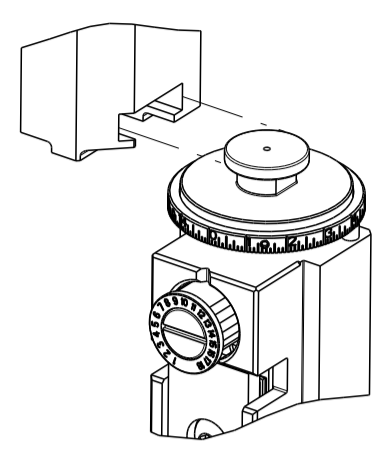


Table with 5 columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, and CONVERT TO. Rows include part numbers 2151058-1 through 7-2151058-7 with various descriptions like 'FINE CRIMP HEIGHT ADJUST' and 'NON-CRIMP HEIGHT ADJUST'.



APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Includes wire (2.03 mm) and insul (2.54 mm) specifications.

Terminal data and specifications table including terminal name (MICRO TIMER 2 CONTACT), wire strip length, insulation diameter range, and terminal application specifications.

Wire size and crimp height reference setting table with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

- 11 RECOMMENDED SPARE PARTS
12 GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
14 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY...

SET UP GAUGE table with columns: LOC, DIST, REVISIONS. Includes revision history with descriptions and dates.

Large parts list table with 13 columns including item numbers, quantities, and descriptions. Items range from 8-21084-0 to 1803125-2.

*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.

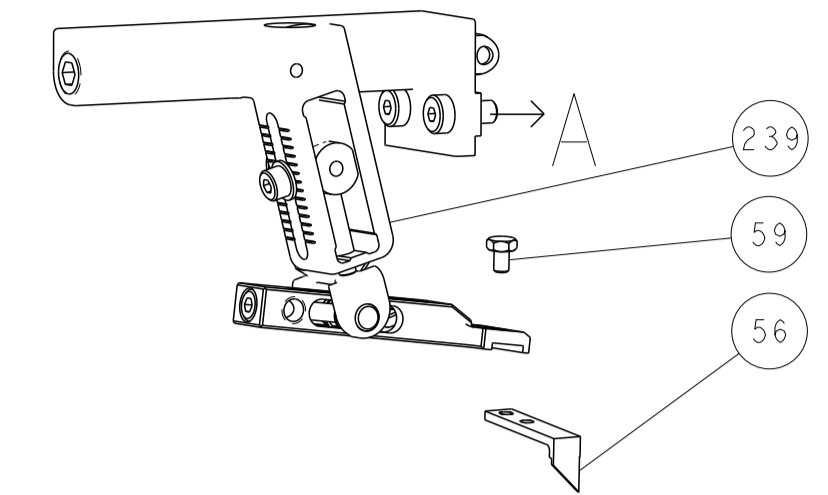
Table with 13 columns: PART NO, DESCRIPTION, ITEM NO. Includes part 2119957-2 APPLICATOR SHIM PACK.

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

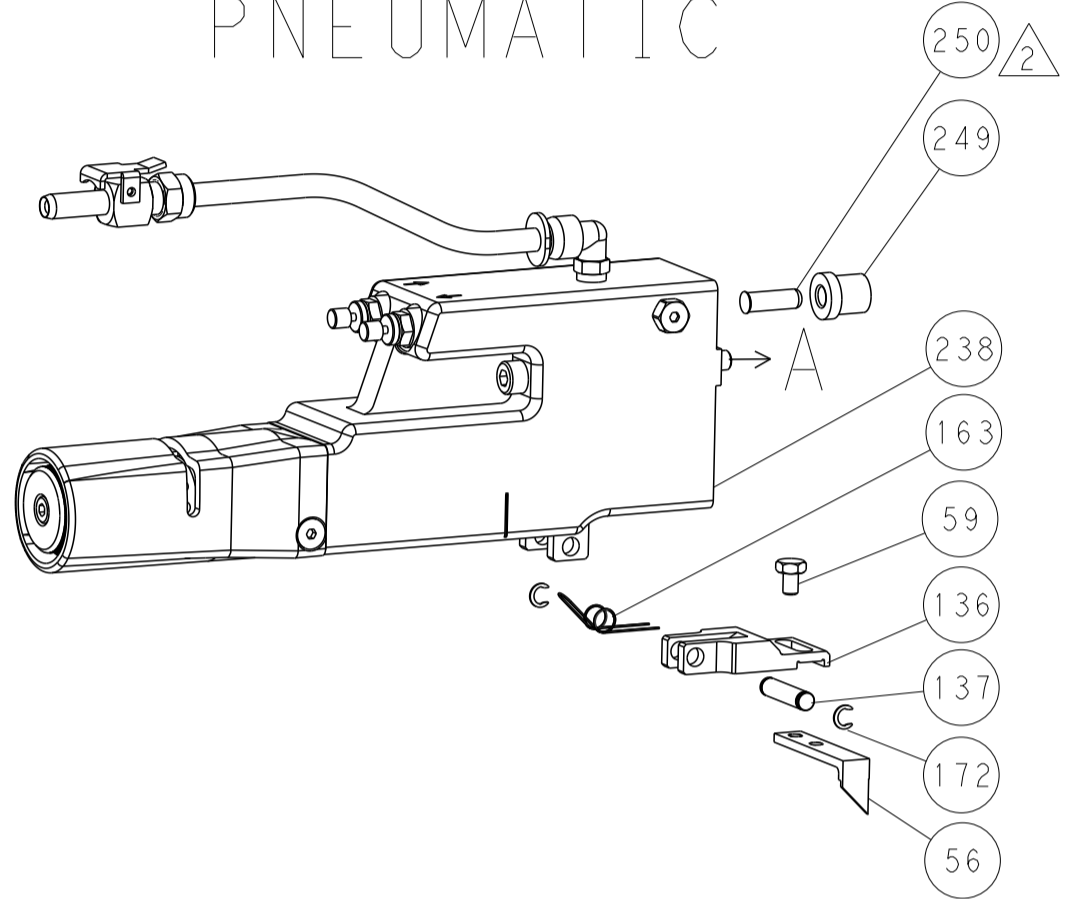
Customer Accessible Production Drawing header including dimensions, tolerances, material, and drawing information like 'Ocean Side Feed Applicator'.

| LOC | DIST | REV | DATE | BY | APPV |
|-----|------|-----|------|----|------|
| | | 1 | | | |

FEED TYPE MECHANICAL



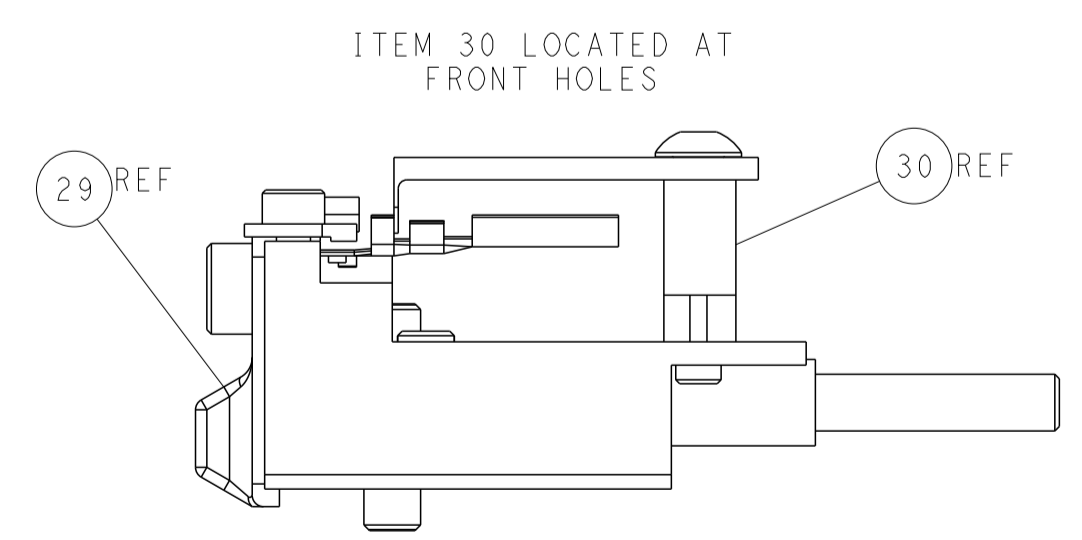
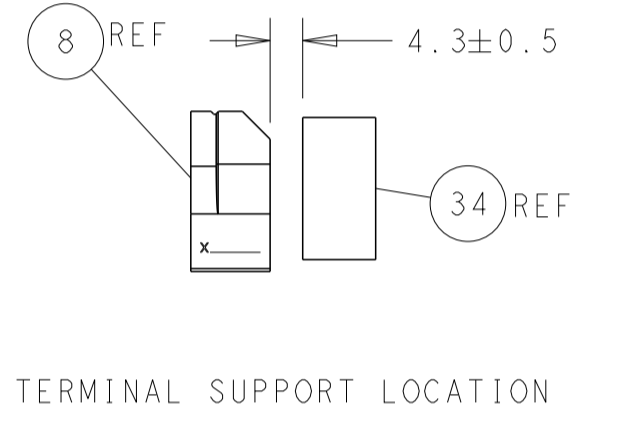
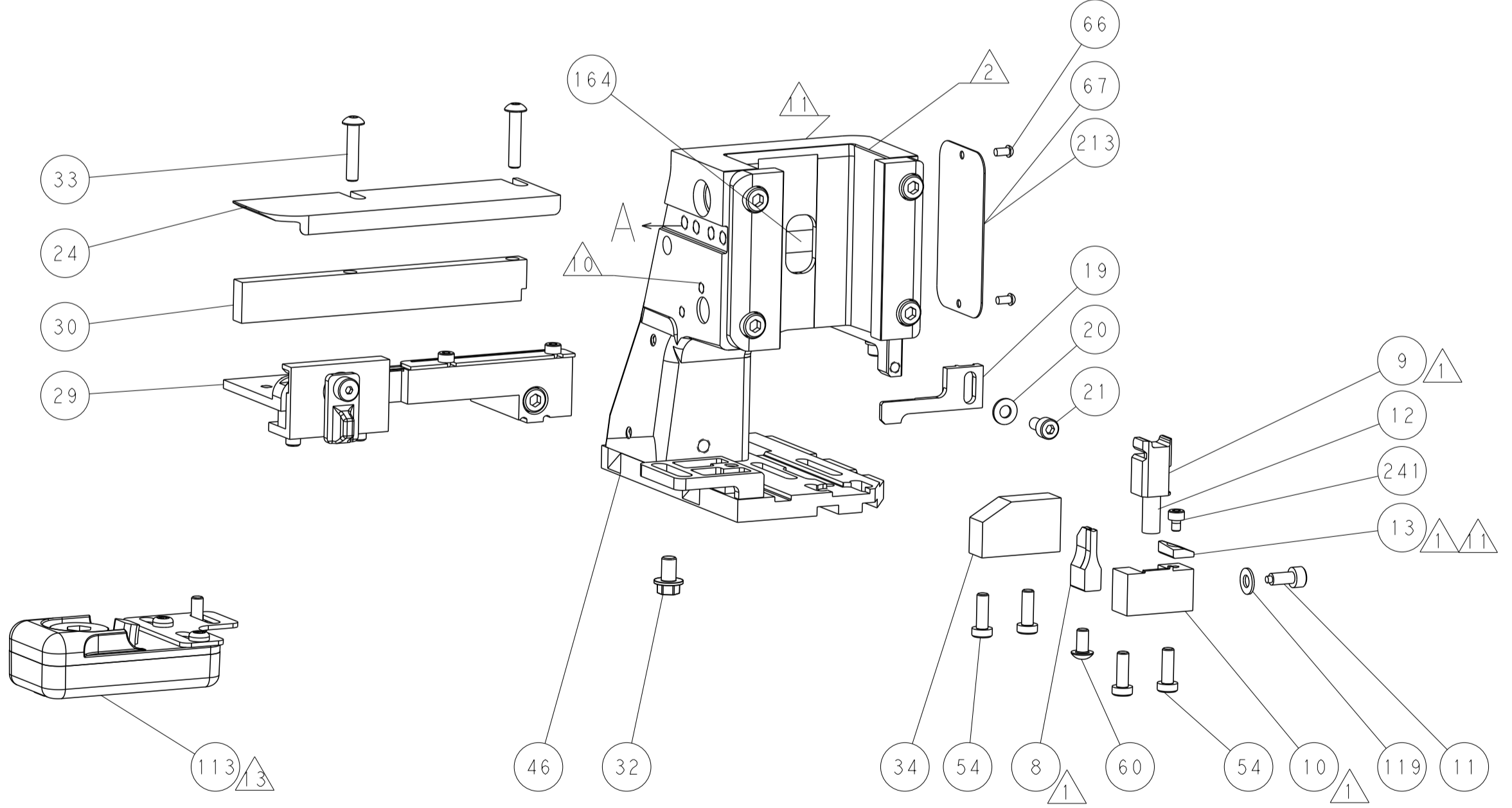
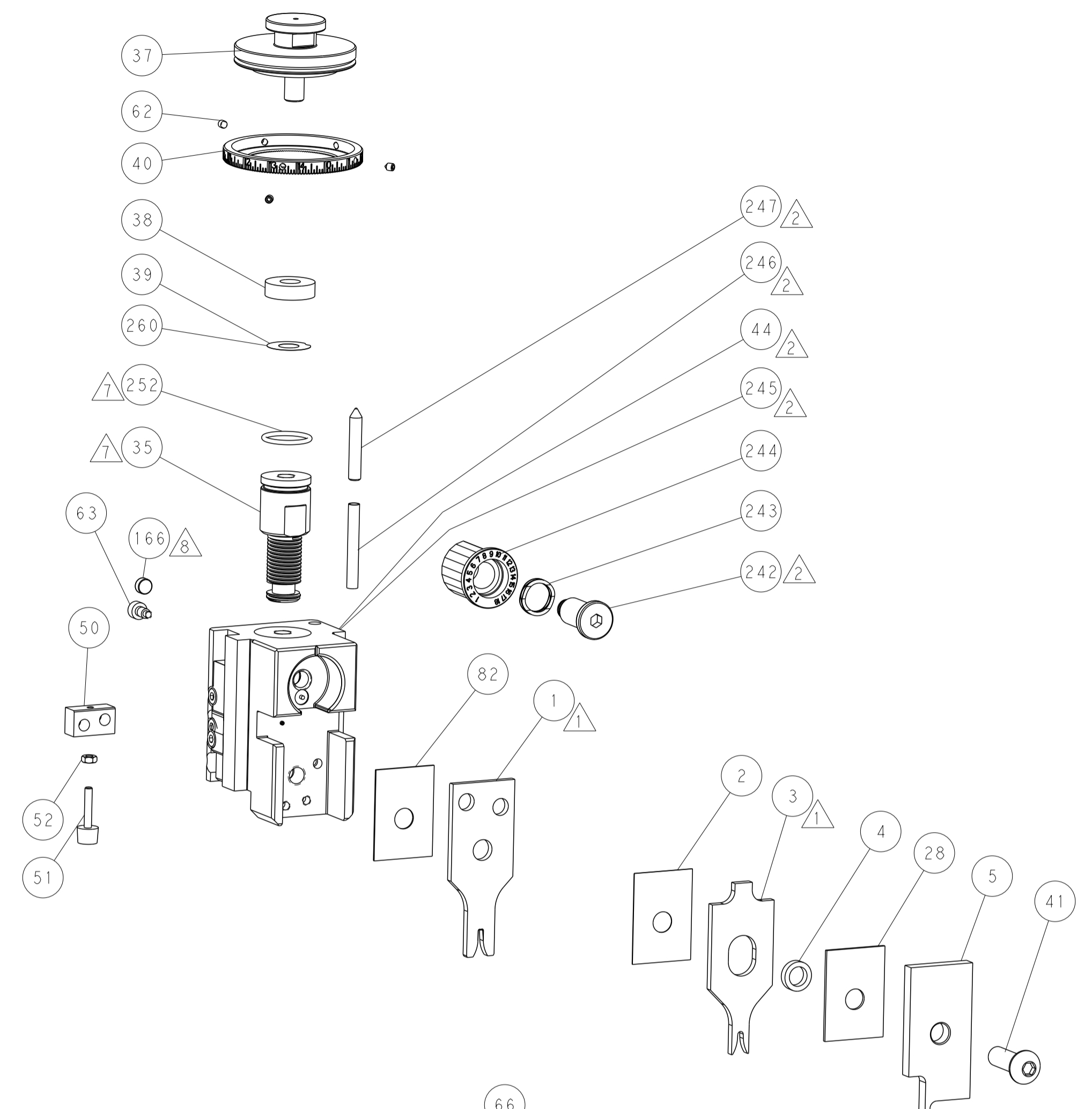
PNEUMATIC



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)

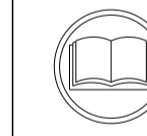
| | | | | | |
|-----------------------|--|---|--|--|--|
| DIMENSIONS: mm | | TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | | DWG: Y. YIN 15SEP2011 CHK: G. BAILEY 15SEP2011 APPV: S. XI 15SEP2011 NAME: Ocean Side Feed Applicator SIZE: CAGE CODE: DRAWING NO: 2151058 RESTRICTED TO: | |
| MATERIAL: | | FINISH: | | WEIGHT: Customer Accessible Production Drawing SCALE: 1:2 SHEET 1 OF 4 REV H | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|----------|--------------------------|--------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2151058-1 | H | 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 | - | 8-2151058-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151058-4 | - | - | - |
| | 2-2151058-2 | H | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151058-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151058-4 | - | - | - |
| | 2-2151058-5 | H | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | 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 |
| | 2-2151058-7 | H | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - |
| | 7-2151058-7 | H | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - |

| APPLICATOR DATA | | |
|-------------------------|----------------|------|
| CRIMP WIRE | SIZE | TYPE |
| INSUL | 2.54 mm [1.00] | F |
| WIRE | 2.03 mm [0.80] | F |
| APPLICATOR INSTRUCTIONS | | |
| 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|--------------------------|-------------------------------|--------------------------|
| TERMINAL NAME: MICRO TIMER 2 CONTACT | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.80-4.40 mm [1.50-.173 IN] | | Ø1.40-2.10 mm [0.055-.083 IN] | |
| TERMINAL APPLICATION SPECIFICATION (A) 114-18081 | - | - | - |
| (B) 114-18082 | - | - | - |
| TERMINALS APPLIED ⁴ | | | |
| TE TERMINAL (A) 964263-2 | TE TERMINAL (A) 964263-3 | TE TERMINAL (B) 964267-2 | TE TERMINAL (B) 964267-1 |
| (B) 964267-3 | (B) 964267-4 | (A) 1241860-2 | (A) 1241860-7 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|---------------------|-----------------------------|--------------------------------|
| 1.00mm ² | 1.20+/-0.05 [0.047+/-0.002] | 7.3 |
| 0.75mm ² | 1.18+/-0.05 [0.046+/-0.002] | 7.5 |
| 0.50mm ² | 1.15+/-0.05 [0.045+/-0.002] | 7.7 |



- 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: 8-2151058-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151058-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151058-5
- 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.
- ⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- ⁸ MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- ¹² TERMINAL LUBRICATOR IS RECOMMENDED WHEN RUNNING GOLD AND SILVER PLATED TERMINALS.

*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.

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

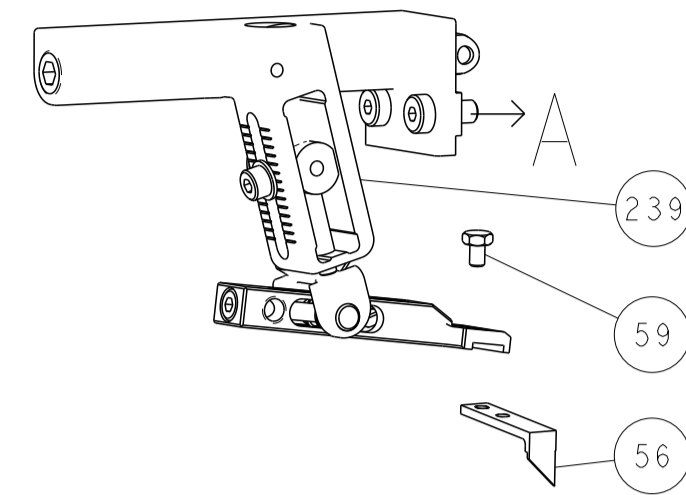
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|------|----|------|
| 2119599-1 | | | REV | DATE | BY | APPV |
| | | | 1 | | | |

| REV | DATE | BY | APPV | DESCRIPTION | ITEM NO | |
|-----|------|-----|------|-------------|-------------------------------------|-----|
| - | - | - | - | SEE SHEET 1 | - | |
| - | 1 | 1 | 1 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | - | - | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | - | 1803259-1 | BUSHING, FLANGED | 249 |
| - | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | 1 | 1 | 1 | 2119082-8 | 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 |
| - | - | - | - | 2168400-6 | SHCS, LOW HEAD, RoHS, M5 X 16 | 240 |
| - | - | - | - | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 |
| - | - | - | - | 2063440-1 | AIR FEED MODULE | 238 |
| - | - | - | - | 2119740-2 | TAG IDENTIFICATION | 213 |
| - | - | - | - | 1901094-3 | SPACER, FEEDER | 198 |
| - | - | - | - | 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 |
| - | - | - | - | 240638-1 | SPRING, FEED FINGER | 163 |
| - | 1 | 1 | 1 | 8-21084-1 | O-RING, .801 ID, .070 DIA. MAT. | 152 |
| - | - | - | - | 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 |
| - | - | - | - | 2119653-2 | FEED CAM, POST FEED | 142 |
| - | 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 |
| - | - | - | - | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
| - | - | - | - | 2119799-1 | HOLDER, FEED FINGER, AF | 136 |
| - | - | REF | - | SEE NOTE 4 | MEMORY CHIP, PROGRAMMED | 135 |
| - | - | - | - | 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 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 |
| - | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 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 |
| - | - | - | - | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | - | - | - | 1338685-1 | PAWL, FEED | 56 |
| - | 2 | 2 | 2 | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10 | 53 |
| - | 1 | 1 | 1 | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 52 |
| - | 1 | 1 | 1 | 811242-5 | BUMPER, HOLD DOWN | 51 |
| - | 1 | 1 | 1 | 690753-2 | SPACER, TONKER | 50 |
| - | - | - | - | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 |
| - | - | - | - | 2119652-1 | FEED CAM, PRE FEED | 48 |
| - | 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 | 1-1752356-8 | 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 | 1320908-3 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 2119959-2 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1-455888-0 | SPACER, CRIMPER | 28 |
| - | 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 | 2119533-1 | 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 | 454276-5 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1 | 1333204-3 | ANVIL, COMBINATION | 8 |
| - | 1 | 1 | 1 | 2119757-4 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 238011-2 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1633965-3 | CRIMPER, INSULATION O PREMIUM | 3 |
| - | 1 | 1 | 1 | 455888-2 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1803125-2 | CRIMPER, WIRE | 1 |

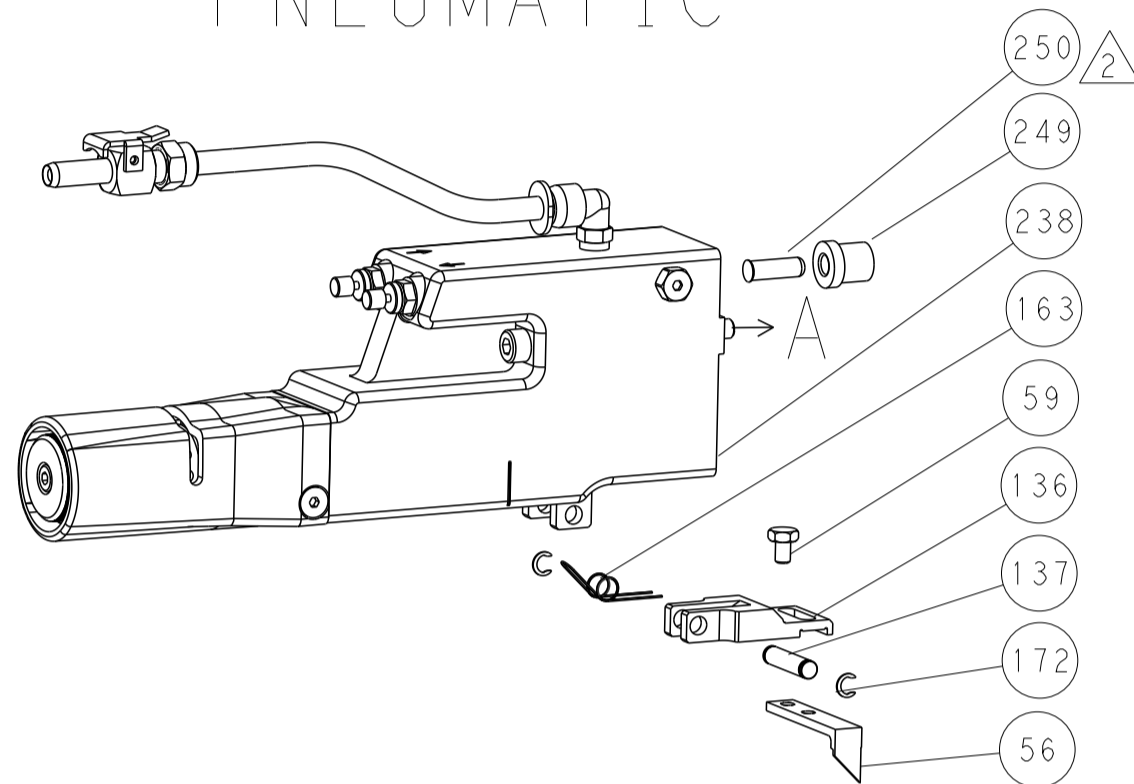
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|-----|------|----|------|-------------|-------------------------------------|
| - | - | - | - | SEE SHEET 1 | - |
| - | 1 | 1 | 1 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE |

| LOC | DIST | REVISIONS | | | |
|-----|------|-------------|------|-----|------|
| P | LTN | DESCRIPTION | DATE | OWN | APVD |
| - | - | SEE SHEET 1 | - | - | - |

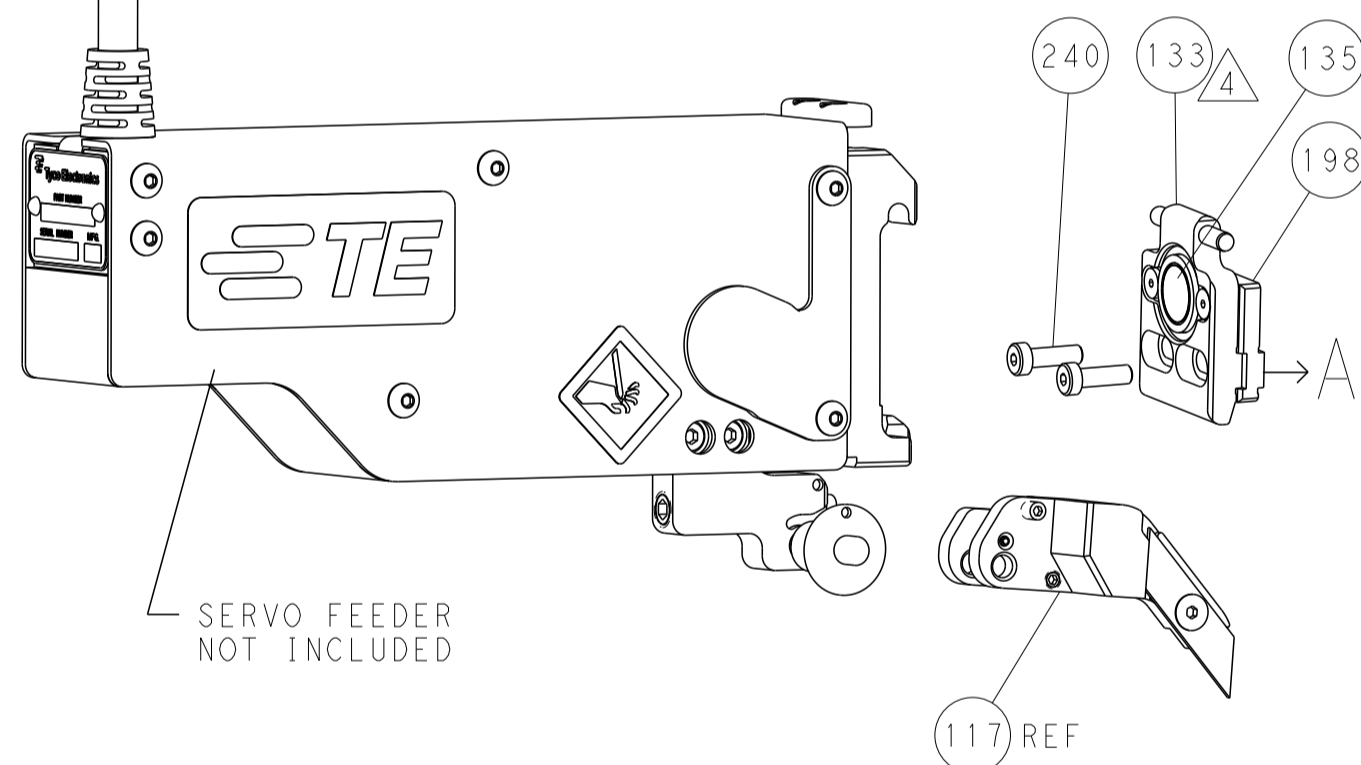
FEED TYPE MECHANICAL



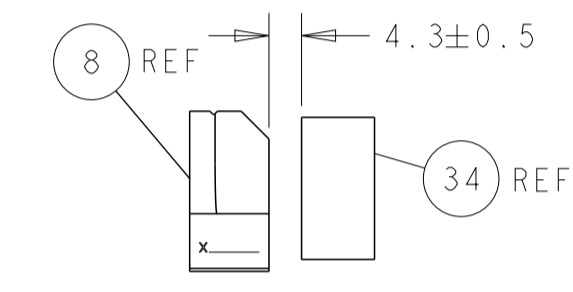
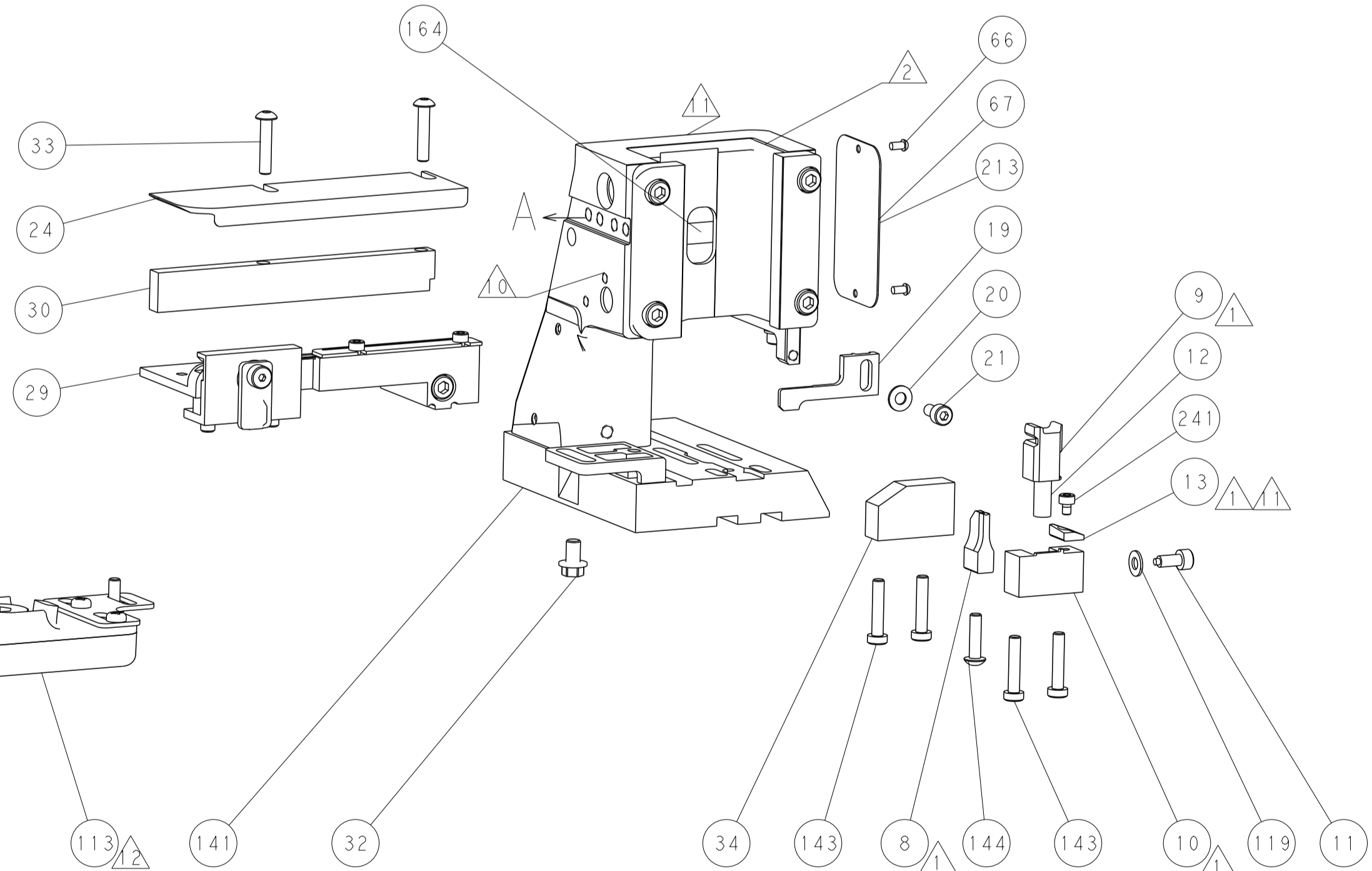
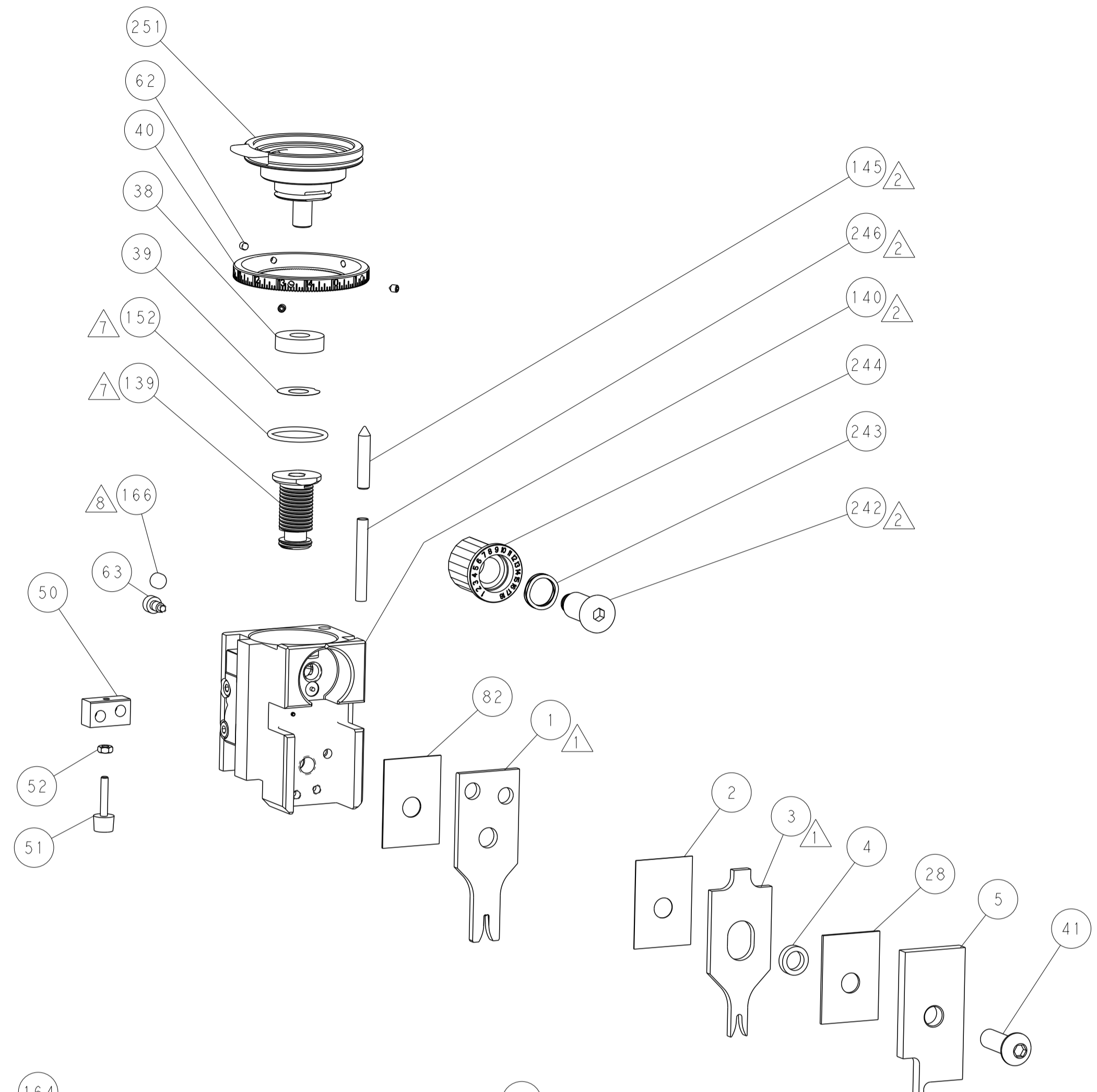
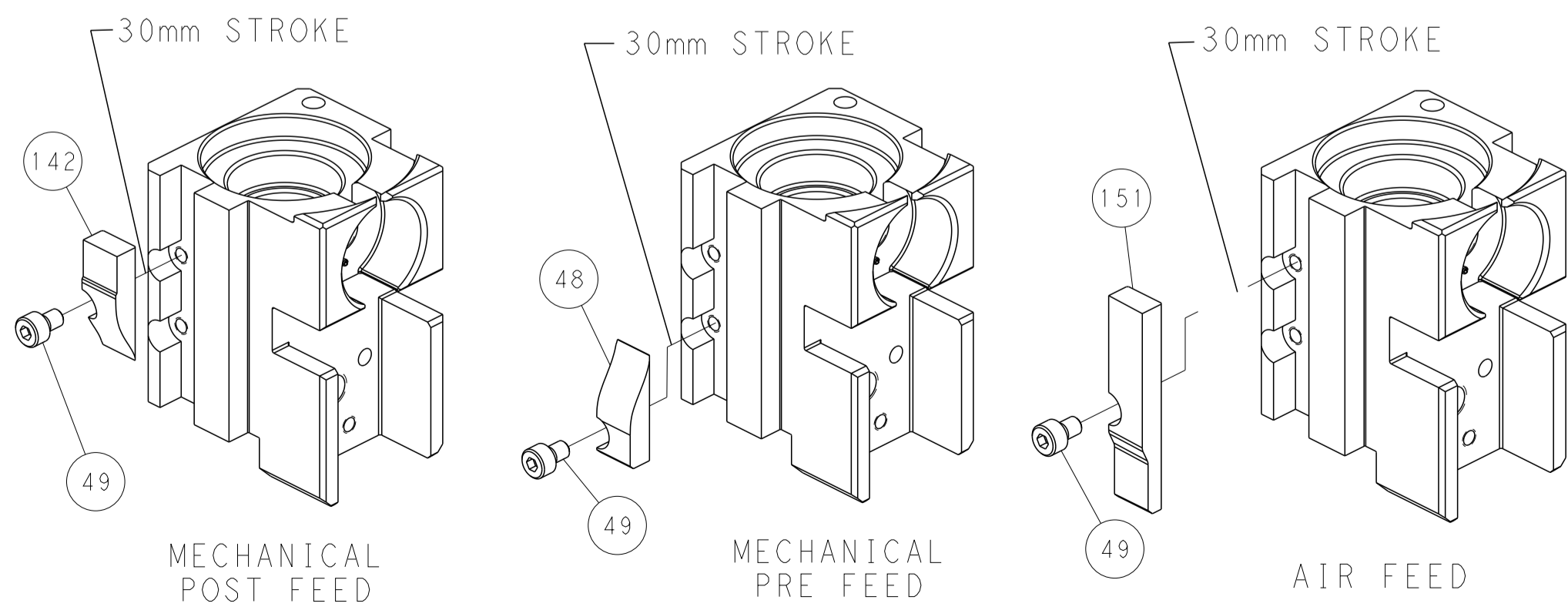
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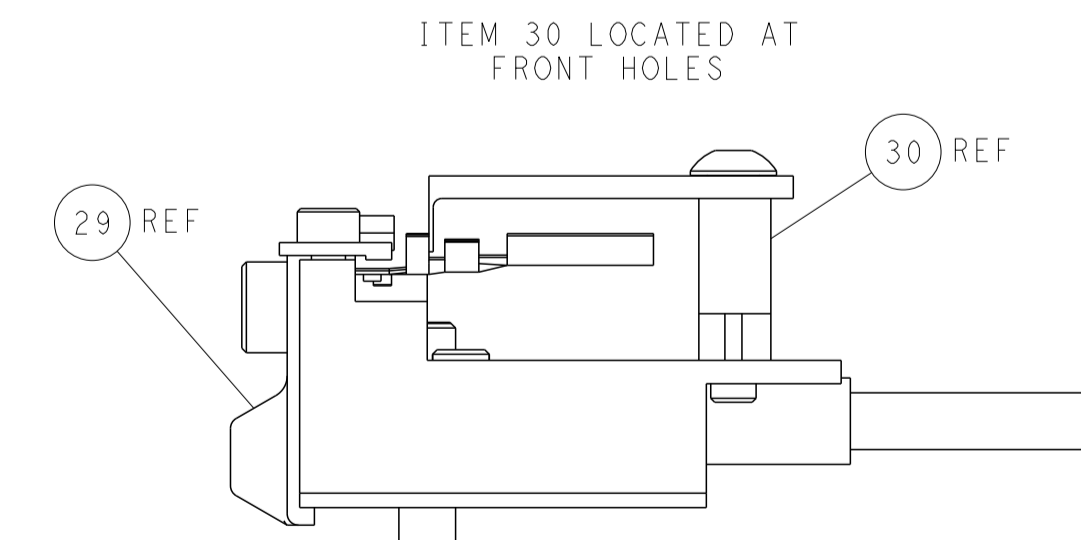
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



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)

| | | | | | |
|-------------|---------|--|---------|--|----------------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN: Y. YIN 15SEP2011 | NAME: Ocean Side Feed Applicator |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | CHK: G. BAILEY 15SEP2011 | |
| MATERIAL: | | FINISH: | | APVD: S. XI 15SEP2011 | RESTRICTED TO: |
| | | | | PRODUCT SPEC: | SIZE: CAGE CODE: DRAWING NO: |
| | | | | APPLICATION SPEC: | Ac 100 1700 2151058 |
| | | | | WEIGHT: | SCALE: 1:2 SHEET 1 OF 4 REV H |
| | | | | Customer Accessible Production Drawing | |