



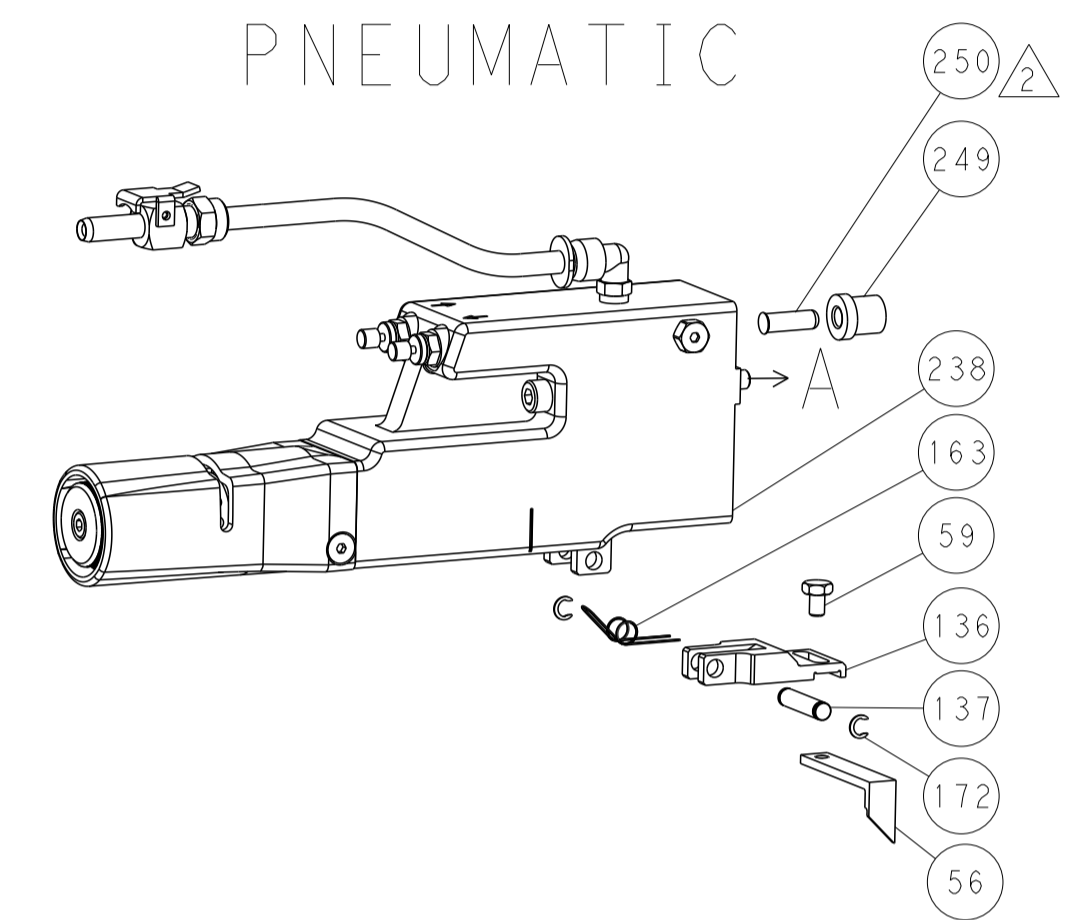
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| A   | 66   |     |      |    |      |

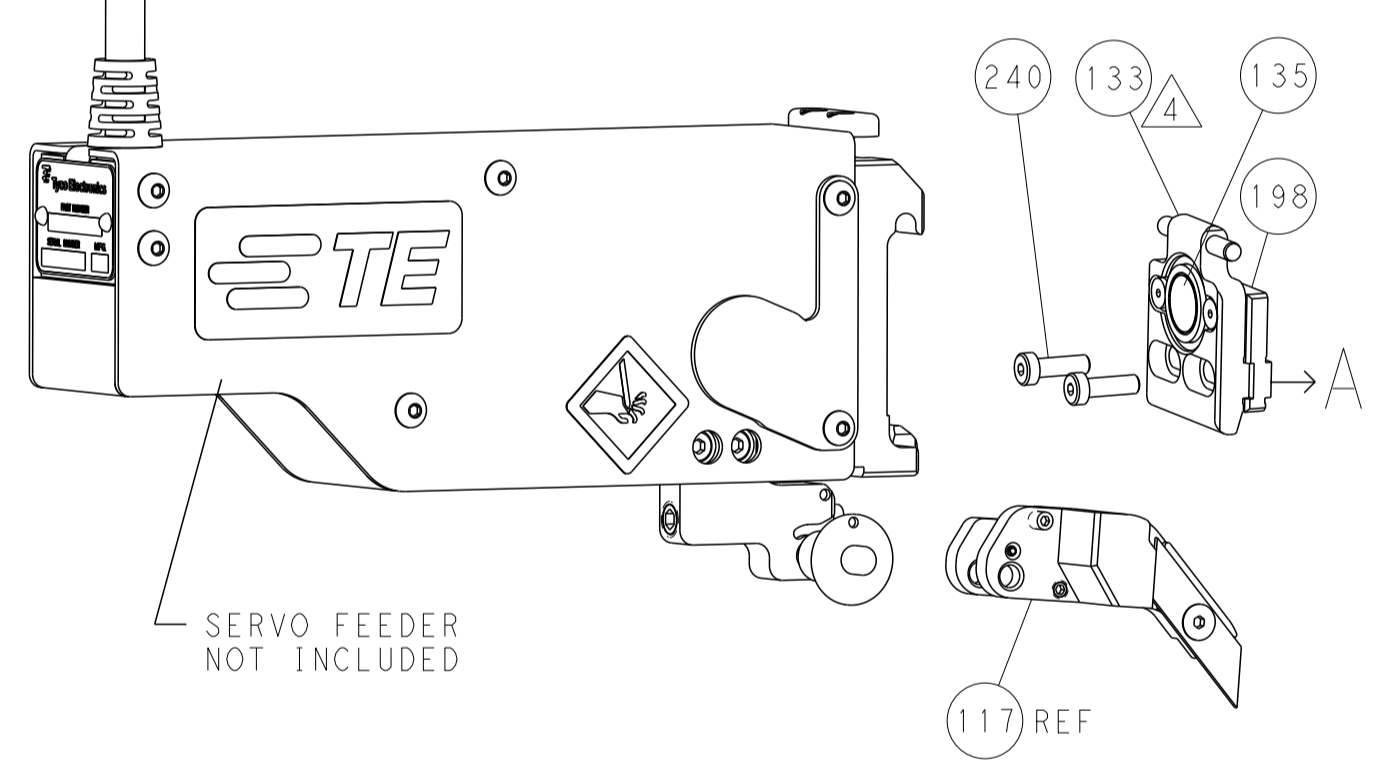
| REVISIONS |      |    |             |
|-----------|------|----|-------------|
| REV       | DATE | BY | DESCRIPTION |
| -         | -    | -  | SEE SHEET 1 |

### FEED TYPE

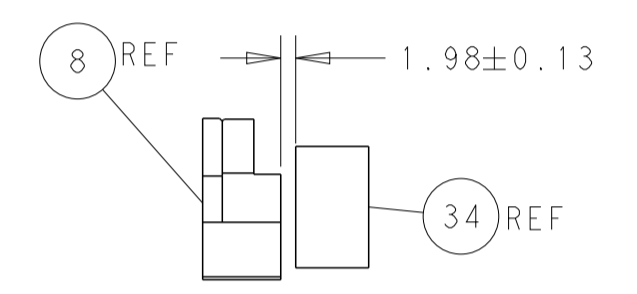
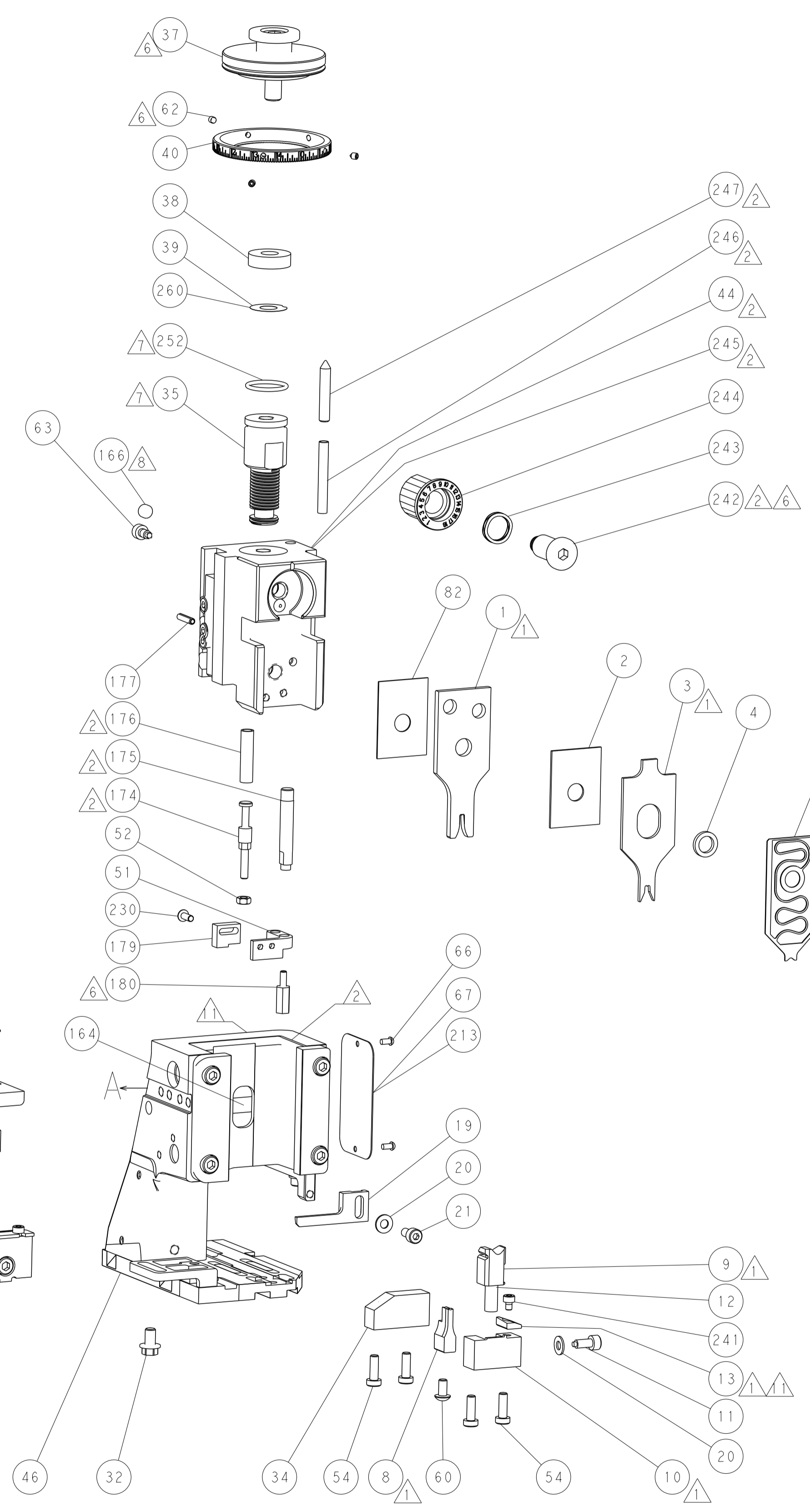
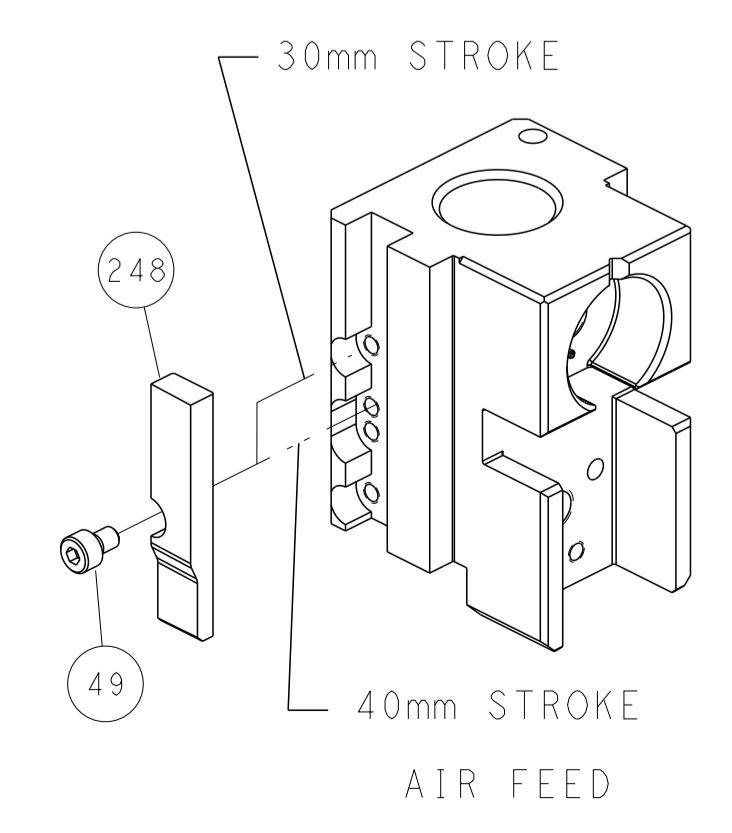
### PNEUMATIC



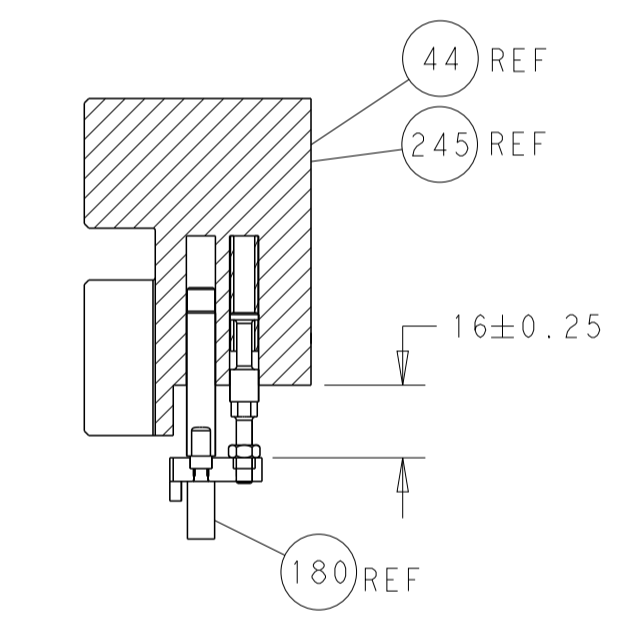
### SERVO LATCH PLATE



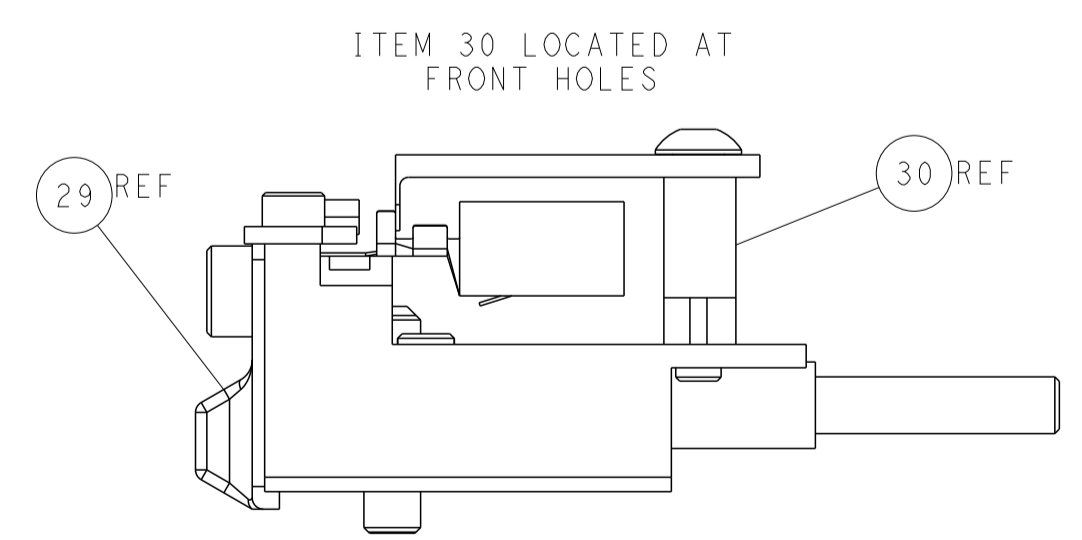
### CAM POSITION



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)

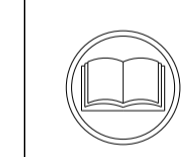
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| DIMENSIONS:<br>mm<br> |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH |  | DWN T. BROOKENS 03JUL2018<br>CHK M. HERR 03JUL2018<br>APVD C. TOPPER 03JUL2018<br>PRODUCT SPEC<br>APPLICATION SPEC<br>WEIGHT<br>SCALE 1:2 SHEET 2 OF 4 REV A |  | NAME Ocean Side Feed Applicator<br>SIZE CAGE CODE DRAWING NO. A1 00779 C=2837331<br>RESTRICTED TO |  |
| MATERIAL:             |  |   |  | CUSTOMER ACCESSIBLE PRODUCTION DRAWING   |  |   |  |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION                 | DESCRIPTION              | FEED TYPE                      | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |             |                        |
|--|-------------|--------------------------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
|  |             |                          |                          |                                | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |             |                        |
|  | 2-2837331-2 | A                        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                      | -                                 | -                     | -         | -           | -         | -           | -                      |
|  |             |                          |                          |                                | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2837331-5 | 1901094-3 | 3-1752354-5 | 2168400-6 (QUANTITY 2) |
|  | 2-2837331-5 | A                        | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE <sup>4</sup> | -                                 | -                     | -         | -           | -         | -           | -                      |
|  |             |                          |                          |                                | PNEUMATIC FEED                    | 2119950-1             | 1338683-8 | 5-18022-5   | 2119641-2 | 2119799-1   | 2063440-1              |
| 2-2837331-7                                  | A           | FINE CRIMP HEIGHT ADJUST | NONE                     | -                              | -                                 | -                     | -         | -           | -         | -           |                        |
| 7-2837331-7                                  | A           | CRIMP TOOLING KIT        | -                        | -                              | -                                 | -                     | -         | -           | -         | -           |                        |

| APPLICATOR DATA                   |                  |      |
|-----------------------------------|------------------|------|
| CRIMP                             | SIZE             | TYPE |
| WIRE                              | 2.16 mm [ .085 ] | F    |
| INSUL                             | 2.79 mm [ .110 ] | F    |
| APPLICATOR INSTRUCTIONS 408-10389 |                  |      |

|   |                                    |
|---|------------------------------------|
| TERMINAL DATA: SUMIKO TERMINAL SUMIKO CRIMP SPECIFICATION |                                    |
| TERMINAL NAME: CONTACT TERMINAL                           |                                    |
| WIRE STRIP LENGTH   | TERMINAL INSULATION DIAMETER RANGE |
| 5.00-5.50 mm [ .197-.217 IN ]                             | Ø2.10-2.50 mm [ .083-.098 IN ]     |
| TERMINAL APPLICATION SPECIFICATION                        | CJCKT0011 Rev 10/31/2014 -         |
| TERMINALS APPLIED <sup>1</sup> <sup>2</sup> <sup>3</sup>  |                                    |
| TE TERMINAL   | SUMIKO TERMINAL                    |
| 3311254-1   | XKTOC6-0140                        |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]          | CRIMP HEIGHT REFERENCE SETTING |
|-----------|---------------------------------|--------------------------------|
| 0.50mm2   | 1.25 +/- 0.05 [ .049 +/- .002 ] | 5.1                            |



- <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: 8-2837331-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2837331-5
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 ITEMS 62 & 180.  
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> 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.
12. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT 101-35000.
- <sup>13</sup> TERMINAL LUBRICANT IS RECOMMENDED.

**\*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 | PART NO   | DESCRIPTION                         | ITEM NO |
|-----|-----|-----|-----|-----------|-------------------------------------|---------|
| -   | 1   | 1   | 1   | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251     |
| -   | -   | -   | 1   | 2119640-1 | PUSH ROD, AIR FEED                  | 250     |

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

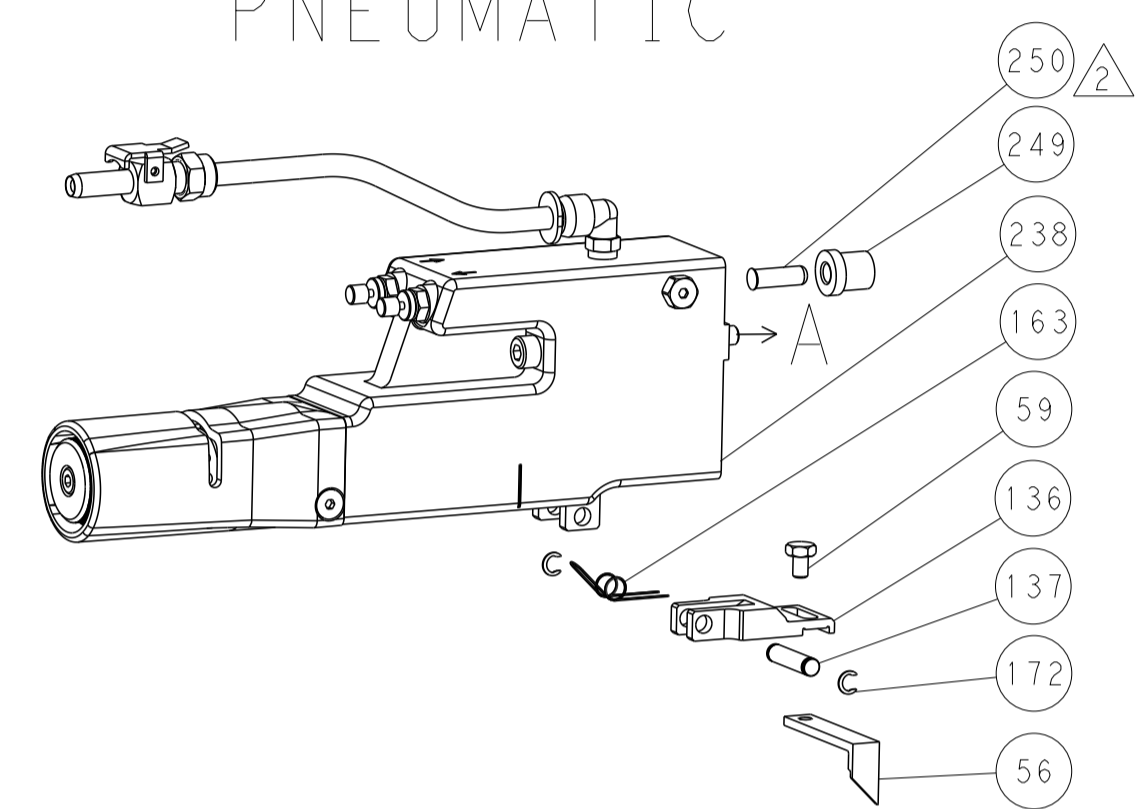
|                           |          |            |           |      |    |      |
|---------------------------|----------|------------|-----------|------|----|------|
| SET UP GAUGE<br>2119599-1 | LOC<br>A | DIST<br>66 | REVISIONS |      |    |      |
|                           |          |            | REV       | DATE | BY | APPD |
|                           |          |            | 1         |      |    |      |
|                           |          |            | 2         |      |    |      |
|                           |          |            | 3         |      |    |      |

| REV | DATE | BY  | APPD | DESCRIPTION                                   | ITEM NO |
|-----|------|-----|------|---|---------|
| -   | -    | -   | 1    | 1803259-1 BUSHING, FLANGED                    | 249     |
| -   | 1    | 1   | 1    | 1-22279-3 SPRING, COMPRESSION                 | 246     |
| -   | 1    | 1   | 1    | 2119082-7 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     |
| -   | 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    | 2063440-1 AIR FEED MODULE                     | 238     |
| -   | 1    | 1   | 1    | 2079383-1 SCR, BHSC, RoHS (M3 X 8)            | 230     |
| -   | -    | 1   | -    | 2119740-2 TAG IDENTIFICATION                  | 213     |
| -   | -    | 1   | -    | 1901094-3 SPACER, FEEDER                      | 198     |
| -   | 1    | 1   | 1    | 3-1752354-5 STANDOFF, HOLD-DOWN               | 180     |
| -   | 1    | 1   | 1    | 4-1976053-5 LOCATER BLOCK, TERMINAL           | 179     |
| -   | 1    | 1   | 1    | 6-993111-6 PIN, SLOTTED SPRING 3.0 X 14.0     | 177     |
| -   | 1    | 1   | 1    | 8-22280-7 SPRING, COMPRESSION                 | 176     |
| -   | 1    | 1   | 1    | 1752353-2 GUIDE PIN, HOLDDOWN                 | 175     |
| -   | 1    | 1   | 1    | 1901680-2 GUIDE PIN, HOLDDOWN                 | 174     |
| -   | -    | -   | 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     |
| -   | 4    | 4   | 4    | 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     |
| -   | -    | REF | -    | 2119944-1 FEED FINGER ASSEMBLY, SF            | 117     |
| -   | 1    | 1   | 1    | 2119955-1 ASSY, LUBRICATOR, SIDE FEED         | 113     |
| -   | 1    | 1   | 1    | 455888-5 SPACER, CRIMPER                      | 82      |
| -   | 1    | 1   | 1    | 2119956-1 DOCUMENTATION PACKAGE               | 71      |
| -   | 1    | 1   | 1    | 2119791-5 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 PNT, M3 x 4.0    | 62      |
| -   | -    | -   | 1    | 5-18022-5 SCR, HEX HD CAP, M4 X 6.0           | 59      |
| -   | -    | -   | 1    | 1338683-8 FEED PAWL                           | 56      |
| -   | 1    | 1   | 1    | 1-5018030-0 NUT, HEX, REG, RoHS, M3.5         | 52      |
| -   | 1    | 1   | 1    | 2-1901681-3 HOLDDOWN, TERMINAL                | 51      |
| -   | -    | -   | 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    | 1-1752356-0 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    | 1-1320908-0 SPACER, STRIP GUIDE               | 30      |
| -   | 1    | 1   | 1    | 2119959-1 ASSEMBLY, 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      |
| -   | 2    | 2   | 2    | 1-18028-2 WASHER, FLAT, REG M4                | 20      |
| -   | 1    | 1   | 1    | 2119533-2 STRIPPER, SIDE FEED                 | 19      |
| -   | 1    | 1   | 1    | 2119806-1 INSERT, SHEAR                       | 13      |
| -   | 1    | 1   | 1    | 3-22280-3 SPRING, COMPRESSION                 | 12      |
| -   | 1    | 1   | 1    | 1-356885-4 STOP, SHEAR                        | 11      |
| -   | 1    | 1   | 1    | 2119805-1 SHEAR HOLDER, FRONT                 | 10      |
| -   | 1    | 1   | 1    | 1803095-3 FLOATING SHEAR, FRONT               | 9       |
| -   | 1    | 1   | 1    | 2-1803608-0 ANVIL, COMBINATION                | 8       |
| -   | -    | -   | -    | -   | 7       |
| -   | -    | -   | -    | -   | 6       |
| -   | 1    | 1   | 1    | 2119757-4 DEPRESSOR, SHEAR                    | 5       |
| -   | 1    | 1   | 1    | 238011-7 BLOCK, CRIMPER SPACER                | 4       |
| -   | 1    | 1   | 1    | 1-1633962-3 CRIMPER, INSULATION F PREMIUM     | 3       |
| -   | 1    | 1   | 1    | 455888-9 SPACER, CRIMPER                      | 2       |
| -   | 1    | 1   | 1    | 2-1803556-6 CRIMPER, WIRE F                   | 1       |

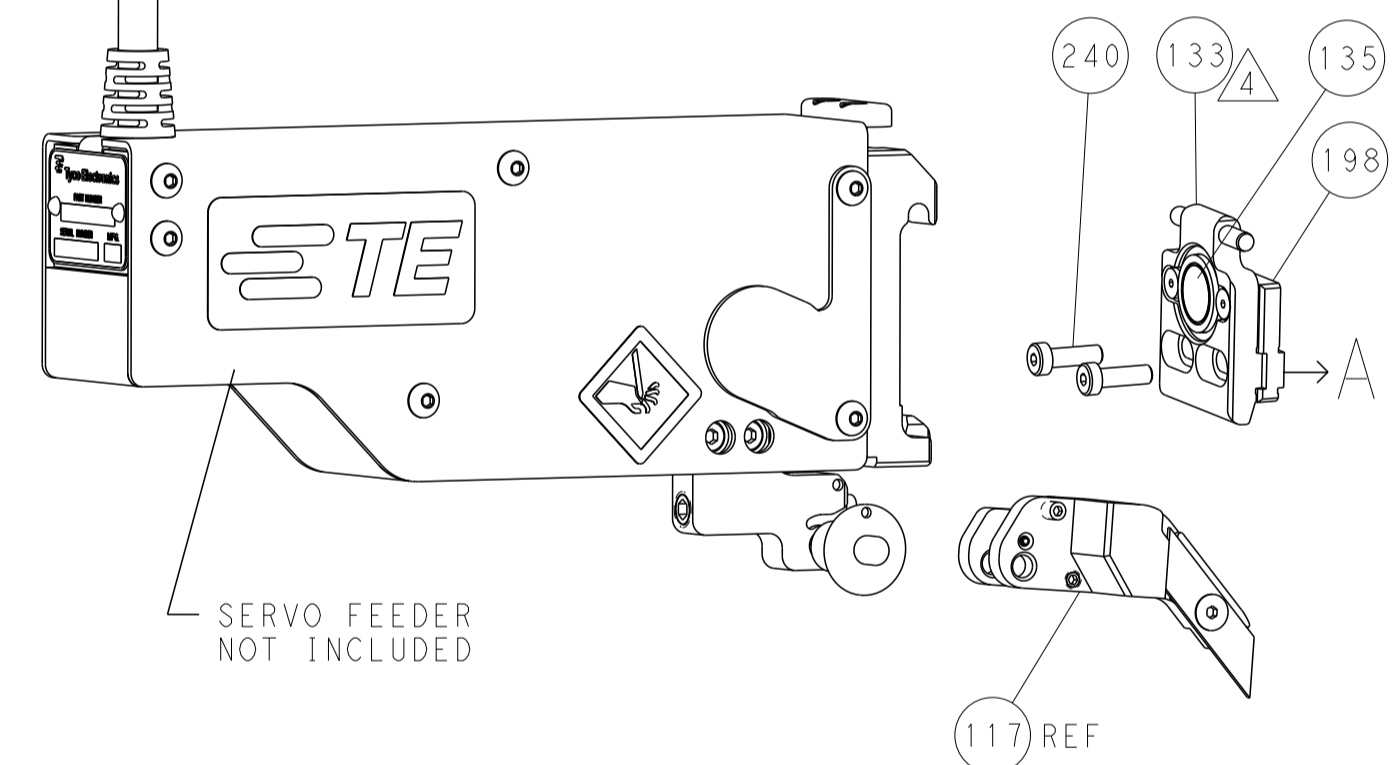
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| DIMENSIONS: mm                         |   | TOLERANCES UNLESS OTHERWISE SPECIFIED: |   | DRAWN: T. BROOKENS 03JUL2018 | TE Connectivity<br>Harrisburg, PA 17105-3608 |                  |
| 0 PLC                                  | ± | 1 PLC                                  | ± | CHK: M. HERR 03JUL2018       | NAME: Ocean Side Feed Applicator             |                  |
| 2 PLC                                  | ± | 3 PLC                                  | ± | APVD: C. TOPPER 03JUL2018    |  |                  |
| 4 PLC                                  | ± | ANGLES                                 | ± | PRODUCT SPEC                 |  |                  |
| FINISH                                 | ± | APPLICATION SPEC                       |   | SIZE: A1                     |  |                  |
| MATERIAL                               |   | FINISH                                 |   | WEIGHT                       | SCALE: 1:2                                   | RESTRICTED TO: A |
| Customer Accessible Production Drawing |   |  |   | SHEET 3 OF 4                 | REV A  |                  |

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

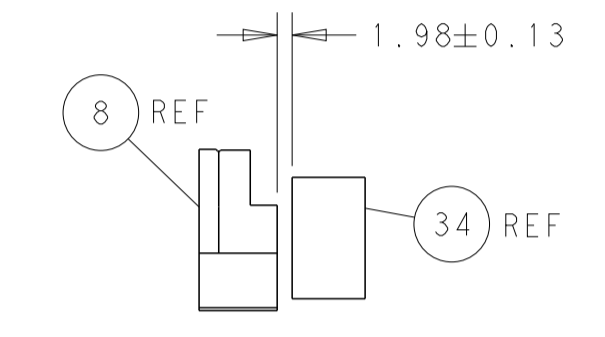
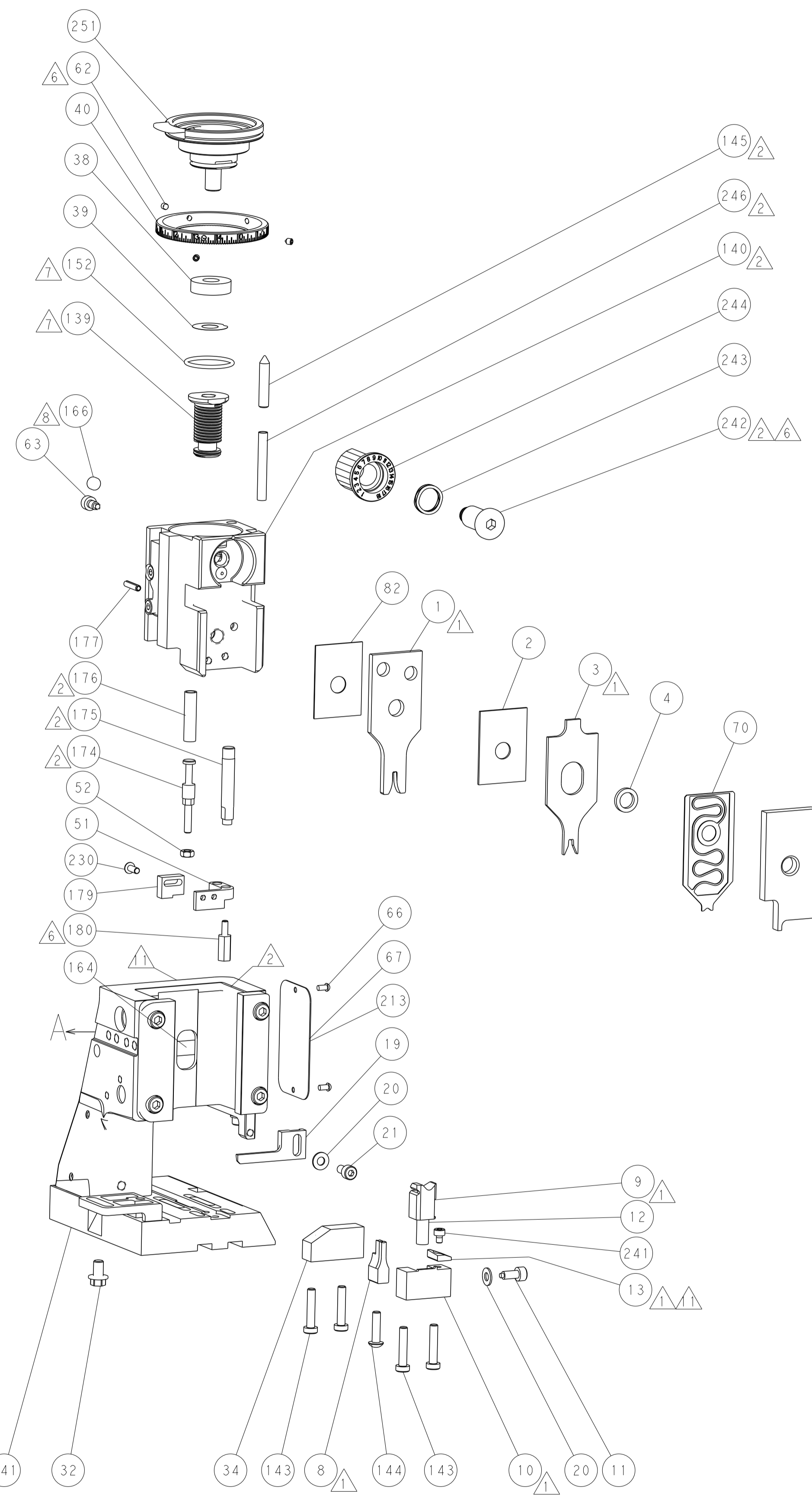
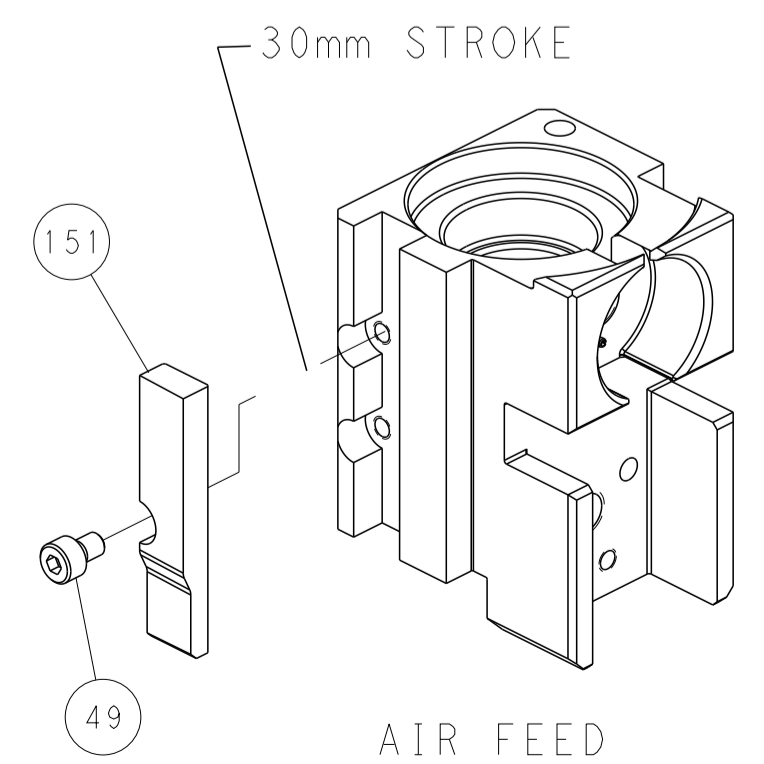
### FEED TYPE PNEUMATIC



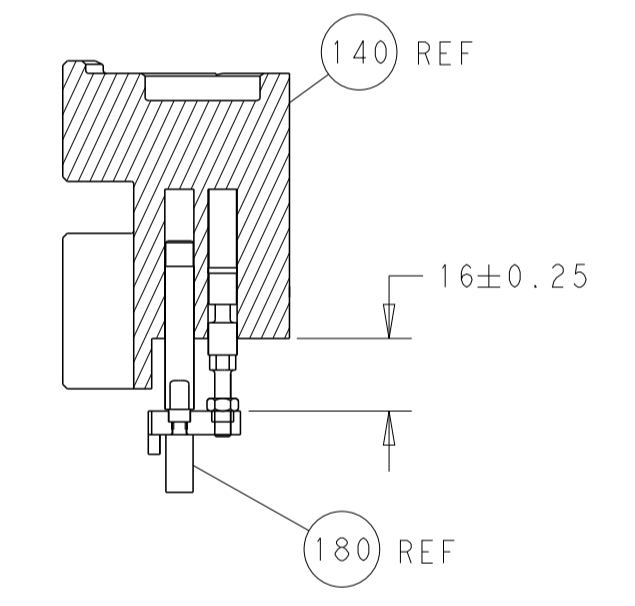
### SERVO LATCH PLATE



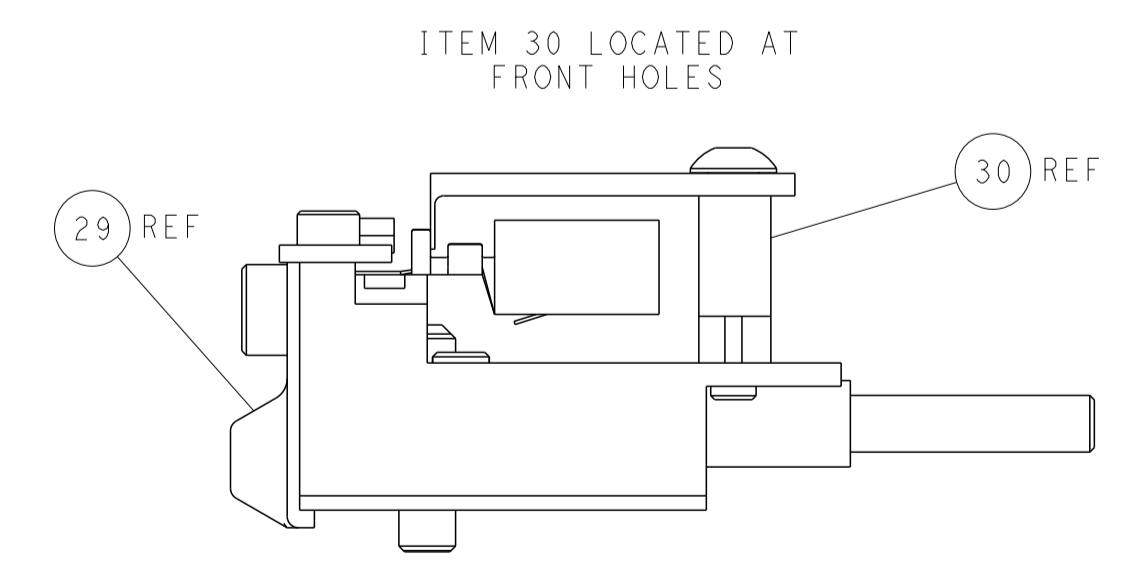
### CAM POSITION



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>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION. ALL RIGHTS RESERVED. © 2018 BY TYCO ELECTRONICS CORPORATION.</small> |   | DWN T. BROOKENS 03JUL2018<br>CHK M. HERR 03JUL2018<br>APVD C. TOPPER 03JUL2018 | NAME<br>Ocean Side Feed<br>Applicator                   |
| DIMENSIONS:<br>mm<br>  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH | WEIGHT<br>SCALE 1:2<br>SHEET 4 OF 4<br>REV A                                   | RESTRICTED TO<br>CUSTOMER ACCESSIBLE PRODUCTION DRAWING |
| MATERIAL:  |   | SIZE CAGE CODE DRAWING NO<br>A1 00779 C=2837331                                | SCALE 1:2 SHEET 4 OF 4 REV A                            |