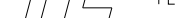
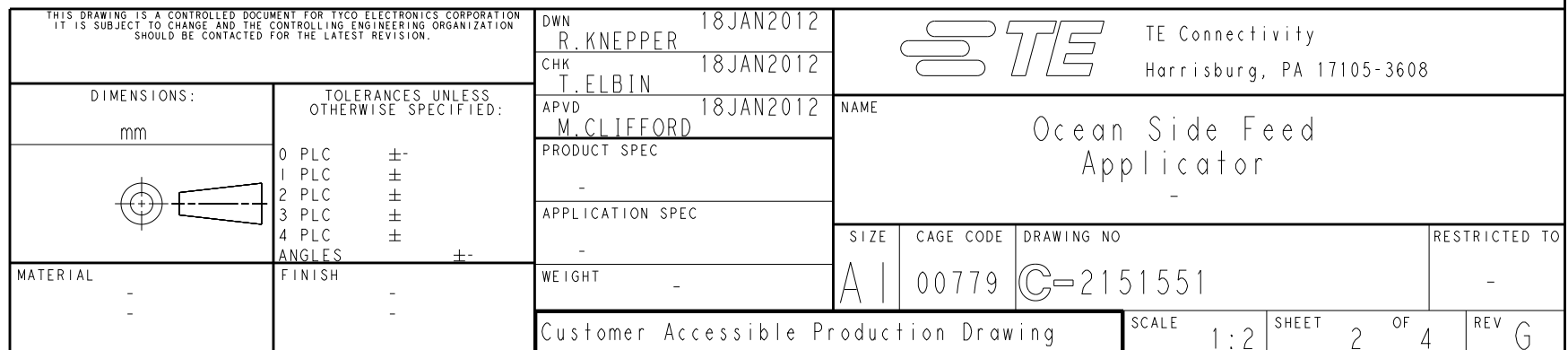
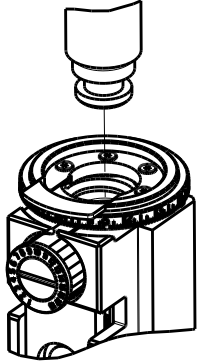


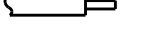
|                                                                                                                                                                                                                                  |  |                                                     |  |                                                                                                                                    |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------|--|
| <small>THIS DRAWING IS A CONTROLLED DOCUMENT AND IS THE PROPERTY OF THE DRAWING ORIGINATOR. IT IS TO BE KEPT IN A SECURE LOCATION AND NOT REPRODUCED OR COPIED WITHOUT THE WRITTEN PERMISSION OF THE DRAWING ORIGINATOR.</small> |  | DWN 18JAN2012<br>CHG 18JAN2012<br>ADR 18JAN2012     |  |  TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| DIMENSIONS:                                                                                                                                                                                                                      |  | TOLERANCES, UNLESS OTHERWISE SPECIFIED:             |  | NAME Ocean Side Feed Applicator                                                                                                    |  |
| mm                                                                                                                                                                                                                               |  | 0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ± |  | PRODUCT SPEC<br>APPLICATION SPEC                                                                                                   |  |
|                                                                                                                                             |  | FINISH                                              |  | SIZE CAGE CODE DRAWING NO RESTRICTED TO<br>A 00779 C=2151551 -                                                                     |  |
| MATERIAL -                                                                                                                                                                                                                       |  | WEIGHT -                                            |  | SCALE 1:2 SHEET 1 OF 4 REV G                                                                                                       |  |
| Customer Accessible Production Drawing                                                                                                                                                                                           |  |                                                     |  |                                                                                                                                    |  |

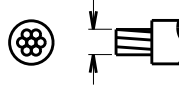
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



| PACIFIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER                               | PART<br>NUMBER | REVISION | DESCRIPTION              | FEED TYPE                         | APPLICATOR STYLE CONVERSION CHART     |                        |           |                            |                |           |                        |
|----------------------------------------------------------------------------------|----------------|----------|--------------------------|-----------------------------------|---------------------------------------|------------------------|-----------|----------------------------|----------------|-----------|------------------------|
|                                                                                  |                |          |                          |                                   | CONVERT TO                            | PART NUMBERS REQUIRED  |           |                            |                |           |                        |
|                                                                                  |                |          |                          |                                   |                                       | -                      | -         | -                          | -              | -         | -                      |
|  | 2-2151551-2    | G        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                         | SERVO LATCH PLATE<br>SMART APPLICATOR | 2119951-1<br>2161326-1 | -<br>-    | 8-2151551-5<br>8-2151551-4 | 1901094-3<br>- | -<br>-    | 2168400-6 (QUANTITY 2) |
|                                                                                  | 2-2151551-5    | G        | FINE CRIMP HEIGHT ADJUST | SERVO<br>LATCH PLATE <sup>4</sup> | -                                     | -                      | -         | -                          | -              | -         | -                      |
|                                                                                  | 2-2151551-7    | G        | FINE CRIMP HEIGHT ADJUST | NONE                              | PNEUMATIC FEED                        | 2119950-1              | 1338685-1 | 5-18022-5                  | 2119641-2      | 2119799-1 | 2063440-1              |
|                                                                                  | 7-2151551-7    | A        | CRIMP TOOLING KIT        | -                                 | -                                     | -                      | -         | -                          | -              | -         | -                      |

| APPLICATOR DATA                                                                                                        |                  |      |
|------------------------------------------------------------------------------------------------------------------------|------------------|------|
| CRIMP                                                                                                                  | SIZE             | TYPE |
| WIRE                                                                                                                   | 3.30 mm [ .130 ] | F    |
| INSUL                                                                                                                  | 4.06 mm [ .160 ] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389  |                  |      |

|                                                                                                                      |             |                                                                                   |                                                               |
|----------------------------------------------------------------------------------------------------------------------|-------------|-----------------------------------------------------------------------------------|---------------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                                           |             | TE CRIMP SPECIFICATION                                                            |                                                               |
| TERMINAL NAME: AMP MCP 6.3/4.8 K LITEALUM CONTACT                                                                    |             |                                                                                   |                                                               |
| WIRE STRIP LENGTH<br>3.40-4.00 mm [ .134 - .157 IN ]                                                                 |             |  | INSULATION DIAMETER RANGE<br>Ø 3.56-3.74mm [ .140 - .147 IN ] |
| TERMINAL APPLICATION SPECIFICATION  | 114-94204   | -                                                                                 | -                                                             |
| TERMINALS APPLIED                   |             |                                                                                   |                                                               |
| TE TERMINAL                                                                                                          | TE TERMINAL | TE TERMINAL                                                                       | TE TERMINAL                                                   |
| 2-2177839-1                                                                                                          | 2-2177839-3 |                                                                                   |                                                               |

|           |                                                                                     |                           |                                                                                     |                                             |
|-----------|-------------------------------------------------------------------------------------|---------------------------|-------------------------------------------------------------------------------------|---------------------------------------------|
| WIRE SIZE |  | CRIMP HEIGHT mm [ INCH ]  |  | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
| 4.00mm2   |                                                                                     | 1.90±0.04 [ .0748±.0016 ] |                                                                                     | 8.5                                         |



<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: 8-2151551-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151551-5

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 99 & 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.

<sup>12</sup> SET THE FINE CRIMP HEIGHT ADJUSTMENT HEAD TO PROPER CRIMP HEIGHT PRIOR TO TIGHTENING/LOCKING THE BRASS TIP SET SCREW, ITEM 99, AGAINST THE ADJUSTMENT BOLT THREADS.

13. APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

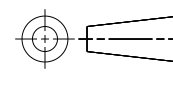
\*WARNING  
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

|     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 2-1722335-1 | THREAD BOLT GEWINDEBOLZEN           | 268     |
| -   | 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   | 2119082-4   | 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     |
| -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<br>2119599-1 | LOC<br>A | DIST<br>66 | REVISIONS |     |             |      |     |
|---------------------------|----------|------------|-----------|-----|-------------|------|-----|
|                           |          |            | P         | LTR | DESCRIPTION | DATE | OWN |
|                           |          |            |           |     |             |      |     |
|                           |          |            | -         |     | SEE SHEET 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   | 2063440-1   | 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     |
| <sup>8</sup> | 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     |
| <sup>7</sup> | 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   | 2-2119656-4 | APPLICATOR BASIC ASSEMBLY, SF       | 141     |
| -            | 1   | 1   | 1   | 2119650-1   | RAM, ASIAN STYLE, SIDE FEED         | 140     |
| <sup>7</sup> | 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     |
| <sup>2</sup> | -   | REF | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
| <sup>2</sup> | 1   | 1   | 1   | 2256587-1   | SCR, SET, SOFT TIP, M4              | 99      |
| -            | 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   | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 65      | 93      |
| -            | 1   | 1   | 1   | 455888-3    | SPACER, CRIMPER                     | 82      |
| -            | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -            | 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      |
| <sup>6</sup> | 3   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62      |
| -            | 1   | 1   | 1   | 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   | 1338685-1   | PAWL, FEED                          | 56      |
| -            | 2   | 2   | 2   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 53      |
| -            | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52      |
| -            | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51      |
| -            | 1   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 50      |
| -            | -   | -   | 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   | 1-1752356-2 | SUPPORT, TERMINAL                   | 34      |
| -            | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33      |
| -            | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32      |
| -            | 1   | 1   | 1   | 1320908-7   | SPACER, STRIP GUIDE                 | 30      |
| -            | 1   | 1   | 1   | 1901086-1   | PLATE, 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   | 1803142-1   | 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   | 690472-2    | STRIPPER                            | 19      |
| <sup>1</sup> | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13      |
| -            | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12      |
| -            | 1   | 1   | 1   | 1-356885-5  | STOP, SHEAR                         | 11      |
| <sup>1</sup> | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
| <sup>1</sup> | 1   | 1   | 1   | 462006-6    | FLOATING SHEAR, FRONT               | 9       |
| <sup>1</sup> | 1   | 1   | 1   | 2161316-2   | ANVIL, COMBINATION                  | 8       |
| -            | 1   | 1   | 1   | 2-240641-9  | SPACER                              | 7       |
| -            | -   | -   | -   | -           | -                                   | 6       |
| -            | 1   | 1   | 1   | 1-1722335-0 | SHEAR DEPRESSOR ASSEMBLY            | 5       |
| -            | 1   | 1   | 1   | 5-238011-2  | BLOCK, CRIMPER SPACER               | 4       |
| <sup>1</sup> | 1   | 1   | 1   | 1722335-8   | CRIMPER, INSULATION F               | 3       |
| -            | -   | -   | -   | -           | -                                   | 2       |
| <sup>1</sup> | 1   | 1   | 1   | 2217302-2   | CRIMPER, WIRE, CONICAL BLEND        | 1       |
| -77          | -27 | -25 | -22 | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                              |  |  |  |                                            |                                                                                                                                    |  |  |  |
|----------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------|--|--|--|
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| DIMENSIONS:<br>mm                                                                                                                            |  |  |  | CHK<br>T. ELBIN<br>18JAN2012               | NAME<br>Ocean Side Feed<br>Applicator                                                                                              |  |  |  |
|                                                         |  |  |  | APVD<br>M. CLIFFORD<br>18JAN2012           |                                                                                                                                    |  |  |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.1<br>1 PLC ±.1<br>2 PLC ±.1<br>3 PLC ±.1<br>4 PLC ±.1<br>ANGLES ±.1<br>FINISH              |  |  |  | PRODUCT SPEC<br>-<br>APPLICATION SPEC<br>- | SIZE<br>A   00779 C=2151551                                                                                                        |  |  |  |
| MATERIAL<br>-                                                                                                                                |  |  |  | WEIGHT<br>-                                | RESTRICTED TO<br>-                                                                                                                 |  |  |  |
|                                                                                                                                              |  |  |  | Customer Accessible Production Drawing     |                                                                                                                                    |  |  |  |
|                                                                                                                                              |  |  |  | SCALE 1:2 SHEET 3 OF 4 REV G               |                                                                                                                                    |  |  |  |

| LOC | DIST | REVISIONS |     |             |      |     |
|-----|------|-----------|-----|-------------|------|-----|
|     |      | P         | LTR | DESCRIPTION | DATE | DWN |
| A   | 66   | -         | -   | SEE SHEET 1 | -    | -   |
|     |      |           |     |             |      |     |
|     |      |           |     |             |      |     |
|     |      |           |     |             |      |     |

D

C

B

A

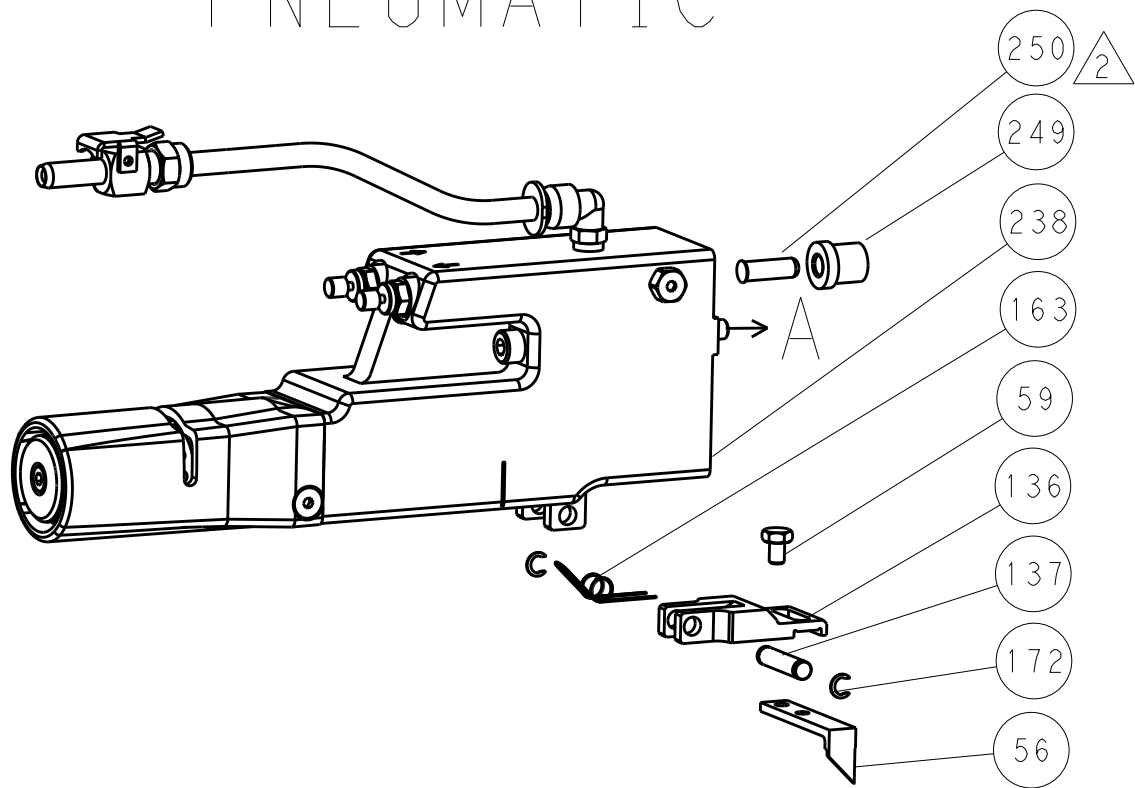
D

C

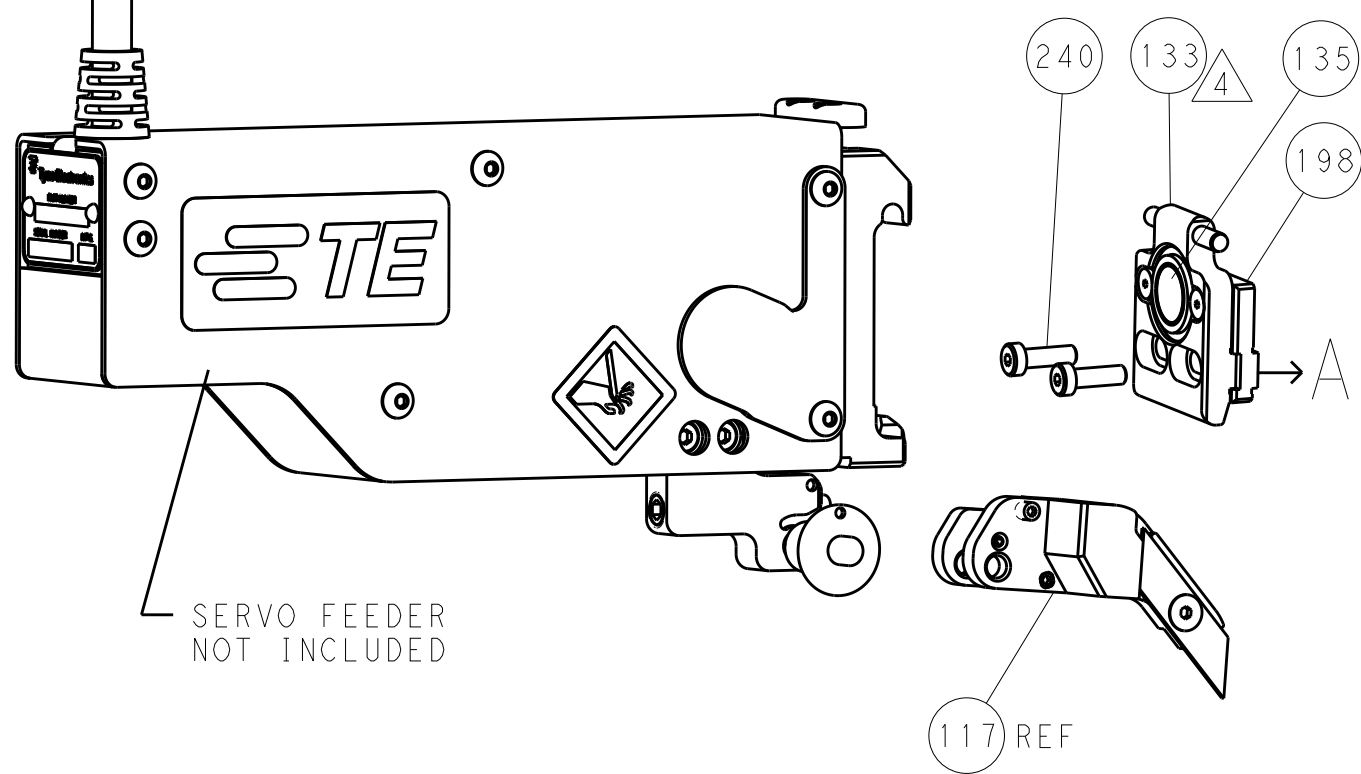
B

A

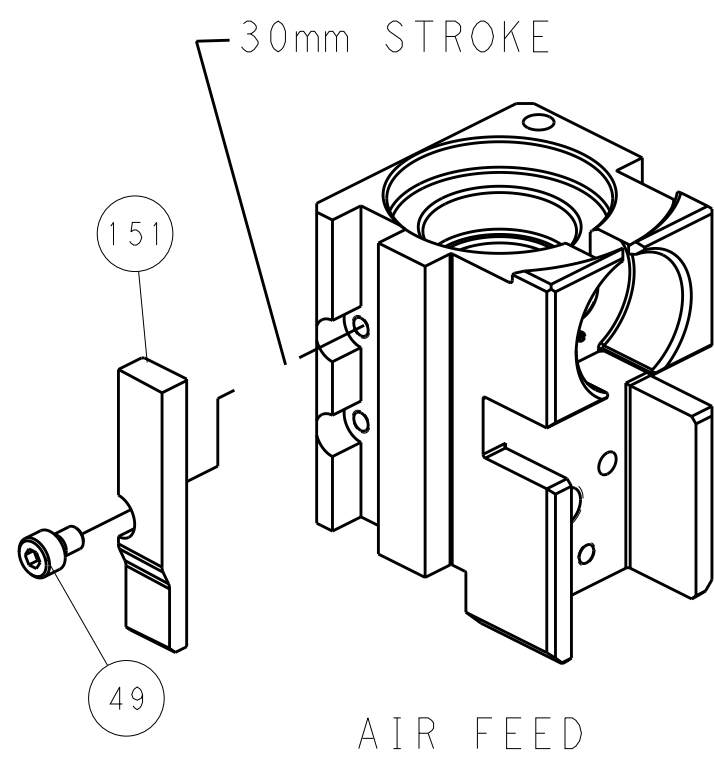
FEED TYPE  
PNEUMATIC



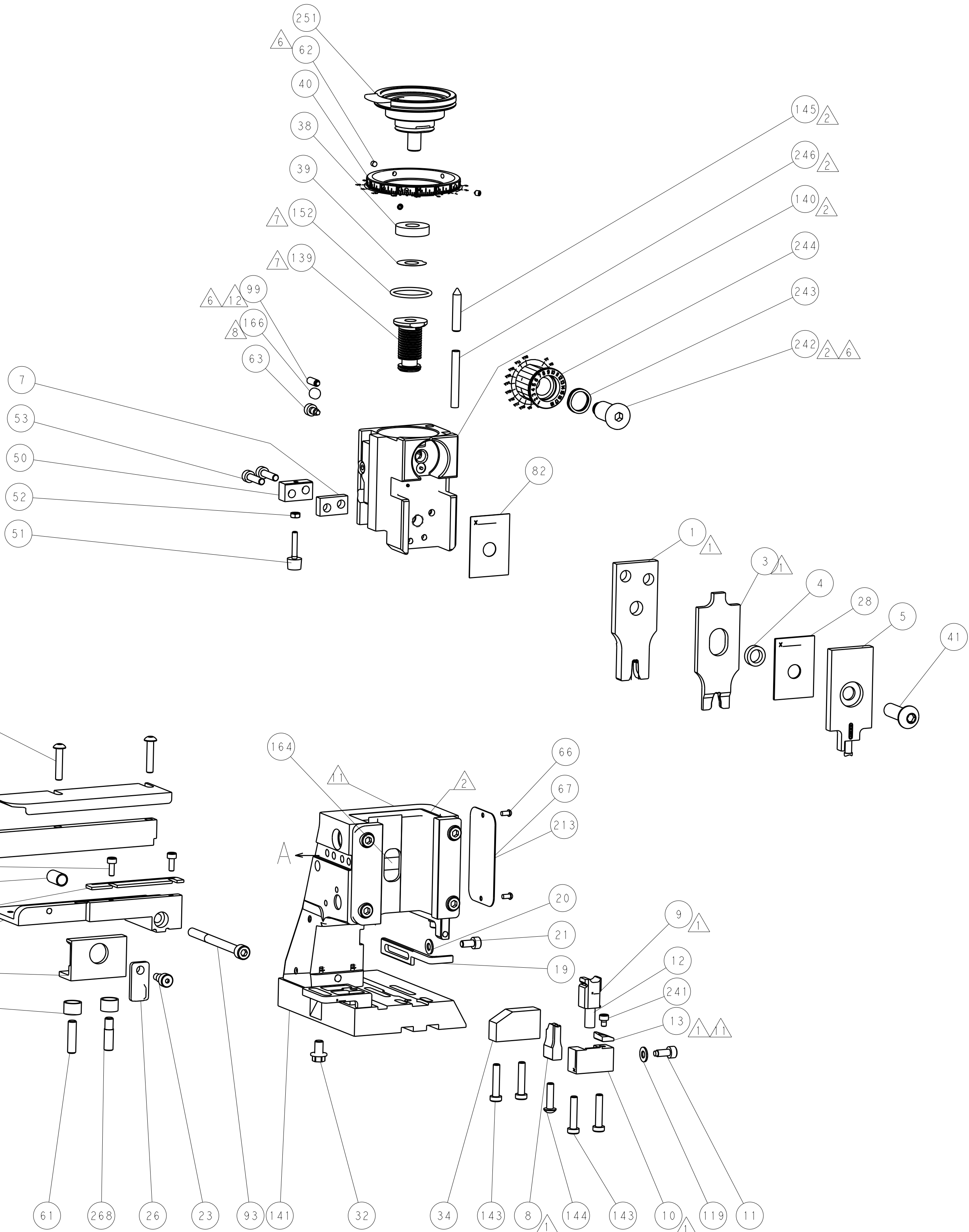
SERVO  
LATCH PLATE



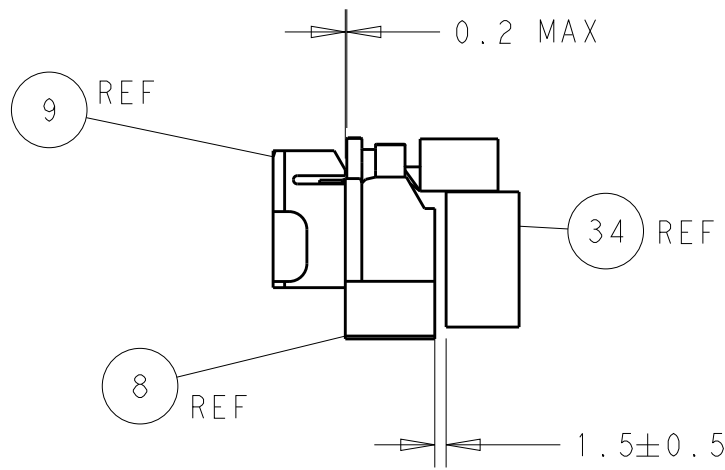
CAM POSITIONS



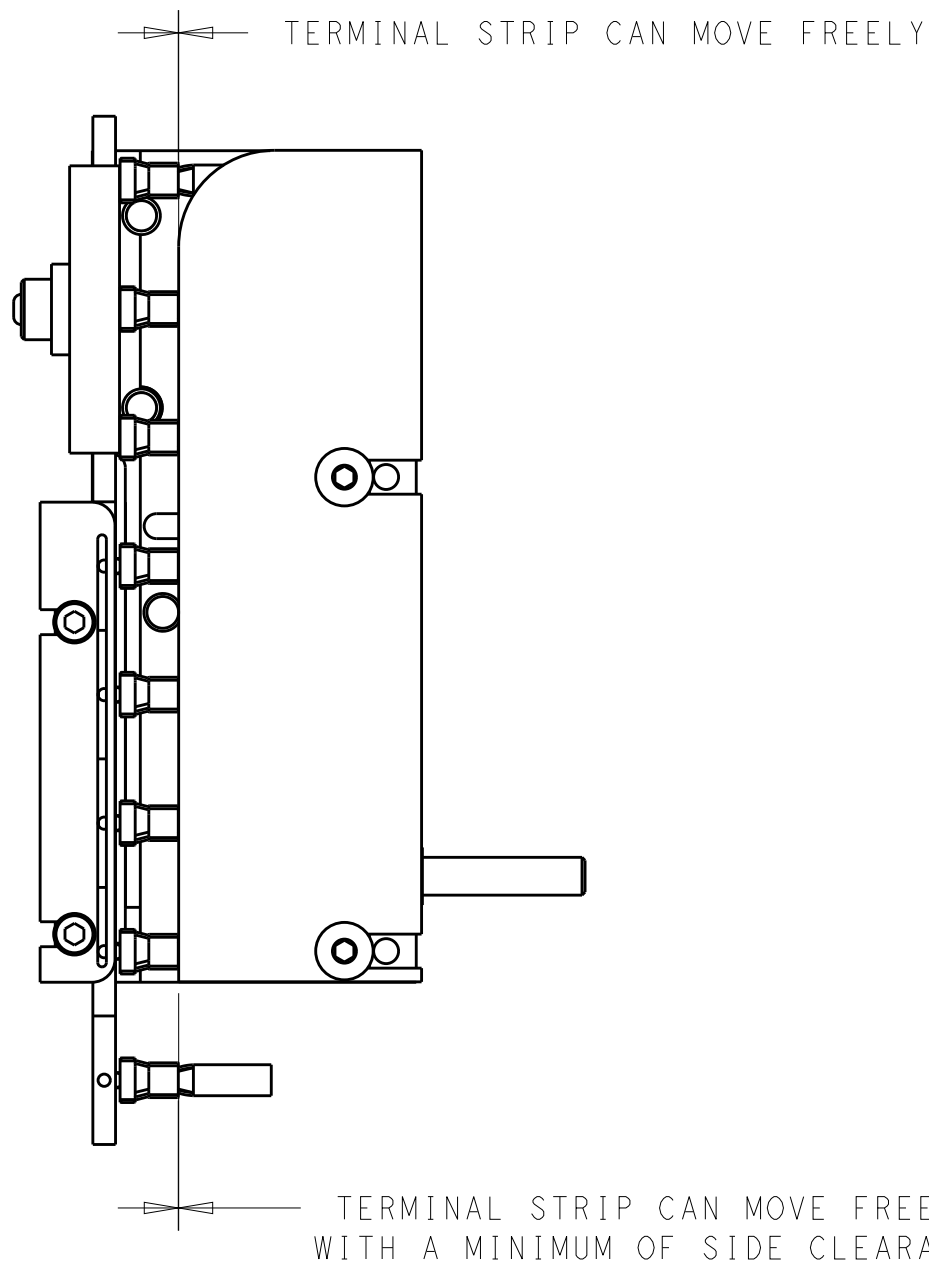
AIR FEED



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

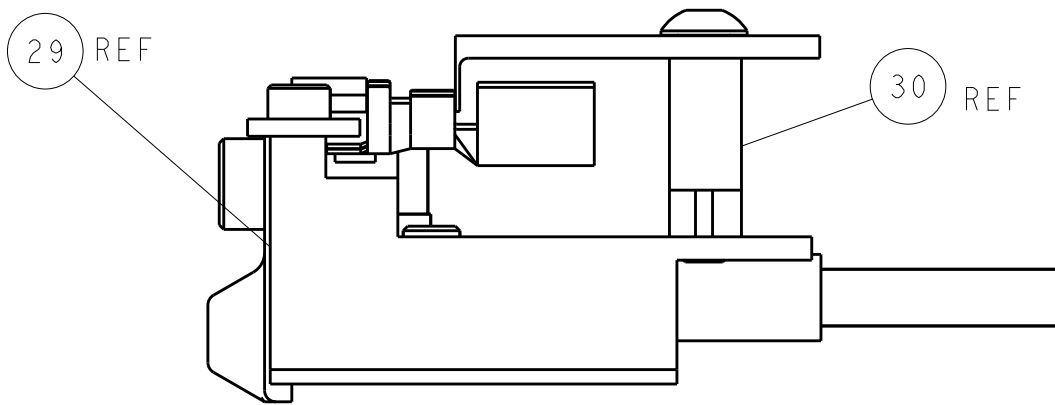


TERMINAL SUPPORT LOCATION



FEED TRACK POSITION

ITEM 30 LOCATED AT  
REAR HOLES



FEED TRACK POSITION  
GUIDE BY WIRE BARREL

|                                                                                                                                                                                      |  |                                        |                                              |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------|----------------------------------------------|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS. SHOULD BE CONTACTED FOR THE LATEST REVISIONS. |  | DWN<br>R. KNEPPER<br>18JAN2012         | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| DIMENSIONS:<br>mm                                                                                                                                                                    |  | CHK<br>T. ELBIN<br>18JAN2012           | NAME<br>Ocean Side Feed<br>Applicator        |  |
| TOLERANCES UNLESS<br>OTHERWISE SPECIFIED:                                                                                                                                            |  | APVD<br>W. CLIFFORD                    | SIZE<br>A                                    |  |
| 0 PLC ±.1                                                                                                                                                                            |  | PRODUCT SPEC                           | CAGE CODE<br>00779                           |  |
| 1 PLC ±.1                                                                                                                                                                            |  | APPLICATION SPEC                       | DRAWING NO<br>2151551                        |  |
| 2 PLC ±.1                                                                                                                                                                            |  | WEIGHT                                 | RESTRICTED TO                                |  |
| 3 PLC ±.1                                                                                                                                                                            |  | Customer Accessible Production Drawing | SCALE<br>1:2                                 |  |
| 4 PLC ±.1                                                                                                                                                                            |  | Customer Accessible Production Drawing | SHEET<br>4                                   |  |
| ANGLES                                                                                                                                                                               |  | Customer Accessible Production Drawing | REV<br>G                                     |  |
| FINISH                                                                                                                                                                               |  | Customer Accessible Production Drawing | REV<br>G                                     |  |

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION