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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

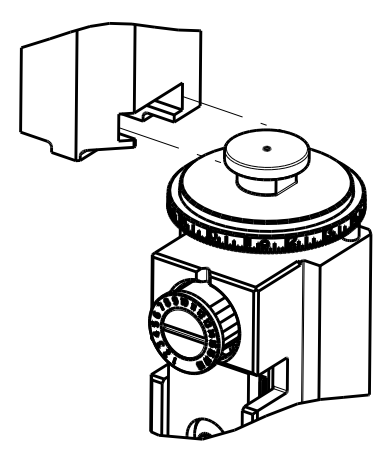
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2266072-1

B

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

2119950-1

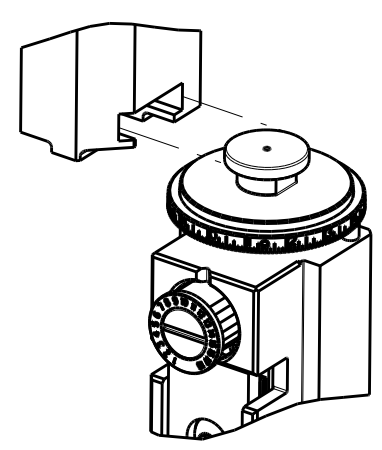
1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1



2266072-2

B

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1

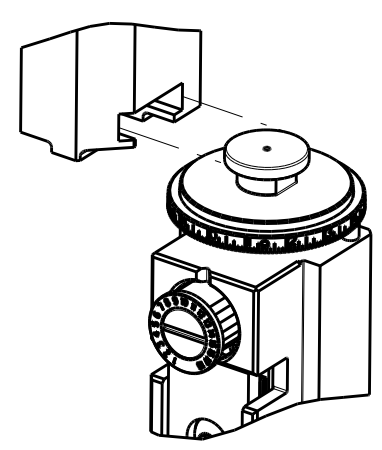
1338685-1

5-18022-5

2119653-1

-

-



2266072-5

B

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2119949-1

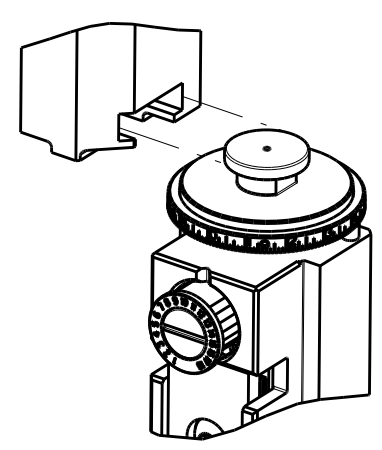
1338685-1

5-18022-5

2119653-1

-

-



2266072-6

B

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

2119949-1

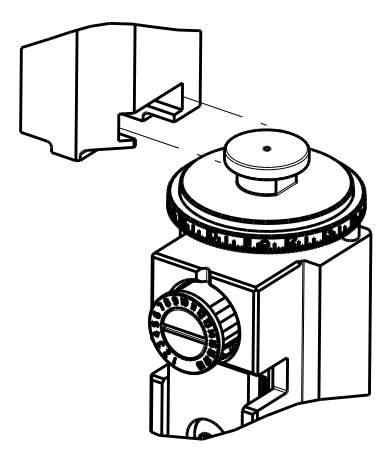
1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1



2266072-7

B

FINE CRIMP HEIGHT ADJUST

NONE

-

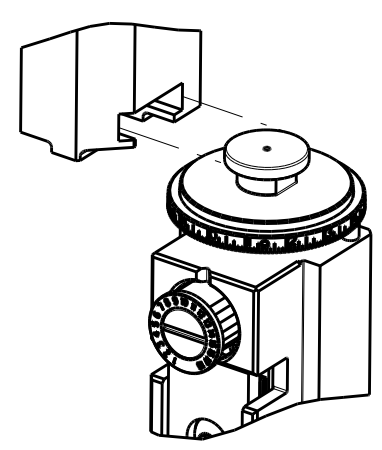
-

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-

-



7-2266072-7

A

CRIMP TOOLING KIT

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-

-

-

-

APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 2.03 mm [.080] F

INSUL 4.06 mm [1.60] O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB 2.8 x 0.8

WIRE STRIP LENGTH INSULATION DIAMETER RANGE

4.20-4.80 mm [1.65-.189 IN] 3.40mm [1.134IN] MAX

TERMINAL APPLICATION SPECIFICATION

114-18051

TERMINALS APPLIED

TE TERMINAL TE SEAL

1-962915-1 2-962915-1 828904-1

1-962915-2 2-962915-2 828904-2

1-962915-3 2-962915-3 828904-3

6-962915-6

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB 2.8 X 0.8

WIRE STRIP LENGTH INSULATION DIAMETER RANGE

4.20-4.80 mm[.165-.189IN] 3.40 mm [1.134IN] MAX

TERMINAL APPLICATION SPECIFICATION

114-18051

TERMINALS APPLIED

TE TERMINAL TE SEAL

1-962915-3 828904-1 828904-3

828904-2

WIRE SIZE CRIMP HEIGHT CRIMP HEIGHT REFERENCE SETTING

1.00mm2 1.20+/-0.05 [1.047+/-0.002] 6.0

0.75mm2 1.18+/-0.05 [1.046+/-0.002] 6.2

0.50mm2 1.15+/-0.05 [1.045+/-0.002] 6.5

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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266072-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266072-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266072-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266072-6

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 ITEM 62 & 180.
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.

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 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. THE INSULATION RANGE IS Ø1.2-2.1 mm.

14 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.

15. THE APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

APPLICATOR STYLE CONVERSION CHART

PART NUMBERS REQUIRED

2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1

2119951-1 - 8-2266072-5 1901094-3 2-1752354-3 2168400-6 (QUANTITY 2)

2161326-1 - 8-2266072-4 - - -

2119949-1 1338685-1 5-18022-5 2119653-1 - -

2119951-1 - 8-2266072-5 1901094-3 2-1752354-3 2168400-6 (QUANTITY 2)

2161326-1 - 8-2266072-4 - - -

2119949-1 1338685-1 5-18022-5 2119653-1 - -

2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1

- - - - - -

- - - - - -

- - - - - -

- - - - - -

SET UP GAUGE 2119599-1

LOC A

DIST 66

REVISIONS

DESCRIPTION DATE DWN APVD

ECR-15-004295 18MAR2015 RK GB

ECR-16-008300 8JUN2016 RS LZ

- - - - 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

- - 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 2-1752354-3 STANDOFF,HOLD-DOWN 180

- 1 1 1 1 1 993111-1 PIN, SLOTTED SPRING 3.0 X 20.0 177

- 1 1 1 1 1 5-22280-0 SPRING, COMPRESSION 176

- 1 1 1 1 1 1752353-3 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

- 1 1 1 1 1 2119956-1 DOCUMENTATION PACKAGE 71

- 1 1 1 1 1 2119791-9 DEPRESSOR, WIRE 70

- 1 1 1 1 1 2119943-1 WASHER, SPACER 69

- 1 - - 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 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

- 1 1 1 1 1 1-5018030-0 NUT, HEX, REG, RoHS, M3.5 52

- 1 1 1 1 1 4-1722335-3 STRIPPER, SIDE FEED 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 2-2119656-1 APPLICATOR BASIC ASSEMBLY, SF 46

- 1 - 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 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 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 1-1320908-2 SPACER, STRIP GUIDE 30

- 1 1 1 1 1 2119959-2 ASSEMBLY, STRIP GUIDE 29

- 1 1 1 1 1 455888-3 SPACER, CRIMPER 28

- 1 1 1 1 1 1320928-6 STRIP GUIDE 24

- 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 318707-1 FLOATING SHEAR, FRONT 9

1 1 1 1 1 2-1333204-6 ANVIL, COMBINATION 8

- 1 1 1 1 1 2119781-1 DEPRESSOR, SHEAR 5

- 1 1 1 1 1 238011-7 BLOCK, CRIMPER SPACER 4

1 1 1 1 1 1-1633965-8 CRIMPER, INSULATION O PREMIUM 3

- 1 1 1 1 1 1-455888-1 SPACER, CRIMPER 2

1 1 1 1 1 1-456405-6 CRIMPER, WIRE PREMIUM 1

-77 -7 -6 -5 -2 -1 PART NO DESCRIPTION ITEM NO

APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 2.03 mm [.080] F

INSUL 4.06 mm [1.60] O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

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114-18051

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TE TERMINAL TE SEAL

1-962915-1 2-962915-1 828904-1

1-962915-2 2-962915-2 828904-2

1-962915-3 2-962915-3 828904-3

6-962915-6

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB 2.8 X 0.8

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TERMINAL APPLICATION SPECIFICATION

114-18051

TERMINALS APPLIED

TE TERMINAL TE SEAL

1-962915-3 828904-1 828904-3

828904-2

WIRE SIZE CRIMP HEIGHT CRIMP HEIGHT REFERENCE SETTING

1.00mm2 1.20+/-0.05 [1.047+/-0.002] 6.0

0.75mm2 1.18+/-0.05 [1.046+/-0.002] 6.2

0.50mm2 1.15+/-0.05 [1.045+/-0.002] 6.5

1 RECOMMENDED SPARE PARTS

2 GREASE BEARING SURFACES LIGHTLY

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4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
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PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266072-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266072-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266072-6

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 ITEM 62 & 180.
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.

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.

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13 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. THE INSULATION RANGE IS Ø1.2-2.1 mm.

14 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.

15. THE APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

APPLICATOR STYLE CONVERSION CHART

PART NUMBERS REQUIRED

2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1

2119951-1 - 8-2266072-5 1901094-3 2-1752354-3 2168400-6 (QUANTITY 2)

2161326-1 - 8-2266072-4 - - -

2119949-1 1338685-1 5-18022-5 2119653-1 - -

2119951-1 - 8-2266072-5 1901094-3 2-1752354-3 2168400-6 (QUANTITY 2)

2161326-1 - 8-2266072-4 - - -

2119949-1 1338685-1 5-18022-5 2119653-1 - -

2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1

- - - - - -

- - - - - -

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- - - - - -

SET UP GAUGE 2119599-1

LOC A

DIST 66

REVISIONS

DESCRIPTION DATE DWN APVD

ECR-15-004295 18MAR2015 RK GB

ECR-16-008300 8JUN2016 RS LZ

- - - - 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

- - 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 2-1752354-3 STANDOFF,HOLD-DOWN 180

- 1 1 1 1 1 993111-1 PIN, SLOTTED SPRING 3.0 X 20.0 177

- 1 1 1 1 1 5-22280-0 SPRING, COMPRESSION 176

- 1 1 1 1 1 1752353-3 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

- 1 1 1 1 1 2119956-1 DOCUMENTATION PACKAGE 71

- 1 1 1 1 1 2119791-9 DEPRESSOR, WIRE 70

- 1 1 1 1 1 2119943-1 WASHER, SPACER 69

- 1 - - 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 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

- 1 1 1 1 1 1-5018030-0 NUT, HEX, REG, RoHS, M3.5 52

- 1 1 1 1 1 4-1722335-3 STRIPPER, SIDE FEED 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 2-2119656-1 APPLICATOR BASIC ASSEMBLY, SF 46

- 1 - 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

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- 1 1 1 1 1 455888-3 SPACER, CRIMPER 28

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- 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 318707-1 FLOATING SHEAR, FRONT 9

1 1 1 1 1 2-1333204-6 ANVIL, COMBINATION 8

- 1 1 1 1 1 2119781-1 DEPRESSOR, SHEAR 5

- 1 1 1 1 1 238011-7 BLOCK, CRIMPER SPACER 4

1 1 1 1 1 1-1633965-8 CRIMPER, INSULATION O PREMIUM 3

- 1 1 1 1 1 1-455888-1 SPACER, CRIMPER 2

1 1 1 1 1 1-456405-6 CRIMPER, WIRE PREMIUM 1

-77 -7 -6 -5 -2 -1 PART NO DESCRIPTION ITEM NO

APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 2.03 mm [.080] F

INSUL 4.06 mm [1.60] O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: TAB 2.8 x 0.8

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4.20-4.80 mm[.165-.189IN] 3.40 mm [1.134IN] MAX

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114-18051

TERMINALS APPLIED

TE TERMINAL TE SEAL

1-962915-1 2-962915-1 828904-1

1-962915-2 2-962915-2 828904-2

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6-962915-6

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114-18051

TERMINALS APPLIED

TE TERMINAL TE SEAL

1-962915-3 828904-1 828904-3

828904-2

WIRE SIZE CRIMP HEIGHT CRIMP HEIGHT REFERENCE SETTING

1.00mm2 1.20+/-0.05 [1.047+/-0.002] 6.0

0.75mm2 1.18+/-0.05 [1.046+/-0.002] 6.2

0.50mm2 1.15+/-0.05 [1.045+/-0.002] 6.5

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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266072-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266072-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266072-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266072-6

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 ITEM 62 & 180.
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.

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 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. THE INSULATION RANGE IS Ø1.2-2.1 mm.

14 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.

15. THE APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

APPLICATOR STYLE CONVERSION CHART

PART NUMBERS REQUIRED

2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1

2119951-1 - 8-2266072-5 1901094-3 2-1752354-3 2168400-6 (QUANTITY 2)

2161326-1 - 8-2266072-4 - - -

2119949-1 1338685-1 5-18022-5 2119653-1 - -

2119951-1 - 8-2266072-5 1901094-3 2-1752354-3 2168400-6 (QUANTITY 2)

2161326-1 - 8-2266072-4 - - -

2119949-1 1338685-1 5-18022-5 2119653-1 - -

2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1

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SET UP GAUGE 2119599-1

LOC A

DIST 66

REVISIONS

DESCRIPTION DATE DWN APVD

ECR-15-004295 18MAR2015 RK GB

ECR-16-008300 8JUN2016 RS LZ

- - - - 1 - 2079988-1 BUSHING, LCH5-12, MISUMI 249

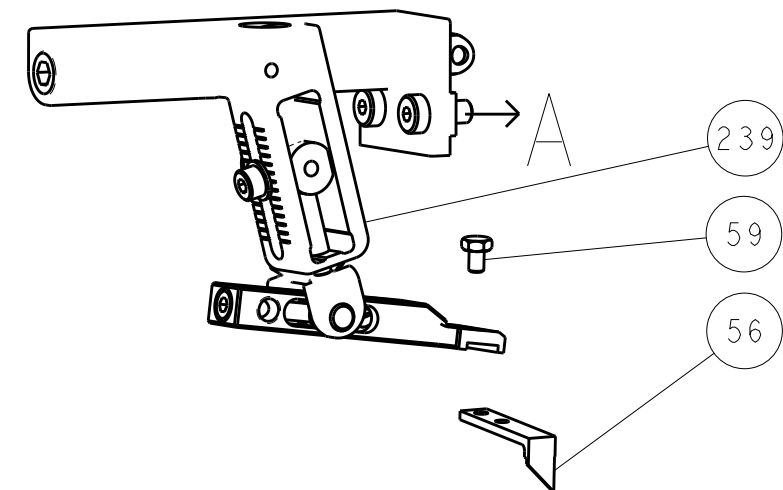
- - - - 1 - 2119641-1 FEED CAM, AIR FEED 248

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

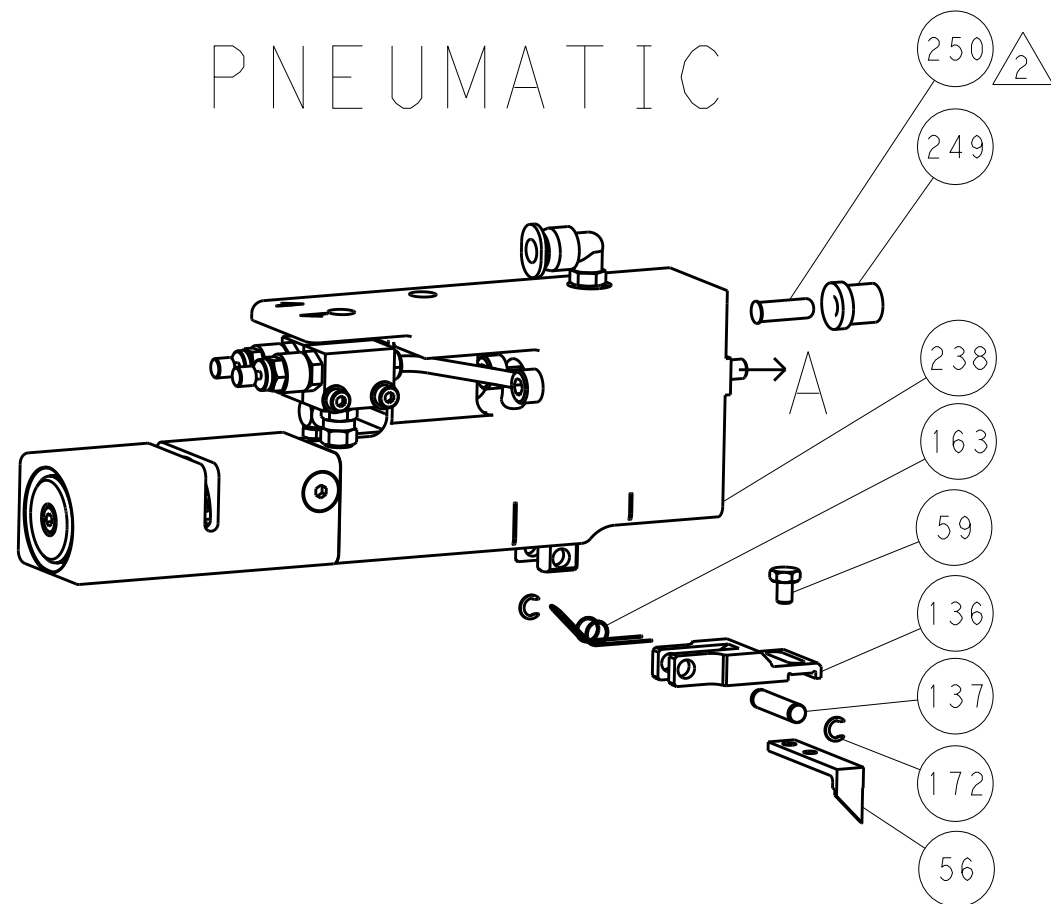
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LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE MECHANICAL



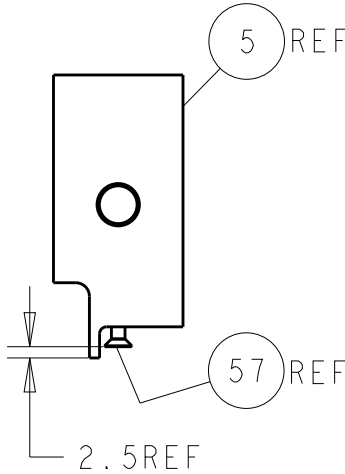
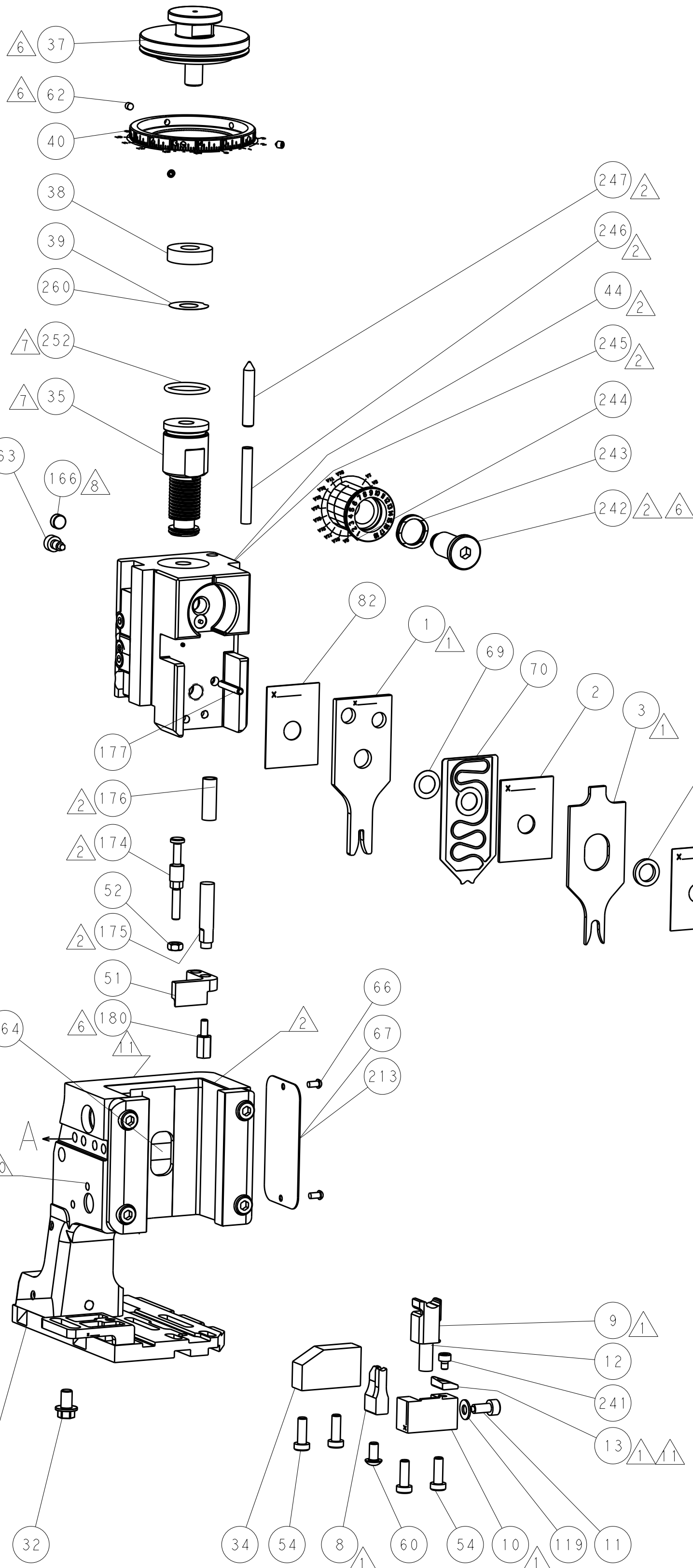
PNEUMATIC



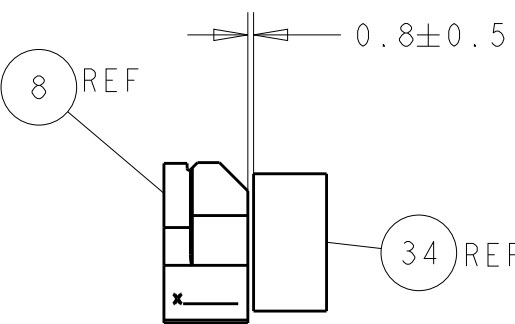
SERVO LATCH PLATE



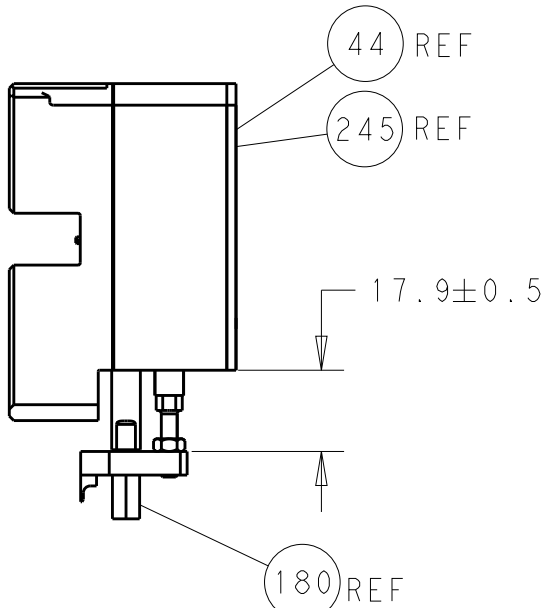
CAM POSITIONS



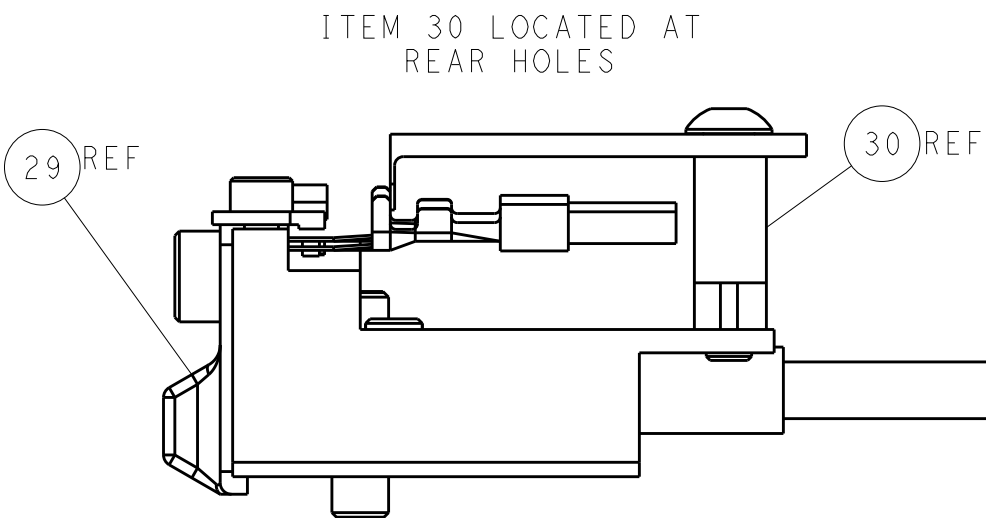
SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



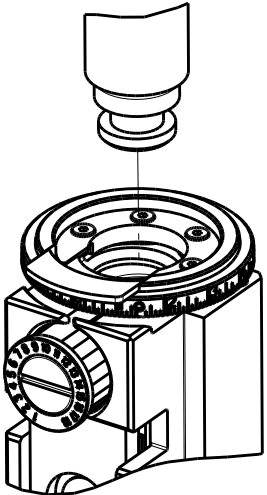
HOLDDOWN SET-UP



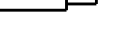
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE WITHOUT NOTICE.				DWN	X. ZHAO	09OCT2013	TE Connectivity				
				CHK	T. ELBIN	09OCT2013	Harrisburg, PA 17105-3608				
				APVD	L. ZHANG	09OCT2013	NAME Ocean Side Feed Applicator -				
				PRODUCT SPEC							
				APPLICATION SPEC							
				SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO				
				A1	00779	C=2266072					
				Customer Accessible Production Drawing		SCALE	1:2	SHEET	2	OF	4
						REV	B1				

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	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
						SERVO LATCH PLATE	2119951-1	-	8-2266072-5	1901094-3	2-1752354-3	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2266072-4	-	-	-
						MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
						SERVO LATCH PLATE	2119951-1	-	8-2266072-5	1901094-3	2-1752354-3	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2266072-4	-	-	-
						MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
						PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
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APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	4.06 mm [.160]	O
APPLICATOR INSTRUCTIONS 408-10389 		

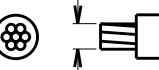
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 2.8 x 0.8			
WIRE STRIP LENGTH 4.20-4.80 mm [.165-.189 IN]			INSULATION DIAMETER RANGE Ø 3.40mm [.134IN] MAX
TERMINAL APPLICATION SPECIFICATION 	114-18051	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1-962915-1	2-962915-1	828904-1	
1-962915-2	2-962915-2	828904-2	
1-962915-3	2-962915-3	828904-3	
	6-962915-6		

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING ⁹ 
1.00mm2	1.20+/-0.05 [.047+/- .002]	6.0
0.75mm2	1.18+/-0.05 [.046+/- .002]	6.2
0.50mm2	1.15+/-0.05 [.045+/- .002]	6.5



- 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:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266072-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266072-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266072-5
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 ITEM 62 & 180.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- ¹² THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. THE INSULATION RANGE IS Ø1.2-2.1 mm.
- ¹³ 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.
14. THE APPLICATOR IS SPECIFIC FOR USE IN A STRIPPER SEAL TERMINATING UNIT.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: TAB 2.8 X 0.8			
WIRE STRIP LENGTH 4.20-4.80 mm [.165-.189IN]			INSULATION DIAMETER RANGE Ø 3.40 mm [.134IN]MAX
TERMINAL APPLICATION SPECIFICATION		 	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
1-962915-3		828904-1	828904-3
		828904-2	

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING ⁹ 
0.61mm2	1.18+/-0.03 [.046+/- .001]	6.2

¹³ THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES **THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

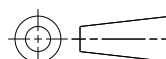
*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-77	-27	-25	-22	-21	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
			-	-	SEE SHEET 1	-

-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	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	-	-	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	-	-	2119740-2	TAG, IDENTIFICATION	213
-	-	1	-	-	1901094-3	SPACER, FEEDER	198
-	1	1	1	1	2-1752354-3	STANDOFF, HOLD-DOWN	180
-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	1	1	1	1	5-22280-0	SPRING, COMPRESSION	176
-	1	1	1	1	1752353-3	GUIDE PIN, HOLDDOWN	175
-	1	1	1	1	1901680-2	GUIDE PIN, HOLDDOWN	174
-	-	-	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
-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	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	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	2-2119656-2	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	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
-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	985575-3	SCR, FLT SKT HD CAP M3 X 10.0	57
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
-	1	1	1	1	4-1722335-3	STRIPPER, SIDE FEED	51
-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	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	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1-1752356-6	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	1-1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	2-1333204-6	ANVIL, COMBINATION	8
-	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1-1633965-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
-	1	1	1	1	1-456405-6	CRIMPER, WIRE PREMIUM	1

-77-27-25-22-21		PART NO		DESCRIPTION		ITEM NO	
NOTE: THIS IS A SUMMARY OF THE INFORMATION CONTAINED IN THIS DRAWING. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT LIABILITY TO THE ORGANIZATION WHOSE NAME IS SHOWN HEREON FOR THE LATEST REVISION.				OWN X_ZHAO 05AUG2011		 TE Connectivity Harrisburg, PA 17105-3608	
				CHK L_ZHANG 05AUG2011			
				APVD S_XI 05AUG2011			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME			
mm				PRODUCT SPEC		Ocean Side Feed	
		Ø PLC ±		-		Applicator	
		1 PLC ±		-		-	
		2 PLC ±		-		-	
		3 PLC ±		-		-	
		4 PLC ±		-		-	
ANGLES		±°		APPLICATION SPEC		-	
FINISH				WEIGHT		RESTRICTED TO	
-		-		A1 00779 C=2266072		-	
Customer Accessible Production Drawing				SCALE 1:2		SHEET 3 OF 4 REV B1	

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

D

C

B

A

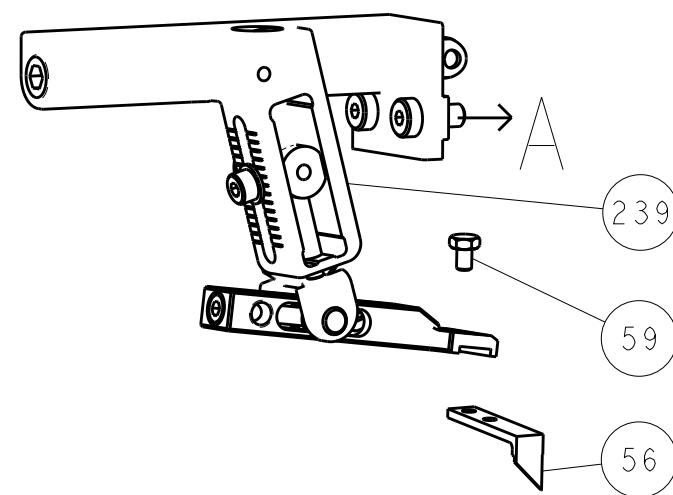
D

C

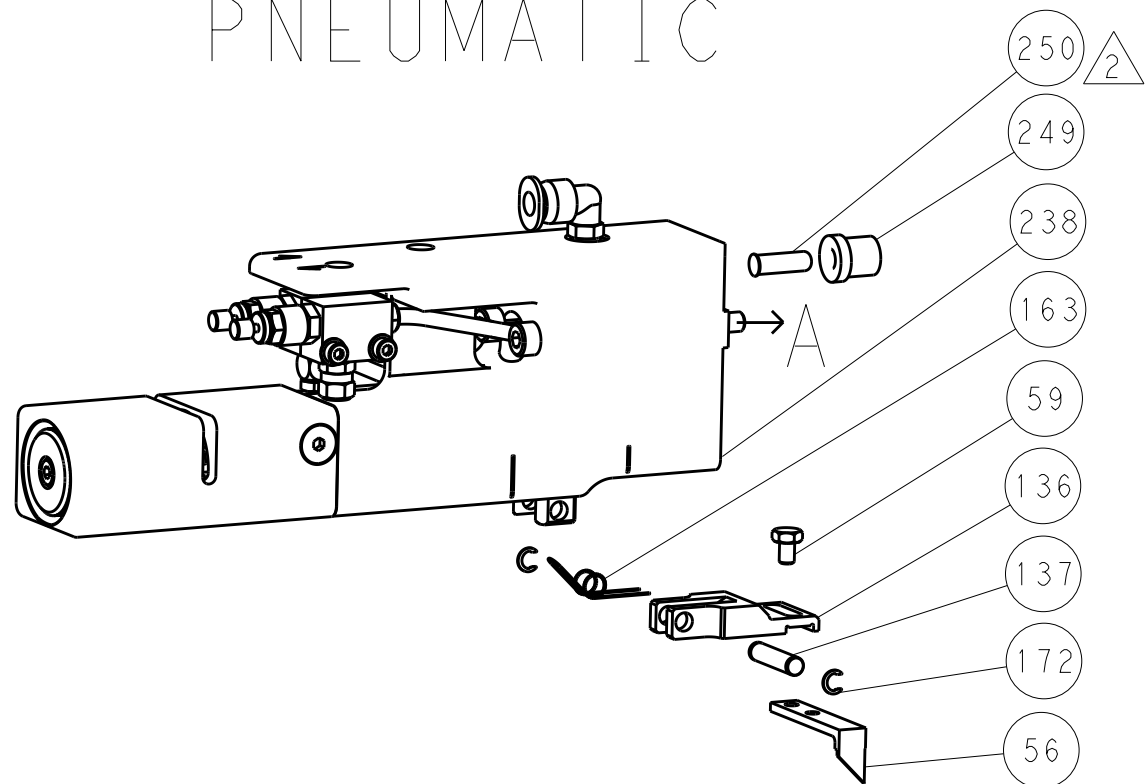
B

A

FEED TYPE MECHANICAL



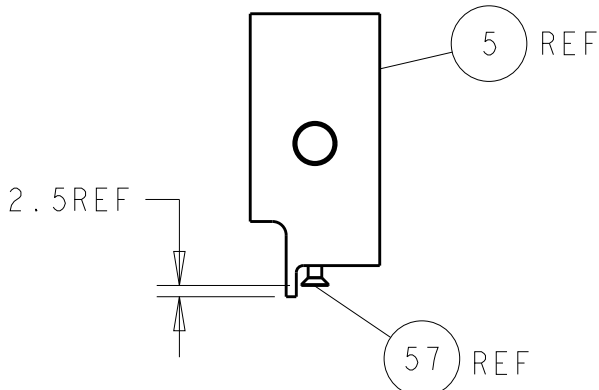
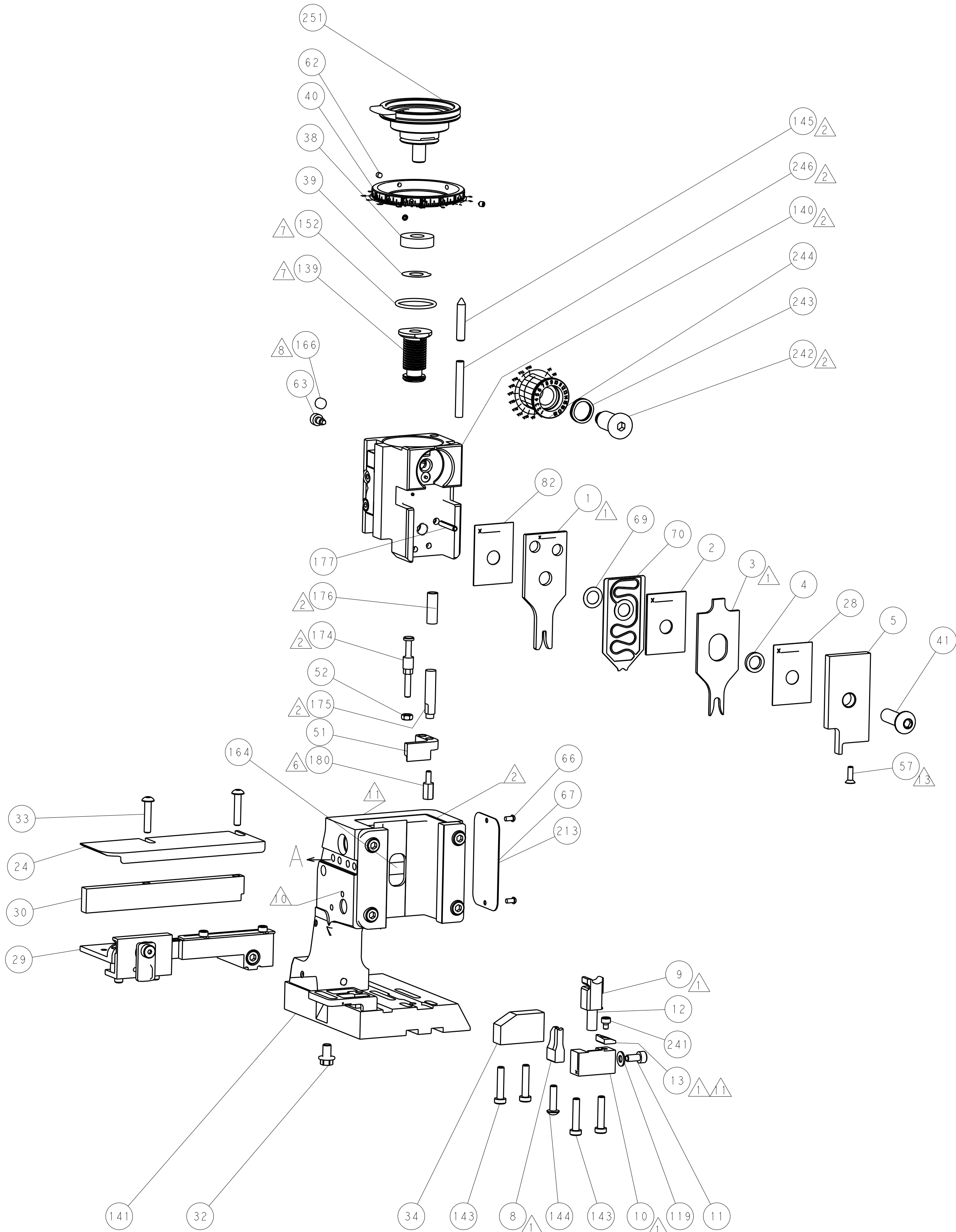
PNEUMATIC



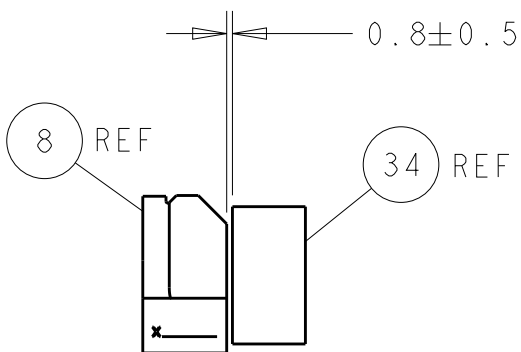
SERVO LATCH PLATE



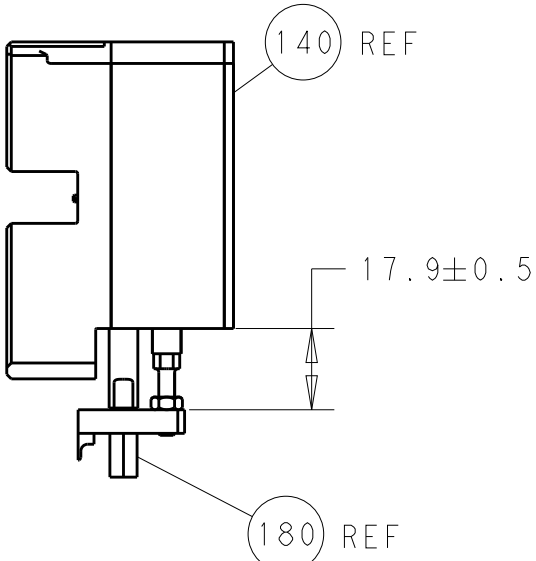
CAM POSITIONS



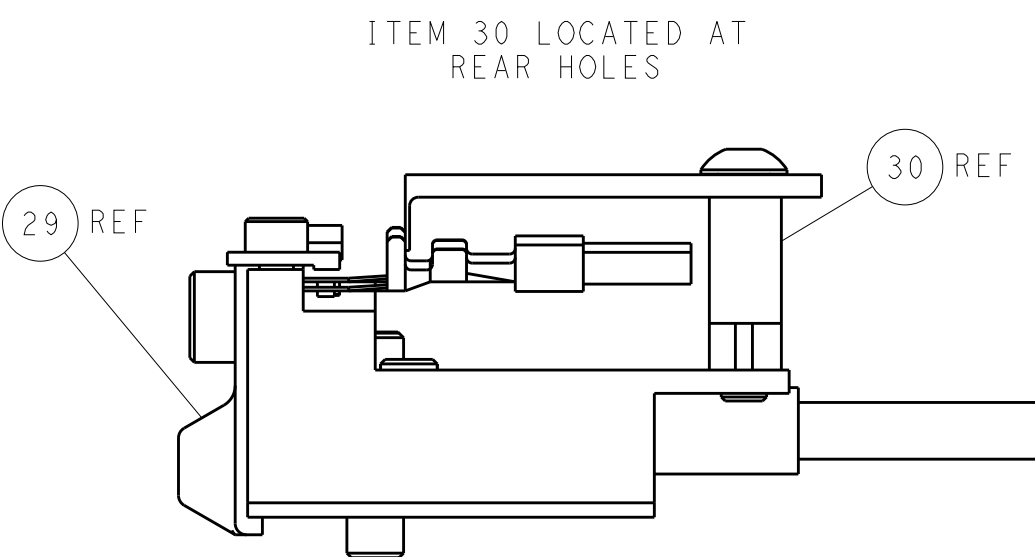
SHEAR DEPRESSOR DETAIL



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)

FIRST PUBLISHED BY: 09OCT2013 THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN: X. ZHAO CHK: T. ELBIN APVD: L. ZHANG	09OCT2013 09OCT2013 09OCT2013	NAME: Ocean Side Feed Applicator	RESTRICTED TO: -
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		SIZE: A1	
0 PLC ±		1 PLC ±		CAGE CODE: 00779	
2 PLC ±		3 PLC ±		DRAWING NO: 2266072	
4 PLC ±		ANGLES FINISH		SCALE: 1:2	
MATERIAL: -		WEIGHT: -		SHEET: 4 OF 4	
Customer Accessible Production Drawing		REV: B1			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION