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20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

REVISION

DESCRIPTION

FEED TYPE

2151896-1

B

FINE CRIMP HEIGHT ADJUST

MECHANICAL

2151896-2

B

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2151896-5

B

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

2151896-6

B

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹²

2151896-7

B

FINE CRIMP HEIGHT ADJUST

NONE

7-2151896-7

B

CRIMP TOOLING KIT

-

APPLICATOR STYLE CONVERSION CHART

CONVERT TO

PART NUMBERS REQUIRED

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1

SERVO LATCH PLATE

2119951-1

-

8-2151896-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151896-4

-

-

-

MECHANICAL FEED

2119949-1

1338685-1

5-18022-5

2119653-1

-

-

SERVO LATCH PLATE

2119951-1

-

8-2151896-5

1901094-3

-

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

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8-2151896-4

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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

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.73 mm [.068]

F

INSUL

2.02 mm [.080]

F

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION

TERMINAL NAME: TAXI TERMINAL

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.37-5.13 mm [.172-.202 IN]

Ø1.20-1.70 mm [.047-.067 IN]

TERMINAL APPLICATION SPECIFICATION

15304701 PG 1 OF 19 Rev - -

PAGE 1 OF 19

- -

TERMINALS APPLIED

TE TERMINAL

DELPHI TERMINAL

TE TERMINAL

DELPHI TERMINAL

286849-1

15304701

286849-3

15393149

286849-2

12176694

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

0.50mm2

1.10+/-0.05 [.043+/- .002]

6.7

0.35mm2

1.05+/-0.05 [.041+/- .002]

7.3

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: 8-2151896-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151896-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151896-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151896-6

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.
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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.70.

*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
-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	OWN	APVD
				I	DEVELOPMENT	18SEP2014	JH	UG
				A	RELEASED	24OCT2014	JH	TE
				B	ECR-14-018739	16DEC2014	JH	UG
				B1	ECR-15-008618	10JUN2015	JH	GB

-	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	2119082-5	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
-	-	-	-	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	318563-1	GUARD, FRONT CHIP	89
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	5-547505-2	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	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	-	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	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	1752356-3	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	1320908-3	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	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	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	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1	2-1803055-5	ANVIL, COMBINATION	8
-	1	1	1	1	1	1-240641-3	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119780-9	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	6-1633961-3	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	2
-	1	1	1	1	1	2-1673600-4	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS IS SUBJECT TO CHANGE AND TO BE USED FOR THE PURPOSE OF IDENTIFICATION ONLY. IT IS SUBJECT TO CHANGE AND TO BE USED FOR THE PURPOSE OF IDENTIFICATION ONLY. IT IS SUBJECT TO CHANGE AND TO BE USED FOR THE PURPOSE OF IDENTIFICATION ONLY.				OWN J. HOU	18SEP2014	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:				CHK Y. YIN	18SEP2014		
mm				APVD J. GUO	18SEP2014		
				PRODUCT SPEC			
				APPLICATION SPEC		NAME	
MATERIAL				WEIGHT		SIZE	
-				-		A1 00779	
-				-		C=2151896	
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PNEUMATIC

This diagram illustrates the assembly of a pneumatic cylinder. The main components are shown in an exploded view, with numbered callouts indicating their positions and assembly order. The components include:

- 250: A small circular cap or plug.
- 249: A larger circular cap or plug.
- 238: A long, thin rod or pin.
- 163: A small, rectangular component, likely a seal or O-ring.
- 59: A small, rectangular component, likely a seal or O-ring.
- 136: A small, rectangular component, likely a seal or O-ring.
- 137: A small, rectangular component, likely a seal or O-ring.
- 172: A small, rectangular component, likely a seal or O-ring.
- 56: A small, rectangular component, likely a seal or O-ring.

The diagram shows the assembly of the cylinder body, including the mounting bracket, the main body, and the various seals and components. The assembly is shown in a disassembled state, with the components labeled with numbers 250, 249, 238, 163, 59, 136, 137, 172, and 56.

SERVO FEEDER NOT INCLUDED

30mm STROKE

47

49

40mm STROKE

MECHANICAL POST FEED

30mm STROKE

48

49

40mm STROKE

MECHANICAL PRE FEED

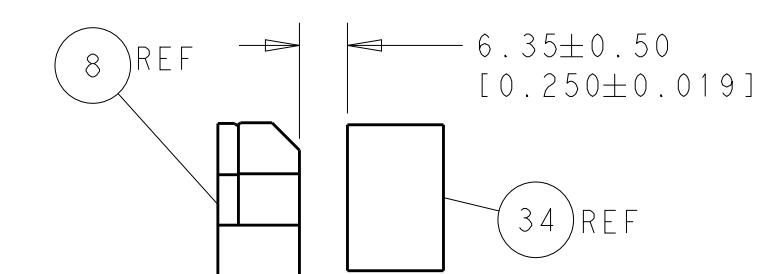
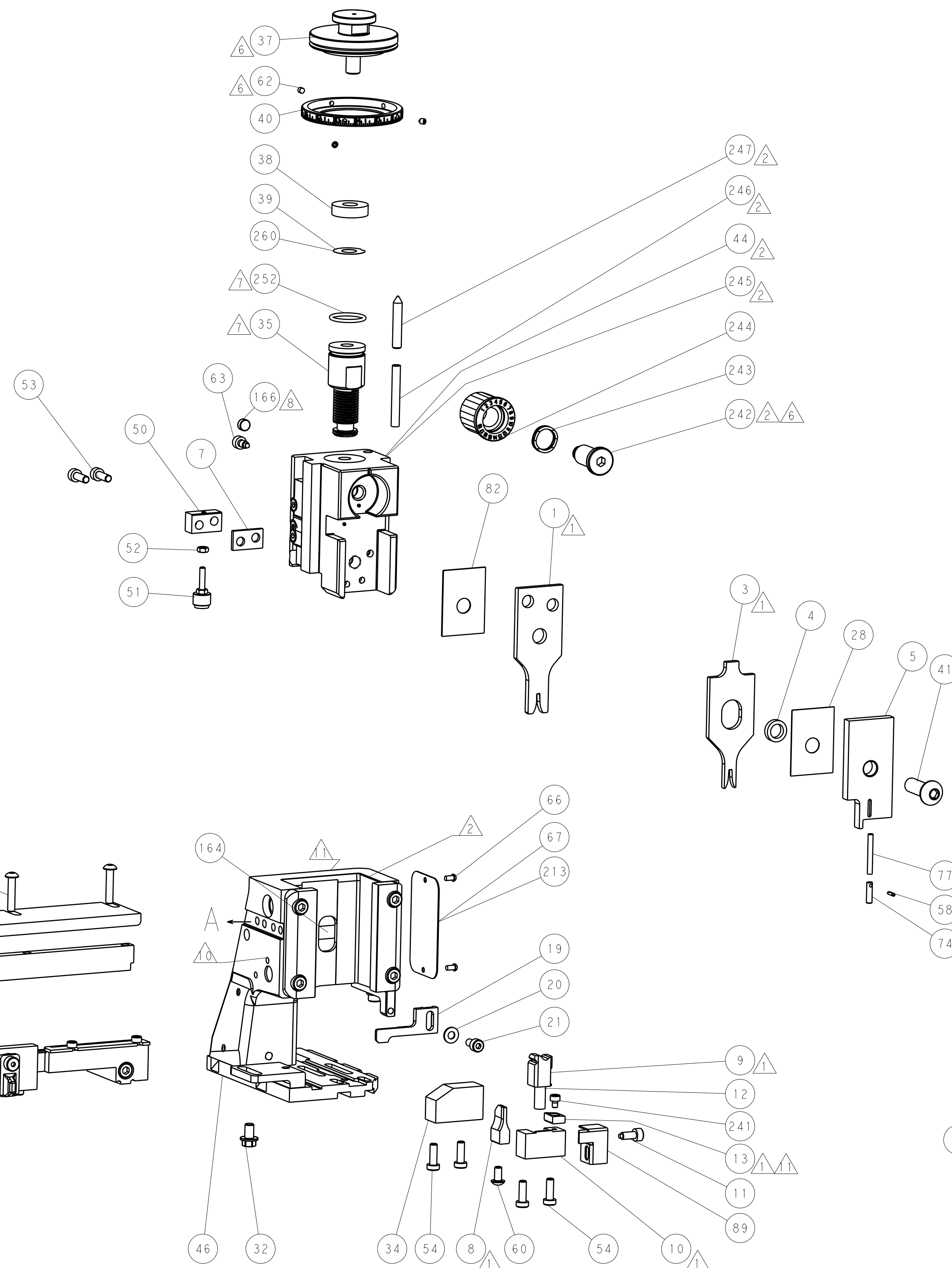
30mm STROKE

248

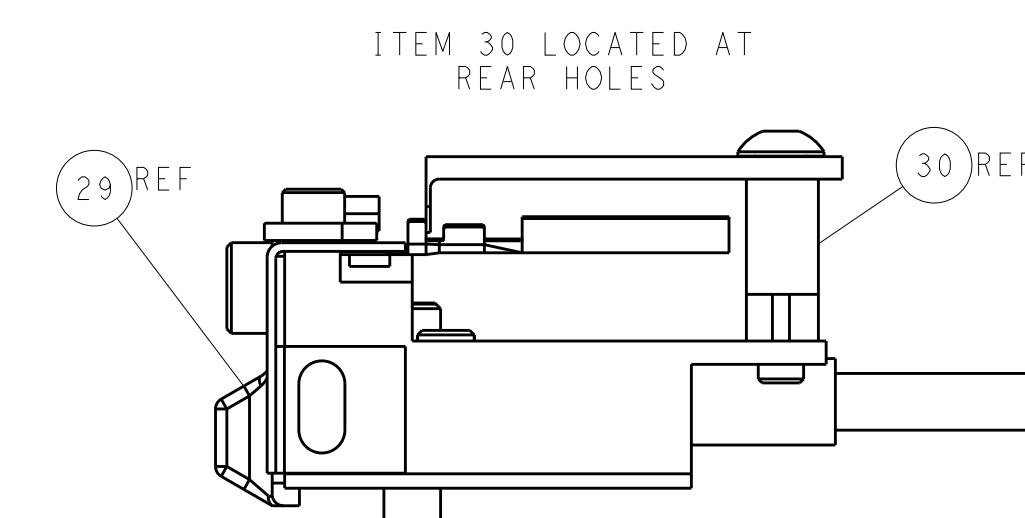
49

40mm STROKE

AIR FEED



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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 ENGINEERING CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION MAY BE REQUIRED TO CHANGE THE DESIGN FOR THE CUSTOMER'S REQUIREMENTS		DWN J. HOU 18SEP2014 CHK Y. LIN 18SEP2014 APVD U. GUO 18SEP2014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 ANGLES ±0.0001		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE CAGE CODE DRAWING NO A 00779 C=2151896	
MATERIAL -		FINISH -		WEIGHT -	
Customer Accessible Production Drawing					
				SCALE 1:2	SHEET 2 of 4
				REV B	

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

D

C

B

A

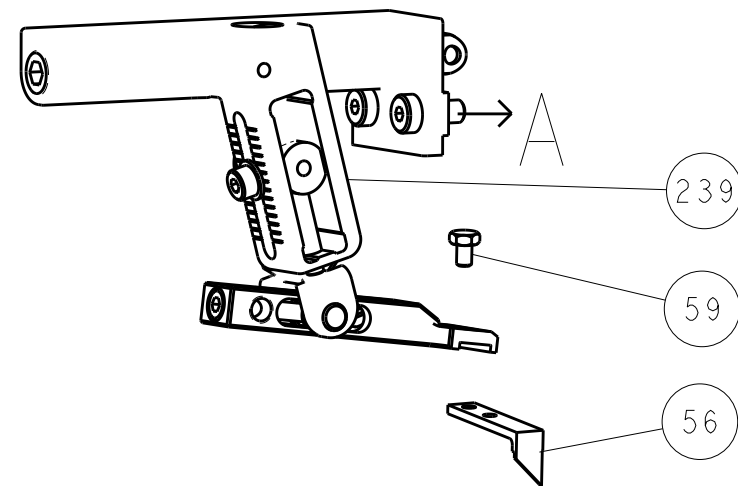
D

C

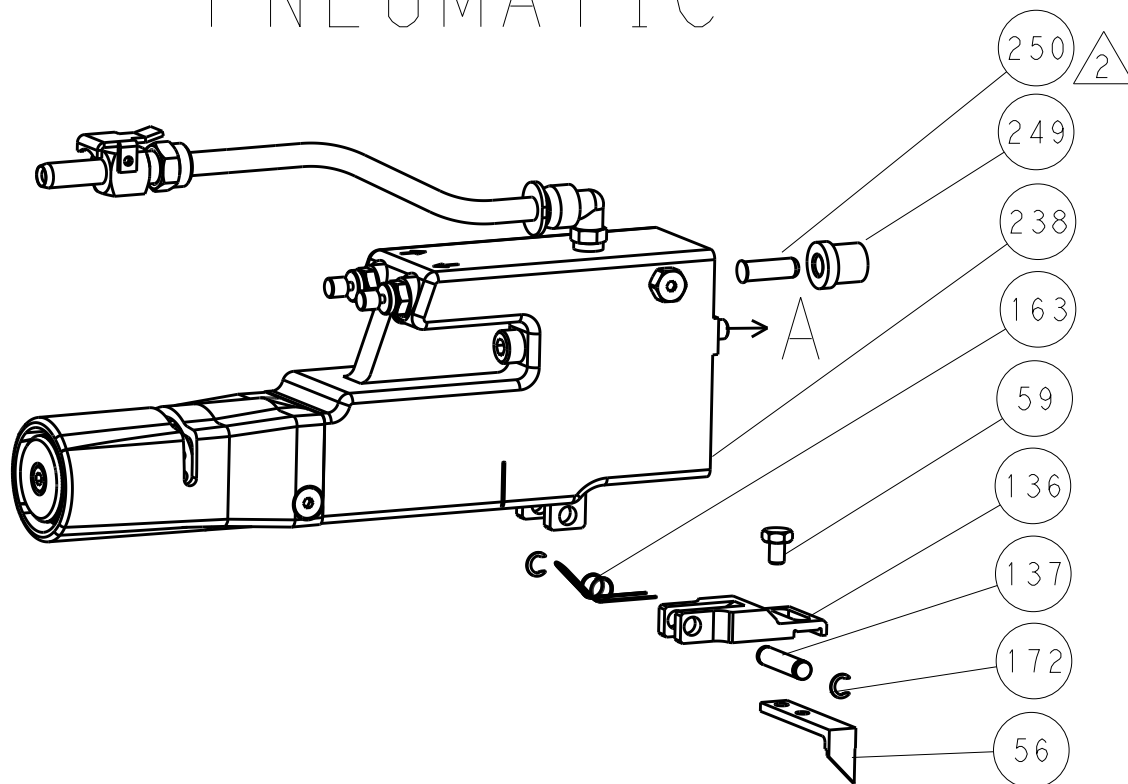
B

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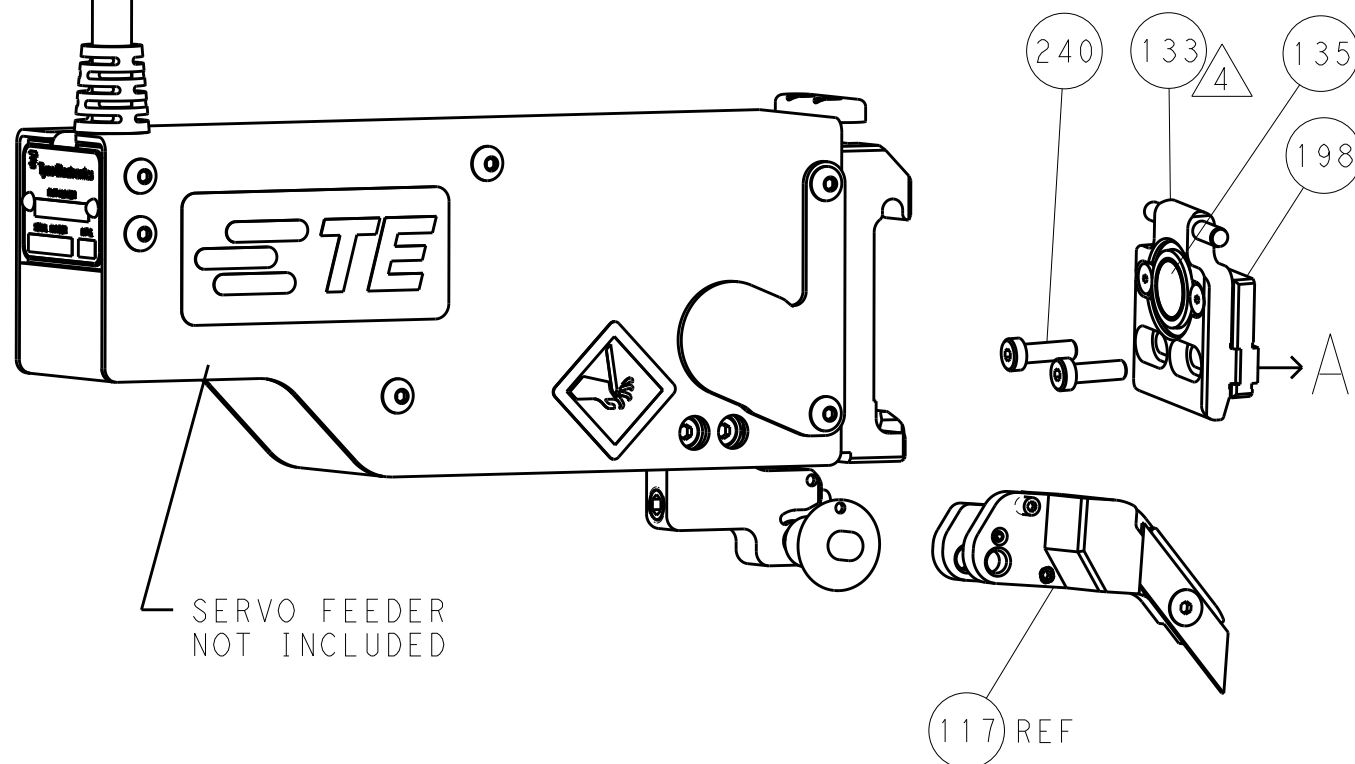
FEED TYPE MECHANICAL



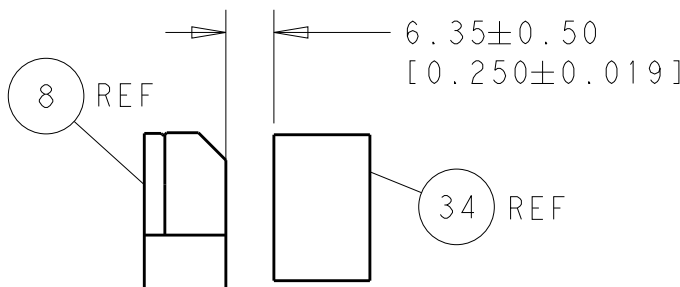
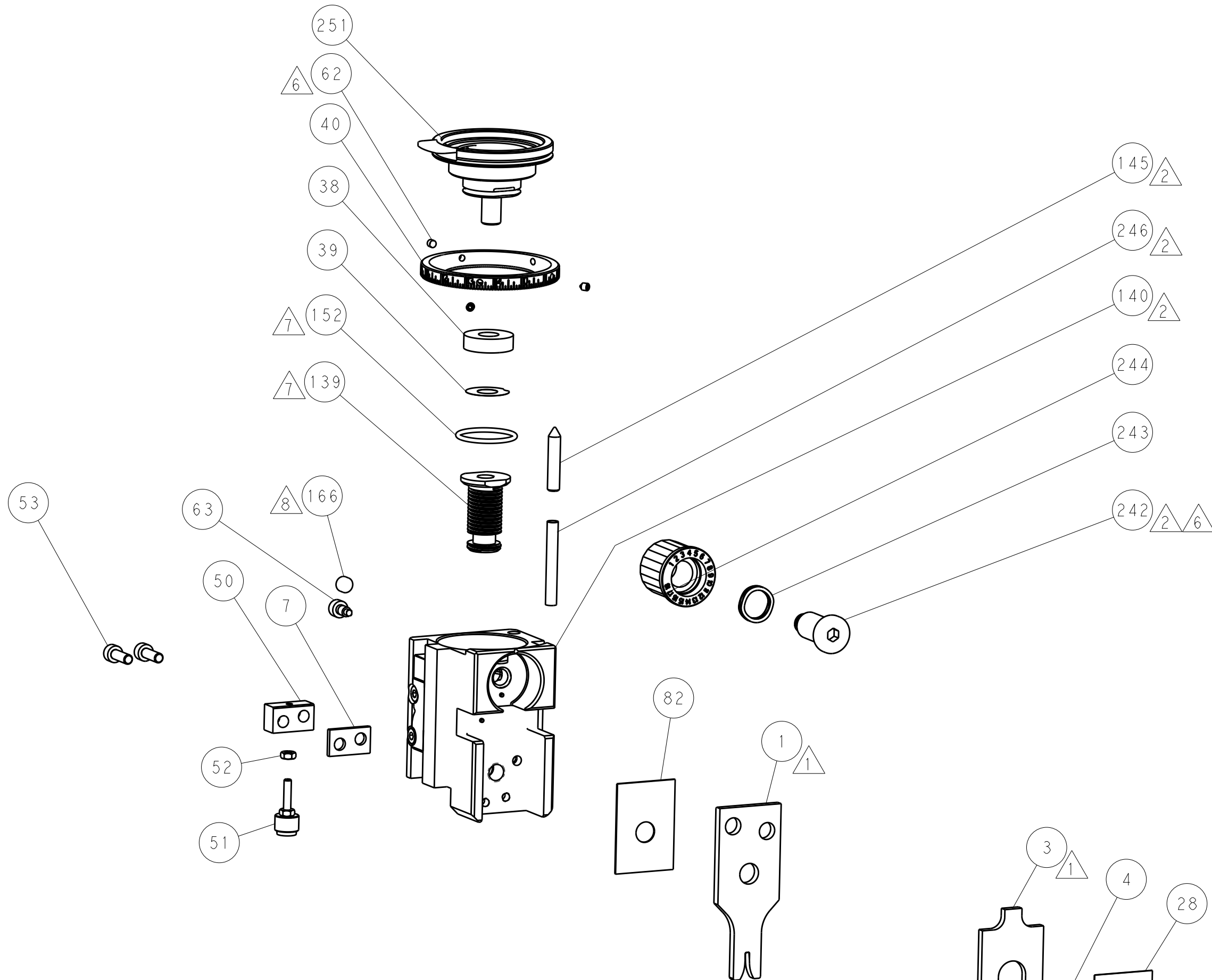
PNEUMATIC



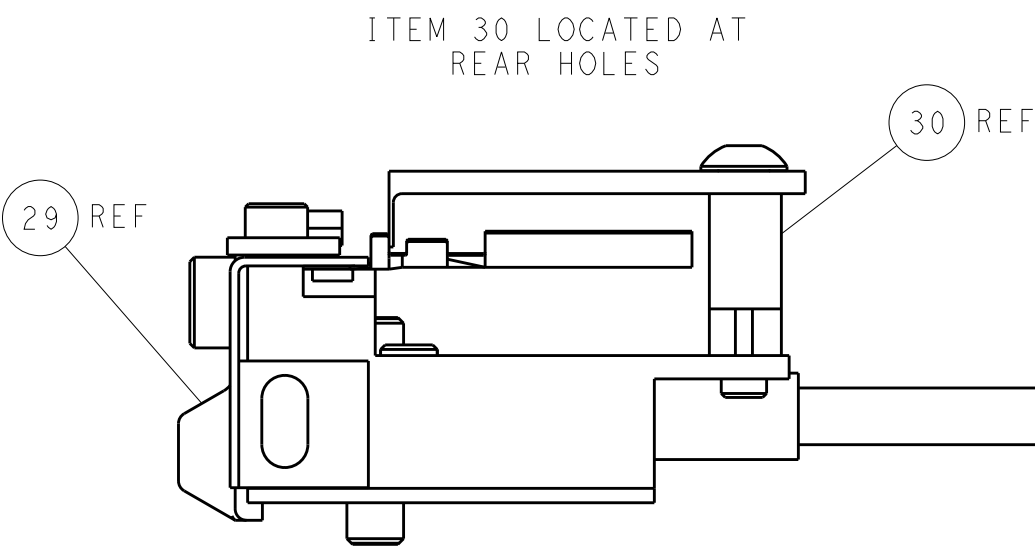
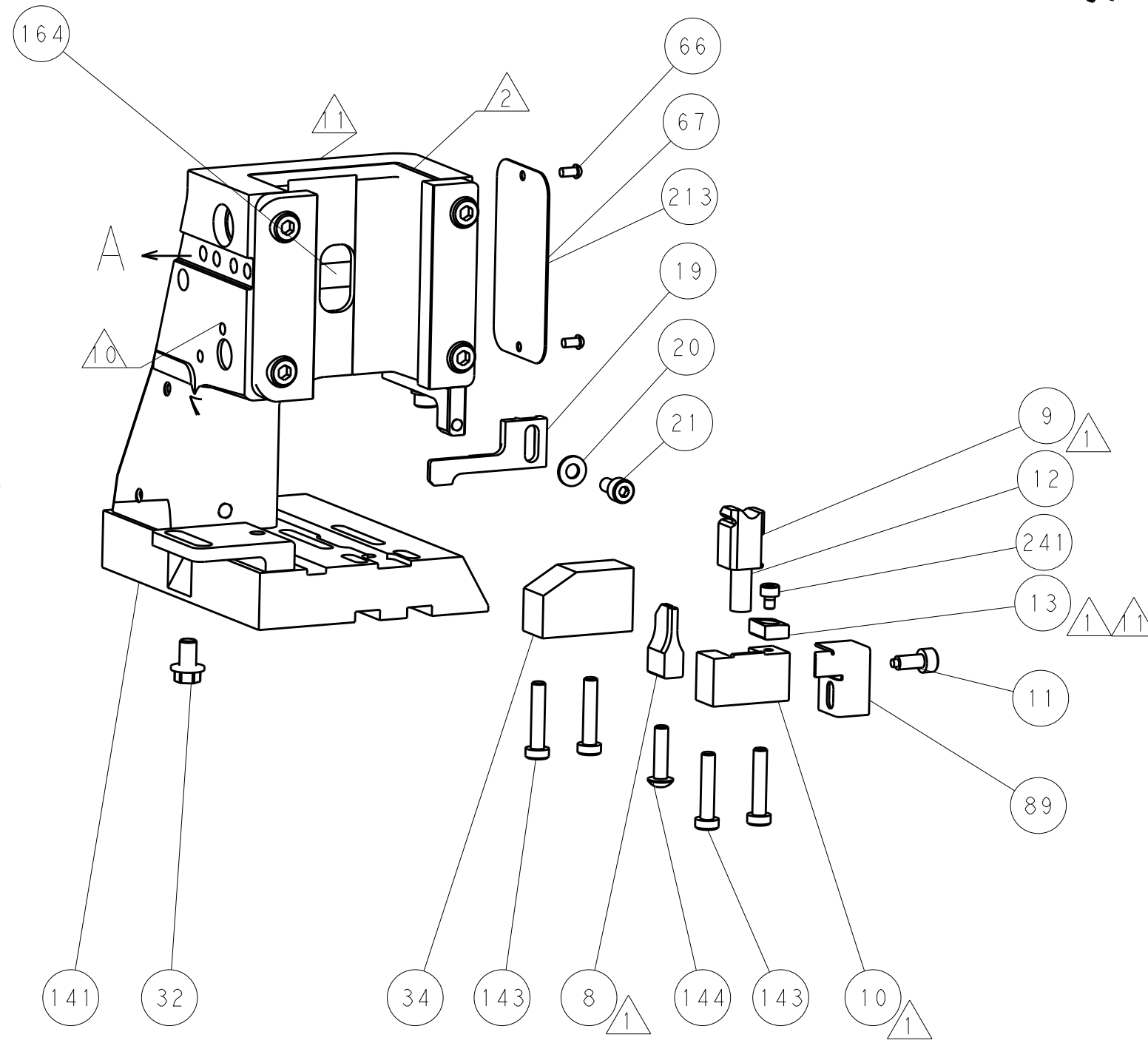
SERVO LATCH PLATE



CAM POSITIONS



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)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN J. HOU 18SEP2014		CHK Y. YIN 18SEP2014		APVD H. GUO 18SEP2014		NAME Ocean Side Feed Applicator	
0 PLC ±.5		1 PLC ±0.13		2 PLC ±0.013		3 PLC ±0.001		4 PLC ±0.001		RESTRICTED TO	
MATERIAL		FINISH		WEIGHT		SIZE A1		CAGE CODE 00779		DRAWING NO C=2151896	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 4		OF 4		REV B1			

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION