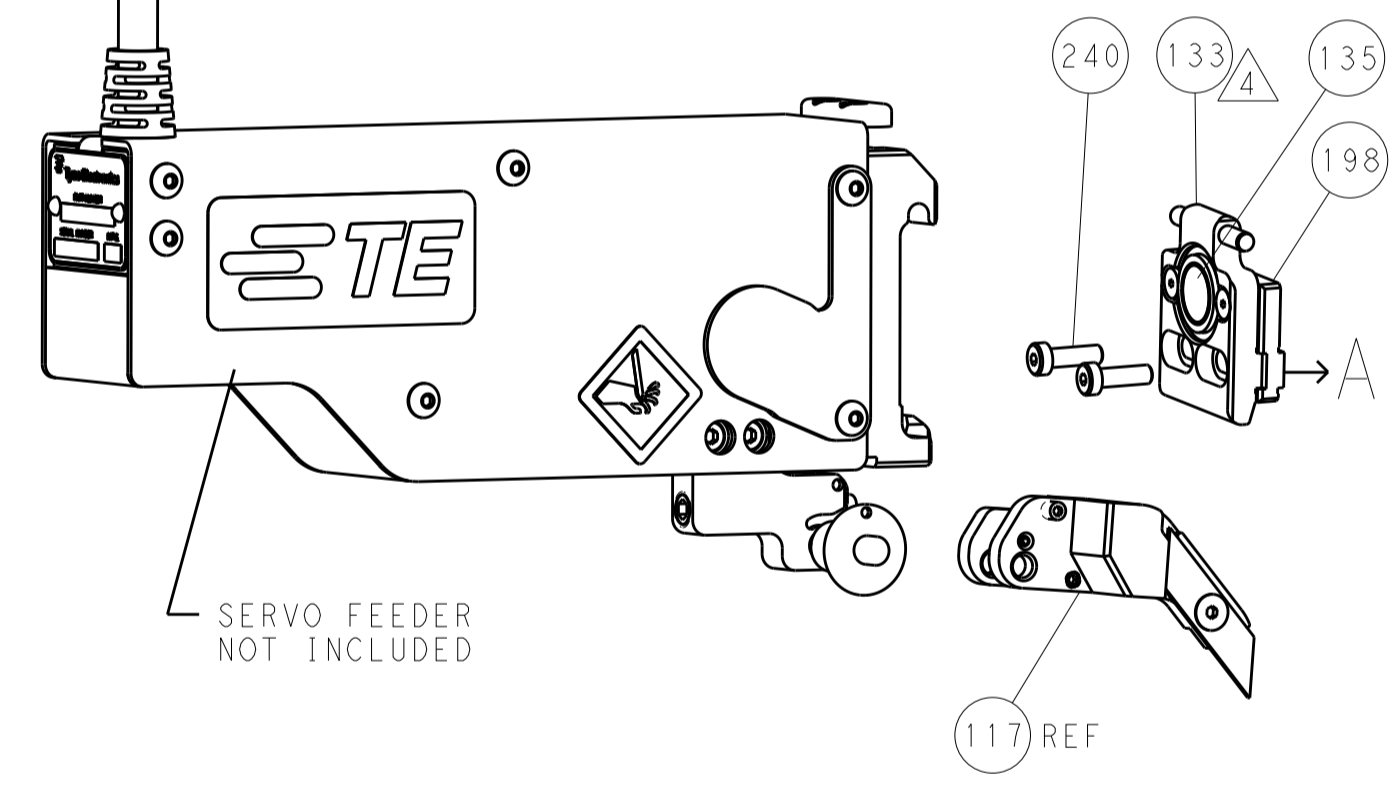
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P	LTN	DESCRIPTION	DATE	DMN	APVD		
A	66	SEE SHEET 1					

### FEED TYPE

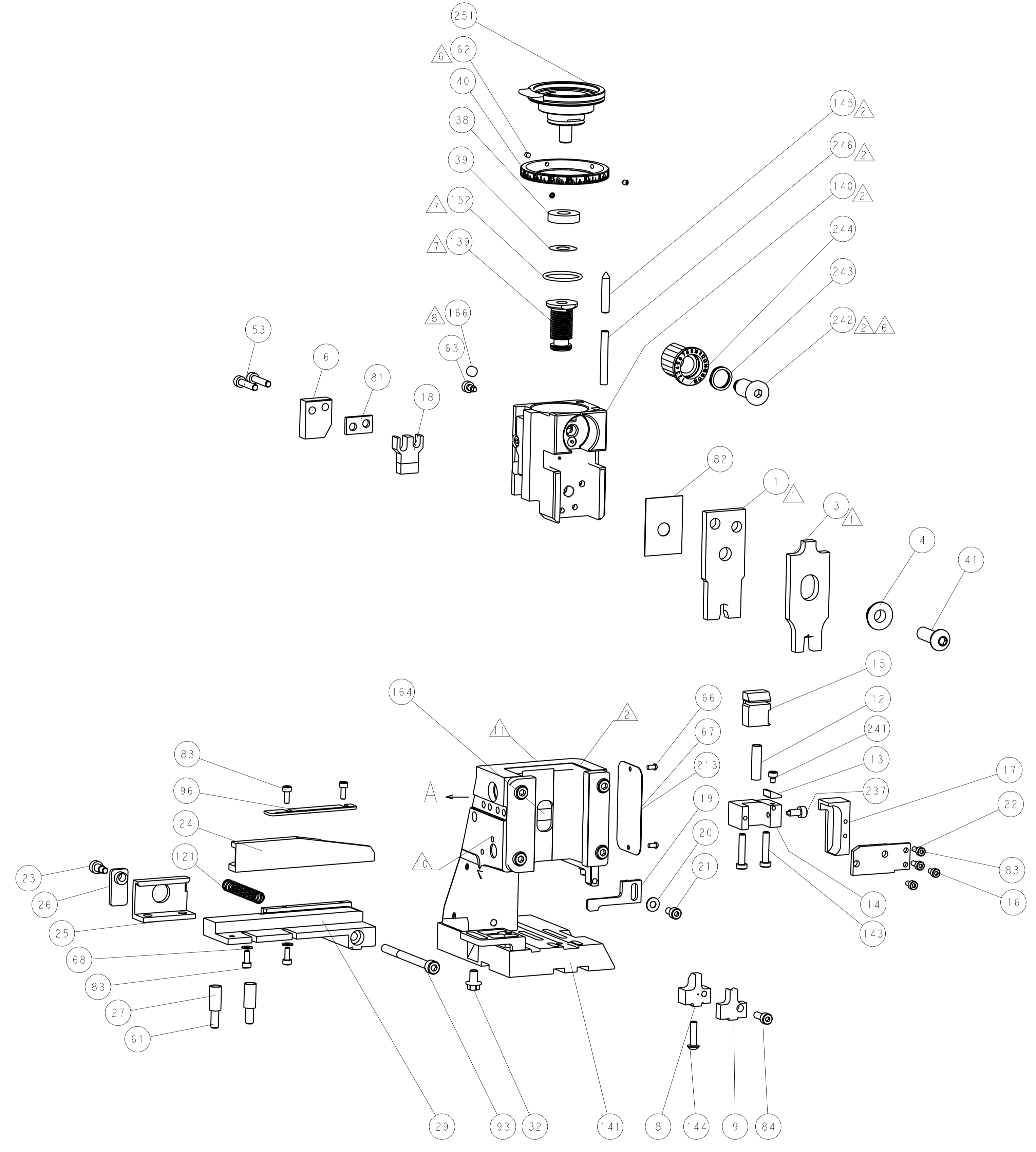
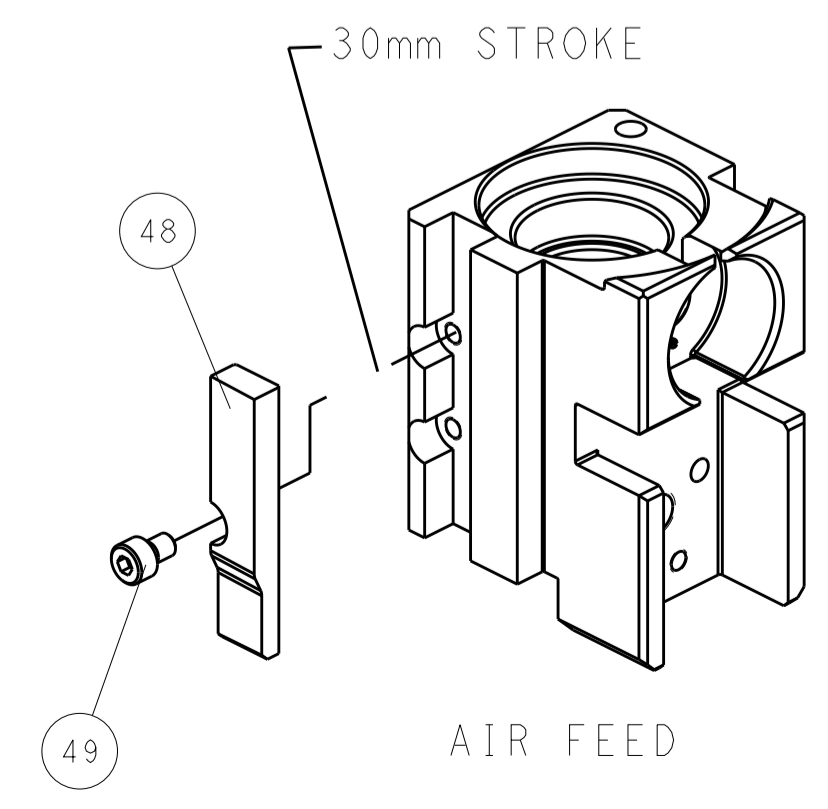
### PNEUMATIC



### SERVO LATCH PLATE



### CAM POSITION



**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 18OCT2013		REV: G. BAILEY 18OCT2013		NAME: STE TE Connectivity	
mm	0 PLC	±		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO	Harrisburg, PA 17105-3608	
	1 PLC	±		PRODUCT SPEC				Ocean Side Feed Applier	
	2 PLC	±		APPLICATION SPEC					
	3 PLC	±		WEIGHT					
	4 PLC	±		SCALE	1:2	SHEET 4 OF 4	REV B		
	ANGLES	±		Customer Accessible Production Drawing					