

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.56 mm [.140]	F

APPLICATOR INSTRUCTIONS  
408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CLIP, TAB			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.73-3.74 mm [.147-.147 IN]		Ø1.91-2.75 mm [.075-.108 IN]	
TERMINAL APPLICATION SPECIFICATION	114-2036		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
63934-1	61723-1	61656-1	

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.22+/-0.05 [.048+/- .002]	11.6
20 AWG	1.09+/-0.05 [.043+/- .002]	13.1
22 AWG	1.02+/-0.05 [.040+/- .002]	13.9

- 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:  
 MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151622-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151622-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151622-5  
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151622-6
- 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 50.
- 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 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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 CUT TO LENGTH AT ASSEMBLY.

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

ITEM NO	DESCRIPTION	ITEM NO
260	APPLICATOR SHIM PACK	2119957-2
252	O-RING, .676 ID, .070 DIA. MAT.	8-21084-0
250	PUSH ROD, AIR FEED	2119640-1
249	BUSHING, LCH5-12, MISUMI	2079988-1
248	FEED CAM, AIR FEED	2119641-1
247	DETENT PIN	2119798-1
246	SPRING, COMPRESSION	1-22279-3
245	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	2119758-1
244	CAM, SNAIL, INSULATION ADJUSTMENT	2119082-9
243	WASHER, WAVE SPRING, CREST-TO-CREST	2079764-1
242	RETAINER, INSULATION DIAL	2119083-1
240	SHCS, LOW HEAD, RoHS, M5 X 16	2168400-6
	PART NO	DESCRIPTION

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

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTB	DESCRIPTION	DATE	DWN	APVD
			1		ORIGINAL	25APR2012	CAM	TE
			A		RELEASED	07JUN2012	CAM	GB

ITEM NO	DESCRIPTION	ITEM NO
239	MECHANICAL FEED ASSEMBLY	2119580-1
238	AIR FEED MODULE	2063440-1
233	PLATE, REAR SHEAR	2063687-2
232	BLADE, SLUG	2161951-1
213	TAG, IDENTIFICATION	2119740-2
198	SPACER, FEEDER	1901094-3
172	RING, RETAIN, EXTERN, 3/16 CRESCENT	21045-3
166	MAGNET, RARE EARTH HIGH ENERGY	994969-1
164	COUNTER, MAGNETIC	994970-2
163	SPRING, FEED FINGER	240638-1
137	PIN, RETAIN, GRVD, 3/16 X .854	3-23627-7
136	HOLDER, FEED FINGER, AF	2119799-1
135	MEMORY CHIP, PROGRAMMED	SEE NOTE 4
133	SERVO FEED LATCH ASM	1633743-1
130	BRACKET, AIR BLAST	2217068-1
129	TUBING, POLYURETHANE	2030758-3
128	NUT, HEX, REG, RoHS, M4	5018030-2
127	SCR, SKT HD CAP, RoHS, M4 X 10	1-2168083-0
126	CLAMP, CABLE, BLACK	986220-3
117	FEED FINGER ASSEMBLY, SF	2119944-1
101	INSERT, COUPLING	23238-1
82	SPACER, CRIMPER	455888-5
71	DOCUMENTATION PACKAGE	2119956-1
70	DEPRESSOR, WIRE	2119791-9
67	TAG, IDENTIFICATION	2119740-1
66	SCREW, DRIVE, RH, RoHS	2168078-1
63	LIMITER, ADJUSTMENT BOLT	2119793-1
62	SCR, SET, SOC, CONE POINT, M3 X 4.0	992763-5
61	SCR, SET, FLT POINT M5 X 20.0	2-18032-5
60	SCR, BHSC, RoHS (M4 X 8)	2079383-4
59	SCR, HEX HD CAP, M4 X 6.0	5-18022-5
56	FEED PAWL	1338683-9
51	BUMPER, HOLD DOWN	1-811242-0
50	SCR, SET, CUP POINT M2.5 X 3.0	3-18031-6
49	SCR, SKT HD CAP M4 X 6.0	18023-9
48	FEED CAM, PRE FEED	2119652-1
47	FEED CAM, POST FEED	2119653-1
46	APPLICATOR BASIC ASSEMBLY, SF	2119656-1
45	SCR, SKT HD CAP, RoHS, M4 X 20	2168083-9
44	RAM, AMP STYLE, SIDE FEED	2119370-1
43	SCR, SKT HD CAP, RoHS, M4 X 16	2168083-8
41	SCR, BHSC, RoHS (M8 X 25)	2079383-7
40	DISC, NUMBERED FA WIRE ADJUSTMENT	2119645-1
39	APPLICATOR SHIM PACK	2119957-1
38	RAM WASHER, PRECISION	2119644-2
37	FA HEAD, ATLANTIC STYLE	2119085-1
36	SCR, SKT HD CAP, RoHS, M4 X 8.0	2168083-2
35	BOLT, ADJUSTMENT	2119092-1
34	SCR, SKT HD CAP, RoHS, M3 X 8.0	2168083-1
33	SCR, BHSC, RoHS (M4 X 20)	2079383-5
32	HEX HEAD, FLANGED, M5 X 8mm LONG	2161328-1
30	SPACER, STRIP GUIDE	1-1320908-5
29	ASSEMBLY, STRIP GUIDE	2119959-3
27	SPRING, COMPRESSION	1-22284-0
26	LEVER, DRAG RELEASE	356835-1
25	DRAG, SPECIAL	3-690754-8
24	PLATE, STRIP GUIDE	1633653-3
23	SCR, SKT HD SHLDR 5.0 DIA X 6.0	980371-4
21	SCR, SKT HD CAP, RoHS, M4 X 8.0	2168083-2
20	WASHER, FLAT, REG M4	1-18028-2
19	STRIPPER, SIDE FEED	2119533-2
12	FENCE	1-2119928-8
11	HOLDER, SLUG BLADE	1803011-4
10		
9		
8	ANVIL, SPECIAL, COMBINATION	1803010-2
7		
6		
5		
4	BLOCK, FL CRIMPER SPACER	2-238009-3
3	CRIMPER, INSULATION F PREMIUM	2-2119582-4
2		
1	CRIMPER, WIRE PREMIUM	5-456404-5
	PART NO	DESCRIPTION

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:	
mm	9 PLC ±.01	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005
	ANGLES ±.0005	FINISH			

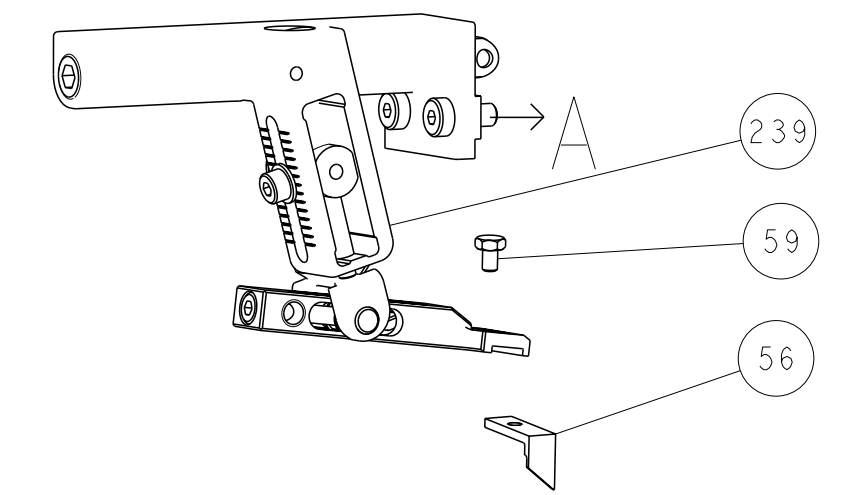
DATE	25APR2012	BY	MOYER
CHK	25APR2012	BY	ELBIN
APVD	25APR2012	BY	ELBIN

NAME	Ocean Side Feed Applicator		
SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C=2151622	

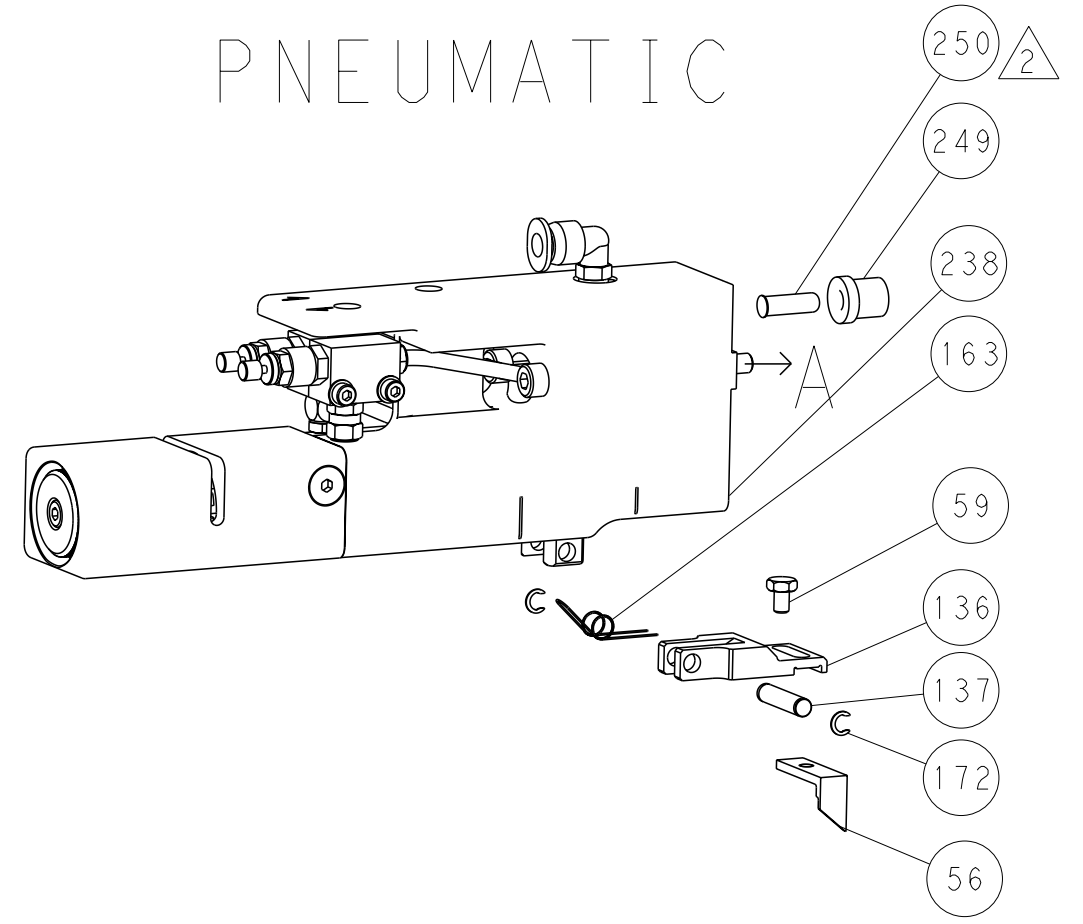
CUSTOMER ACCESSIBLE PRODUCTION DRAWING SCALE 1:1 SHEET 1 OF 4 REV A

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

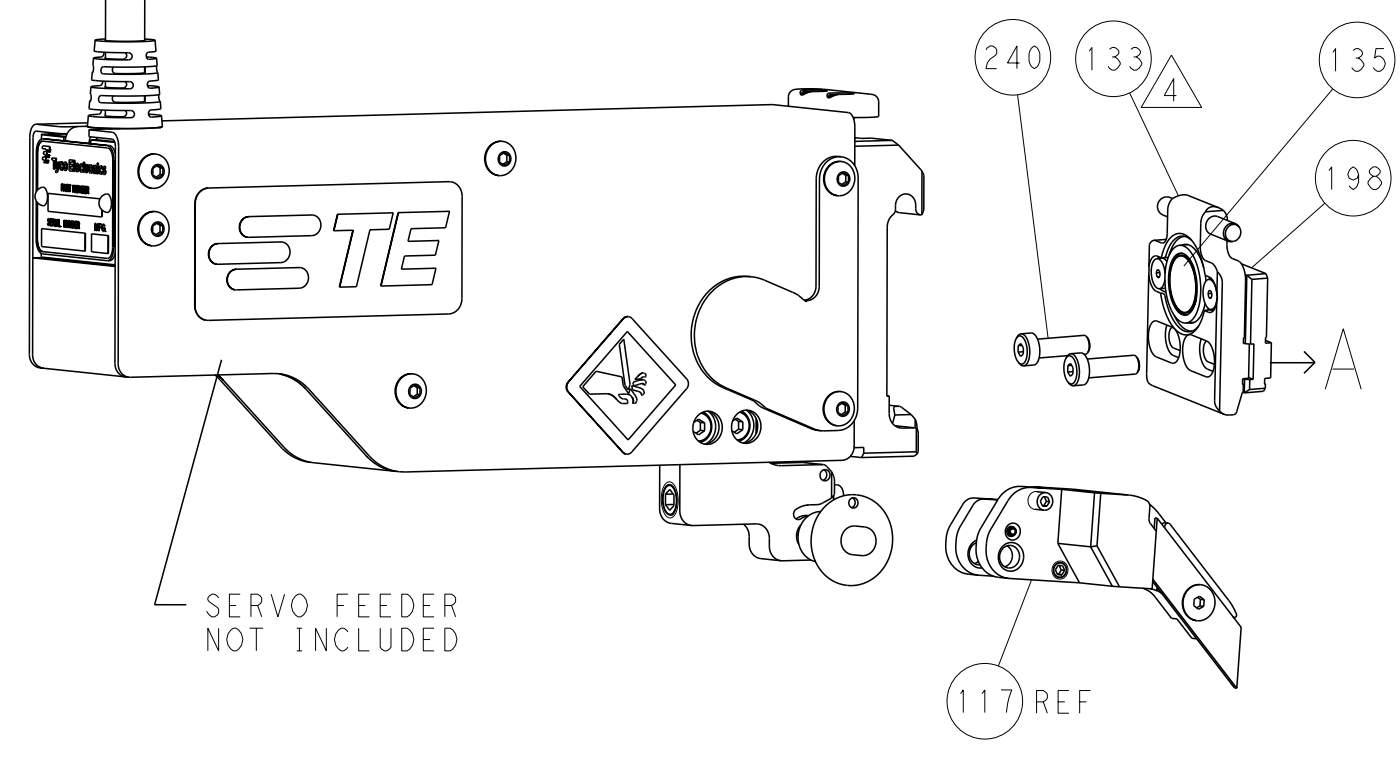
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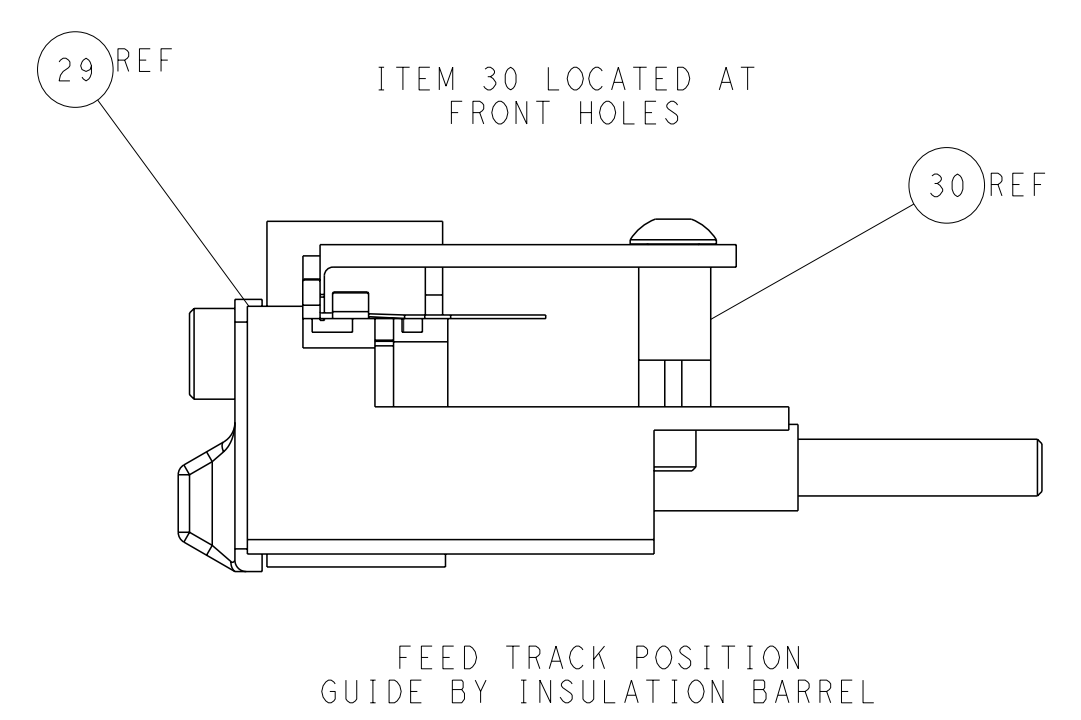
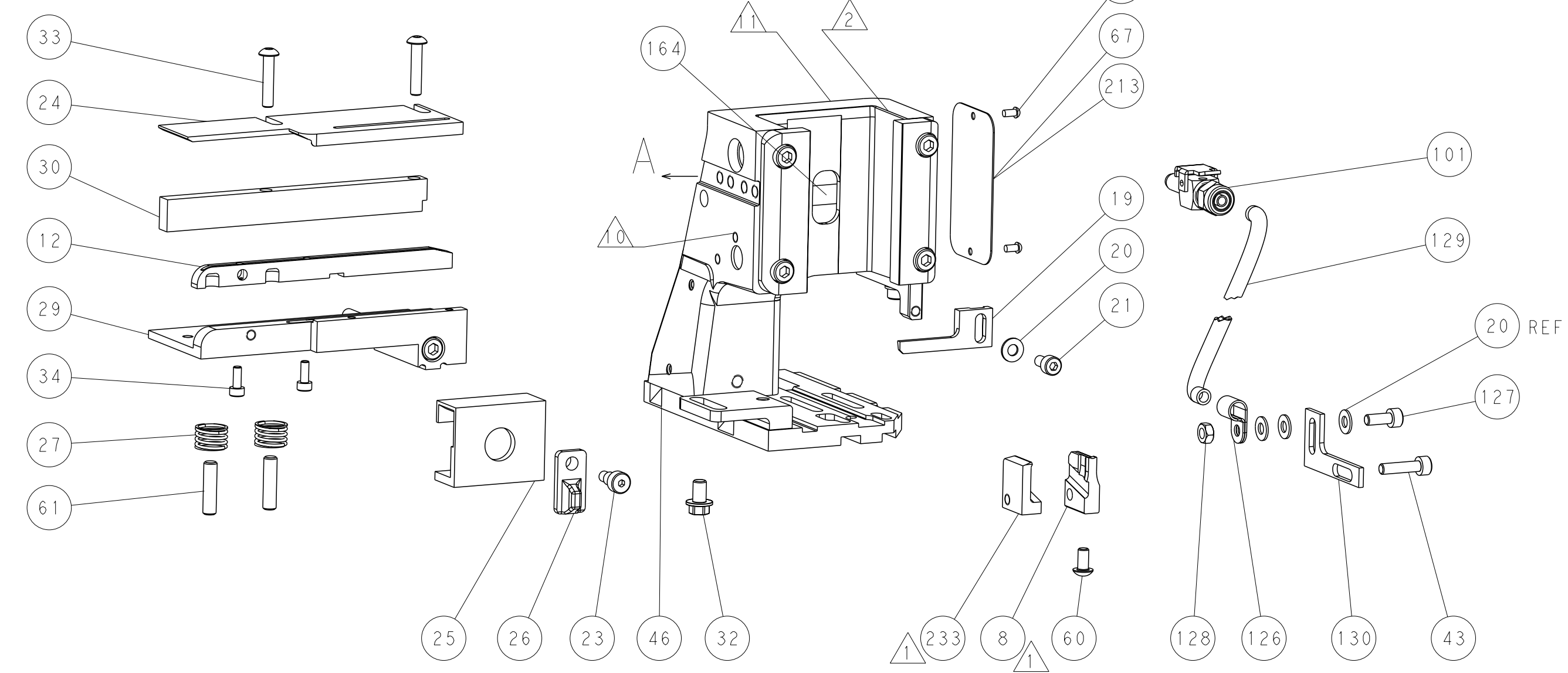
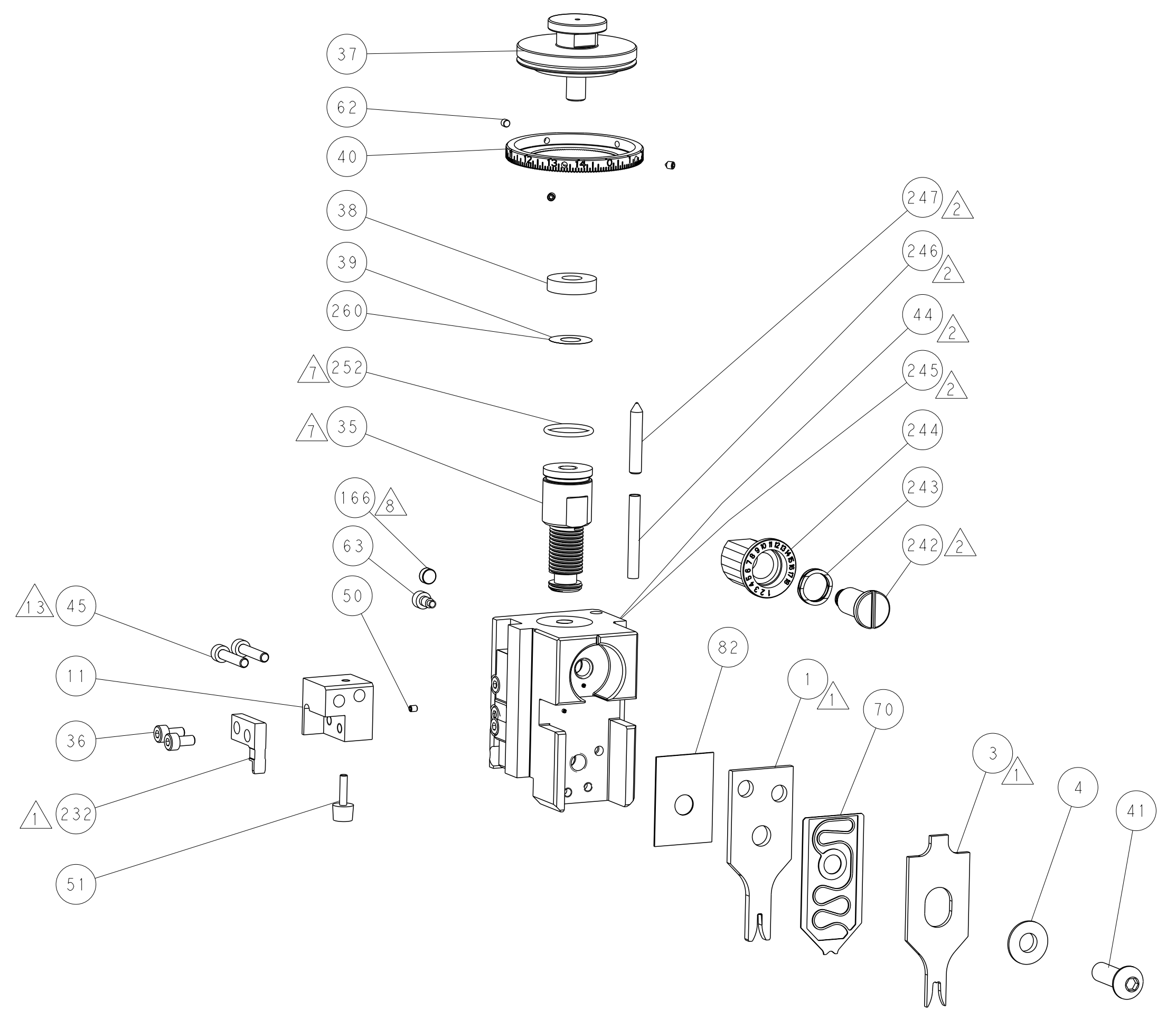
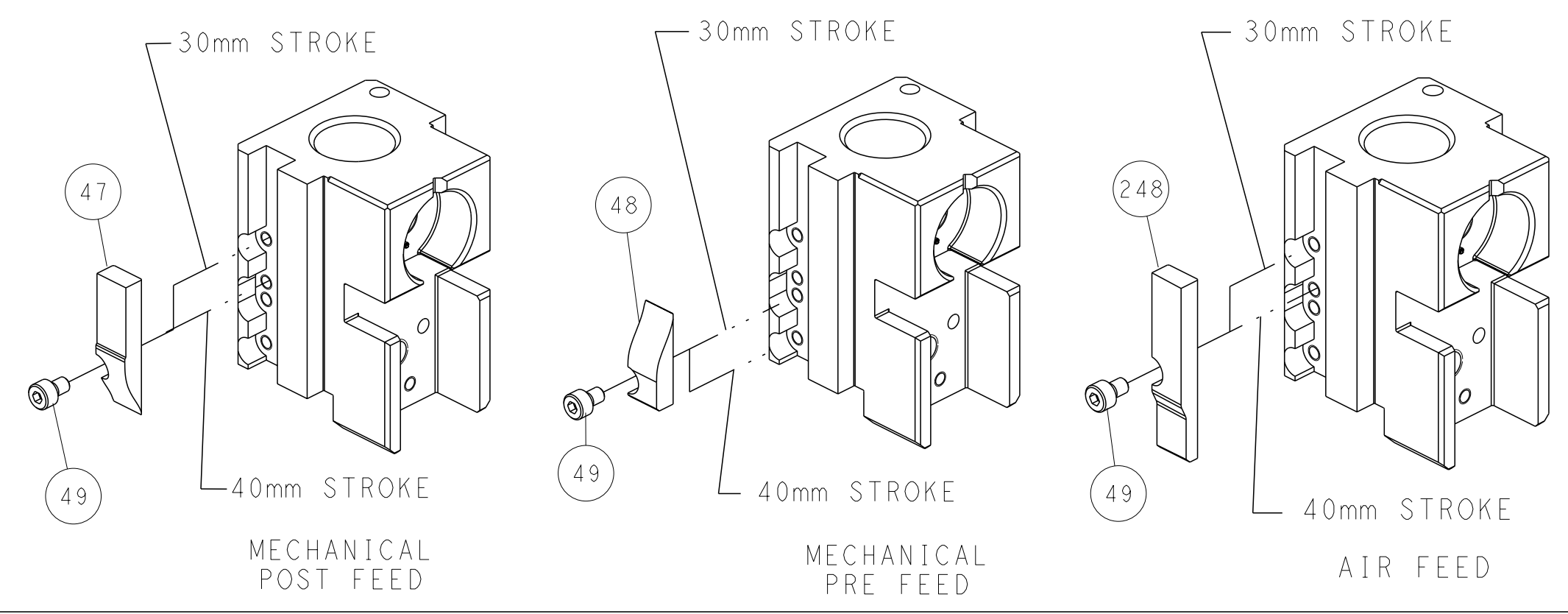
### PNEUMATIC



### 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)

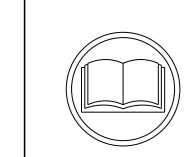
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. MOYER 25APR2012		TE Connectivity	
mm	9 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.02	4 PLC ±0.005	5 PLC ±0.005	Harrisburg, PA 17105-3608
	ANGLES	FINISH		APVD T. ELBIN 25APR2012	NAME	SIZE	CAGE CODE
				PRODUCT SPEC	Ocean Side Feed	00779	2151622
				APPLICATION SPEC	RESTRICTED TO		
MATERIAL				WEIGHT	CUSTOMER ACCESSIBLE PRODUCTION DRAWING	SCALE	1:1
						SHEET	2 OF 4
						REV	A

APPLICATOR STYLE CONVERSION CHART. Table with columns: CONVERT TO, PART NUMBERS REQUIRED. Rows include PNEUMATIC FEED, SERVO LATCH PLATE, SMART APPLICATOR, MECHANICAL FEED, and SMART APPLICATOR.

APPLICATOR DATA. Table with columns: CRIMP, SIZE, TYPE. Rows include WIRE (1.78 mm) and INSUL (3.56 mm). Includes APPLICATOR INSTRUCTIONS 408-10389.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. Table with columns: TE TERMINAL, TE CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH and INSULATION DIAMETER RANGE.

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING. Table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING. Rows include 18 AWG, 20 AWG, 22 AWG.



- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
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: 8-2151622-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151622-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151622-5
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 ITEM 50.
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.
CUT TO LENGTH AT ASSEMBLY.

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

Table with columns: PART NO, DESCRIPTION, ITEM NO. Rows include FINE ADJUST HEAD ASM, PUSH ROD, BUSHING, SPRING, CAM, SNAIL, WASHER, WAVE SPRING, CREST-TO-CREST, RETAINER, INSULATION DIAL, SHCS, LOW HEAD, MECHANICAL FEED ASSEMBLY, AIR FEED MODULE.

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 2119599-1. Table with columns: LOC, DIST, REVISIONS. Includes a table for REVISIONS with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD.

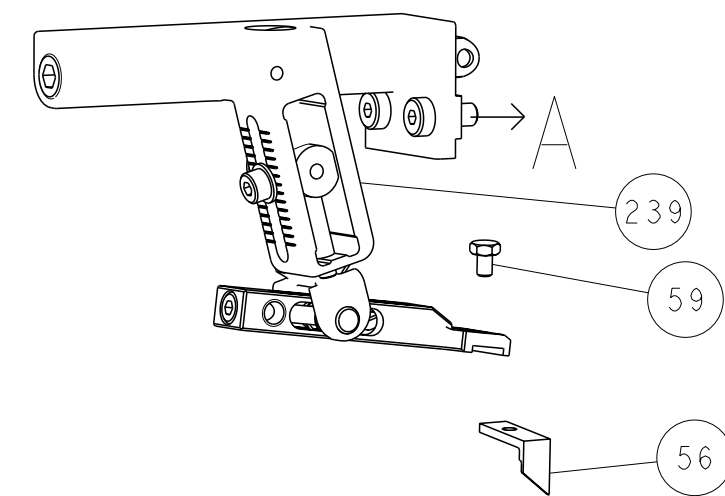
Main parts list table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD. Lists various components like PLATE, REAR SHEAR, BLADE, SLUG, TAG, IDENTIFICATION, SPACER, FEEDER, RING, RETAIN, EXTERN, MAGNET, COUNTER, SPRING, O-RING, FEED CAM, SCR, TUBING, NUT, CLAMP, FEED FINGER ASSEMBLY, INSERT, SPACER, CRIMPER, DOCUMENTATION PACKAGE, DEPRESSOR, WIRE, TAG, IDENTIFICATION, SCREW, DRIVE, RH, LIMITER, SCR, SET, CONE POINT, SCR, HEX HD CAP, FEED PAWL, BUMPER, HOLD DOWN, SCR, SET, CUP POINT, SCR, SKT HD CAP, FEED CAM, PRE FEED, SCR, SKT HD CAP, SCR, SKT HD CAP, DISC, NUMBERED FA WIRE ADJUSTMENT, APPLICATOR SHIM PACK, RAM WASHER, SCR, SKT HD CAP, SCR, SKT HD CAP, SCR, SKT HD CAP, SPRING, COMPRESSION, LEVER, DRAG RELEASE, DRAG, SPECIAL, PLATE, STRIP GUIDE, SCR, SKT HD SHLDR, WASHER, FLAT, STRIPPER, SIDE FEED, FENCE, HOLDER, SLUG BLADE.

STE TE Connectivity logo and drawing information. Includes DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, SCALE, SHEET 3 OF 4, REV A.

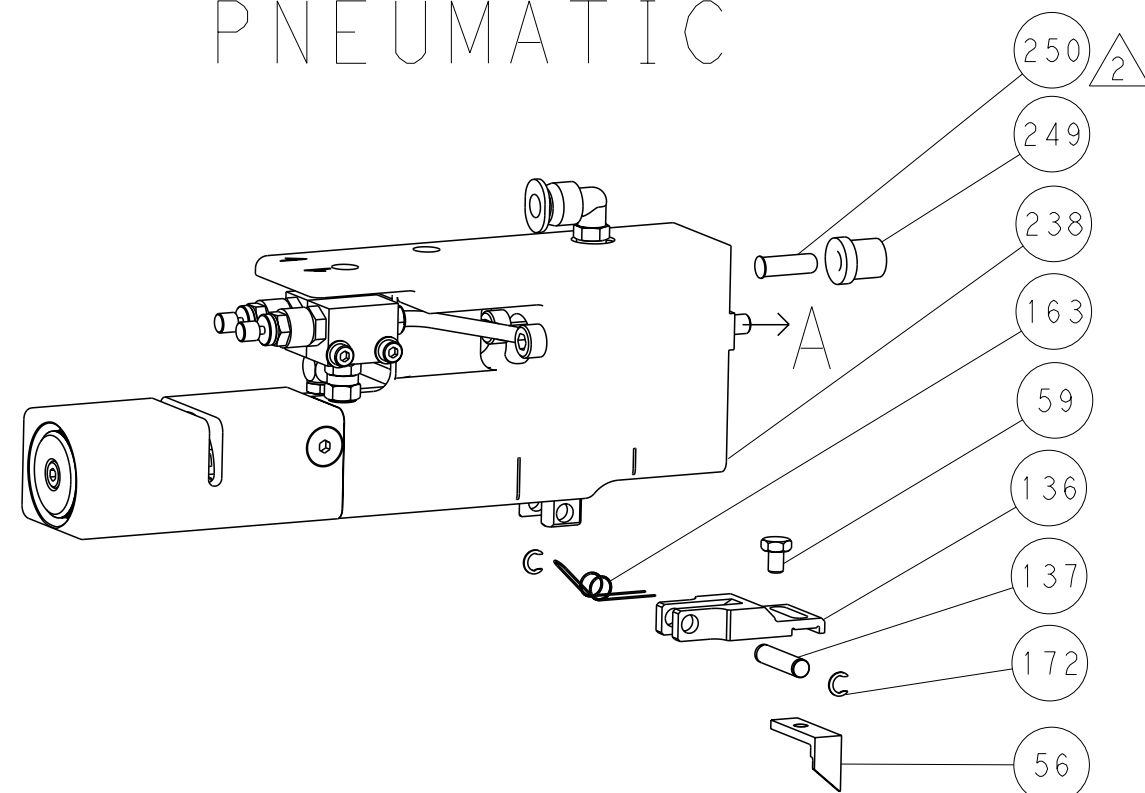
LOC		DIST		REVISIONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
				SEE SHEET 1			

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2009

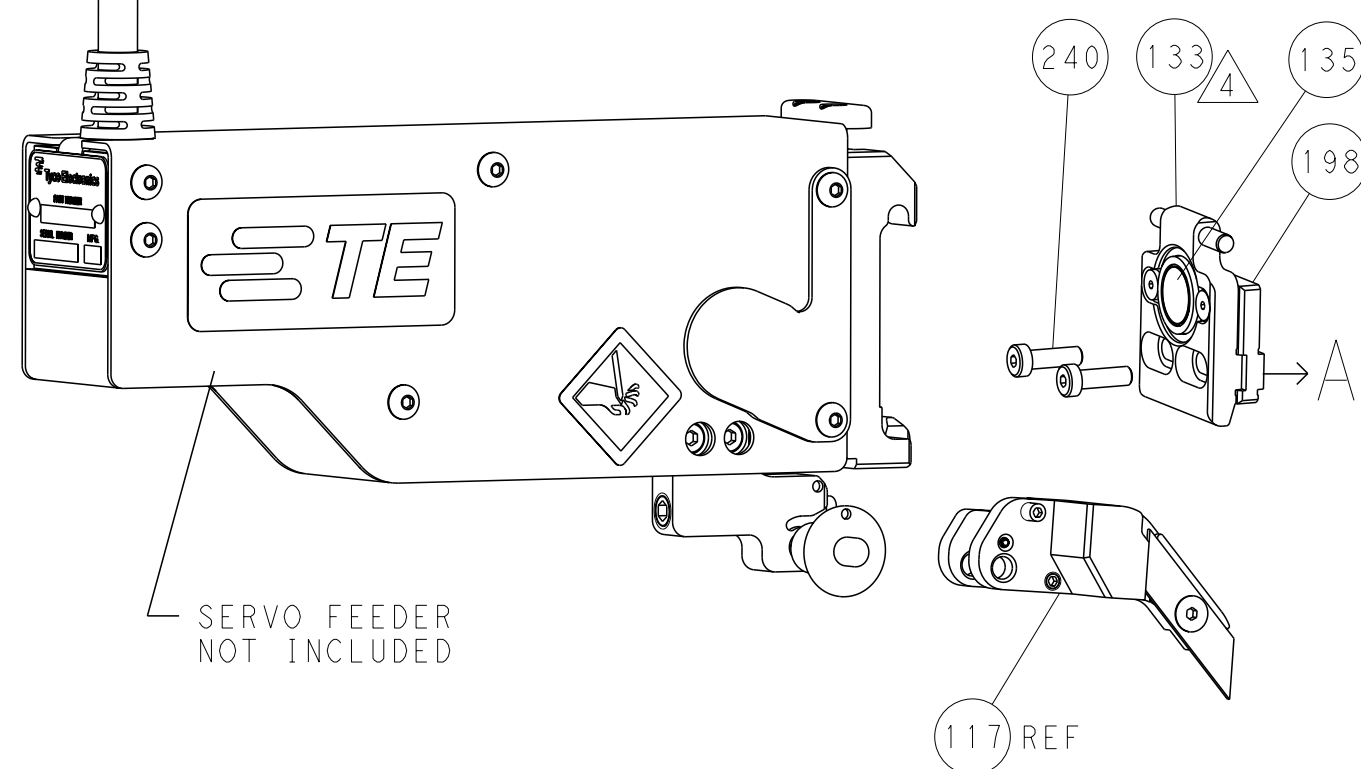
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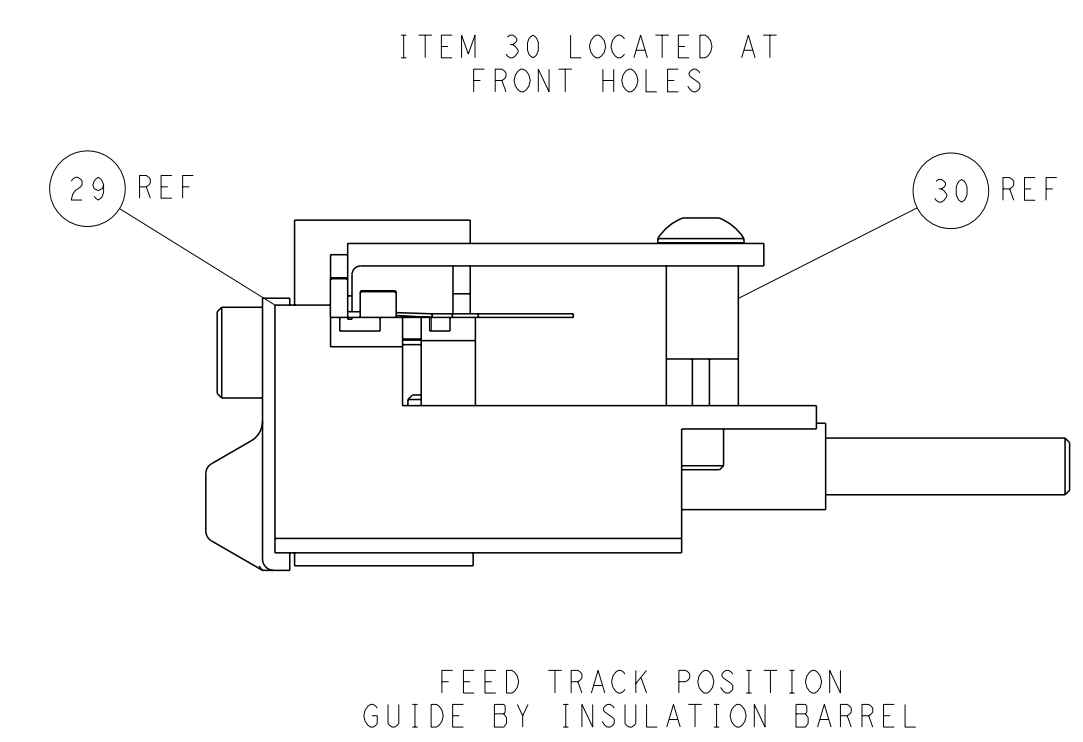
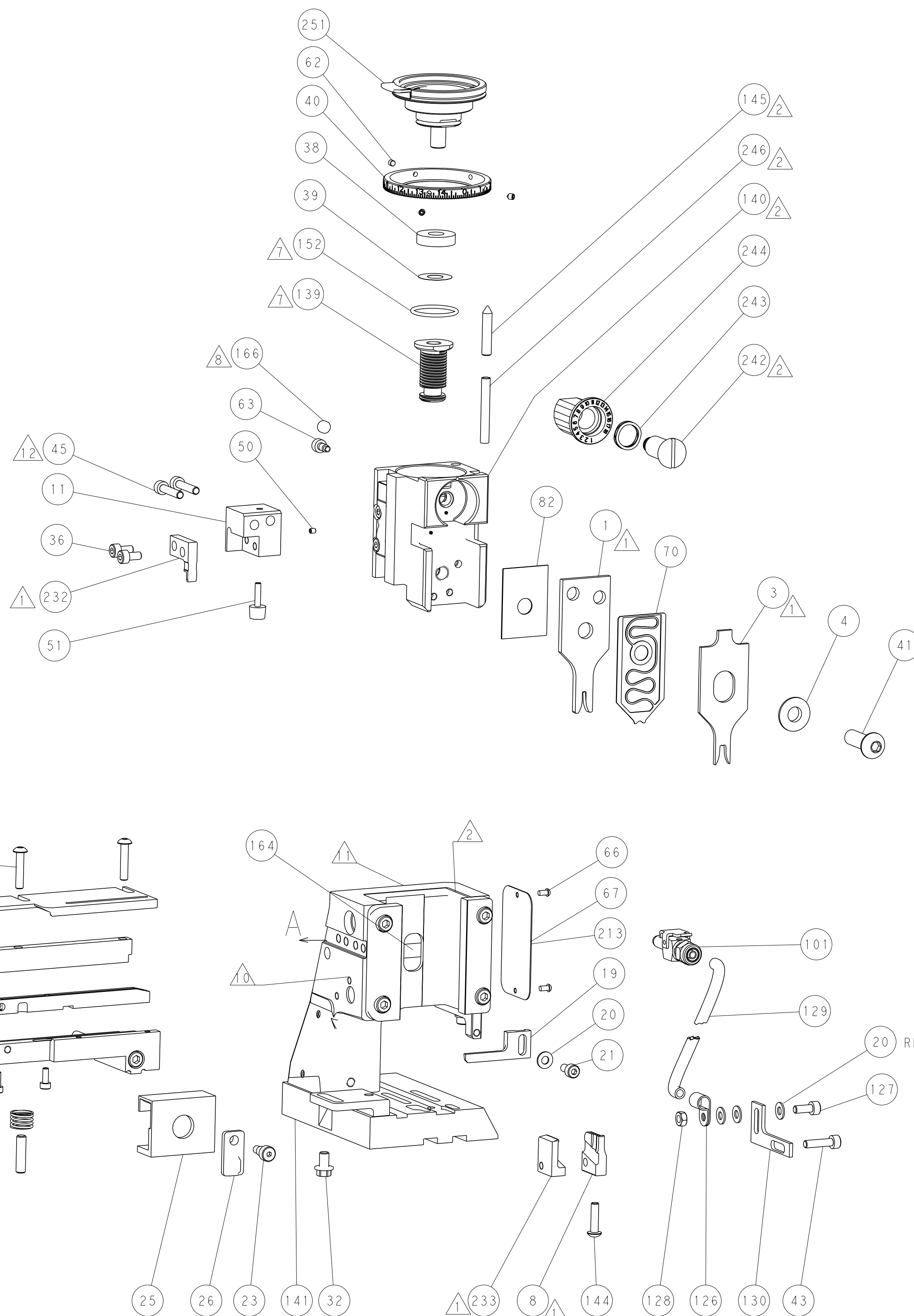
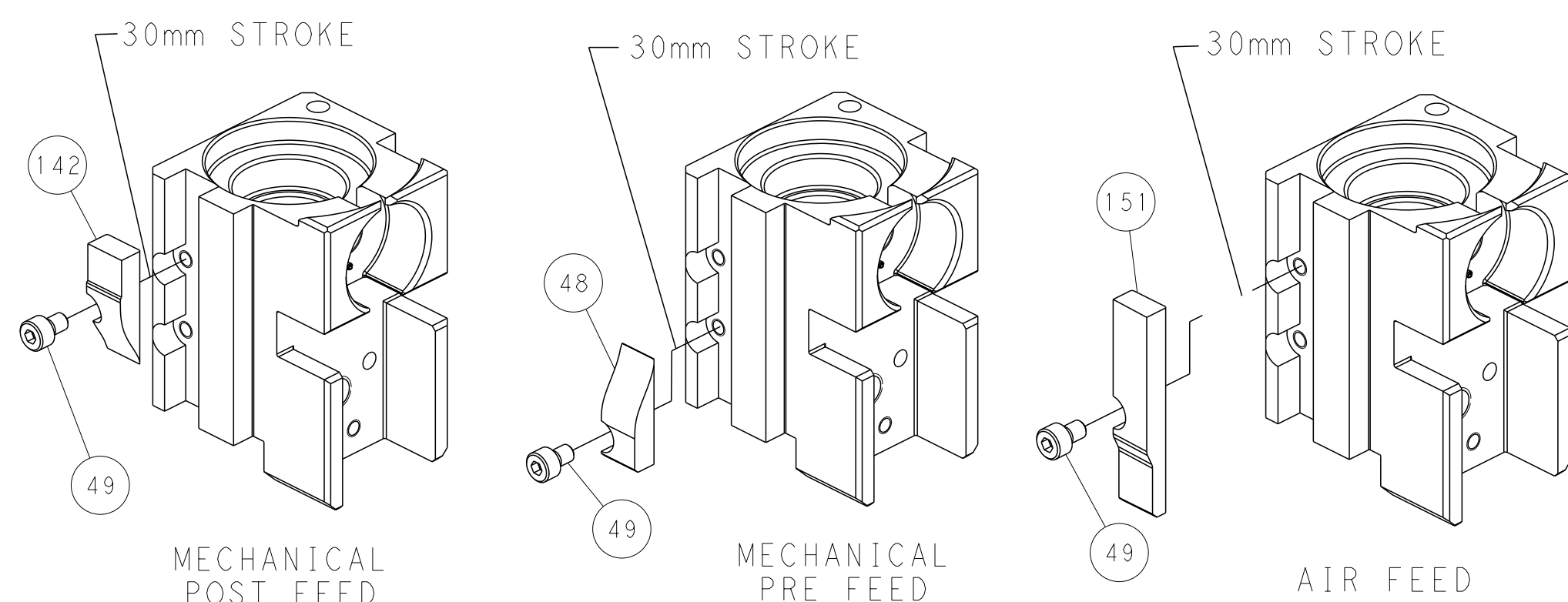
# PNEUMATIC



# 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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. MOYER 25APR2012		TE Connectivity	
mm	9 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.005	5 PLC ±0.005	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		CHK T. ELBIN 25APR2012		NAME	
				APVD T. ELBIN 25APR2012		Ocean Side Feed Applicator	
				PRODUCT SPEC		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
				APPLICATION SPEC		A 00779 C-2151622	
				WEIGHT		SCALE 1:1 SHEET 4 OF 4 REV A	
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING			