

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151017-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151017-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151017-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151017-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	2151017-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2151017-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151017-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151017-6	C	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
				-	-	-	-	-	-	-	
2151017-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151017-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 1.22 mm [.048]	F	
INSUL 2.03 mm [.080]	F	

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIV MATE-N-LOK PIN CONTACT			
WIRE STRIP LENGTH	INSULATION DIAMETER RANGE		
3.20-4.00 mm [.126-.157 IN]	Ø1.20-1.75 mm [.047-.069 IN]		
TERMINAL APPLICATION SPECIFICATION			
(A)114-5050	(C)114-1111		
(B)114-16017	-		

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 170359-1	(A) 170359-2	(A) 170359-3	(A) 170359-4
(A) 1-170359-2	(A) 1-170359-3	(A) 170361-1	(A) 170361-2
(A) 170361-3	(A) 170361-4	(A) 170361-5	(A) 170361-6
(A) 1-170361-3	-	-	-

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: MINI UNIV MATE-N-LOK PIN CONTACT			
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3.20-4.00 mm [.126-.157 IN]	Ø1.20-1.75 mm [.047-.069 IN]		
TERMINAL APPLICATION SPECIFICATION			
(B)114-16017	(C)114-1111		
-	-		

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(B) 1-770901-0	(B) 770901-1	(B) 770901-2	(B) 770901-3
(C) 1-794218-0	(C) 794218-1	(C) 794218-2	(C) 794218-3
(B) 770902-4	(B) 770902-1	(B) 770902-2	(B) 770902-3
(B) 1-770902-1	(B) 770902-5	(B) 770902-6	(B) 1-770902-0
(C) 1-794219-0	(C) 794219-1	(C) 794219-2	(C) 794219-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.34mm2	0.78+/-0.05 [.031+/- .002]	8.2
24 AWG OR 0.22mm2	0.69+/-0.05 [.027+/- .002]	9.1
26 AWG OR 0.14mm2	0.63+/-0.05 [.025+/- .002]	9.8

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26 AWG	0.63+/-0.05 [.025+/- .002]	9.8

- 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: 8-2151017-4
  - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151017-4
  - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151017-5
  - SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151017-6
- 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 50 & 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 ITEM 37.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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

**\*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	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-77	-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)

SET UP GAUGE	LOC	DIST	REVISIONS					
2119599-1	A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
			C		ECR-16-001720	03FEB2016	MR	GB

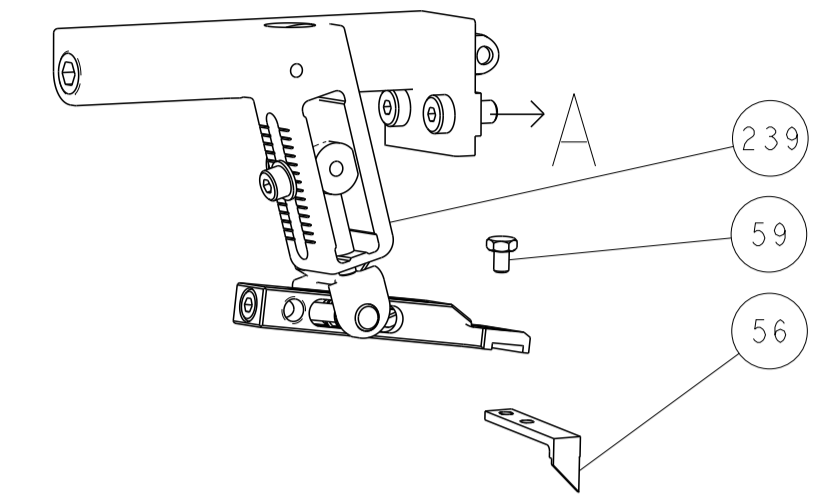
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	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
-	1	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
-	1	1	1	1	1	1752353-2	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	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	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	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	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
-	1	1	1	1	1	1-1752354-5	STANDOFF, HOLD-DOWN	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	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	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	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	1752356-1	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1320908-3	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1	1333225-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1-238011-3	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	1-2119582-9	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	2
-	1	1	1	1	1	568176-6	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL:		FINISH:		WEIGHT:	
mm	0 PLC	±							
	1 PLC	±							
	2 PLC	±							
	3 PLC	±							
	4 PLC	±							
	ANGLES	±							
	FINISH	±							

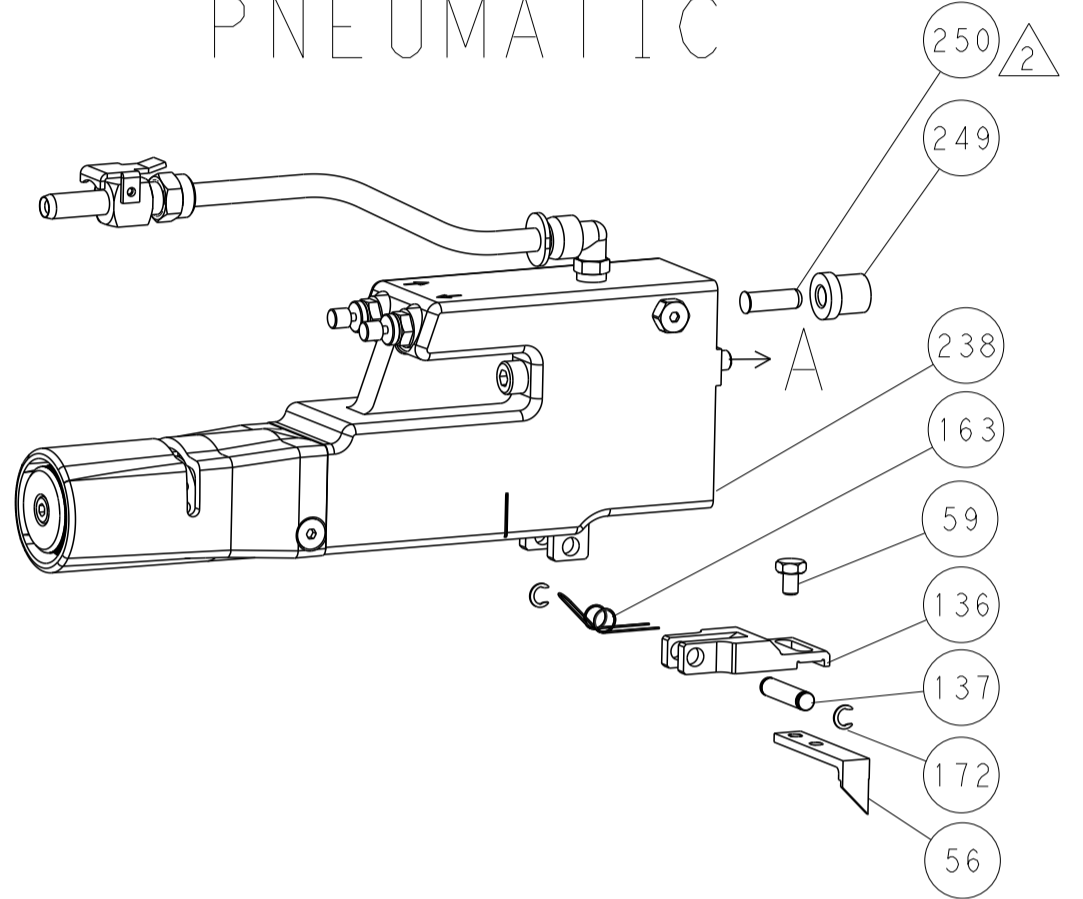
OWN	H. HUANG	09NOV2011	CHK	S. XI	09NOV2011	APVD	J. CRUZ	09NOV2011
NAME		Ocean Side Feed Applicator		SIZE		CAGE CODE		DRAWING NO
				A1		00779		©=2151017
RESTRICTED TO		Customer Accessible Production Drawing		SCALE		SHEET		1 OF 4
				REV				

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

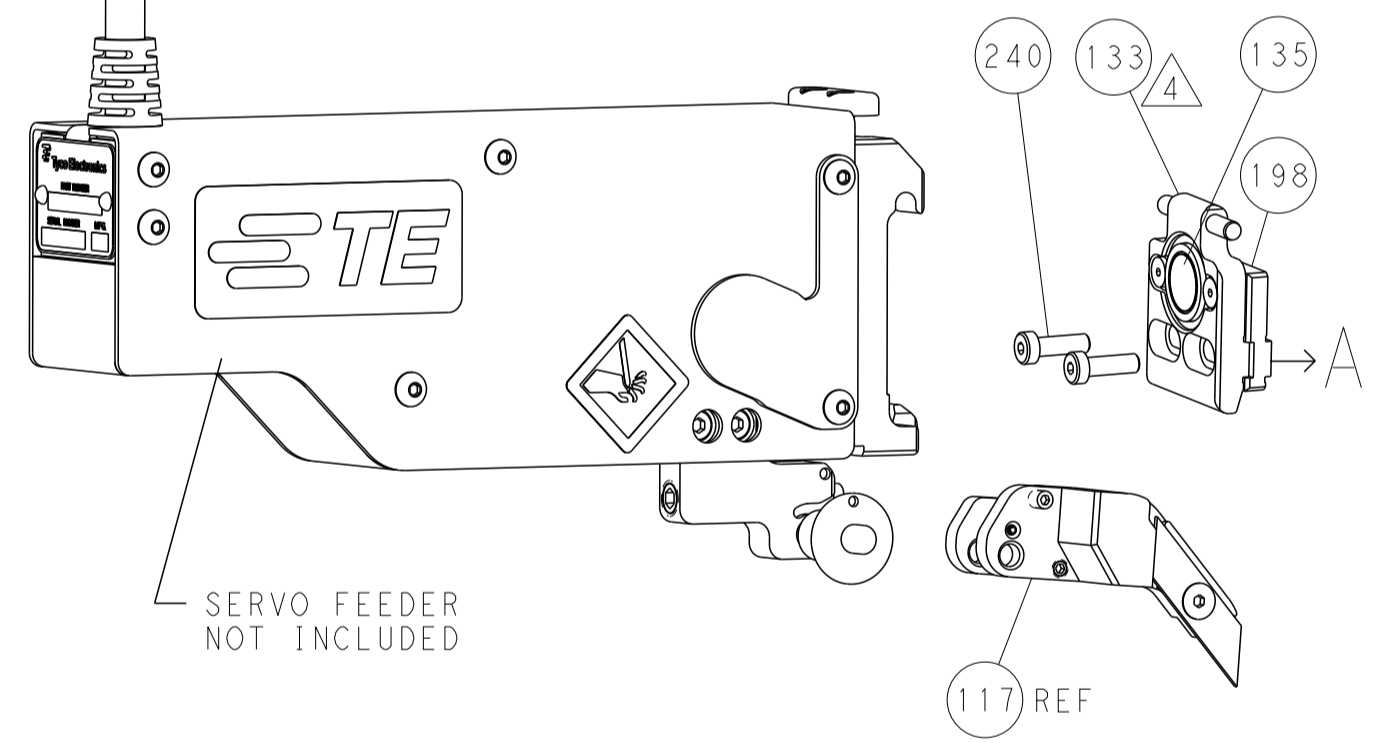
### FEED TYPE MECHANICAL



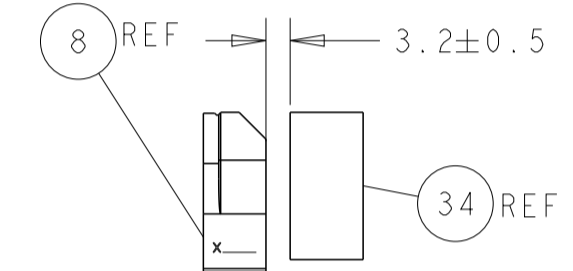
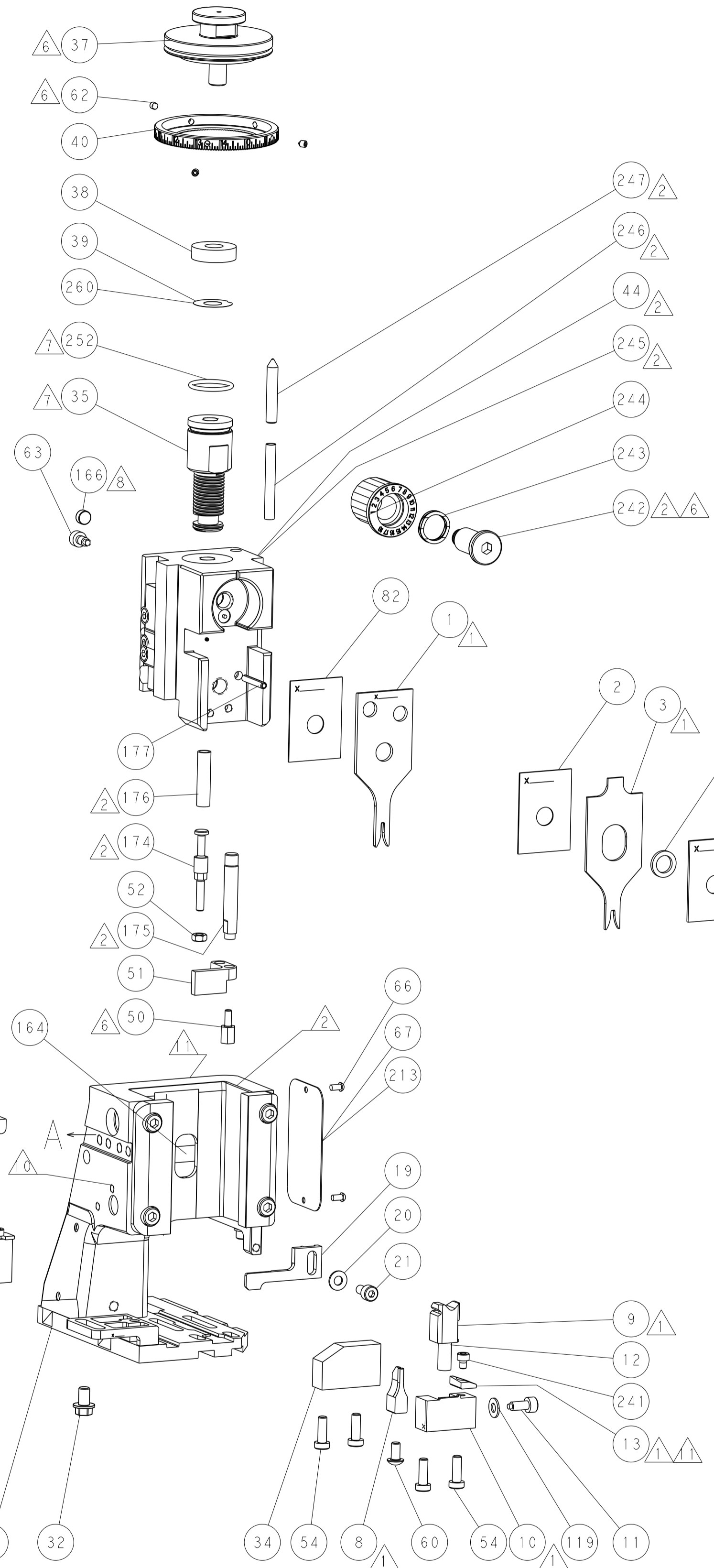
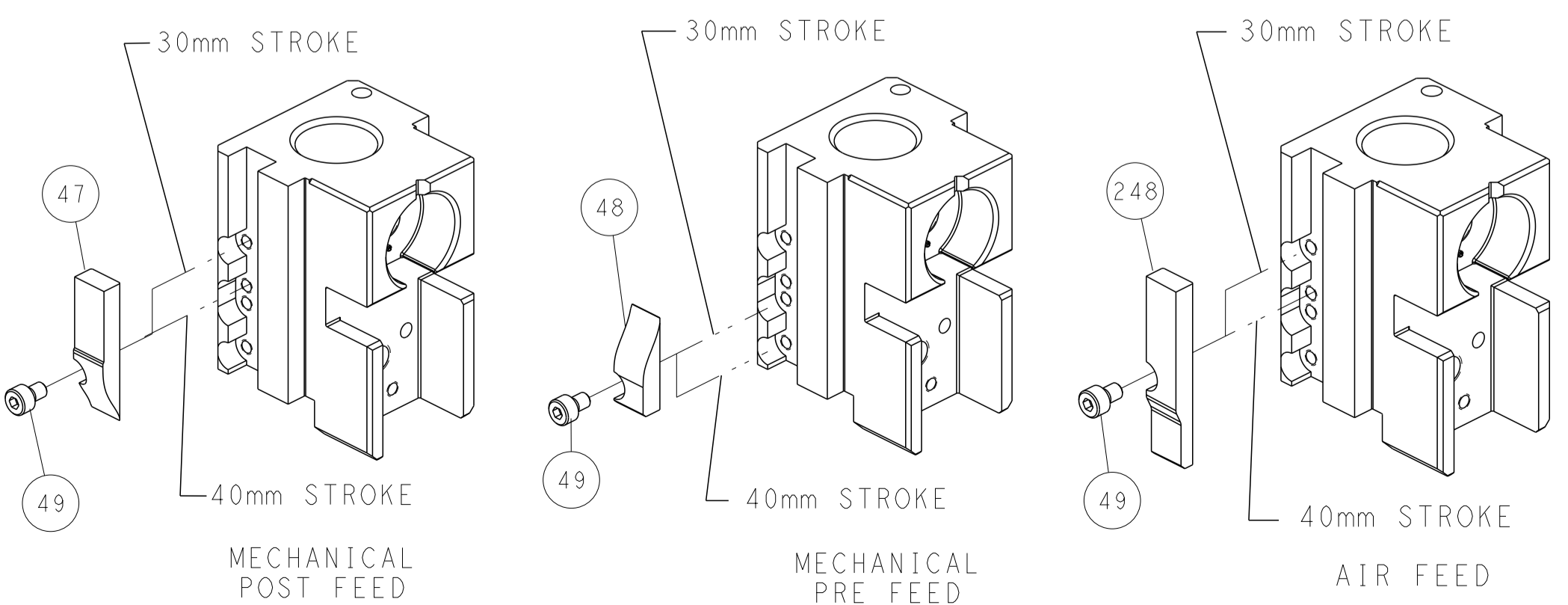
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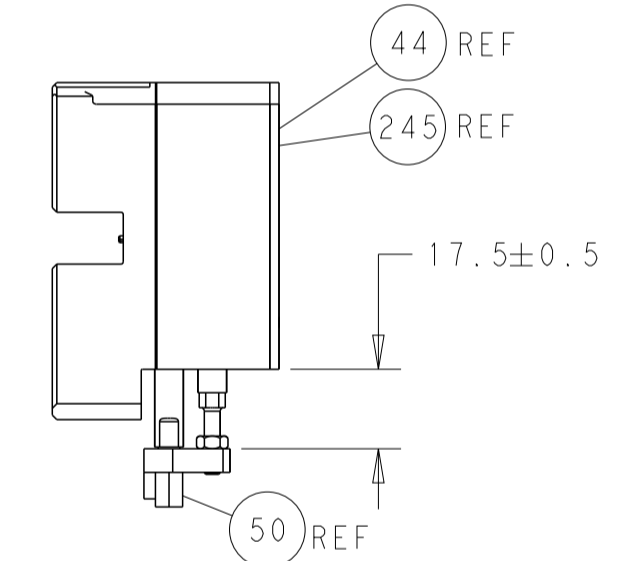
### SERVO LATCH PLATE



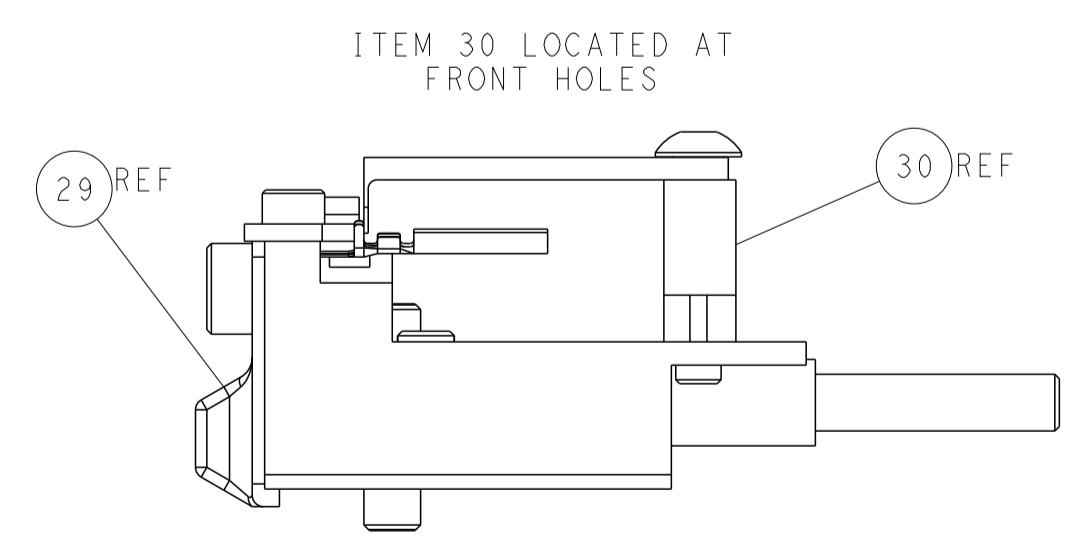
### CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DMN: H. HUANG 09NOV2011 CHK: S. XI 09NOV2011 APVD: J. CRUZ 09NOV2011	NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151017	TE Connectivity Harrisburg, PA 17105-3608
DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	WEIGHT: - SCALE: 1:2 SHEET: 2 of 4 REV: C	RESTRICTED TO: - Customer Accessible Production Drawing		

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
	2-2151017-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	SERVO LATCH PLATE	2119951-1	-	8-2151017-5	1901094-3	-	2168400-6 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2151017-4	-	-		
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	
	2-2151017-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151017-5	1901094-3	-	2168400-6 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2151017-4	-	-		
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	
	2-2151017-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	2119951-1	-	8-2151017-5	1901094-3	-	-		
	2-2151017-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-		
	7-2151017-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-		

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 1.22 mm [.048]	F	
INSUL 2.03 mm [.080]	F	
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(A) 170361-3	(A) 170361-4	(A) 170361-5	(A) 170361-6
(A) 1-170361-3	-	-	-

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(B) 1-770901-0	(B) 770901-1	(B) 770901-2	(B) 770901-3
(C) 1-794218-0	(C) 794218-1	(C) 794218-2	(C) 794218-3
(B) 770902-4	(B) 770902-1	(B) 770902-2	(B) 770902-3
(B) 1-770902-1	(B) 770902-5	(B) 770902-6	(B) 1-770902-0
(C) 1-794219-0	(C) 794219-1	(C) 794219-2	(C) 794219-3

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
22 AWG OR 0.34mm2	0.78+/-0.05 [.031+/-0.002]	8.2
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- 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: 8-2151017-4  
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151017-4  
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151017-5
- 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 50 & 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.
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 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
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249

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

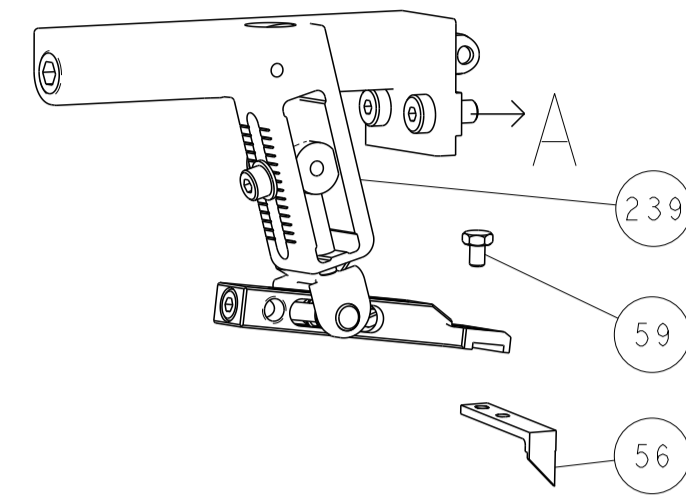
SET UP GAUGE	LOC	DIST	REVISIONS					
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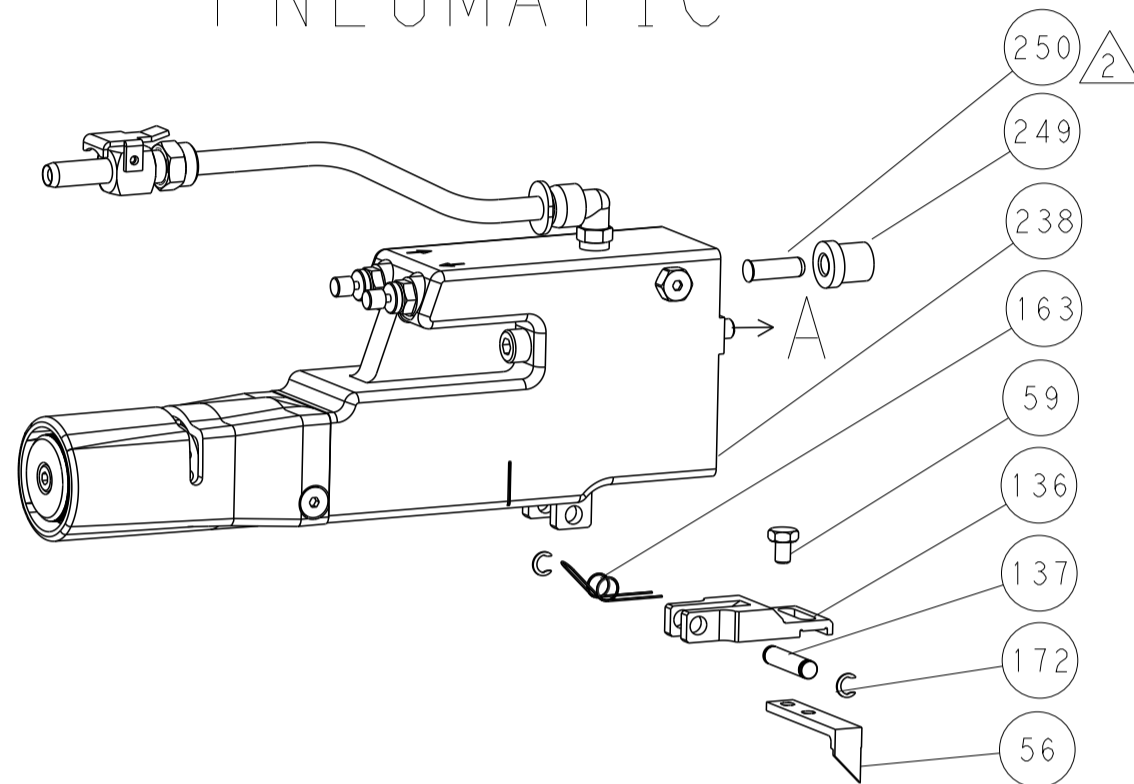
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DRAWING NO		RESTRICTED TO	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±	FINISH ±
MATERIAL				WEIGHT	SIZE	CAGE CODE	DRAWING NO
					A1	00779	©=2151017
Customer Accessible Production Drawing				SCALE	1:2	SHEET	3 OF 4

LOC	DIST	REVISIONS					
A	66	P	LYN	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

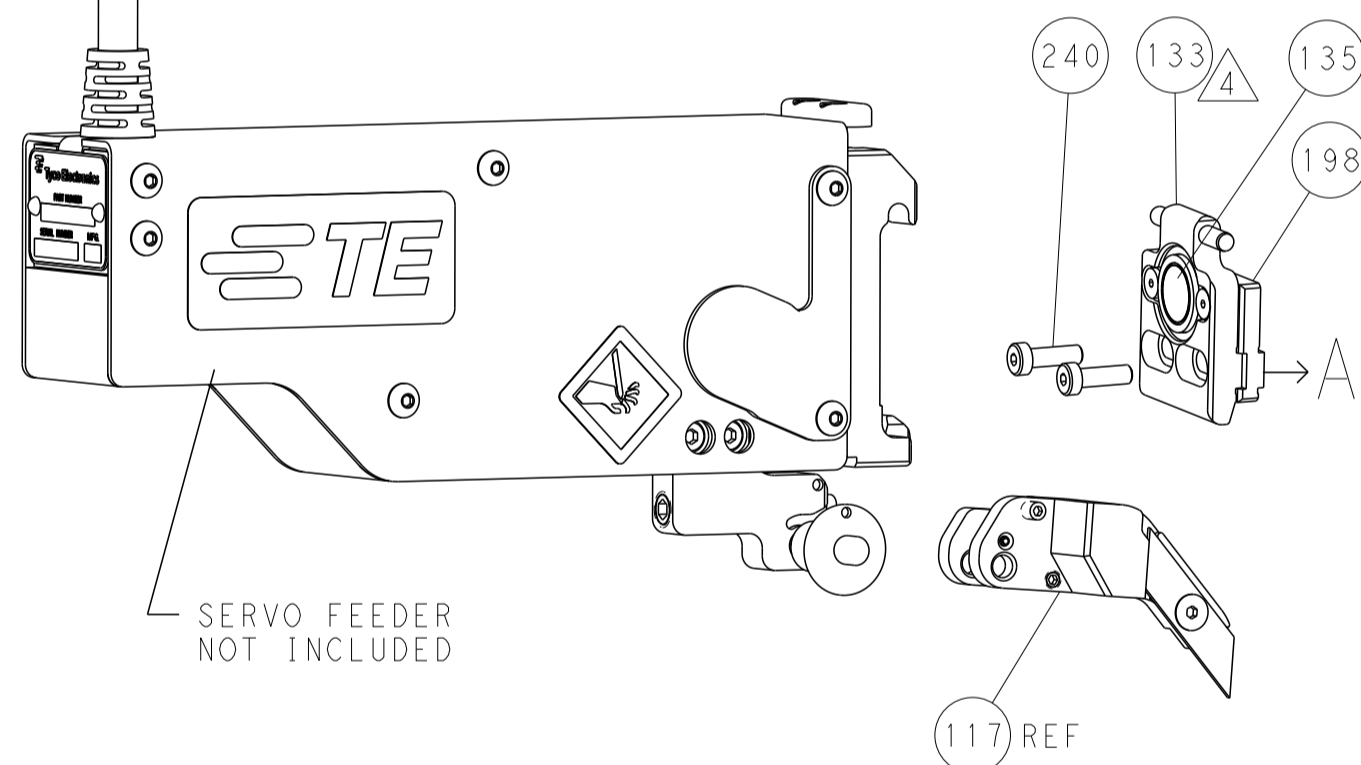
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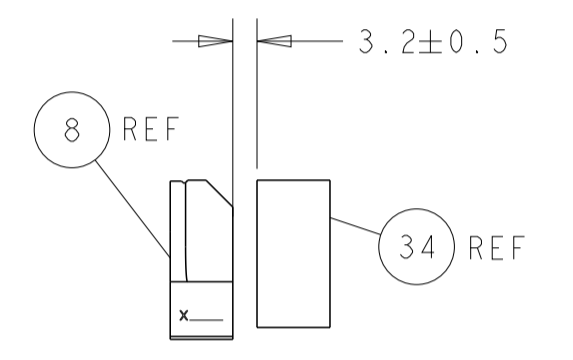
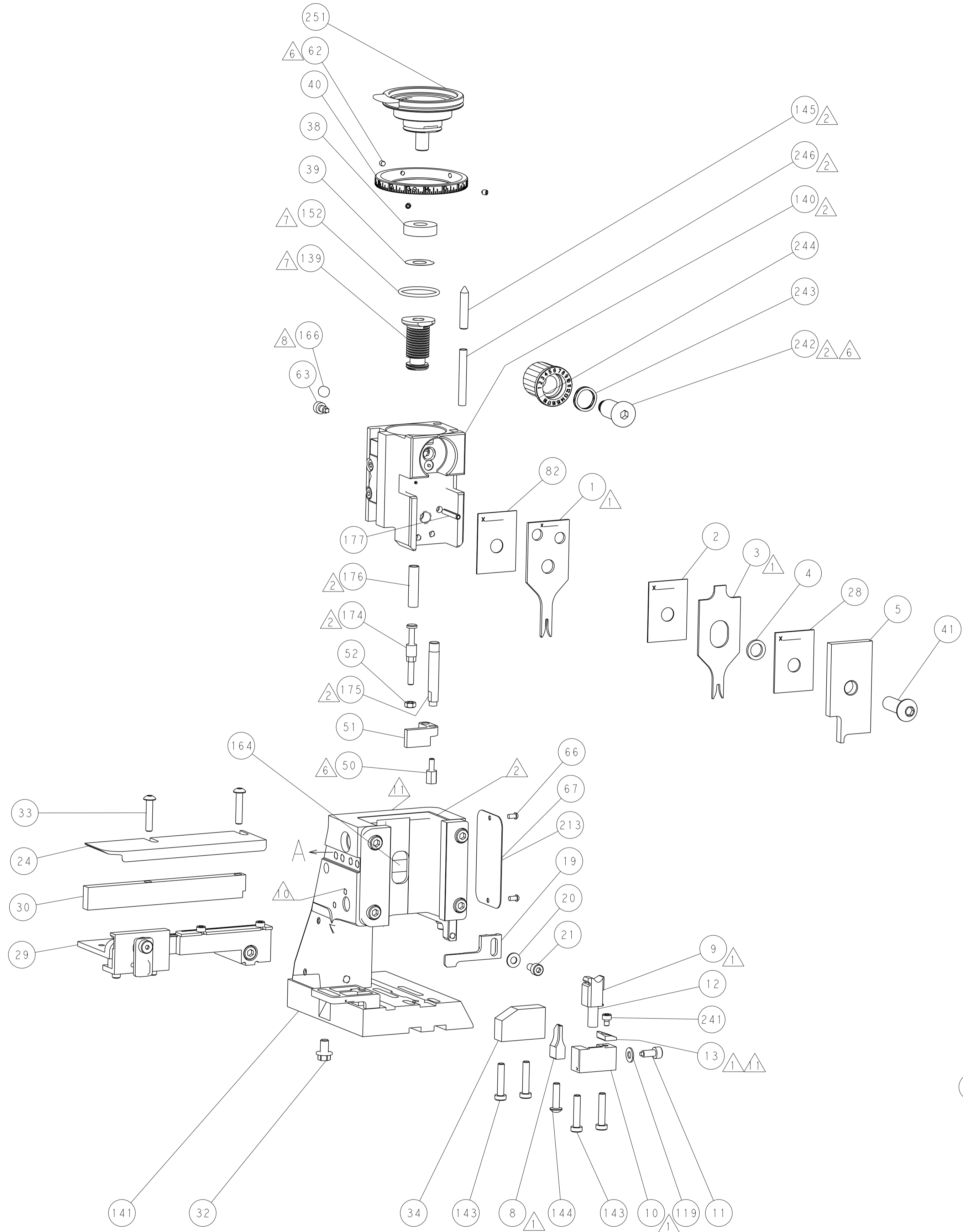
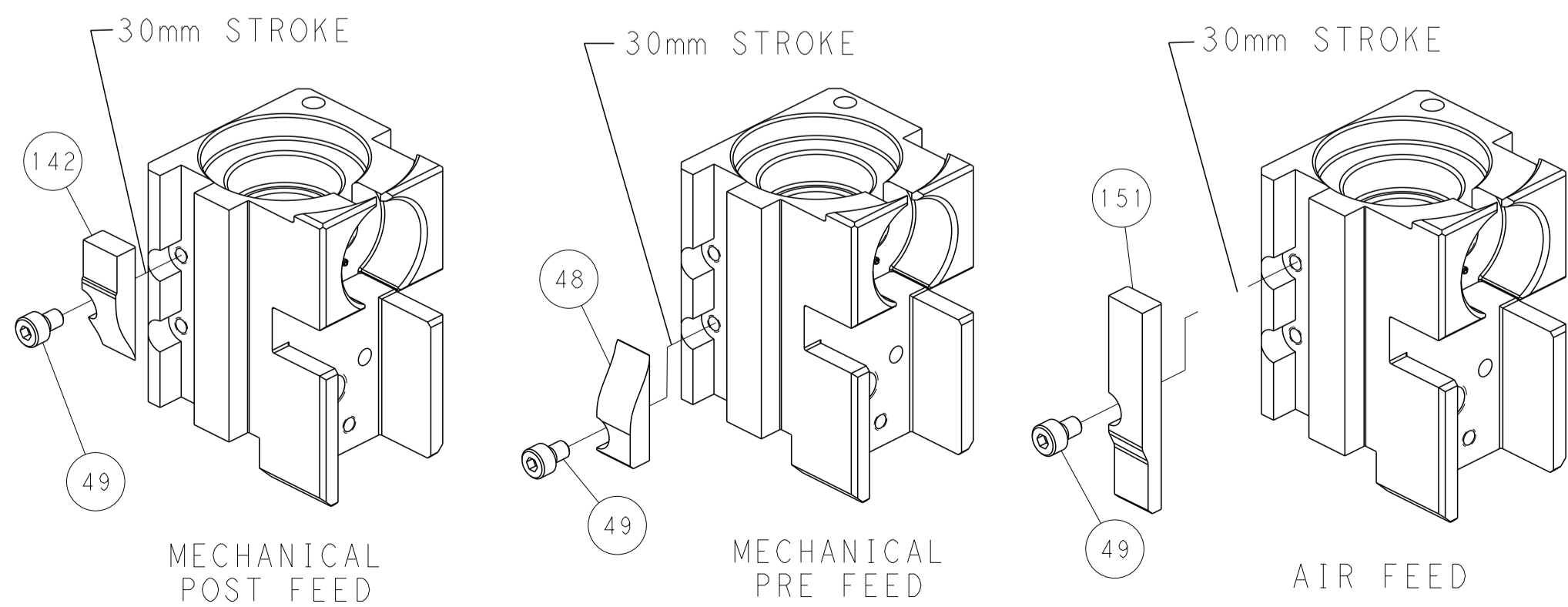
# PNEUMATIC



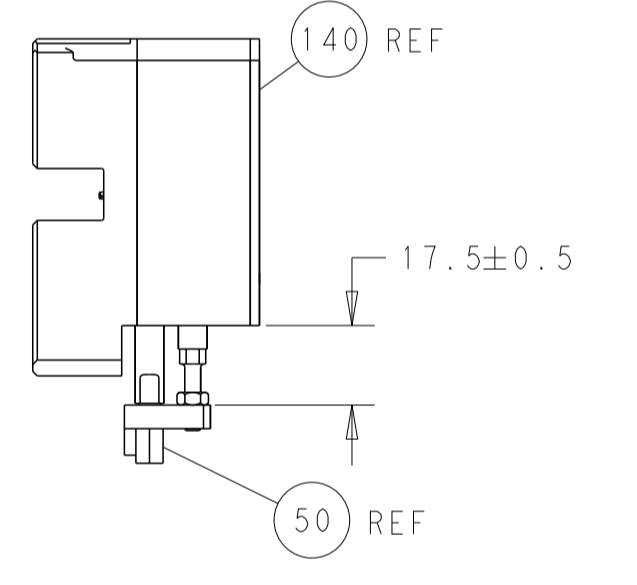
# SERVO LATCH PLATE



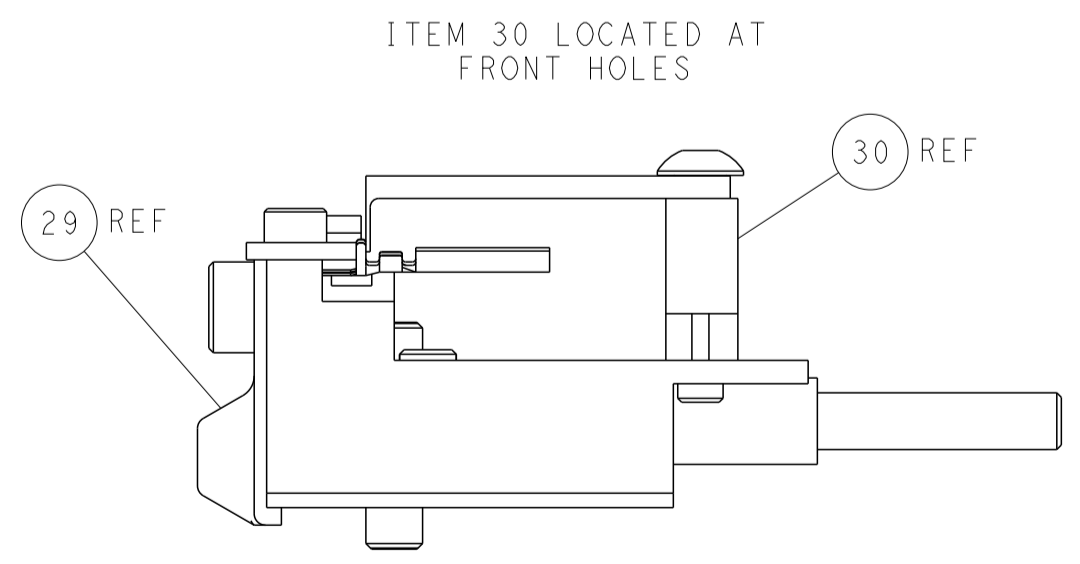
# CAM POSITIONS



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)

DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH ±		DWN R. HUANG 09NOV2011 CHK S. XI 09NOV2011 APVD J. CRUZ 09NOV2011 PRODUCT SPEC APPLICATION SPEC WEIGHT Customer Accessible Production Drawing		NAME Ocean Side Feed Applicator SIZE CAGE CODE DRAWING NO A1 00779 C=2151017 SCALE 1:2 SHEET 4 OF 4 REV C		RESTRICTED TO - - -	
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