

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | |
|-----------------------------------------------|-------------|--------------------------|--------------------------|-------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-------------|------------------------|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | |
| | 2151921-1 | A | 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 | - | 8-2151921-5 | 1901094-3 | 2-1752354-4 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151921-4 | - | - | - |
| | 2151921-2 | A | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151921-5 | 1901094-3 | 2-1752354-4 | 2168400-6 (QUANTITY 2) |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151921-4 | - | - | - |
| | 2151921-5 | A | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | 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 | |
| 2151921-6 | A | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | - | - | - | - | - | - | - | |
| 2151921-7 | A | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | |
| 7-2151921-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | |

| APPLICATOR DATA | | |
|-----------------------------------|------|------|
| CRIMP WIRE | SIZE | TYPE |
| 1.57 mm [0.062] | | F |
| 2.29 mm [0.090] | | O |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | TE CRIMP SPECIFICATION |
|---------------------------------------------------|------------------------------------------------------------|
| TERMINAL NAME: TAB 2.8 x 0.8 | |
| WIRE STRIP LENGTH 3.20-3.80 mm [0.126-.150 IN] | INSULATION DIAMETER RANGE Ø1.15-1.60 mm [0.045-.063 IN] |
| TERMINAL APPLICATION SPECIFICATION 114-18051 | |
| TERMINALS APPLIED | |
| TE TERMINAL | TE TERMINAL |
| 1-963860-1 | 1-963860-2 |
| 2-963860-2 | 1-963860-3 |
| | 2-963860-1 |

| WIRE SIZE | CRIMP HEIGHT mm [INCH] | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-----------------------------|--------------------------------|
| 0.50mm2 | 1.12+/-0.03 [0.044+/-0.001] | 6.1 |
| 0.35mm2 | 1.05+/-0.03 [0.041+/-0.001] | 6.8 |
| 0.25mm2 | 1.00+/-0.03 [0.039+/-0.001] | 7.5 |
| 0.20mm2 | 0.98+/-0.03 [0.039+/-0.001] | 7.6 |

- 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: 8-2151921-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151921-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151921-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151921-6
- 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 ITEMS 62, 180 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 180 & 242.
- 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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.68.

***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 | 1 | 1803078-4 | SPACER, PRECISION | 259 |
| - | 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 |
| - | 1 | - | 1 | 1 | 1 | 2119798-1 | DETENT PIN | 247 |
| - | 1 | - | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| -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)

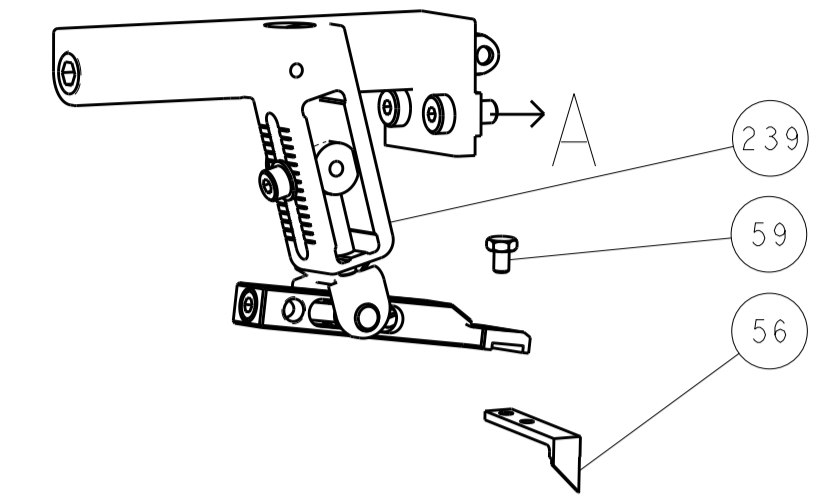
| SET UP GAUGE | LOC | DIST | REVISIONS | | | | |
|--------------|-----|------|-----------|-------------|-----------|-----|------|
| 2119599-1 | A | 66 | P LTR | DESCRIPTION | DATE | OWN | APVD |
| | | | A | RELEASED | 20MAY2013 | RK | GB |

| | | | | | | | | |
|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | - | 1 | - | - | - | 2161314-1 | RAM, STEPPED, ATLANTIC, SF, NON-ADJ | 245 |
| - | 1 | 1 | 1 | 1 | 1 | 2119082-8 | 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 | 2-1752354-4 | STANDOFF, HOLD-DOWN | 180 |
| - | 1 | 1 | 1 | 1 | 1 | 6-993111-6 | PIN, SLOTTED SPRING 3.0 X 14.0 | 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 | 455888-4 | SPACER, CRIMPER | 82 |
| - | 2 | 2 | 2 | 2 | 2 | 2168083-1 | SCR, SKT HD CAP, RoHS, M3 X 8.0 | 77 |
| - | 1 | 1 | 1 | 1 | 1 | 1633782-2 | FENCE | 76 |
| - | 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 | 1901681-5 | HOLDDOWN, TERMINAL | 51 |
| - | - | - | - | 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 | 2161311-1 | RAM, STEPPED, AMP STYLE, SIDE FEED | 44 |
| - | 1 | 1 | 1 | 1 | 1 | 1-2079383-5 | SCR, BHSC, RoHS (M8 X 40) | 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 | 1-1752356-6 | 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 | 1320908-6 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1 | 2119959-2 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 1-455888-5 | 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 | 2119805-5 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1 | 1 | 1 | 1 | 1-454276-2 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1 | 1 | 1 | 1633216-2 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 2119757-1 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 238011-9 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1 | 1-2119784-8 | CRIMPER, INSULATION O PREMIUM | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-5 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 1 | 1-456403-3 | CRIMPER, WIRE PREMIUM | 1 |
| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

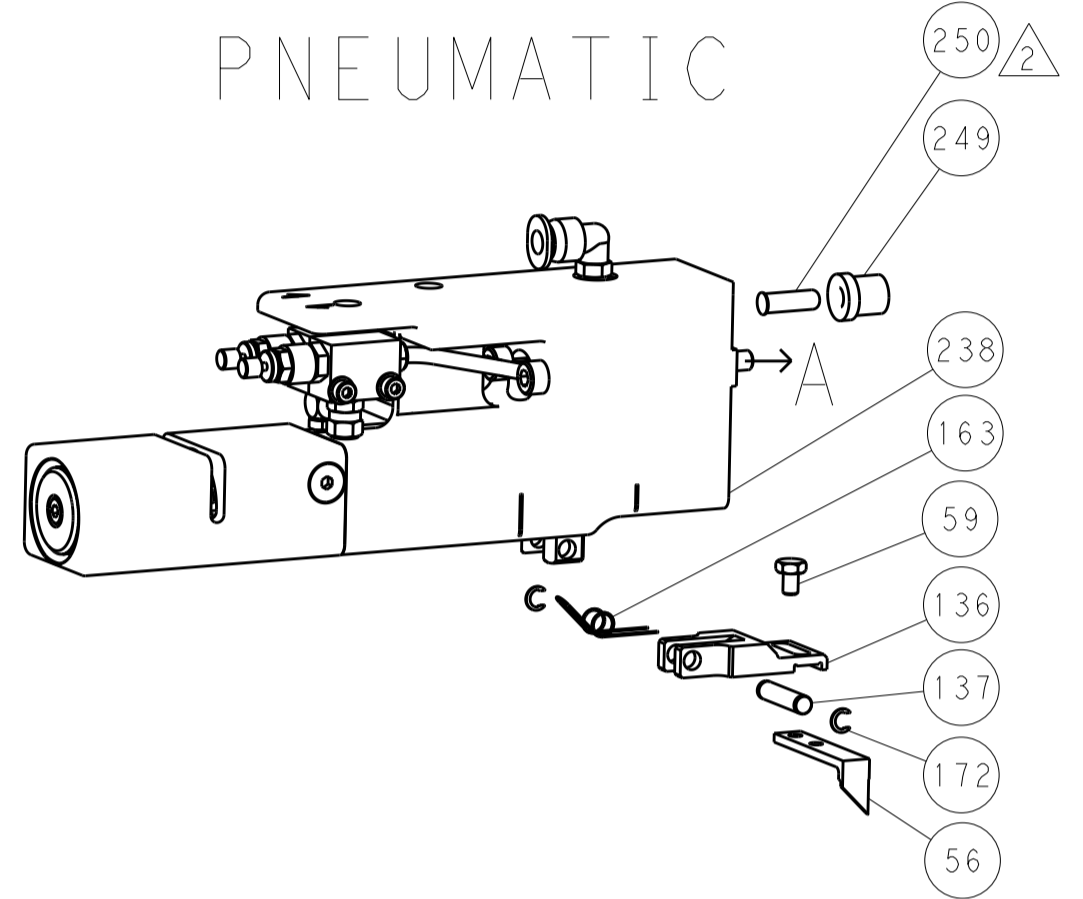
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | OWN | CHK | DATE | NAME | |
|-------------|--------------|----------------------------------------|----------------|--------------|----------|-----------|----------------------------------------|--|
| mm | 0 PLC ±0.1 | 1 PLC ±0.1 | 2 PLC ±0.02 | H. HUANG | L. ZHANG | 09APR2013 | Ocean Side Feed Applicator | |
| | 3 PLC ±0.005 | 4 PLC ±0.0005 | ANGLES ±0.0005 | J. GUO | | 09APR2013 | Customer Accessible Production Drawing | |
| MATERIAL | FINISH | WEIGHT | SCALE | SHEET 1 OF 4 | | REV A | RESTRICTED TO | |

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

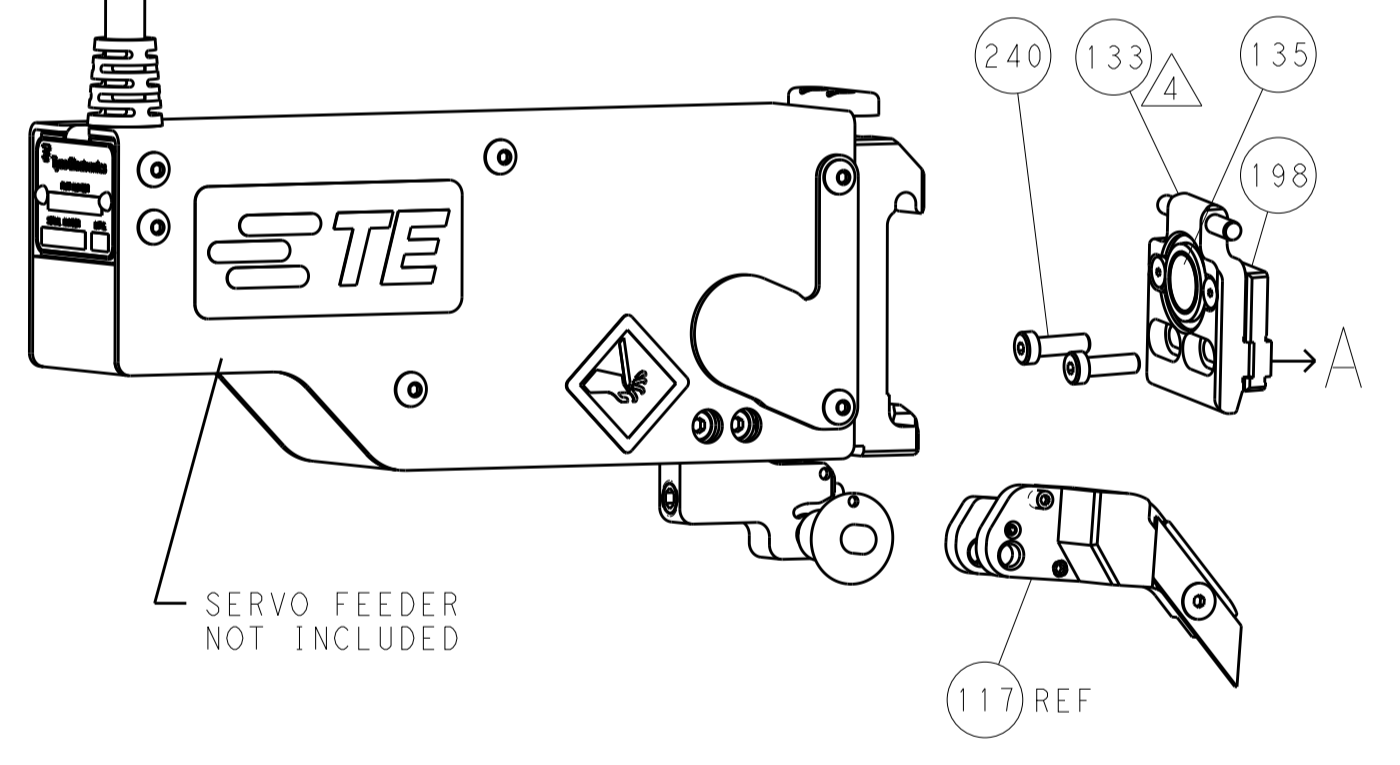
FEED TYPE MECHANICAL



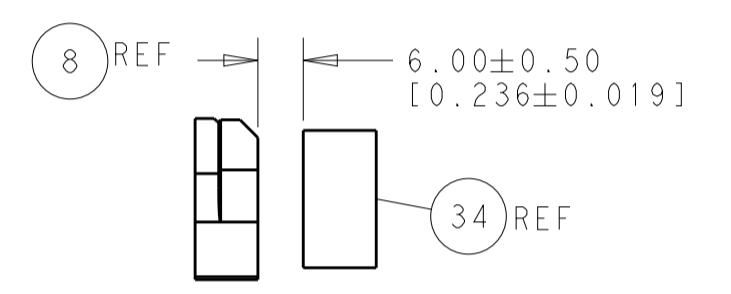
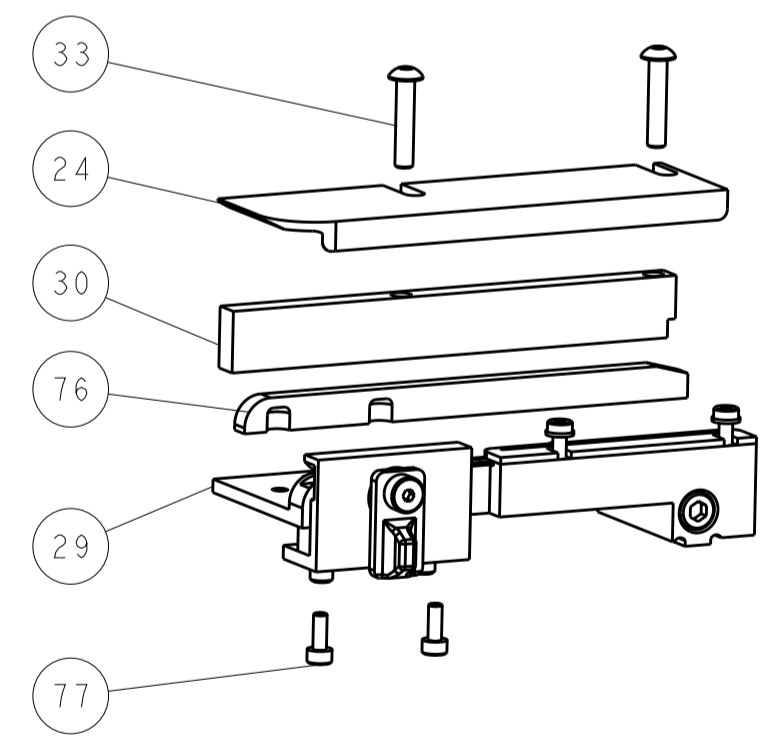
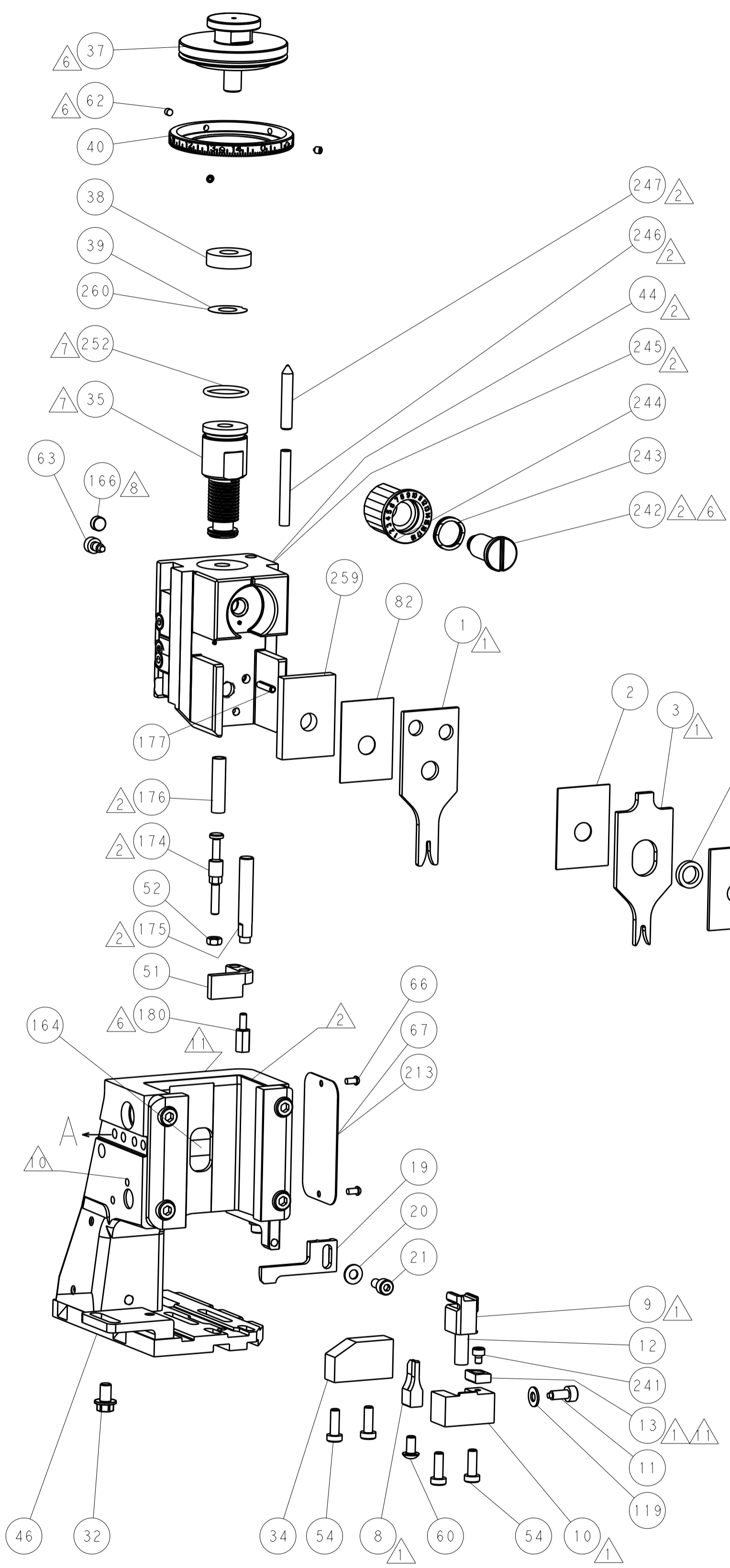
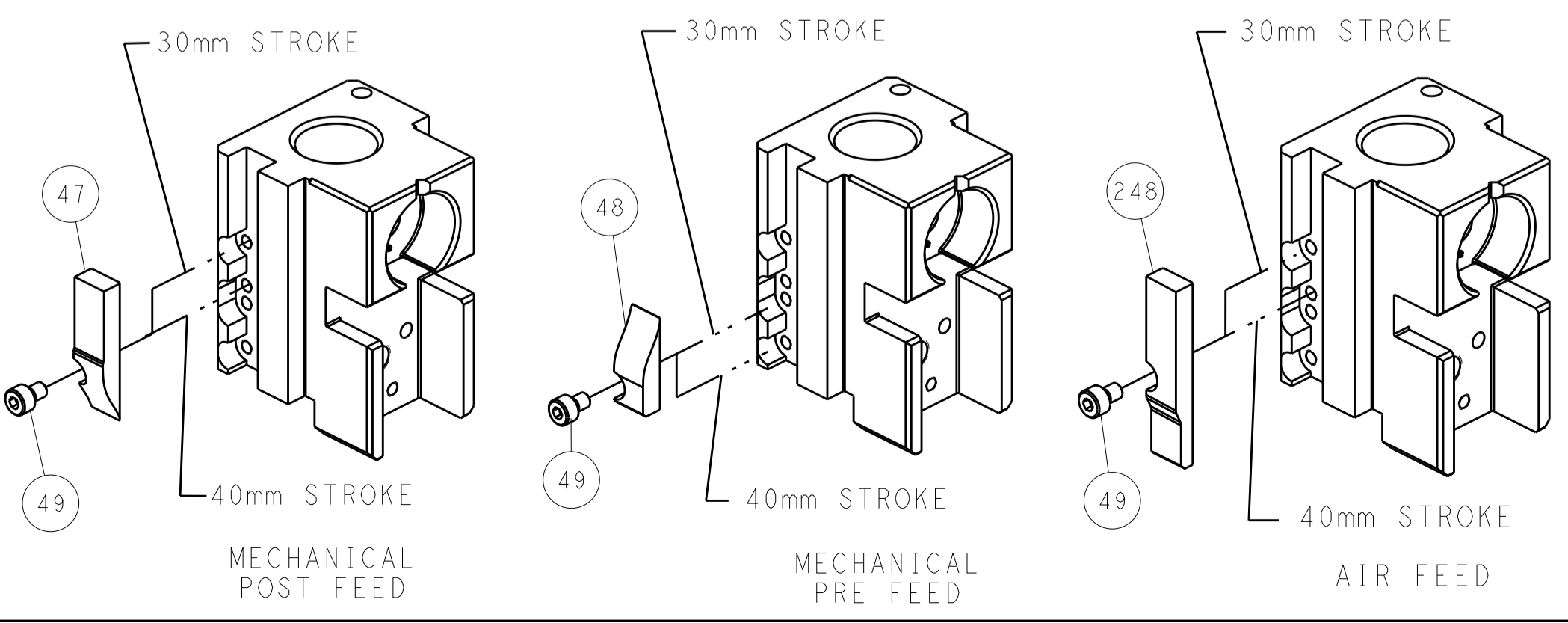
PNEUMATIC



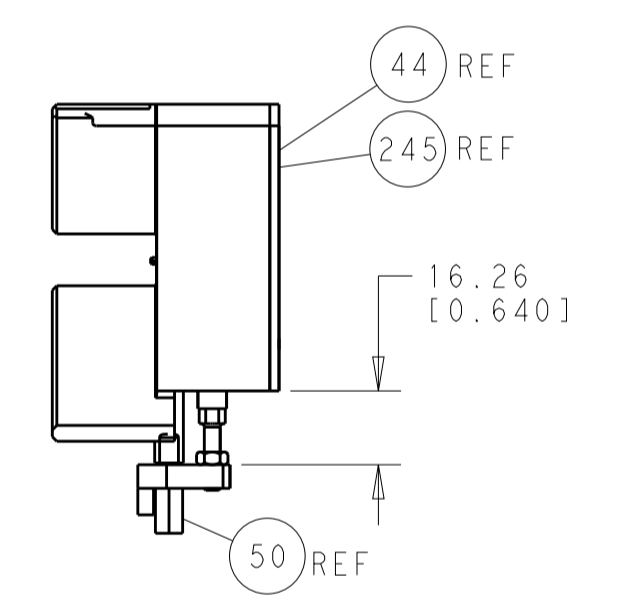
SERVO LATCH PLATE



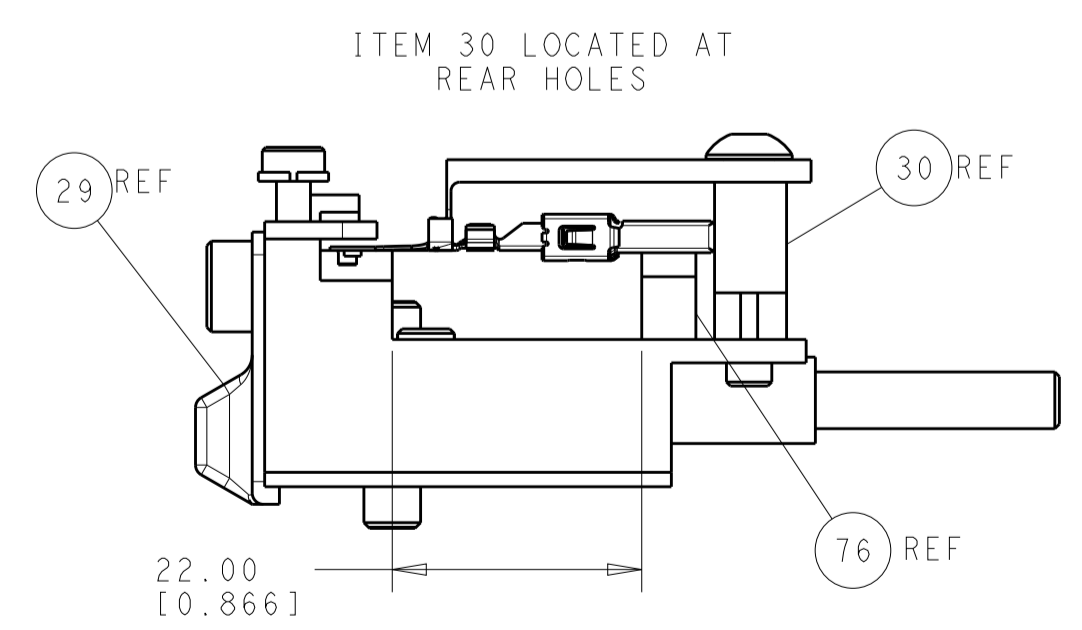
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



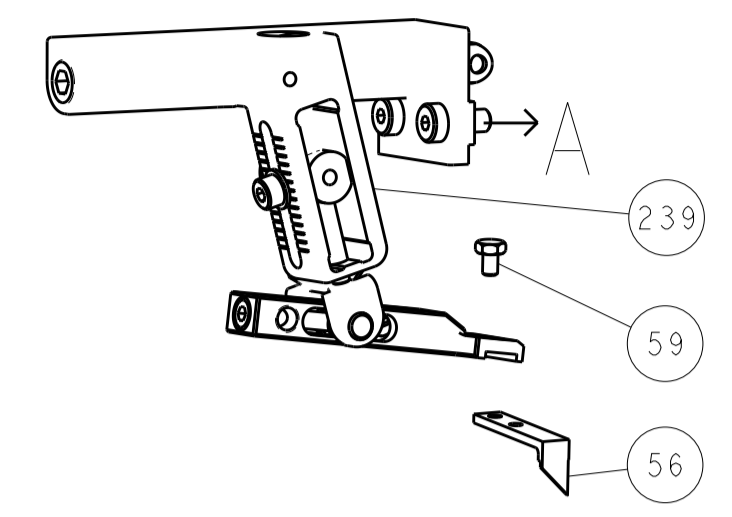
FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

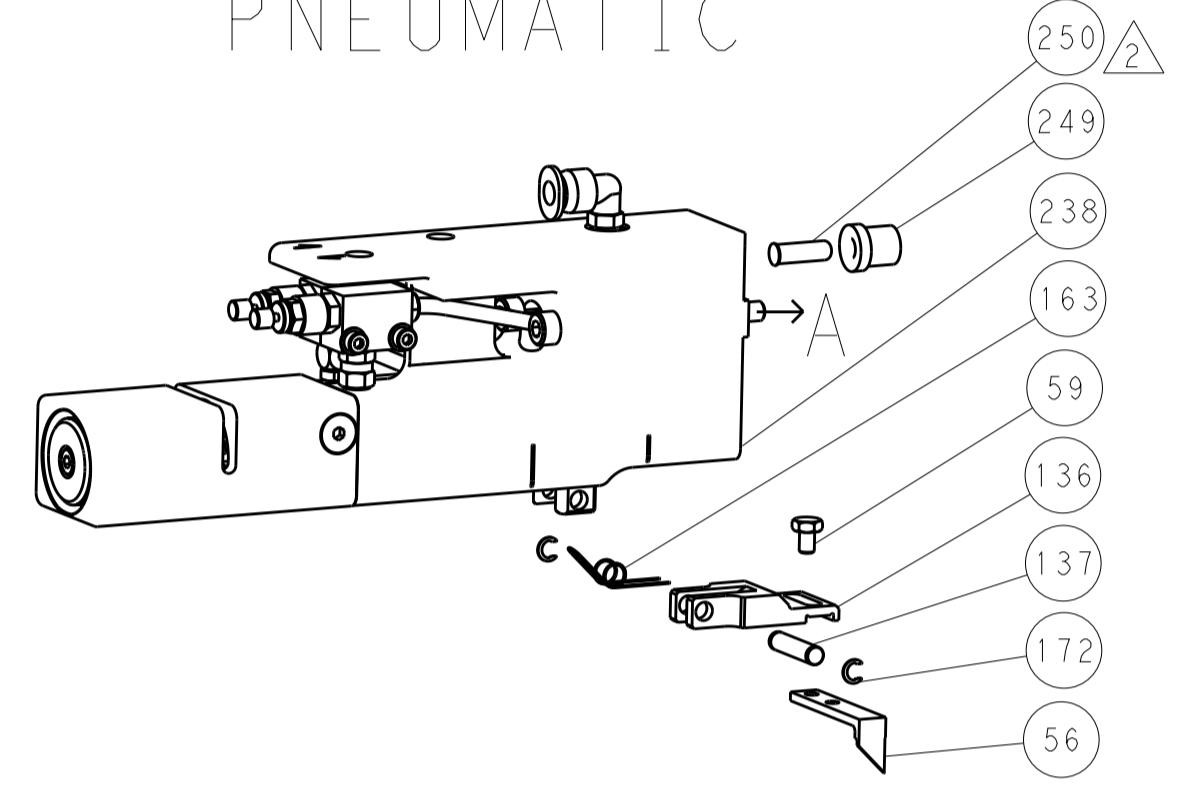
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|-------------|------------|----------------------------------------|-------------|----------------------------------------|---------------|-------------------------------------------------|------------------------------------|
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWN H. HUANG 09APR2013 | | TE Connectivity Harrisburg, PA 17105-3608 | |
| mm | 0 PLC ±0.1 | 1 PLC ±0.1 | 2 PLC ±0.02 | 3 PLC ±0.005 | 4 PLC ±0.0005 | APVD L. ZHANG 09APR2013 | NAME Ocean Side Feed Applicator |
| MATERIAL: | | FINISH: | | WEIGHT: | | SIZE CAGE CODE DRAWING NO A1 00779 C=2151921 | |
| | | | | Customer Accessible Production Drawing | | RESTRICTED TO SCALE 1:1 SHEET 2 OF 4 REV A | |

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

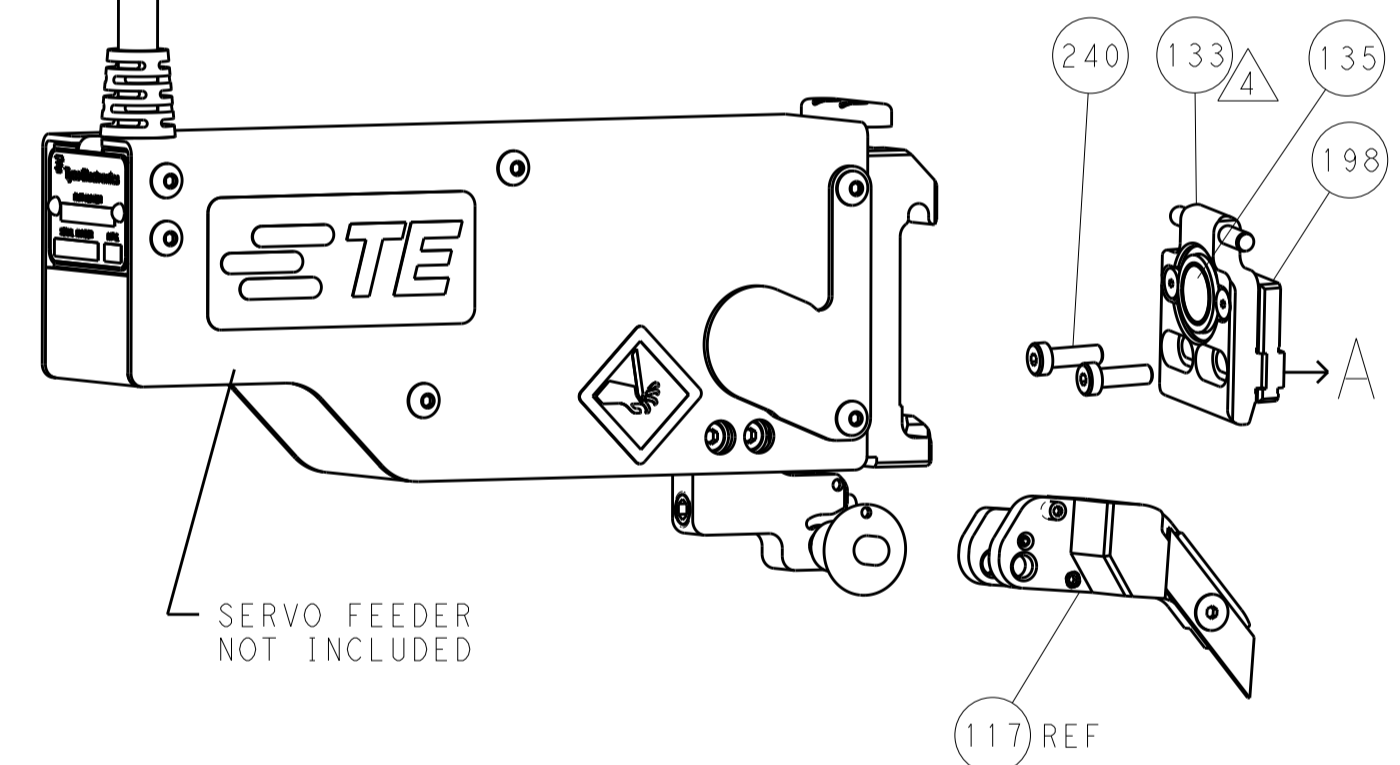
FEED TYPE MECHANICAL



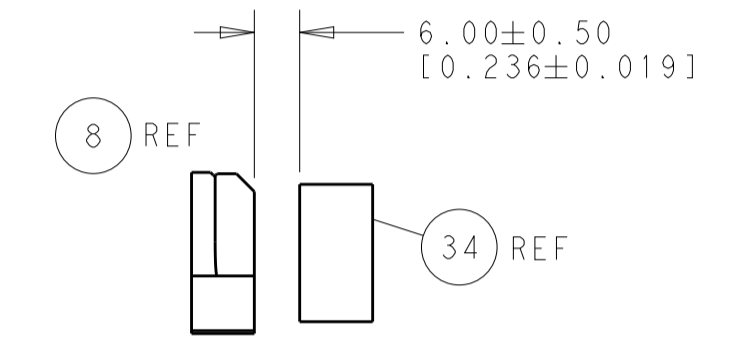
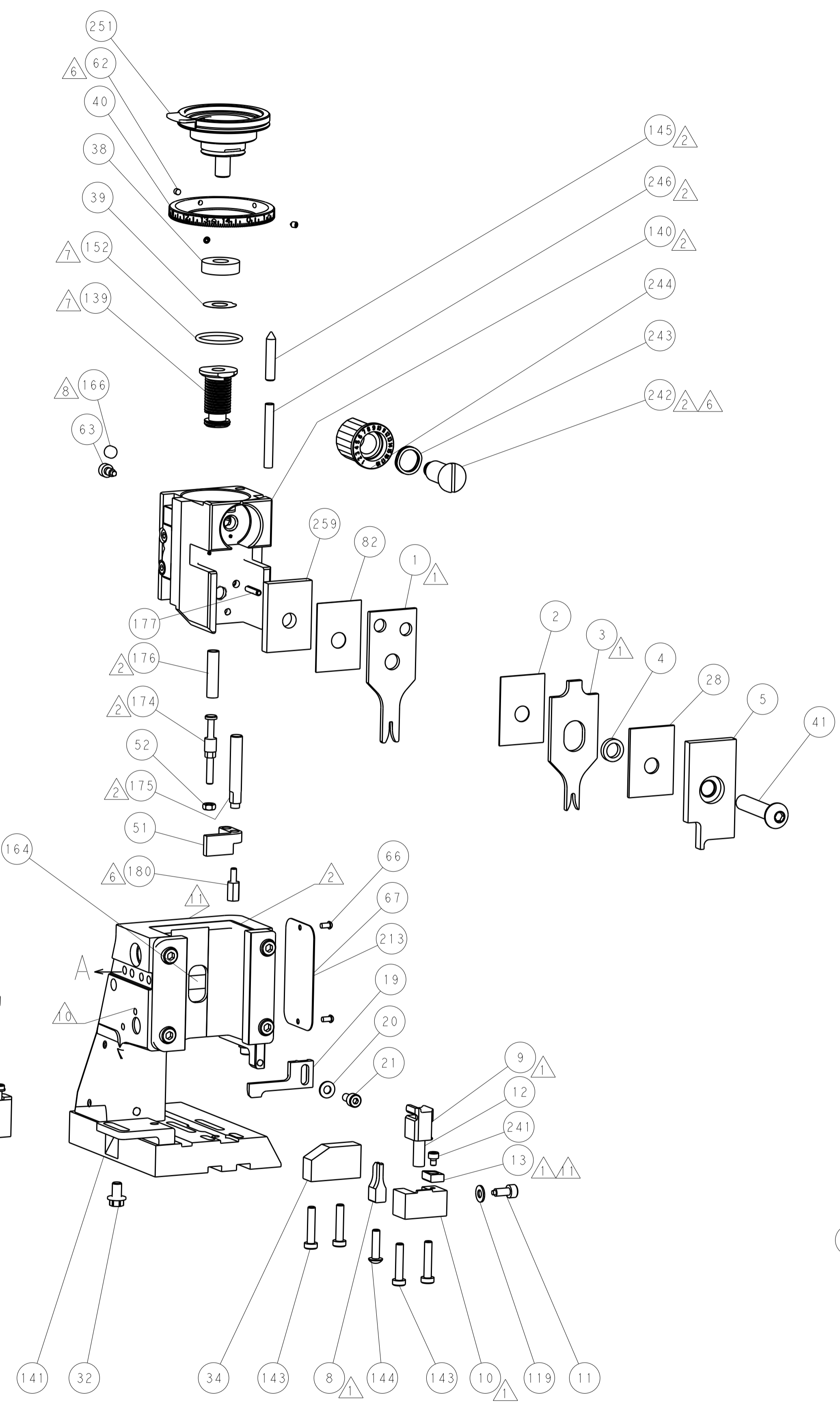
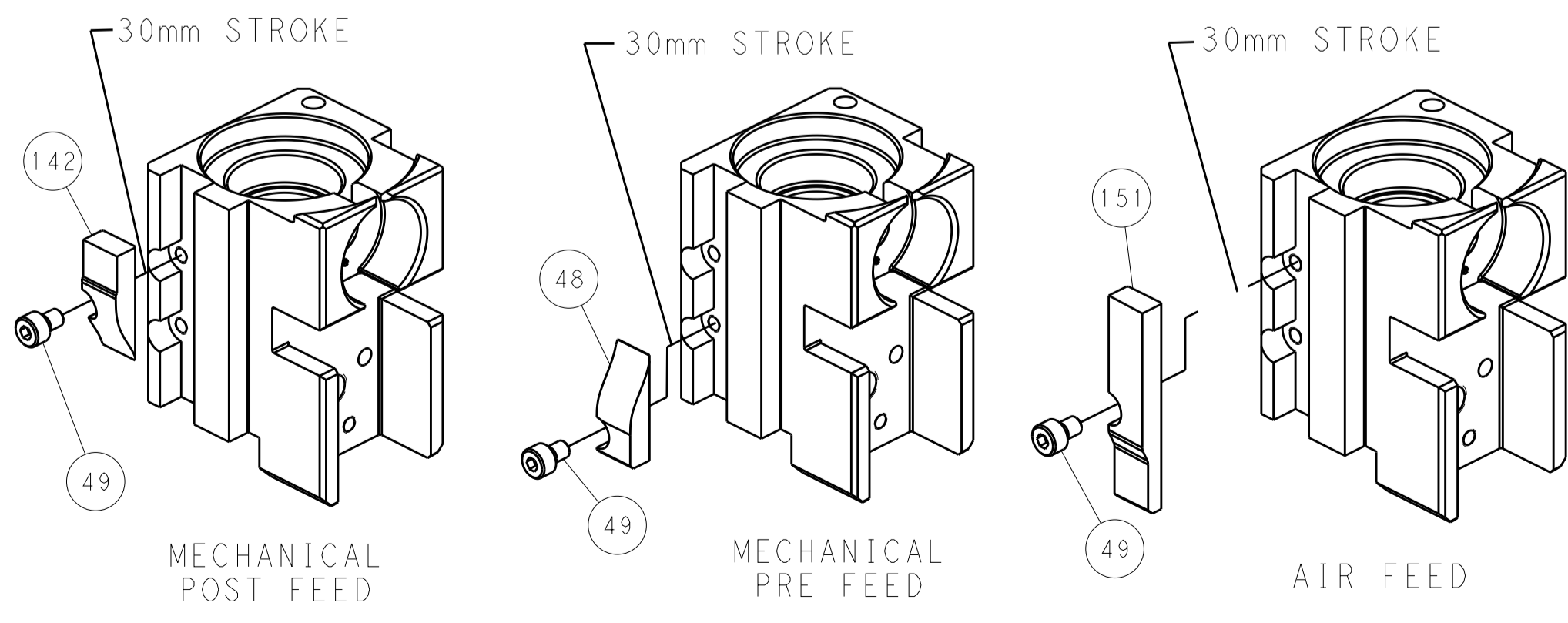
PNEUMATIC



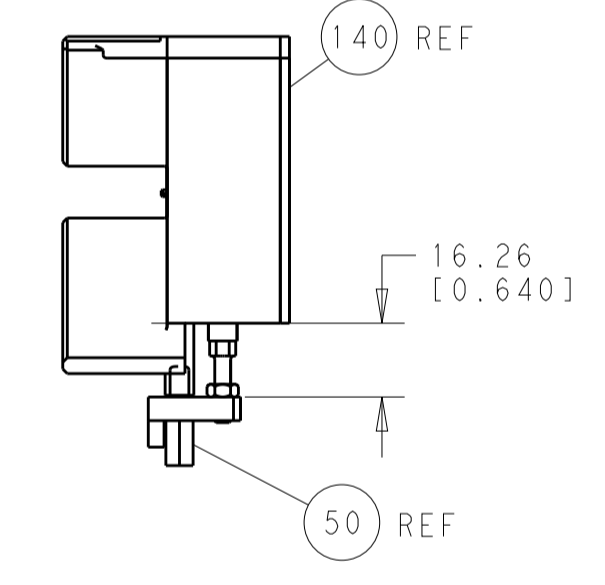
SERVO LATCH PLATE



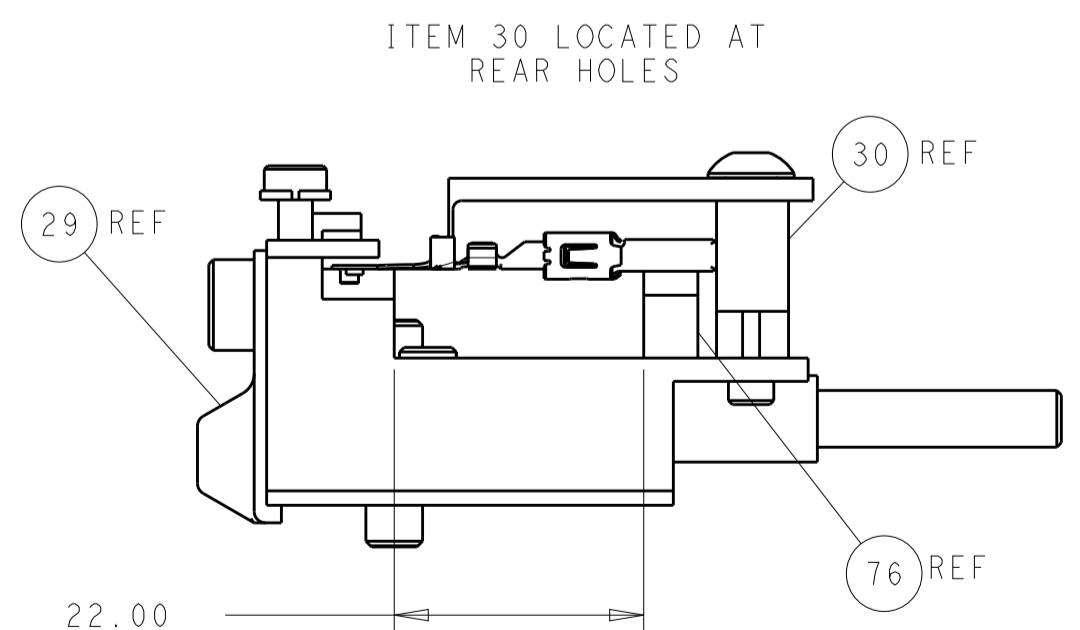
CAM POSITIONS



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: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG: H. HUANG 09APR2013 | | TE Connectivity | |
| mm | 0 PLC ±0.1 | 1 PLC ±0.1 | 2 PLC ±0.02 | 3 PLC ±0.005 | 4 PLC ±0.0005 | ANGLES ± | FINISH |
| MATERIAL: | | FINISH: | | CHK: L. ZHANG 09APR2013 | | NAME: Ocean Side Feed Applicator | |
| APVD: H. GUO 09APR2013 | | PRODUCT SPEC: | | APVD: H. GUO 09APR2013 | | APPLICATION SPEC: | |
| WEIGHT: | | SCALE: 1:1 | | SIZE: A1 | | CAGE CODE: 00779 | |
| Customer Accessible Production Drawing | | SCALE: 1:1 | | SHEET: 4 | | REV: A | |