

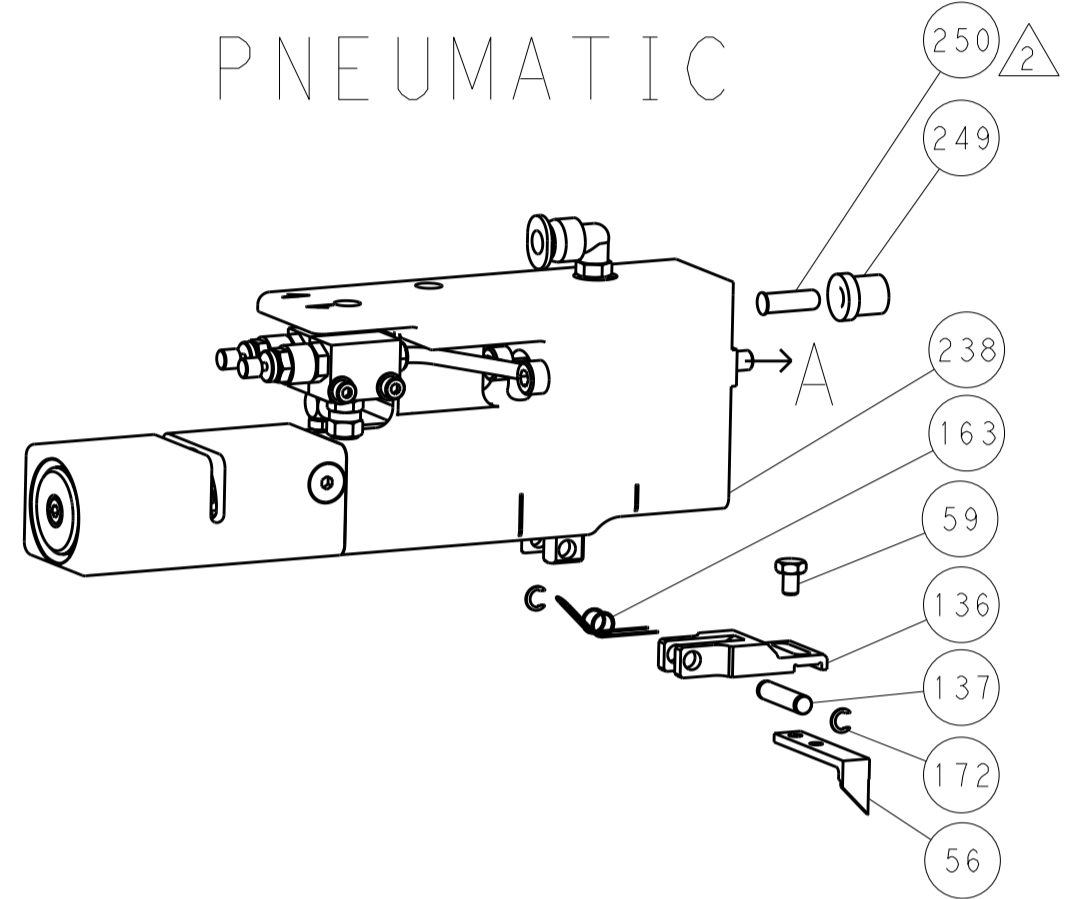


LOC		DIST		REVISIONS			
A	66	P	LTN	DESCRIPTION	DATE	DMN	APVD
		-		SEE SHEET 1			

### FEED TYPE MECHANICAL



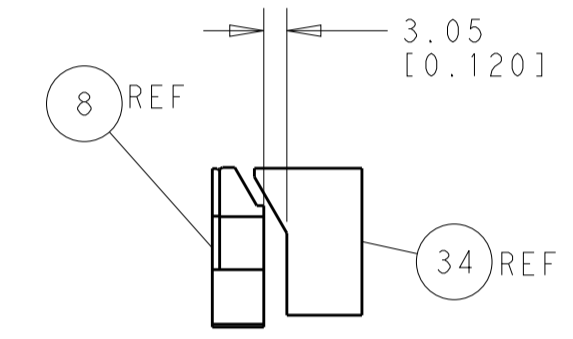
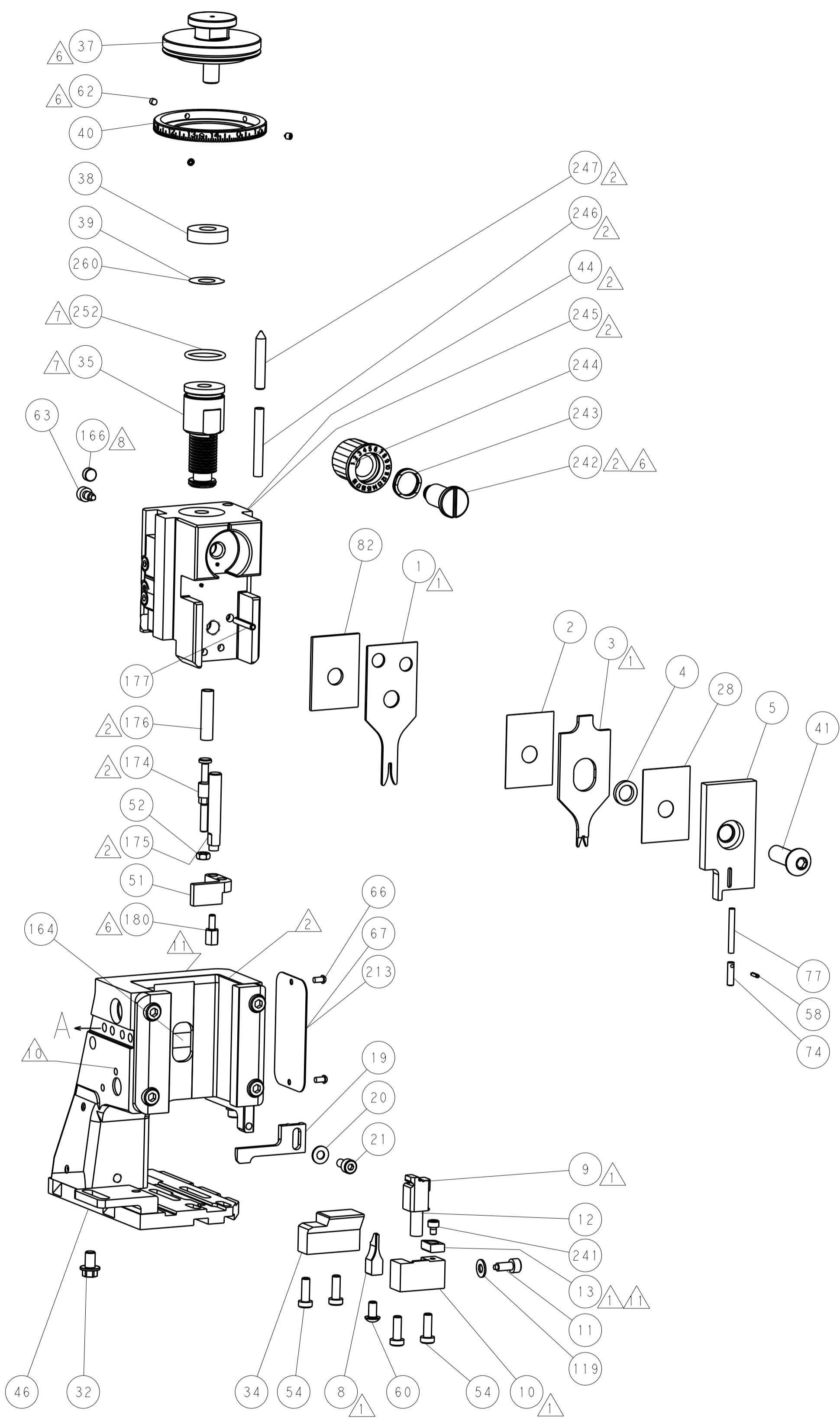
### PNEUMATIC



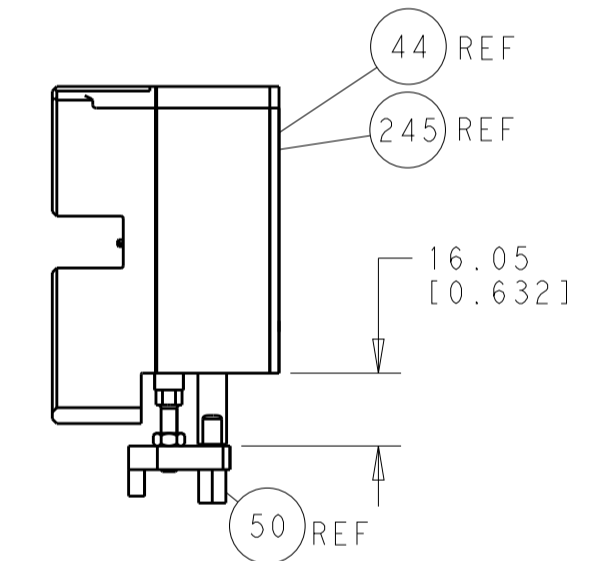
### SERVO LATCH PLATE



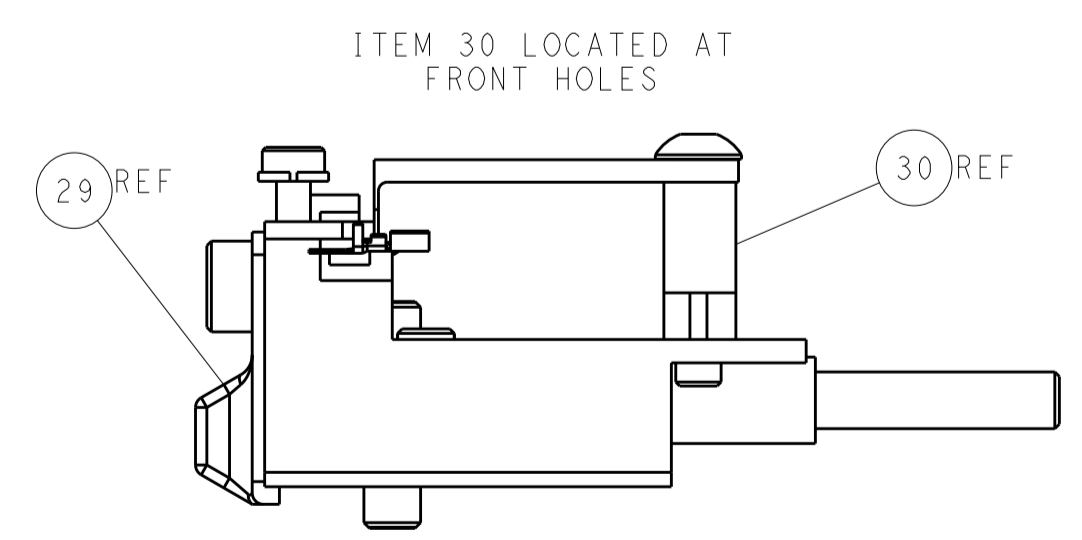
### CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: C. CHEN 19APR2013		TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	APVD: U. GUO 19APR2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME: Ocean Side Feed Applicator		RESTRICTED TO:	
Customer Accessible Production Drawing		SCALE: 1:1		SHEET 2 OF 4		REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2151925-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	-	8-2151925-5	1901094-3	1-1752354-4	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151925-4	-	-	-
	2-2151925-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151925-5	1901094-3	1-1752354-4	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151925-4	-	-	-
	2-2151925-5	A	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
	2-2151925-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151925-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP WIRE	SIZE	TYPE
	1.40 mm [.055]	F
INSUL	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS		
408-10389		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION	
TERMINAL NAME: TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.36-3.17 mm [ .093-.125 IN ]		$\varnothing$ 0.90-1.50 mm [ .035-.059 IN ]	
TERMINAL APPLICATION SPECIFICATION	JST SPEC		
TERMINALS APPLIED			
TE TERMINAL	JST TERMINAL	TE TERMINAL	JST TERMINAL
1832519-2	SPHD-002T-P0.5		

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	0.645+/-0.025 [ .025+/- .001 ]	8.9
26 AWG	0.625+/-0.025 [ .025+/- .001 ]	9.2
28 AWG	0.575+/-0.025 [ .023+/- .001 ]	9.7



- 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: 8-2151925-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151925-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151925-5
- 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, 180 & 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.

-	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
-77	-27	-25	-22	-21	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)

REVISEMENTS	DATE	BY	APPD
SEE SHEET 1	-	-	-

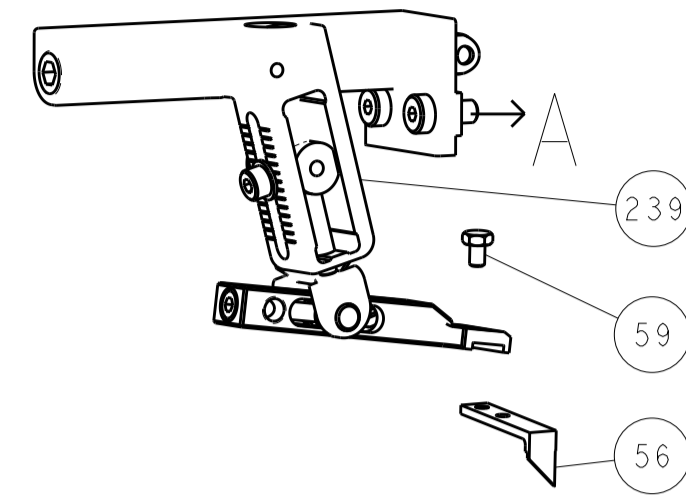
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-	1	1	2119083-1			242	
-	1	1	7-18023-7			241	
-	-	2	2168400-6			240	
-	-	-	2119580-1			239	
-	-	-	2063440-1			238	
-	-	1	2119740-2			213	
-	-	1	1901094-3			198	
-	1	1	1-1752354-4			180	
-	1	1	993111-1			177	
-	1	1	8-22280-7			176	
-	1	1	1752353-2			175	
-	1	1	1901680-2			174	
-	-	2	21045-3			172	
-	1	1	994969-1			166	
-	REF	REF	994970-2			164	
-	-	1	240638-1			163	
-	1	1	8-21084-1			152	
-	-	1	2119641-2			151	
-	1	1	2119798-2			145	
-	1	1	2079383-8			144	
-	4	4	2168400-5			143	
-	-	-	2119653-2			142	
-	1	1	1-2119656-0			141	
-	1	1	2119650-1			140	
-	1	1	2119092-2			139	
-	-	1	3-23627-7			137	
-	-	1	2119799-1			136	
-	REF	REF	SEE NOTE 4			135	
-	1	-	1633743-1			133	
-	1	1	1-18028-2			119	
-	REF	REF	2119944-1			117	
-	1	1	1-455888-5			82	
-	1	1	5-547505-2			77	
-	1	1	854769-4			74	
-	1	1	2119956-1			71	
-	1	-	2119740-1			67	
-	2	2	2168078-1			66	
-	1	1	2119793-1			63	
-	3	3	992763-5			62	
-	-	1	5-18022-5			59	
-	1	1	21028-2			58	
-	-	1	1338685-1			56	
-	1	1	1-5018030-0			52	
-	1	1	1-1901681-3			51	
-	-	1	18023-9			49	
-	-	-	2119652-1			48	
-	1	1	2079383-7			41	
-	1	1	2119645-1			40	
-	1	1	2119957-1			39	
-	1	1	2119644-1			38	
-	1	1	2-1752356-6			34	
-	2	2	2079383-5			33	
-	1	1	2161328-1			32	
-	1	1	1320908-6			30	
-	1	1	2119959-1			29	
-	1	1	455888-3			28	
-	1	1	1320928-2			24	
-	1	1	2168083-2			21	
-	1	1	1-18028-2			20	
-	1	1	2119533-1			19	
-	1	1	2119806-1			13	
-	1	1	3-22280-3			12	
-	1	1	1-356885-4			11	
-	1	1	2119805-1			10	
-	1	1	1633861-1			9	
1	1	1	4-1633927-3			8	
-	-	-	-			7	
-	-	-	-			6	
-	1	1	2119780-6			5	
-	1	1	238011-5			4	
1	1	1	1803017-3			3	
-	1	1	455888-1			2	
1	1	1	3-456402-4			1	
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
mm	0 PLC ± .1	1 PLC ±0.1	2 PLC ±0.2
	3 PLC ±0.05	4 PLC ±0.005	ANGLES ± .1
MATERIAL:		FINISH:	
Customer Accessible Production Drawing		SCALE	SHEET 3 OF 4 REV A

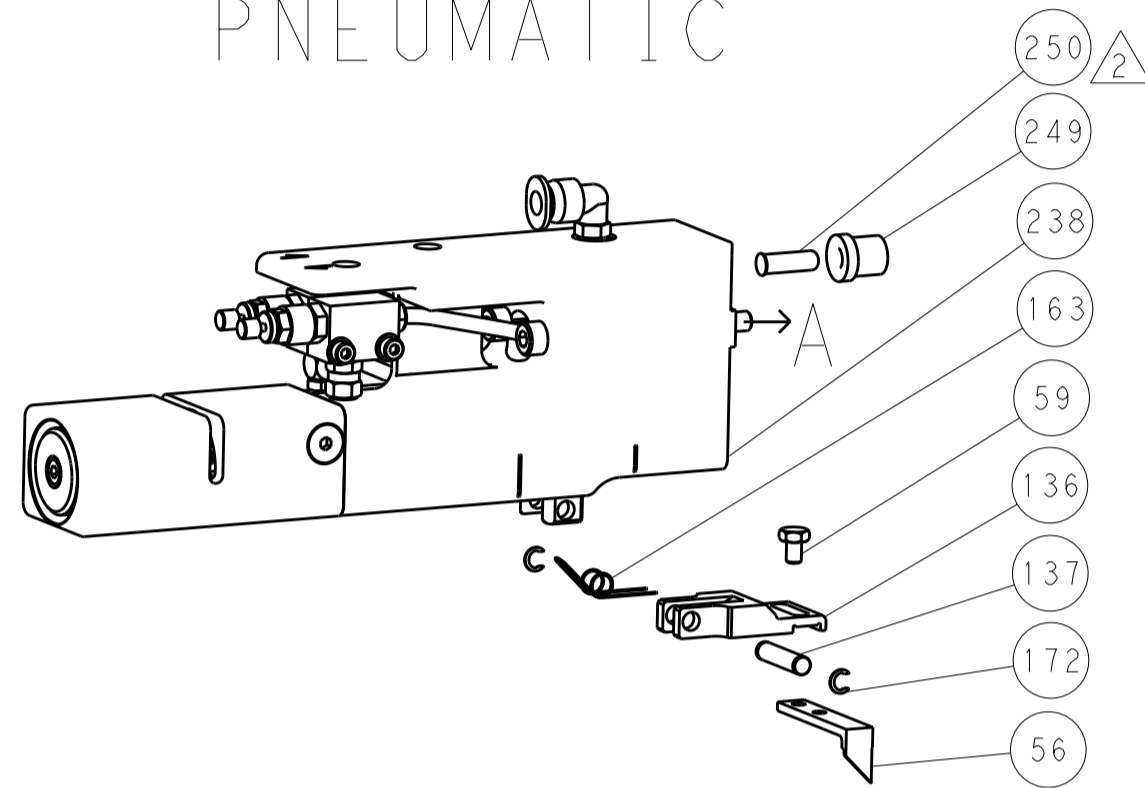
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1	-	-	-

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

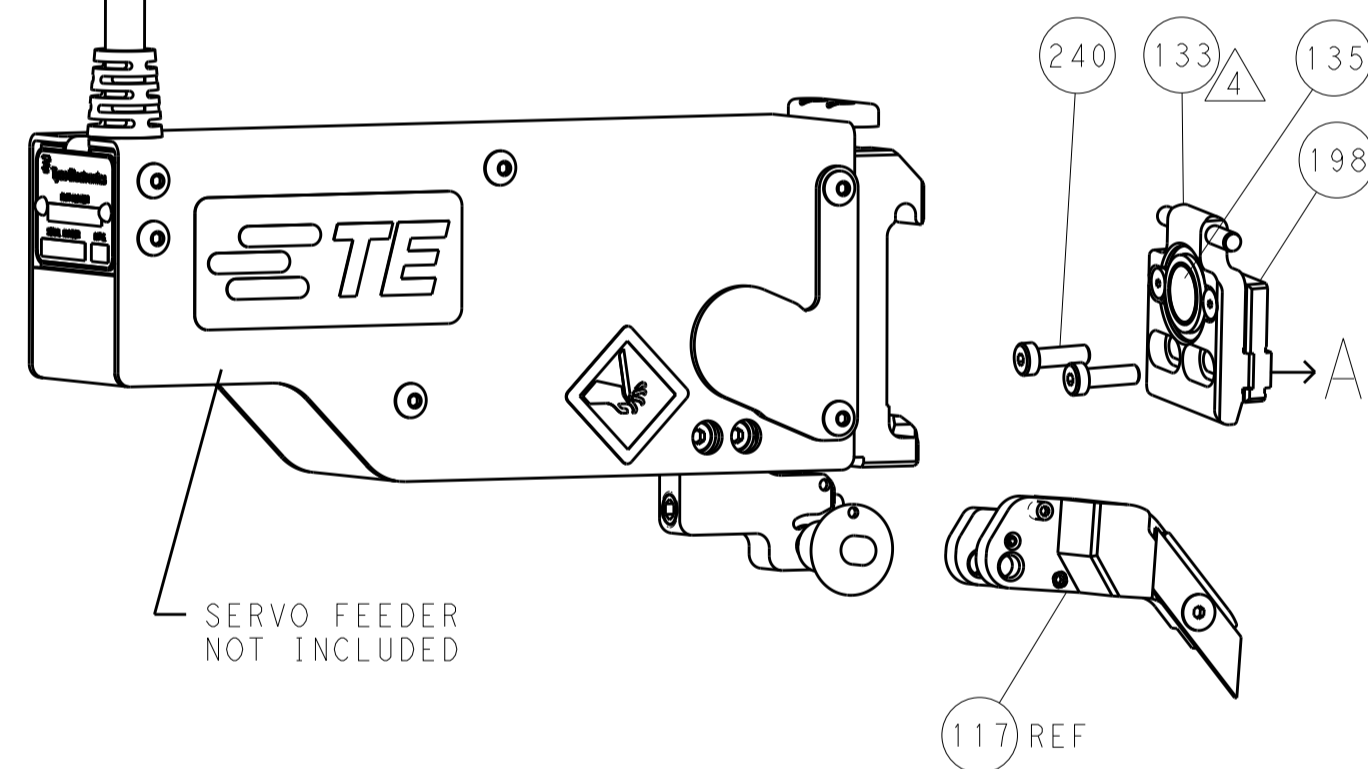
## FEED TYPE MECHANICAL



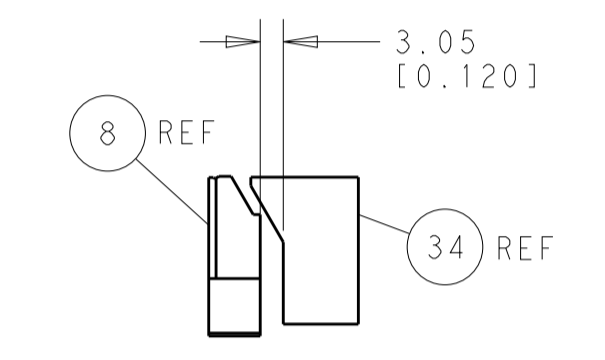
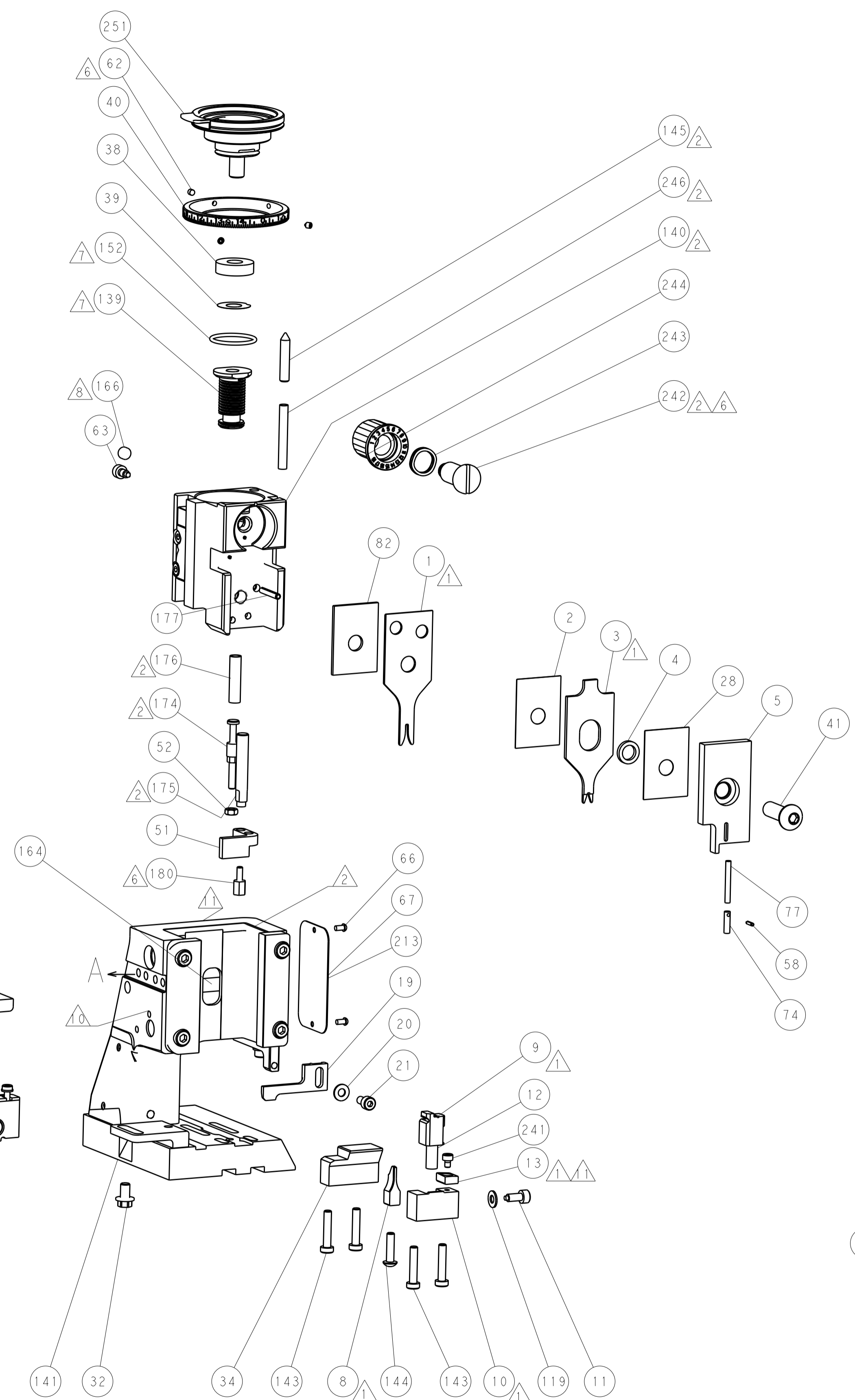
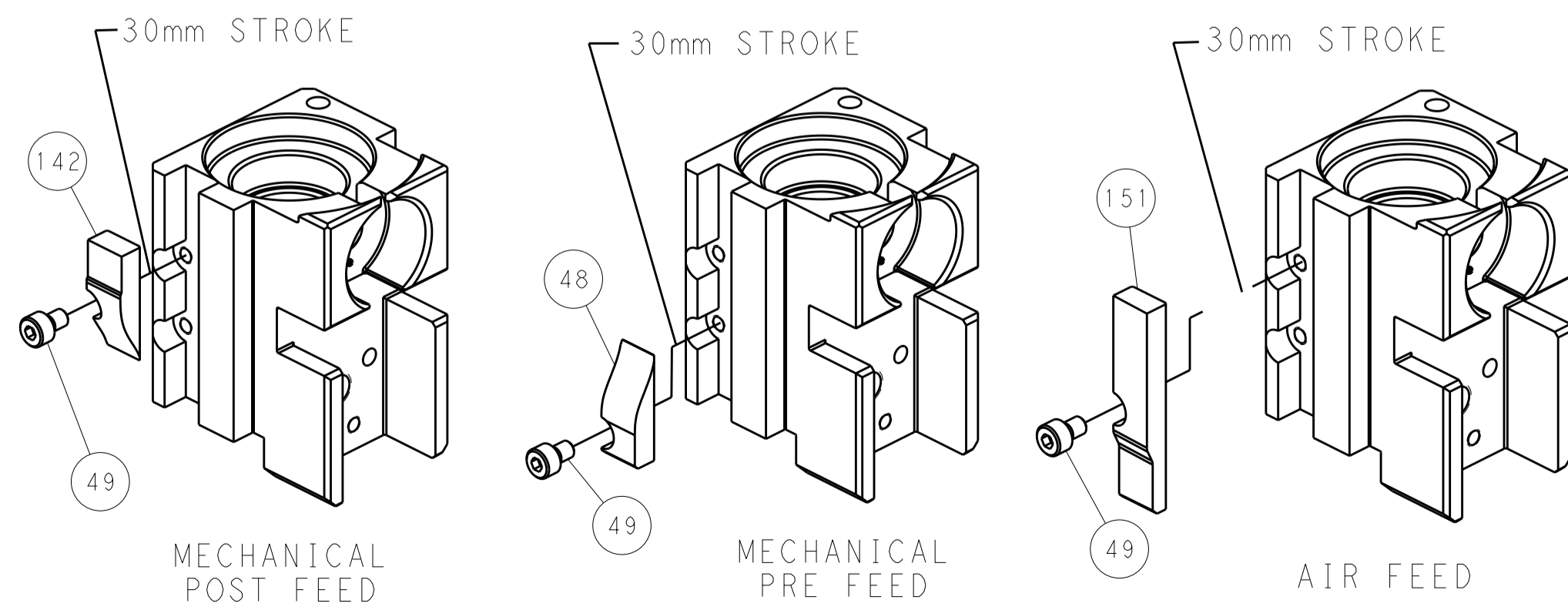
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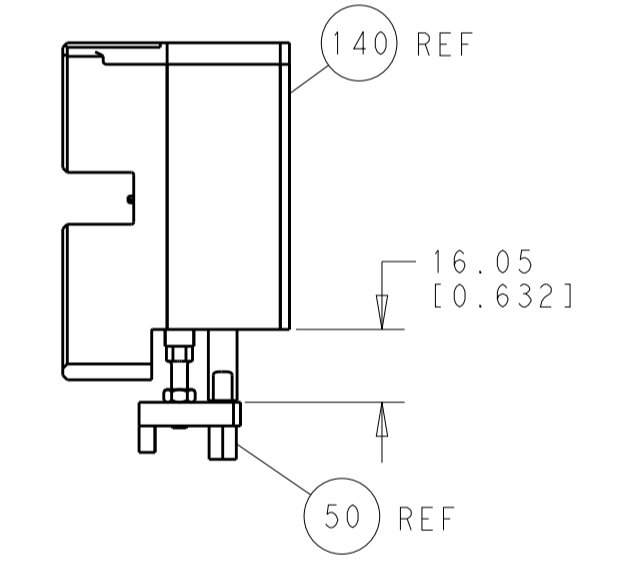
## SERVO LATCH PLATE



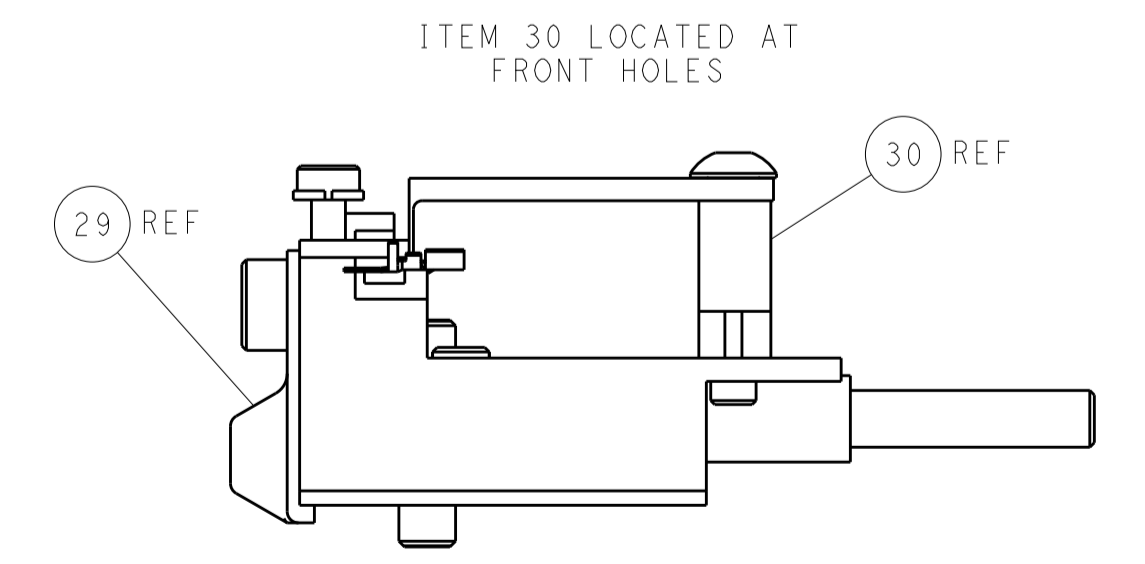
## CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THE INFORMATION CONTAINED HEREON IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT NOTICE TO THE USER. CONTACT THE ORGANIZATION FOR THE LATEST REVISION.</small>		DWN: C. CHEN 19APR2013 CHK: U. GUO 19APR2013 APVD: J. CRUZ 19APR2013	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±0.0005		NAME: Ocean Side Feed Applicator PRODUCT SPEC: APPLICATION SPEC: SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151925	RESTRICTED TO: SCALE: 1:1 SHEET: 4 OF: 4 REV: A
MATERIAL: FINISH:		WEIGHT: Customer Accessible Production Drawing	SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION