

14. APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

APPLICATOR STYLE CONVERSION CHART						
CONVERT TO	PART NUMBERS REQUIRED					
-	-	-	-	-	-	-
SERVO LATCH PLATE	2119951-1	-	8-2151551-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151551-4	-	-	-
-	-	-	-	-	-	-
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-

SET UP GAUGE 2119599-1	LOC	DIST	REVISIONS						
	A	66	P	LTR	DESCRIPTION	DATE	DNW	APPV	
				D4	ECR-15-003249	3MAR15	RS	LZ	
				E	ECR-15-015082	14OCT2015	DJG	DS	
				F	ECR-16-002618	23FEB2016	KH	CT	
				G	ECR-16-013608	23SEP2016	JH	CT	

6	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	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	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
	-	-	-	-	1	2063440-1	AIR FEED MODULE	238
8	-	-	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	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
6	-	-	-	-	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	133
	-	-	REF	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	133
	-	-	1	1	-	1633743-1	SERVO FEED LATCH ASM	133
6	-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	121
	-	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	2256587-1	SCR, SET, SOFT TIP, M4	99
	-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
6	-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
	-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	93
	-	1	1	1	1	455888-3	SPACER, CRIMPER	82
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
6	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	1	1	1	1	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
	-	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 20)	60
6	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	-	-	-	1	1338685-1	PAWL, FEED	56
	-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
	-	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
6	-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	1	690753-2	SPACER, TONKER	50
	-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1	1	2-2119656-3	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	-	-	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
6	-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	-	-	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	1	-	-	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1	1	2119644-2	RAM WASHER, PRECISION	38
	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
6	-	1	-	-	1	2119092-1	BOLT, ADJUSTMENT	35
	-	1	1	1	1	1-1752356-2	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	1320908-7	SPACER, STRIP GUIDE	30
6	-	1	1	1	1	1901086-1	PLATE, STRIP GUIDE	29
	-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
	-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1	1	1803142-1	DRAG, TERMINAL	25
6	-	1	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	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	690472-2	STRIPPER	19
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
	-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	1-356885-5	STOP, SHEAR	11
	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	2161316-2	ANVIL, COMBINATION	8
	-	1	1	1	1	2-240641-9	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	1-1722335-0	SHEAR DEPRESSOR ASSEMBLY	5
	-	1	1	1	1	5-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1722335-8	CRIMPER, INSULATION F	3
	-	-	-	-	-	-	-	2
	1	1	1	1	1	2217302-2	CRIMPER, WIRE, CONICAL BLEND	1
	-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

-	1	1	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	268
-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	207988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

101. DIMENSIONS: THIS COMPANY'S DIMENSIONS ARE THE GOVERNING DIMENSIONS FOR THE PART. THE BUYER'S DIMENSIONS SHALL BE CONSIDERED FOR THE LATEST VERSION.		OWN 18JAN2012 C. KNEPPER CHK 18JAN2012 T. ELBIN APP 18JAN2012 M. CLIFFORD		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 					

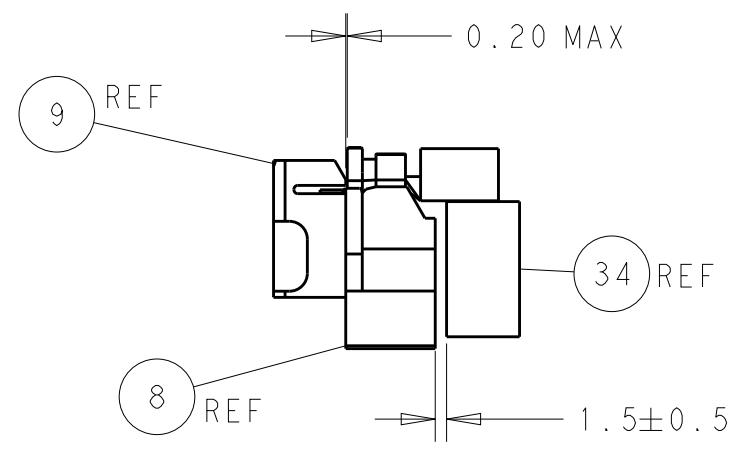
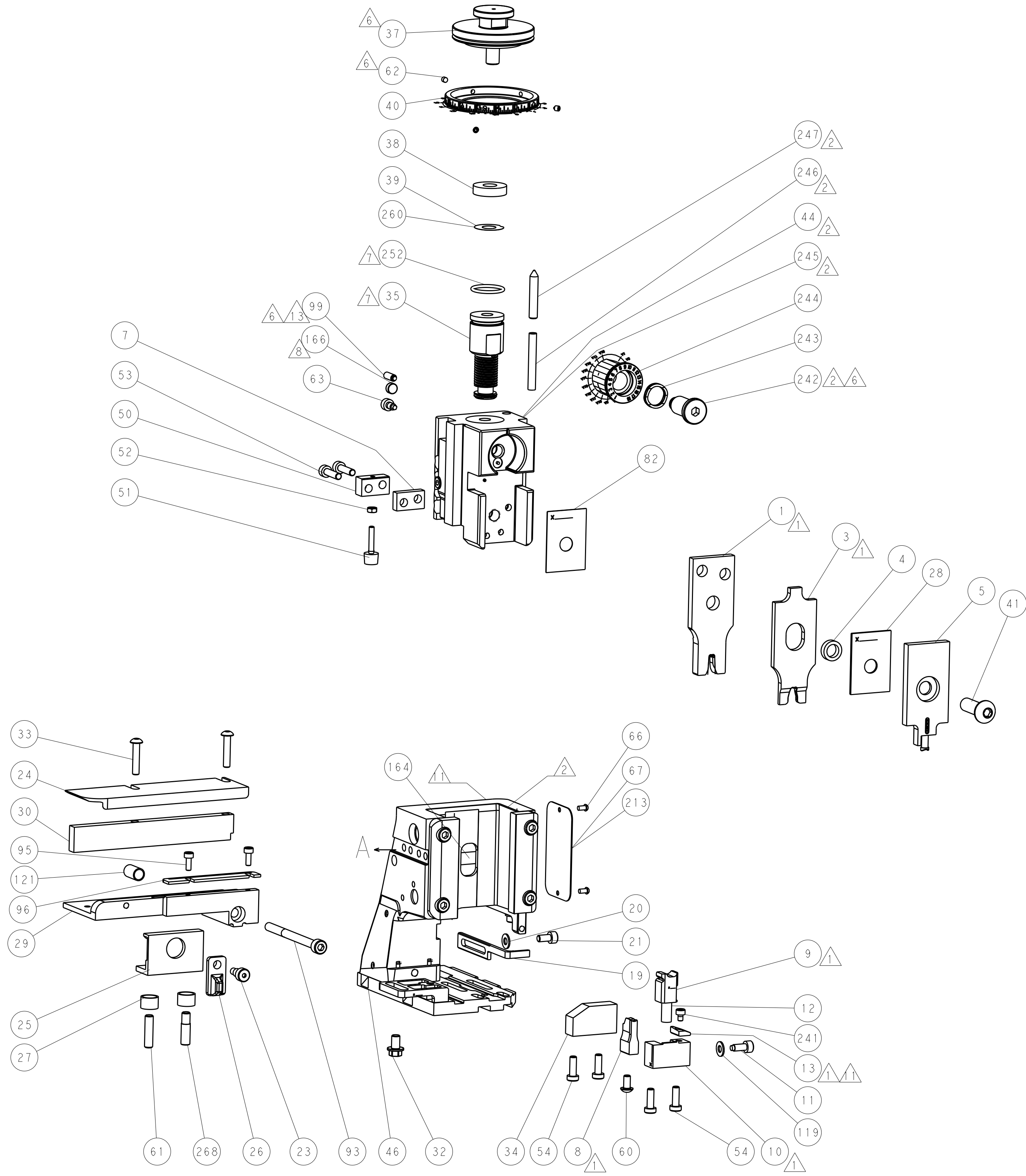
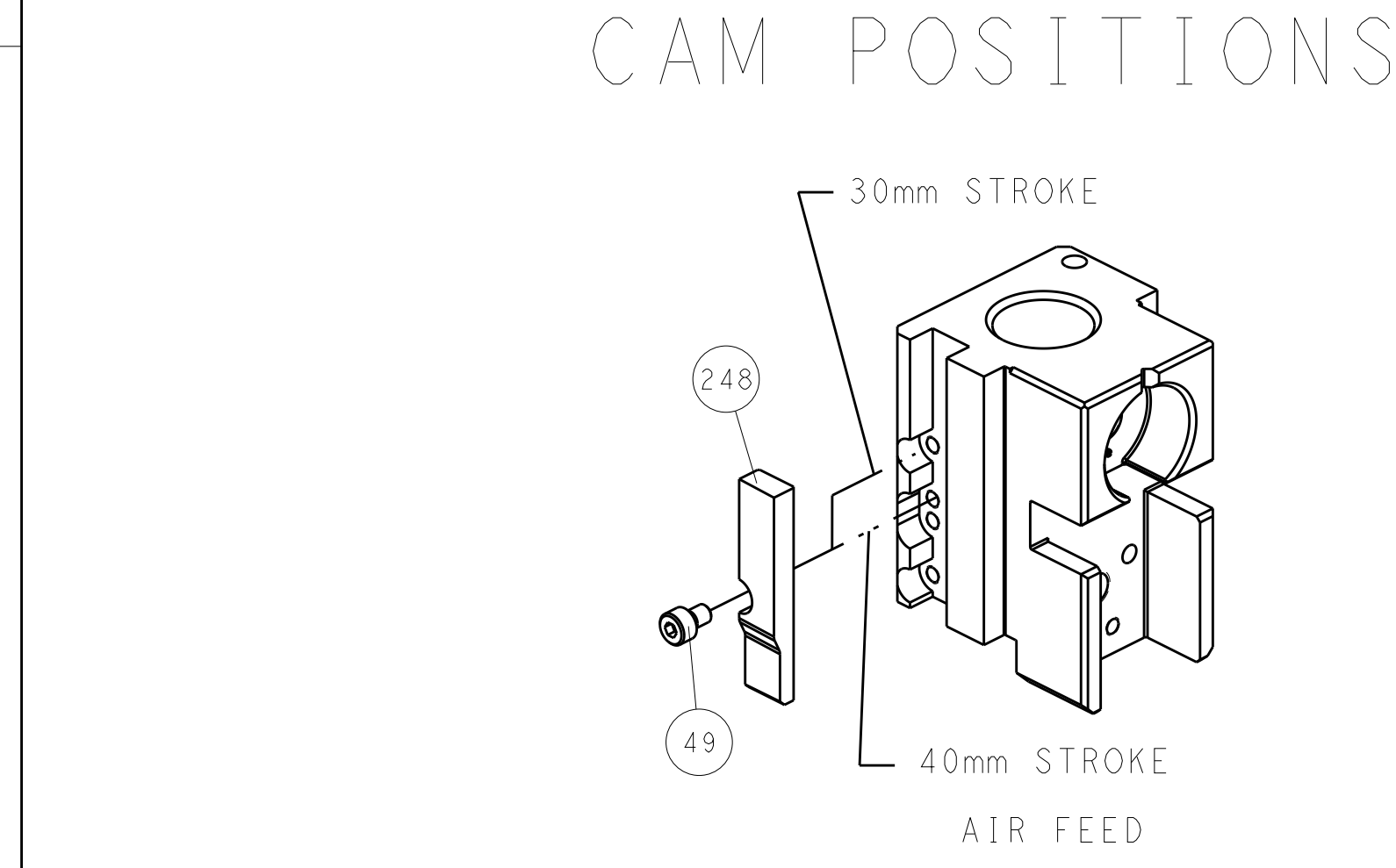
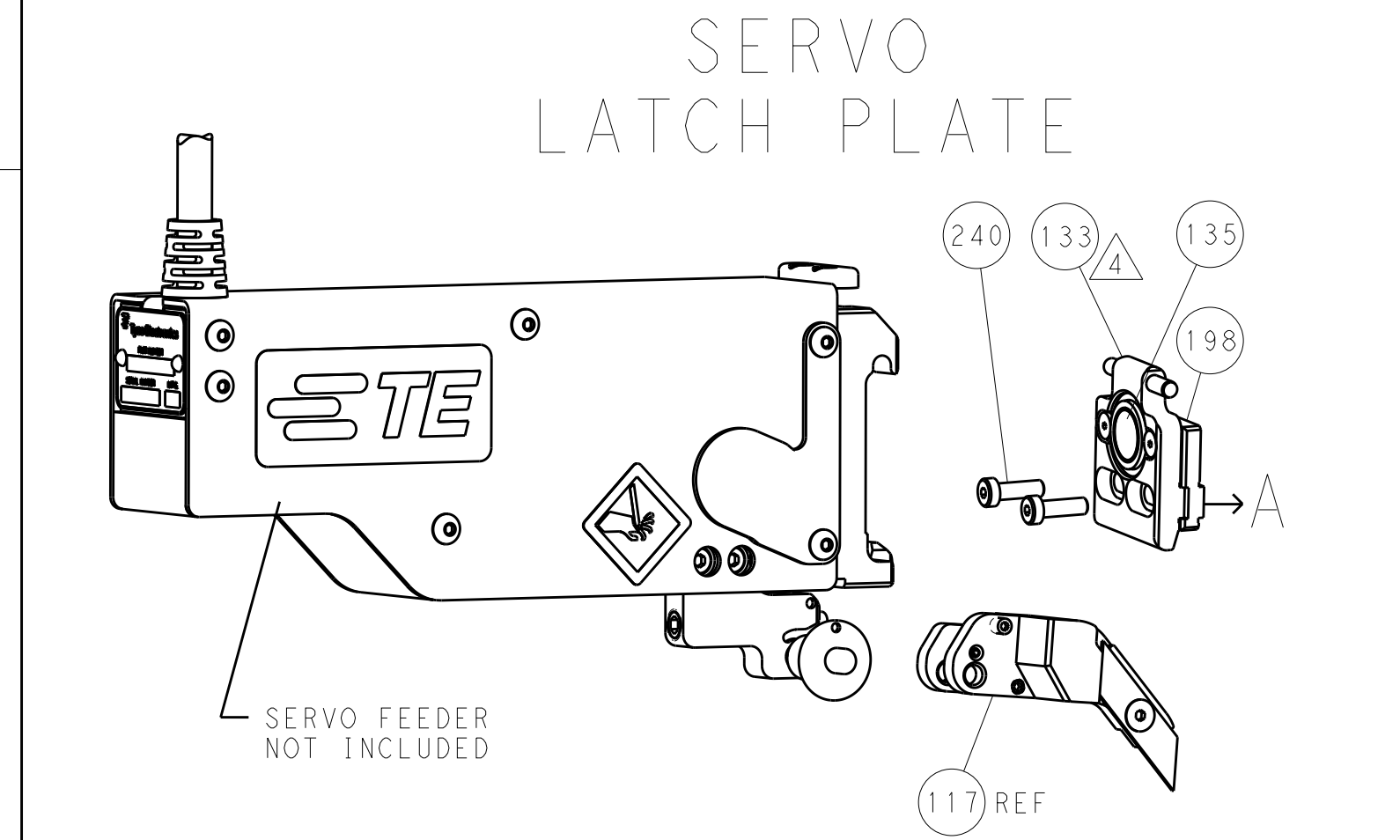
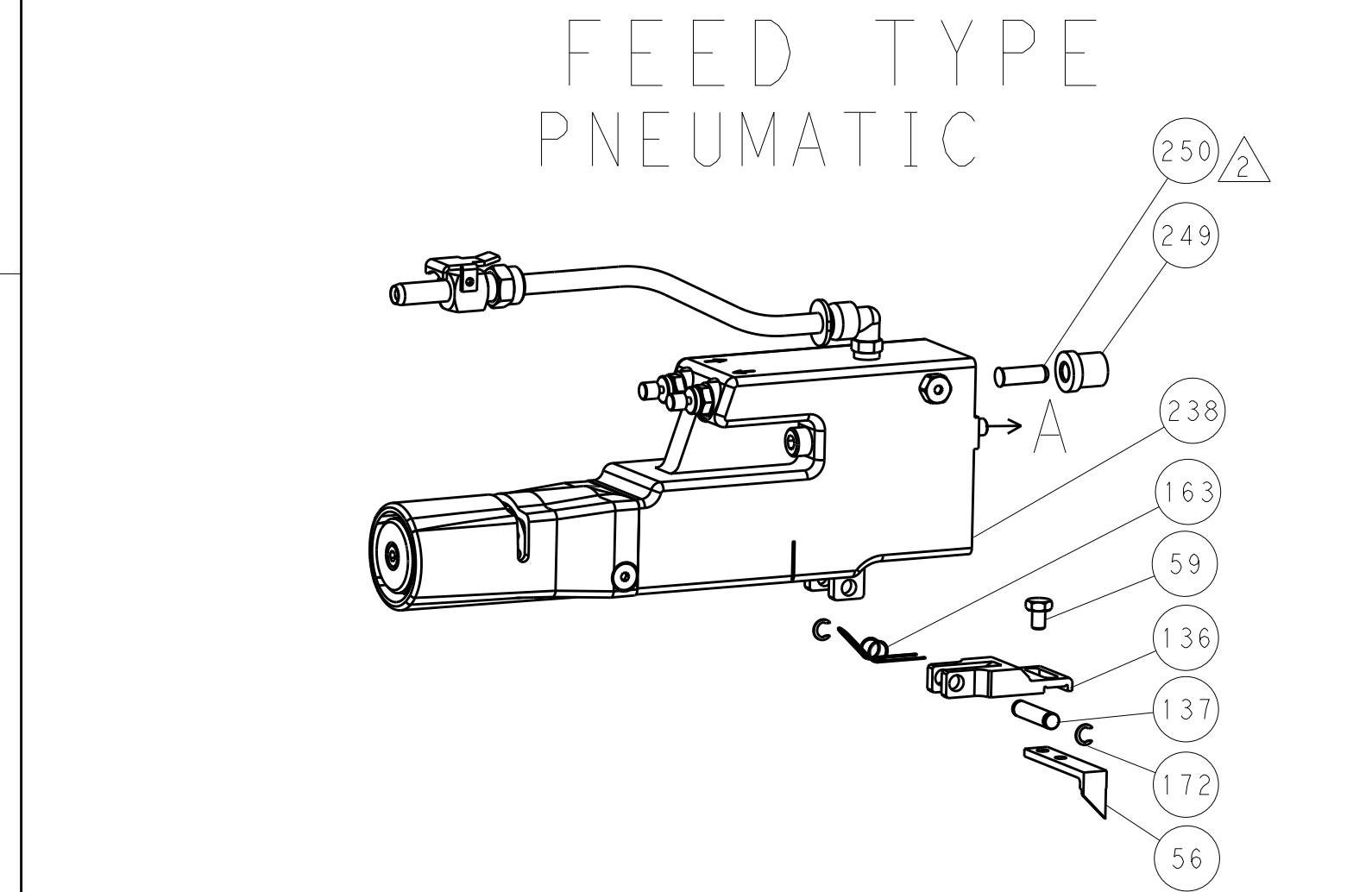
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

D

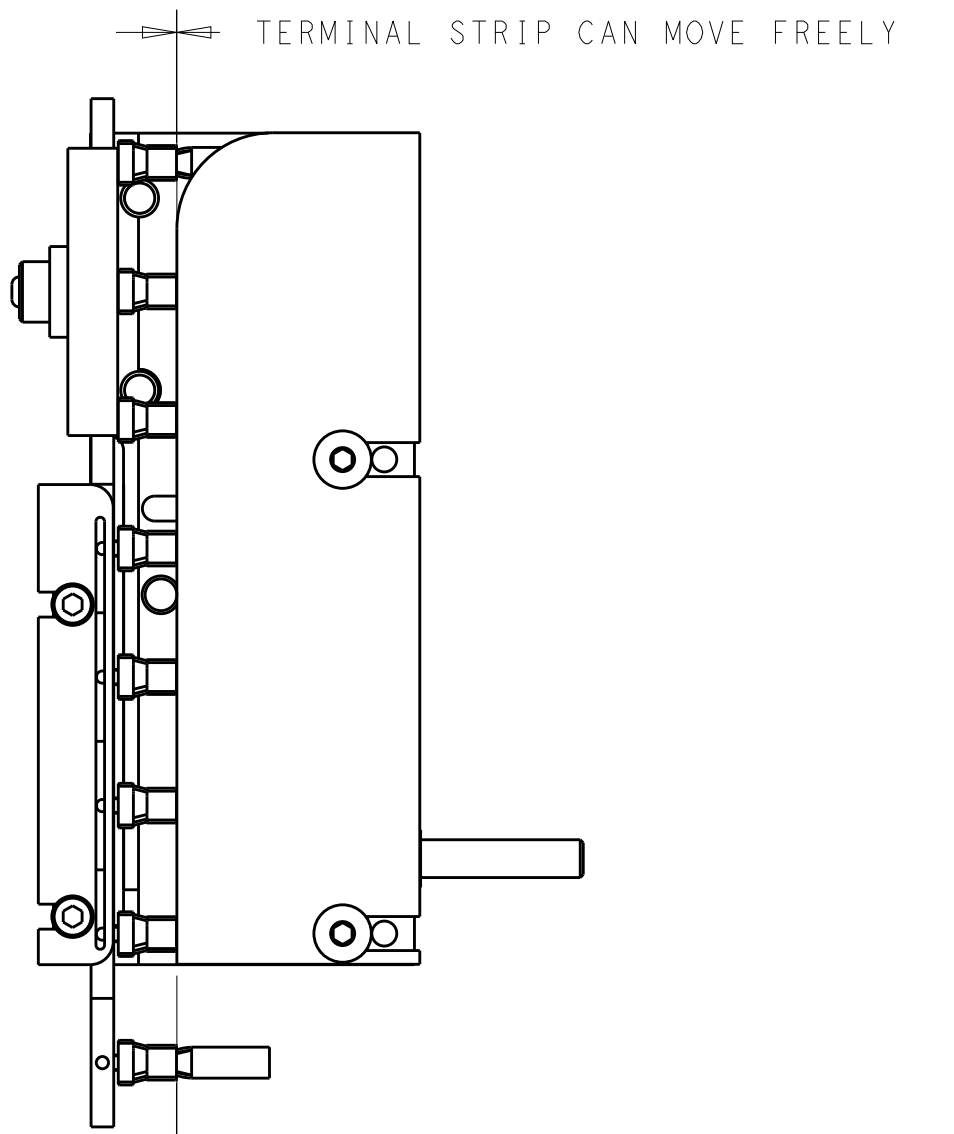
C

B

A



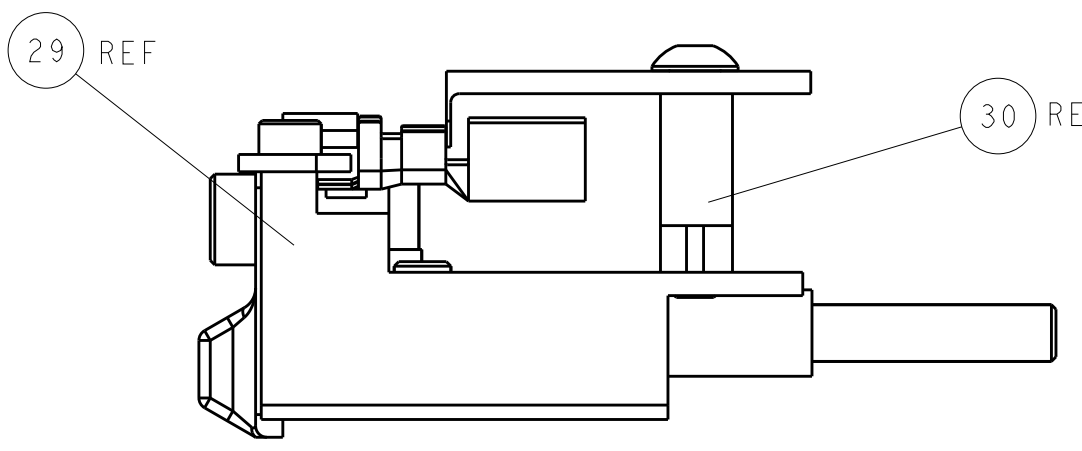
TERMINAL SUPPORT LOCATION



TERMINAL STRIP CAN MOVE FREELY
WITH A MINIMUM OF SIDE CLEARANCE

FEED TRACK POSITION

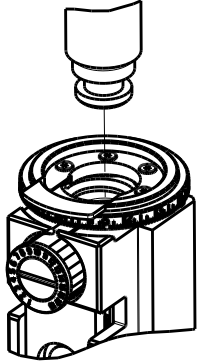
ITEM 30 LOCATED AT
REAR HOLES



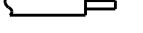
FEED TRACK POSITION
GUIDE BY WIRE BARREL

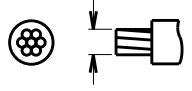
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R. KNEPPER 18JAN2012		TE Connectivity Harrisburg, PA 17105-3608	
mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		CHK T. ELBIN 18JAN2012		NAME Ocean Side Feed Applicator	
MATERIAL		WEIGHT		APVD M. CLIFFORD 18JAN2012		SIZE A1	
Customer Accessible Production Drawing		SCALE 1:2		PRODUCT SPEC		CAGE CODE 00779	
				APPLICATION SPEC		DRAWING NO 2151551	
						RESTRICTED TO G	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						-	-	-	-	-	-
	2-2151551-2	G	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE SMART APPLICATOR	2119951-1 2161326-1	- -	8-2151551-5 8-2151551-4	1901094-3 -	- -	2168400-6 (QUANTITY 2)
	2-2151551-5	G	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	-	-	-	-	-	-	-
	2-2151551-7	G	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151551-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	3.30 mm [.130]	F
INSUL	4.06 mm [.160]	F
APPLICATOR INSTRUCTIONS 408-10389 		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP 6.3/4.8 K LITEALUM CONTACT			
WIRE STRIP LENGTH 3.40-4.00 mm [.134 -.157 IN]			INSULATION DIAMETER RANGE Ø 3.56-3.74mm [.140-.147 IN]
TERMINAL APPLICATION SPECIFICATION 	114-94204	-	-
TERMINALS APPLIED 			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
2-2177839-1	2-2177839-3		

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
4.00mm2		1.90±0.04 [.0748±.0016]		8.5



- 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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151551-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151551-5
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 ITEMS 99 & 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 TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 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 SET THE FINE CRIMP HEIGHT ADJUSTMENT HEAD TO PROPER CRIMP HEIGHT PRIOR TO TIGHTENING/LOCKING THE BRASS TIP SET SCREW, ITEM 99, AGAINST THE ADJUSTMENT BOLT THREADS.
13. APPLICATOR TO BE USED IN CONJUNCTION WITH LEADMAKER INTIGRATION KIT, P/N 2280475-1 FOR CLAMPING AND SENSING OF FEED TRACK.

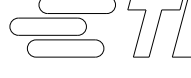
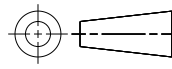
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	268
-	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
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-77	-27	-25	-22	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 2119599-1	LOC A	DIST 66	REVISIONS				
			P	LTR	DESCRIPTION	DATE	OWN
			-	-	SEE SHEET 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
-	-	-	1	2063440-1	AIR FEED MODULE	238
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⁸	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	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
-	-	-	1	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	1	1	1	2-2119656-4	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
⁷	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	1	2119799-1	HOLDER, FEED FINGER, AF	136
-	-	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
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²	-	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
²	1	1	1	2256587-1	SCR, SET, SOFT TIP, M4	99
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⁶	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	1	1	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1338685-1	PAWL, FEED	56
-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
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-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	2119644-2	RAM WASHER, PRECISION	38
-	1	1	1	1-1752356-2	SUPPORT, TERMINAL	34
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1320908-7	SPACER, STRIP GUIDE	30
-	1	1	1	1901086-1	PLATE, STRIP GUIDE	29
-	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1803142-1	DRAG, TERMINAL	25
-	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	690472-2	STRIPPER	19
¹	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1-356885-5	STOP, SHEAR	11
¹	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
¹	-	1	1	462006-6	FLOATING SHEAR, FRONT	9
¹	1	1	1	2161316-2	ANVIL, COMBINATION	8
-	1	1	1	2-240641-9	SPACER	7
-	-	-	-	-	-	6
-	1	1	1	1-1722335-0	SHEAR DEPRESSOR ASSEMBLY	5
-	1	1	1	5-238011-2	BLOCK, CRIMPER SPACER	4
¹	1	1	1	1722335-8	CRIMPER, INSULATION F	3
-	-	-	-	-	-	2
¹	1	1	1	2217302-2	CRIMPER, WIRE, CONICAL BLEND	1
-77	-27	-25	-22	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTROLLED BY THE ISSUING ORGANIZATION. SHOULD BE CONTROLLED FOR THE LATEST EDITION.				OWN CHR. KNEPPER 18JAN2012	 TE Connectivity Harrisburg, PA 17105-3608		
DIMENSIONS: mm				CHK T. ELBIN 18JAN2012			
				APVD M. CLIFFORD 18JAN2012	NAME Ocean Side Feed Applicator		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH				PRODUCT SPEC	SIZE A		
MATERIAL -				APPLICATION SPEC	CASE CODE 00779		
				WEIGHT -	DRAWING NO ©=2151551		
				Customer Accessible Production Drawing			RESTRICTED TO -
				SCALE 1:2			REV G

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

D

D

C

C

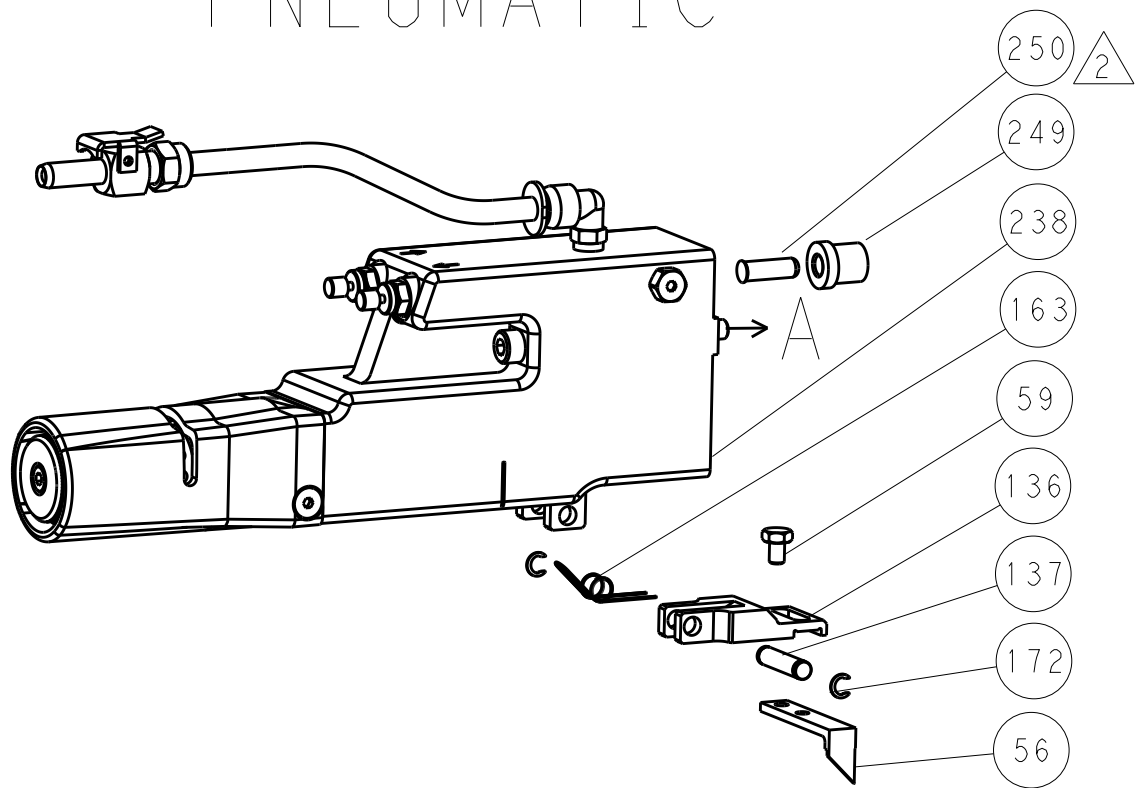
B

B

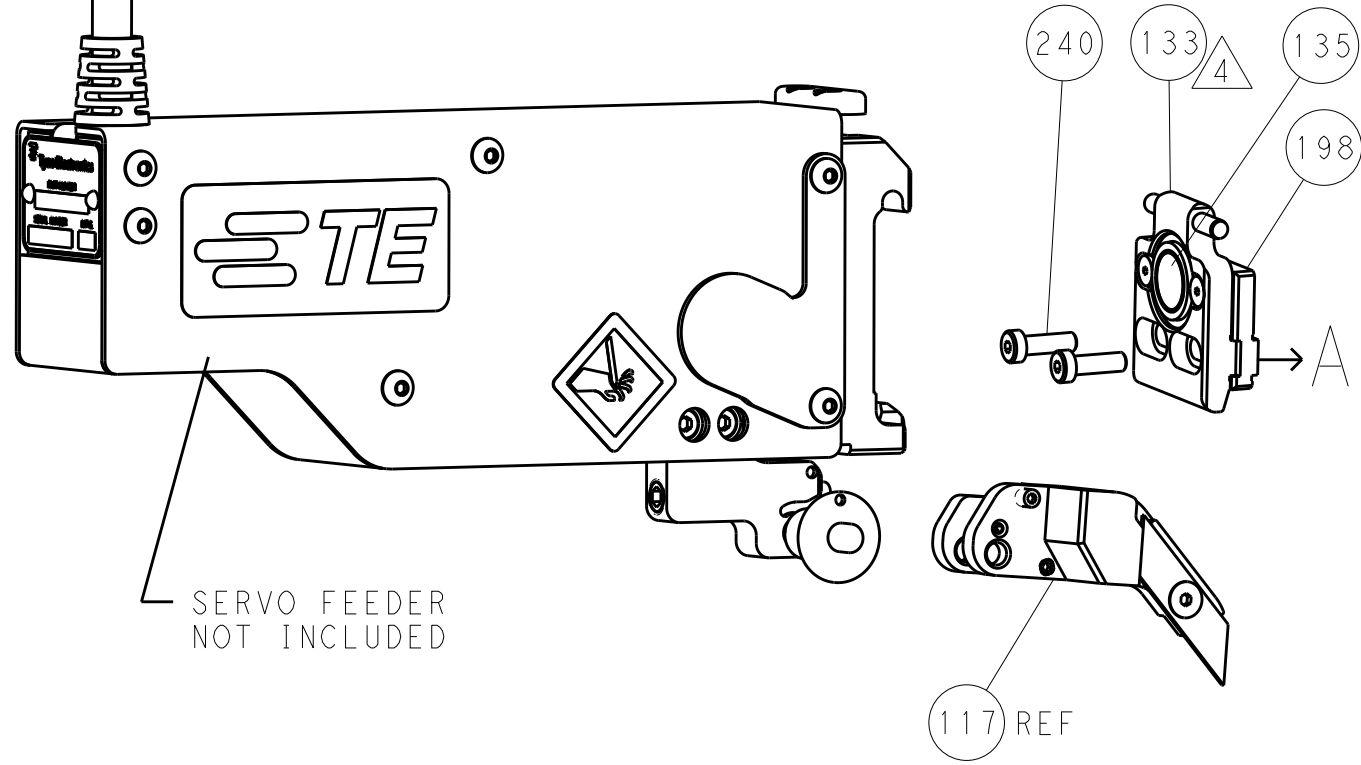
A

A

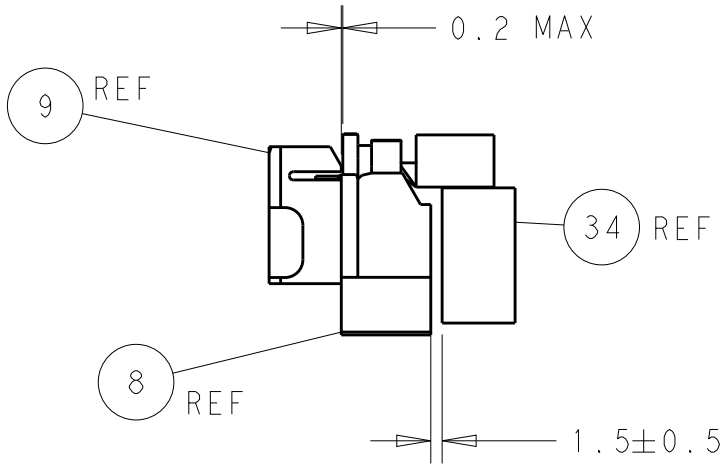
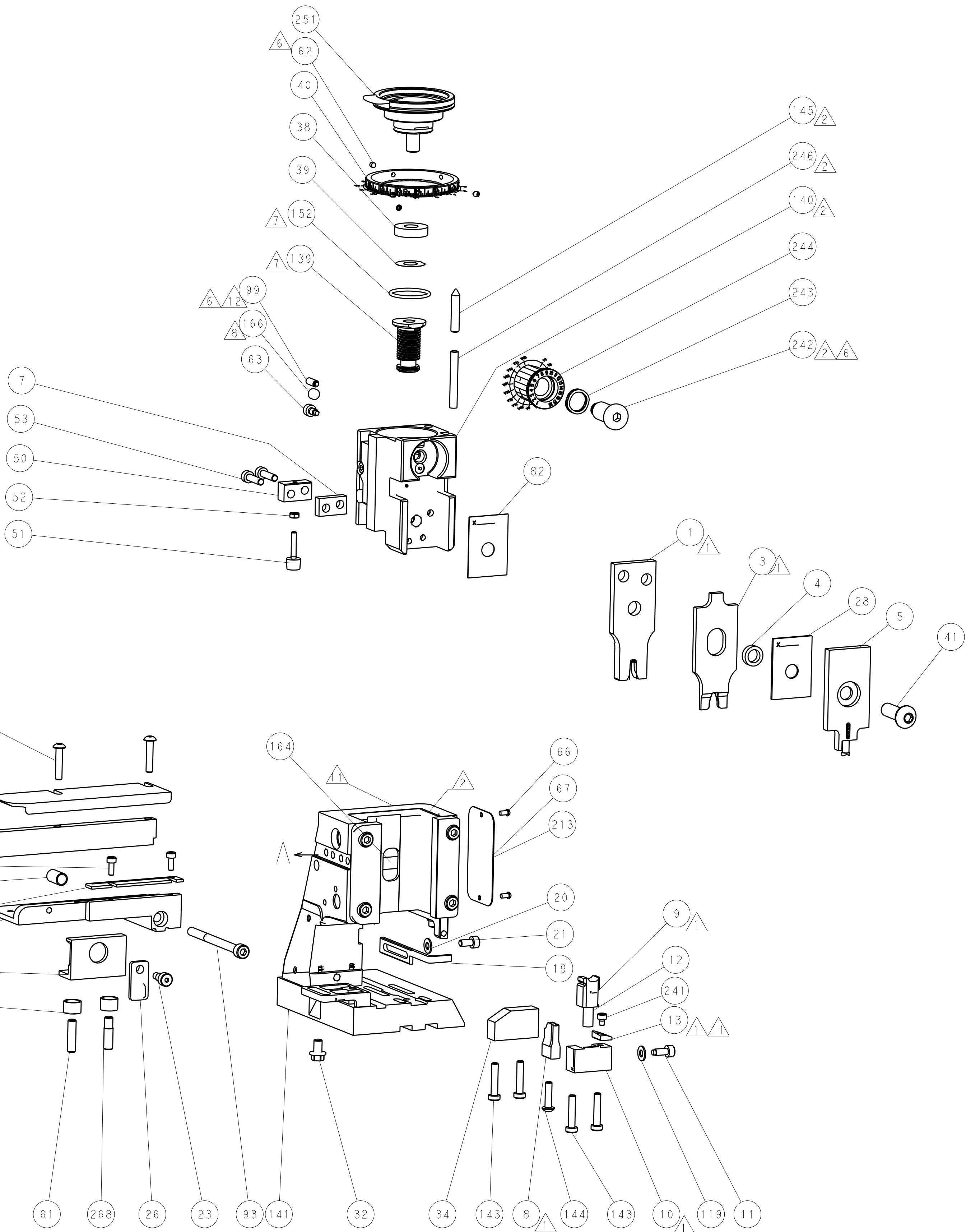
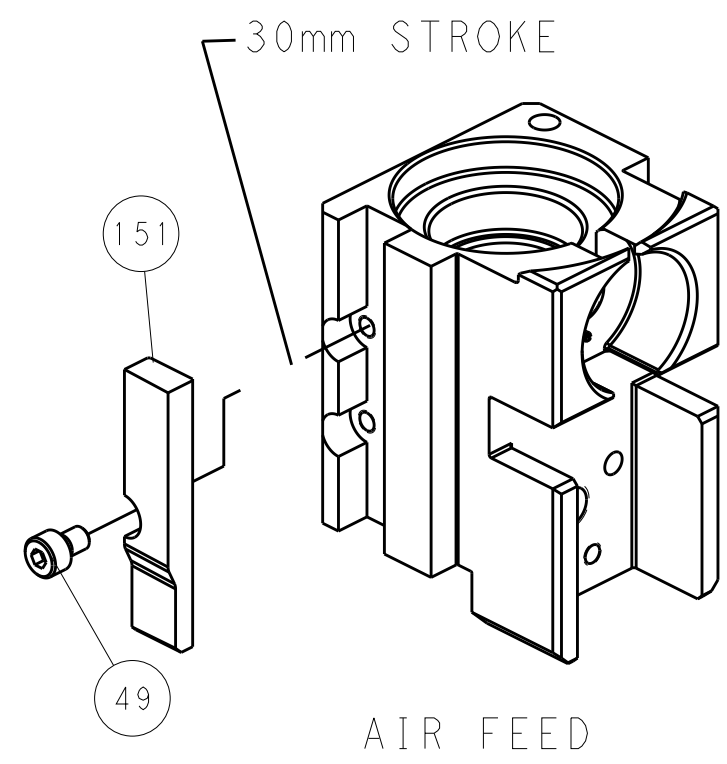
FEED TYPE PNEUMATIC



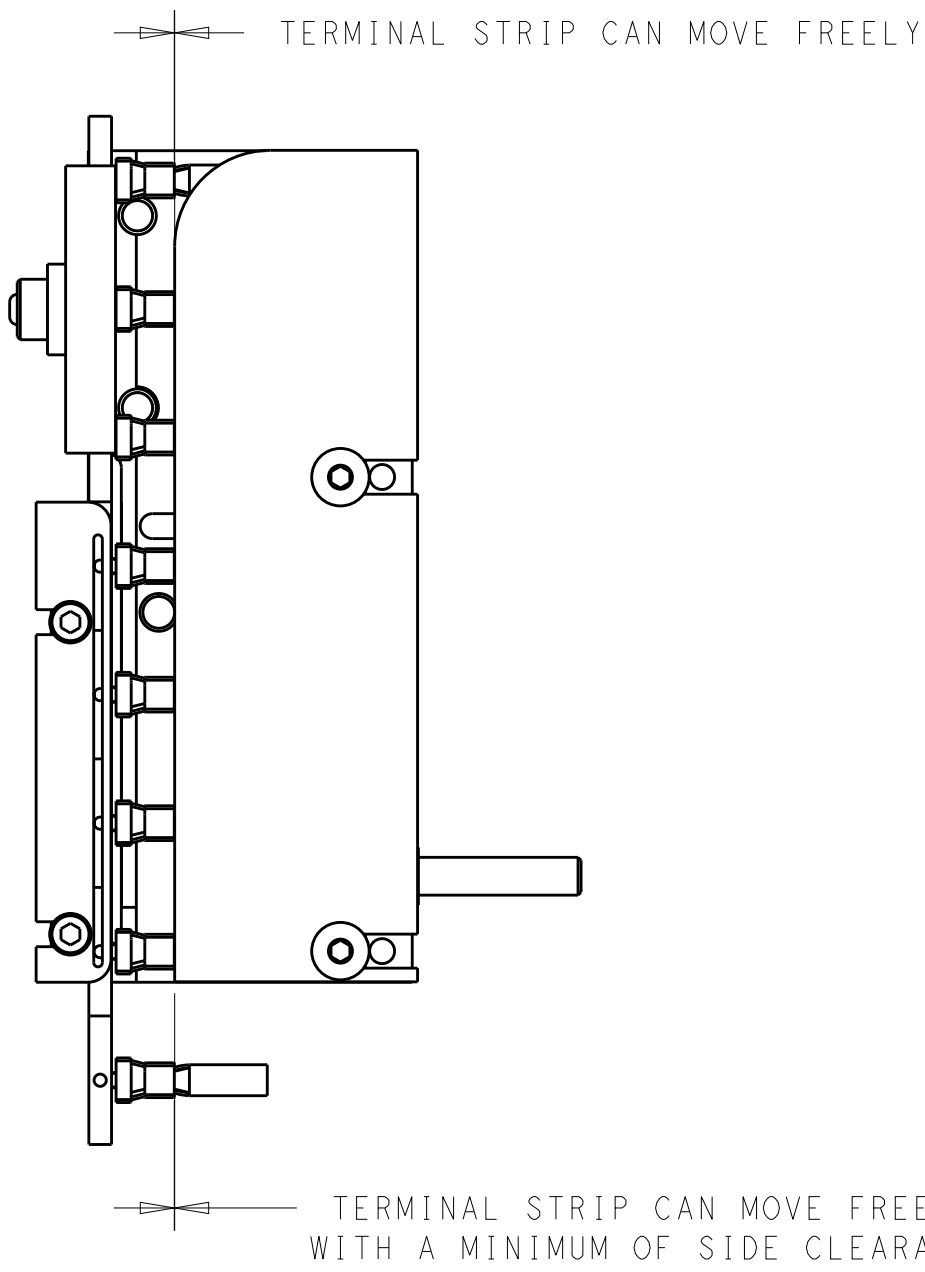
SERVO LATCH PLATE



CAM POSITIONS

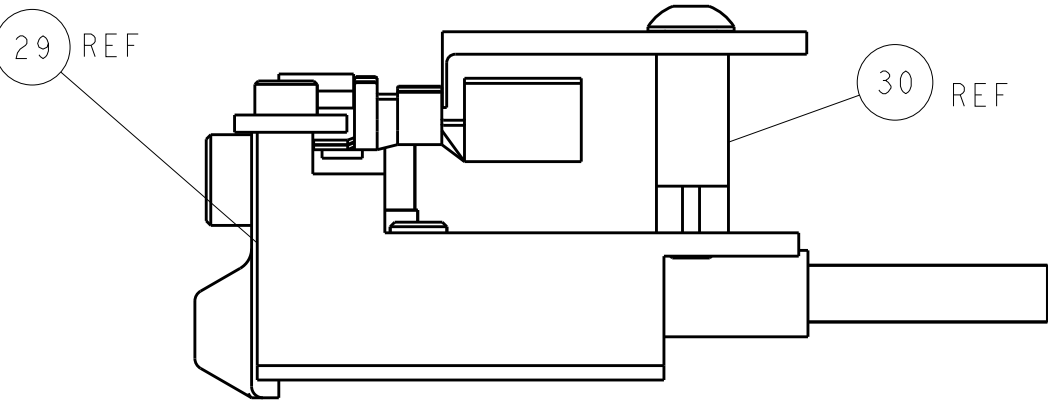


TERMINAL SUPPORT LOCATION



FEED TRACK POSITION

ITEM 30 LOCATED AT
REAR HOLES



FEED TRACK POSITION
GUIDE BY WIRE 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. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN R. KNEPPER 18JAN2012	NAME Ocean Side Feed Applicator
DIMENSIONS: mm		CHK T. ELBIN 18JAN2012	SIZE A1
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		APVD M. CLIFFORD 18JAN2012	CAGE CODE 00779
MATERIAL -		PRODUCT SPEC -	DRAWING NO C=2151551
-		APPLICATION SPEC -	RESTRICTED TO -
-		WEIGHT -	SCALE 1:2
Customer Accessible Production Drawing		SHEET 4	OF 4
		REV G	