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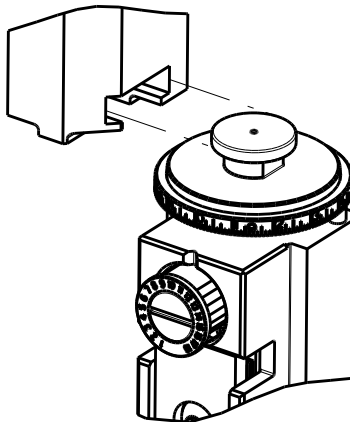
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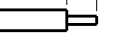
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION
	2151893-1	A	FINE CRIMP HEIGHT ADJUST
	2151893-2	A	FINE CRIMP HEIGHT ADJUST
	2151893-5	A	FINE CRIMP HEIGHT ADJUST
	2151893-6	A	NON-CRIMP HEIGHT ADJUST
	2151893-7	A	FINE CRIMP HEIGHT ADJUST
	7-2151893-7	A	CRIMP TOOLING KIT

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	2.54 mm [1.00]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL M-N-L SOCKET AND PIN			
WIRE STRIP LENGTH 4.00-4.75 mm [.157-.187 IN]		INSULATION DIAMETER RANGE Ø1.00-2.50 mm [.039-.098 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18011	-	-
	-	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
926884-1	926885-1	926886-1	
926884-3	926885-2	926886-3	
926884-6	926885-3	926886-7	
	926885-6		

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING ⁹
18 AWG	1.22+/-0.05 [.048+/- .002]	7
20 AWG	1.09+/-0.05 [.043+/- .002]	8.4
22 AWG	1.01+/-0.05 [.040+/- .002]	9.3
24 AWG	0.96+/-0.05 [.038+/- .002]	9.8



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: 8-2151893-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151893-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151893-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151893-6

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 & 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 ITEMS 37 & 180.

⁷ GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

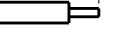
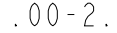
⁸ MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

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 4.58.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: UNIVERSAL M-N-L SOCKET AND PIN			
WIRE STRIP LENGTH 4.00-4.75 mm [.157-.187 IN]		INSULATION DIAMETER RANGE Ø1.00-2.50 mm [.039-.098 IN]	
TERMINAL APPLICATION SPECIFICATION 		-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
926884-3			

WIRE SIZE 	CRIMP HEIGHT mm [INCH] 	CRIMP HEIGHT REFERENCE SETTING ⁹
0.50mm2	1.09+/-0.05 [.043+/- .002]	8.4
0.35mm2	1.01+/-0.05 [.040+/- .002]	9.3

*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.

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.

-	-	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
-	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
-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)

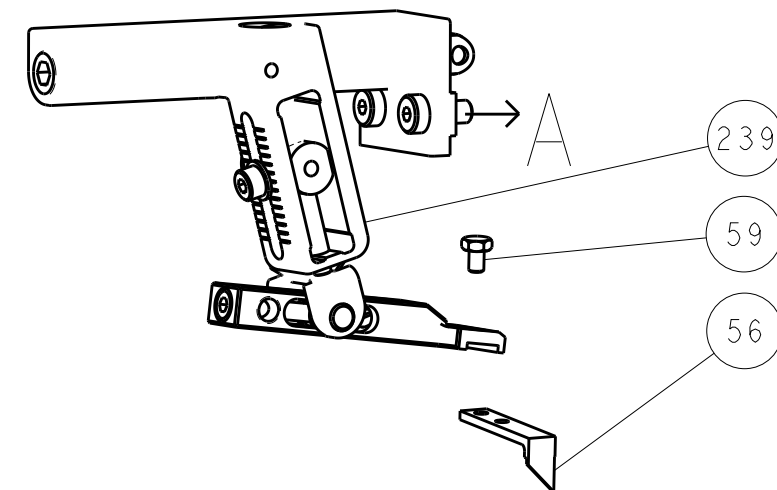
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
	P	LTR	DESCRIPTION	DATE	DWN	APVD
	A		RELEASED	04APR2013	RW	TE
	A1		ECR-16-002688	25FEB2016	KH	JDG

⁶	-	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
⁶	-	1	1	1	1	1	1-1752354-9	STANDOFF, HOLD-DOWN	180
	-	1	1	1	1	1	6-993111-6	PIN, SLOTTED SPRING 3.0 X 14.0	177
	-	1	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1	1	1752353-2	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	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	1	1	2119791-9	DEPRESSOR, WIRE	70
	-	1	1	1	1	1	2119943-1	WASHER, SPACER	69
	-	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	2119793-1	LIMITER, ADJUSTMENT BOLT	63
⁶	-	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
	-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
	-	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	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	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
⁶	-	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	3-1752356-4	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	2119959-1	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	1	455888-3	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
	-	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	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	1	2119805-1	SHEAR HOLDER, FRONT	10
¹	-	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
¹	1	1	1	1	1	1	1338692-1	ANVIL, COMBINATION .070	8
	-	-	-	-	-	-	-	-	7
	-	-	-	-	-	-	-	-	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	1	1-2119582-0	CRIMPER, INSULATION F PREMIUM	3
	-	-	-	-	-	-	-	-	2
¹	1	1	1	1	1	1	1-456404-8	CRIMPER, WIRE PREMIUM	1
	-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

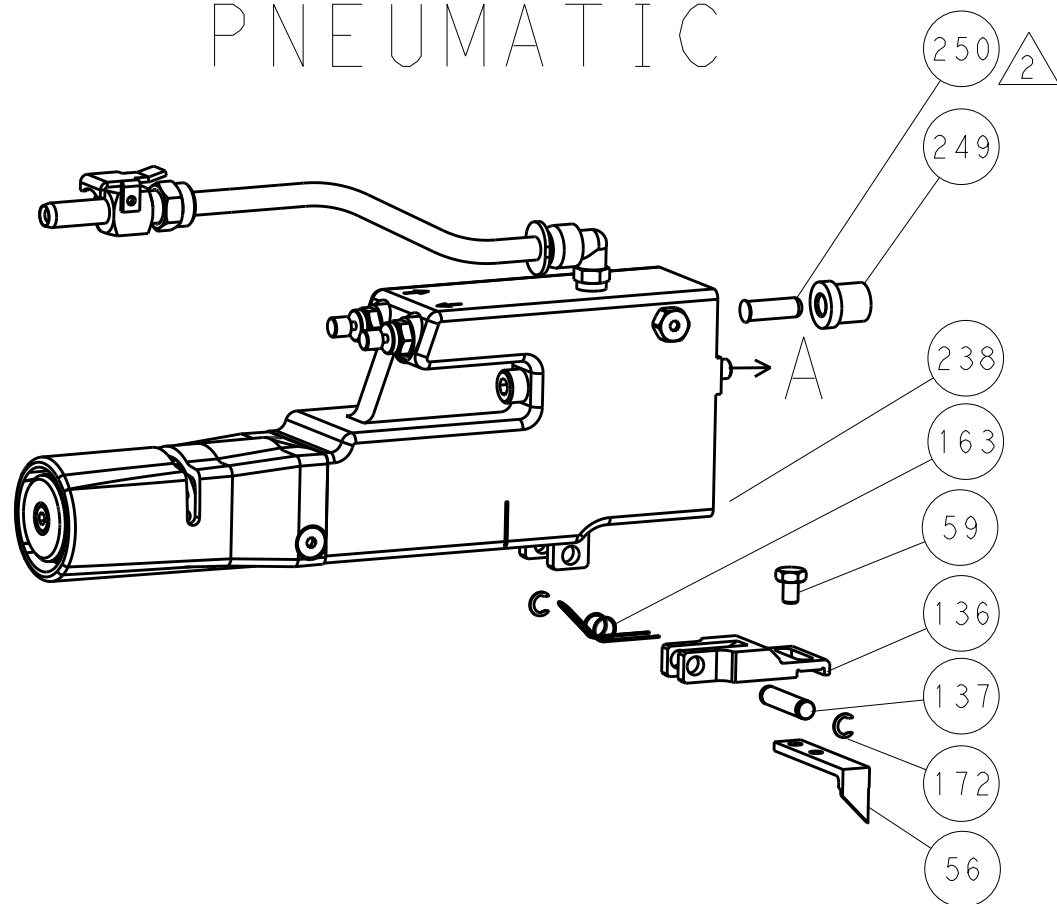
THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER SHALL BE CONTACTED FOR THE LATEST NOTIFICATION.		DWN R.O.WILSON CHK K.J.STAKEM APVD T.L.FLRIN	14FEB2013 18FEB2013 18FEB2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES FINISH	PRODUCT SPEC	NAME Ocean Side Feed Applicator	SIZE A1	CAGE CODE 00779
MATERIAL -	FINISH -	APPLICATION SPEC	DRAWING NO C-2151893	RESTRICTED TO -	SCALE 1:2
Customer Accessible Production Drawing		WEIGHT -	SHEET 1	OF 4	REV A1

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

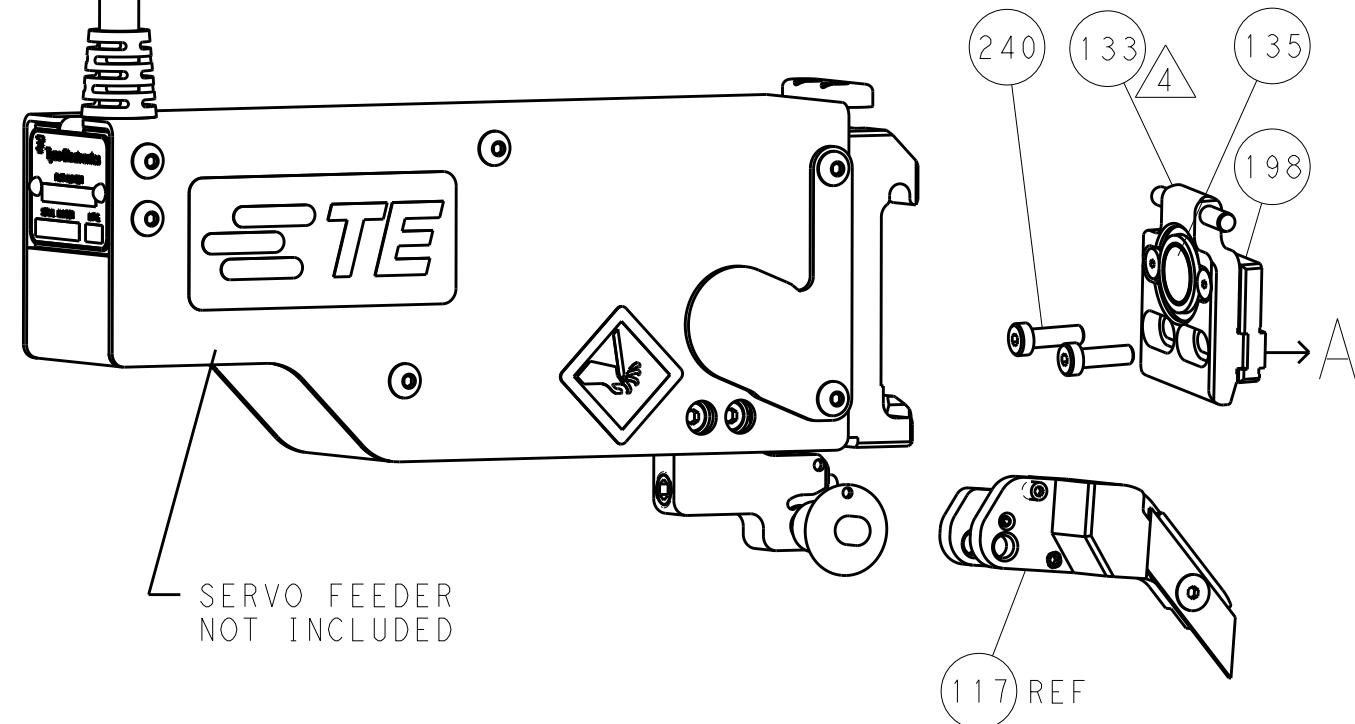
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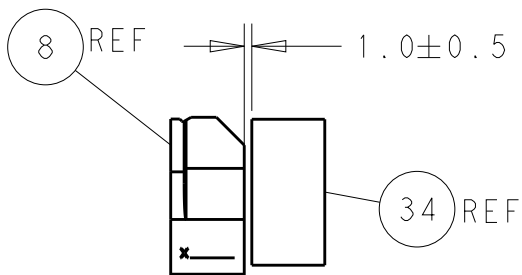
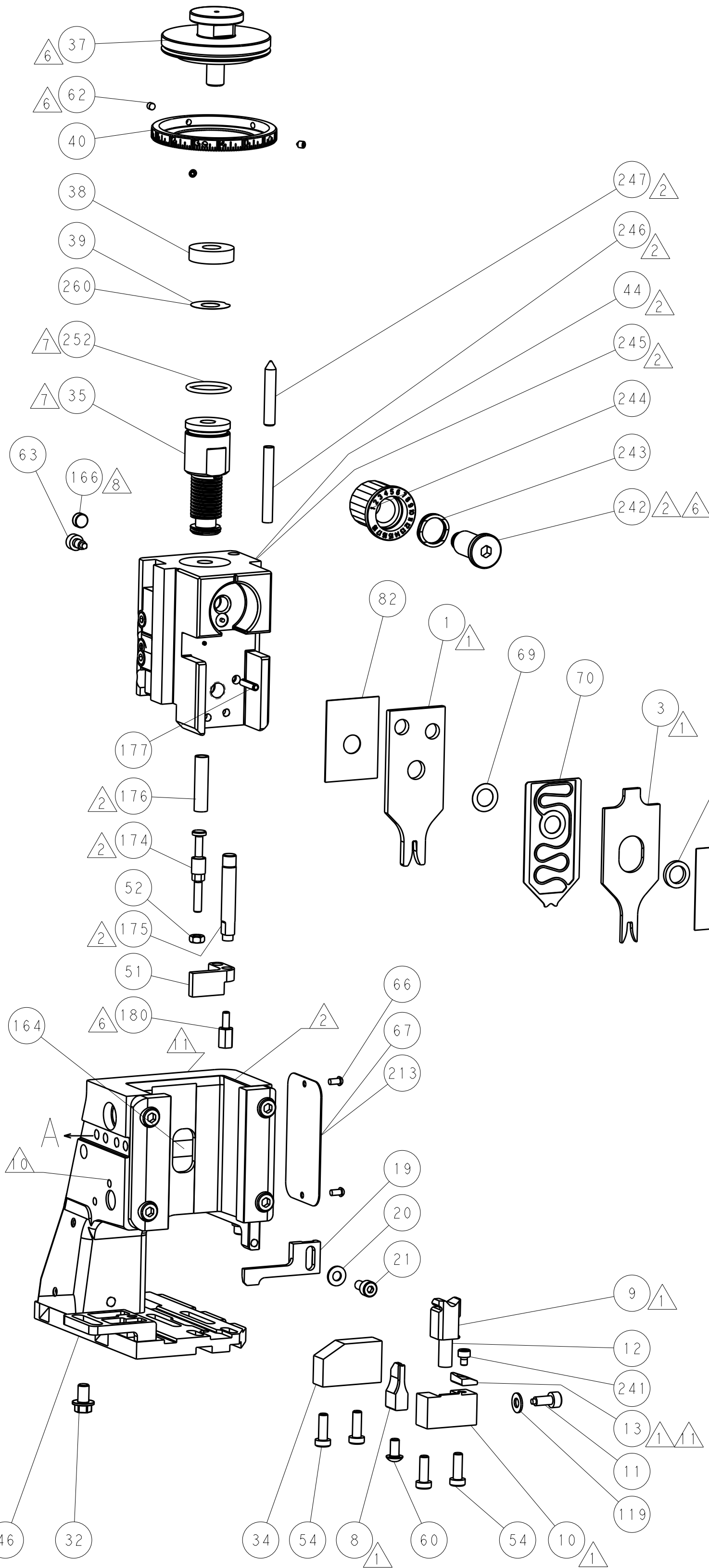
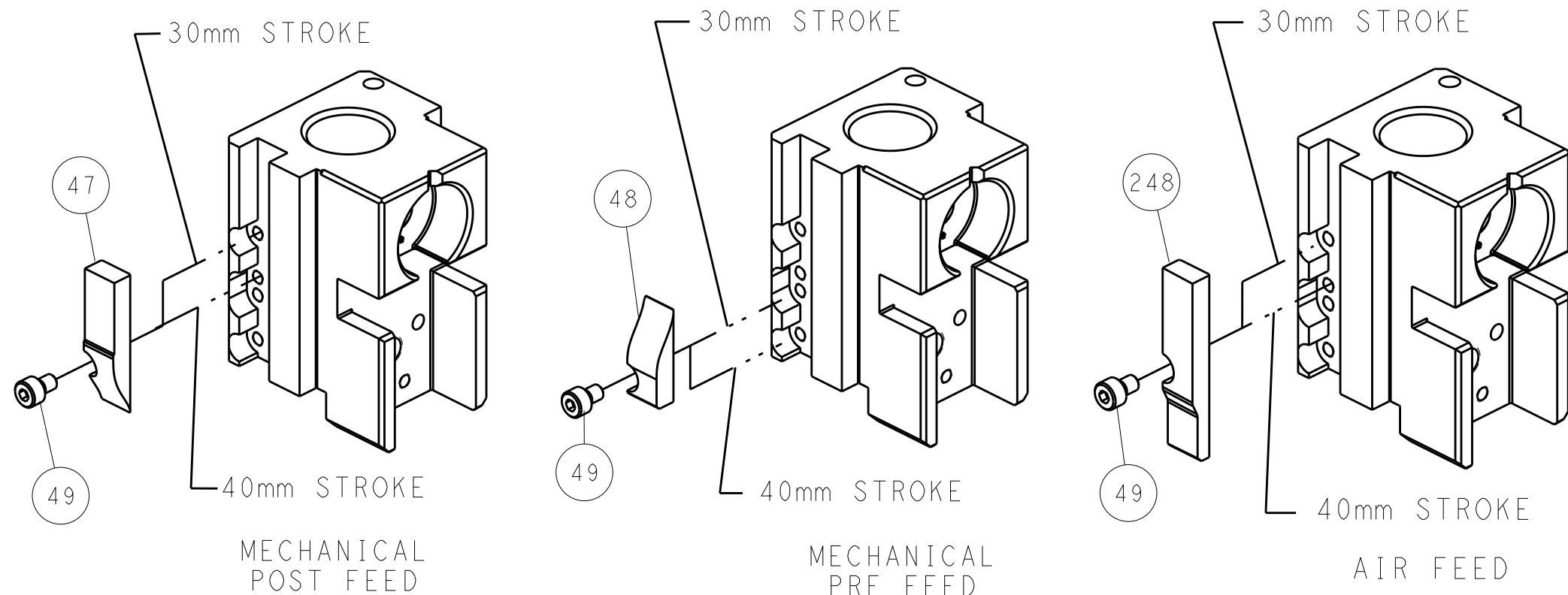
PNEUMATIC



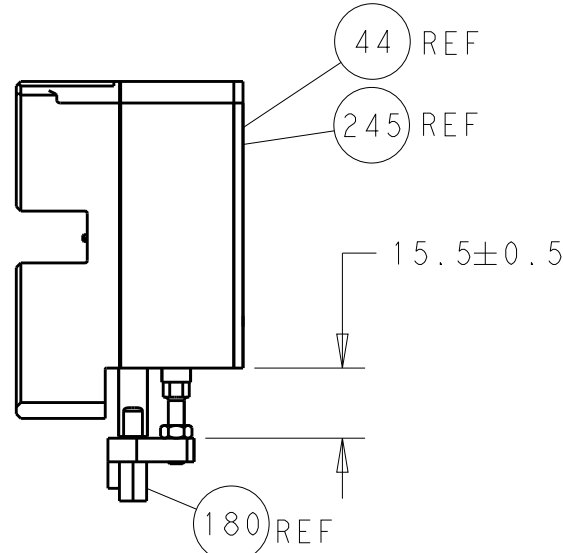
SERVO
LATCH PLATE



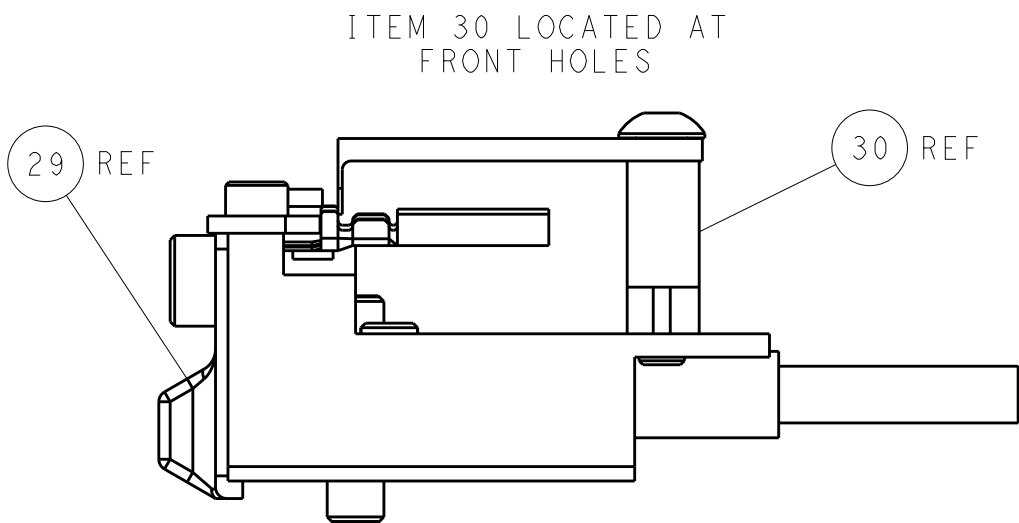
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP

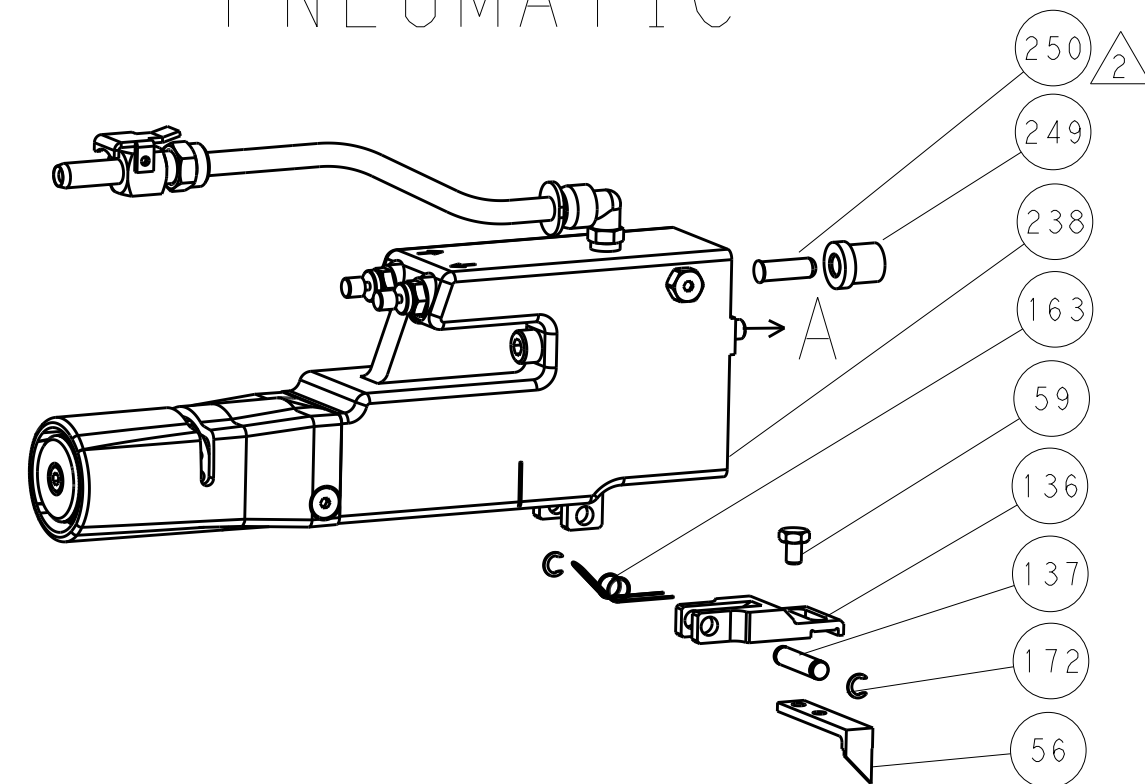
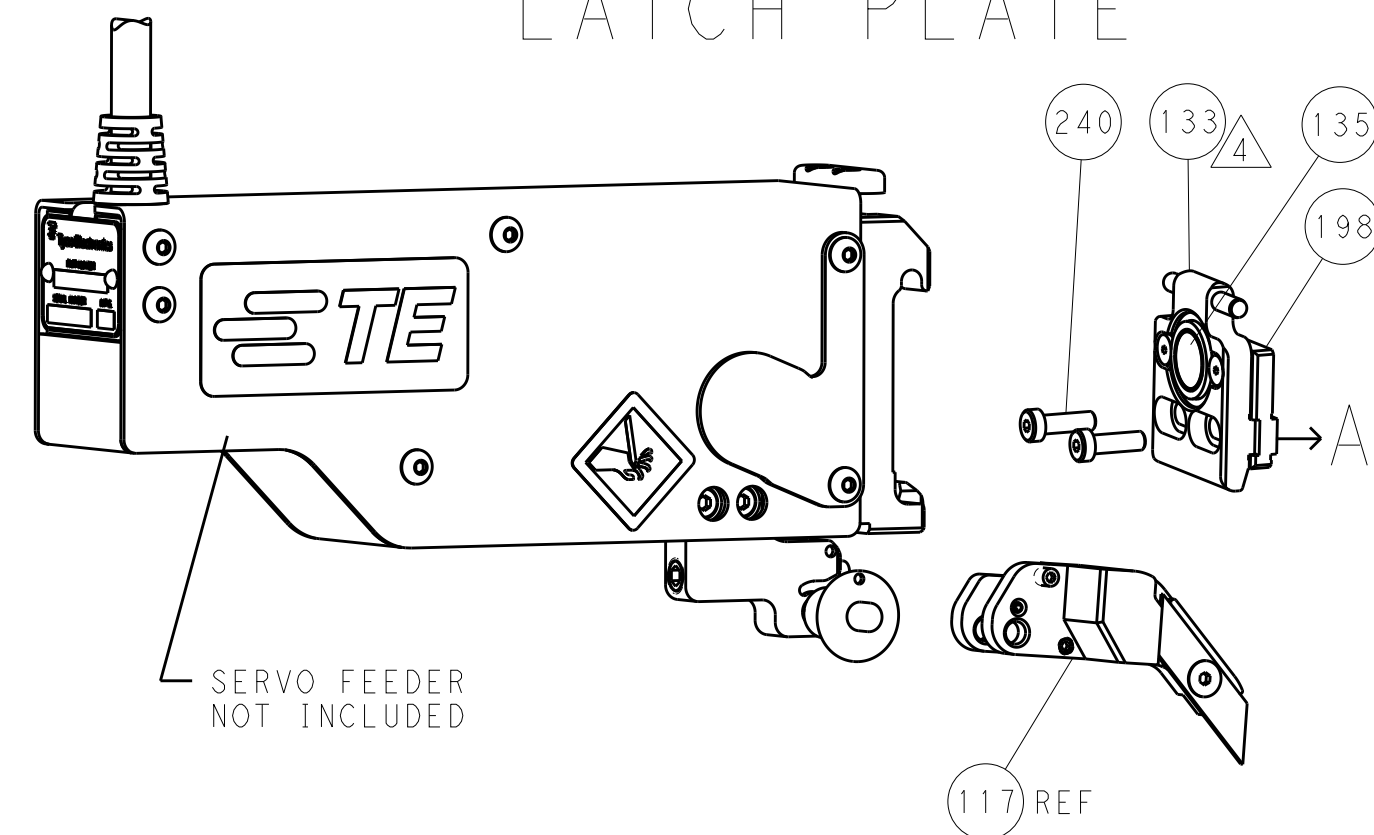


FEED TRACK POSITION
GUIDE BY INSULATION BARREL

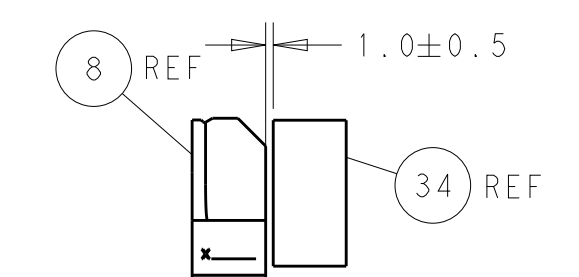
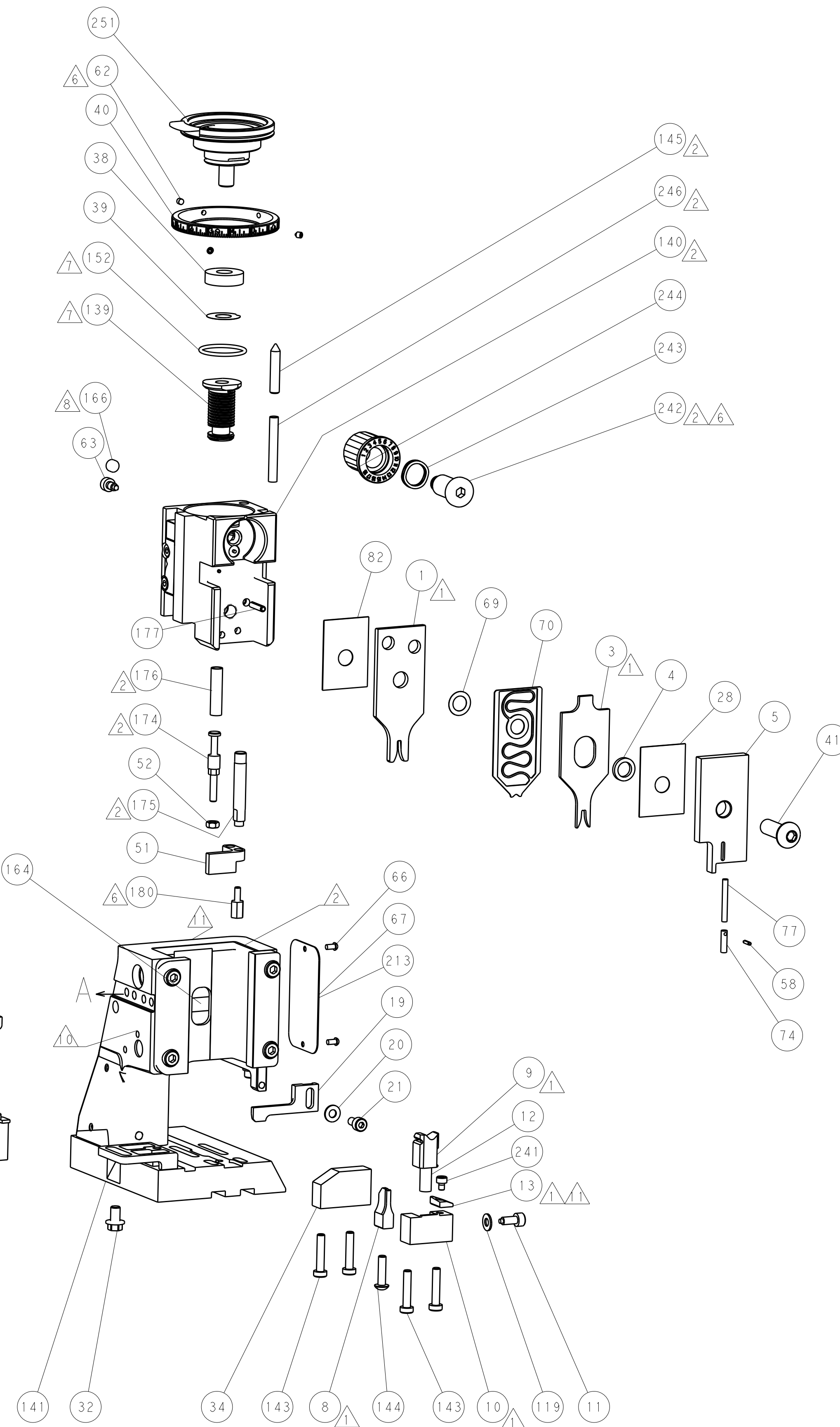
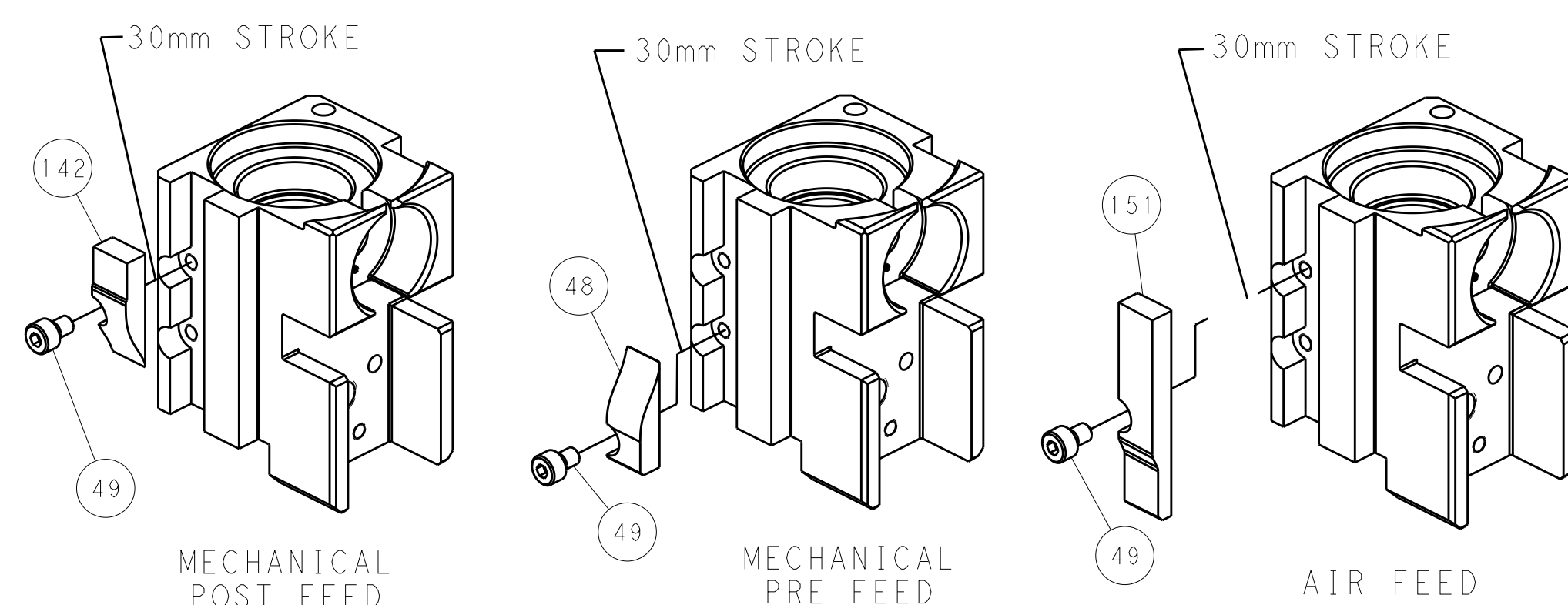
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN R. O. WILSON 14FEB2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK K. J. STAKEM 18FEB2013	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD T. L. ELGIN 18FEB2013	SIZE A1	
0 PLC ±		PRODUCT SPEC	CAGE CODE 00779	
1 PLC ±		APPLICATION SPEC	DRAWING NO 2151893	
2 PLC ±		WEIGHT	SCALE 1:2	
3 PLC ±		Customer Accessible Production Drawing	SHEET 2 of 4	
4 PLC ±			REV A1	
ANGLES FINISH				

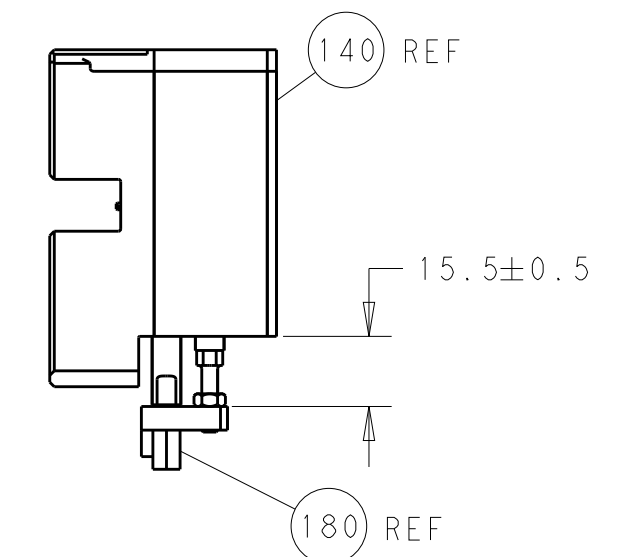
PNEUMATIC

SERVO
LATCH PLATE

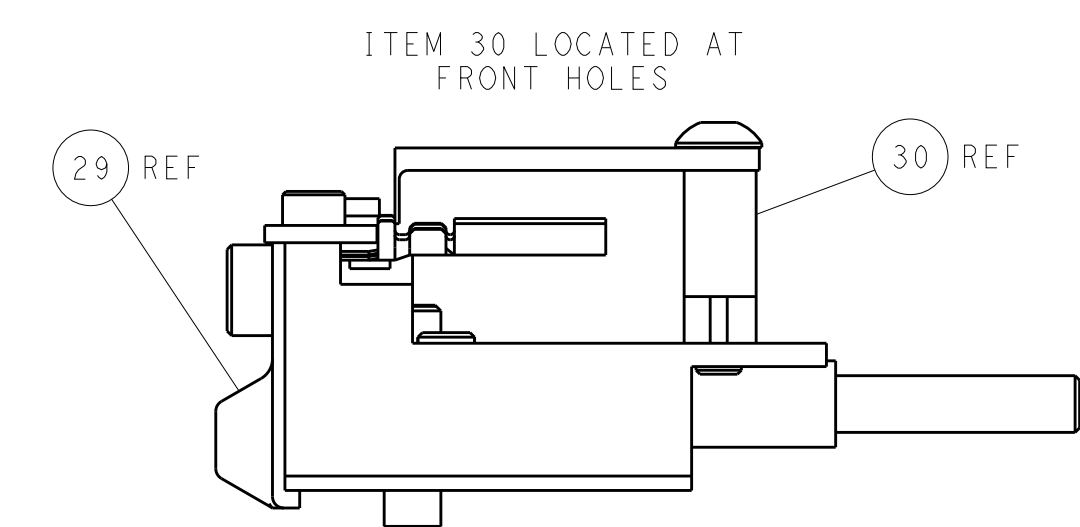
CAM POSITIONS



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)

THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONSULTED FOR THE LATEST REVISION		DWN P. O. WILSON 14FEB2013 CHK K. J. STAKEM 18FEB2013 APVD T. L. FLINN 18FEB2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±. 1 PLC ±. 2 PLC ±. 3 PLC ±. 4 PLC ±. ANGLES ±. FINISH -		NAME Ocean Side Feed Applicator -	
MATERIAL -		PRODUCT SPEC - APPLICATION SPEC - WEIGHT -		SIZE A 00779	
		DRAWING NO C=2151893		RESTRICTED TO -	
		SCALE 1:2 SHEET A OF A REV A			
Customer Accessible Production Drawing					