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| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|---|-------------|--------------------------|---|-------------------|-----------------------------------|-----------------------|-------------|-------------|-----------|------------------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | | | | | | | | | | | |
| | 2151300-1 | H | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151300-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151300-4 | - | - | |
| | | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 |
| | 2151300-2 | H | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151300-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151300-4 | - | - | |
| | | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 |
| 2151300-5 | H | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | |
| | | | | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | |
| | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | |
| | | | | - | - | - | - | - | - | - | |
| 2151300-6 | H | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE ⁴ ₁₂ | - | - | - | - | - | - | - | |
| | | | | - | - | - | - | - | - | - | |
| 2151300-7 | H | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 3-2151300-2 | H | FINE CRIMP HEIGHT ADJUST | DOUBLE ACTING PNEUMATIC WITH SENSORS ³ | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | |
| | | | | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | |
| | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151300-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | |
| 7-2151300-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------|-----------------|---------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.40 mm [1.055] | F |
| INSUL | 1.83 mm [1.072] | SPECIAL |

APPLICATOR INSTRUCTIONS 408-10389

| TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION | | | |
|---|-------------|-------------------------------|-------------|
| TERMINAL NAME: TAB CONTACT 1.2 MM | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.30-3.90 mm [1.130-1.154 IN] | | Ø1.40-1.90 mm [1.055-.075 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-18464 | - | - |
| TERMINALS APPLIED ⁴ | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1418760-1 | 1418760-2 | 1418760-3 | 5-1418760-1 |
| 5-1418760-2 | 5-1418760-3 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|------------------------------|-----------------------------|--------------------------------|
| 0.75mm ² | 1.05+/-0.03 [1.041+/-0.001] | 6.7 |
| 0.5mm ² OR 20 AWG | 0.93+/-0.03 [1.037+/-0.001] | 7.9 |

- 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: 8-2151300-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151300-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151300-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151300-6
- 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 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.
- 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 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.
- ¹⁴ 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.

| | | | | | | | | | |
|-----|-----|----|----|----|----|-------------|---------------------------------|-------------|---------|
| - | 1 | - | - | - | - | 1803430-1 | AIR FEED MODULE | 290 | |
| - | 2 | 2 | 2 | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 269 | |
| - | 1 | 1 | 1 | 1 | 1 | 1-1633782-1 | FENCE | 267 | |
| - | - | - | - | - | - | 2119957-2 | APPLICATOR SHIM PACK | 260 | |
| - | 1 | 1 | - | 1 | 1 | 8-21084-0 | O-RING, .676 ID, .070 DIA. MAT. | 252 | |
| - | - | - | - | - | - | 2119640-1 | PUSH ROD, AIR FEED | 250 | |
| - | - | - | - | - | - | 1803259-1 | BUSHING, FLANGED | 249 | |
| -77 | -32 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

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

| REVISIONS | | | |
|-----------|----|---------------|-----------|
| P | LN | DESCRIPTION | DATE |
| E | 1 | ECR-16-015345 | 28OCT2016 |
| F | 1 | ECR-16-017831 | 16DEC2016 |
| G | 1 | ECR-17-004695 | 31MAR2017 |
| H | 1 | ECR-17-006149 | 28APR2017 |

SET UP GAUGE 2119599-1
 LOC A
 DIST 66

| - | - | - | - | - | - | 1 | - | 2119641-1 | FEED CAM, AIR FEED | 248 |
|-----|-----|-----|-----|-----|-----|-----|---|-------------|-------------------------------------|---------|
| - | 1 | 1 | - | 1 | 1 | 1 | - | 2119798-1 | DETENT PIN | 247 |
| - | 1 | 1 | - | 1 | 1 | 1 | - | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | - | - | 1 | - | - | - | - | 2119758-1 | RAM, AMP STYLE, SIDE FEED, NON-ADJ. | 245 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2119082-5 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 7-18023-7 | SCR, SKT HD CAP M3 X 4.0 | 241 |
| - | - | - | 2 | 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 | 1 | - | - | - | 2119740-2 | TAG, IDENTIFICATION | 213 |
| - | - | - | 1 | 1 | - | - | - | 1901094-3 | SPACER, FEEDER | 198 |
| - | 2 | - | - | - | 2 | - | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 |
| - | REF | REF | REF | REF | REF | REF | - | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 1 | - | - | - | 1 | - | - | 240638-1 | SPRING, FEED FINGER | 163 |
| - | 1 | - | - | - | 1 | - | - | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
| - | 1 | - | - | - | 1 | - | - | 2119799-1 | HOLDER, FEED FINGER, AF | 136 |
| - | - | - | REF | REF | - | - | - | SEE NOTE 4 | MEMORY CHIP, PROGRAMMED | 135 |
| - | - | - | 1 | 1 | - | - | - | 1633743-1 | SERVO FEED LATCH ASM | 133 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | - | REF | REF | - | - | - | 2119944-1 | FEED FINGER ASSEMBLY,SF | 117 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 455888-5 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 5-547505-2 | SPRING, COMPRESSION | 77 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 854769-5 | HOLDER, INS | 74 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | - | - | 1 | 1 | - | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2 | 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 | 3 | - | 992763-5 | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 60 |
| - | 1 | - | - | - | 1 | 1 | - | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 21028-2 | PIN, SLOTTED SPRING .062 X .250 | 58 |
| - | 1 | - | - | - | 1 | 1 | - | 1338685-1 | PAWL, FEED | 56 |
| - | 4 | 4 | 4 | 4 | 4 | 4 | - | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 54 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | - | 2168083-8 | SCR, SKT HD CAP, RoHS, M4 X 16 | 53 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 5018030-1 | NUT, HEX, REG, RoHS, M3 | 52 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 811242-5 | BUMPER, HOLD DOWN | 51 |
| - | 1 | 1 | 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 | - | - | 2119653-1 | FEED CAM, POST FEED | 47 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2119656-9 | APPLICATOR BASIC ASSEMBLY, SF | 46 |
| - | 1 | 1 | - | 1 | 1 | 1 | - | 2119370-1 | RAM, AMP STYLE, SIDE FEED | 44 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2079383-7 | SCR, BHSC, RoHS (M8 X 25) | 41 |
| - | 1 | 1 | - | 1 | 1 | 1 | - | 2119645-1 | DISC, NUMBERED FA WIRE ADJUSTMENT | 40 |
| - | 1 | 1 | - | 1 | 1 | 1 | - | 2119957-1 | APPLICATOR SHIM PACK | 39 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2119644-1 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 |
| - | 1 | 1 | - | 1 | 1 | 1 | - | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 3-1752356-3 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | - | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2161328-1 | HEX HEAD, FLANGED, M5 X 8mm LONG | 32 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 1320908-3 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2119959-2 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 455888-3 | SPACER, CRIMPER | 28 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 1320928-6 | STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2119533-1 | STRIPPER, SIDE FEED | 19 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 1-356885-4 | STOP, SHEAR | 11 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 1633861-1 | SHEAR, FLOATING | 9 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | - | 1333231-5 | ANVIL, COMBINATION, SPECIAL | 8 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 5-240641-0 | SPACER | 7 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 1-2119780-1 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | - | 4-238011-2 | BLOCK, CRIMPER SPACER | 4 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | - | 1633989-1 | CRIMPER, INSULATION, SPECIAL | 3 |
| 1 | 1 | 1 | 1 | 1 | 1 | 1 | - | 3-1633730-2 | CRIMPER, WIRE | 1 |
| -77 | -32 | -7 | -6 | -5 | -2 | -1 | | PART NO | DESCRIPTION | ITEM NO |

| | | | | | |
|-------------|---------|--|---------|-------------------|-------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DATE: 24AUG2011 | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± |
| MATERIAL: | | FINISH: | | DATE: 24AUG2011 | DATE: 24AUG2011 |
| | | | | APVD: T. ELBIN | APVD: T. ELBIN |
| | | | | PRODUCT SPEC: | PRODUCT SPEC: |
| | | | | APPLICATION SPEC: | APPLICATION SPEC: |
| | | | | WEIGHT: | WEIGHT: |
| | | | | SCALE: 1:2 | SCALE: 1:2 |
| | | | | SHEET 1 of 4 | SHEET 1 of 4 |
| | | | | REV H | REV H |

TE Connectivity
 Harrisburg, PA 17105-3608

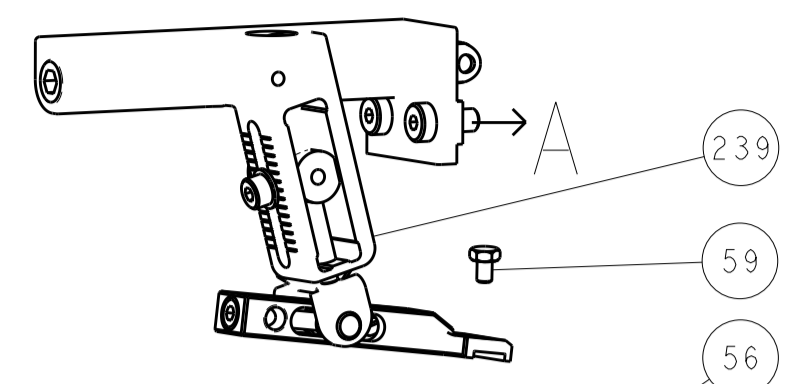
Ocean Side Feed
 Applicator

SIZE: A | CAGE CODE: 00779 | DRAWING NO: ©-2151300

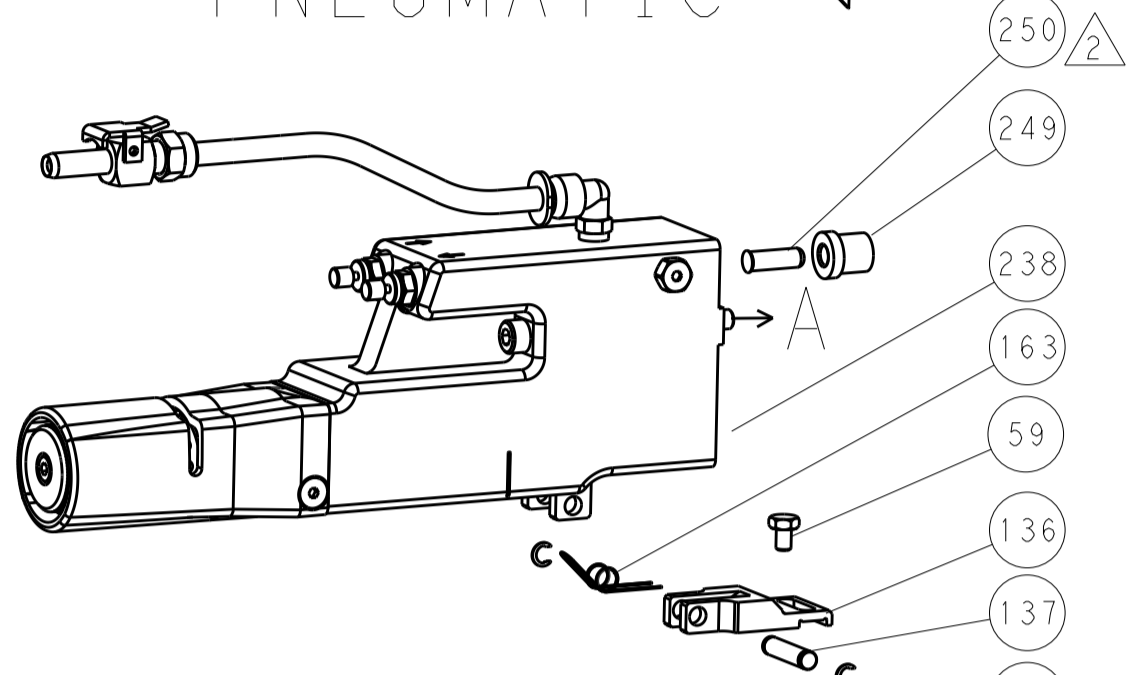
Customer Accessible Production Drawing

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

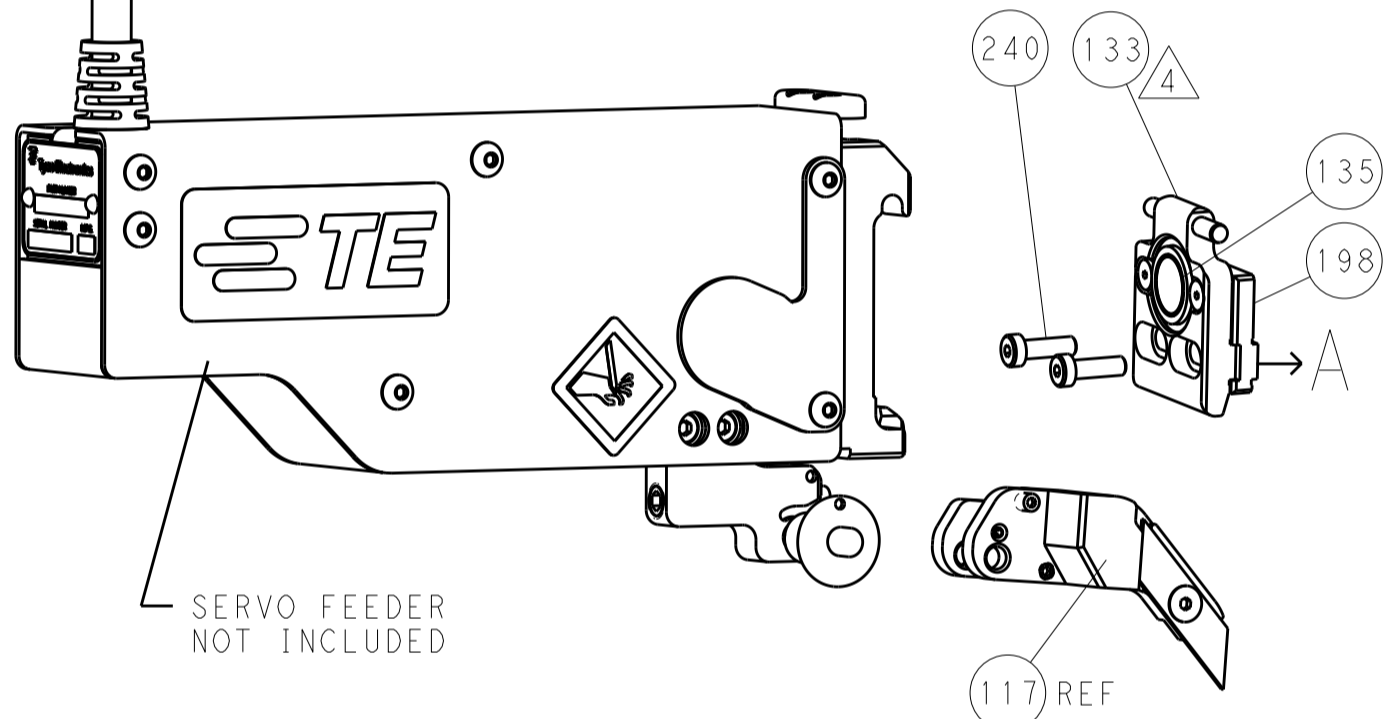
FEED TYPE MECHANICAL



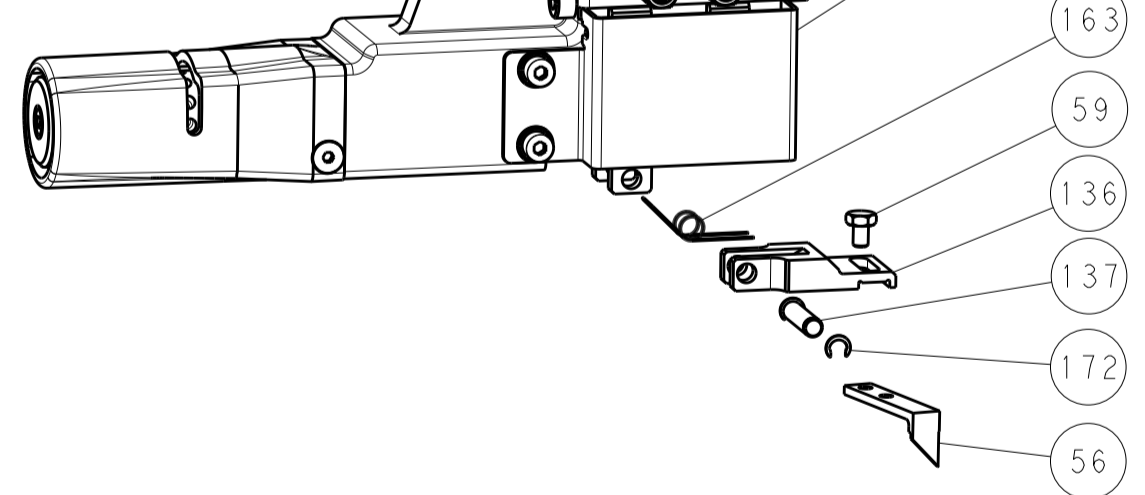
PNEUMATIC



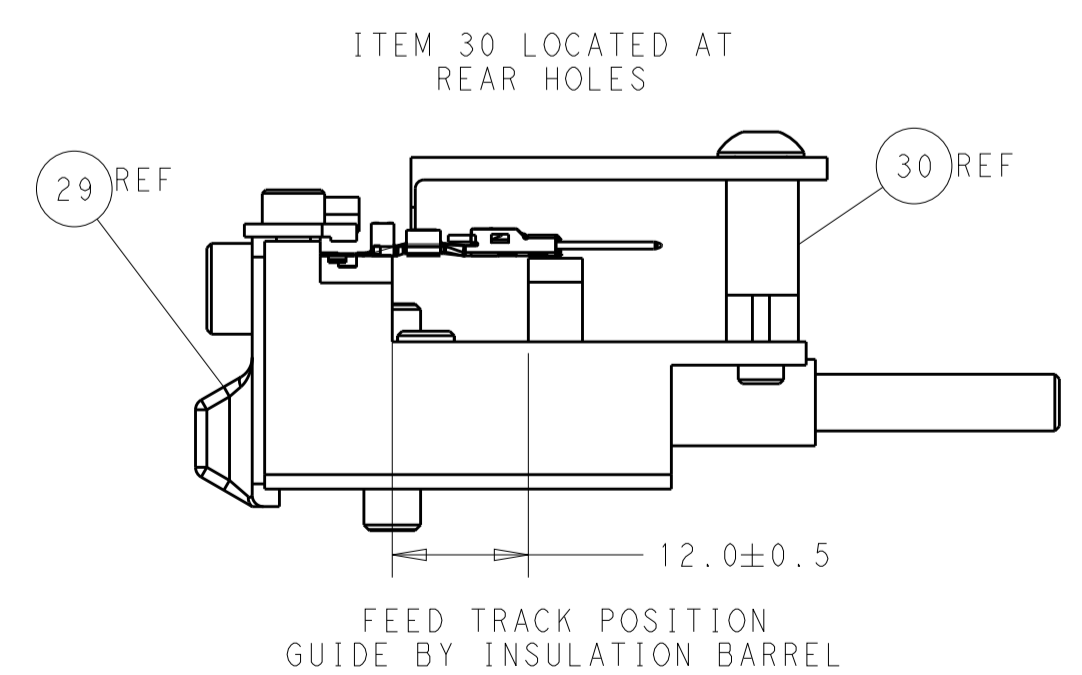
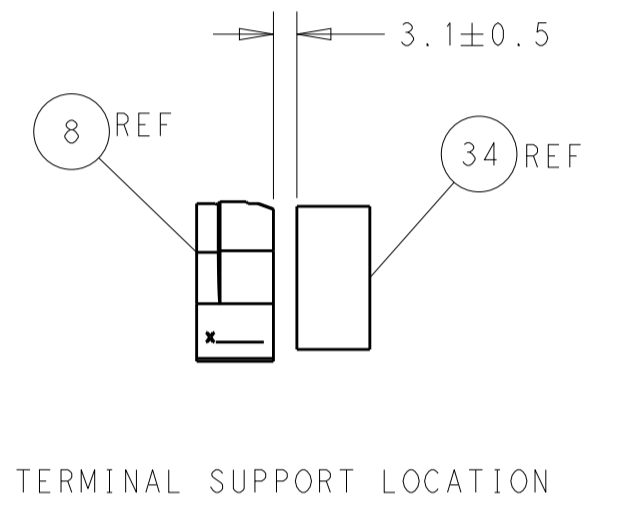
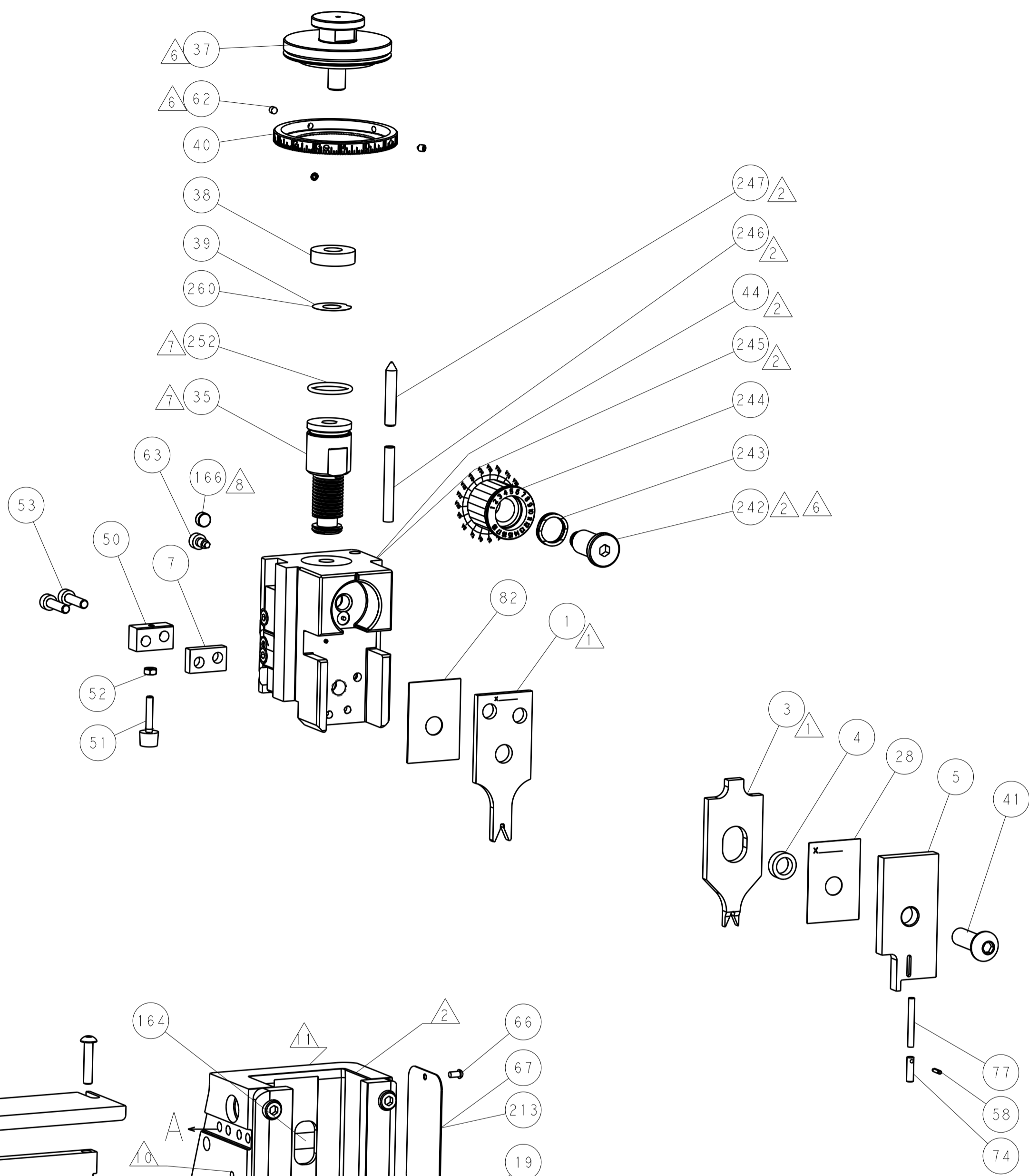
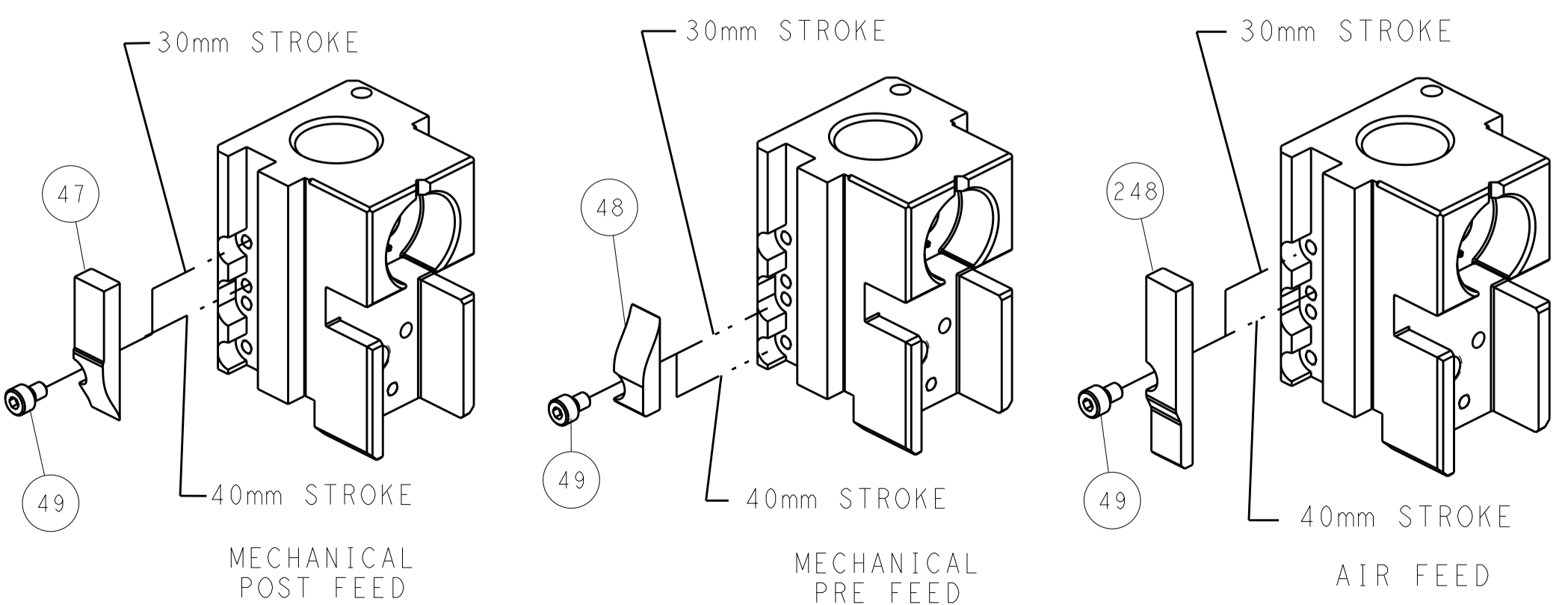
SERVO LATCH PLATE



DOUBLE ACTING PNEUMATIC WITH SENSORS



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: | | OWN: C. MOYER 24AUG2011 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | Harrisburg, PA 17105-3608 | |
| MATERIAL: | | FINISH: | | CHK: T. ELBIN 24AUG2011 | | NAME: Ocean Side Feed Applicator | |
| | | | | APVD: T. ELBIN 24AUG2011 | | SIZE: CAGE CODE: DRAWING NO: 00779 ©=2151300 | |
| | | | | PRODUCT SPEC: | | RESTRICTED TO: | |
| | | | | APPLICATION SPEC: | | Customer Accessible Production Drawing | |
| | | | | WEIGHT: | | SCALE: 1:2 SHEET 2 OF 4 REV H | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|--|-------------|-------------------|--------------------------|--|-----------------------------------|-----------------------|-------------|-------------|-----------|------------------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2-2151300-1 | 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 | - | 8-2151300-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151300-4 | - | - | - |
| | 2-2151300-2 | H | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151300-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) |
| | 2-2151300-5 | H | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE 4 | SMART APPLICATOR | 2161326-1 | - | 8-2151300-4 | - | - | - |
| | | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - |
| | 2-2151300-7 | H | FINE CRIMP HEIGHT ADJUST | NONE | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 |
| | | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 |
| | 4-2151300-2 | H | FINE CRIMP HEIGHT ADJUST | DOUBLE ACTING PNEUMATIC WITH SENSORS 2 | 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 | |
| SERVO LATCH PLATE | | | | | 2119951-1 | - | 8-2151300-5 | 1901094-3 | - | 2168400-6 (QUANTITY 2) | |
| 7-2151300-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------------------------|----------------|---------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.40 mm [.055] | F |
| INSUL | 1.83 mm [.072] | SPECIAL |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|------------------------------------|-------------|------------------------------|-------------|
| TERMINAL NAME: TAB CONTACT 1.2 MM | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 3.30-3.90 mm [.130-.154 IN] | | Ø1.40-1.90 mm [.055-.075 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-18464 | - | - |
| TERMINALS APPLIED 3 | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1418760-1 | 1418760-2 | 1418760-3 | 5-1418760-1 |
| 5-1418760-2 | 5-1418760-3 | | |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|------------------|-------------------------------|--------------------------------|
| 0.75mm2 | 1.05 +/- 0.03 [.041 +/- .001] | 6.7 |
| 0.5mm2 OR 20 AWG | 0.93 +/- 0.03 [.037 +/- .001] | 7.9 |



- 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: 8-2151300-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151300-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151300-5
- 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 ITEMS 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 THIS APPLICATOR IS EQUIPPED WITH THE DOUBLE ACTING FEED WITH SENSORS AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.
- 13 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.

| | | | | | | | |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|-------------|
| - | 1 | - | - | - | 1803430-1 | AIR FEED MODULE | 290 |
| - | 2 | 2 | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 269 |
| - | 1 | 1 | 1 | 1 | 1-1633782-1 | FENCE | 267 |
| - | 1 | 1 | 1 | 1 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | - | - | - | 1 | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| -77 | -42 | -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)

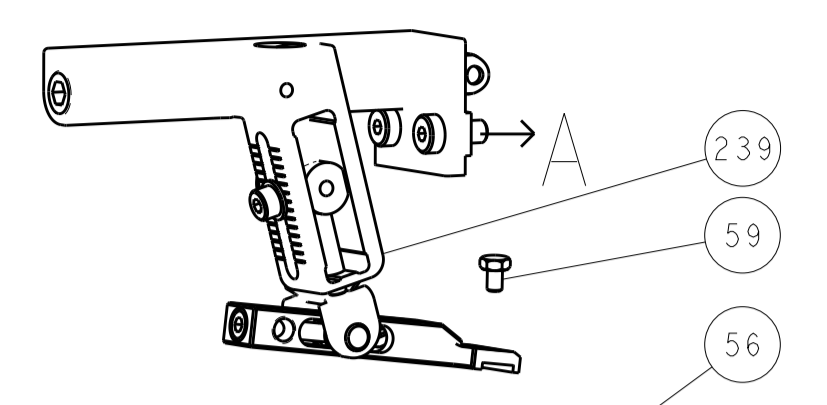
| SET UP GAUGE | LOC | DIST | REVISIONS | | | | | |
|--------------|-----|------|-----------|-----|-------------|------|-----|------|
| 2119599-1 | A | 66 | P | LTN | DESCRIPTION | DATE | OWN | APVD |
| | | | - | - | SEE SHEET 1 | - | - | - |

| | | | | | | | | |
|-----|-----|-----|-----|-----|-------------|-------------------------------------|-------------------------------------|---------|
| - | - | - | - | - | 1803259-1 | BUSHING, FLANGED | 249 | |
| - | 1 | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 | |
| - | 1 | 1 | 1 | 1 | 2119082-5 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 | |
| - | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 | |
| 6 | - | 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 | |
| - | - | - | - | - | 2119580-1 | MECHANICAL FEED ASSEMBLY | 239 | |
| - | - | - | - | - | 2063440-1 | AIR FEED MODULE | 238 | |
| - | - | - | 1 | - | 2119740-2 | TAG IDENTIFICATION | 213 | |
| - | - | - | 1 | - | 1901094-3 | SPACER, FEEDER | 198 | |
| - | - | - | - | - | 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 | |
| 7 | - | 1 | 1 | 1 | 8-21084-1 | O-RING, .801 ID, .070 DIA. MAT. | 152 | |
| - | - | - | - | - | 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 | |
| - | - | - | - | - | 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 | |
| 8 | - | 1 | 1 | 1 | 2119092-2 | BOLT, ADJUSTMENT | 139 | |
| - | 1 | - | - | - | 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 |
| - | - | - | 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 |
| 9 | - | 1 | 1 | 1 | 2119955-1 | ASSY, LUBRICATOR, SIDE FEED | 113 | |
| - | 1 | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 | |
| - | 1 | 1 | 1 | 1 | 5-547505-2 | SPRING, COMPRESSION | 77 | |
| - | 1 | 1 | 1 | 1 | 854769-5 | HOLDER, INS | 74 | |
| - | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 | |
| - | 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 | |
| 6 | - | 3 | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62 |
| - | 1 | - | - | - | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 | |
| - | 1 | 1 | 1 | 1 | 21028-2 | PIN, SLOTTED SPRING .062 X .250 | 58 | |
| - | 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 | |
| - | - | - | - | - | 18023-9 | SCR, SKT HD CAP M4 X 6.0 | 49 | |
| - | - | - | - | - | 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 | 3-1752356-3 | 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 | 1320908-3 | SPACER, STRIP GUIDE | 30 | |
| - | 1 | 1 | 1 | 1 | 2119959-2 | ASSEMBLY, STRIP GUIDE | 29 | |
| - | 1 | 1 | 1 | 1 | 455888-3 | SPACER, CRIMPER | 28 | |
| - | 1 | 1 | 1 | 1 | 1320928-6 | 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 | 1633861-1 | SHEAR, FLOATING | 9 | |
| 1 | 1 | 1 | 1 | 1 | 1333231-5 | ANVIL, COMBINATION, SPECIAL | 8 | |
| - | 1 | 1 | 1 | 1 | 5-240641-0 | SPACER | 7 | |
| - | 1 | 1 | 1 | 1 | 1-2119780-1 | DEPRESSOR, SHEAR | 5 | |
| - | 1 | 1 | 1 | 1 | 4-238011-2 | BLOCK, CRIMPER SPACER | 4 | |
| 1 | 1 | 1 | 1 | 1 | 1633989-1 | CRIMPER, INSULATION, SPECIAL | 3 | |
| 1 | 1 | 1 | 1 | 1 | 3-1633730-2 | CRIMPER, WIRE | 1 | |
| -77 | -42 | -27 | -25 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |

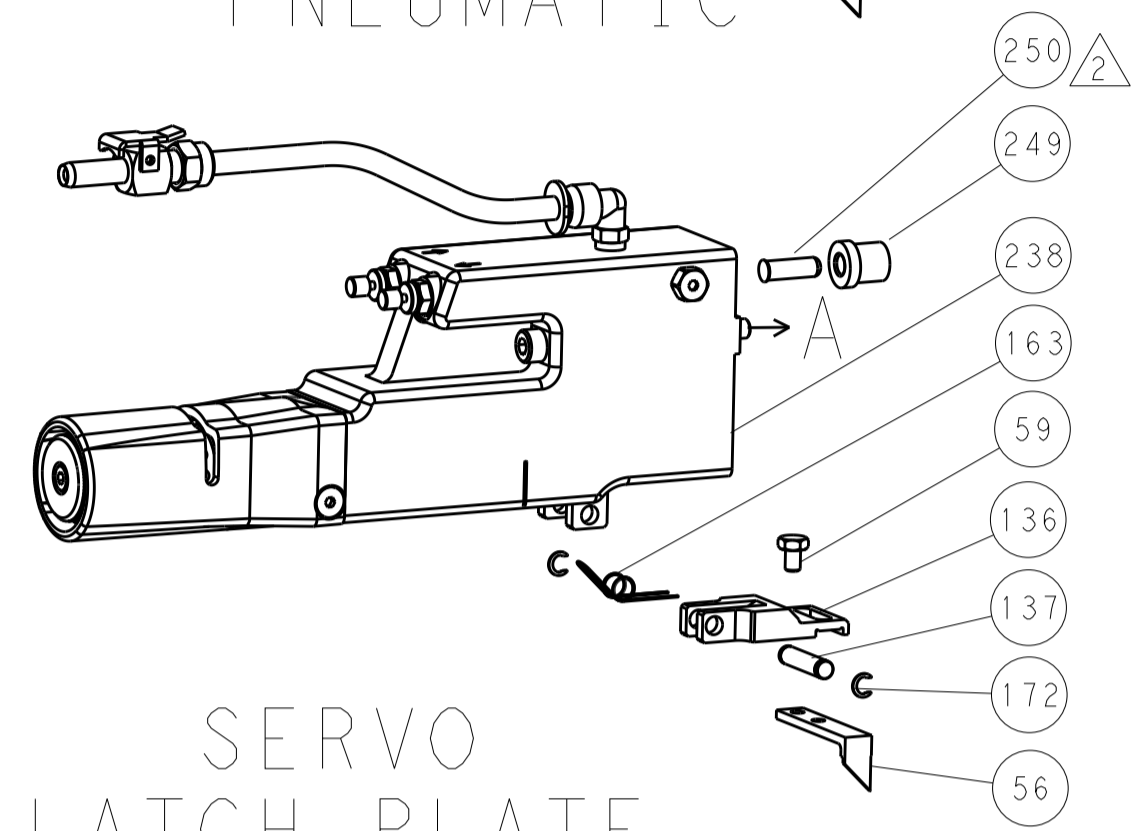
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | APVD | DATE | REV | DESCRIPTION | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO |
|-------------|-------|--|---|----------|-----------|-----|----------------------------|------|-----------|------------|---------------|
| | mm | 0 PLC | ± | T. ELBIN | 24AUG2011 | A | Ocean Side Feed Applicator | - | - | 00779 | - |
| | 1 PLC | ± | | | | | | | | | |
| | 2 PLC | ± | | | | | | | | | |
| | 3 PLC | ± | | | | | | | | | |
| MATERIAL | | FINISH | | WTG | SCALE | | SHEET | | 3 | OF | 4 |
| - | | - | | - | 1:2 | | REV | | H | | |

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

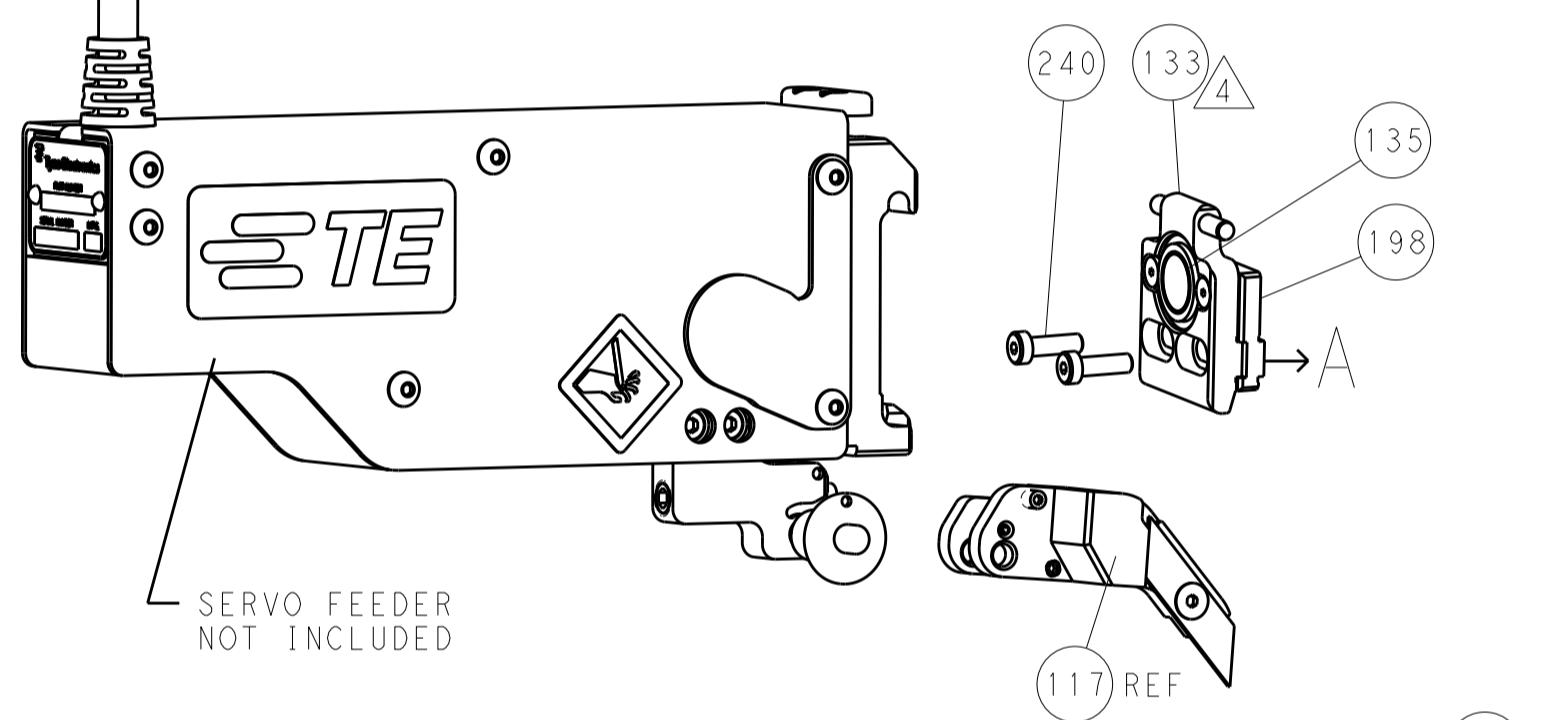
FEED TYPE MECHANICAL



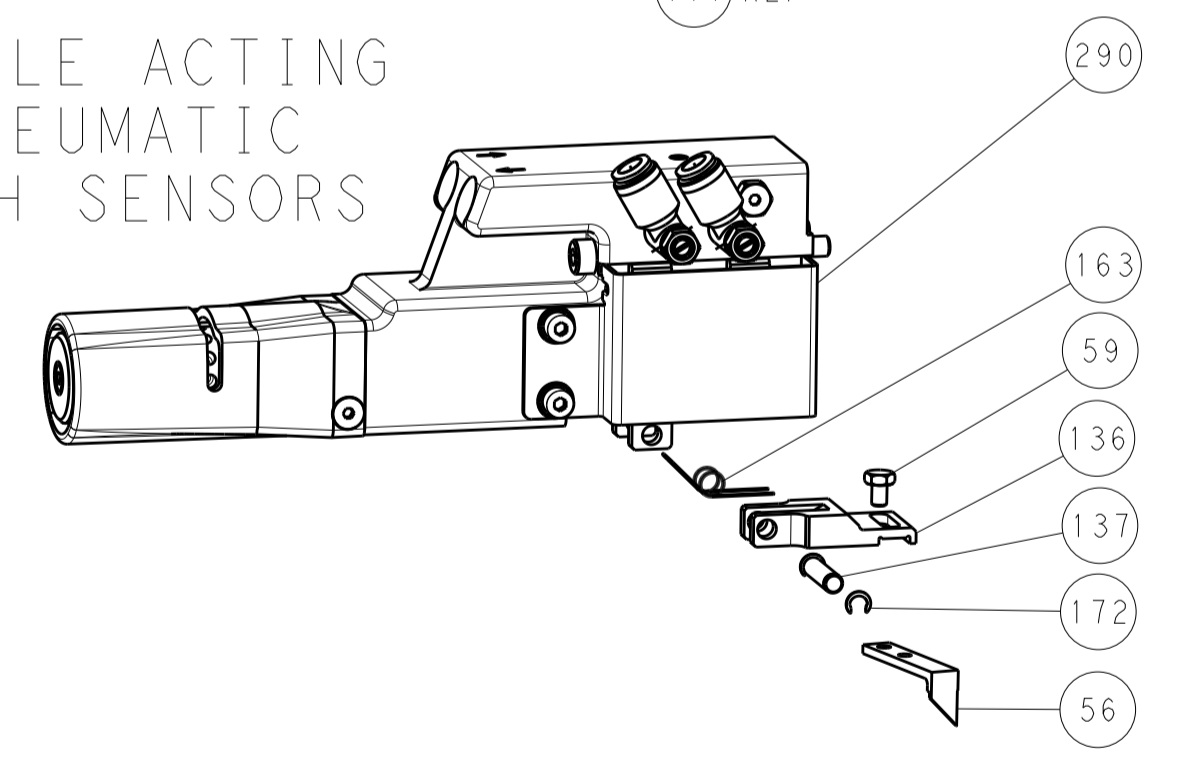
PNEUMATIC



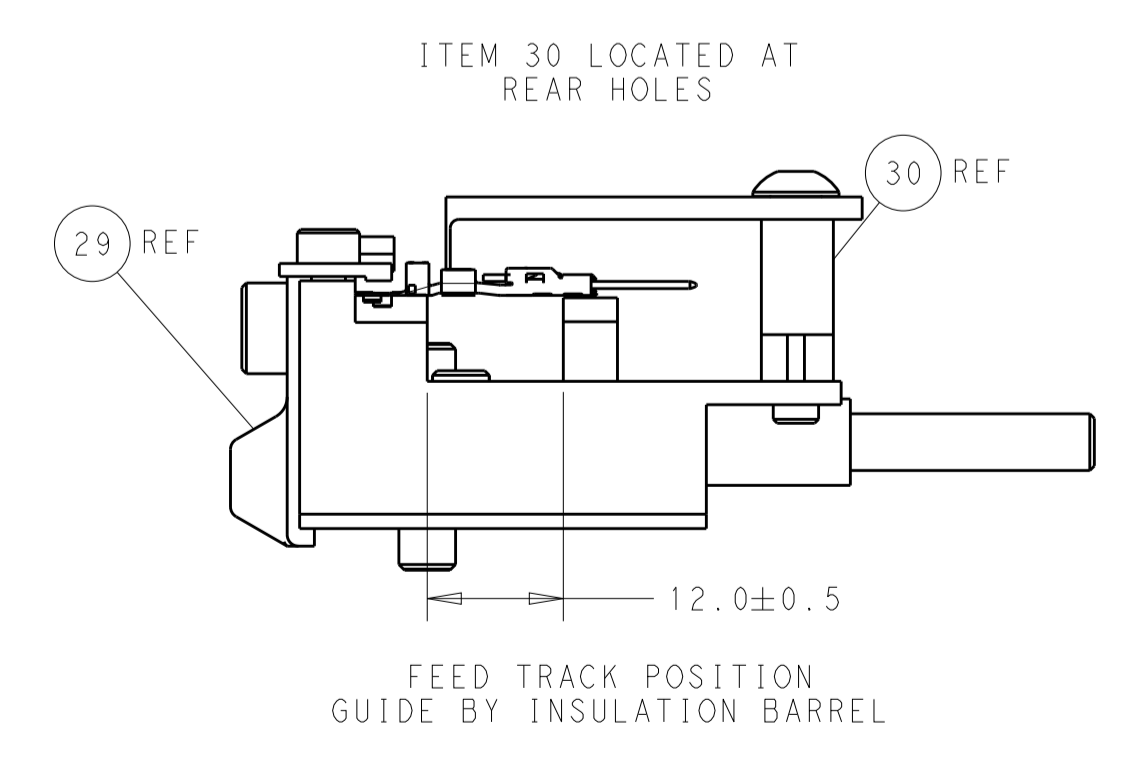
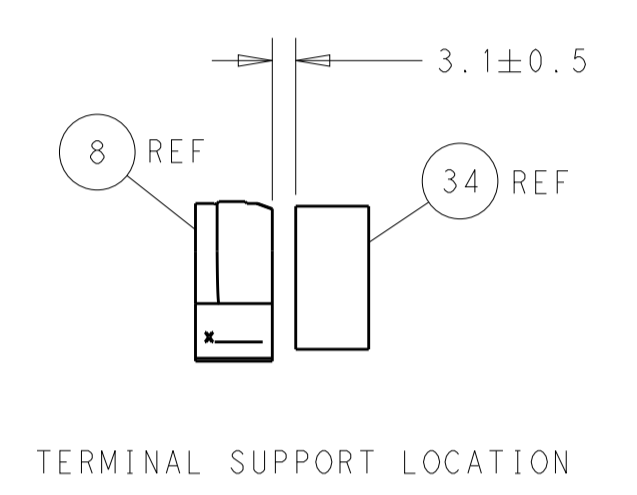
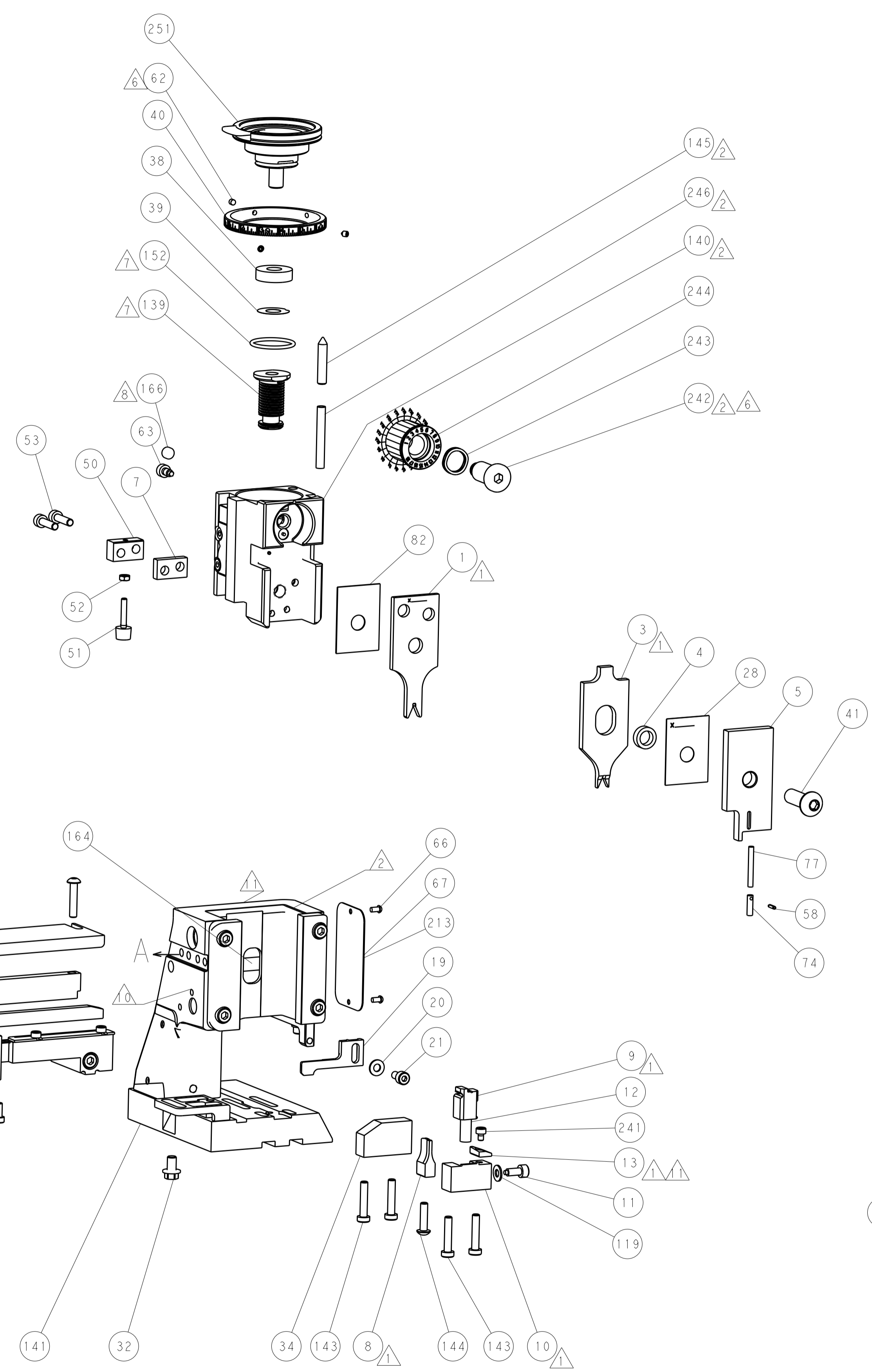
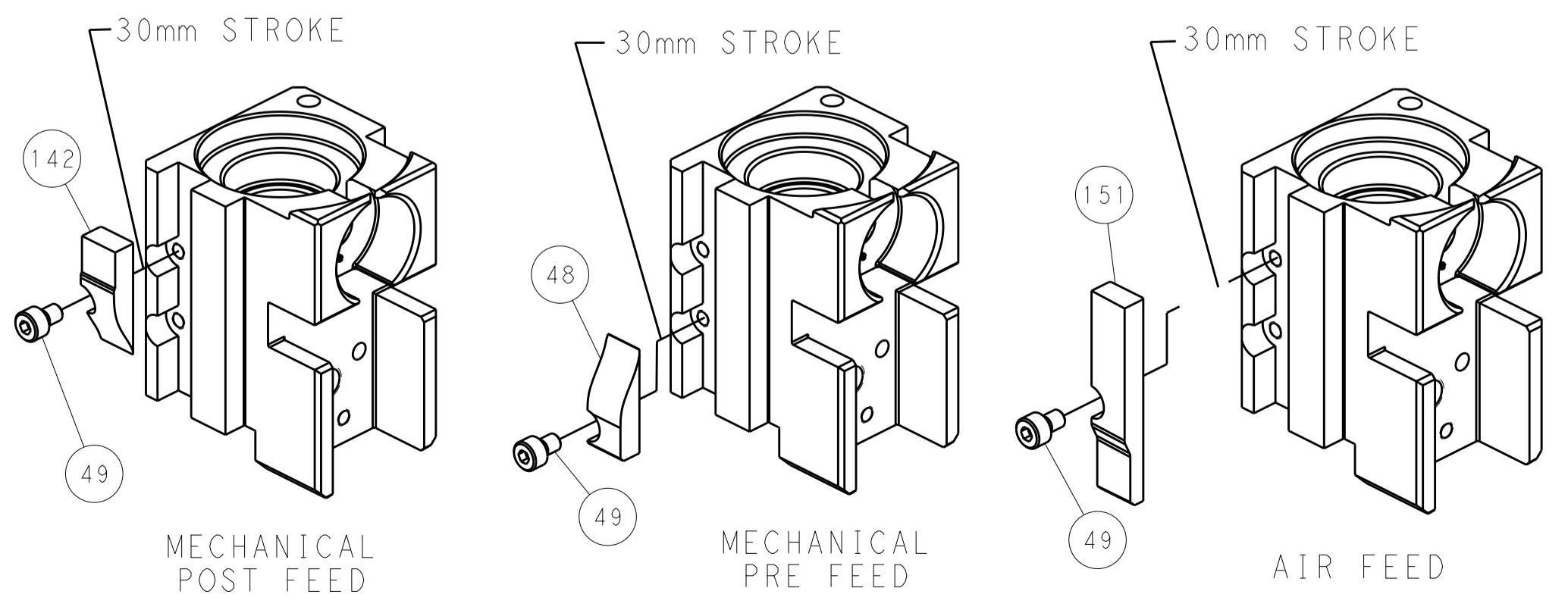
SERVO LATCH PLATE



SERVO FEEDER NOT INCLUDED
 DOUBLE ACTING PNEUMATIC WITH SENSORS



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: | | DWG: C. MOYER 24AUG2011 | | REV: T. ELBIN 24AUG2011 | | NAME: Ocean Side Feed Applicator | |
| mm | 0 PLC | ± | | SIZE | CAGE CODE | DRAWING NO | RESTRICTED TO | | |
| | 1 PLC | ± | | SCALE | | | | | |
| | 2 PLC | ± | | WEIGHT | | | | | |
| | 3 PLC | ± | | MATERIAL | | | | | |
| | 4 PLC | ± | | FINISH | | | | | |
| | ANGLES | ± | | Customer Accessible Production Drawing | | SCALE | SHEET | OF | REV |
| | | | | A1 00779 C=2151300 | | 1:2 | 4 | 4 | H |