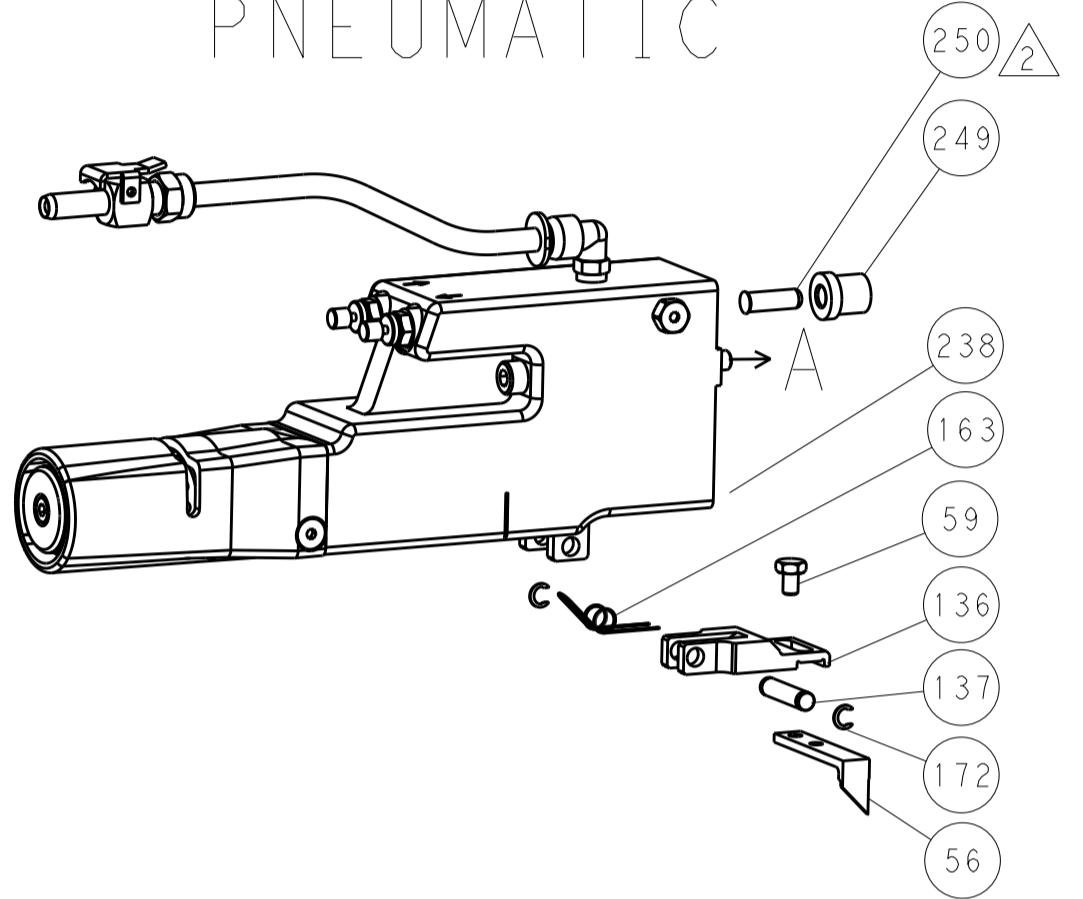


| LOC | | DIST | | REVISIONS | | | |
|-----|----|------|-----|-------------|------|-----|------|
| A | 66 | P | LTM | DESCRIPTION | DATE | DWN | APVD |
| | | - | - | SEE SHEET 1 | - | - | - |

FEED TYPE MECHANICAL



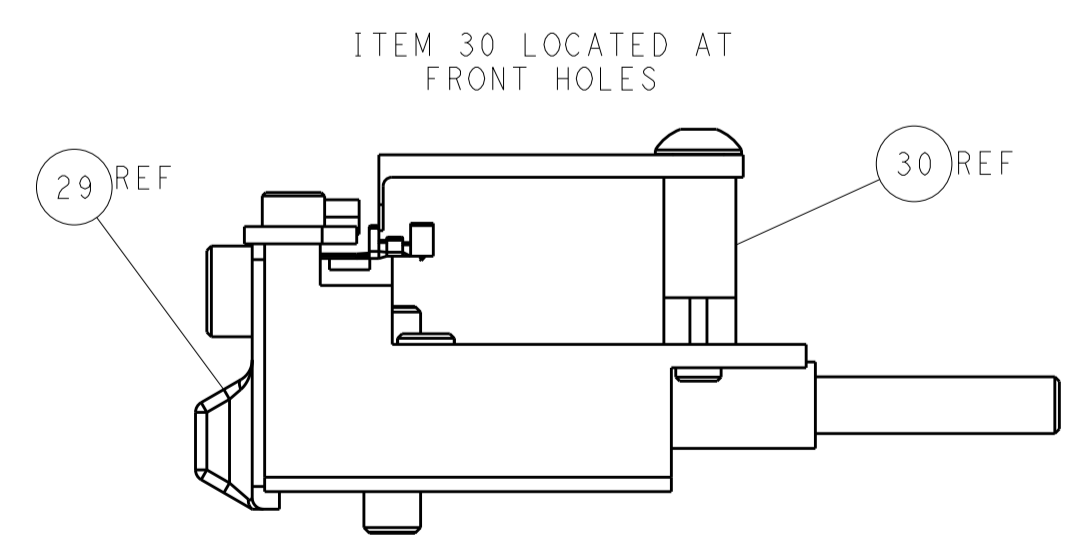
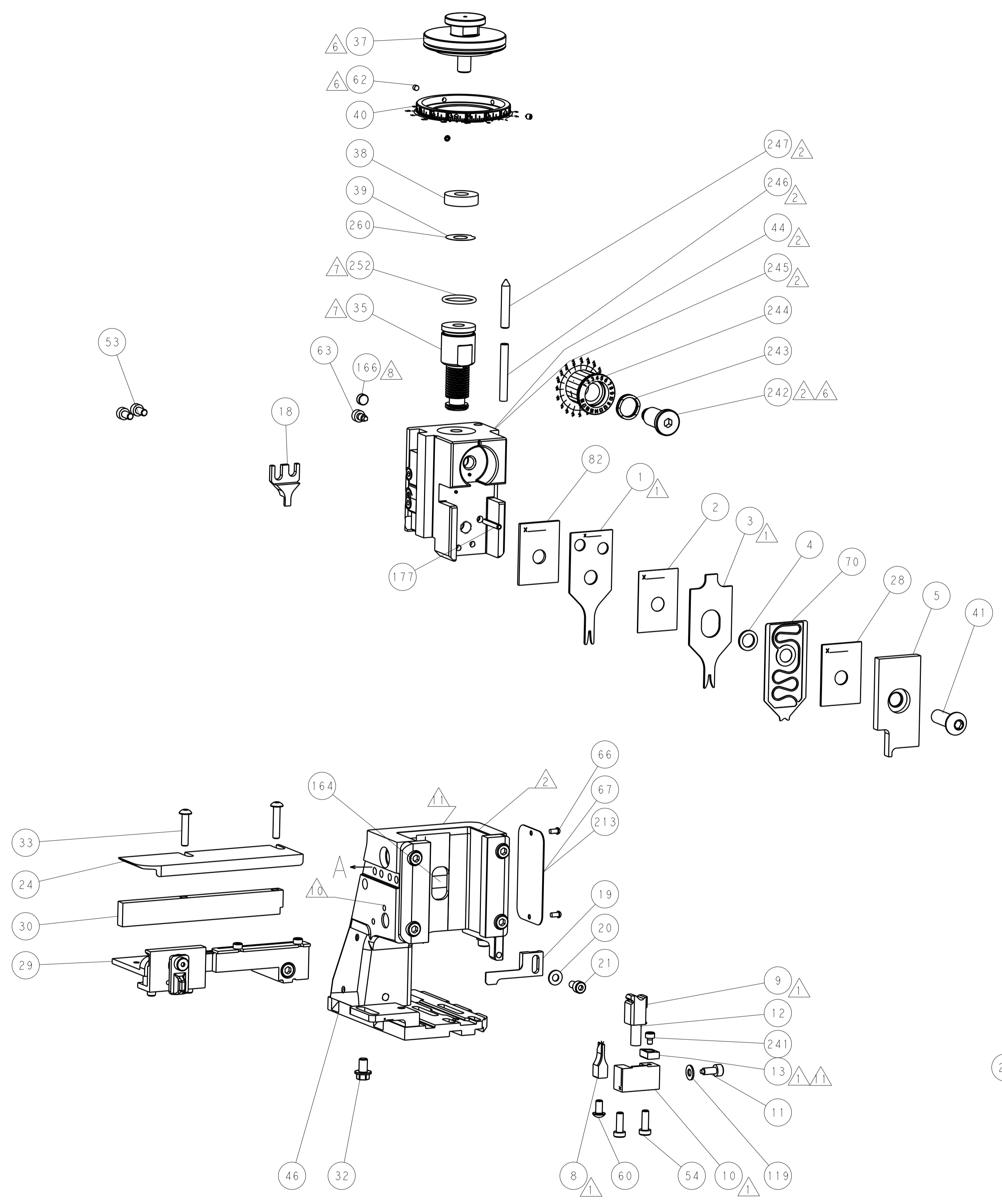
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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: C. CHEN 25MAY2011 | | TE Connectivity | |
| mm | 0 PLC ±0.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.001 | APVD: S. XI 25MAY2011 | Harrisburg, PA 17105-3608 |
| MATERIAL: | | FINISH: | | NAME: Ocean Side Feed Applicator | | RESTRICTED TO: | |
| | | | | SIZE: A1 | | CAGE CODE: 00779 | |
| | | | | DRAWING NO: C=2151102 | | SCALE: 1:2 | |
| | | | | SHEET: 2 of 4 | | REV: C | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2151102-1 | C | 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 | - | 8-2151102-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151102-4 | - | - | - |
| | 2-2151102-2 | C | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151102-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151102-4 | - | - | - |
| | 2-2151102-5 | C | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 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 |
| | 2-2151102-7 | C | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2151102-7 | C | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.16 mm [.046] | F |
| INSUL | 1.50 mm [.059] | F |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|-------------------------|---|-------------------------|
| TERMINAL NAME: AMP CT CONN 2mm PITCH TYPE II REC.CONTACT | | | |
| WIRE STRIP LENGTH 1.90-2.30 [.075-.090 IN] | | INSULATION DIAMETER RANGE Ø0.93-1.50 mm [.037-.059 IN] | |
| TERMINAL APPLICATION SPECIFICATION 114-5179 | - | - | - |
| TERMINALS APPLIED | | | |
| TE TERMINAL 179227-1 | TE TERMINAL 179227-2 | TE TERMINAL 179227-3 | TE TERMINAL 179227-4 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-------------------------------|-------------------------------|--------------------------------|
| 22 AWG OR 0.37mm ² | 0.83 +/- 0.05 [.033 +/- .002] | 8.4 |
| 0.30mm ² | 0.83 +/- 0.05 [.033 +/- .002] | 8.4 |
| 24 AWG OR 0.22mm ² | 0.77 +/- 0.05 [.030 +/- .002] | 9.0 |
| 26 AWG OR 0.12mm ² | 0.71 +/- 0.05 [.028 +/- .002] | 9.6 |

- 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: 8-2151102-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151102-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151102-5
- 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 62.
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.

***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.

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 | LTM | DESCRIPTION | DATE | OWN | APVD |
| - | - | - | - | - | SEE SHEET 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 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | 1 | 1 | 1 | 1 | 2119082-9 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 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 | 993111-1 | PIN, SLOTTED SPRING 3.0 X 20.0 | 177 |
| - | - | - | 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 |
| - | 2 | 2 | 2 | 2 | 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 | 1-455888-6 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 1 | 1 | 2119791-5 | DEPRESSOR, WIRE | 70 |
| - | 1 | - | 1 | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | 1 | 1 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| - | 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 | 1338685-1 | PAWL, FEED | 56 |
| - | 2 | 2 | 2 | 2 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 53 |
| - | - | - | 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 | 2119644-1 | RAM WASHER, PRECISION | 38 |
| - | 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 | 2119533-3 | STRIPPER, SIDE FEED | 19 |
| - | 1 | 1 | 1 | 1 | 4-690518-6 | HOLD DOWN, TERMINAL | 18 |
| - | 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 | 1803095-1 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1 | 1 | 8-1333225-2 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 2-238011-0 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 2-2119582-3 | CRIMPER, INSULATION F PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 9-1633664-2 | CRIMPER, WIRE | 1 |

| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OTHERWISE SPECIFIED: | |
|-------------|---------------|--|-------------|----------------------|--------------|
| mm | 0 PLC ±.5 | 1 PLC ±0.5 | 2 PLC ±0.13 | 3 PLC ±0.013 | 4 PLC ±0.001 |
| | ANGLES ±.0001 | | | | |
| MATERIAL: | FINISH: | WEIGHT: | SCALE: | SHEET: | REV: |
| | | | 1:2 | 3 OF 4 | C |

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

FEED TYPE MECHANICAL



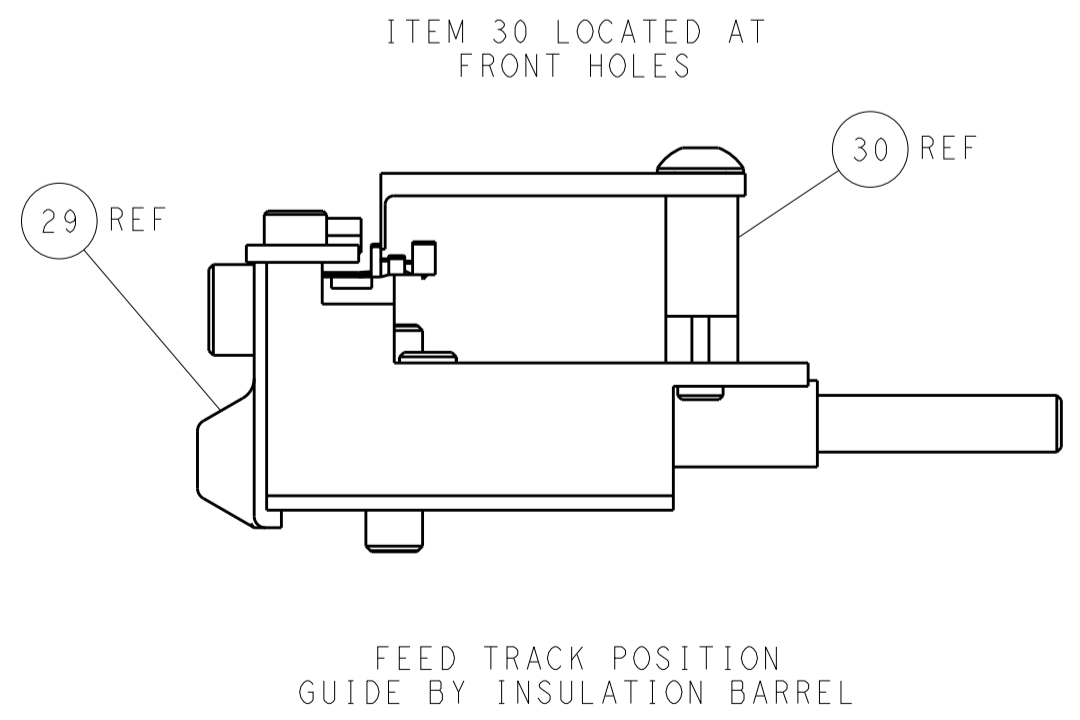
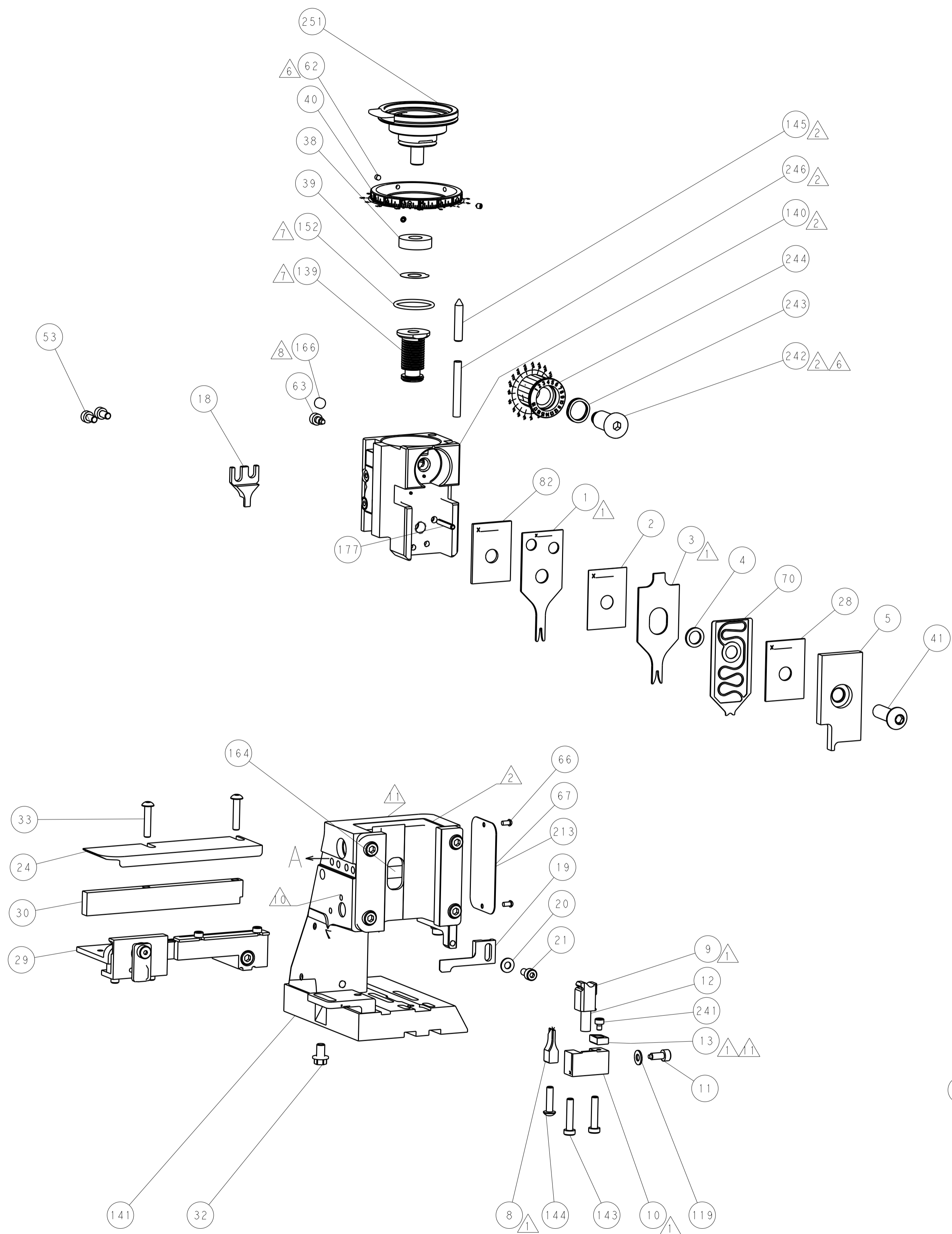
PNEUMATIC



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>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS TO BE USED ONLY FOR THE PURPOSES AND IN THE MANNER SPECIFIED BY THE DRAWING. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION WHEN NO LONGER REQUIRED.</small> | | DWN: C. CHEN 25MAY2011 CHK: S. XI 25MAY2011 APVD: J. CRUZ 25MAY2011 | NAME: STE Connectivity Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.1 | PRODUCT SPEC: APPLICATION SPEC: WEIGHT: MATERIAL: | SIZE: CAGE CODE: DRAWING NO: A11 00779 ©=2151102 SCALE: 1:2 SHEET 4 OF 4 REV C | RESTRICTED TO: |