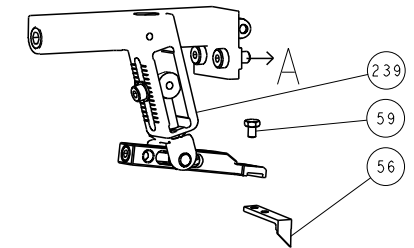


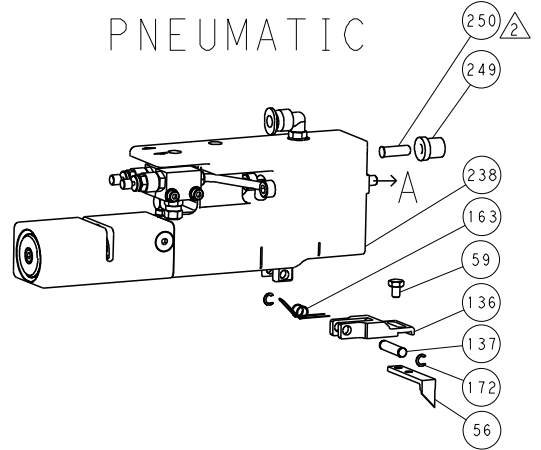


| REVISONS |     | DATE        | DWN | APVD |
|----------|-----|-------------|-----|------|
| #        | LYR | DESCRIPTION |     |      |
| -        | -   | SEE SHEET 1 | -   | -    |

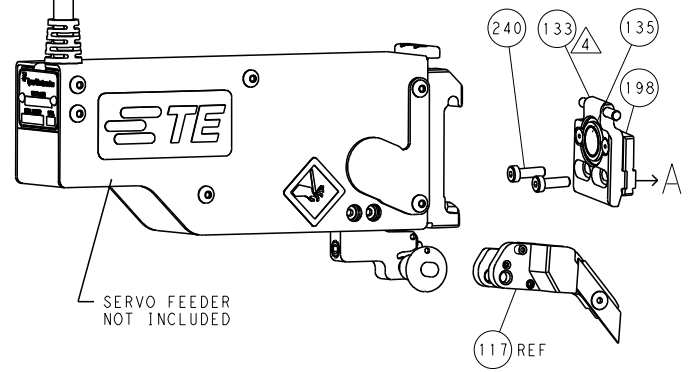
### FEED TYPE MECHANICAL



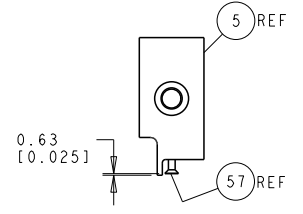
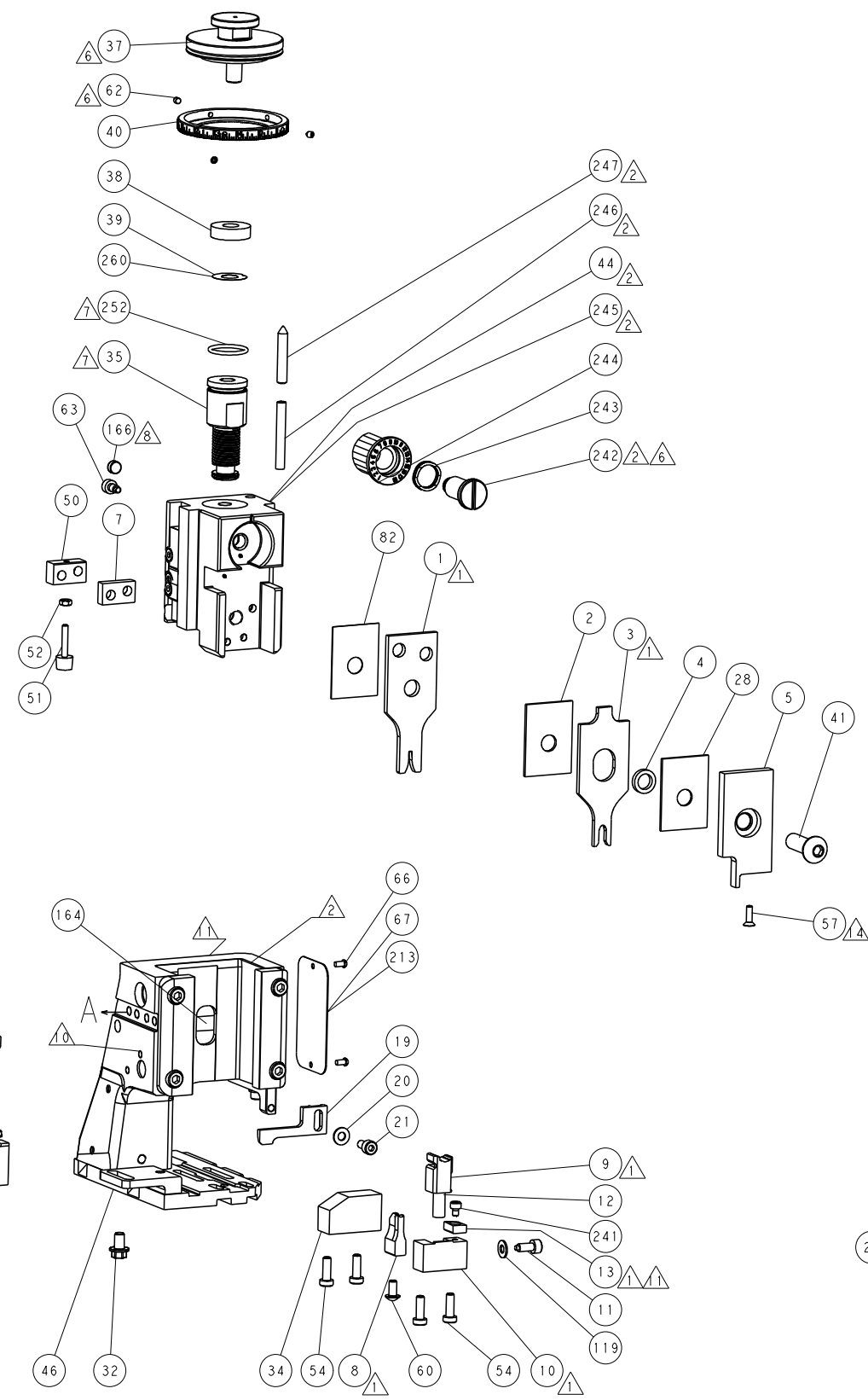
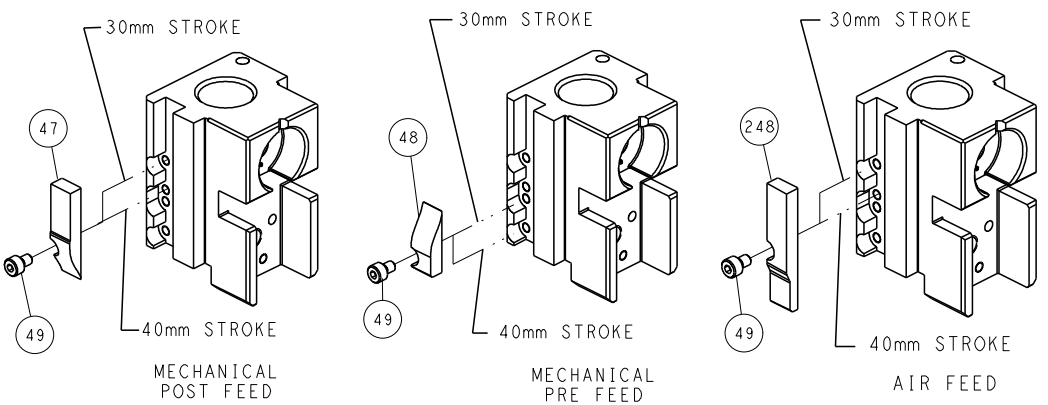
### PNEUMATIC



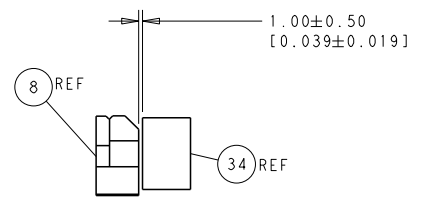
### SERVO LATCH PLATE



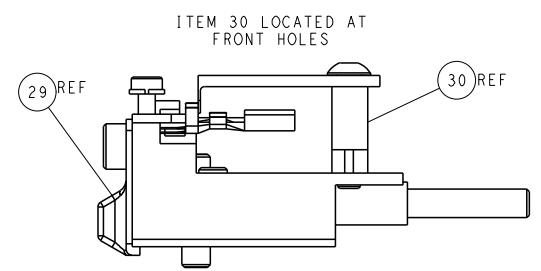
### CAM POSITIONS



SHEAR DEPRESSOR DETAIL



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)

|             |            |  |              |        |           |  |
|-------------|------------|--|--------------|--------|-----------|--|
| DIMENSIONS: |            | TOLERANCES UNLESS OTHERWISE SPECIFIED: |              | DWN    | 14MAR2013 | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| mm          | 0 PLC ±0.5 | 1 PLC ±0.13                            | 2 PLC ±0.013 | CHK    | 14MAR2013 |  |
| MATERIAL:   |            | FINISH:                                |              | APVD   | 14MAR2013 | NAME   |
|             |            |  |              |        |           | Ocean Side Feed Applicator                   |
|             |            |  |              | WEIGHT |           | SIZE   |
|             |            |  |              |        |           | CAGE CODE                                    |
|             |            |  |              |        |           | DRAWING NO                                   |
|             |            |  |              |        |           | RESTRICTED TO                                |
|             |            |  |              |        |           | SCALE  |
|             |            |  |              |        |           | 1:2  |
|             |            |  |              |        |           | SHEET  |
|             |            |  |              |        |           | 2 OF 4                                       |
|             |            |  |              |        |           | REV  |
|             |            |  |              |        |           | B  |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |             |                        |
|--|-------------|----------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
|  |             |          |                          |                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |             |                        |
|  | 2-2151519-1 | B        | 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             | -         | 8-2151519-5 | 1901094-3 | 2-1752354-0 | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151519-4 | -         | -           | -                      |
|  | 2-2151519-2 | B        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC         | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -           | -                      |
|  |             |          |                          |                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151519-5 | 1901094-3 | 2-1752354-0 | 2168400-6 (QUANTITY 2) |
|  |             |          |                          |                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151519-4 | -         | -           | -                      |
|  | 2-2151519-5 | B        | 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              |
|  | 2-2151519-7 | B        | FINE CRIMP HEIGHT ADJUST | NONE              | -                                 | -                     | -         | -           | -         | -           | -                      |
|  | 7-2151519-7 | A        | CRIMP TOOLING KIT        | -                 | -                                 | -                     | -         | -           | -         | -           | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 1.57 mm [.062] | F    |
| INSUL                                | 3.30 mm [1.30] | O    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

| TERMINAL DATA: TE TERMINAL                               |             | TE CRIMP SPECIFICATION      |                  |
|--|-------------|-----------------------------|------------------|
| TERMINAL NAME: HPF 1.5mm SENSORCONTACT ASSEMBLY AND BODY |             |                             |                  |
| WIRE STRIP LENGTH  |             | INSULATION DIAMETER RANGE   |                  |
| 4.20-4.60 mm [1.65-1.81 IN]                              |             | Ø2.60 mm MAX [Ø.102 IN MAX] |                  |
| TERMINAL APPLICATION SPECIFICATION                       | 114-18912   | -                           | -                |
| TERMINALS APPLIED  |             |                             |                  |
| TE TERMINAL  | TE TERMINAL | TE SEAL                     | TE SEAL          |
| 1563623-2  |             | 9-963530-1                  | 963530-1         |
|  |             | 9-964971-1                  | 964971-1         |
| 2208362-3  |             | 967067-1                    |                  |
|  |             |                             | INSULATION RANGE |
|  |             |                             | Ø1.4-1.9 mm      |
|  |             |                             | Ø1.2-1.6 mm      |
|  |             |                             | Ø1.4-2.1 mm      |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 0.50mm2   | 0.99+/-0.03 [.039+/-0.001] | 8.5                            |

- △ 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: 8-2151519-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151519-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151519-5
- 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 ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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.
- △ THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. INSULATION RANGE QUOTED IS THAT OF THE TERMINAL. THE SEAL INSULATION RANGE IS Ø1.40-1.90 [Ø.055-.075 IN.] FOR 963530 SERIES
- △ APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION. APPLY #1-23419-5 LOC-TITE TO THREADS.
- △ INS. RANGE Ø1.2-1.6 (Ø.047 -.063) FOR 964971 SERIES

**\*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.

| -77 | -27 | -25 | -22 | -21 | PART NO   | DESCRIPTION                         | ITEM NO |
|-----|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 1   | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251     |

**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   | #         | DATE        | BY | APPD |
|              |     |      | -         | SEE SHEET 1 | -  | -    |

|   |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | -   | -   | 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   | 2119082-7   | 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 |
| - | -   | -   | 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 |
| - | 4   | 4   | 4   | 4   | 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                          | 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   | 455888-4    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| - | 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   | 1   | 1   | 985575-3    | SCR, FLT SKT HD CAP M3 X 10.0       | 57  |
| - | -   | -   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 2   | 2   | 2   | 2   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 53  |
| - | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52  |
| - | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51  |
| - | 1   | 1   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 50  |
| - | -   | -   | 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  |
| - | 1   | 1   | 1   | 1   | 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   | 1-1320908-2 | 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   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
| - | 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   | 318707-1    | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1   | 1   | 1333332-2   | ANVIL, COMBINATION, SPECIAL         | 8   |
| - | 1   | 1   | 1   | 1   | 2-240641-9  | SPACER                              | 7   |
| - | -   | -   | -   | -   | -           | -                                   | 6   |
| - | 1   | 1   | 1   | 1   | 2119781-1   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 238011-4    | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 1   | 1   | 2-1633996-7 | CRIMPER, INSULATION SPECIAL         | 3   |
| - | 1   | 1   | 1   | 1   | 1-455888-3  | SPACER, CRIMPER                     | 2   |
| - | 1   | 1   | 1   | 1   | 1-456403-5  | CRIMPER, WIRE PREMIUM               | 1   |

|             |  |  |  |                         |  |   |  |
|-------------|--|--|--|-------------------------|--|---|--|
| DIMENSIONS: |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |  | DWG Y. YIN 14MAR2013    |  | TE Connectivity   |  |
| mm          |  | 0 PLC ±.5                              |  | CHK G. BAILEY 14MAR2013 |  | Harrisburg, PA 17105-3608   |  |
|             |  | 1 PLC ±.13                             |  | APPD U. GUO 14MAR2013   |  | NAME Ocean Side Feed Applicator                                     |  |
|             |  | 2 PLC ±.013                            |  | PRODUCT SPEC            |  | SIZE CAGE CODE DRAWING NO   |  |
|             |  | 3 PLC ±.013                            |  | APPLICATION SPEC        |  | A1 00779 ©=2151519  |  |
|             |  | 4 PLC ±.0001                           |  | WEIGHT                  |  | RESTRICTED TO   |  |
|             |  | ANGLES                                 |  | MATERIAL                |  | Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV B |  |

