

8

7

THIS DRAWING IS UNPUBLISHED.

RELEASED FOR PUBLICATION

20

© COPYRIGHT 20

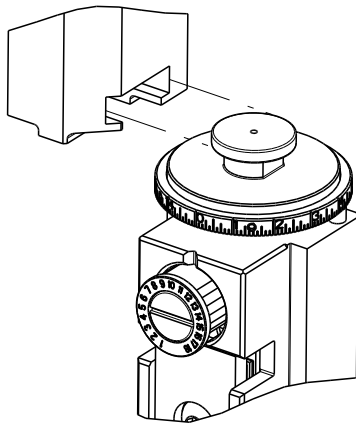
BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

ATLANTIC VERSION  
TERMINATOR  
INTERFACE ADAPTER

PART  
NUMBER

REVISION

DESCRIPTION



2151328-1

E

FINE CRIMP HEIGHT ADJUST

2151328-2

E

FINE CRIMP HEIGHT ADJUST

2151328-5

E

FINE CRIMP HEIGHT ADJUST

2151328-6

E

NON-CRIMP HEIGHT ADJUST

2151328-7

E

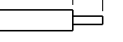
FINE CRIMP HEIGHT ADJUST

7-2151328-7

A

CRIMP TOOLING KIT

|                                      |                  |      |
|--------------------------------------|------------------|------|
| APPLICATOR DATA                      |                  |      |
| CRIMP                                | SIZE             | TYPE |
| WIRE                                 | 1.02 mm [ .040 ] | F    |
| INSUL                                | 2.90 mm [ .114 ] | O    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                  |      |

|                                                                                                                      |             |                                                                                   |                                                                                                                                                                                                  |
|----------------------------------------------------------------------------------------------------------------------|-------------|-----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                                           |             | TE CRIMP SPECIFICATION                                                            |                                                                                                                                                                                                  |
| TERMINAL NAME: MQS EDS SOCKET                                                                                        |             |                                                                                   |                                                                                                                                                                                                  |
| WIRE STRIP LENGTH<br>3.25-3.55 mm [.128-.140 IN]                                                                     |             |  | INSULATION DIAMETER RANGE<br>  |
| TERMINAL APPLICATION SPECIFICATION  | 114-18025   | -                                                                                 | -                                                                                                                                                                                                |
|                                                                                                                      | -           | -                                                                                 | -                                                                                                                                                                                                |
| TERMINALS APPLIED                                                                                                    |             |                                                                                   |                                                                                                                                                                                                  |
| TE TERMINAL                                                                                                          | TE TERMINAL | TE SEAL                                                                           | TE SEAL                                                                                                                                                                                          |
| 2141826-1                                                                                                            | 2141830-1   | 967067-2                                                                          |                                                                                                                                                                                                  |
| 2141826-5                                                                                                            | 2141830-2   |                                                                                   |                                                                                                                                                                                                  |
| 2141830-3                                                                                                            |             |                                                                                   |                                                                                                                                                                                                  |

|           |                                |                                |
|-----------|--------------------------------|--------------------------------|
| WIRE SIZE | CRIMP HEIGHT mm [ INCH ]       | CRIMP HEIGHT REFERENCE SETTING |
| 0.17mm2   | 0.70+/-0.02 [ .0276+/- .0008 ] | 10.4                           |
| 0.13mm2   | 0.68+/-0.02 [ .0268+/- .0008 ] | 10.7                           |



- 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: 8-2151328-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151328-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151328-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151328-6
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 50 & 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 -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.
- 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.

|     |    |    |    |    |    |           |                                 |         |
|-----|----|----|----|----|----|-----------|---------------------------------|---------|
| -   | -  | 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  | -  | 1803259-1 | BUSHING, FLANGED                | 249     |
| -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)

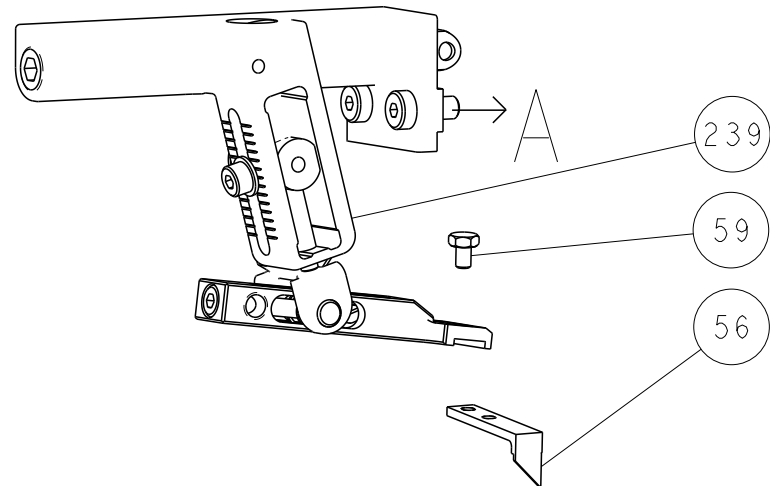
|                           |          |               |           |  |           |     |      |
|---------------------------|----------|---------------|-----------|--|-----------|-----|------|
| SET UP GAUGE<br>2119599-1 | LOC<br>A | DIST<br>66    | REVISIONS |  |           |     |      |
| P                         | LTR      | DESCRIPTION   |           |  | DATE      | DWN | APVD |
| D                         |          | ECR-14-007492 |           |  | 20MAT2014 | JH  | TE   |
| D1                        |          | ECR-15-000589 |           |  | 14JAN2015 | YY  | JT   |
| D2                        |          | ECR-15-013464 |           |  | 14SEP2015 | YY  | UG   |
| E                         |          | ECR-16-013436 |           |  | 21SEP2016 | TB  | GB   |

|   |     |     |     |     |     |             |                                     |     |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | -   | -   | -   | 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   | 2119082-4   | 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   | 9931111-1   | PIN, SLOTTED SPRING 3.0 X 20.0      | 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   | 455888-6    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70  |
| - | 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   | 1901681-1   | HOLDDOWN, TERMINAL                  | 51  |
| - | 1   | 1   | 1   | 1   | 1   | 1-1752354-7 | STANDOFF,HOLD-DOWN                  | 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   | 2-1752356-0 | 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   | 1-455888-0  | 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   | 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   | 1   | 1333332-6   | ANVIL, COMBINATION, SPECIAL         | 8   |
| - | 1   | 1   | 1   | 1   | 1   | 2119781-1   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 1   | 3-238011-8  | BLOCK, CRIMPER SPACER               | 4   |
| 1 | 1   | 1   | 1   | 1   | 1   | 1633996-2   | CRIMPER, INSULATION SPECIAL         | 3   |
| 1 | 1   | 1   | 1   | 1   | 1   | 4-1633738-0 | CRIMPER, WIRE                       | 1   |

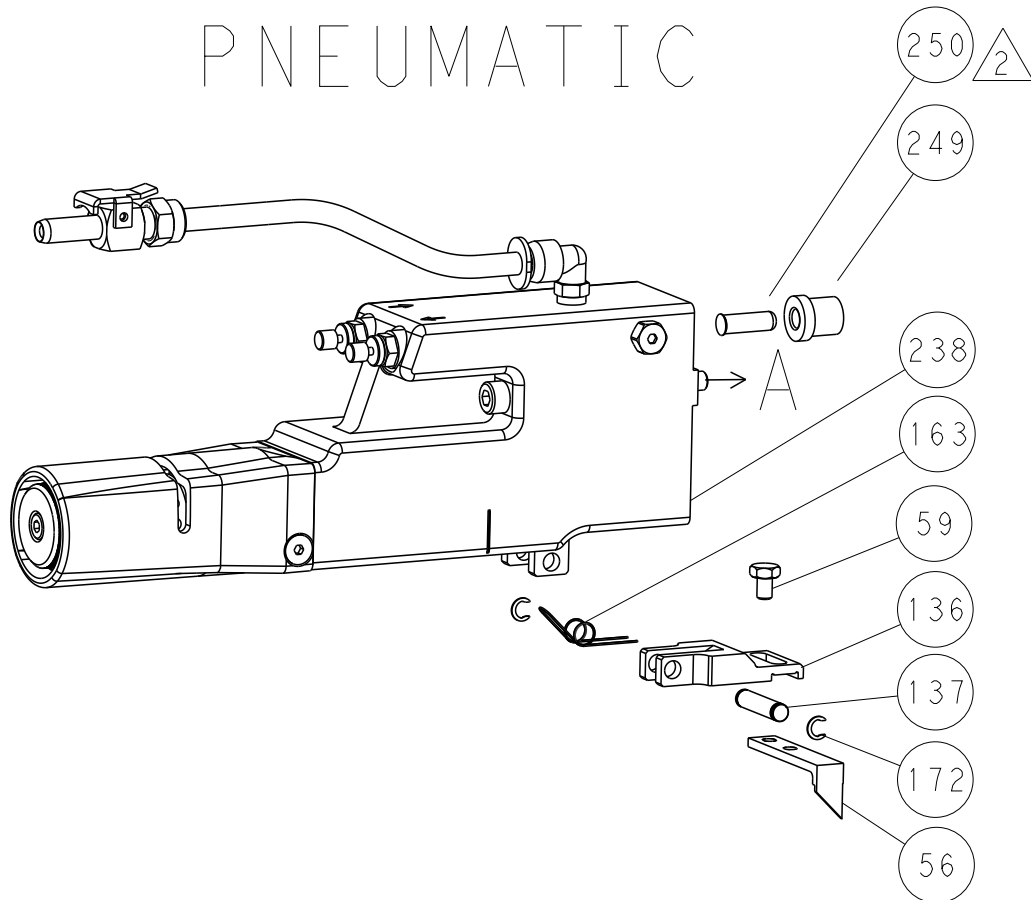
|                                                                                                                                                                                                                                       |  |                  |           |                                              |  |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------|-----------|----------------------------------------------|--|
| THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS OF THIS DRAWING. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS. |  | DWN<br>A. HUANG  | 24AUG2011 | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| DIMENSIONS:<br>mm                                                                                                                                                                                                                     |  | APVD<br>S. XI    | 24AUG2011 | NAME<br>Ocean Side Feed<br>Applicator        |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.1<br>1 PLC ±.1<br>2 PLC ±.1<br>3 PLC ±.1<br>4 PLC ±.1<br>ANGLES ±.1                                                                                                                 |  | PRODUCT SPEC     |           | SIZE<br>A                                    |  |
| MATERIAL<br>-                                                                                                                                                                                                                         |  | APPLICATION SPEC |           | CASE CODE<br>00779                           |  |
| FINISH<br>-                                                                                                                                                                                                                           |  | WEIGHT<br>-      |           | DRAWING NO<br>C-2151328                      |  |
| Customer Accessible Production Drawing                                                                                                                                                                                                |  | SCALE<br>1:2     |           | SHEET<br>1 OF 4                              |  |
|                                                                                                                                                                                                                                       |  |                  |           | REV<br>E                                     |  |

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

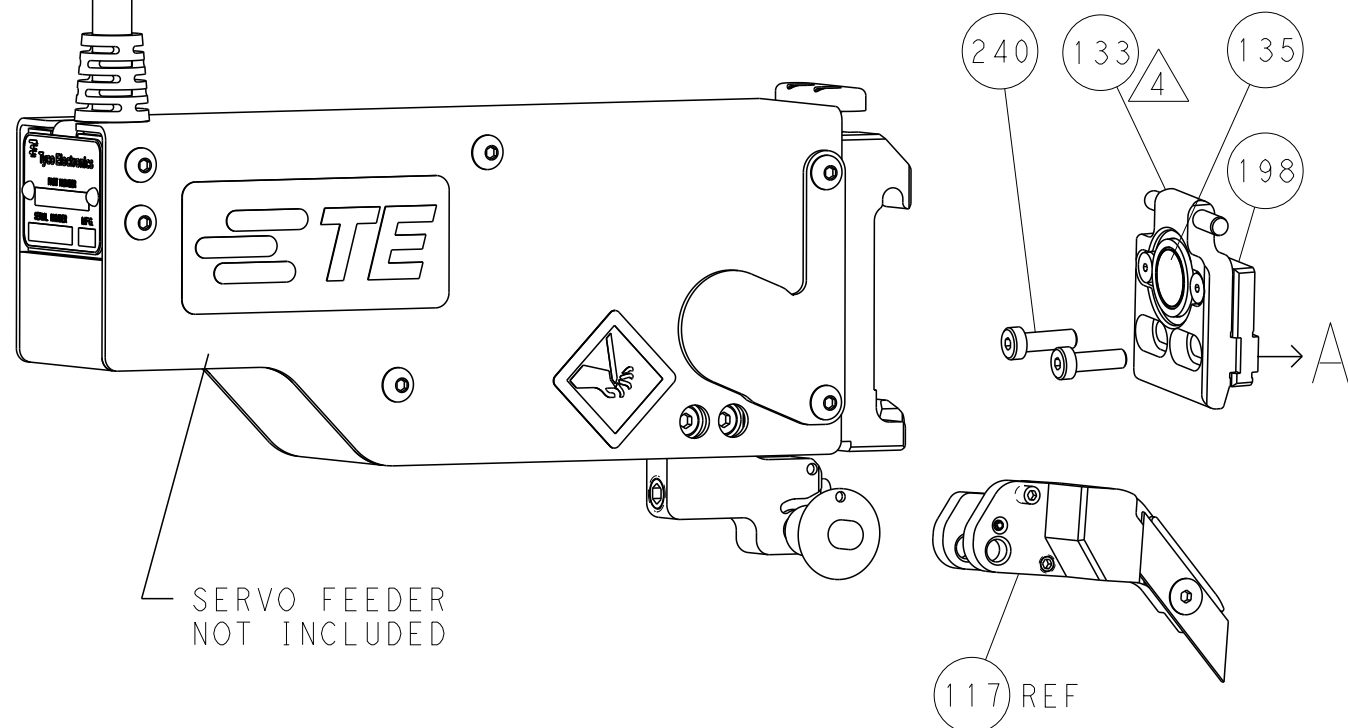
FEED TYPE  
MECHANICAL



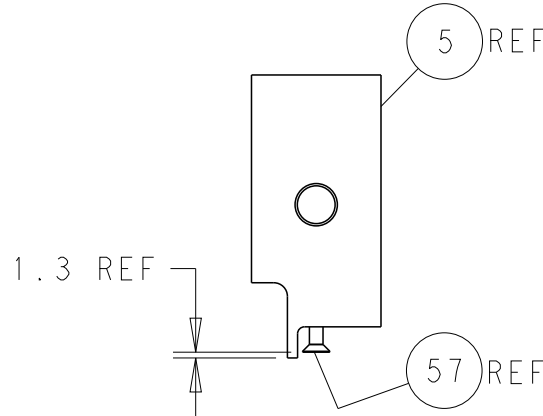
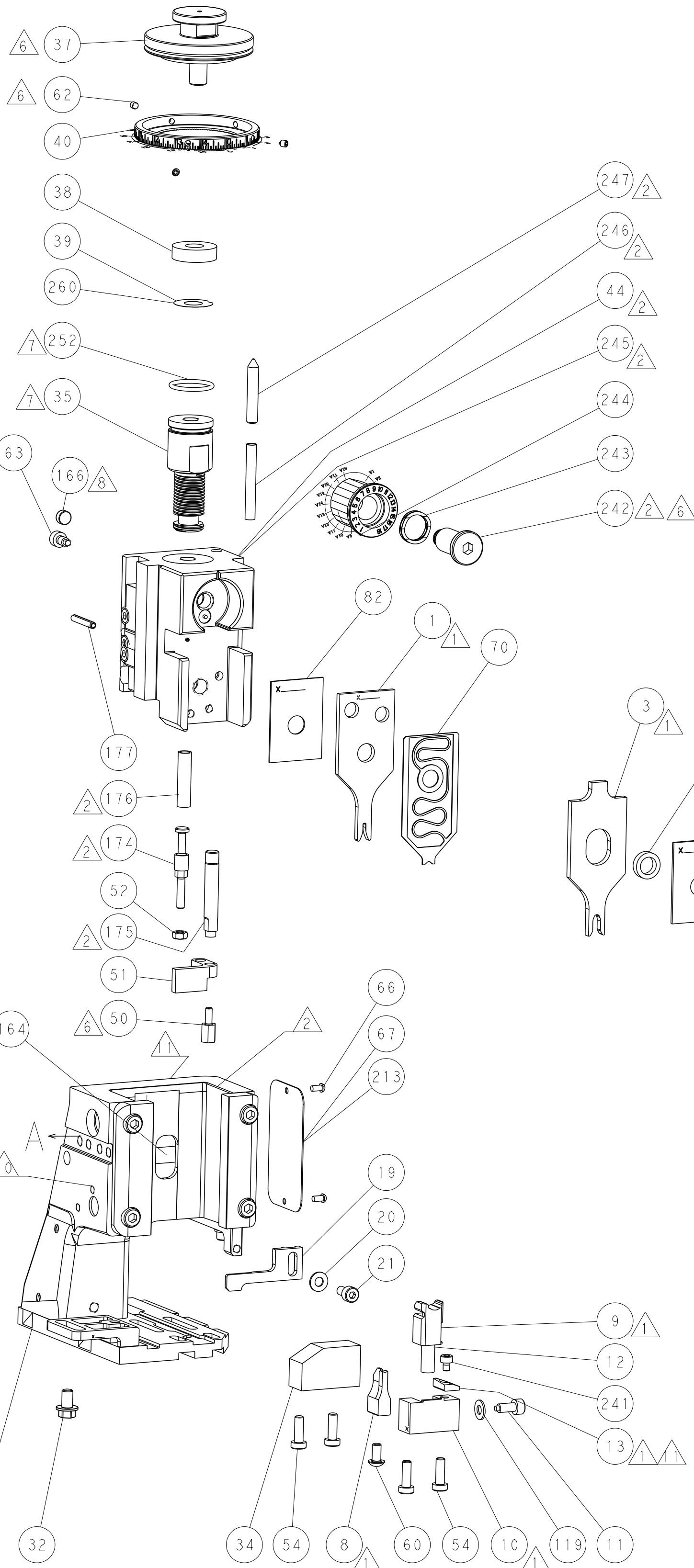
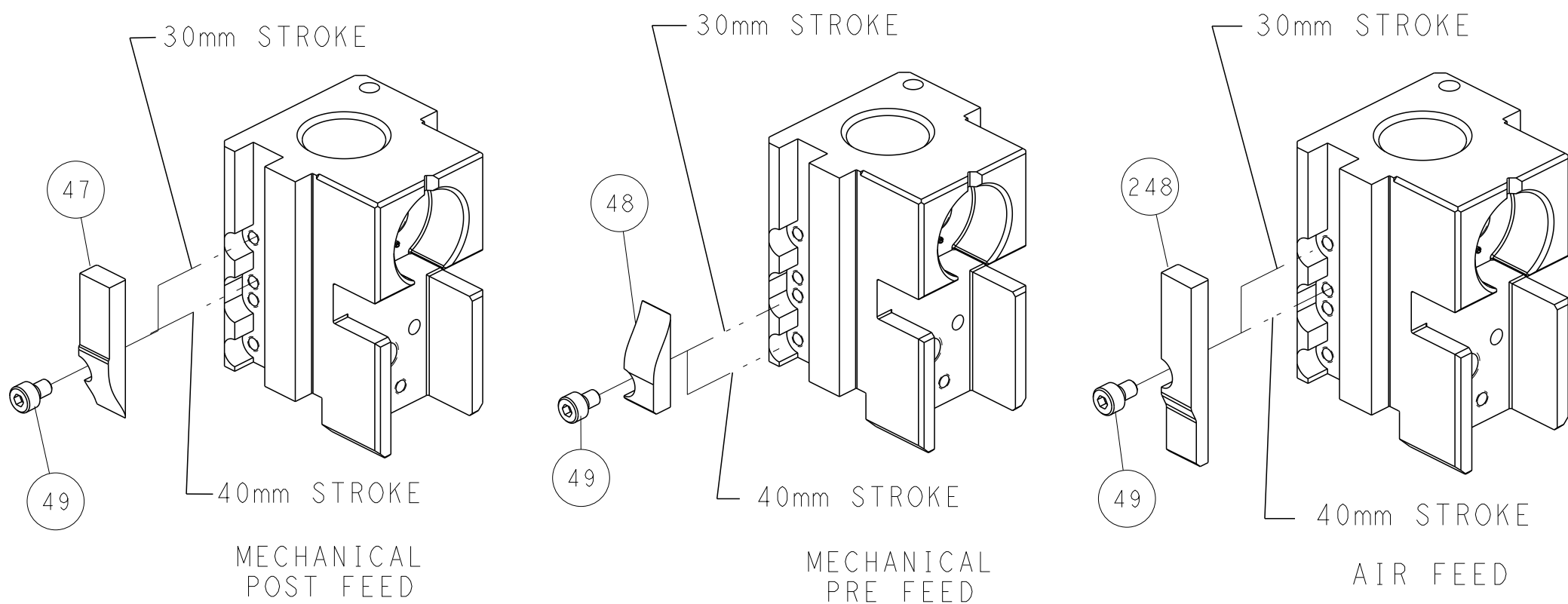
PNEUMATIC



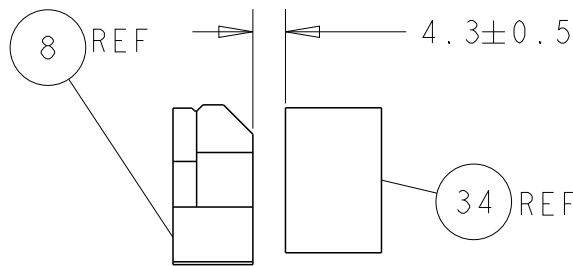
SERVO  
LATCH PLATE



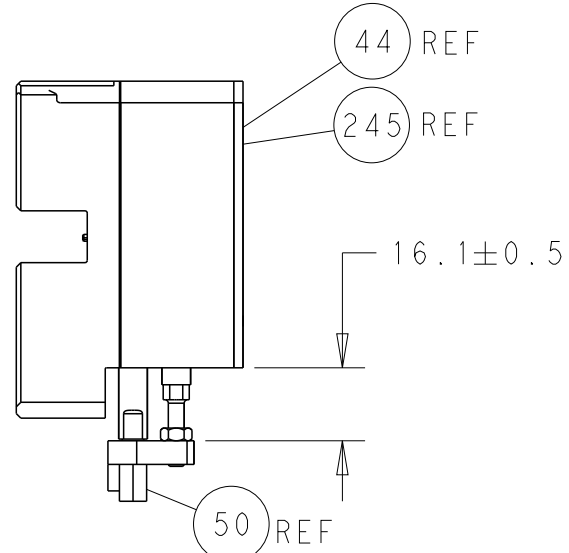
CAM POSITIONS



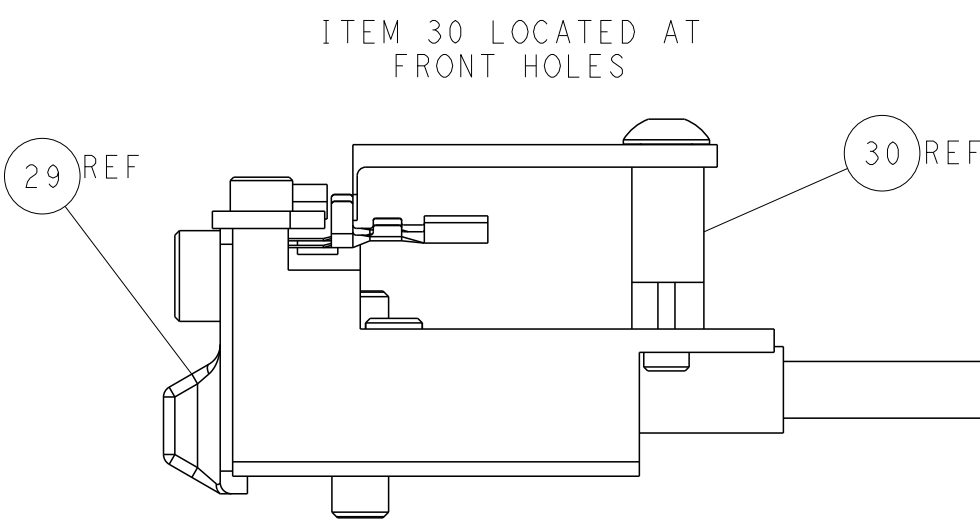
SHEAR DEPRESSOR DETAIL



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. |  |  |  | DWN<br>K. HUANG<br>24AUG2011           |  |  |  | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |  |  |
| DIMENSIONS:                                                                                                                                          |  |  |  | CHK<br>S. XI<br>24AUG2011              |  |  |  | NAME<br>Ocean Side Feed<br>Applicator        |  |  |  |
| mm                                                                                                                                                   |  |  |  | PRODUCT SPEC                           |  |  |  | SIZE<br>A1                                   |  |  |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:                                                                                                               |  |  |  | APPLICATION SPEC                       |  |  |  | CAGE CODE<br>00779                           |  |  |  |
| 0 PLC ±.1                                                                                                                                            |  |  |  | WEIGHT                                 |  |  |  | DRAWING NO<br>C-2151328                      |  |  |  |
| 1 PLC ±.1                                                                                                                                            |  |  |  | MATERIAL                               |  |  |  | RESTRICTED TO                                |  |  |  |
| 2 PLC ±.1                                                                                                                                            |  |  |  | FINISH                                 |  |  |  | SCALE<br>1:2                                 |  |  |  |
| 3 PLC ±.1                                                                                                                                            |  |  |  | Customer Accessible Production Drawing |  |  |  | SHEET<br>2                                   |  |  |  |
| 4 PLC ±.1                                                                                                                                            |  |  |  | Customer Accessible Production Drawing |  |  |  | OF 4                                         |  |  |  |
| ANGLES                                                                                                                                               |  |  |  | SCALE                                  |  |  |  | REV<br>E                                     |  |  |  |
| FINISH                                                                                                                                               |  |  |  | SCALE                                  |  |  |  | REV                                          |  |  |  |

| PACIFIC VERSION<br>TERMINATOR<br>INTERFACE ADAPTER | PART<br>NUMBER | REVISION | DESCRIPTION              | FEED TYPE                         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |
|----------------------------------------------------|----------------|----------|--------------------------|-----------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|
|                                                    |                |          |                          |                                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |
|                                                    |                |          |                          |                                   |                                   | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|                                                    | 2-2151328-1    | E        | FINE CRIMP HEIGHT ADJUST | MECHANICAL                        | PNEUMATIC FEED                    | 2119950-1             | 1338685-1 | 5-18022-5   | 2119641-2 | 2119799-1 | 2063440-1              |
|                                                    |                |          |                          |                                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151328-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|                                                    |                |          |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151328-4 | -         | -         | -                      |
|                                                    | 2-2151328-2    | E        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                         | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |
|                                                    |                |          |                          |                                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151328-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |
|                                                    |                |          |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151328-4 | -         | -         | -                      |
|                                                    | 2-2151328-5    | E        | FINE CRIMP HEIGHT ADJUST | SERVO<br>LATCH PLATE <sup>4</sup> | 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              |
|                                                    | 2-2151328-7    | E        | FINE CRIMP HEIGHT ADJUST | NONE                              | -                                 | -                     | -         | -           | -         | -         | -                      |
|                                                    | 7-2151328-7    | A        | CRIMP TOOLING KIT        | -                                 | -                                 | -                     | -         | -           | -         | -         | -                      |

| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 1.02 mm [.040] | F    |
| INSUL                                | 2.90 mm [.114] | O    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

|                                                                                                                      |             |                                                                                   |                                                                                                                                                                                                  |
|----------------------------------------------------------------------------------------------------------------------|-------------|-----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| TERMINAL DATA: TE TERMINAL                                                                                           |             | TE CRIMP SPECIFICATION                                                            |                                                                                                                                                                                                  |
| TERMINAL NAME: MQS EDS SOCKET                                                                                        |             |                                                                                   |                                                                                                                                                                                                  |
| WIRE STRIP LENGTH<br>3.25-3.55 mm [.128-.140 IN]                                                                     |             |  | INSULATION DIAMETER RANGE<br>  |
| TERMINAL APPLICATION SPECIFICATION  | 114-18025   | -                                                                                 | -                                                                                                                                                                                                |
| TERMINALS APPLIED                                                                                                    |             |                                                                                   |                                                                                                                                                                                                  |
| TE TERMINAL                                                                                                          | TE TERMINAL | TE SEAL                                                                           | TE SEAL                                                                                                                                                                                          |
| 2141826-1                                                                                                            | 2141830-1   | 967067-2                                                                          |                                                                                                                                                                                                  |
| 2141826-5                                                                                                            | 2141830-2   |                                                                                   |                                                                                                                                                                                                  |
| 2141830-3                                                                                                            |             |                                                                                   |                                                                                                                                                                                                  |

|           |                              |                                |
|-----------|------------------------------|--------------------------------|
| WIRE SIZE | CRIMP HEIGHT mm [INCH]       | CRIMP HEIGHT REFERENCE SETTING |
| 0.17mm2   | 0.70+/-0.02 [.0276+/--.0008] | 10.4                           |
| 0.13mm2   | 0.68+/-0.02 [.0268+/--.0008] | 10.7                           |



<sup>1</sup> RECOMMENDED SPARE PARTS

<sup>2</sup> GREASE BEARING SURFACES LIGHTLY

3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

<sup>4</sup> APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151328-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151328-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151328-5

5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

<sup>6</sup> APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 50 & 62.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

<sup>7</sup> GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

<sup>8</sup> MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

<sup>9</sup> 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.

<sup>10</sup> SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

<sup>11</sup> 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.

<sup>12</sup> THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

<sup>13</sup> APPLY TORQ-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.

\*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     |
| -   | -   | -   | 1   | -   | 2119640-1 | PUSH ROD, AIR FEED                  | 250     |
| -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)

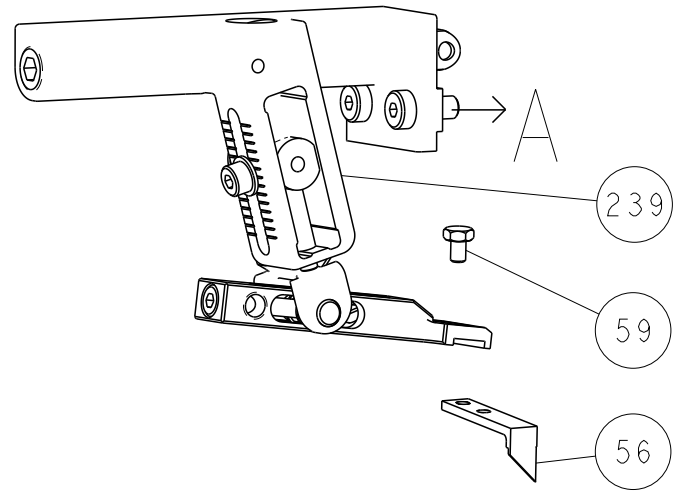
| SET UP GAUGE<br>2119599-1 | LOC<br>A | DIST<br>66 | REVISIONS |     |             |      |
|---------------------------|----------|------------|-----------|-----|-------------|------|
|                           |          |            | P         | LTR | DESCRIPTION | DATE |
|                           |          |            |           |     | SEE SHEET 1 |      |
|                           |          |            |           |     |             |      |
|                           |          |            |           |     |             |      |
|                           |          |            |           |     |             |      |

|   |   |     |     |     |     |             |                                     |     |
|---|---|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| 6 | - | -   | -   | 1   | -   | 1803259-1   | BUSHING, FLANGED                    | 249 |
|   | - | 1   | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246 |
|   | - | 1   | 1   | 1   | 1   | 2119082-4   | 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 |
| 7 | - | -   | 1   | -   | -   | 1901094-3   | SPACER, FEEDER                      | 198 |
|   | - | 1   | 1   | 1   | 1   | 993111-1    | PIN, SLOTTED SPRING 3.0 X 20.0      | 177 |
|   | - | 1   | 1   | 1   | 1   | 8-22280-7   | SPRING, COMPRESSION                 | 176 |
|   | - | 1   | 1   | 1   | 1   | 1752353-2   | 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 |
| 7 | - | -   | -   | 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   | 1-2119656-0 | 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 |
| 6 | - | -   | 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   | 455888-6    | SPACER, CRIMPER                     | 82  |
|   | - | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
|   | - | 1   | 1   | 1   | 1   | 2119791-5   | DEPRESSOR, WIRE                     | 70  |
|   | - | 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   | 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   | 1901681-1   | HOLDDOWN, TERMINAL                  | 51  |
|   | - | 1   | 1   | 1   | 1   | 1-1752354-7 | STANDOFF,HOLD-DOWN                  | 50  |
|   | - | -   | -   | 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  |
| 6 | - | 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   | 2-1752356-0 | 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   | 1320908-3   | SPACER, STRIP GUIDE                 | 30  |
|   | - | 1   | 1   | 1   | 1   | 2119959-1   | ASSEMBLY, STRIP GUIDE               | 29  |
|   | - | 1   | 1   | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28  |
|   | - | 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   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
|   | - | 1   | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
|   | - | 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   | 1   | 1333332-6   | ANVIL, COMBINATION, SPECIAL         | 8   |
|   | - | 1   | 1   | 1   | 1   | 2119781-1   | DEPRESSOR, SHEAR                    | 5   |
| 1 | - | 1   | 1   | 1   | 1   | 3-238011-8  | BLOCK, CRIMPER SPACER               | 4   |
|   | 1 | 1   | 1   | 1   | 1   | 1633996-2   | CRIMPER, INSULATION SPECIAL         | 3   |
|   | 1 | 1   | 1   | 1   | 1   | 4-1633738-0 | CRIMPER, WIRE                       | 1   |

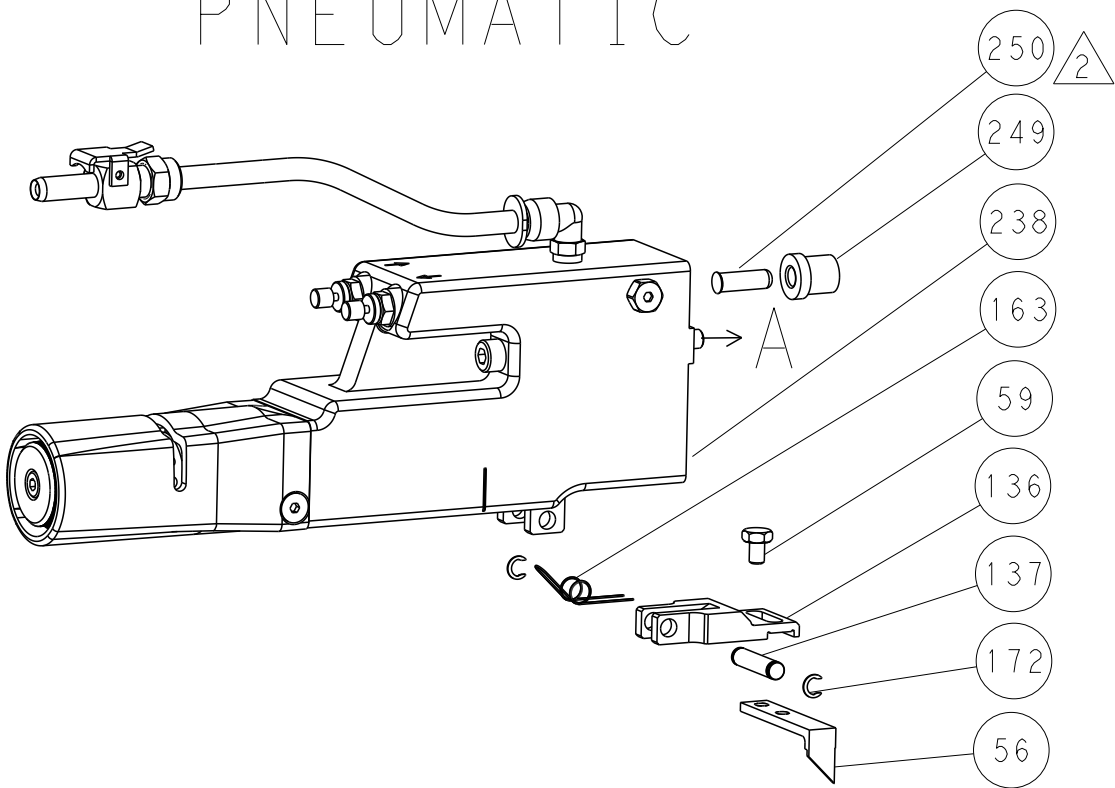
|                                                                                                                                      |  |                                                                                                                                 |           |                                              |  |
|--------------------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------------------------------------------------------------|-----------|----------------------------------------------|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR OBTAINING THE LATEST EDITION. |  | DWN<br>R. HUANG                                                                                                                 | 24AUG2011 | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| DIMENSIONS:<br>mm                                                                                                                    |  | APVD<br>S. XI                                                                                                                   | 24AUG2011 | NAME<br>Ocean Side Feed<br>Applicator        |  |
|                                                                                                                                      |  | TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±.1<br>1 PLC ±.1<br>2 PLC ±.1<br>3 PLC ±.1<br>4 PLC ±.1<br>ANGLES ±.1<br>FINISH |           | PRODUCT SPEC                                 |  |
| MATERIAL<br>-                                                                                                                        |  | WEIGHT<br>-                                                                                                                     |           | APPLICATION SPEC                             |  |
|                                                                                                                                      |  | SIZE<br>A                                                                                                                       |           | CASE CODE<br>00779                           |  |
|                                                                                                                                      |  | DRAWING NO<br>C=2151328                                                                                                         |           | RESTRICTED TO<br>-                           |  |
|                                                                                                                                      |  | Customer Accessible Production Drawing                                                                                          |           | SCALE<br>1:2                                 |  |
|                                                                                                                                      |  | SHEET<br>3                                                                                                                      |           | OF<br>4                                      |  |
|                                                                                                                                      |  | REV<br>E                                                                                                                        |           |                                              |  |

| LOC |     | DIST        |  | REVISIONS |     |      |  |
|-----|-----|-------------|--|-----------|-----|------|--|
| P   | LYR | DESCRIPTION |  | DATE      | DWN | APVD |  |
| -   | -   | SEE SHEET 1 |  | -         | -   | -    |  |
|     |     |             |  |           |     |      |  |
|     |     |             |  |           |     |      |  |
|     |     |             |  |           |     |      |  |

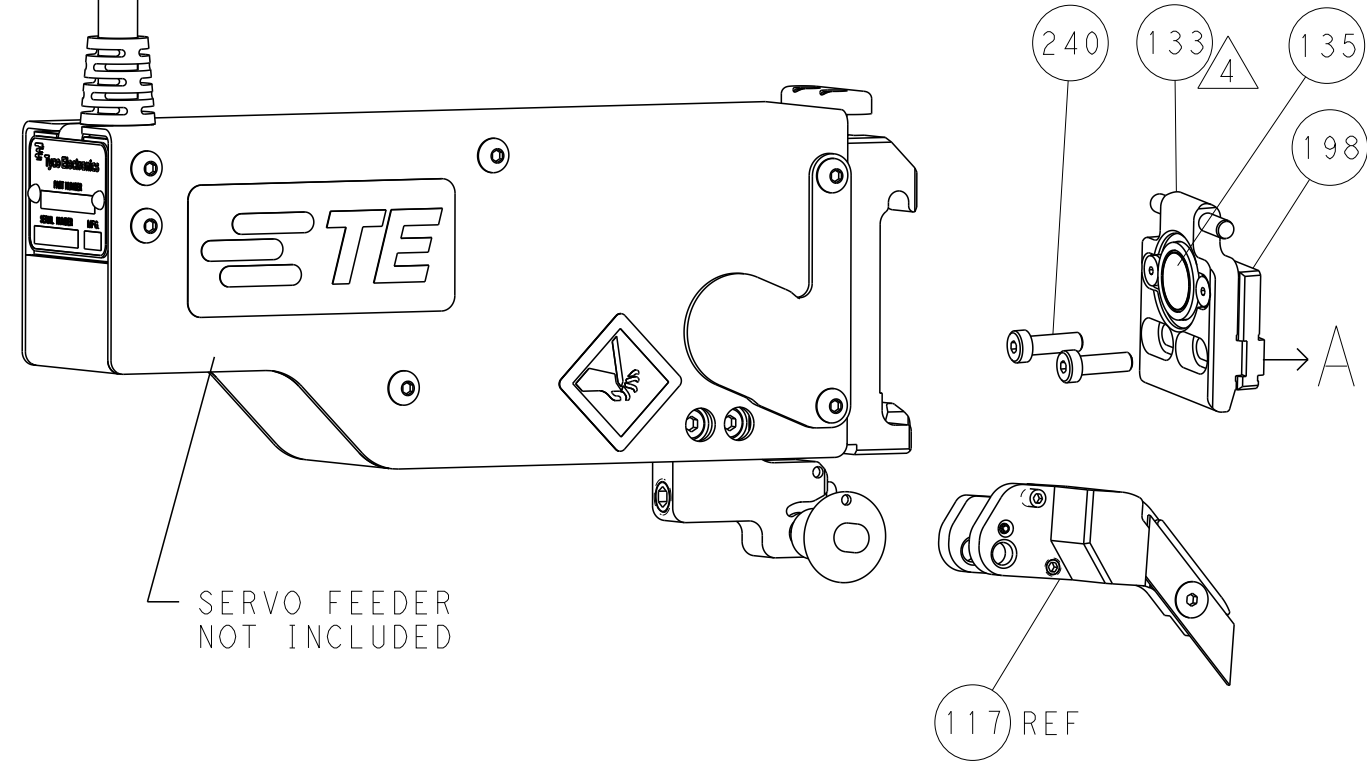
# FEED TYPE MECHANICAL



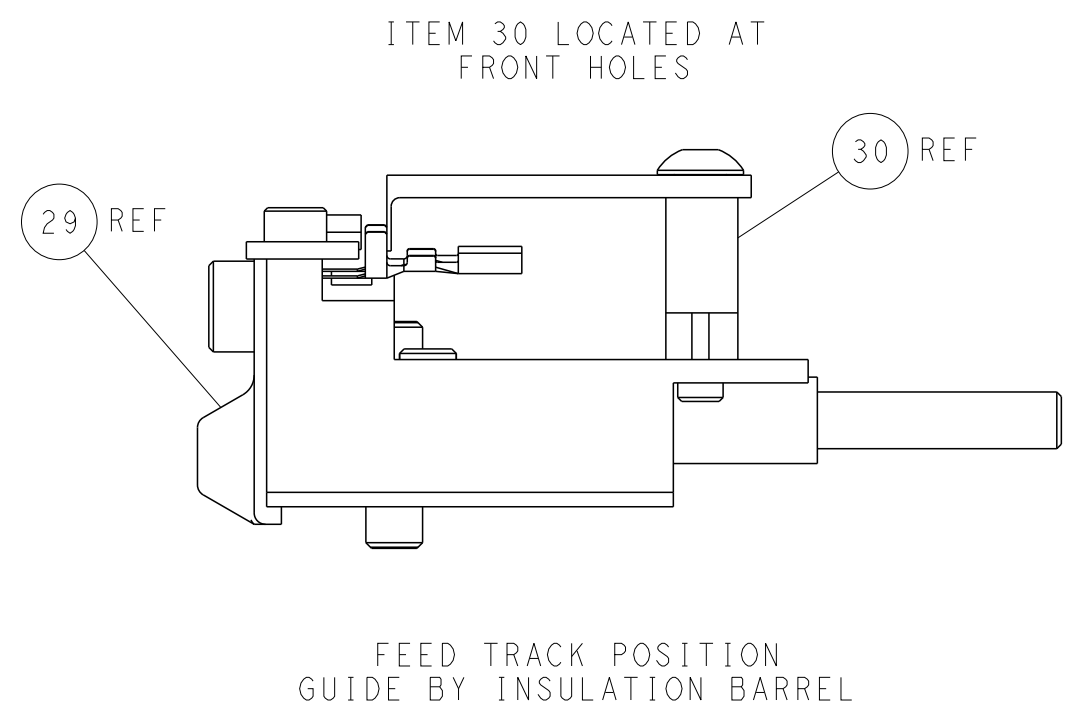
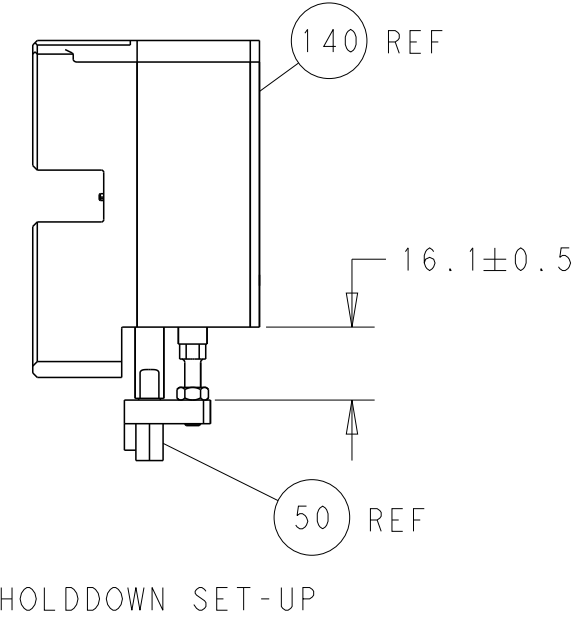
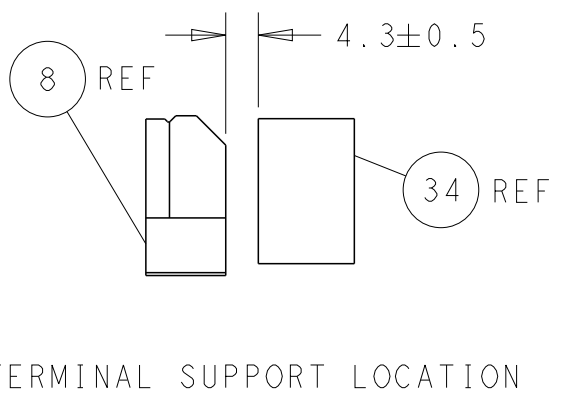
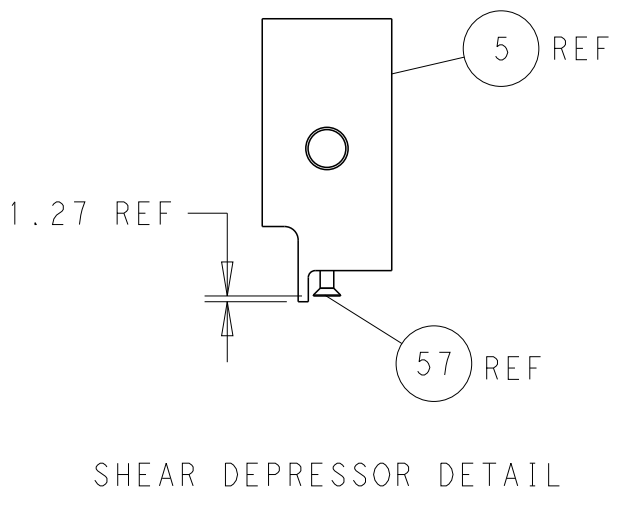
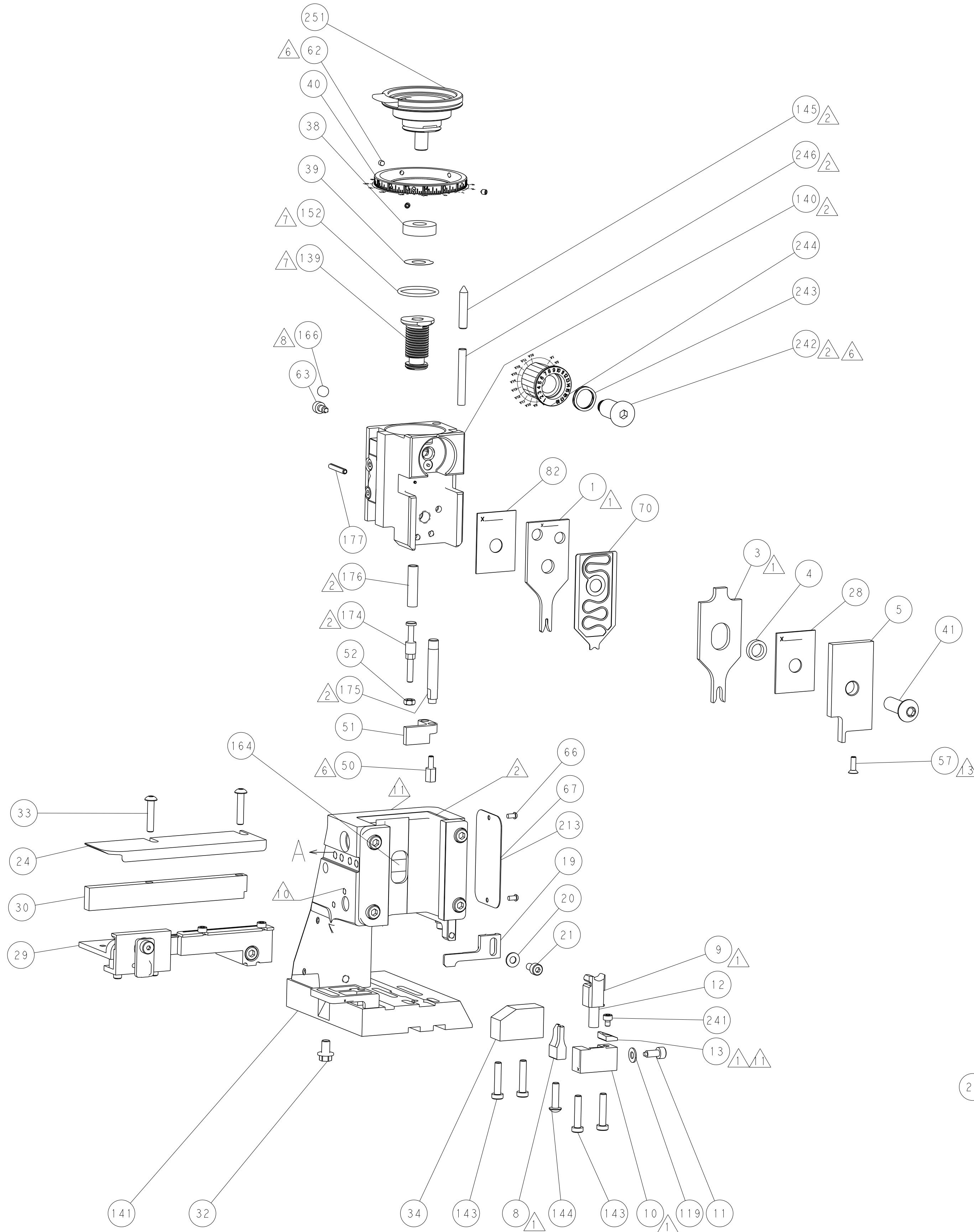
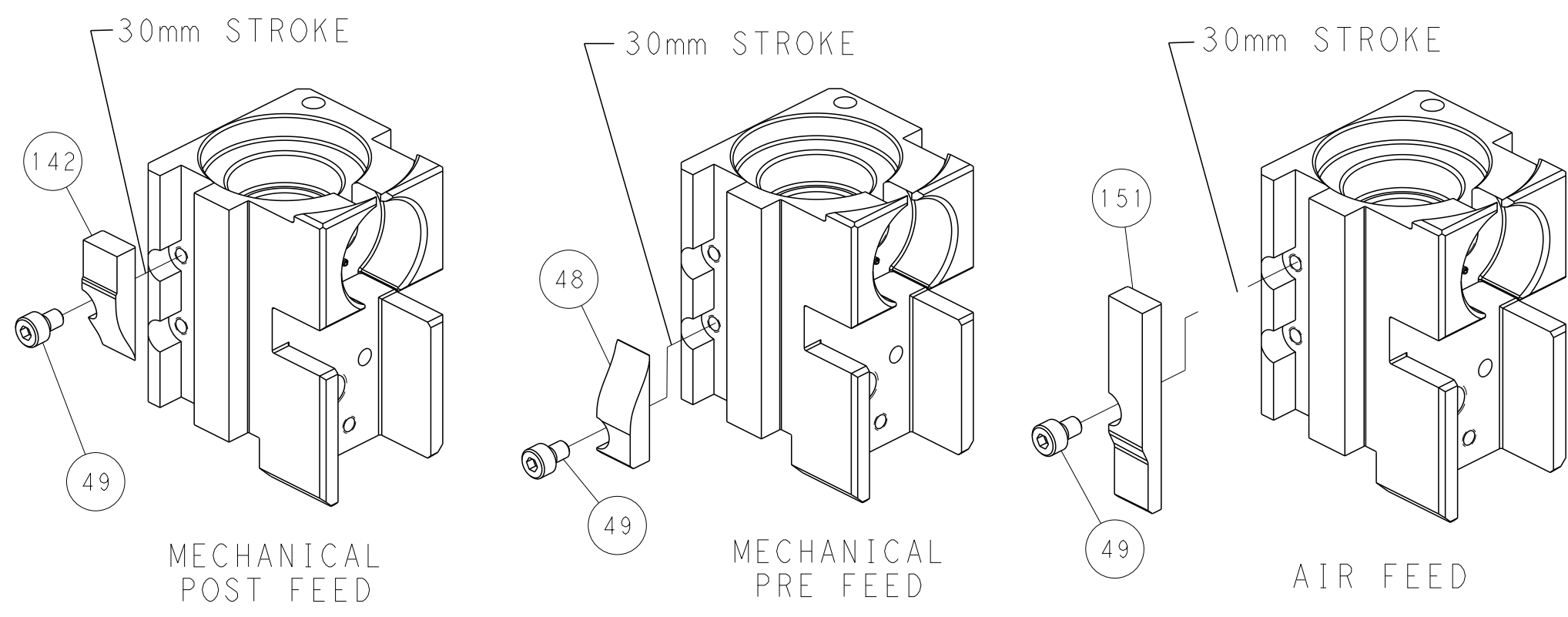
# PNEUMATIC



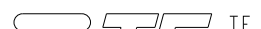
# SERVO LATCH PLATE



# CAM POSITIONS



PACIFIC VERSION  
Shown on sheets 3 of 4 & 4 of 4  
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

|                                                                                                                                                                                                         |  |                                        |           |                                                                                                                                    |              |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------|-----------|------------------------------------------------------------------------------------------------------------------------------------|--------------|
| THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ESD: ELECTRONIC DESIGN CORPORATION<br>IT IS SUBJECT TO CHANGE AND THE CONTROL AND CHANGE NO. ORGANIZATION<br>SHOULD BE CONTROLLED FOR THE LATEST VERSION. |  | DWN<br>K. HUANG                        | 24AUG2011 |  TE Connectivity<br>Harrisburg, PA 17105-3608 |              |
| DIMENSIONS:                                                                                                                                                                                             |  | CHK<br>-                               | -         | NAME                                                                                                                               |              |
| mm                                                                                                                                                                                                      |  | APVD<br>S. XI                          | 24AUG2011 | Ocean Side Feed<br>Applicator                                                                                                      |              |
|                                                                                                                    |  | PRODUCT SPEC                           |           | -                                                                                                                                  |              |
|                                                                                                                                                                                                         |  | APPLICATION SPEC                       |           | -                                                                                                                                  |              |
|                                                                                                                                                                                                         |  | SIZE                                   |           | CAGE CODE                                                                                                                          | DRAWING NO   |
|                                                                                                                                                                                                         |  | WEIGHT                                 |           | RESTRICTED TO                                                                                                                      |              |
| MATERIAL                                                                                                                                                                                                |  | A1 00779                               |           | ©=2151328                                                                                                                          |              |
|                                                                                                                                                                                                         |  | Customer Accessible Production Drawing |           | SCALE 1:2                                                                                                                          | SHEET 4 OF 4 |
|                                                                                                                                                                                                         |  |                                        |           | REV E                                                                                                                              |              |