

8

7

6

5

4

3

2

1

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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION  
TERMINATOR  
INTERFACE ADAPTER

PART  
NUMBER

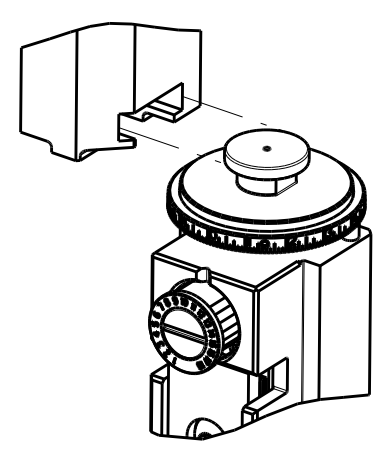
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151917-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1

2151917-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

1338685-1

5-18022-5

2119653-1

-

-

2151917-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

1338685-1

5-18022-5

2119653-1

-

-

2151917-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

12

-

-

-

-

-

-

2151917-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

-

7-2151917-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

.091 [2.31 mm]

F

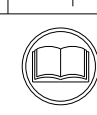
INSUL

.140 [3.56 mm]

F

APPLICATOR INSTRUCTIONS

408-10389

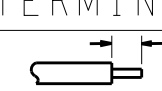


TERMINAL DATA: ETCO TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: RING TERMINAL

WIRE STRIP LENGTH



INSULATION DIAMETER RANGE

.109-.124 IN [2.77-3.15 mm]

Ø.060-.075 IN [1.52-1.91 mm]

TERMINAL APPLICATION SPECIFICATION

NONE

-

-

TERMINALS APPLIED

TE TERMINAL

ETCO TERMINAL

TE TERMINAL

ETCO TERMINAL

1949601-1

R16-4-THB

1949601-7

R16-2-NPS

1949601-2

R16-4-HB

1949601-8

R16-099-HB

1949601-3

R16-4-NPS

1949601-9

R16-066-HB

1949601-4

R16-125-HB

1-1949601-0

R16-6-THB

1949601-5

R16-2-THB

1-1949601-1

R16-6-HB

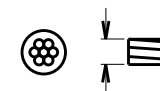
1949601-6

R16-2-HB

-

-

WIRE SIZE



CRIMP HEIGHT INCH [mm]



CRIMP HEIGHT REFERENCE SETTING

9

20 AWG

0.061+/-0.002 [1.55+/-0.05]

6.2

22 AWG

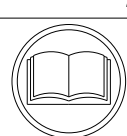
0.058+/-0.002 [1.47+/-0.05]

6.8

24 AWG

0.056+/-0.002 [1.42+/-0.05]

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: 8-2151917-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151917-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151917-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151917-6

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

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 4.25.

13 CUT TO LENGTH AT ASSEMBLY.

-

-

1

-

-

-

2119957-2

APPLICATOR SHIM PACK

260

-

1

1

1

1

1

1803078-3

SPACER, PRECISION

259

-

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

-

1

-

1

1

1

1-22279-3

SPRING, COMPRESSION

246

-

-

1

-

-

-

2161314-1

RAM, STEPPED, ATLANTIC, SF, NON-ADJ

245

-

1

1

1

1

1

2119082-9

CAM, SNAIL, INSULATION ADJUSTMENT

244

-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

P

LTR

DESCRIPTION

DATE

OWN

APVD

A

RELEASED

09MAY2013

LG

TE

-

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

1

1

1

356885-4

STOP, SHEAR

237

-

-

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

-

1

1

1

1

1

1-22281-8

SPRING, COMPRESSION

121

-

-

1

1

-

-

1901092-1

FEED FINGER ASSEMBLY, SF

117

-

1

1

1

1

1

1-690438-0

FRONT STRIP GUIDE

96

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2

2

2

2

2

2168083-1

SCR, SKT HD CAP, RoHS, M3 X 8.0

95

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1

1

1

1

1

2168083-6

SCR, SKT HD CAP, RoHS, M5 X 65

93

-

1

1

1

1

1

1-455888-8

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

-

2

2

2

2

2

2-18032-5

SCR, SET, FLT POINT M5 X 20.0

61

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1

1

1

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1

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

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-

-

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1

1

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

-

-

-

-

1

1

1338683-2

FEED PAWL

56

-

2

2

2

2

2

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

-

2

2

2

2

2

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

53

-

-

-

-

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

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1

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2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

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1

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1

1

1

2161311-1

RAM, STEPPED, AMP STYLE, SIDE FEED

44

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1

1

1

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1

1-2079383-5

SCR, BHSC, RoHS (M8 X 40)

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

-

1

1

1

1

1

1-2119644-2

RAM WASHER, PRECISION

38

-

1

1

1

1

1

2119085-1

FA HEAD, ATLANTIC STYLE

37

-

1

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1

1

1

2119092-1

BOLT, ADJUSTMENT

35

-

2

2

2

2

2

2079383-8

SCR, BHSC, RoHS (M4 X 16)

33

-

1

1

1

1

1

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

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1

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1-1320908-6

SPACER, STRIP GUIDE

30

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1

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1803089-1

PLATE, REAR STRIP GUIDE

29

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2

2

2

2

2

22283-1

SPRING, COMPRESSION

27

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1

1

1

1

1

356835-1

LEVER, DRAG RELEASE

26

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1

1

1

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1

240792-1

DRAG, TERMINAL

25

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1

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1633630-2

PLATE, STRIP GUIDE

24

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980371-4

SCR, SKT HD SHLDR 5.0 DIA X 6.0

23

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1

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2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

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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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1

2119533-1

STRIPPER, SIDE FEED

19

-

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

690464-4

SHEAR PLATE, REAR

15

-

1

1

1

1

1

2119862-1

SHEAR HOLDER, REAR

14

-

1

1

1

1

1

2119806-1

INSERT, SHEAR

13

-

1

1

1

1

1

3-22280-3

SPRING, COMPRESSION

12

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10

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9

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4-1633927-2

ANVIL, COMBINATION

8

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7

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690468-1

DEPRESSOR SHEAR, REAR

6

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5

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3-238009-9

BLOCK, FL CRIMPER SPACER

4

1

1

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1

3-2119784-9

CRIMPER, INSULATION O PREMIUM

3

-

-

-

-

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-

-

-

2

1

1

1

1

1

1

1633609-5

CRIMPER, WIRE

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

THIS IS SUBJECT TO CHANGE AND WITHOUT WARRANTY. THE USER ASSUMES ALL RISK OF INJURY OR DAMAGE TO PROPERTY OR PERSONS. THE USER SHALL BE CONTACTED FOR THE LATEST TESTING.

OWN

R.O.WILSON

02APR2013

CHK

K.J.STAKEM

12APR2013

APVD

T.L.FLIN

12APR2013

NAME

Ocean Side Feed

Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2151917

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

REV

A

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

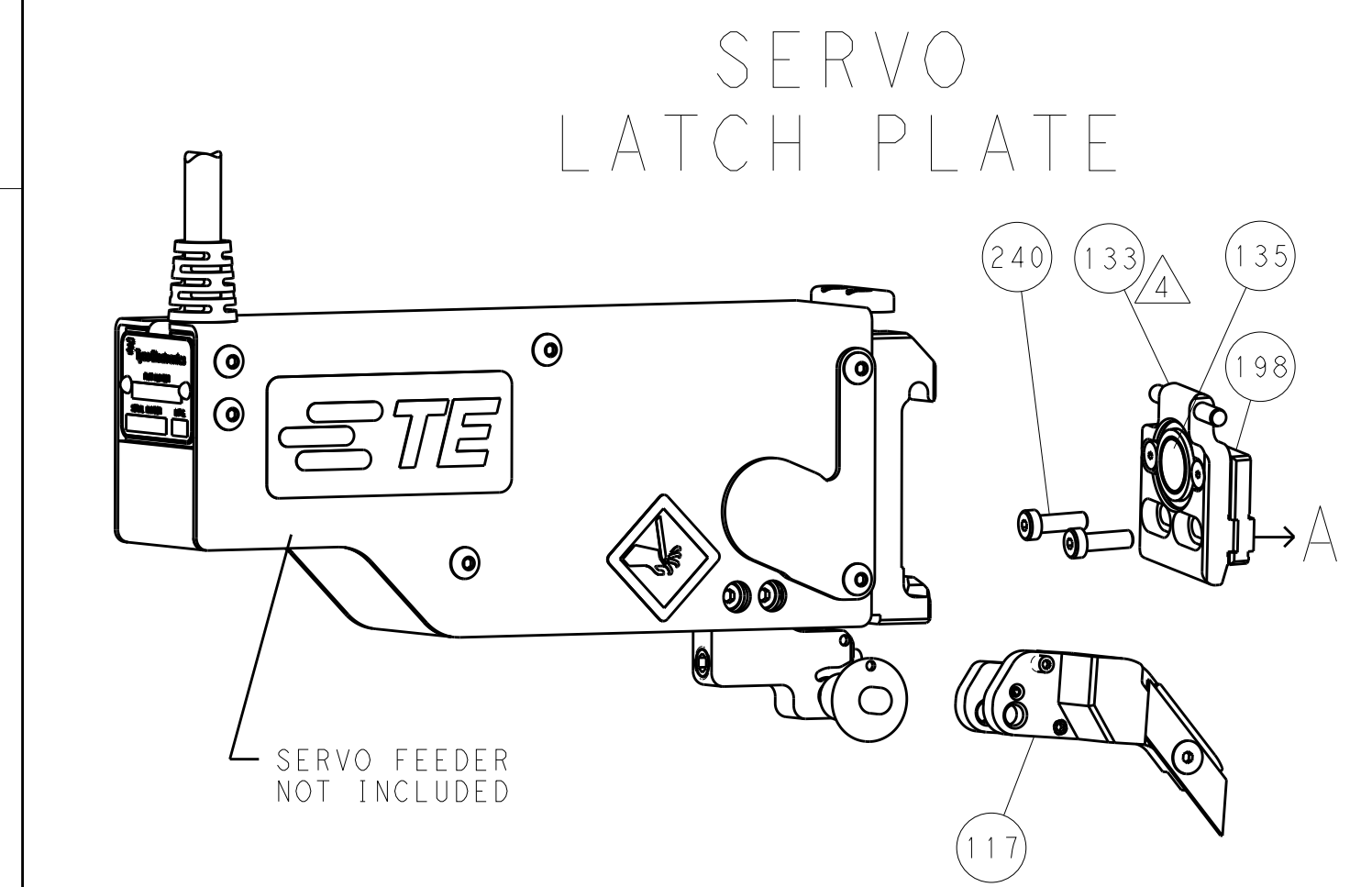
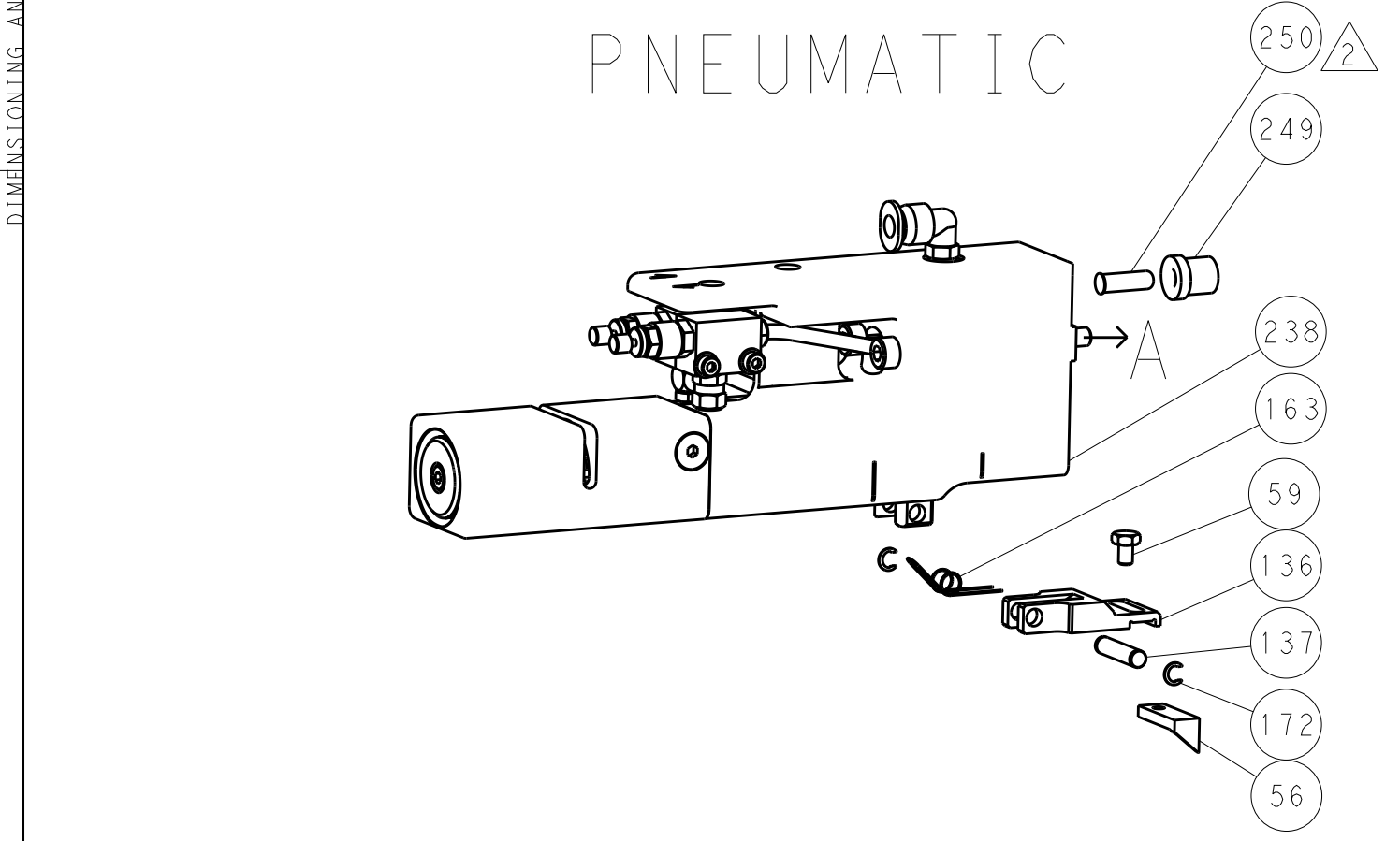
A

B

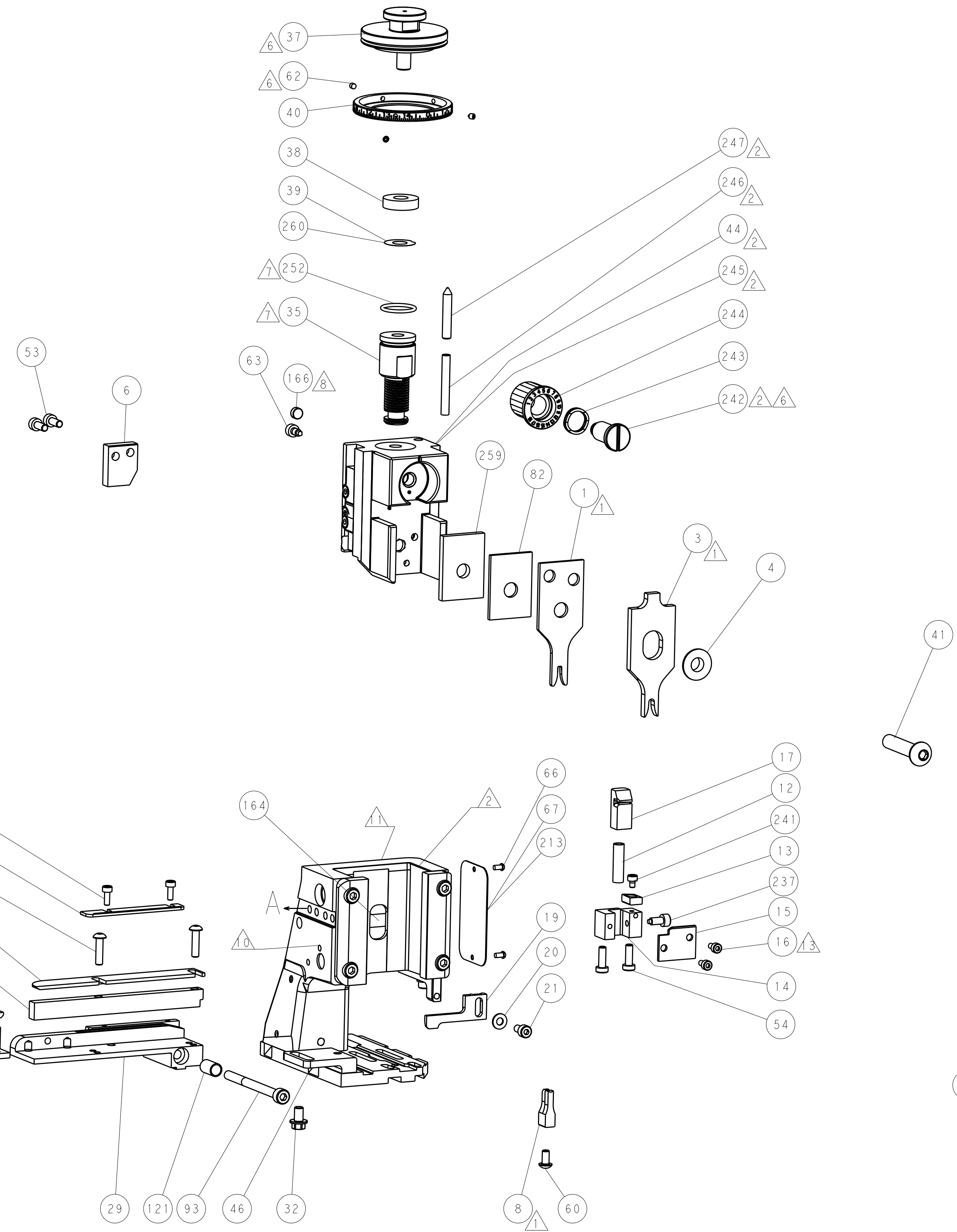
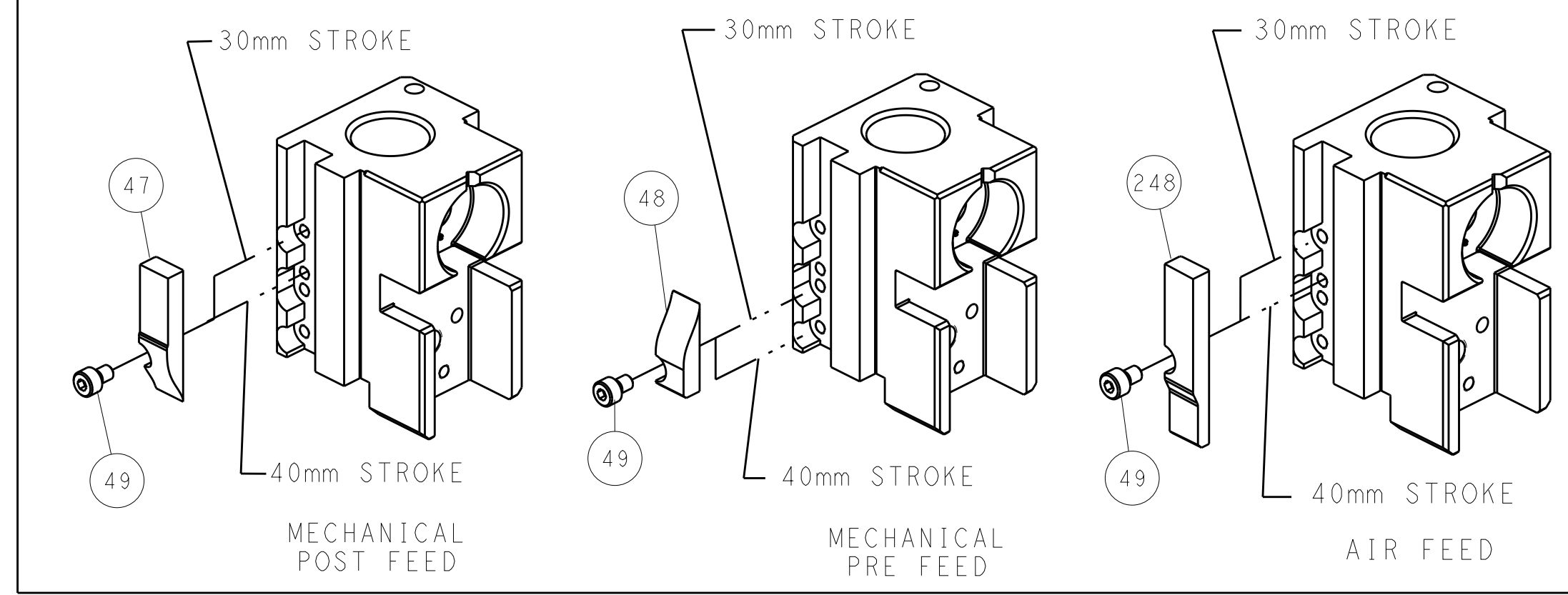
C

D

# FEED TYPE MECHANICAL

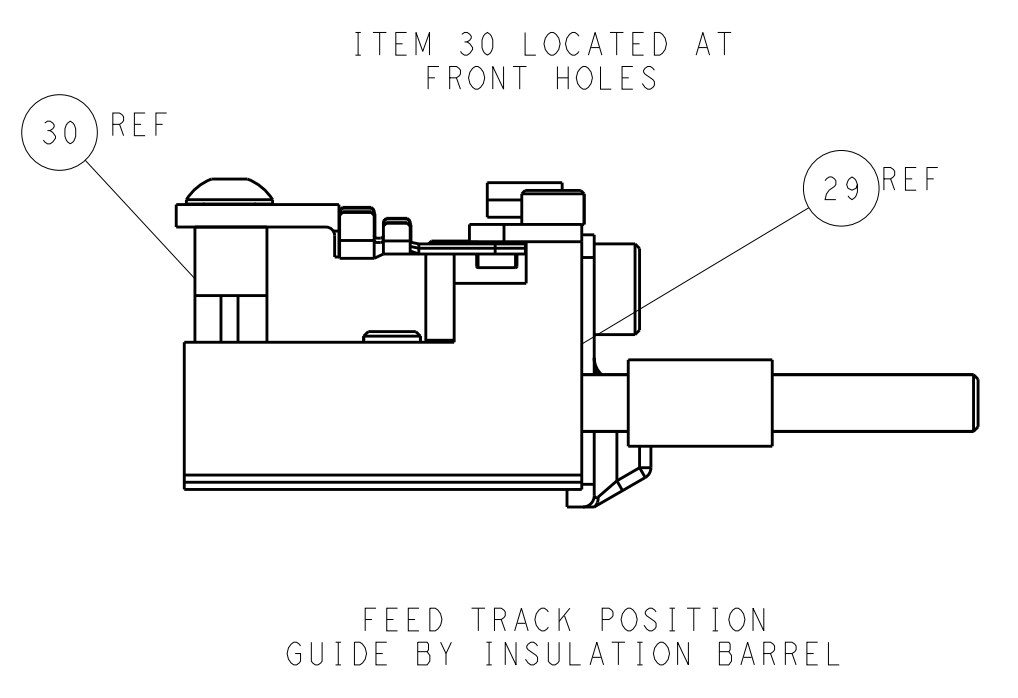


# CAM POSITIONS



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

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. ANY REVISIONS TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY REVISIONS TO THIS DRAWING MUST BE APPROVED BY THE DESIGNING ORGANIZATION. |  |  |  | DWN: R.O. WILSON 02APR2013<br>CHK: K.J. STAKEM 12APR2013<br>APVD: T.L. ELGIN 12APR2013                                       |  |  |  | STE TE Connectivity<br>Harrisburg, PA 17105-3608                       |  |  |  |
| DIMENSIONS: mm                                                                                                                                                                                                                                                           |  |  |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.1<br>1 PLC ±.02<br>2 PLC ±.02<br>3 PLC ±.005<br>4 PLC ±.0005<br>ANGLES ±.1 |  |  |  | NAME: Ocean Side Feed Applicator                                       |  |  |  |
| MATERIAL: -                                                                                                                                                                                                                                                              |  |  |  | FINISH: -                                                                                                                    |  |  |  | SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151917                        |  |  |  |
|                                                                                                                                                                                                                                                                          |  |  |  | WEIGHT: -                                                                                                                    |  |  |  | Customer Accessible Production Drawing SCALE: 1:1 SHEET: 2 OF 4 REV: A |  |  |  |

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION







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

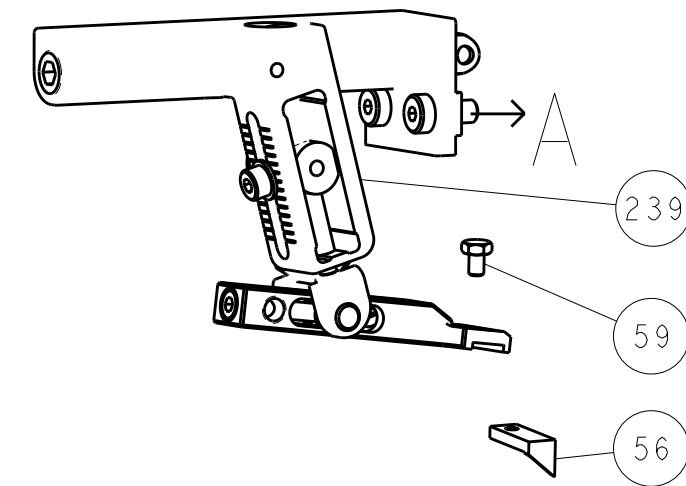
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

C

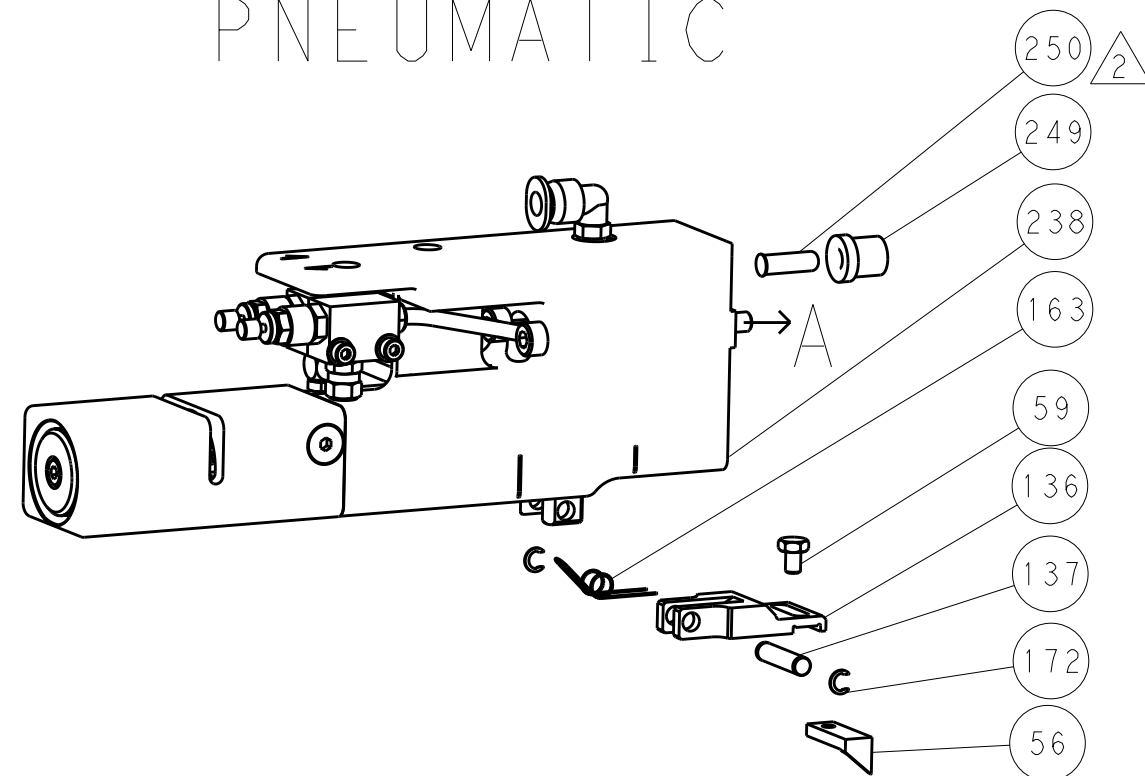
B

A

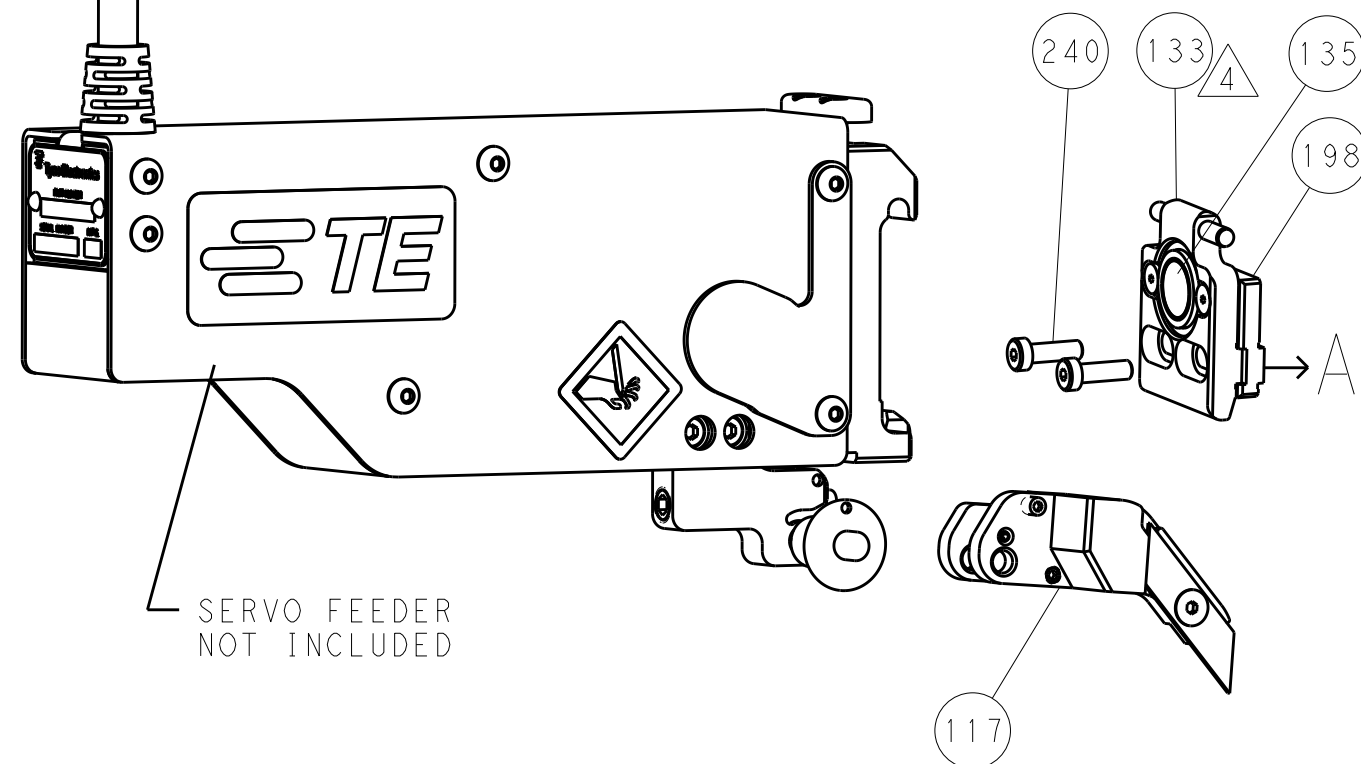
# FEED TYPE MECHANICAL



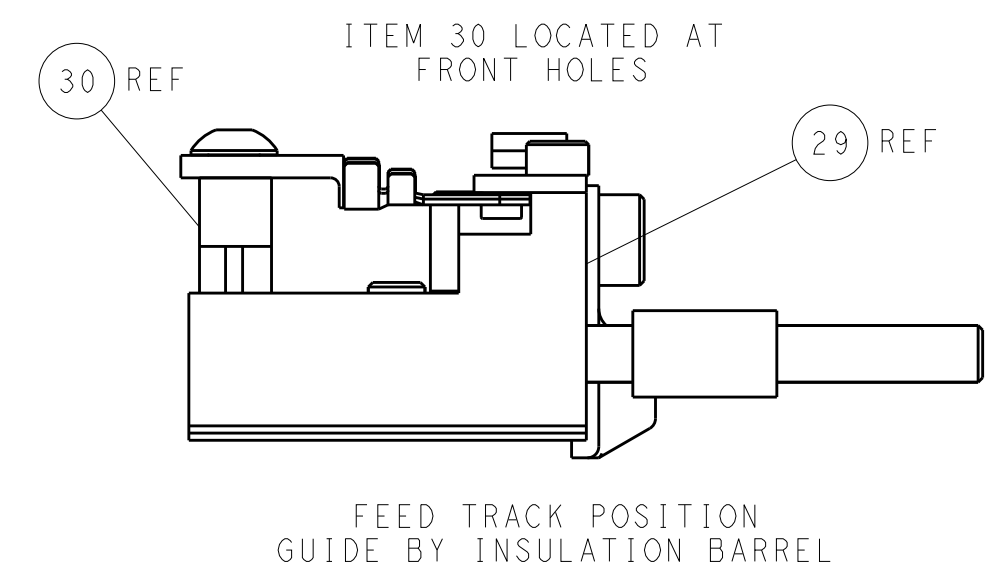
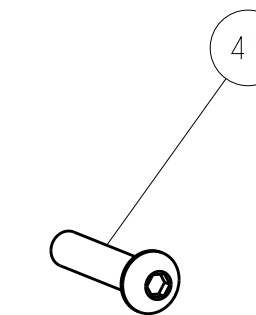
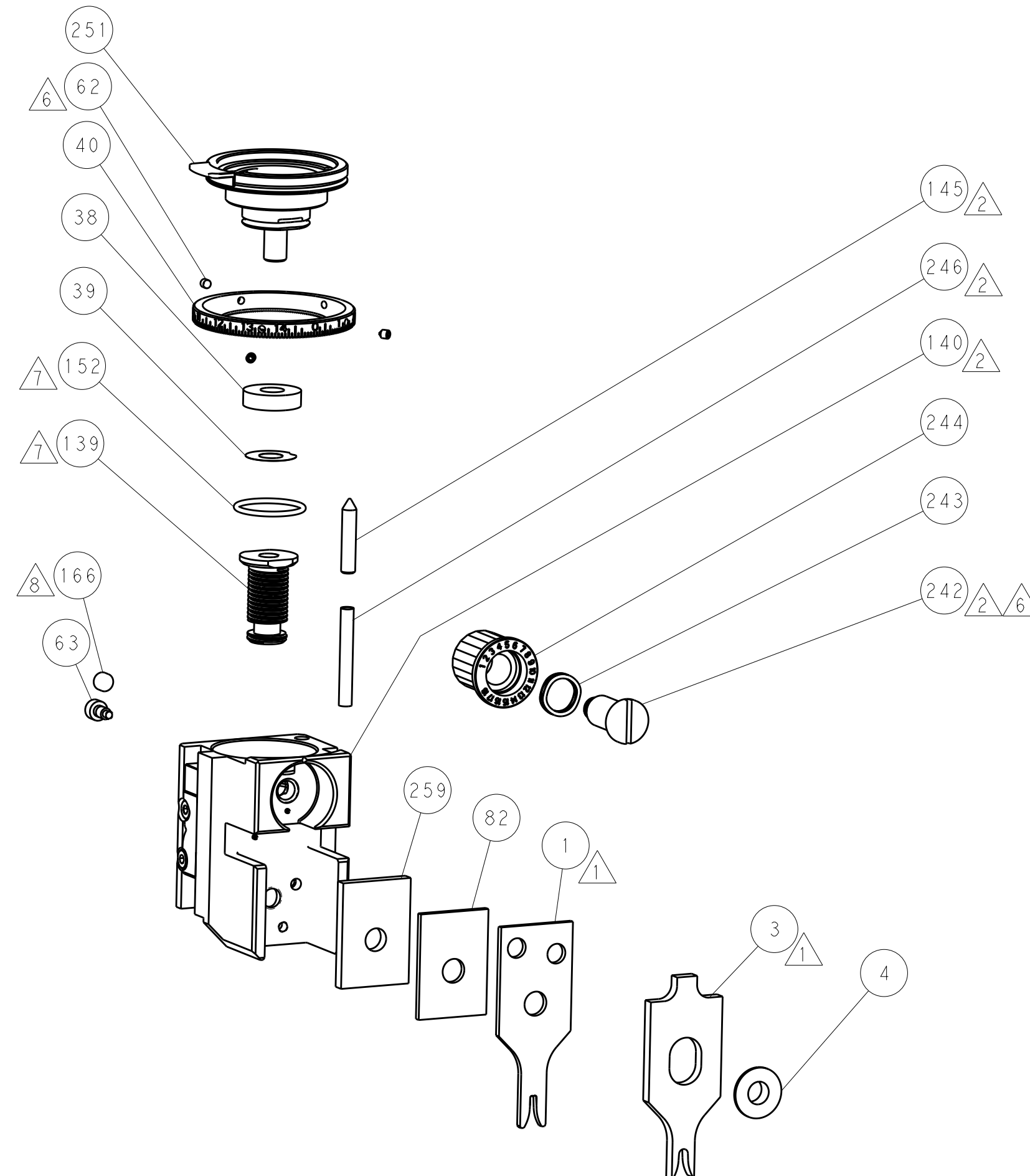
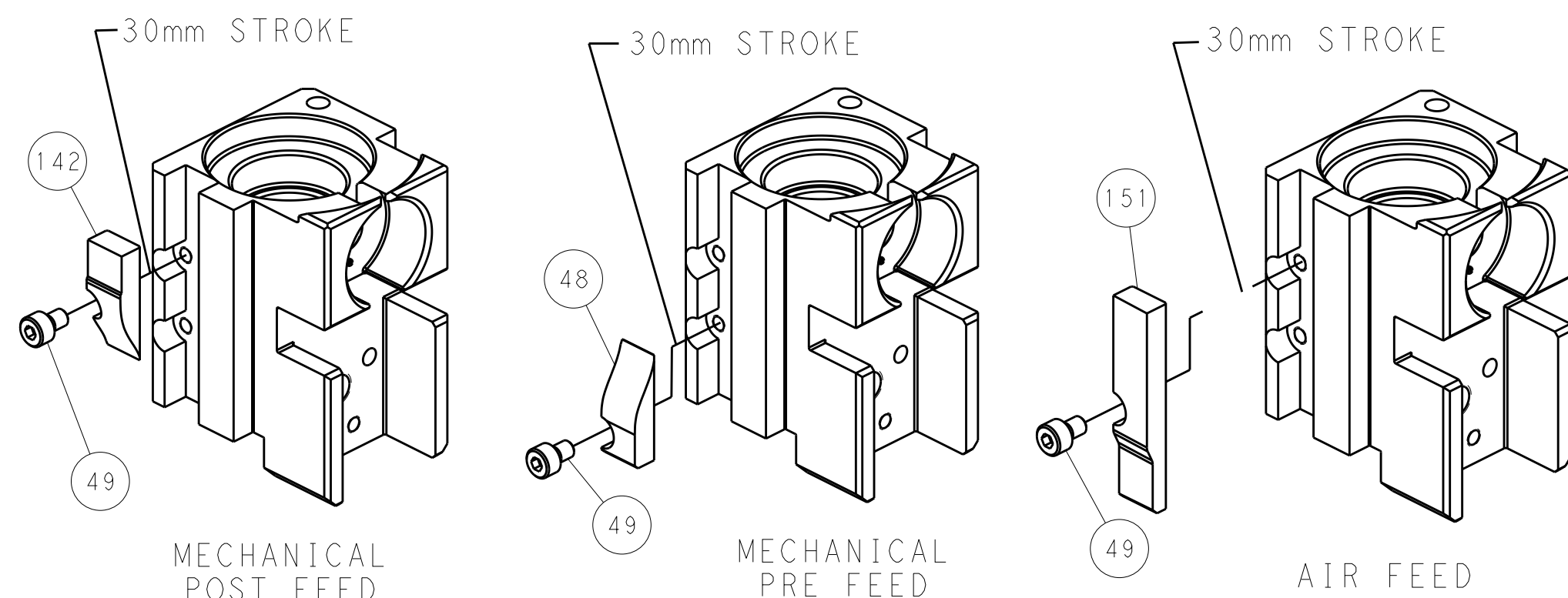
# PNEUMATIC



# 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)

|                                        |  |                                           |  |                              |  |                              |  |                              |  |                                       |  |
|----------------------------------------|--|-------------------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|---------------------------------------|--|
| DIMENSIONS:<br>mm                      |  | TOLERANCES UNLESS<br>OTHERWISE SPECIFIED: |  | DWN<br>R.O. WILSON 02APR2013 |  | CHK<br>K.J. STAKEM 12APR2013 |  | APVD<br>T.L. ELGIN 12APR2013 |  | NAME<br>Ocean Side Feed<br>Applicator |  |
| 0 PLC ±.1                              |  | 1 PLC ±.02                                |  | 2 PLC ±.02                   |  | 3 PLC ±.005                  |  | 4 PLC ±.0005                 |  | ANGLES                                |  |
| FINISH                                 |  | MATERIAL                                  |  | WEIGHT                       |  | SIZE<br>A1                   |  | CAGE CODE<br>00779           |  | DRAWING NO<br>C=2151917               |  |
| Customer Accessible Production Drawing |  | SCALE<br>1:1                              |  | SHEET<br>4                   |  | OF<br>4                      |  | REV<br>A                     |  | RESTRICTED TO                         |  |