

8

7

6

5

4

3

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1

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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

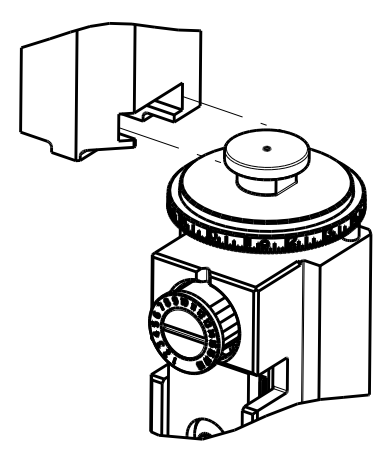
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151204-1

B

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

2119950-1

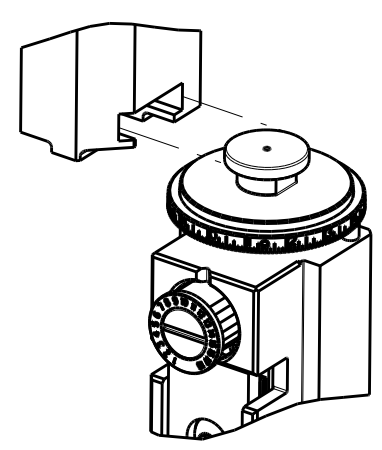
1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1



2151204-2

B

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1

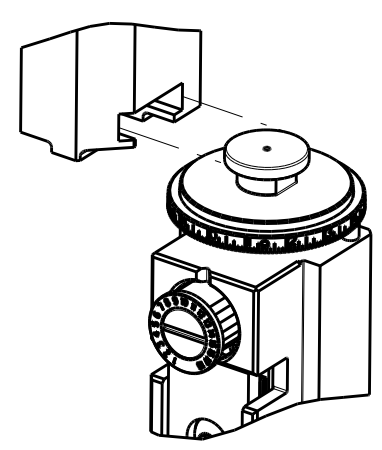
1338685-1

5-18022-5

2119653-1

-

-



2151204-5

B

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

MECHANICAL FEED

2119949-1

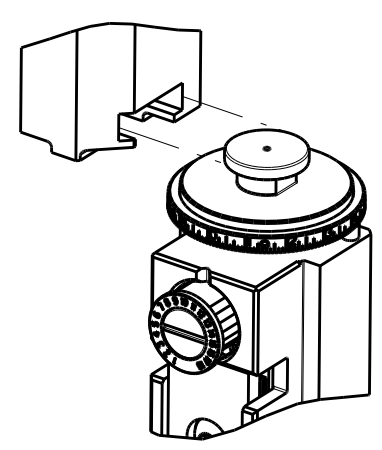
1338685-1

5-18022-5

2119653-1

-

-



2151204-6

B

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

12

-

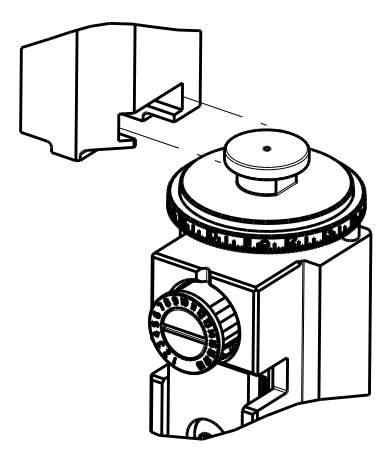
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2151204-7

B

FINE CRIMP HEIGHT ADJUST

NONE

-

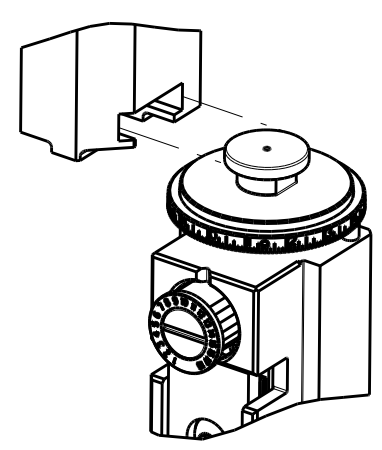
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7-2151204-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.29 mm [.090]

F

INSUL

3.68 mm [1.45]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: MINI MIC TAB CTC.

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

3.00-3.50 mm [.118-.138 IN]

Ø1.70-3.30 mm [.067-.130 IN]

TERMINAL APPLICATION SPECIFICATION

114-20045

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE SEAL

TE SEAL

282109-1

282109-4

281934-2

281934-3

282109-2

282109-5

282109-3

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

1.50mm2

1.52+/-0.05 [.060+/- .002]

9.7

1.00mm2

1.45+/-0.05 [.057+/- .002]

10.3

0.75mm2

1.34+/-0.05 [.053+/- .002]

11.6

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: 8-2151204-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151204-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151204-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151204-6

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 ITEMS 62 & 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.

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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.28.

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.
APPLY #1-23419-5 LOC-TITE TO THREADS.

*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

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

2119957-2

APPLICATOR SHIM PACK

260

8-21084-0

O-RING, .676 ID, .070 DIA. MAT.

252

2119640-1

PUSH ROD, AIR FEED

250

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

2119599-1

LOC

A

DIST

66

REVISIONS

P

LTR

DESCRIPTION

DATE

DWN

APVD

A

RELEASED

05APR2013

LG

GB

B

ECR-13-009635

13JUN2013

YY

UG

-

-

-

-

1

-

2079988-1

BUSHING, LCH5-12, MISUMI

249

-

-

-

-

1

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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

-

-

1

-

-

-

2119758-1

RAM, AMP STYLE, SIDE FEED, NON-ADJ.

245

-

1

1

1

1

1

2119082-7

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

-

-

-

-

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

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-

1

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240638-1

SPRING, FEED FINGER

163

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-

-

1

-

3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

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1

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2119799-1

HOLDER,FEED FINGER, AF

136

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REF

REF

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SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

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1

1

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1633743-1

SERVO FEED LATCH ASM

133

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1

1

1

1

1

1-18028-2

WASHER, FLAT, REG M4

119

-

-

REF

REF

-

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2119944-1

FEED FINGER ASSEMBLY,SF

117

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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

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-

-

-

1

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

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1

1

1

1

1

985575-3

SCR, FLT SKT HD CAP M3 X 10.0

57

-

-

-

-

1

1

1338685-1

PAWL, FEED

56

-

4

4

4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

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2

2

2

2

2

2168083-8

SCR, SKT HD CAP, RoHS, M4 X 16

53

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1

1

1

1

1

5018030-1

NUT, HEX, REG, RoHS, M3

52

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1

1

1

1

1

811242-5

BUMPER, HOLD DOWN

51

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1

1

1

1

1

690753-2

SPACER, TONKER

50

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-

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1

2

18023-9

SCR, SKT HD CAP M4 X 6.0

49

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-

-

-

-

1

2119652-1

FEED CAM, PRE FEED

48

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1

2119653-1

FEED CAM, POST FEED

47

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1

1

1

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1

2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

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1

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1

1

1

2119370-1

RAM, AMP STYLE, SIDE FEED

44

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1

1

1

1

1

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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1

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1

1

1

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

-

1

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1

1

1

2119957-1

APPLICATOR SHIM PACK

39

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1

1

1

1

1

2119644-2

RAM WASHER, PRECISION

38

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1

1

1

1

1

2119085-1

FA HEAD, ATLANTIC STYLE

37

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1

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1

1

1

2119092-1

BOLT, ADJUSTMENT

35

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1

1

1

1

1

1-1752356-9

SUPPORT, TERMINAL

34

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2

2

2

2

2

2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

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1

1

1

1

1

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

-

1

1

1

1

1

1-1320908-0

SPACER, STRIP GUIDE

30

-

1

1

1

1

1

2119959-1

ASSEMBLY, STRIP GUIDE

29

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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

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1

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1

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1

1-18028-2

WASHER, FLAT, REG M4

20

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1

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2119533-1

STRIPPER, SIDE FEED

19

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2119806-1

INSERT, SHEAR

13

-

1

1

1

1

1

3-22280-3

SPRING, COMPRESSION

12

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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

318707-1

FLOATING SHEAR, FRONT

9

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1

1

1

1

1

2-1333205-1

ANVIL, COMBINATION

8

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1

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1

2-240641-0

SPACER

7

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6

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1

1

1

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1

2119781-1

DEPRESSOR, SHEAR

5

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1

1

1

1

1

2-238011-2

BLOCK, CRIMPER SPACER

4

-

1

1

1

1

1

3-2119784-8

CRIMPER, INSULATION O PREMIUM

3

-

1

1

1

1

1

1-455888-0

SPACER, CRIMPER

2

-

1

1

1

1

1

2-456406-9

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

2119957-2

APPLICATOR SHIM PACK

260

8-21084-0

O-RING, .676 ID, .070 DIA. MAT.

252

2119640-1

PUSH ROD, AIR FEED

250

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE CURRENT REVISION OF THIS DRAWING. ANY CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:

mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±.1

1 PLC ±.02

2 PLC ±.02

3 PLC ±.005

4 PLC ±.0005

ANGLES ±.1

FINISH

MATERIAL

DWN

HOFFNER

11MAR2013

CHK

T.ELBIN

12MAR2013

APVD

T.ELBIN

12MAR2013

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2151204

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

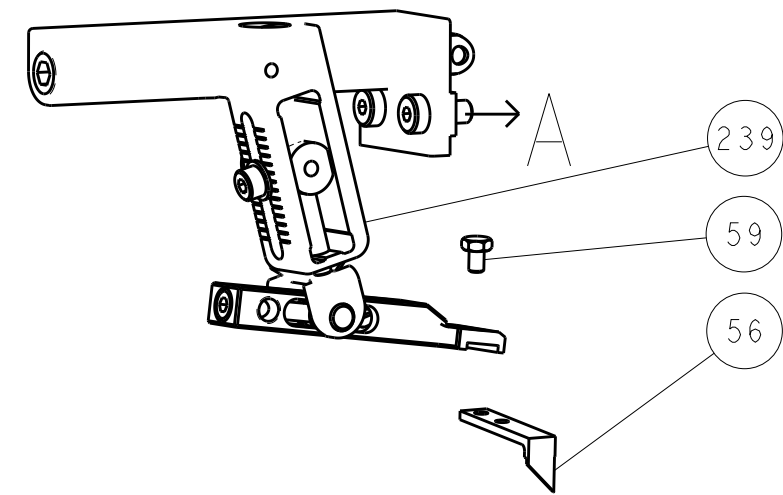
REV

B

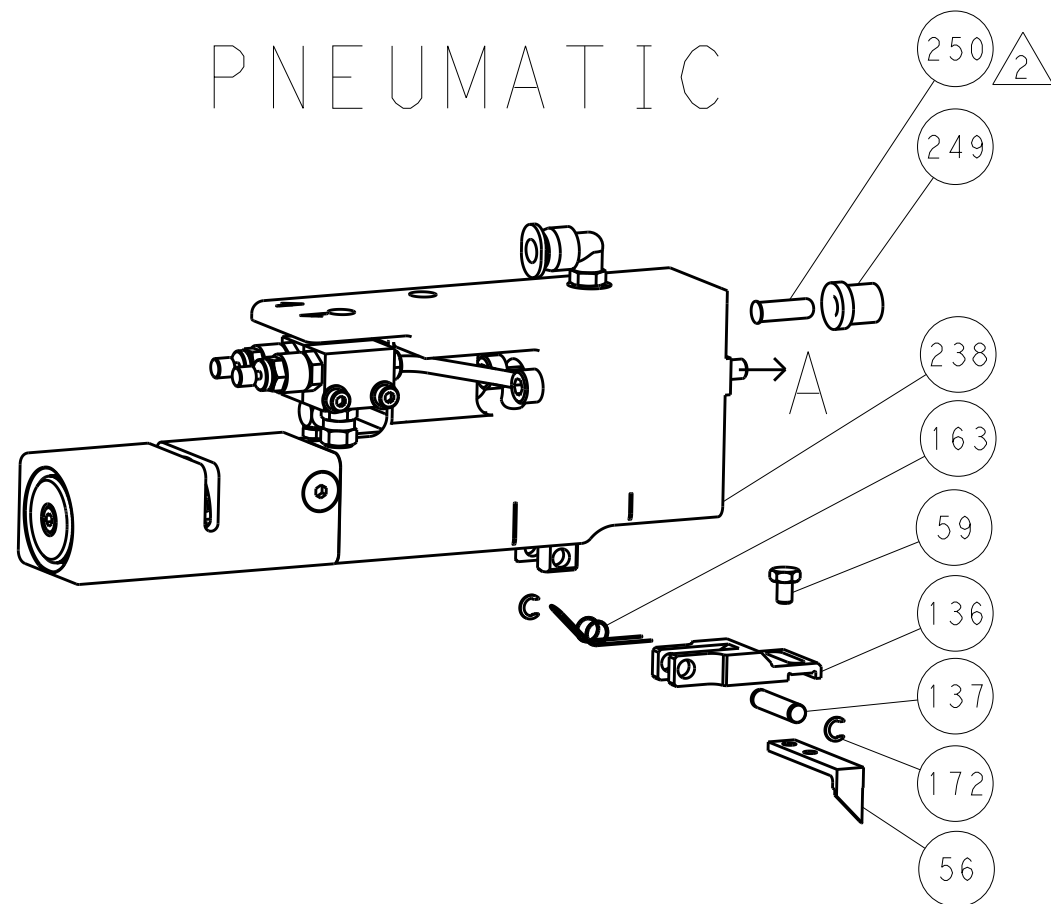
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

LOC		DIST		REVISONS			
A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

FEED TYPE
MECHANICAL



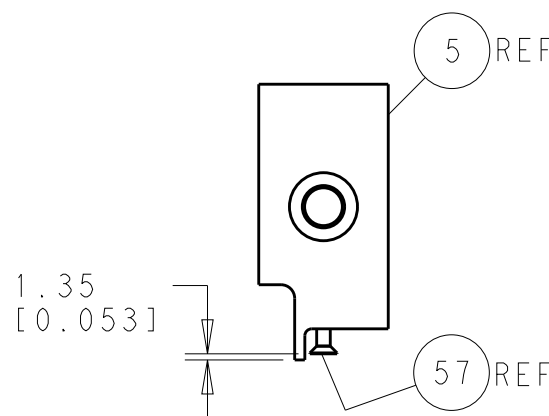
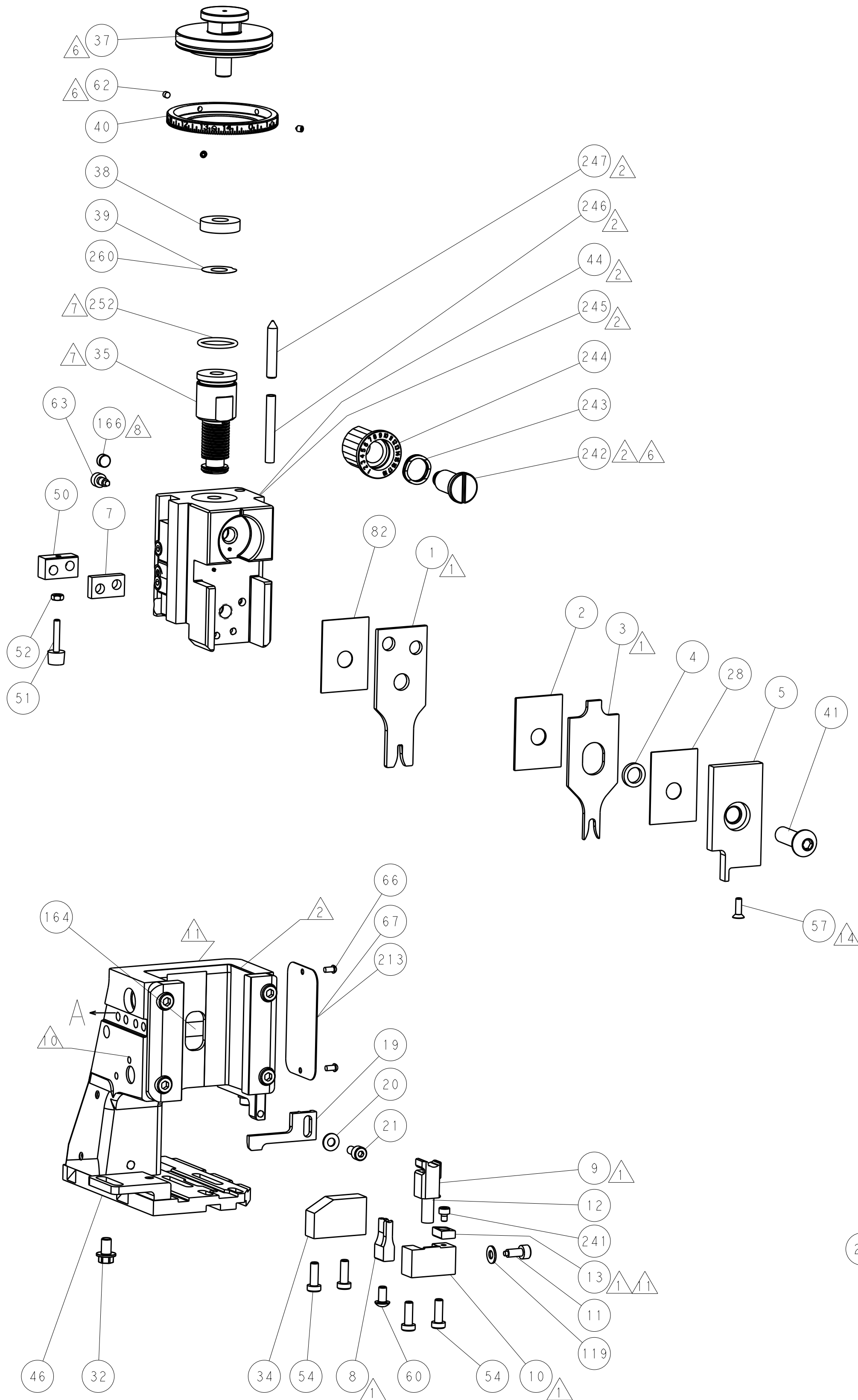
PNEUMATIC



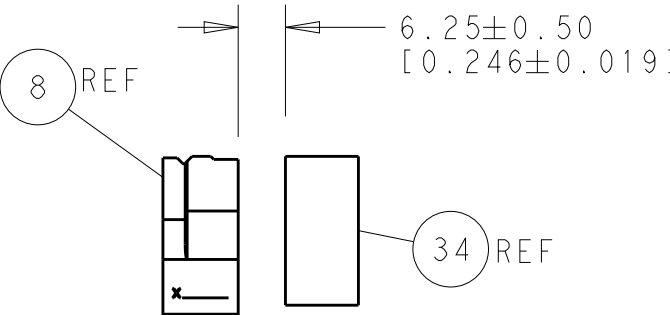
SERVO
LATCH PLATE



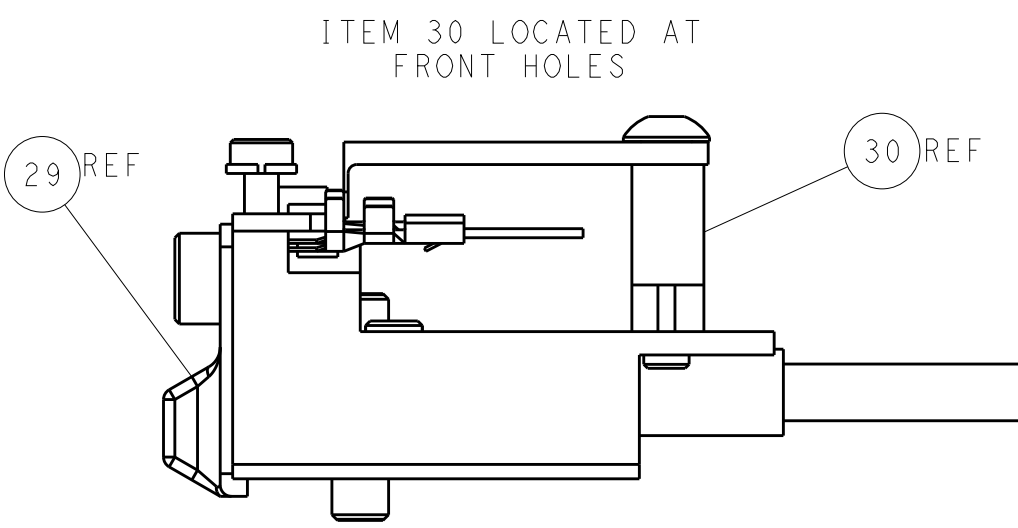
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



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)

FIRST PUBLISHED BY: 12/01/2013 THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.				DWN: HOFFNER 11MAR2013 CHK: TELBIN 12MAR2013 APVD: TELBIN 12MAR2013				TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS: mm				TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.02 2 PLC ±.02 3 PLC ±.005 4 PLC ±.0005 ANGLES ±.1				NAME: Ocean Side Feed Applicator			
MATERIAL: -				FINISH: -				SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151204			
Customer Accessible Production Drawing				SCALE: 1:1				SHEET 2 OF 4 REV B			

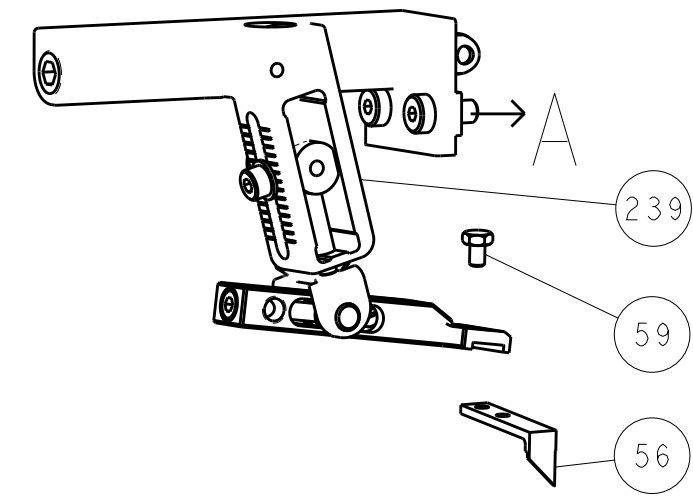
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

C

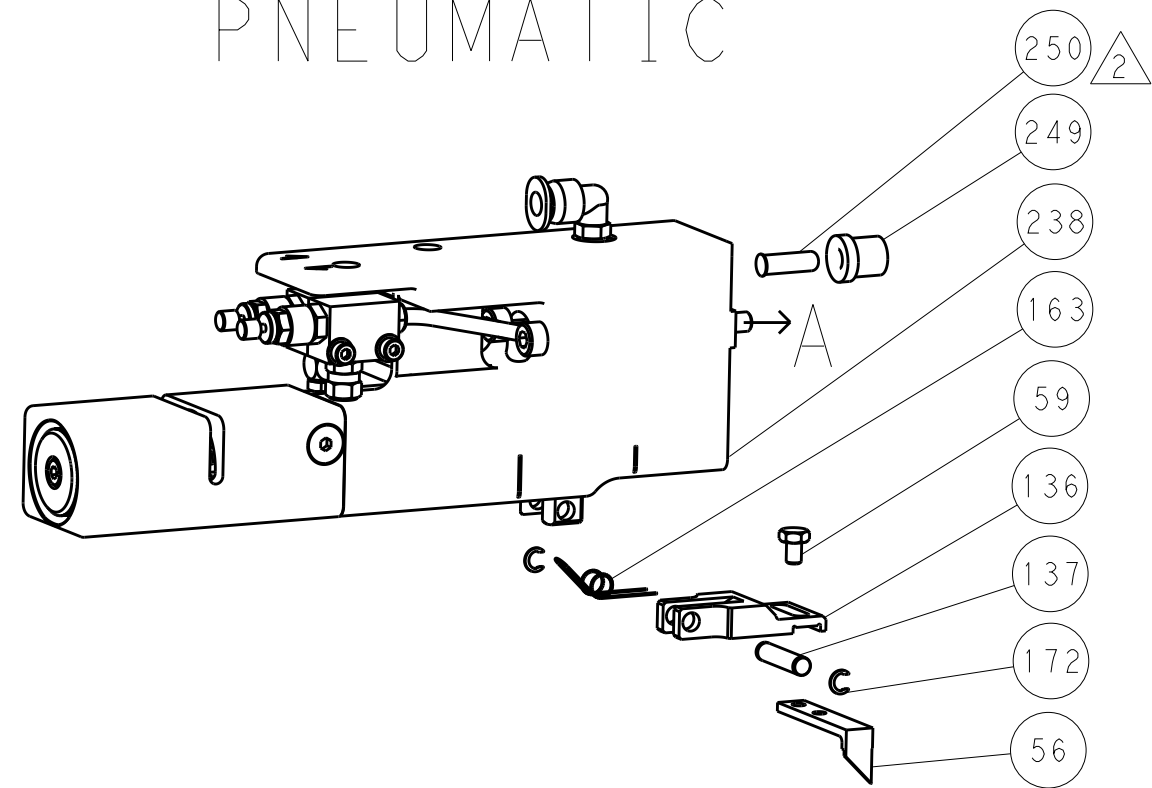
B

A

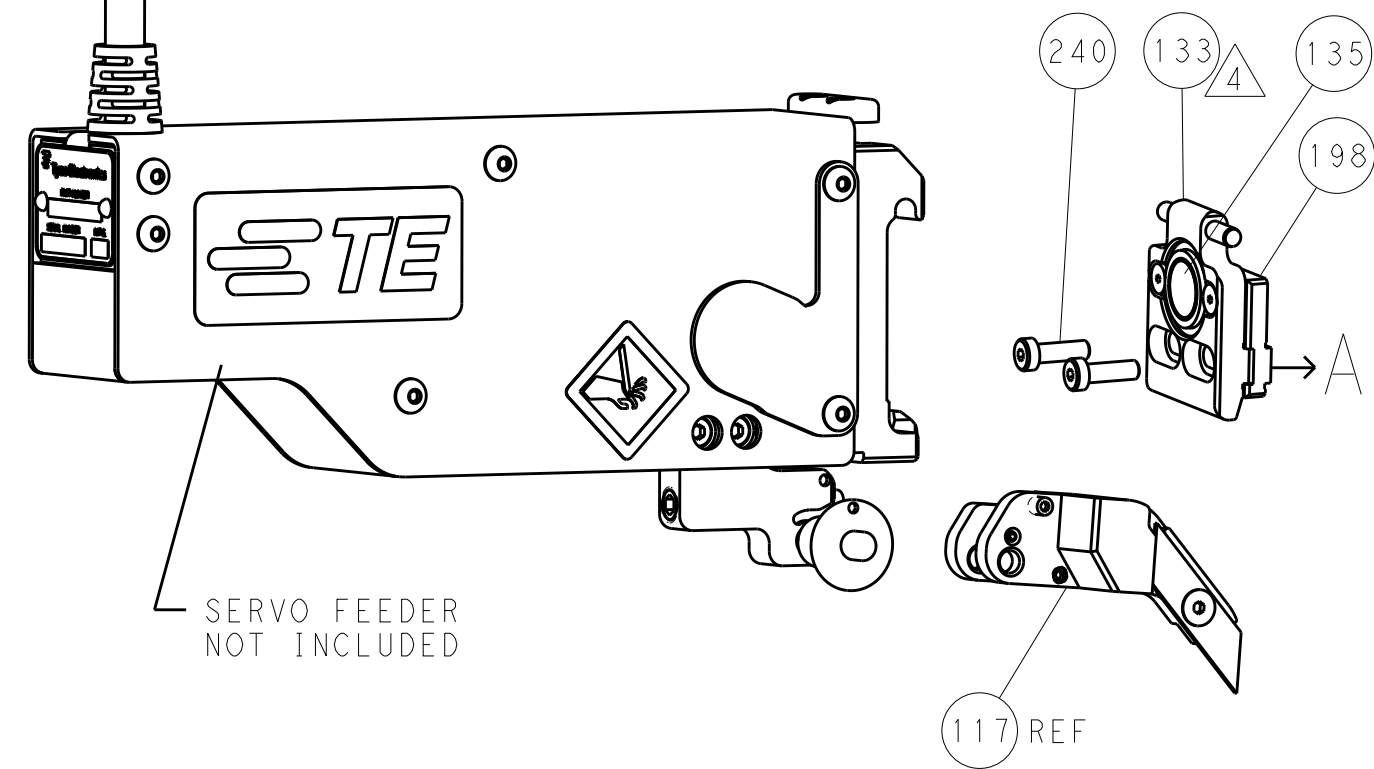
FEED TYPE MECHANICAL



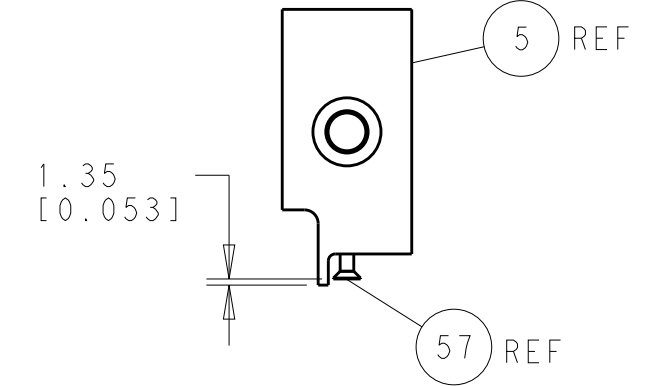
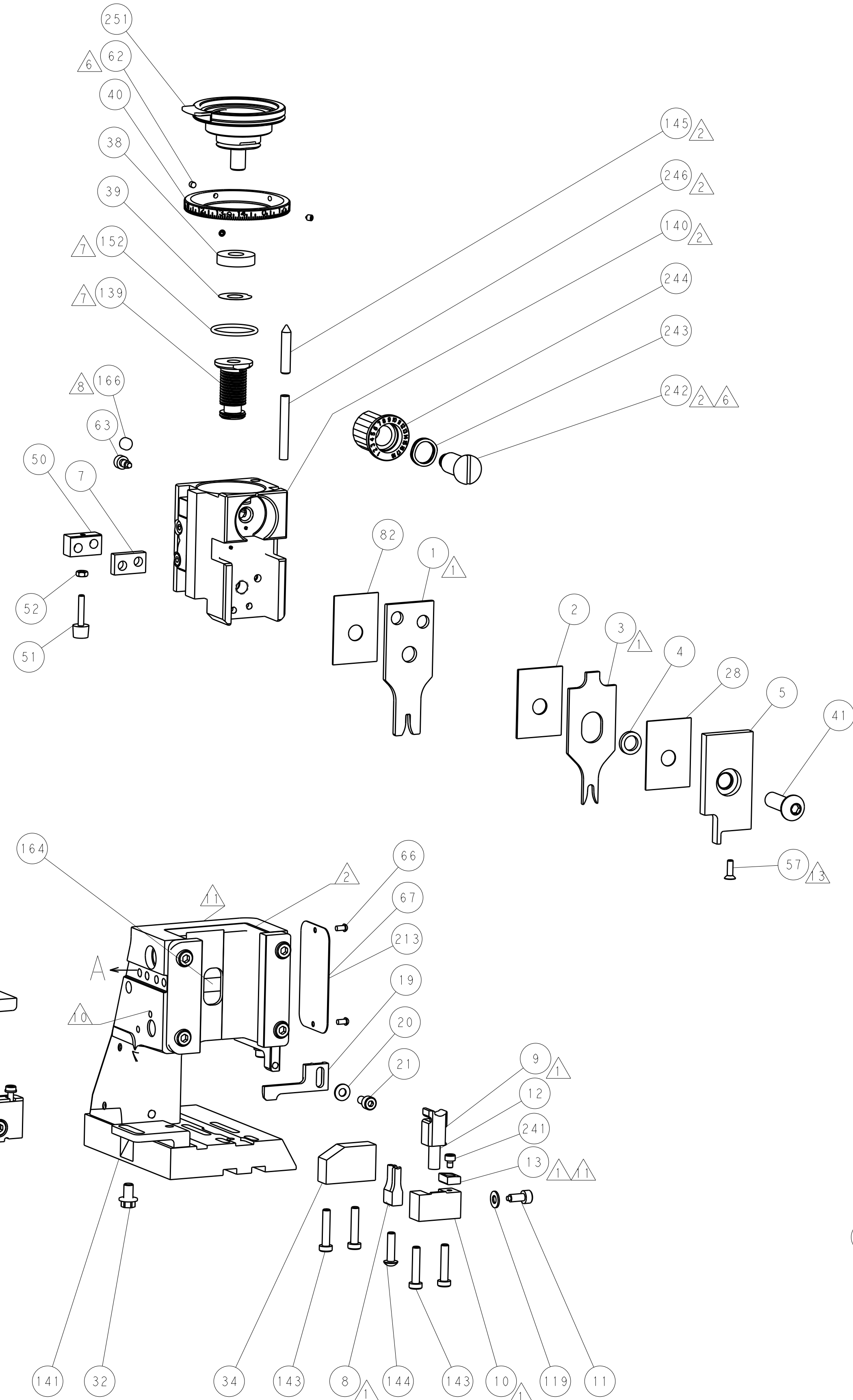
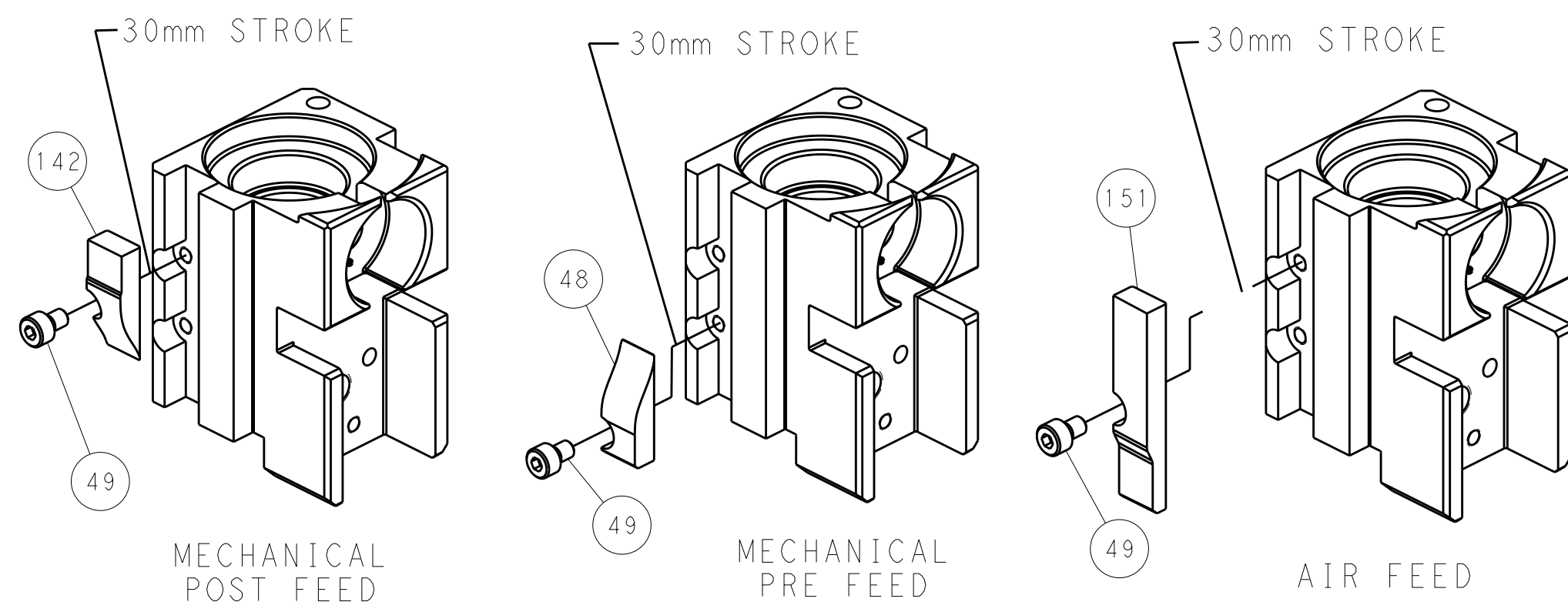
PNEUMATIC



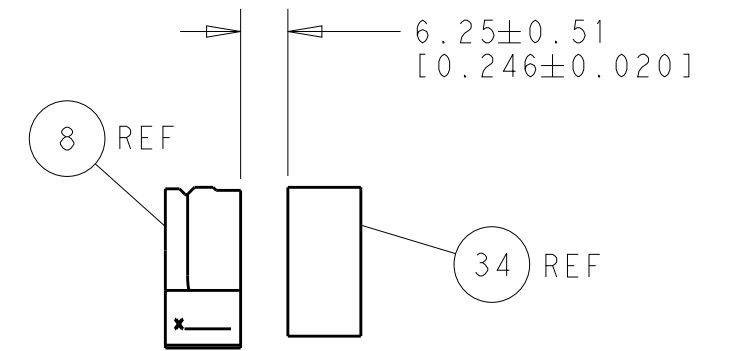
SERVO LATCH PLATE



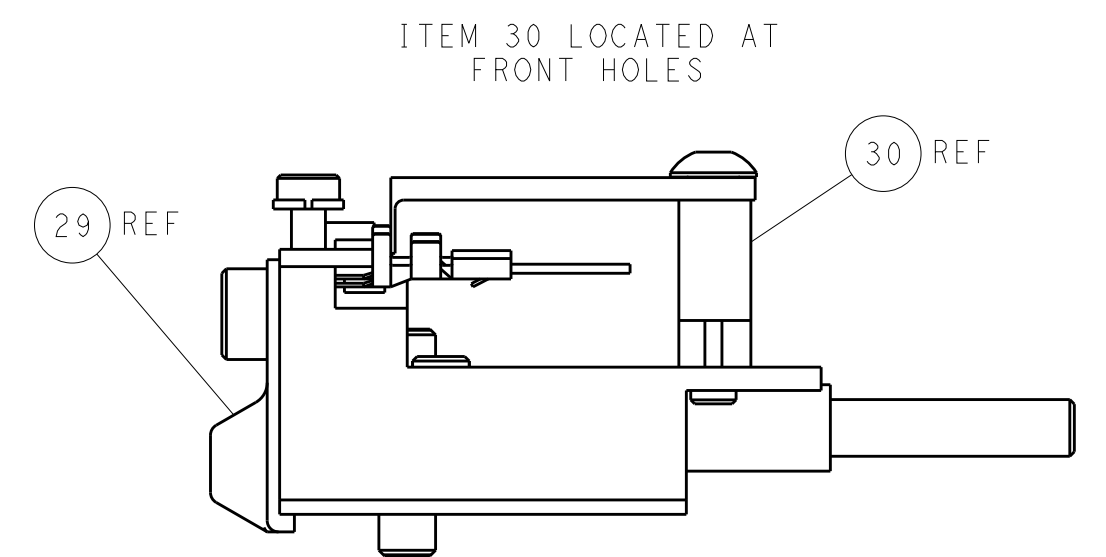
CAM POSITIONS



SHEAR DEPRESSOR DETAIL



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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS.		OWN: HOFFNER	11MAR2013	TE Connectivity	
DIMENSIONS:		CHK: T.ELBIN	12MAR2013	Harrisburg, PA 17105-3608	
mm		APVD: T.ELBIN	12MAR2013	NAME: Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		SIZE: CAGE CODE: DRAWING NO:	
0 PLC ±0.1		APPLICATION SPEC		A1 00779 C=2151204	
1 PLC ±0.02		WEIGHT		Customer Accessible Production Drawing	
2 PLC ±0.005		SCALE		1:1	
3 PLC ±0.0005		SHEET		4 OF 4	
4 PLC ±0.0005		REV		B	
ANGLES FINISH		RESTRICTED TO			