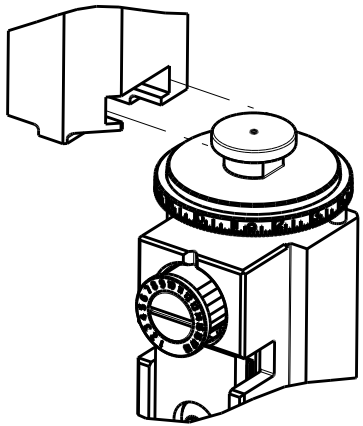
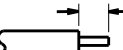


8		7		
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER		PART NUMBER	REVISION	DESCRIPTION
	2151020-1	D	FINE CRIMP HEIGHT ADJUST	
	2151020-2	D	FINE CRIMP HEIGHT ADJUST	
	2151020-5	D	FINE CRIMP HEIGHT ADJUST	
	2151020-6	D	NON-CRIMP HEIGHT ADJUST	
	2151020-7	D	FINE CRIMP HEIGHT ADJUST	
	7-2151020-7	A	CRIMP TOOLING KIT	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.57 mm [.062]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: CONTACT,MOD IV CRIMP SNAP-IN			
WIRE STRIP LENGTH			INSULATION DIAMETER RANGE
3.58-4.78 mm [.141-.188 IN]		Ø	1.75 mm [.069 IN] MAX
TERMINAL APPLICATION SPECIFICATION		114-25003	-
		-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
85969-6	141760-1	141600-1	87309-8
85969-2	1-141097-1	141600-5	87309-9
85969-7	166309-1	171275-1	1-87309-2
85969-8	166309-2	171275-2	87523-2
85969-9	166309-3	171275-4	87523-4
102680-1	166309-4	171275-5	87523-5
102680-2	166309-5	1-87195-7	1-87523-5
86492-2	167301-4	1-87195-9	1-87523-8
86492-4	1-167301-6	2-87195-0	2-87523-3
86492-6	2-167301-2	2-87195-3	6-87523-8
86492-9	2-167301-4	2-87195-4	-
1-86492-0	-	-	-



RECOMMENDED SPARE PARTS

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: 8-2151020-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151020-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151020-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151020-6

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.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 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. TERMINAL LUBRICANT IS RECOMMENDED.

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.83+/-0.11 [.033+/- .004]	7.5
22 AWG	0.78+/-0.06 [.031+/- .002]	8.4
24 AWG	0.73+/-0.095 [.029+/- .004]	9.2

*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.

-	-	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
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-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)

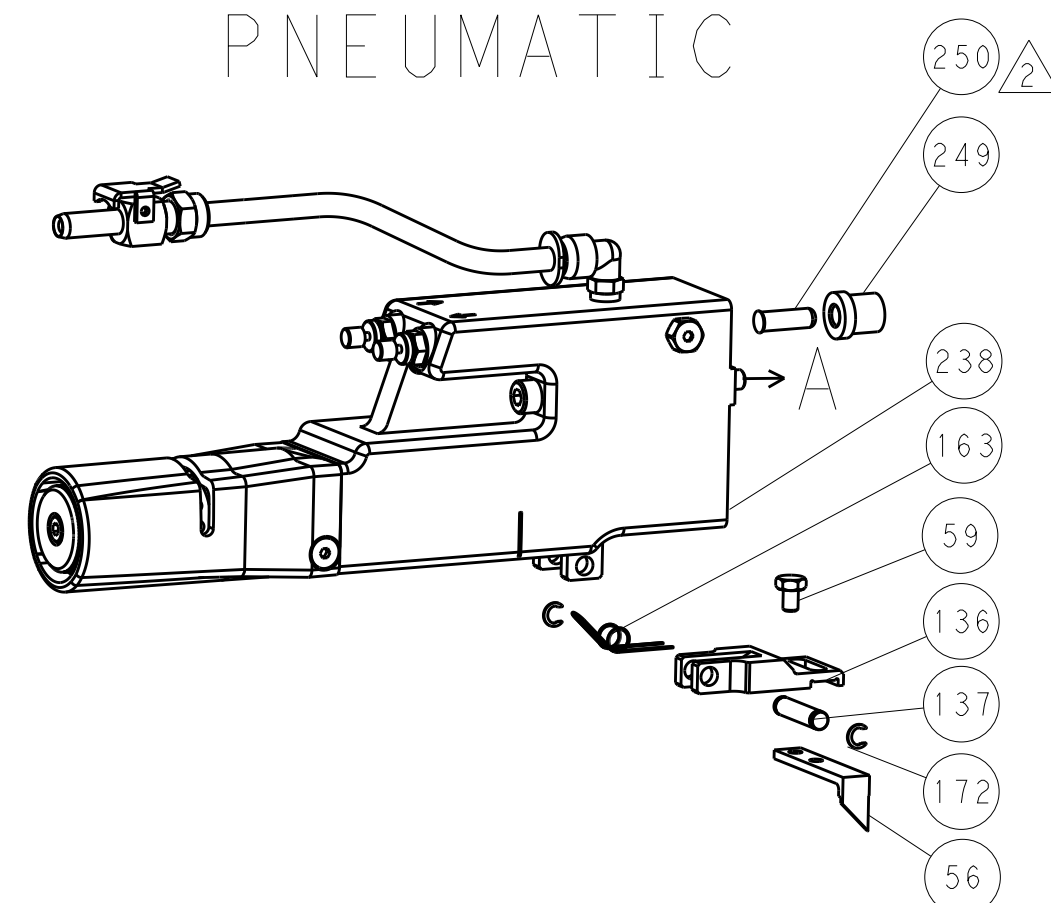
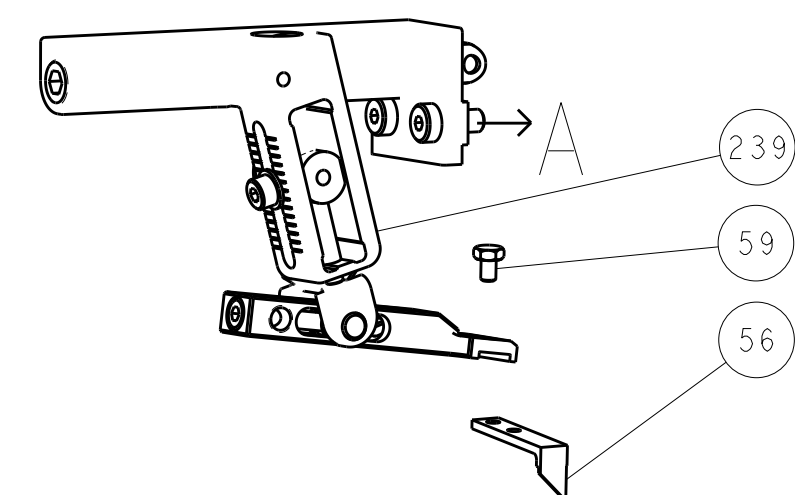
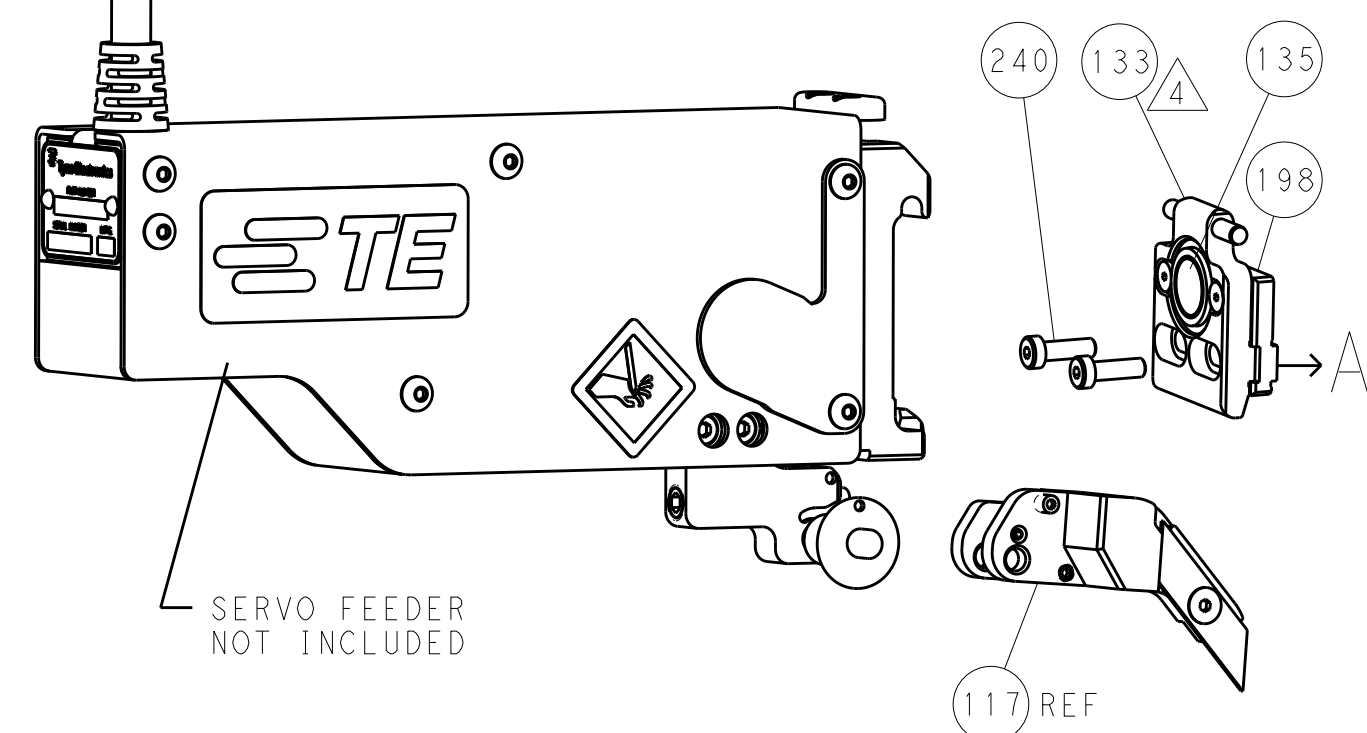
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
			B		ECR-13-006390	15APR2013
			D		ECR-16-015896	10NOV2016

-	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
-	2	2	2	2	2	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
-	-	-	-	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
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	455888-7	SPACER, CRIMPER	82
-	1	1	1	1	1	4-240641-1	SPACER	81
-	1	1	1	1	1	22278-7	SPRING, COMPRESSION	77
-	1	1	1	1	1	854769-4	HOLDER, INS	74
-	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	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	-	-	-	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	1-18023-3	SCR, SKT HD CAP M4 X 16.0	53
-	-	-	-	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	1-2119644-4	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
-	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	2119959-1	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
-	3	3	3	3	3	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	1	690518-1	HOLD DOWN, TERMINAL	18
-	1	1	1	1	1	690463-1	FLOATING SHEAR, REAR	17
-	2	2	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6	16
-	1	1	1	1	1	1-690691-1	PLATE, REAR SHEAR	15
-	1	1	1	1	1	2119862-1	SHEAR HOLDER, REAR	14
-	2	2	2	2	2	2280441-1	INSERT, SHEAR	13
-	2	2	2	2	2	3-22280-3	SPRING, COMPRESSION	12
-	2	2	2	2	2	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1338701-1	ANVIL, COMBINATION	8
-	1	1	1	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
-	1	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1633966-6	CRIMPER, INSULATION O	3
-	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	1	1	3-456402-1	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

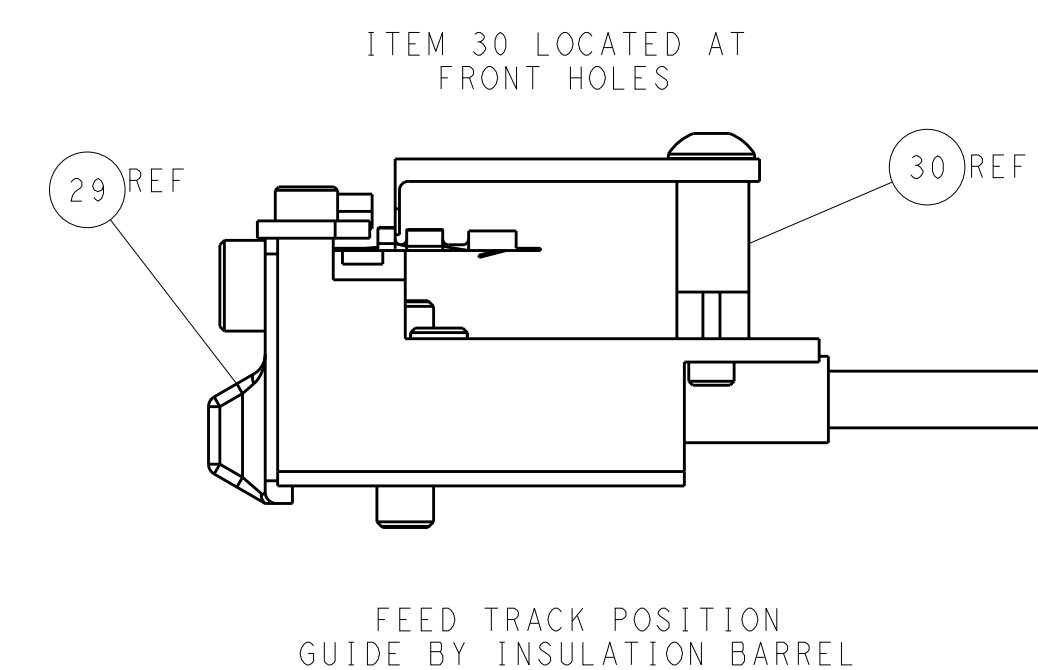
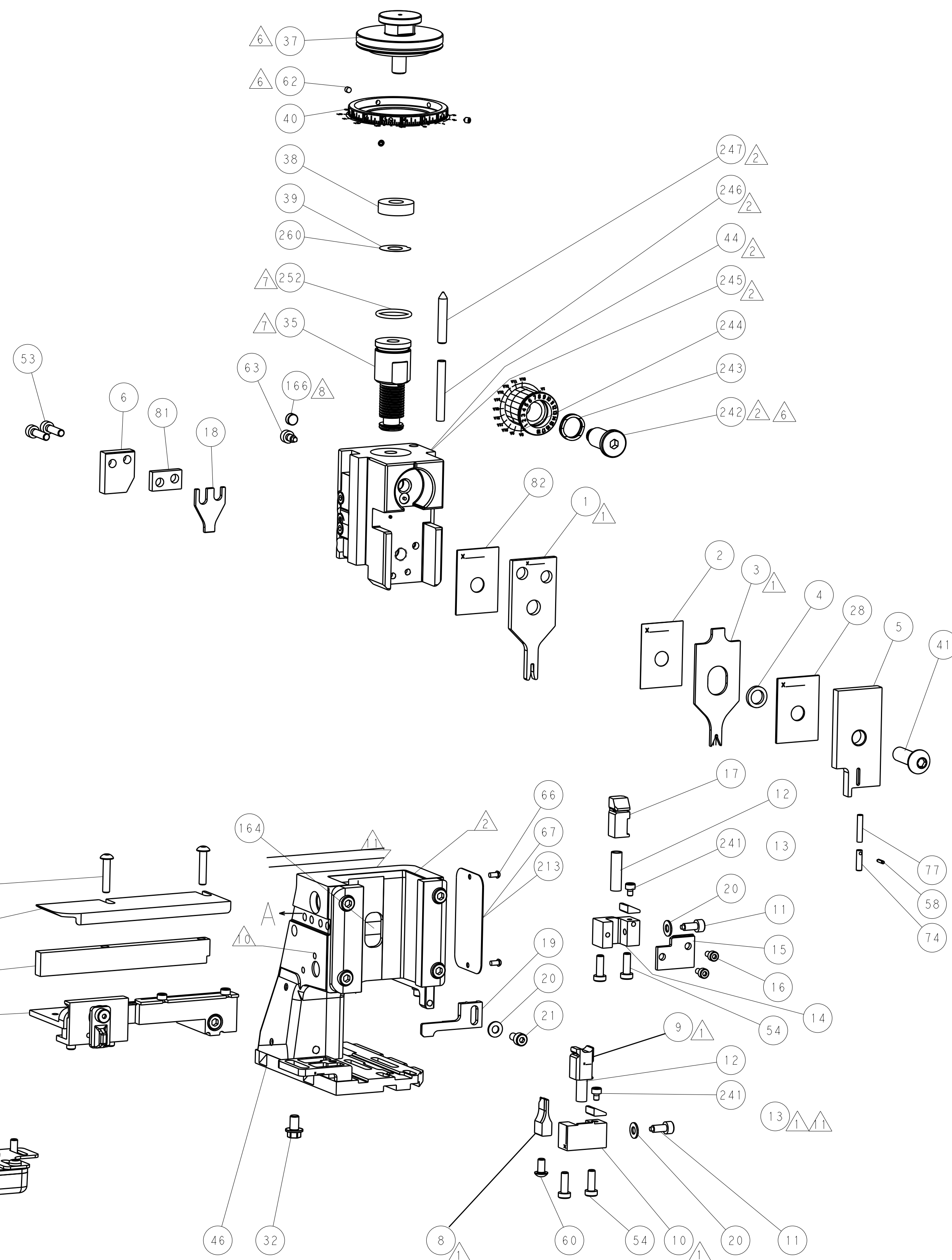
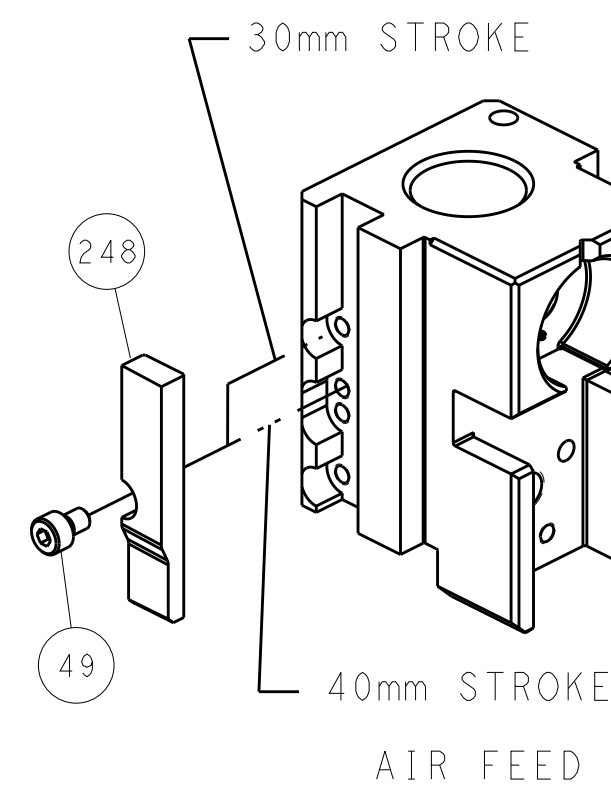
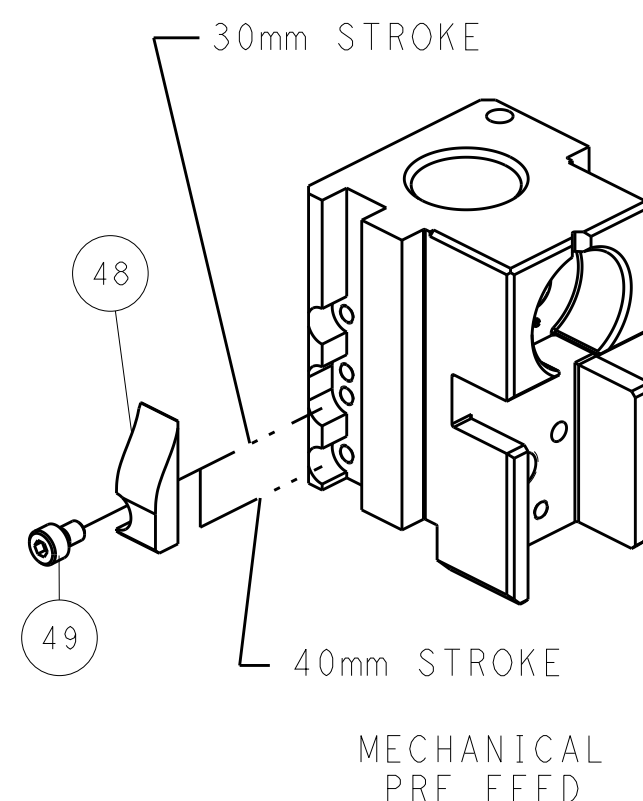
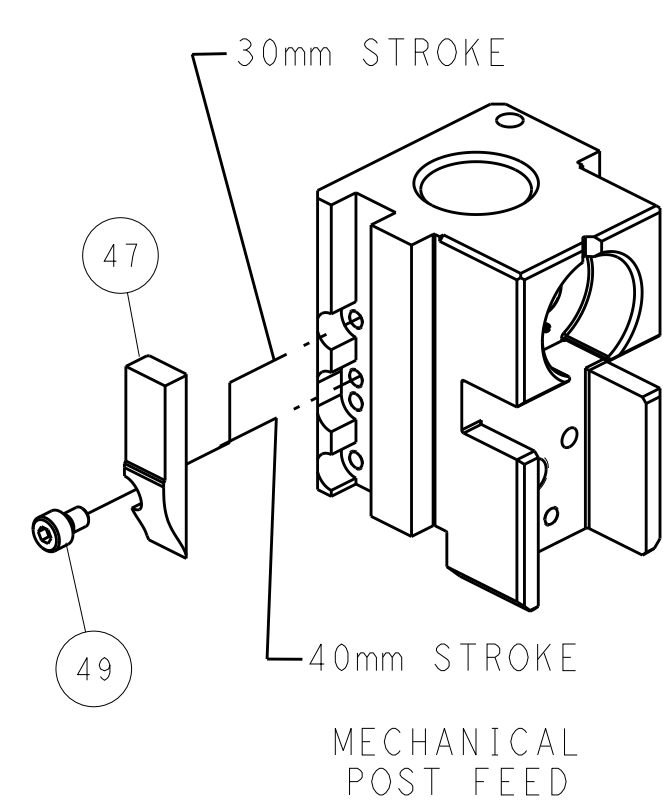
THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS OF THIS DRAWING. FOR THE LATEST REVISIONS, CONTACT THE ORGANIZATION TO WHICH YOU BELONG.		DWN G. STAKEM	07OCT2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK G. BAILEY	07OCT2011	NAME	
mm		APVD T. ELBIN	07OCT2011	Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		SIZE	
0 PLC ±.1		APPLICATION SPEC		CAGE CODE	
1 PLC ±.1		WEIGHT		DRAWING NO	
2 PLC ±.1		Customer Accessible Production Drawing		RESTRICTED TO	
3 PLC ±.1		SCALE		1 of 4	
4 PLC ±.1		REV		D	
ANGLES		Customer Accessible Production Drawing		SHEET	
FINISH		SCALE		1:2	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PNEUMATIC

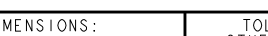
SERVO
LATCH PLATE

CAM POSITIONS



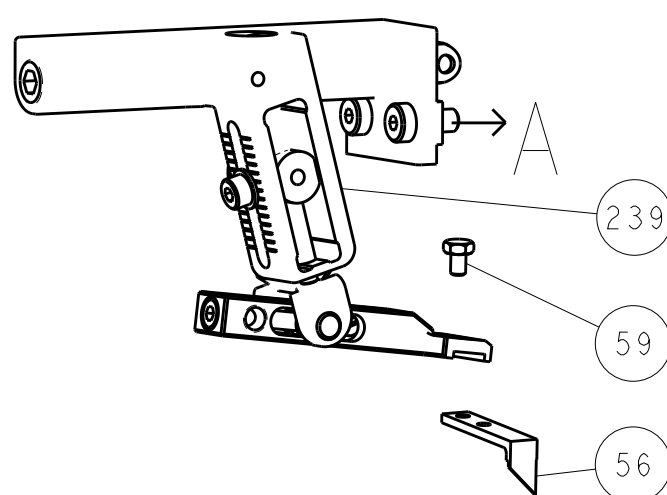
ATLANTIC VERSION

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

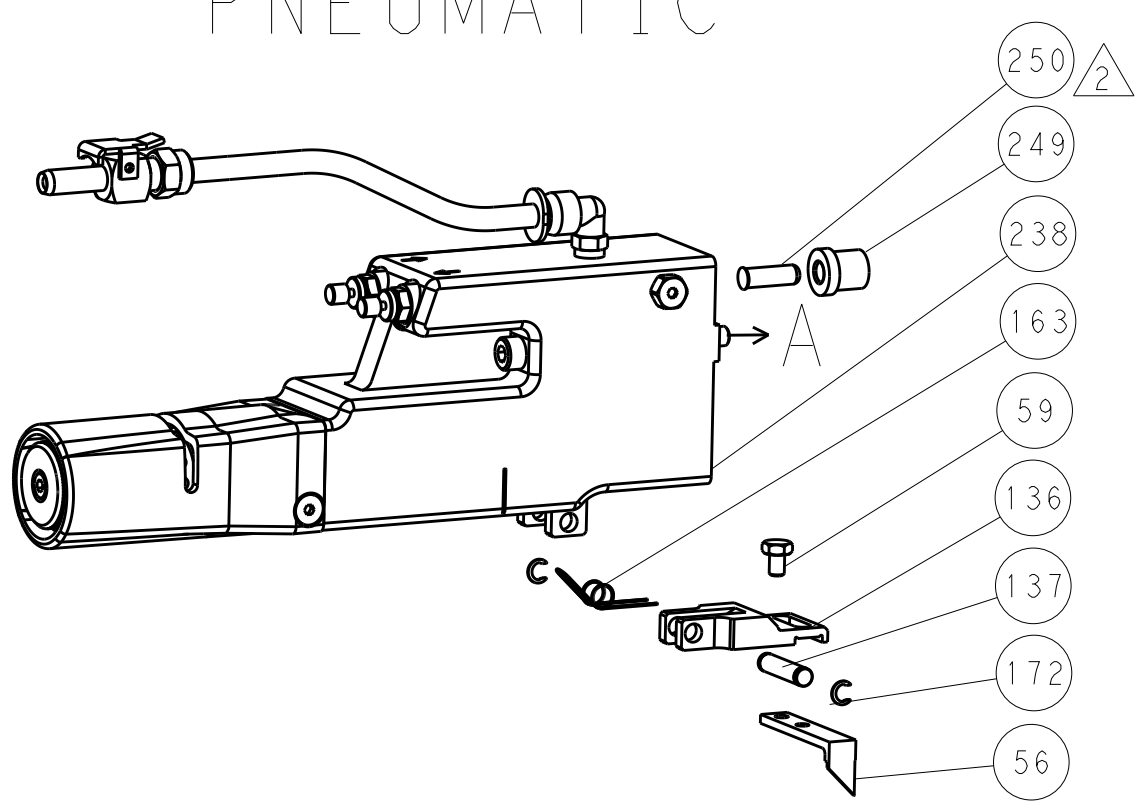
THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE NOTIFIED FOR THE LATEST REVISION		DWN # 010C2011 STAKEM CHK G. BAILEY 070C2011 APVD T. FLIRIN 070C2011		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A 1	
MATERIAL -		FINISH -		CAGE CODE 00779	
WEIGHT -		DRAWING NO C=2151020		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:2 SHEET 2 OF 4 REV D	

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

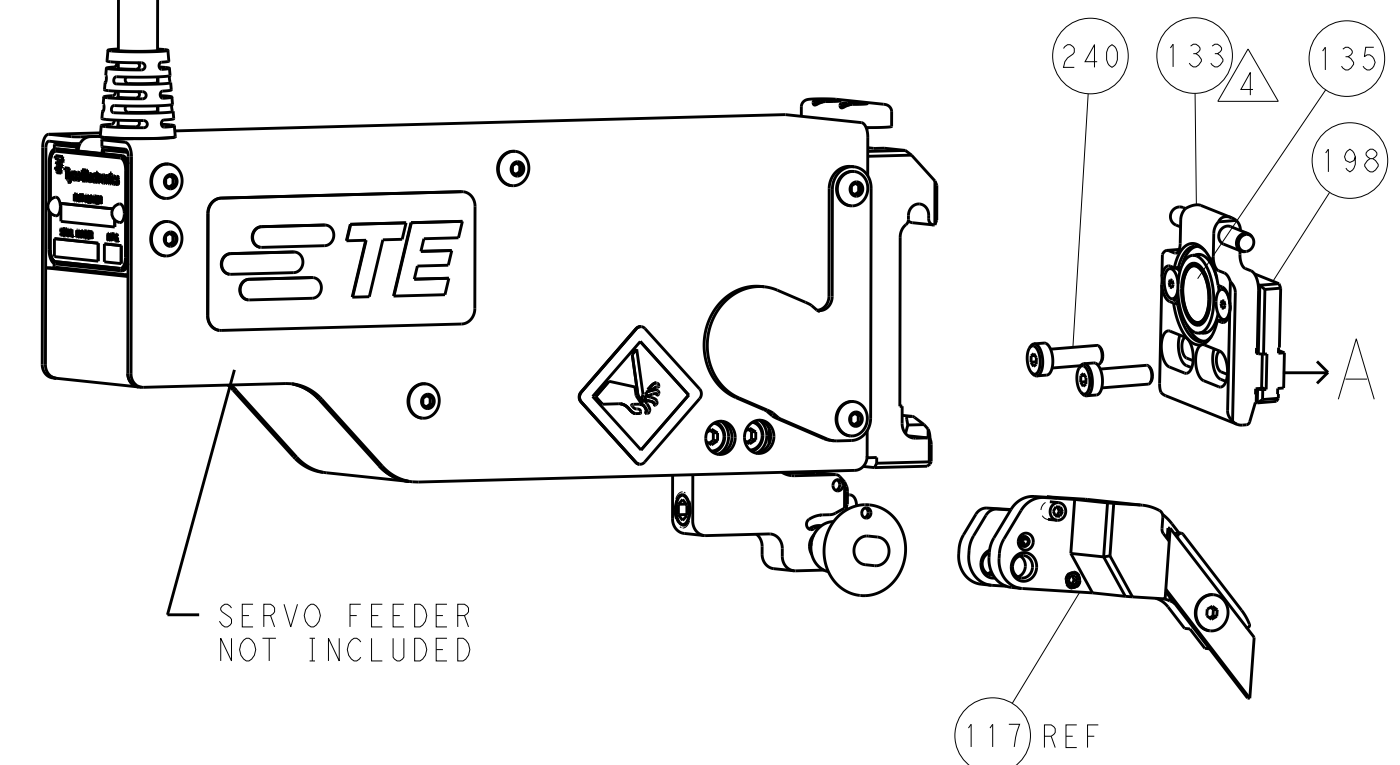
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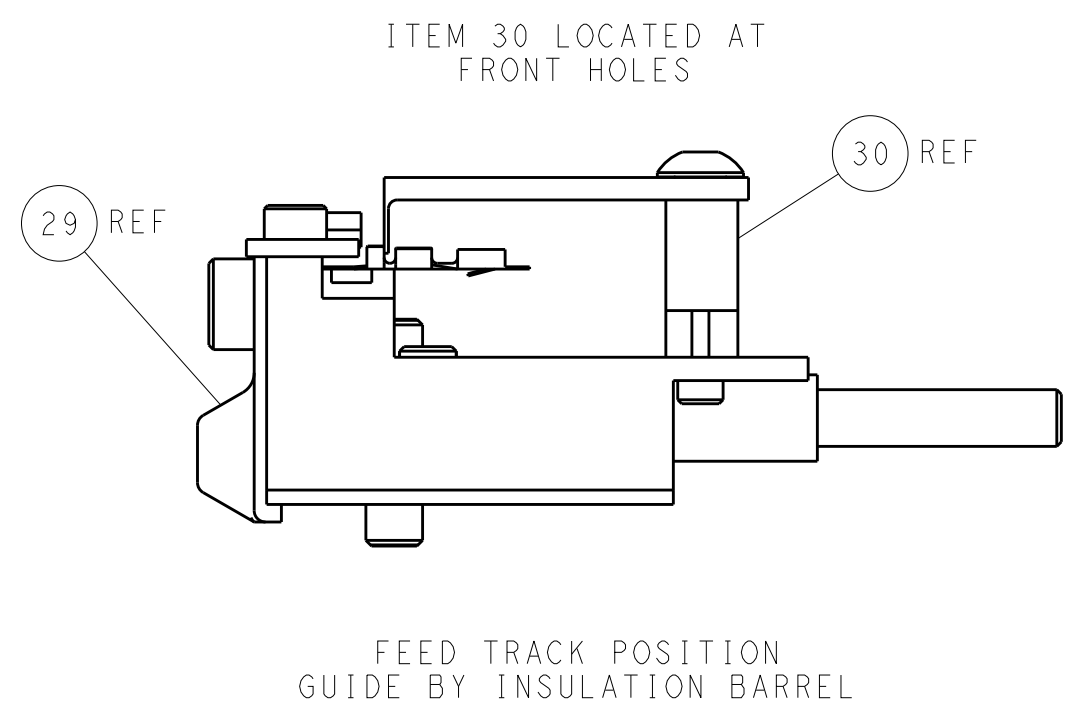
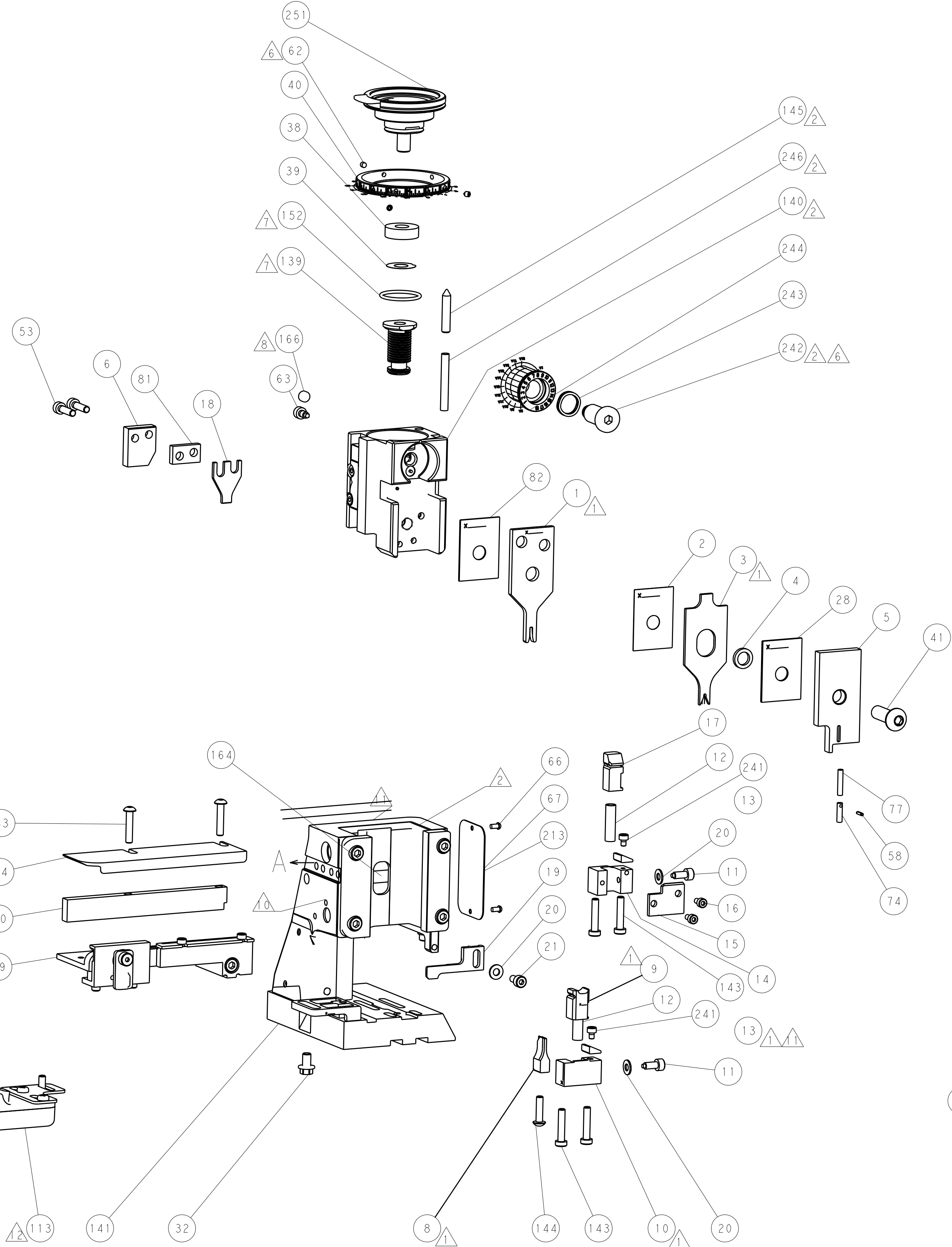
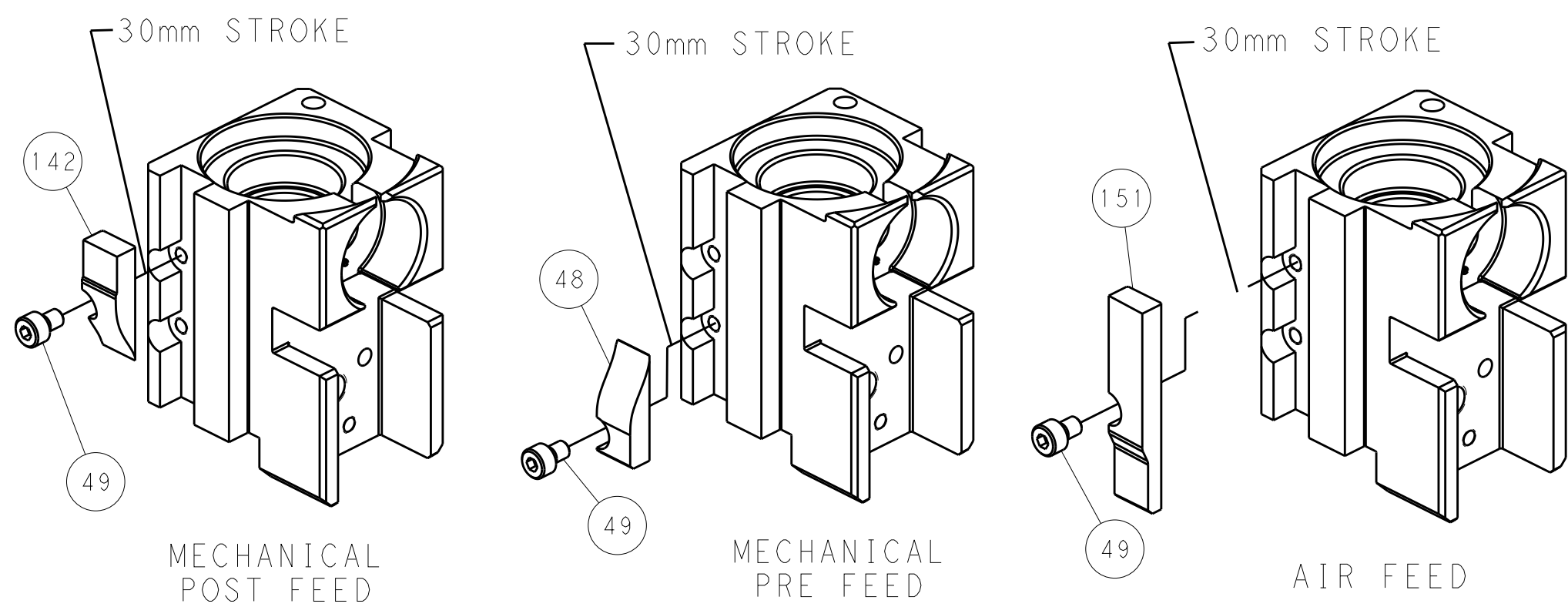
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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

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DIMENSIONS: mm		CHK G. BAILEY 07OCT2011		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		APVD T. ELBIN 07OCT2011	NAME Ocean Side Feed Applicator	
MATERIAL		PRODUCT SPEC	SIZE A1	
		APPLICATION SPEC	CAGE CODE 00779	
		WEIGHT	DRAWING NO C=2151020	
		Customer Accessible Production Drawing	RESTRICTED TO	
		SCALE 1:2	SHEET 4 OF 4	
			REV D	