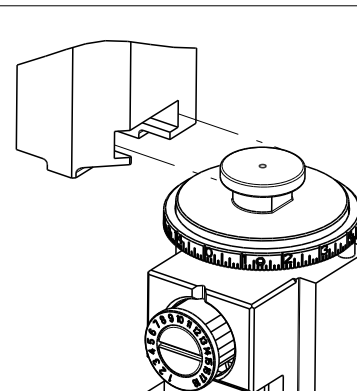


|                                                                                                                                                              |                |                                                       |                          |                                                                                                                                                                                       |                                   |                       |           |             |           |             |                        |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|-------------------------------------------------------|--------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
| 8                                                                                                                                                            |                | 7                                                     |                          | 6                                                                                                                                                                                     |                                   | 5                     |           | 4           |           | 3           |                        |
| THIS DRAWING IS UNPUBLISHED.                                                                                                                                 |                | RELEASED FOR PUBLICATION                              |                          | 20                                                                                                                                                                                    |                                   |                       |           |             |           |             |                        |
| © COPYRIGHT 20                                                                                                                                               |                | BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED. |                          |                                                                                                                                                                                       |                                   |                       |           |             |           |             |                        |
| <div>ATLANTIC VERSION<br/>TERMINATOR<br/>INTERFACE ADAPTER</div> <div></div> | PART<br>NUMBER | REVISION                                              | DESCRIPTION              | FEED TYPE                                                                                                                                                                             | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |             |                        |
|                                                                                                                                                              |                |                                                       |                          |                                                                                                                                                                                       | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |             |                        |
|                                                                                                                                                              |                |                                                       |                          |                                                                                                                                                                                       | -                                 | -                     | -         | -           | -         | -           | -                      |
|                                                                                                                                                              | 2151443-2      | D                                                     | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                                                                                                                                                                             | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151443-5 | 1901094-3 | 1-1752354-3 | 2168400-6 (QUANTITY 2) |
|                                                                                                                                                              |                |                                                       |                          |                                                                                                                                                                                       | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151443-4 | -         | -           | -                      |
|                                                                                                                                                              | 2151443-5      | D                                                     | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE                                                                                    | -                                 | -                     | -         | -           | -         | -           | -                      |
|                                                                                                                                                              |                |                                                       |                          |                                                                                                                                                                                       | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-1 | 2119799-1   | 2063440-1              |
|                                                                                                                                                              | 2151443-6      | D                                                     | NON-CRIMP HEIGHT ADJUST  |  SERVO LATCH PLATE  | -                                 | -                     | -         | -           | -         | -           | -                      |
|                                                                                                                                                              |                |                                                       |                          |                                                                                                                                                                                       | -                                 | -                     | -         | -           | -         | -           | -                      |
|                                                                                                                                                              | 2151443-7      | D                                                     | FINE CRIMP HEIGHT ADJUST | NONE                                                                                                                                                                                  | -                                 | -                     | -         | -           | -         | -           | -                      |
| 7-2151443-7                                                                                                                                                  | D              | CRIMP TOOLING KIT                                     | -                        | -                                                                                                                                                                                     | -                                 | -                     | -         | -           | -         | -           |                        |

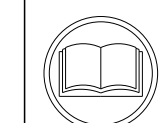
| APPLICATOR DATA                      |                |                                                                                   |
|--------------------------------------|----------------|-----------------------------------------------------------------------------------|
| CRIMP                                | SIZE           | TYPE                                                                              |
| WIRE                                 | 0.80 mm [.031] | F                                                                                 |
| INSUL                                | 0.85 mm [.033] | F                                                                                 |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |  |

|                                                       |                |                                                            |                |
|-------------------------------------------------------|----------------|------------------------------------------------------------|----------------|
| TERMINAL DATA: MOLEX TERMINAL                         |                | MOLEX CRIMP SPECIFICATION                                  |                |
| TERMINAL NAME: 1.25 WIRE TO BOARD CONN, CRIMP RECEPT. |                |                                                            |                |
| WIRE STRIP LENGTH<br>1.40-1.90 mm [.055-.075 IN]      |                | INSULATION DIAMETER RANGE<br>Ø .051-0.99 mm [.020-.039 IN] |                |
| TERMINAL APPLICATION<br>SPECIFICATION                 |                | SPEC 63900-3700 Rev D                                      |                |
| TERMINALS APPLIED                                     |                |                                                            |                |
| TE TERMINAL                                           | MOLEX TERMINAL | TE TERMINAL                                                | MOLEX TERMINAL |
| 993820-1                                              | 50079-8000     |                                                            |                |

|                                                       |                |                                                           |                |
|-------------------------------------------------------|----------------|-----------------------------------------------------------|----------------|
| TERMINAL DATA: MOLEX TERMINAL                         |                | MOLEX CRIMP SPECIFICATION                                 |                |
| TERMINAL NAME: 1.25 WIRE TO BOARD CONN, CRIMP RECEPT. |                |                                                           |                |
| WIRE STRIP LENGTH<br>1.40-1.90 mm [.055-.075 IN]      |                | INSULATION DIAMETER RANGE<br>Ø .01-0.99 mm [.020-.039 IN] |                |
| TERMINAL APPLICATION SPECIFICATION                    |                | SPEC 63900-3700 Rev D                                     |                |
| TERMINALS APPLIED                                     |                |                                                           |                |
| TE TERMINAL                                           | MOLEX TERMINAL | TE TERMINAL                                               | MOLEX TERMINAL |
| 993820-2                                              | 50058-8000     |                                                           |                |

| WIRE<br>SIZE      |  | CRIMP HEIGHT<br>mm [INCH]     |  | CRIMP HEIGHT<br>REFERENCE SETTING |
|-------------------|-------------------------------------------------------------------------------------|-------------------------------|-------------------------------------------------------------------------------------|-----------------------------------|
| 26 AWG OR 0.12mm2 |                                                                                     | 0.635+/-0.025 [0.024+/-0.001] |                                                                                     | 5.8                               |
| 28 AWG OR 0.08mm2 |                                                                                     | 0.585+/-0.025 [0.023+/-0.001] |                                                                                     | 6.4                               |

| WIRE SIZE         |  | CRIMP HEIGHT<br>mm [INCH]        |  | CRIMP HEIGHT<br>REFERENCE SETTING |
|-------------------|-------------------------------------------------------------------------------------|----------------------------------|-------------------------------------------------------------------------------------|-----------------------------------|
| 28 AWG OR 0.08mm2 |                                                                                     | 0.535 +/- 0.025 [0.021 +/- .001] |                                                                                     | 6.7                               |
| 30 AWG OR 0.05mm2 |                                                                                     | 0.505 +/- 0.025 [0.020 +/- .001] |                                                                                     | 7.0                               |
| 32 AWG OR 0.03mm2 |                                                                                     | 0.485 +/- 0.025 [0.019 +/- .001] |                                                                                     | 7.3                               |

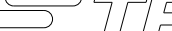


1. RECOMMENDED SPARE PARTS
2. GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
4. APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151443-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151443-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151443-6
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
6. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.  
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.
7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
8. MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
9. 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.
10. TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
11. THIS APPLICATOR DOES NOT CUT CARRIER STRIP.
12. 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
13. ADJUSTMENTS MAY BE REQUIRED WHEN CHANGING TERMINALS.

|     |    |    |    |    |           |                               |         |
|-----|----|----|----|----|-----------|-------------------------------|---------|
| -   | 2  | 2  | 2  | 2  | 22281-8   | SPRING, COMPRESSION           | 279     |
| -   | 2  | 2  | 2  | 2  | 2-18032-5 | SCR, SET, FLT POINT M5 X 20.0 | 278     |
| -77 | -7 | -6 | -5 | -2 | PART NO   | DESCRIPTION                   | ITEM NO |

|                           |               |             |           |
|---------------------------|---------------|-------------|-----------|
| 2                         |               | 1           |           |
| SET UP GAUGE<br>2119599-1 | LOC<br>A      | DIST<br>66  | REVISIONS |
| P                         | LTR           | DESCRIPTION | DATE      |
| D1                        | ECR-16-017620 | 13DEC2016   | MR TE     |
| D2                        | ECR-17-005333 | 12APR2017   | TB CT     |
|                           |               |             |           |
|                           |               |             |           |

|   |     |     |     |     |     |             |                                     |         |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
|   | -   | 1   | 1   | 1   | 1   | 1-22281-8   | SPRING, COMPRESSION                 | 277     |
|   | -   | 1   | 1   | 1   | 1   | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 6.5     | 276     |
|   | -   | 1   | 1   | 1   | 1   | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 275     |
|   | -   | 1   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 274     |
|   | -   | 1   | 1   | 1   | 1   | 240792-1    | DRAG, TERMINAL                      | 273     |
|   | -   | 2   | 2   | 2   | 2   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 271     |
|   | -   | 1   | 1   | 1   | 1   | 1-690438-0  | FRONT STRIP GUIDE                   | 270     |
| 7 | -   | -   | 1   | -   | -   | 2119957-2   | APPLICATOR SHIM PACK                | 260     |
|   | -   | 1   | -   | 1   | 1   | 8-21084-0   | O-RING, .676 ID, .070 DIA. MAT.     | 252     |
|   | -   | -   | -   | -   | 1   | 2119640-1   | PUSH ROD, AIR FEED                  | 250     |
|   | -   | -   | -   | -   | 1   | 2079988-1   | BUSHING, LCH5-12, MISUMI            | 249     |
|   | -   | -   | -   | -   | 1   | 2119641-1   | FEED CAM, AIR FEED                  | 248     |
|   | -   | 1   | -   | 1   | 1   | 2119798-1   | DETENT PIN                          | 247     |
|   | -   | 1   | -   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246     |
|   | -   | -   | 1   | -   | -   | 2119758-1   | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245     |
|   | -   | 1   | 1   | 1   | 1   | 2119082-1   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
|   | -   | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| 6 | -   | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242     |
|   | -   | -   | 2   | 2   | -   | 2168400-6   | SHCS, LOW HEAD, RoHS, M5 X 16       | 240     |
|   | -   | -   | -   | -   | 1   | 2063440-1   | AIR FEED MODULE                     | 238     |
|   | -   | -   | 1   | 1   | -   | 2119740-2   | TAG, IDENTIFICATION                 | 213     |
|   | -   | -   | 1   | 1   | -   | 1901094-3   | SPACER, FEEDER                      | 198     |
| 8 | -   | -   | -   | -   | 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   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137     |
|   | -   | -   | -   | -   | 1   | 2119799-1   | HOLDER, FEED FINGER, AF             | 136     |
|   | -   | -   | REF | REF | -   | SEE NOTE 4  | MEMORY CHIP, PROGRAMMED             | 135     |
|   | -   | -   | 1   | 1   | -   | 1633743-1   | SERVO FEED LATCH ASM                | 133     |
|   | -   | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 119     |
|   | -   | -   | REF | REF | -   | 2119944-1   | FEED FINGER ASSEMBLY, SF            | 117     |
|   | -   | 1   | 1   | 1   | 1   | 1-455888-8  | SPACER, CRIMPER                     | 82      |
|   | -   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
|   | -   | 1   | 1   | 1   | 1   | 1-2119791-8 | DEPRESSOR, WIRE                     | 70      |
|   | -   | 1   | -   | -   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
|   | -   | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66      |
| 6 | -   | 1   | -   | 1   | 1   | 2119793-1   | LIMITER, ADJUSTMENT BOLT            | 63      |
|   | -   | 3   | -   | 3   | 3   | 992763-5    | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62      |
|   | -   | 1   | 1   | 1   | 1   | 2079383-4   | SCR, BHSC, RoHS (M4 X 8)            | 60      |
|   | -   | -   | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
|   | -   | -   | -   | -   | 1   | 1338685-1   | PAWL, FEED                          | 56      |
|   | -   | 2   | 2   | 2   | 2   | 2168400-1   | SHCS, LOW HEAD, RoHS, M4 X 12       | 54      |
|   | -   | -   | -   | -   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
|   | -   | 1   | 1   | 1   | 1   | 2119656-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46      |
|   | -   | 1   | -   | 1   | 1   | 2119370-1   | RAM, AMP STYLE, SIDE FEED           | 44      |
|   | -   | 1   | 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   | 1   | 2119644-1   | RAM WASHER, PRECISION               | 38      |
| 6 | -   | 1   | 1   | 1   | 1   | 2119085-1   | FA HEAD, ATLANTIC STYLE             | 37      |
| 7 | -   | 1   | -   | 1   | 1   | 2119092-1   | BOLT, ADJUSTMENT                    | 35      |
|   | -   | 1   | 1   | 1   | 1   | 2-1752356-6 | 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   | 1320908-2   | SPACER, STRIP GUIDE                 | 30      |
|   | -   | 1   | 1   | 1   | 1   | 2-1901086-0 | PLATE, STRIP GUIDE                  | 29      |
|   | -   | 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   | 3-2280-3    | SPRING, COMPRESSION                 | 12      |
|   | -   | 1   | 1   | 1   | 1   | 1-356885-5  | STOP, SHEAR                         | 11      |
| 1 | -   | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
| 1 | -   | 1   | 1   | 1   | 1   | 1803095-6   | FLOATING SHEAR, FRONT               | 9       |
| 1 | 1   | 1   | 1   | 1   | 1   | 4-1633621-5 | ANVIL, COMBINATION                  | 8       |
|   | -   | -   | -   | -   | -   | -           | -                                   | 7       |
|   | -   | -   | -   | -   | -   | -           | -                                   | 6       |
|   | -   | 1   | 1   | 1   | 1   | 2119757-1   | DEPRESSOR, SHEAR                    | 5       |
|   | -   | 1   | 1   | 1   | 1   | 2-238011-5  | BLOCK, CRIMPER SPACER               | 4       |
| 1 | 1   | 1   | 1   | 1   | 1   | 1803167-5   | CRIMPER, INSULATION F SPECIAL       | 3       |
|   | -   | 1   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     | 2       |
| 1 | 1   | 1   | 1   | 1   | 1   | 1633713-8   | CRIMPER, WIRE PREMIUM               | 1       |
|   | -77 | -7  | -6  | -5  | -2  | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                                                                                                |  |                                                                                                                                     |  |                                                                                                                                    |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------|--|
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| DIMENSIONS:<br>mm                                                                                                                                                                                              |  | TO DIMENSIONS UNLESS OTHERWISE SPECIFIED:                                                                                           |  | NAME<br>Ocean Side Feed<br>Applicator<br>-                                                                                         |  |
|                                                                                                                           |  | PRODUCT SPEC<br>-<br>APPLICATION SPEC<br>-                                                                                          |  | SIZE<br>A1                                                                                                                         |  |
| MATERIAL<br>-                                                                                                                                                                                                  |  | WEIGHT<br>-                                                                                                                         |  | CAGE CODE<br>00779                                                                                                                 |  |
| FINISH<br>-                                                                                                                                                                                                    |  | DRAWING NO<br>C=2151443                                                                                                             |  | RESTRICTED TO<br>-                                                                                                                 |  |
| Customer Accessible Production Drawing                                                                                                                                                                         |  |                                                                                                                                     |  | SCALE 1:2 SHEET 1 OF 4 REV D2                                                                                                      |  |

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

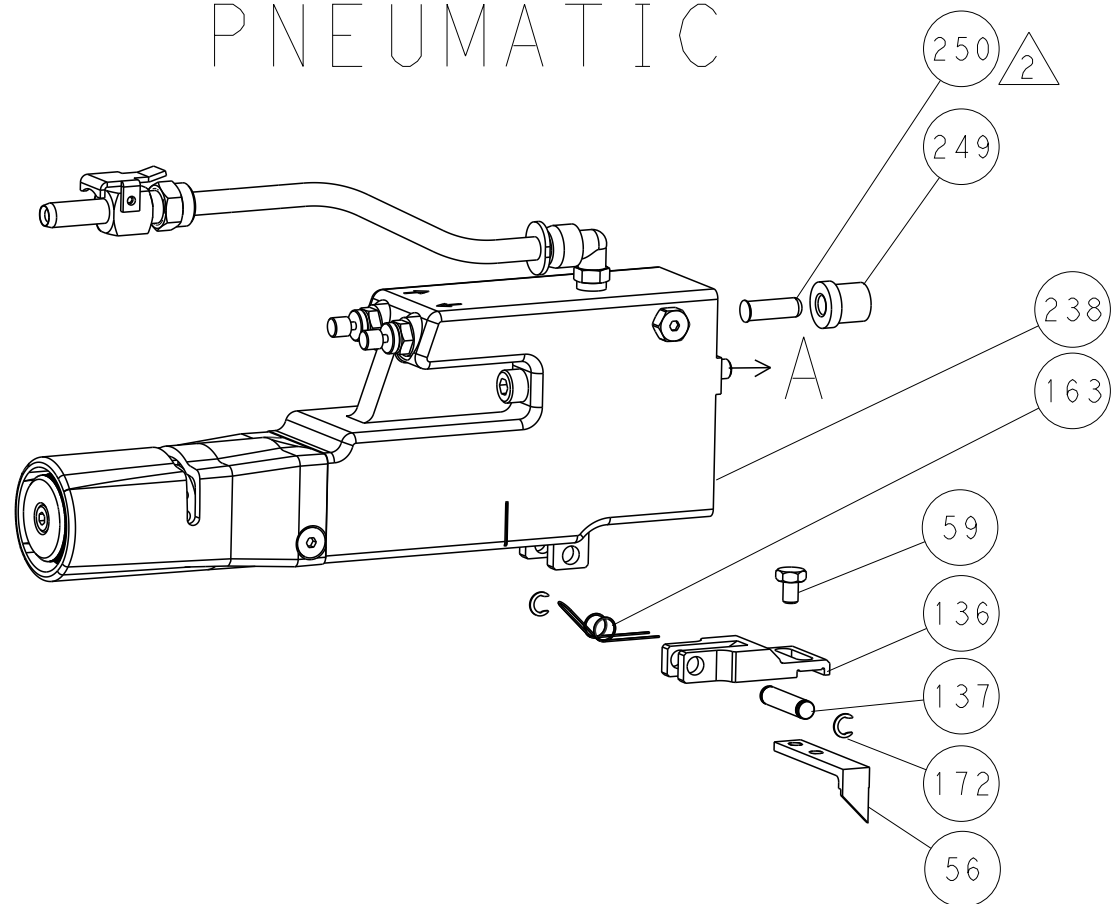
ATLANTIC VERSION  
Shown on sheets 1 of 4 & 2 of 4  
(Pacific version shown on sheets 3 of 4 & 4 of 4)



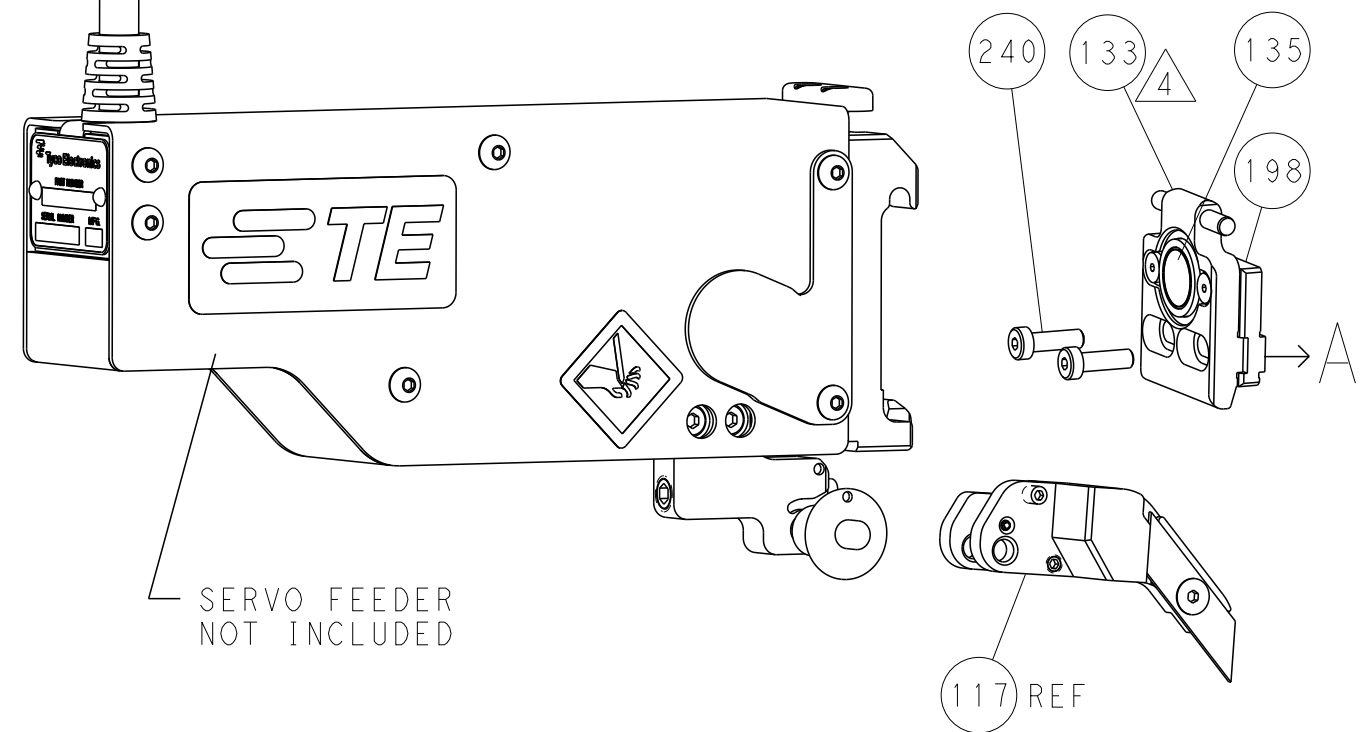
| LOC |     | DIST        | REVISONS |  |      |     |      |
|-----|-----|-------------|----------|--|------|-----|------|
| P   | LYR | DESCRIPTION |          |  | DATE | DWN | APVD |
| -   | -   | SEE SHEET 1 |          |  | -    | -   | -    |
|     |     |             |          |  |      |     |      |
|     |     |             |          |  |      |     |      |

FEED TYPE

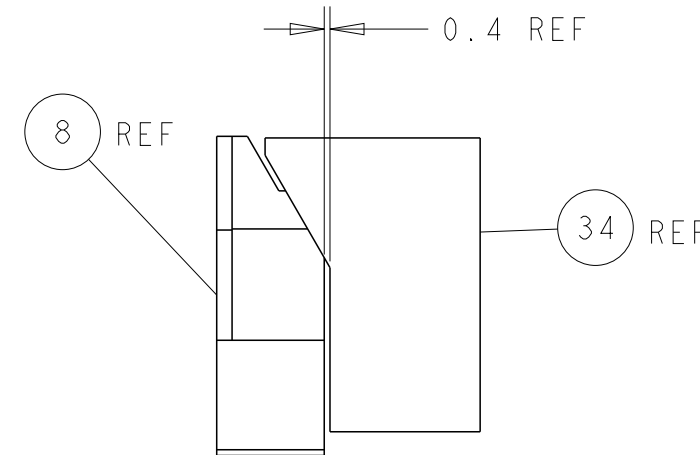
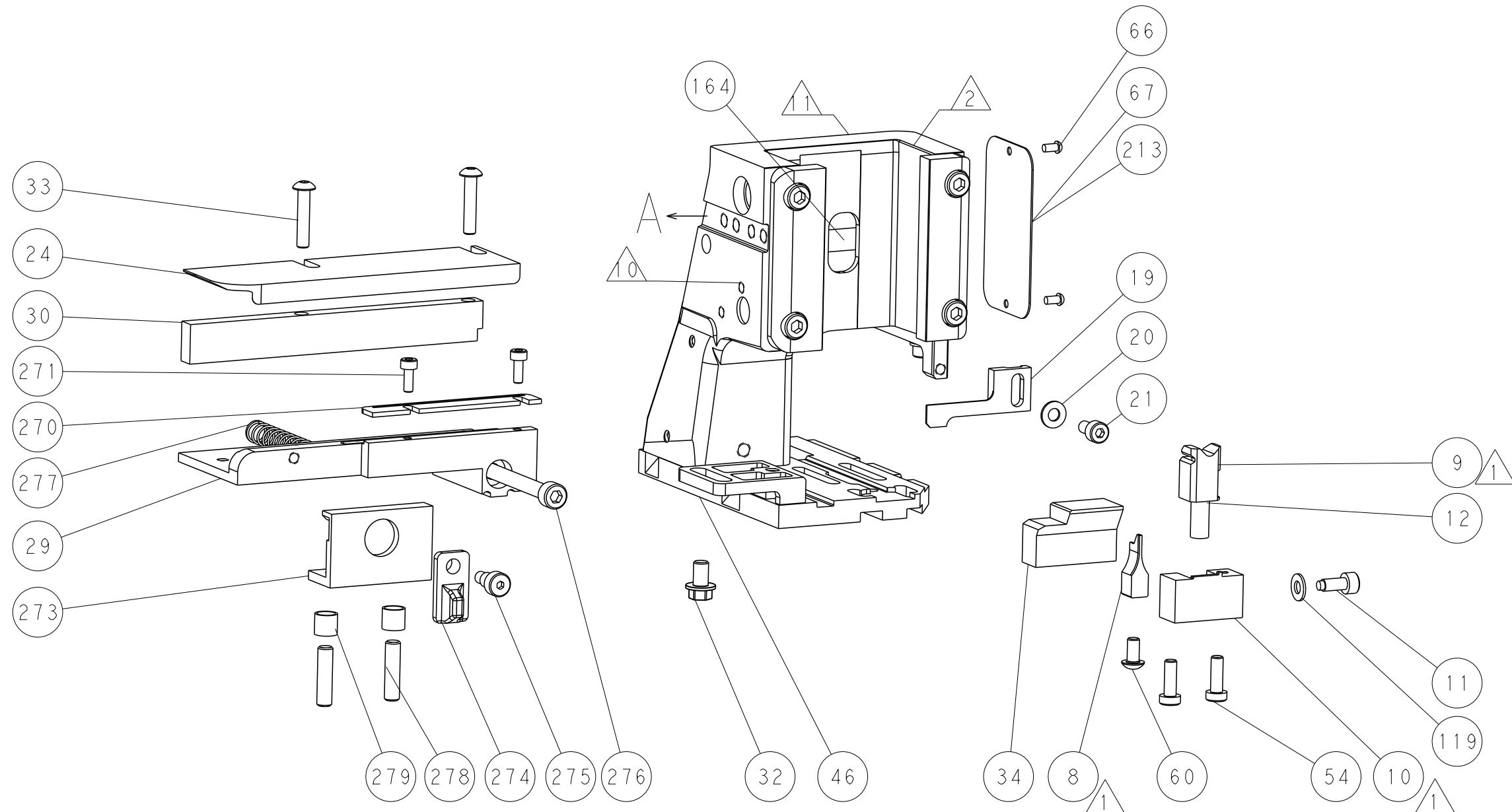
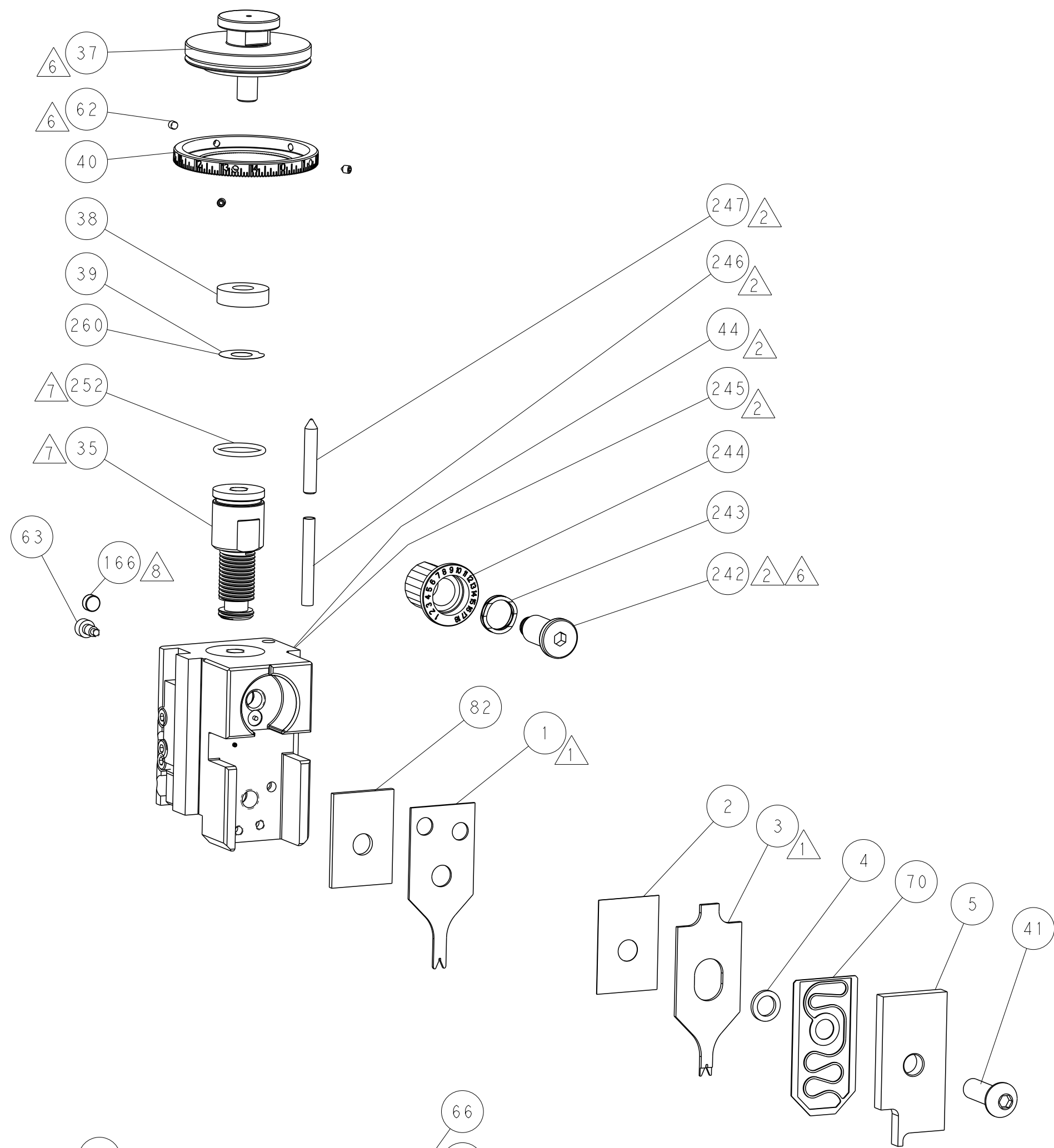
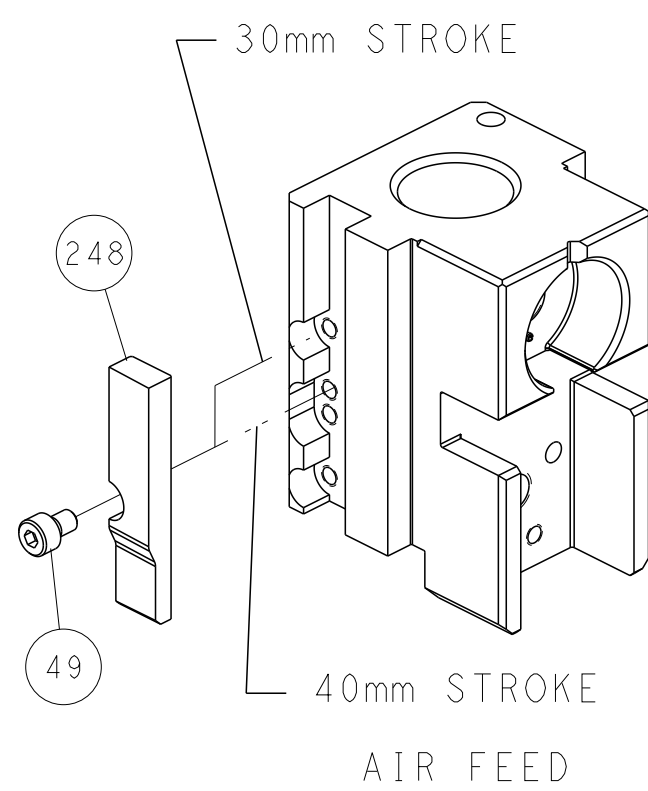
PNEUMATIC



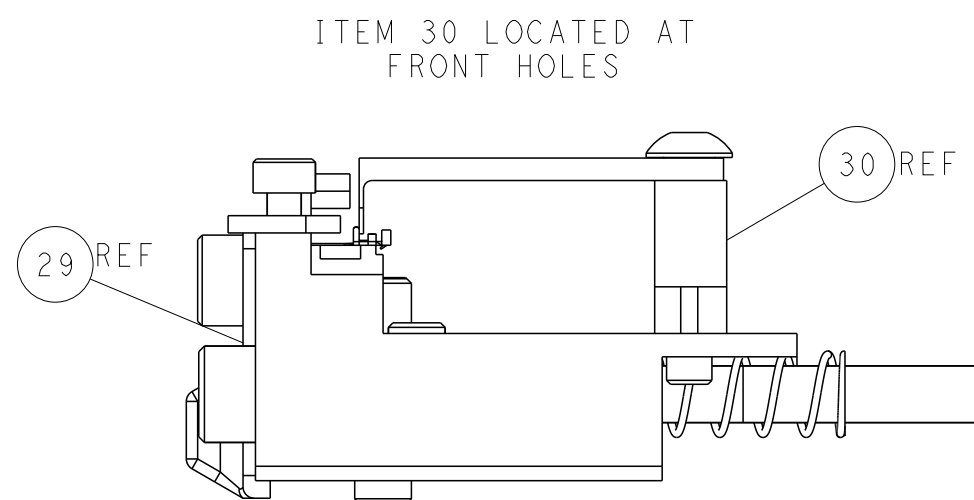
SERVO LATCH PLATE



CAM POSITION



TERMINAL SUPPORT LOCATION



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)

|                                                                                                                                                                                          |  |                                           |           |                                              |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------|-----------|----------------------------------------------|--|
| THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION. |  | DWN<br>X. ZHAO                            | 25MAY2012 | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
|                                                                                                                                                                                          |  | CHK<br>T. ELBIN                           | 25MAY2012 |                                              |  |
|                                                                                                                                                                                          |  | APVD<br>S. XI                             | 25MAY2012 | NAME<br>Ocean Side Feed<br>Applicator        |  |
| DIMENSIONS:<br>mm                                                                                                                                                                        |  | TOLERANCES UNLESS<br>OTHERWISE SPECIFIED: |           | PRODUCT SPEC                                 |  |
|                                                                                                                                                                                          |  | 0 PLC ±                                   |           | APPLICATION SPEC                             |  |
|                                                                                                                                                                                          |  | 1 PLC ±                                   |           | ANGLES                                       |  |
|                                                                                                                                                                                          |  | 2 PLC ±                                   |           | FINISH                                       |  |
|                                                                                                                                                                                          |  | 3 PLC ±                                   |           | MATERIAL                                     |  |
|                                                                                                                                                                                          |  | 4 PLC ±                                   |           | WEIGHT                                       |  |
|                                                                                                                                                                                          |  | 5 PLC ±                                   |           | Customer Accessible Production Drawing       |  |
|                                                                                                                                                                                          |  | 6 PLC ±                                   |           | SCALE 1:2                                    |  |
|                                                                                                                                                                                          |  | 7 PLC ±                                   |           | SHEET 2 of 4                                 |  |
|                                                                                                                                                                                          |  | 8 PLC ±                                   |           | REV D2                                       |  |



| PACIFIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER | PART<br>NUMBER | REVISION | DESCRIPTION              | FEED TYPE                         | APPLICATOR STYLE CONVERSION CHART     |                        |        |                            |                |                  |                        |
|----------------------------------------------------|----------------|----------|--------------------------|-----------------------------------|---------------------------------------|------------------------|--------|----------------------------|----------------|------------------|------------------------|
|                                                    |                |          |                          |                                   | CONVERT TO                            | PART NUMBERS REQUIRED  |        |                            |                |                  |                        |
|                                                    |                |          |                          |                                   |                                       | -                      | -      | -                          | -              | -                | -                      |
|                                                    | 2-2151443-2    | D        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                         | SERVO LATCH PLATE<br>SMART APPLICATOR | 2119951-1<br>2161326-1 | -<br>- | 8-2151443-5<br>8-2151443-4 | 1901094-3<br>- | 1-1752354-3<br>- | 2168400-6 (QUANTITY 2) |
|                                                    | 2-2151443-5    | D        | FINE CRIMP HEIGHT ADJUST | SERVO<br>LATCH PLATE <sup>4</sup> | -                                     | -                      | -      | -                          | -              | -                | -                      |
|                                                    | 2-2151443-7    | D        | FINE CRIMP HEIGHT ADJUST | NONE                              | -                                     | -                      | -      | -                          | -              | -                | -                      |
|                                                    | 7-2151443-7    | D        | CRIMP TOOLING KIT        | -                                 | -                                     | -                      | -      | -                          | -              | -                | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 0.80 mm [.031] | F    |
| INSUL                                | 0.85 mm [.033] | F    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

| TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION |                       |                                                           |                |
|---------------------------------------------------------|-----------------------|-----------------------------------------------------------|----------------|
| TERMINAL NAME: 1.25 WIRE TO BOARD CONN, CRIMP RECEPT.   |                       |                                                           |                |
| WIRE STRIP LENGTH<br>1.40-1.90 mm [.055-.075 IN]        |                       | INSULATION DIAMETER RANGE<br>Ø0.51-0.99 mm [.020-.039 IN] |                |
| TERMINAL APPLICATION SPECIFICATION                      | SPEC 63900-3700 Rev D | -                                                         | -              |
| TERMINALS APPLIED                                       |                       | -                                                         | -              |
| TE TERMINAL                                             | MOLEX TERMINAL        | TE TERMINAL                                               | MOLEX TERMINAL |
| 993820-1                                                | 50079-8000            |                                                           |                |

|                   |  |                              |  |                                             |
|-------------------|--|------------------------------|--|---------------------------------------------|
| WIRE SIZE         |  | CRIMP HEIGHT mm [INCH]       |  | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
| 26 AWG OR 0.12mm2 |  | 0.625+/-0.025 [.024+/- .001] |  | 5.8                                         |
| 28 AWG OR 0.08mm2 |  | 0.585+/-0.025 [.023+/- .001] |  | 6.4                                         |

| TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION |                       |                                                           |                |
|---------------------------------------------------------|-----------------------|-----------------------------------------------------------|----------------|
| TERMINAL NAME: 1.25 WIRE TO BOARD CONN, CRIMP RECEPT.   |                       |                                                           |                |
| WIRE STRIP LENGTH<br>1.40-1.90 mm [.055-.075 IN]        |                       | INSULATION DIAMETER RANGE<br>Ø0.51-0.99 mm [.020-.039 IN] |                |
| TERMINAL APPLICATION SPECIFICATION                      | SPEC 63900-3700 Rev D | -                                                         | -              |
| TERMINALS APPLIED                                       |                       | -                                                         | -              |
| TE TERMINAL                                             | MOLEX TERMINAL        | TE TERMINAL                                               | MOLEX TERMINAL |
| 993820-2                                                | 50058-8000            |                                                           |                |

|                   |  |                              |  |                                             |
|-------------------|--|------------------------------|--|---------------------------------------------|
| WIRE SIZE         |  | CRIMP HEIGHT mm [INCH]       |  | CRIMP HEIGHT REFERENCE SETTING <sup>9</sup> |
| 28 AWG OR 0.08mm2 |  | 0.535+/-0.025 [.021+/- .001] |  | 6.7                                         |
| 30 AWG OR 0.05mm2 |  | 0.505+/-0.025 [.020+/- .001] |  | 7.0                                         |
| 32 AWG OR 0.03mm2 |  | 0.485+/-0.025 [.019+/- .001] |  | 7.3                                         |

\*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.



<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: 8-2151443-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151443-5

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 ITEM 62.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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> THIS APPLICATOR DOES NOT CUT CARRIER STRIP

12. ADJUSTMENTS MAY BE REQUIRED WHEN CHANGING TERMINALS.

| SET UP GAUGE<br>2119599-1 | LOC<br>A | DIS<br>66 | REVISIONS |     |             |      |     |      |
|---------------------------|----------|-----------|-----------|-----|-------------|------|-----|------|
|                           |          |           | P         | LTR | DESCRIPTION | DATE | DWN | APVD |
|                           |          |           | -         | -   | SEE SHEET 1 | -    | -   | -    |
|                           |          |           |           |     |             |      |     |      |
|                           |          |           |           |     |             |      |     |      |
|                           |          |           |           |     |             |      |     |      |

|     |     |     |     |             |                                     |         |
|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| -   | 2   | 2   | 2   | 22281-8     | SPRING, COMPRESSION                 | 279     |
| -   | 2   | 2   | 2   | 2-18032-5   | SCR, SET, FLT POINT M5 X 20.0       | 278     |
| -   | 1   | 1   | 1   | 1-22281-8   | SPRING, COMPRESSION                 | 277     |
| -   | 1   | 1   | 1   | 2168083-6   | SCR, SKT HD CAP, RoHS, M5 X 65      | 276     |
| -   | 1   | 1   | 1   | 980371-4    | SCR, SKT HD SHLDR 5.0 DIA X 6.0     | 275     |
| -   | 1   | 1   | 1   | 356835-1    | LEVER, DRAG RELEASE                 | 274     |
| -   | 1   | 1   | 1   | 240792-1    | DRAG, TERMINAL                      | 273     |
| -   | 2   | 2   | 2   | 2168083-1   | SCR, SKT HD CAP, RoHS, M3 X 8.0     | 271     |
| -   | 1   | 1   | 1   | 1-690438-0  | FRONT STRIP GUIDE                   | 270     |
| -   | 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   | 2119082-1   | 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     |
| -   | -   | 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     |
| -   | 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   | 1-2119656-0 | 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   | 1-18028-2   | WASHER, FLAT, REG M4                | 119     |
| -   | -   | REF | -   | 2119944-1   | FEED FINGER ASSEMBLY,SF             | 117     |
| -   | 1   | 1   | 1   | 1-455888-8  | SPACER, CRIMPER                     | 82      |
| -   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71      |
| -   | 1   | 1   | 1   | 1-2119791-8 | DEPRESSOR, WIRE                     | 70      |
| -   | 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      |
| -   | -   | -   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -   | -   | -   | 1   | 1338685-1   | PAWL, FEED                          | 56      |
| -   | -   | -   | 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   | 2119644-1   | RAM WASHER, PRECISION               | 38      |
| -   | 1   | 1   | 1   | 2-1752356-6 | 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   | 1320908-2   | SPACER, STRIP GUIDE                 | 30      |
| -   | 1   | 1   | 1   | 2-1901086-0 | PLATE, STRIP GUIDE                  | 29      |
| -   | 1   | 1   | 1   | 1320928-2   | STRIP GUIDE                         | 24      |
| -   | 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   | 2119533-3   | STRIPPER, SIDE FEED                 | 19      |
| -   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12      |
| -   | 1   | 1   | 1   | 1-356885-5  | STOP, SHEAR                         | 11      |
| -   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
| -   | 1   | 1   | 1   | 1803095-6   | FLOATING SHEAR, FRONT               | 9       |
| -   | 1   | 1   | 1   | 4-1633621-5 | ANVIL, COMBINATION                  | 8       |
| -   | -   | -   | -   | -           | -                                   | 7       |
| -   | -   | -   | -   | -           | -                                   | 6       |
| -   | 1   | 1   | 1   | 2119757-1   | DEPRESSOR, SHEAR                    | 5       |
| -   | 1   | 1   | 1   | 2-238011-5  | BLOCK, CRIMPER SPACER               | 4       |
| -   | 1   | 1   | 1   | 1803167-5   | CRIMPER, INSULATION F SPECIAL       | 3       |
| -   | 1   | 1   | 1   | 455888-1    | SPACER, CRIMPER                     | 2       |
| -   | 1   | 1   | 1   | 1633713-8   | CRIMPER, WIRE PREMIUM               | 1       |
| -77 | -27 | -25 | -22 | PART NO     | DESCRIPTION                         | ITEM NO |

|                                                                                                                                                         |  |                                                                 |  |                                                    |                                     |                                              |  |
|---------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------|--|----------------------------------------------------|-------------------------------------|----------------------------------------------|--|
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| DIMENSIONS:<br>mm                                                                                                                                       |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:                          |  | NAME<br>Ocean Side Feed<br>Applicator              |                                     | RESTRICTED TO                                |  |
|                                                                                                                                                         |  | 0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ± |  | PRODUCT SPEC                                       |                                     | SIZE CASE CODE DRAWING NO                    |  |
| MATERIAL                                                                                                                                                |  | FINISH                                                          |  | APPLICATION SPEC                                   |                                     | 00779 ©=2151443                              |  |
| -                                                                                                                                                       |  | -                                                               |  | WEIGHT                                             |                                     | -                                            |  |
| -                                                                                                                                                       |  | -                                                               |  | Customer Accessible Production Drawing             |                                     | SCALE 1:2 SHEET 3 OF 4 REV D2                |  |

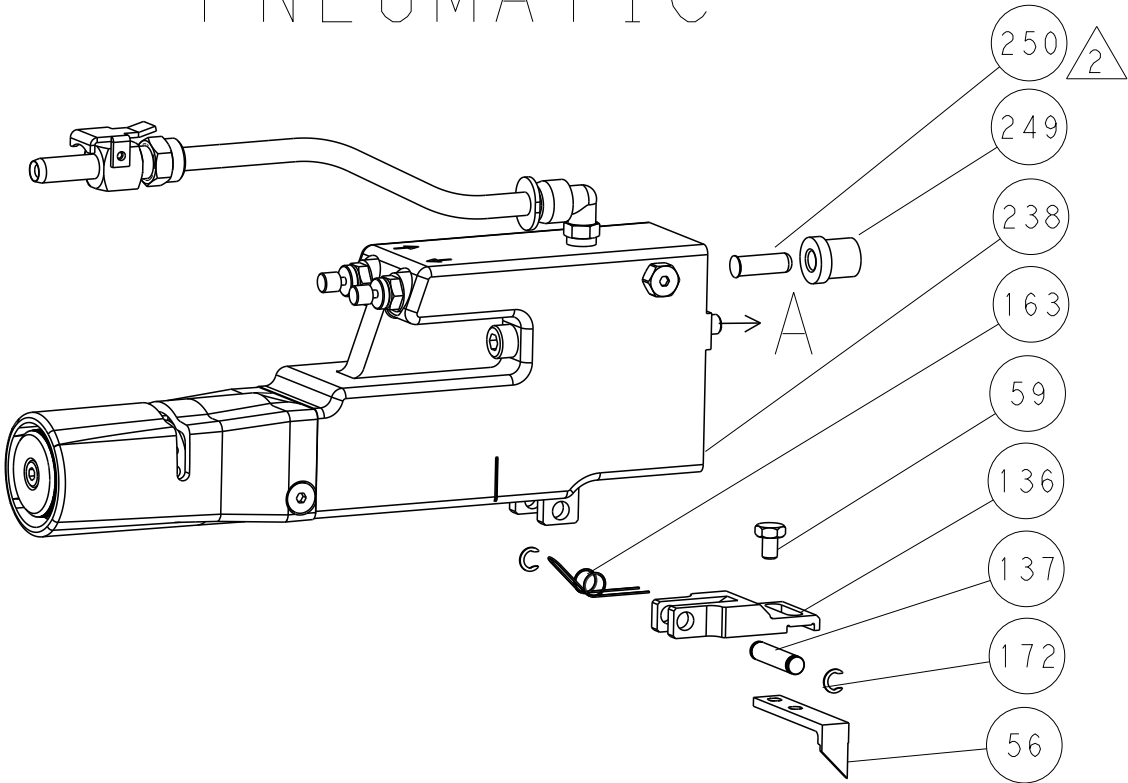
PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)



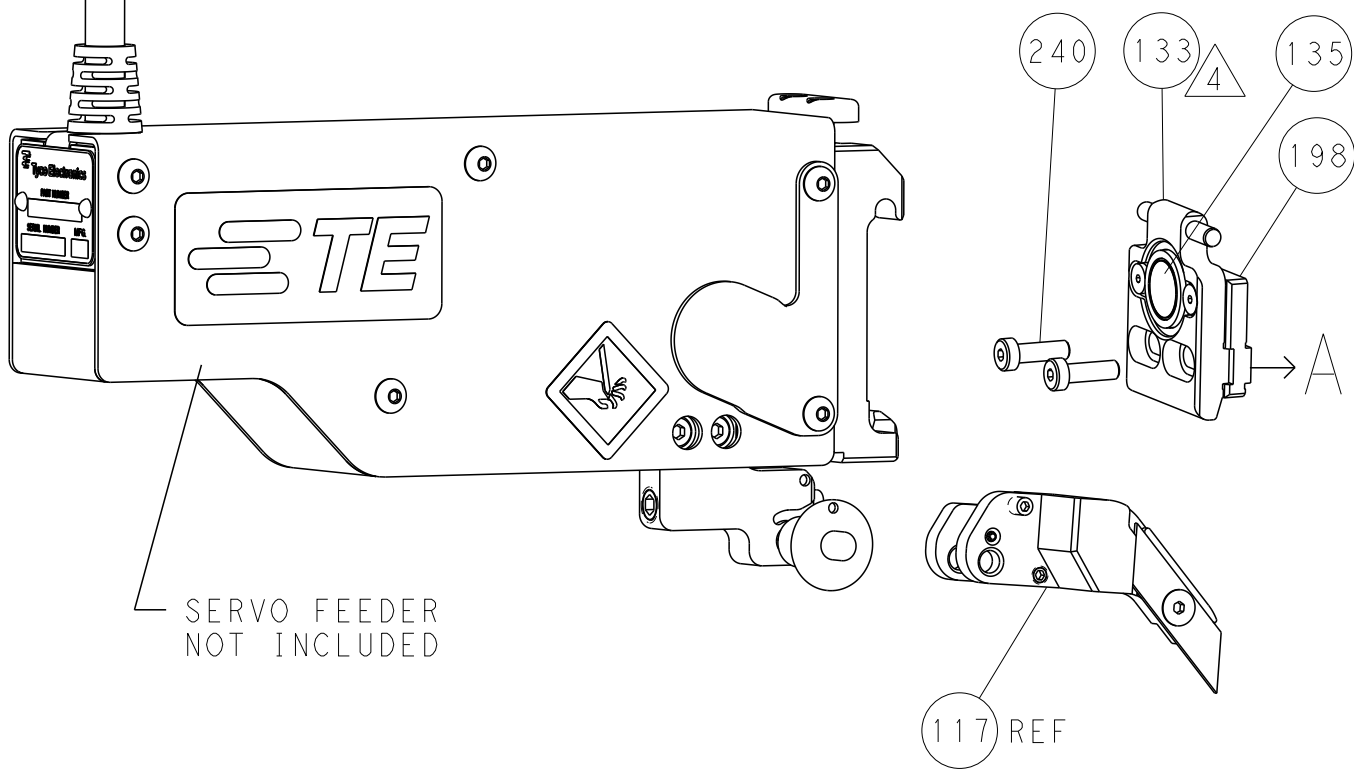
| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTR | DESCRIPTION | DATE | DWN | APVD |
|     |    | -    | -   | SEE SHEET 1 | -    | -   | -    |
|     |    |      |     |             |      |     |      |
|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

FEED TYPE

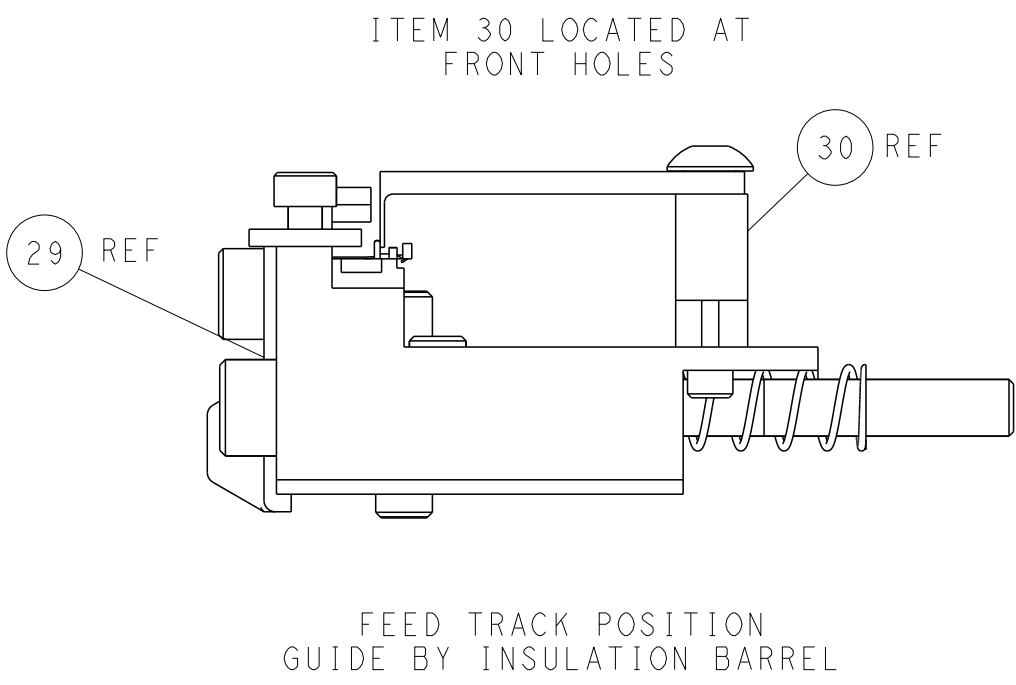
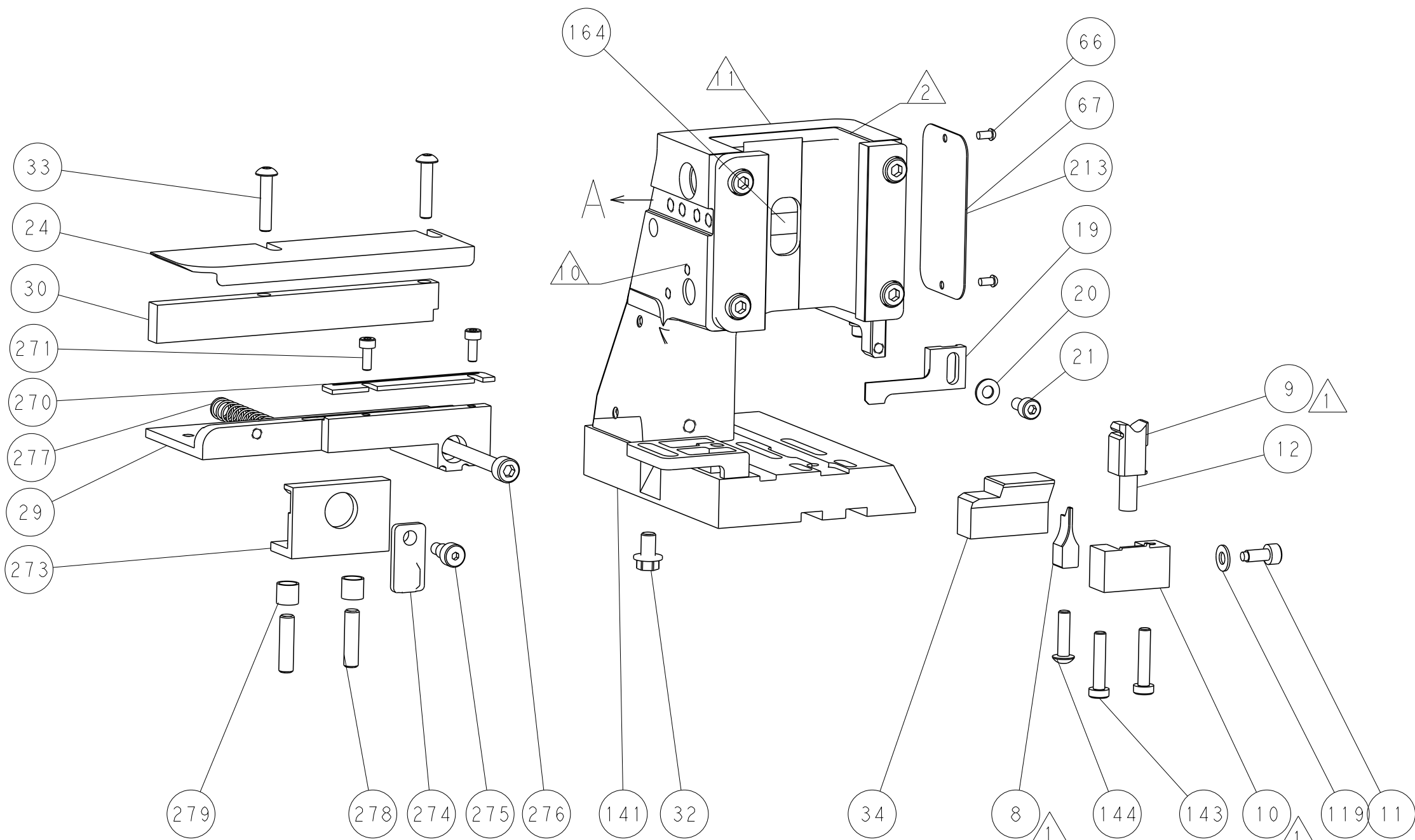
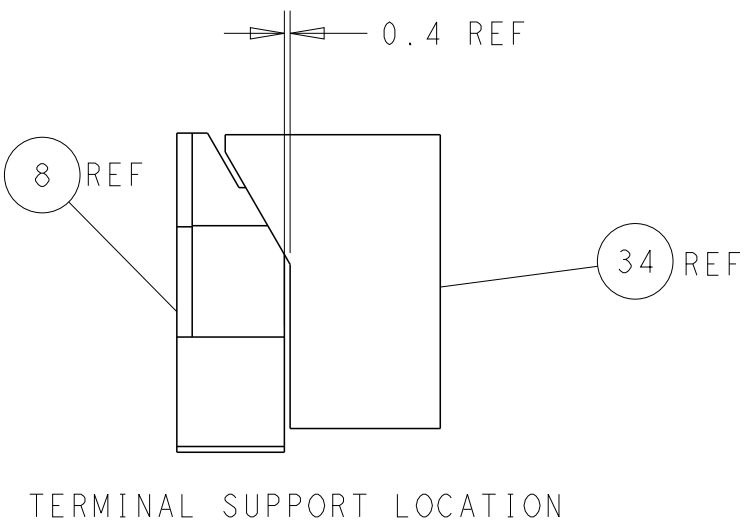
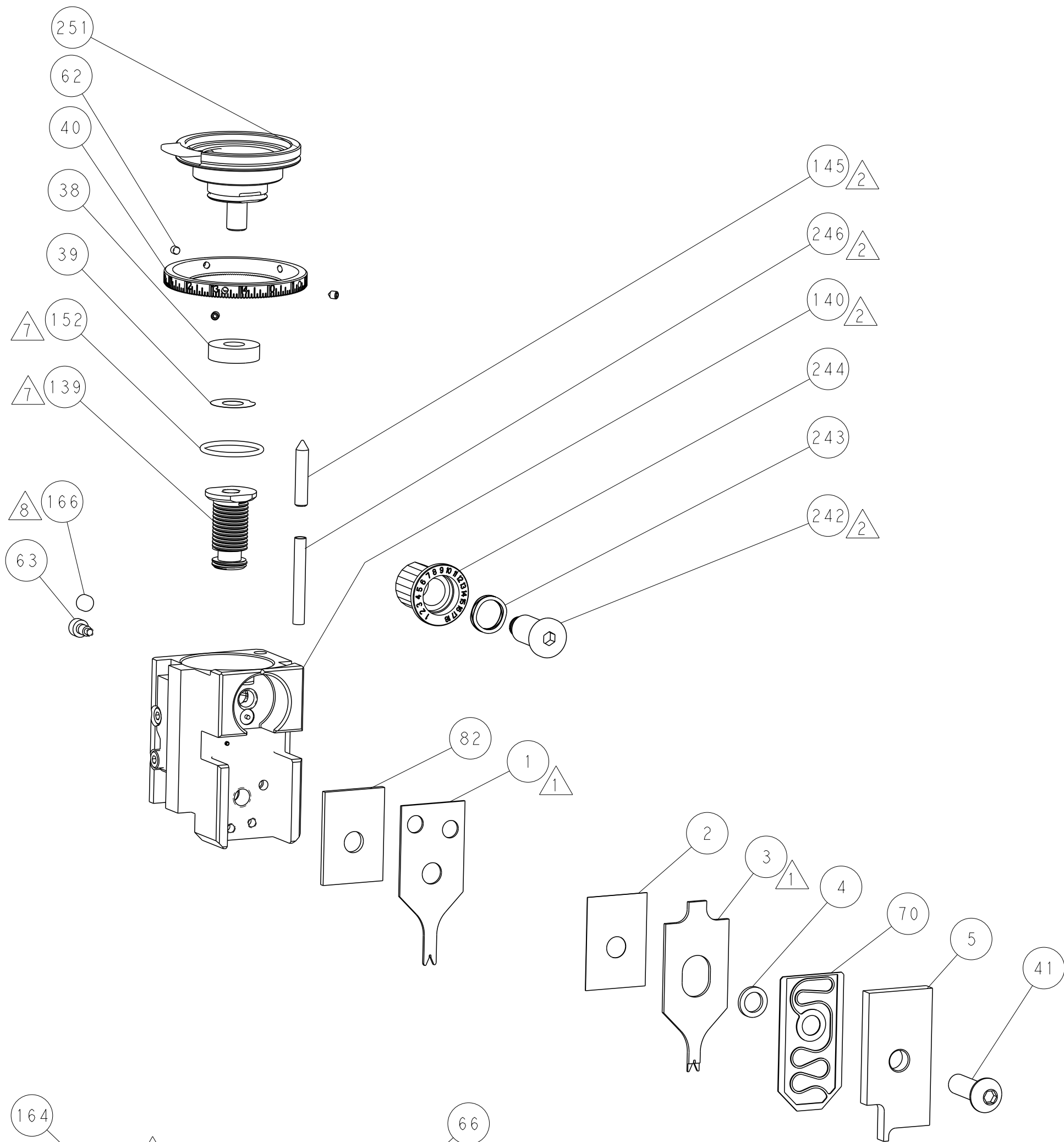
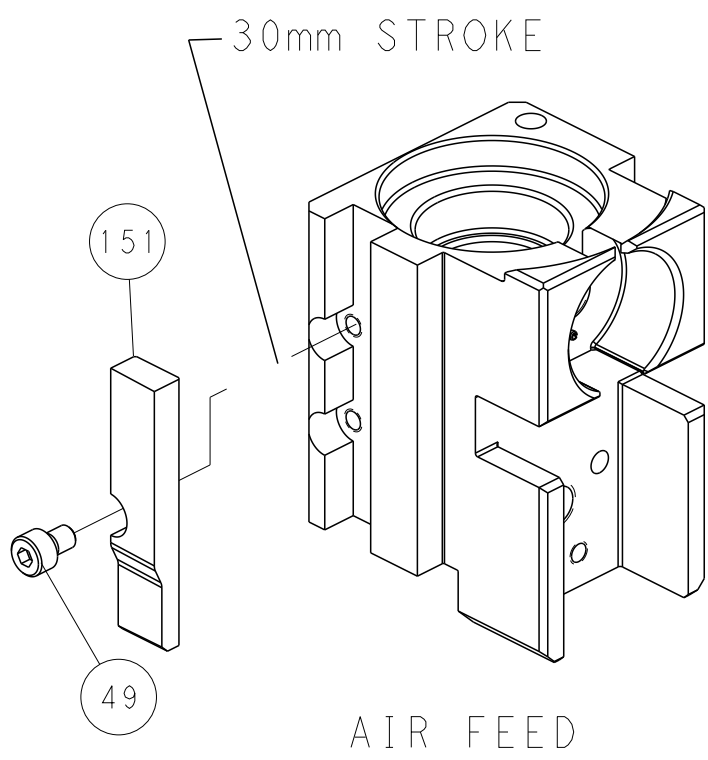
PNEUMATIC



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)

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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