

Table with columns: ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER, PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

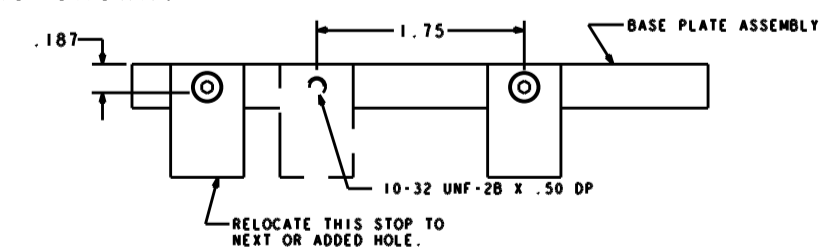
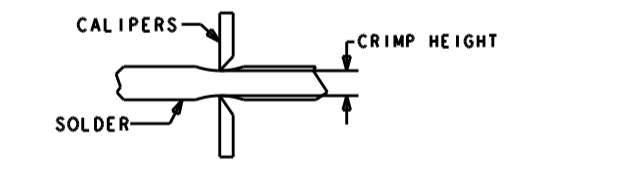
Table with columns: CRIMP WIRE, SIZE, TYPE, APPLICATOR INSTRUCTIONS 408-10389.

Table with columns: TERMINAL DATA: TE TERMINAL, TE CRIMP SPECIFICATION, WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

Table with columns: WIRE SIZE, CRIMP HEIGHT INCH [mm], CRIMP HEIGHT REFERENCE SETTING, SOLDER.

- 1 RECOMMENDED SPARE PARTS
2 GREASE BEARING SURFACES LIGHTLY
3 LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER: PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151699-4 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151699-5 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151699-6
5 ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
6 GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
7 MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
8 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.
9 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.
10 WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT
11 ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
12 ITEM 5 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.

- 3 TO CHECK CRIMP HEIGHT. CRIMP SOLDER (Ø.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.
4 IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.
5 ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.
6 ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.
7 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
8 CUT TO LENGTH AT ASSEMBLY.



*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.

Table with columns: -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)

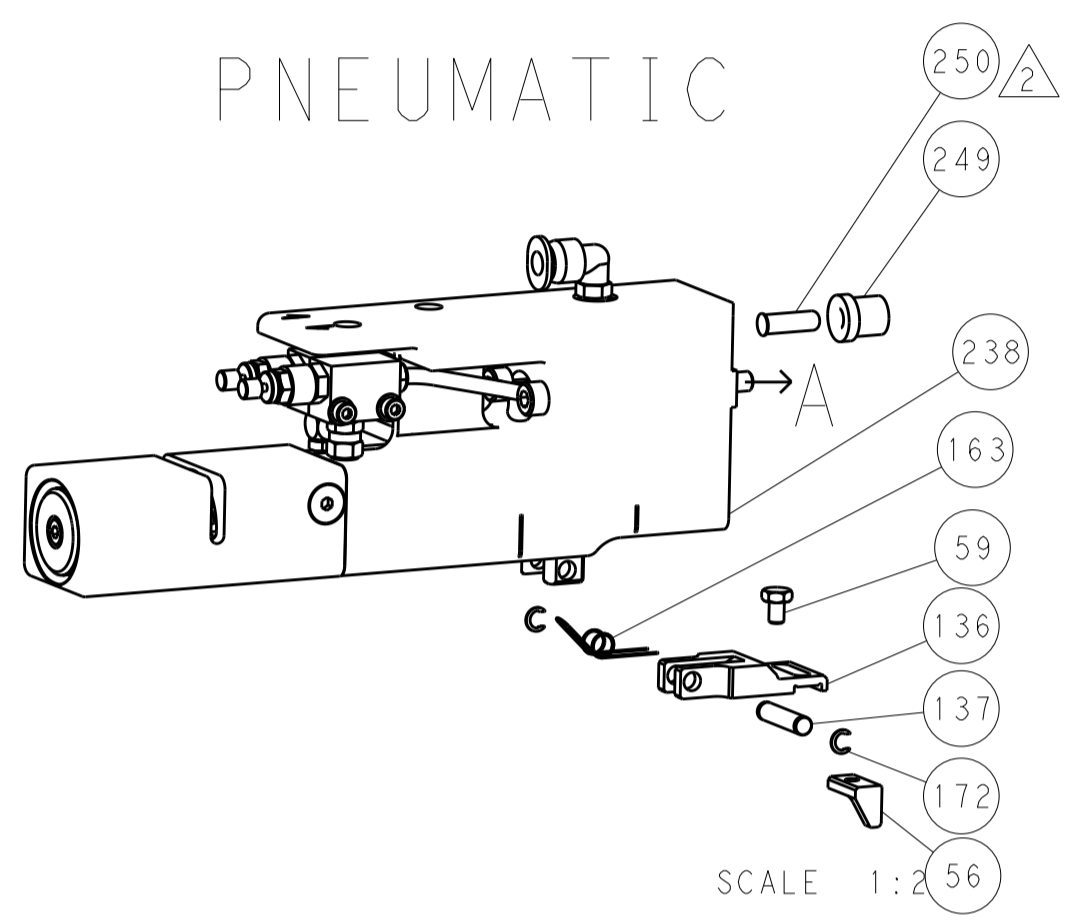
Table with columns: SET UP GAUGE 2119599-1, LOC A, DIST 66, REVISIONS.

Large table with columns: QTY, PART NO, DESCRIPTION, DATE, DWG, REV, ITEM NO. Includes various part numbers and descriptions.

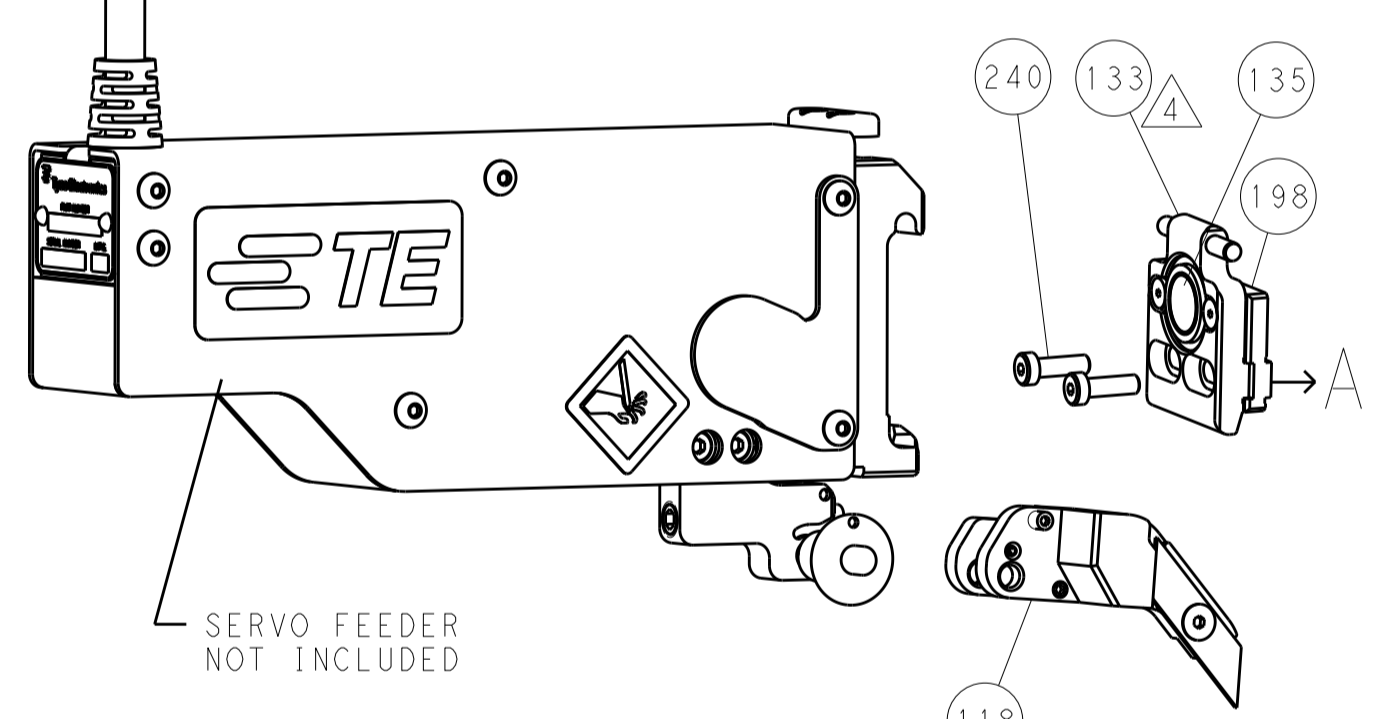
Table with columns: DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, SCALE, SHEET 1 OF 4, REV A.

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

FEED TYPE PNEUMATIC

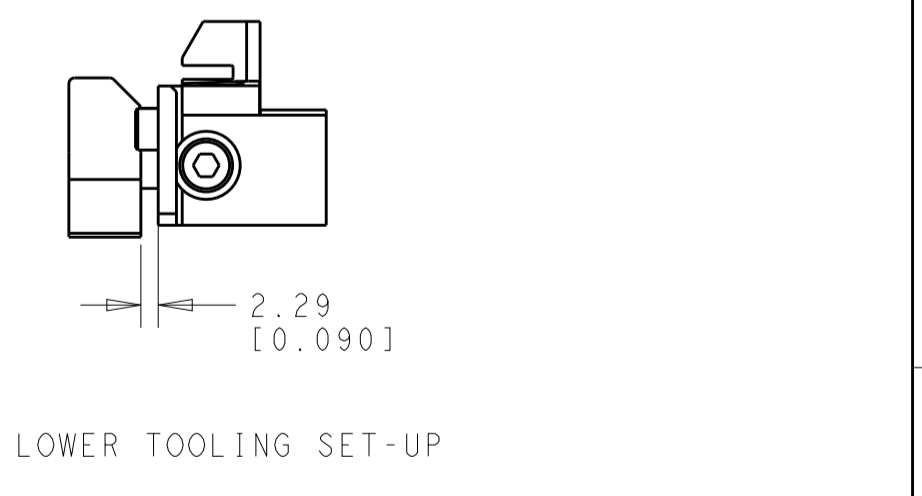
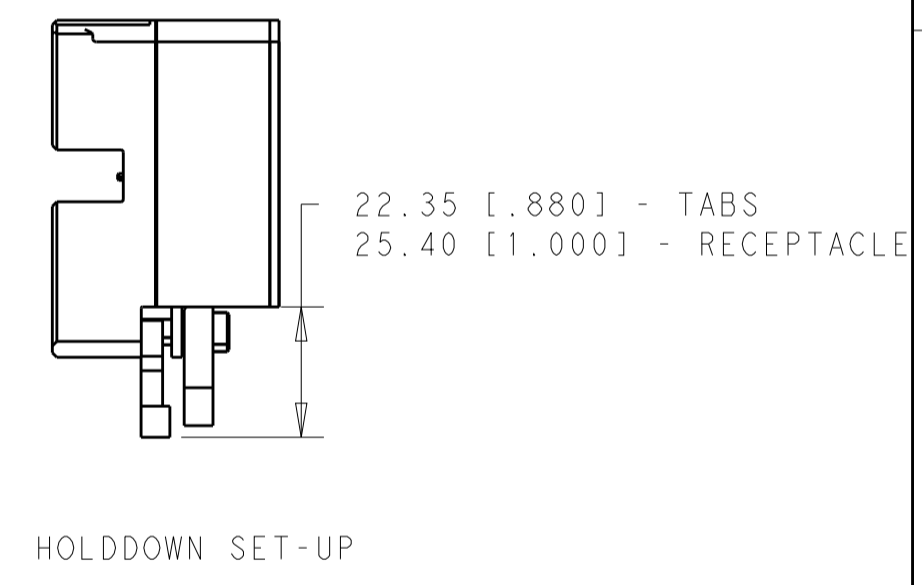
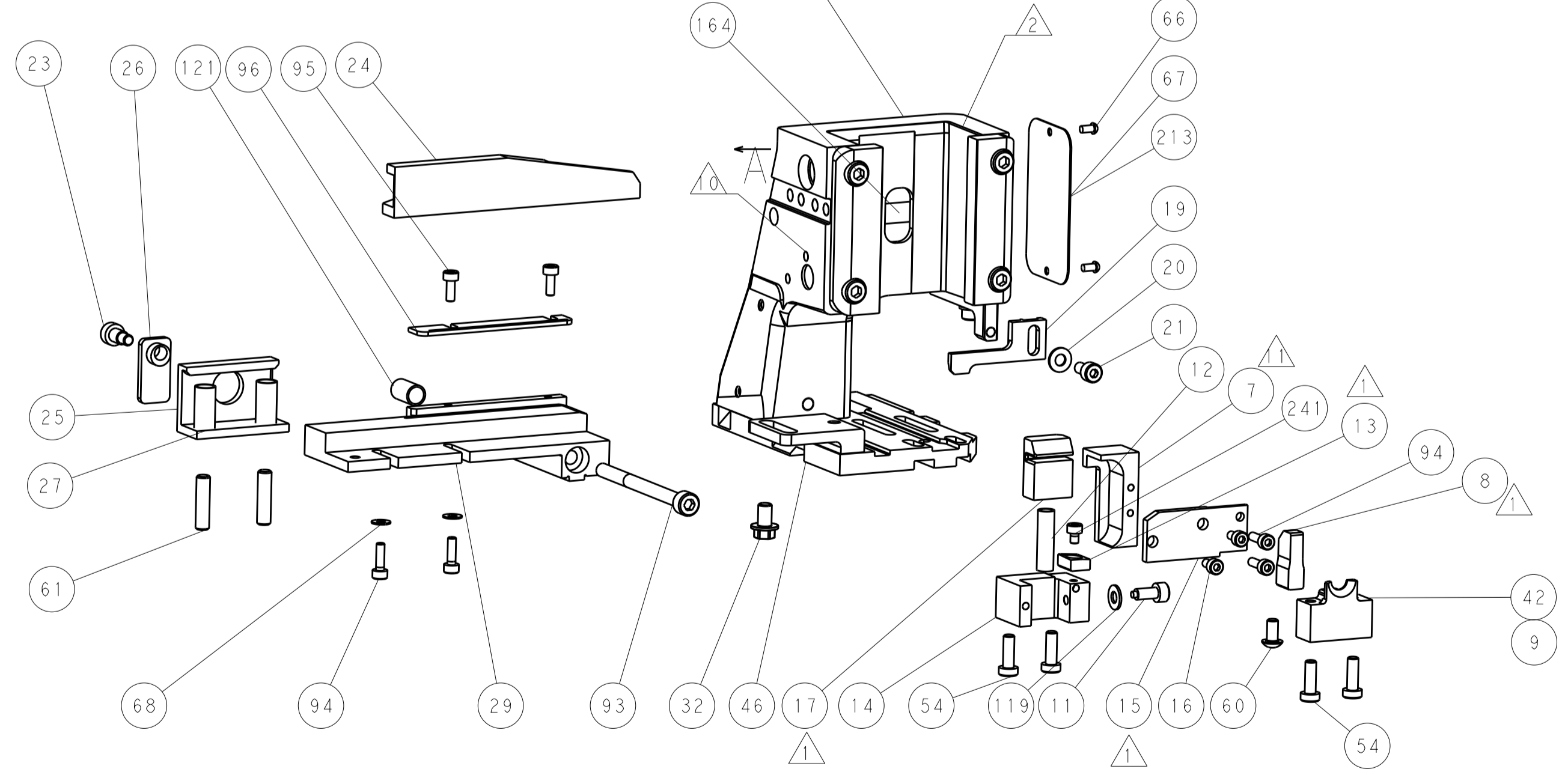
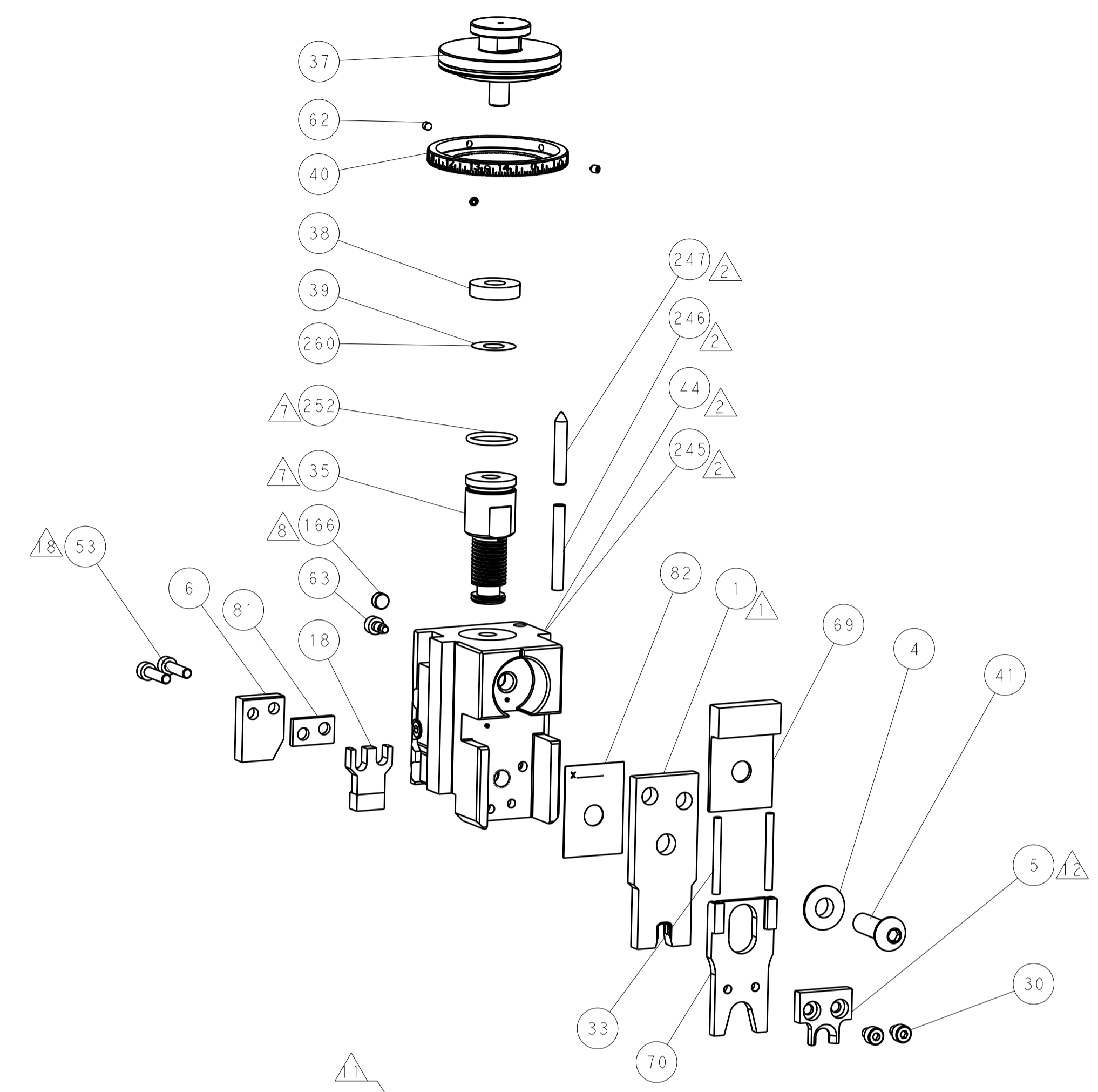
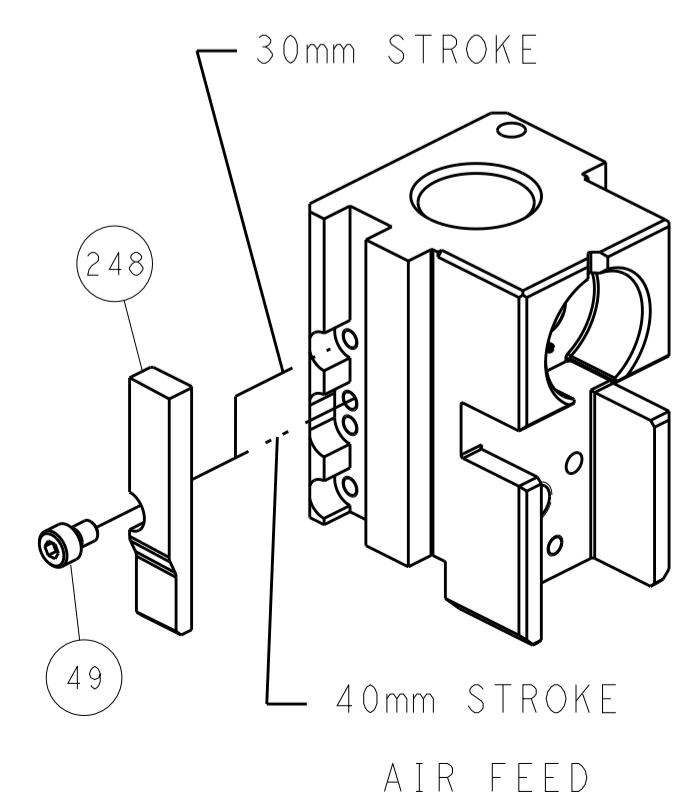


SERVO LATCH PLATE



***FEED FINGER REPRESENTATION ABOVE MAY DIFFER FROM ACTUAL FEED FINGER THAT IS REQUIRED BY THIS APPLICATOR

CAM POSITIONS



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 2012 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN: B. WEAVER 18JUN2012 CHK: G. HOFFNER 18JUN2012 APVD: T. ELBIN 18JUN2012	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±0.0005		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151699	RESTRICTED TO: - SCALE: 1:1 SHEET: 2 of 4 REV: A
MATERIAL: - FINISH: -		WEIGHT: - Customer Accessible Production Drawing	SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151699-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	-	-	-	-	-	-	
	2-2151699-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	2161540-1	8-2151699-5	1901094-3	1976043-1	2168400-6 (QUANTITY 2)
	2-2151699-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	
	7-2151699-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
	.205 [5.21 mm]	D
INSUL	-	-

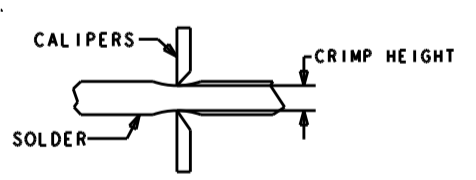
APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: FULLY INSULATED FASTON			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
.240-.322 IN [6.10-8.18 mm]		∅ .240 MAX	
TERMINAL APPLICATION SPECIFICATION	114-2123		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
3-520370-2			

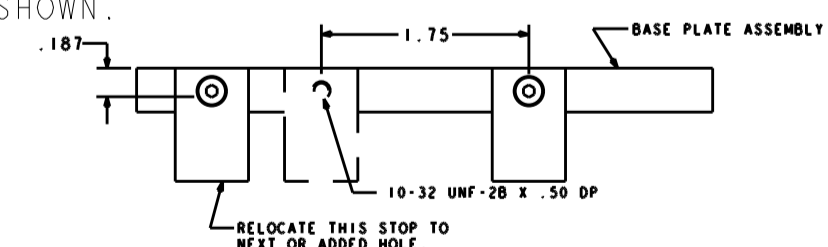
WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING	∅ SOLDER
14	0.075+/-0.002 [1.91+/-0.05]	5.6	.19 IN [4.83mm]
16	0.070+/-0.002 [1.78+/-0.05]	7.0	.19 IN [4.83mm]

- 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:
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151699-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151699-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151699-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- 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.
- 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.
- ITEM 7 MUST BE REMOVED IF APPLICATOR IS USED ON BENCH MACHINE.
- ITEMS 5 AND 9 ARE REQUIRED WHEN RUNNING ON A LEADMAKER. ITEM 42 REQUIRED WHEN RUNNING ON A BENCH MACHINE.

TO CHECK CRIMP HEIGHT, CRIMP SOLDER (∅.19 IN [4.83mm] 60/40 SOLID CORE) AND MEASURE AT CENTER OF SLUG.



IT MAY BE NECESSARY TO MODIFY THE T-TERMINATING/K-PRESS BASE PLATE BEFORE USE BY ADDING A 10-32 HOLE TO RELOCATE THE FORWARD STOP AS SHOWN.



ITEMS 253 AND 255 MUST BE INSTALLED IN THE G-TERMINATING UNIT CHIP RELIEF HOLE BEFORE INSTALLING THE APPLICATOR.

ITEM 257, REQUIRED IF APPLICATOR IS RUN ON T-TERMINATING UNIT/K-PRESS. GUARD, ITEM 256, REQUIRED IF APPLICATOR IS BEING USED ON G-TERMINATOR.

TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.

CUT TO LENGTH AT ASSEMBLY.

***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.

REF	REF	REF	REF	DESCRIPTION	ITEM NO
-	-	-	-	462992-7 GUARD ASSEMBLY	257
-	REF	REF	REF	679532-1 INSERT, GUARD	256
-	1	1	1	189728-1 BRACKET, SPACER	255
-	1	1	1	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, LCHS-12, MISUMI	249
-	1	1	1	1-22279-3 SPRING, COMPRESSION	246
-	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
-77	-27	-25	-22	PART NO	

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

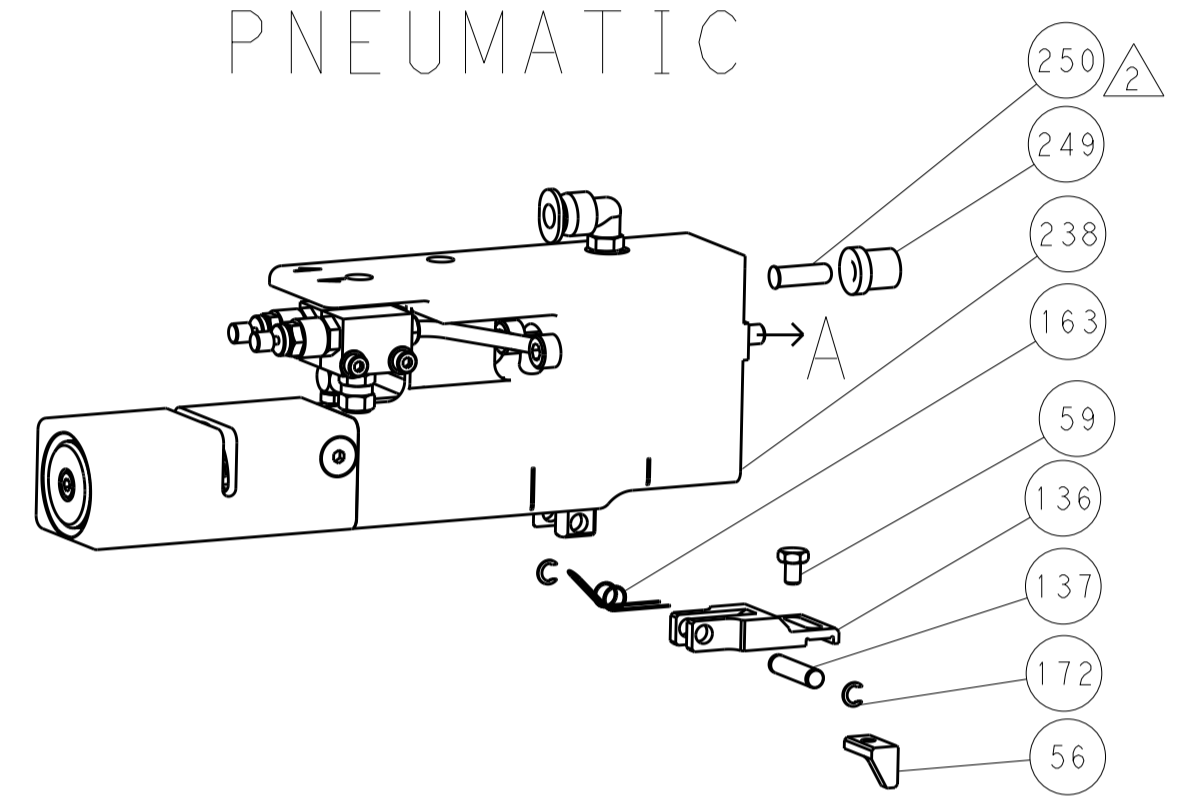
REV	DATE	BY	APPD	DESCRIPTION	ITEM NO
-	-	-	-	2119580-1 MECHANICAL FEED ASSEMBLY	239
-	-	-	1	2063440-2 AIR FEED MODULE	238
-	-	1	-	2119740-2 TAG, IDENTIFICATION	213
-	-	1	-	1901094-3 SPACER, FEEDER	198
-	-	2	-	21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	994969-1 MAGNET, RARE EARTH HIGH ENERGY	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
-	4	4	4	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	1-18028-2 WASHER, FLAT, REG M4	119
-	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
-	4	4	4	18023-4 SCR, SKT HD CAP M3 X 10.0	94
-	1	1	1	2168083-6 SCR, SKT HD CAP, RoHS, M5 X 65	93
-	1	1	1	455888-4 SPACER, CRIMPER	82
-	1	1	1	240641-9 SPACER	81
-	1	1	1	2119956-1 DOCUMENTATION PACKAGE	71
-	1	1	1	2161332-4 DEPRESSOR, WIRE FUNNEL	70
-	1	1	1	2161331-1 SPACER, WIRE FUNNEL DEPRESSOR	69
-	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	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	2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16	53
-	-	-	1	18023-9 SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	462433-7 SUPPORT, INSULATION	42
-	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
-	2	2	2	5-22278-1 SPRING, COMPRESSION	33
-	1	1	1	2161328-1 HEX HEAD, FLANGED, M5 X 8mm LONG	32
-	2	2	2	1-2168083-4 SCR, SKT HD CAP, RoHS, M4 X 5	30
-	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	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	463460-2 HOLD DOWN, TERMINAL	18
-	1	1	1	469542-3 REAR FLOATING SHEAR	17
-	2	2	2	1-2168083-1 SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1	2161335-2 SHEAR PLATE, REAR	15
-	1	1	1	2119862-2 SHEAR HOLDER, REAR	14
-	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	462843-6 TERMINAL SUPPORT	9
-	1	1	1	464282-2 ANVIL, SAND-BLASTED 16-14	8
-	1	1	1	803925-2 GUIDE, CARRIER SCRAP	7
-	1	1	1	2-690468-5 DEPRESSOR SHEAR, REAR	6
-	1	1	1	462431-5 WIRE FUNNEL	5
-	1	1	1	238009-3 BLOCK, FL CRIMPER SPACER	4
-	1	1	1	464281-1 CRIMPER, SEMI FLAT 16-14	1
-77	-27	-25	-22	PART NO	

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

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: B. WEAVER 18JUN2012		CHK: G. HOFENER		NAME: Ocean Side Feed Applicator	
0 PLC ±.1		1 PLC ±.01		APVD: T. ELBIN 18JUN2012		PRODUCT SPEC: -		SIZE: A	
2 PLC ±.005		3 PLC ±.005		APPLICATION SPEC: -		WEIGHT: -		CAGE CODE: 00779	
4 PLC ±.0005		ANGLES: -		FINISH: -		SCALE: 1:1		SHEET 3 OF 4	
MATERIAL: -		REVISIONS: -		CUSTOMER ACCESSIBLE PRODUCTION DRAWING		REV: A		RESTRICTED TO: -	

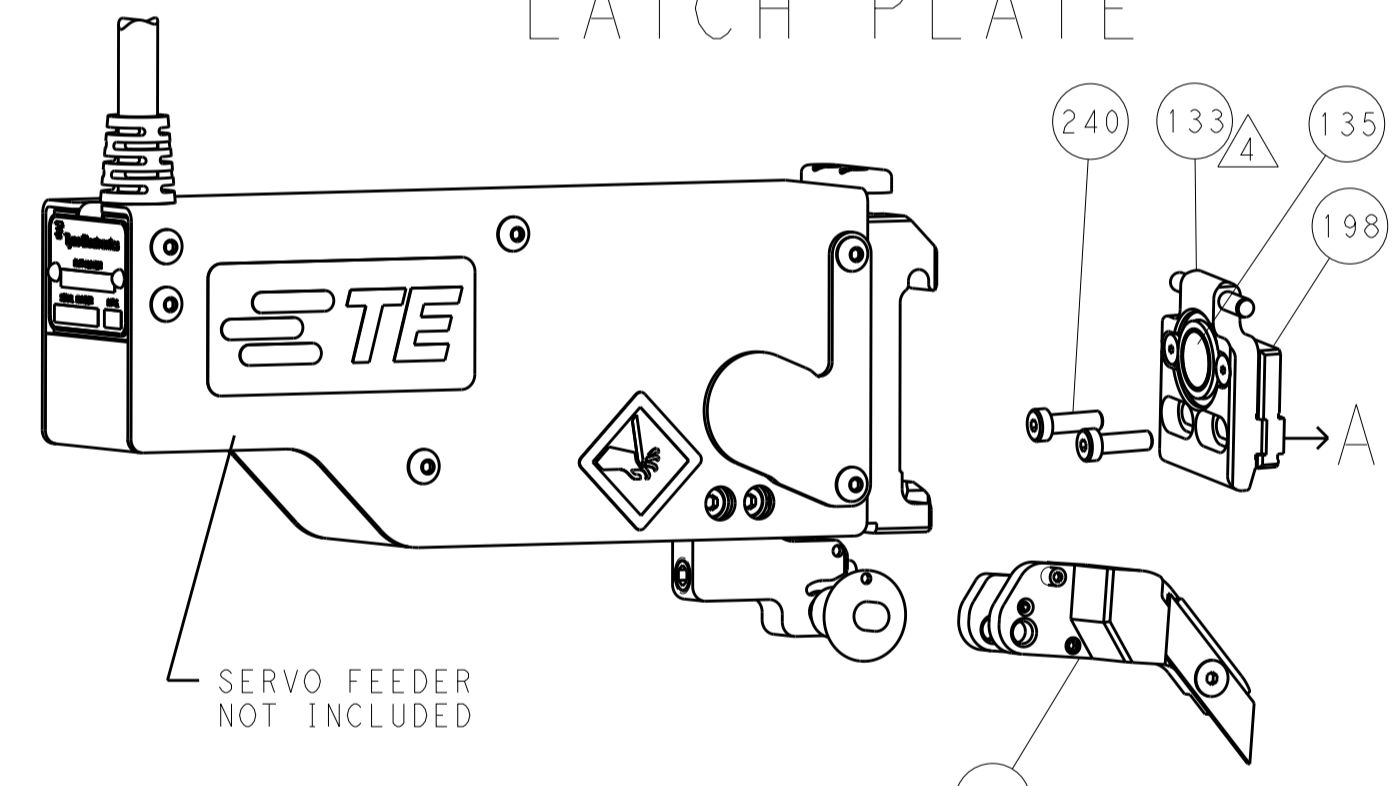
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE PNEUMATIC



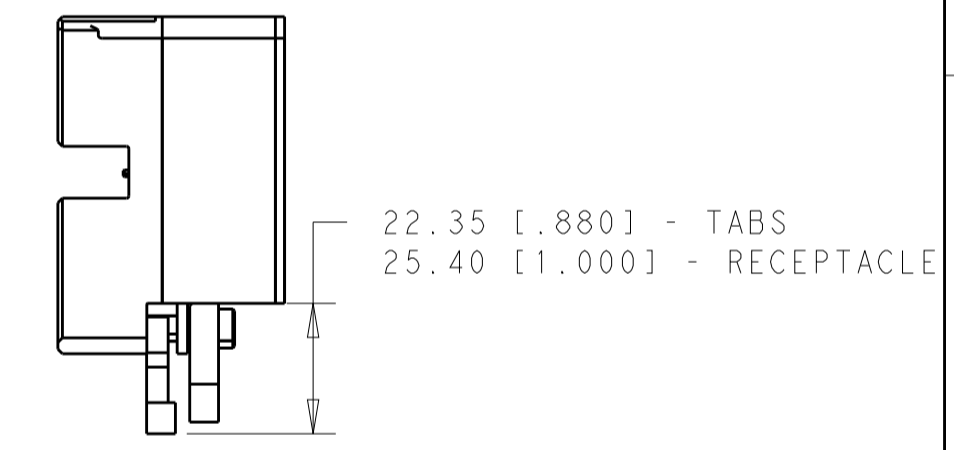
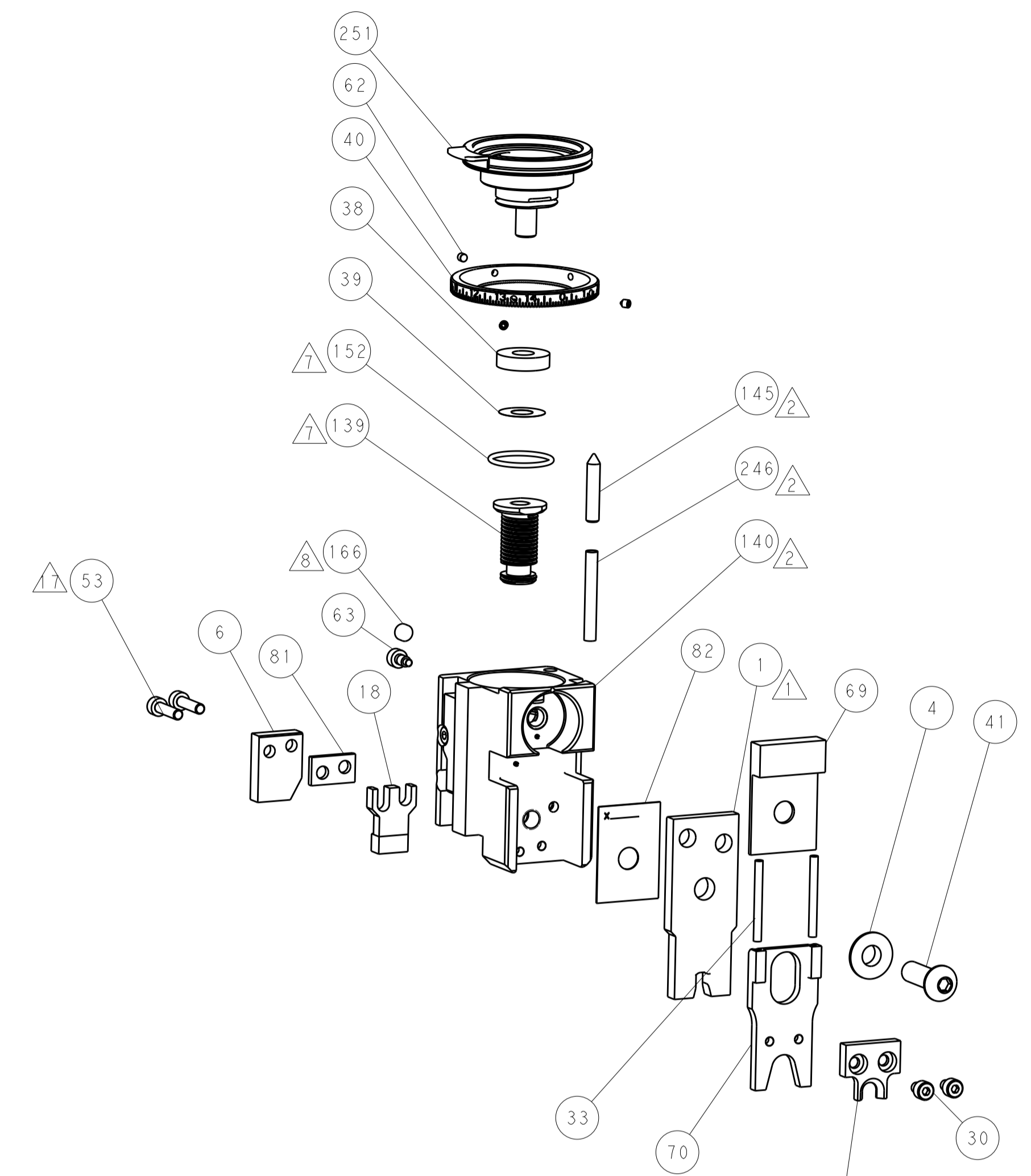
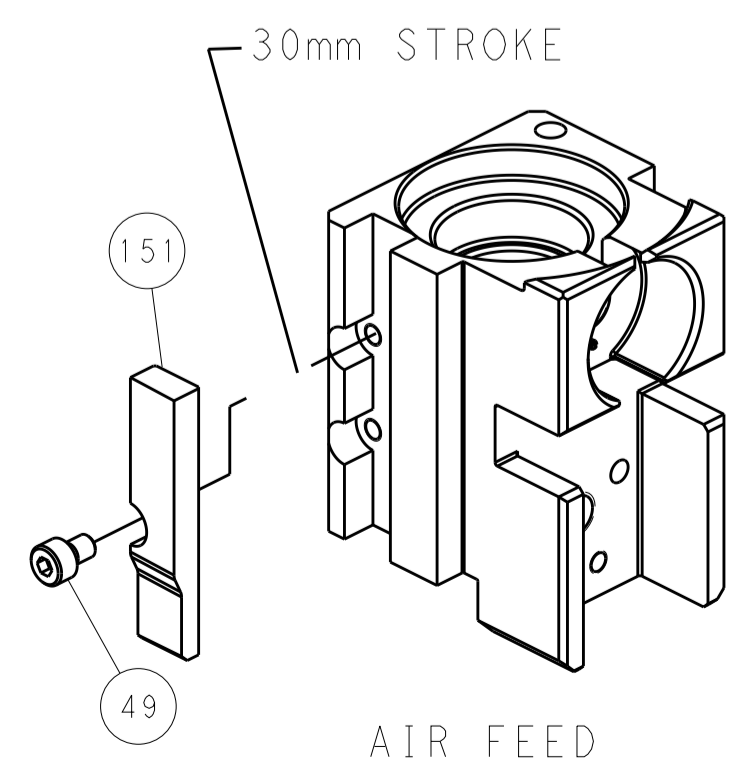
SCALE 1:2

SERVO LATCH PLATE

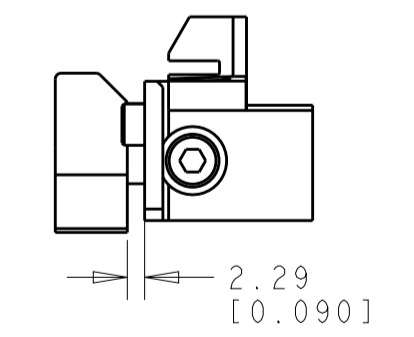


***FEED FINGER REPRESENTATION ABOVE MAY DIFFER FROM ACTUAL FEED FINGER THAT IS REQUIRED BY THIS APPLICATOR

CAM POSITION



HOLDDOWN SET-UP



LOWER TOOLING SET-UP

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 B. WEAVER 18JUN2012		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	APVD T. ELBIN 18JUN2012	NAME Ocean Side Feed Applicator
MATERIAL	FINISH	WEIGHT	SIZE CAGE CODE DRAWING NO	RESTRICTED TO	Customer Accessible Production Drawing		
			A 00779 C=2151699		SCALE 1:1	SHEET 4 OF 4	REV A

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003