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THIS DRAWING IS UNPUBLISHED.

RELEASED FOR PUBLICATION

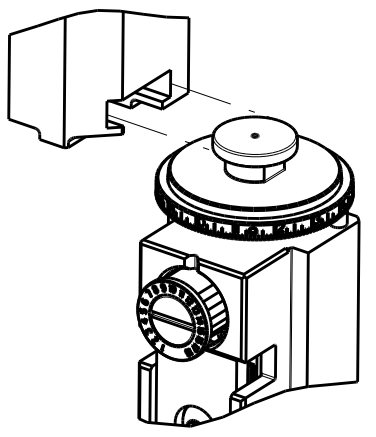
20

20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

REVISION

DESCRIPTION

FEED TYPE

2151523-2

D

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2151523-5

D

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE

2151523-6

D

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE

2151523-7

D

FINE CRIMP HEIGHT ADJUST

NONE

7-2151523-7

B

CRIMP TOOLING KIT

-

APPLICATOR STYLE CONVERSION CHART

CONVERT TO

PART NUMBERS REQUIRED

SERVO LATCH PLATE
SMART APPLICATOR

2119951-1

-

8-2151523-5

1901094-3

1-1752354-5

2168400-6 (QUANTITY 2)

SMART APPLICATOR

2161326-1

-

8-2151523-4

-

-

-

PNEUMATIC FEED

2119950-1

1338685-1

5-18022-5

2119799-1

2119799-1

2063440-1

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.07 mm [.042]

F

INSUL

1.07 mm [.042]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: NANO MQS TERMINAL

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

3.25-3.55mm [.128-.140 IN]

Ø 0.95-1.20mm [.037-.047 IN]

TERMINAL APPLICATION SPECIFICATION

(A)114-18858

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

(A)2-1703930-1

(A)2-1703930-2

(A)2-1703930-3

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

0.35mm2

0.78+/-0.02 [.031+/- .001]

9.2

0.22mm2

0.70+/-0.02 [.028+/- .001]

10.4

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:
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151523-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151523-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151523-6

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

PRODUCTION ONLY ALLOWED WITH TOOLS WITH PNEUMATIC OR SERVOELECTRICAL FEED. MECHANICAL FEED IS NOT ALLOWED.

11

WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.98.

12

CUT TO LENGTH AT ASSEMBLY.

*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.

12	-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
11	-	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	2119798-1	DETENT PIN	247
	-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
	-	-	1	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
	-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

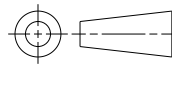
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS				
P	LTR	DESCRIPTION		DATE	OWN	APVD		
	D	ECR-16-012987		09SEP2016	MR	GB		
	D1	ECR-16-016132		15NOV2016	RS	LZ		
6	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
	-	-	2	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
	-	-	-	-	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
8	-	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	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	1-18028-2	WASHER, FLAT, REG M4	119
	-	1	1	1	1	1-22281-8	SPRING, COMPRESSION	98
	-	1	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	97
	-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	96
	-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	95
	-	1	1	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	1	1	1803205-1	INSULATION HOLDER	74
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
6	-	1	-	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	-	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
	-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	-	-	-	1	1338685-1	PAWL, FEED	56
2	-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
	-	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	1	690753-2	SPACER, TONKER	50
	-	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
	-	1	-	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
	-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	-	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	1	-	1	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
6	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
	-	1	1	1	1	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	36
7	-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
	-	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
	-	1	1	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	31
	-	1	1	1	1	1320908-2	SPACER, STRIP GUIDE	30
	-	1	1	1	1	1901086-1	PLATE, STRIP GUIDE	29
	-	1	1	1	1	455888-3	SPACER, CRIMPER	28
	-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1	1	1803142-1	DRAG, TERMINAL	25
	-	1	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	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	3-22280-3	SPRING, COMPRESSION	12
	-	1	1	1	1	2-519000-1	SCR, SKT HD CAP M4 X 10.0	11
1	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	1803095-7	FLOATING SHEAR, FRONT	9
	1	1	1	1	1	1-1633620-2	ANVIL, COMBINATION	8
	-	1	1	1	1	240641-1	SPACER	7
	-	-	-	-	-	-	-	6
	-	1	1	1	1	1803140-1	DEPRESSOR, SHEAR	5
	-	1	1	1	1	5-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1803143-2	CRIMPER, INSULATION O	3
	-	-	-	-	-	-	-	2
1	1	1	1	1	1	2-1333281-7	CRIMPER, WIRE PREMIUM	1
	-77	-7	-6	-5	-2	PART NO	DESCRIPTION	ITEM NO

THE FOLLOWING IS A SUMMARY OF THE INFORMATION CONTAINED IN THIS DRAWING. IT IS SUBJECT TO CHANGE WITHOUT NOTICE AND WITHOUT OBLIGATION TO BE CONTACTED FOR THE LATEST REVISION.

OWN: BOB HIGMAN 09MAY2013
CHK: G. BAILEY 09MAY2013
APVD: M. CLIFFORD 09MAY2013

DIMENSIONS:
mm



TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±
FINISH

MATERIAL: -

FINISH: -

WEIGHT: -

Customer Accessible Production Drawing

NAME: Ocean Side Feed Applicator

SIZE: A1

CAGE CODE: 00779

DRAWING NO: ©=2151523

RESTRICTED TO: -

SCALE: 1:2

SHEET: 1

OF: 4

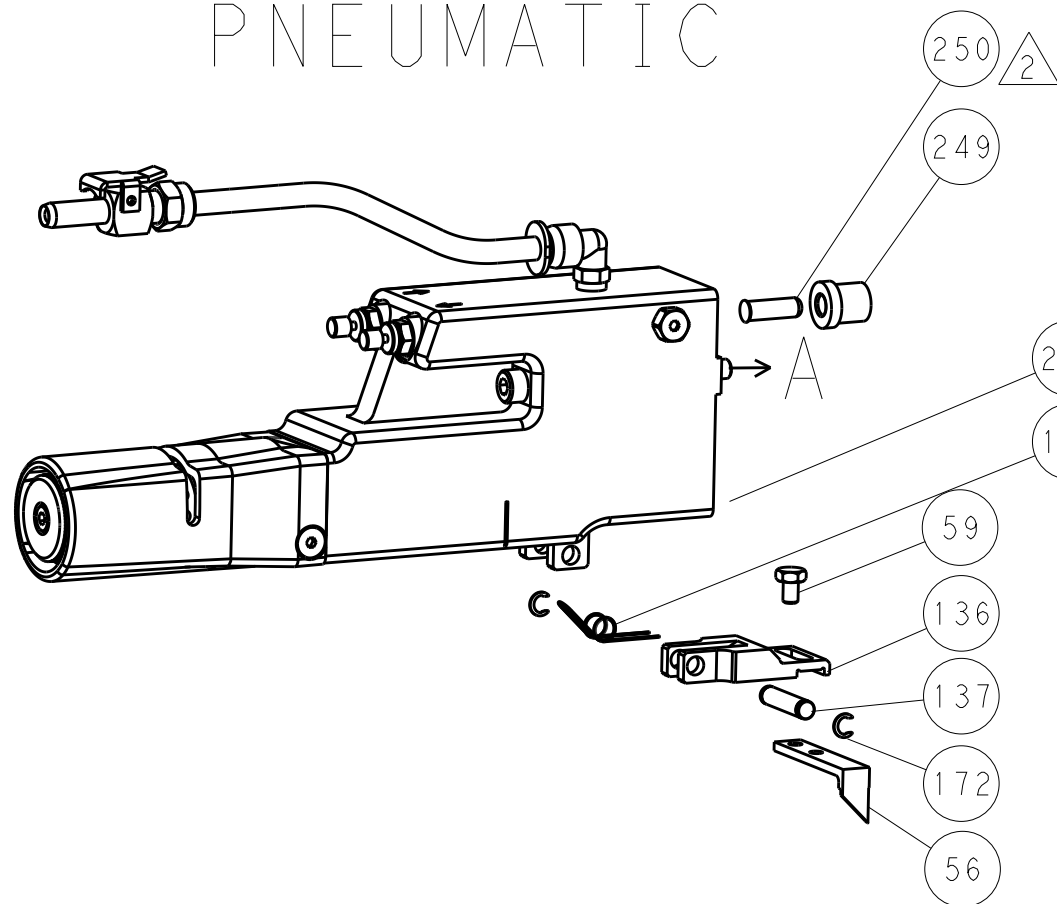
REV: 01

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

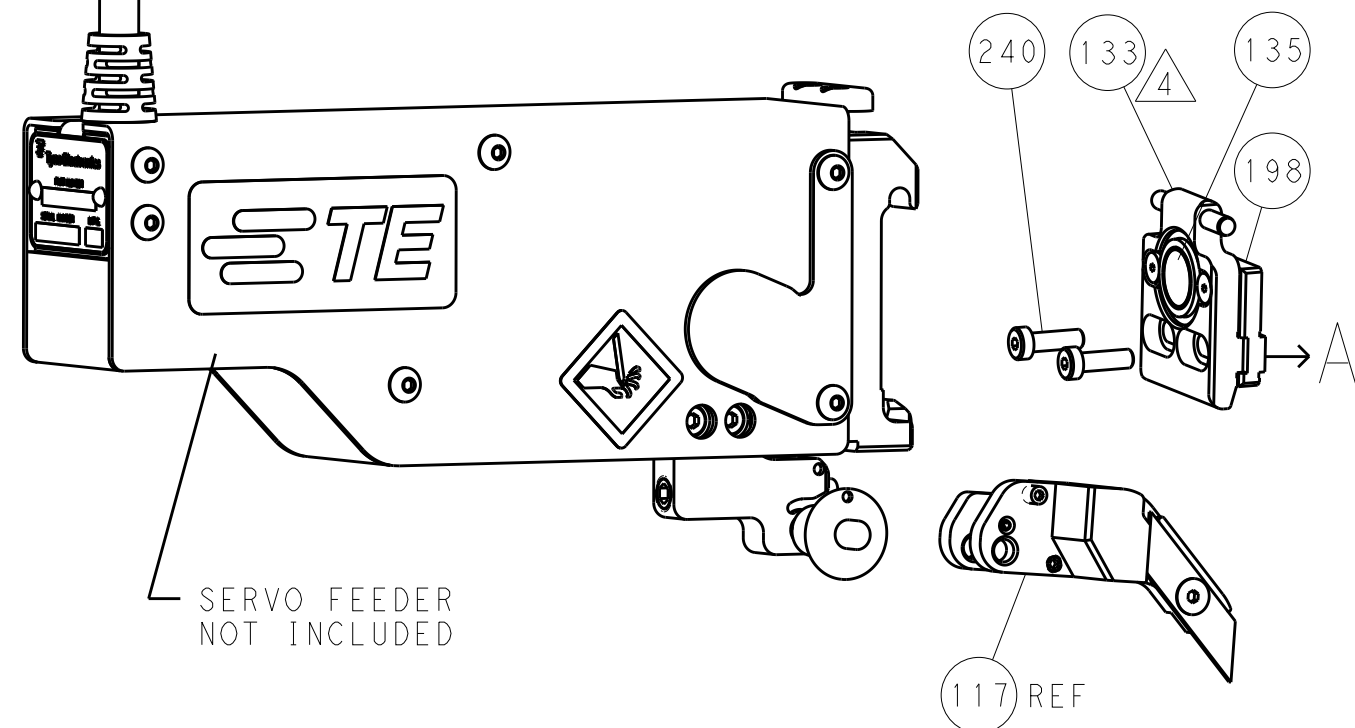
LOC	DIST	REVISIONS					
		P	LTR	DESCRIPTION	DATE	DWN	APVD
A	66	-	-	SEE SHEET 1	-	-	-

FEED TYPE

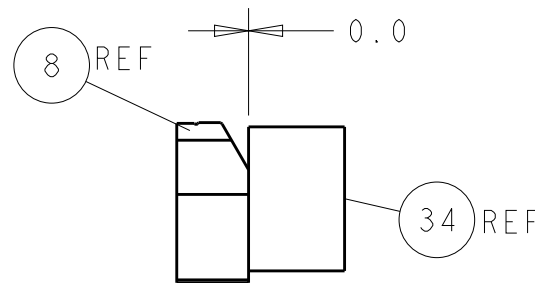
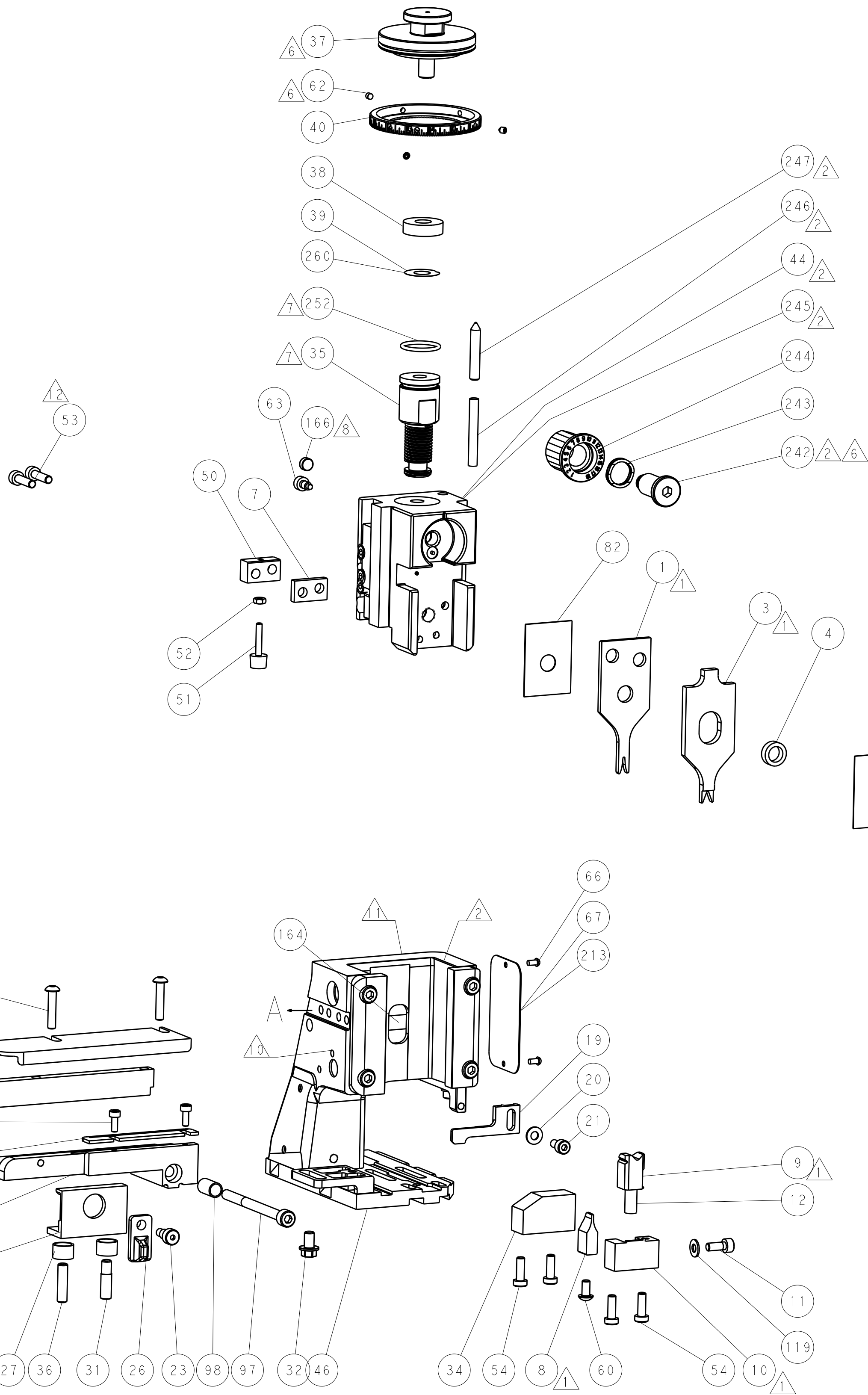
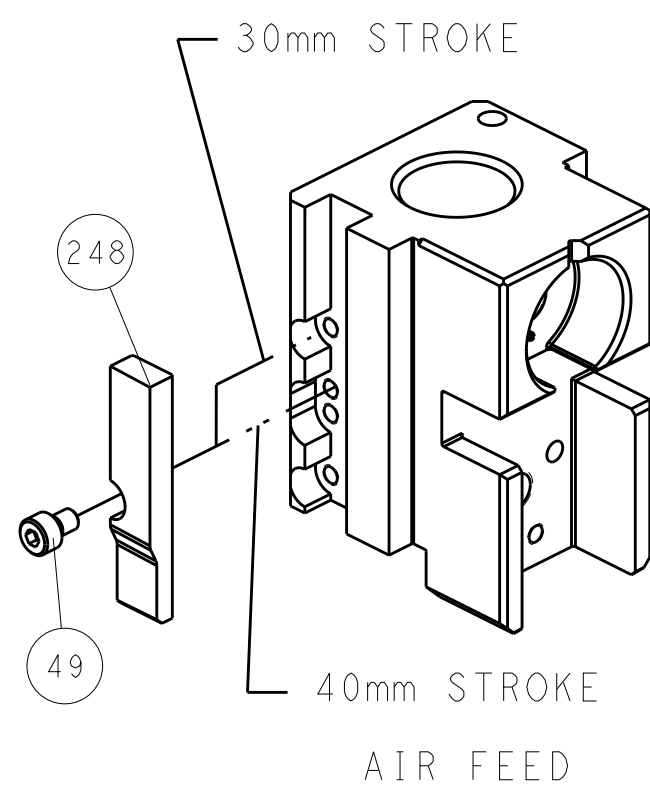
PNEUMATIC



SERVO LATCH PLATE

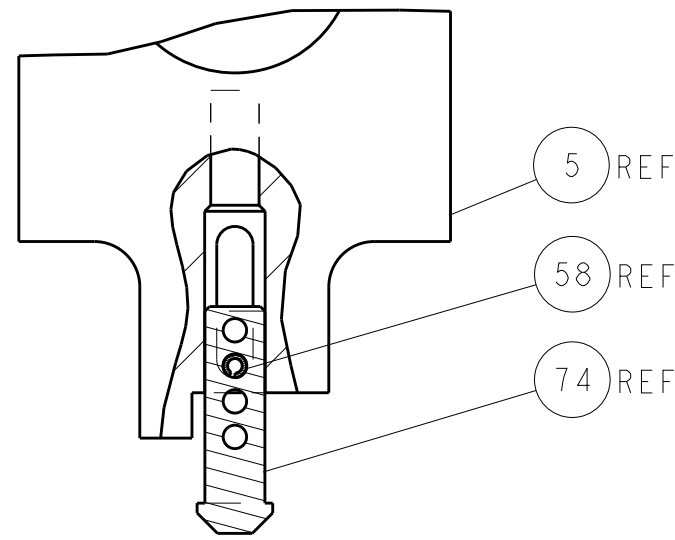


CAM POSITION



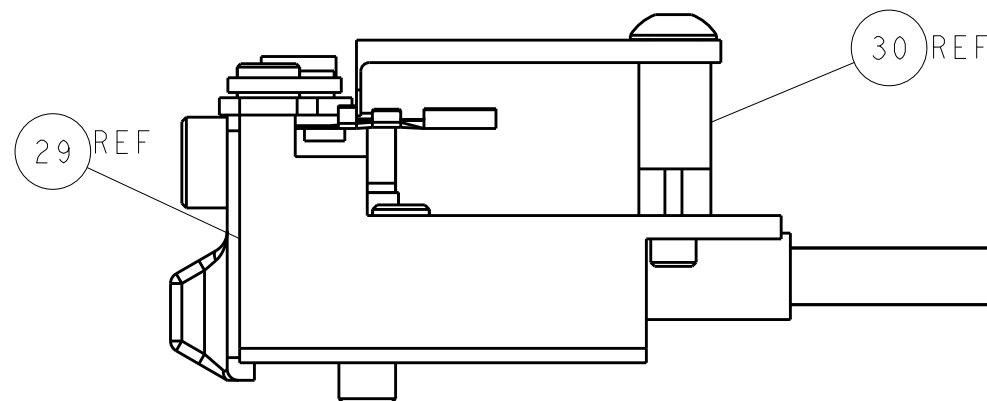
TERMINAL SUPPORT LOCATION

ITEM 58 LOCATED AS SHOWN



INSULATION HOLDER SETUP LOCATION

ITEM 30 LOCATED AT FRONT HOLES



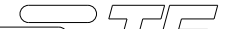
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

1ST PUBLISHED BY: COMPANY/ISSUED FOR: THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE/REVISION WITHOUT NOTICE. ANY CHANGES/REVISIONS SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN: BOB HIGMAN 09MAY2013 CHK: G. BAILEY 09MAY2013 APVD: M. CLIFFORD 09MAY2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC	NAME: Ocean Side Feed Applicator
MATERIAL: -		WEIGHT: -	SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151523	RESTRICTED TO: -
Customer Accessible Production Drawing		SCALE: 1:2	SHEET: 2 OF 4	REV: D1

	-	SEE SHEET 1	-	-	-

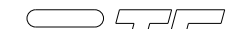
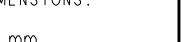
	-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
	-	-	-	1	2063440-1	AIR FEED MODULE	238
	-	-	1	-	2119740-2	TAG, IDENTIFICATION	213
	-	-	1	-	1901094-3	SPACER, FEEDER	198
	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
8	-	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
	-	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
	-	-	-	1	240638-1	SPRING, FEED FINGER	163
7	-	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152
	-	-	-	1	2119641-2	FEED CAM, AIR FEED	151
	-	1	1	1	2119798-2	DETENT PIN	145
	-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
	-	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
	-	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	14
	-	1	1	1	2119650-1	Bolt, ASIAN STYLE, SIDE FEED	140
7	-	1	1	1	2119092-2	RAM, ADJUSTMENT	139
	-	-	-	1	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
	-	-	-	1	2119799-1	HOLDER, FEED FINGER, AF	136
	-	-	REF	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
	-	-	1	-	1633743-1	SERVO FEED LATCH ASM	133
	-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
	-	1	1	1	1-22281-8	SPRING, COMPRESSION	98
	-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65	97
	-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	96
	-	1	1	1	1-690438-0	FRONT STRIP GUIDE	95
	-	1	1	1	455888-4	SPACER, CRIMPER	82
	-	1	1	1	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	1	1803205-1	INSULATION HOLDER	74
	-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	-	1	2119740-1	TAG, IDENTIFICATION	67
	-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
6	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0	62
	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	-	-	1	1338685-1	PAWL, FEED	56
7	-	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
	-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
	-	1	1	1	811242-5	BUMPER, HOLD DOWN	51
	-	1	1	1	690753-2	SPACER, TONKER	50
	-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
	-	1	1	1	2119644-1	RAM WASHER, PRECISION	38
	-	1	1	1	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	36
	-	1	1	1	1752356-6	SUPPORT, TERMINAL	34
	-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
	-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG	32
	-	1	1	1	2-1722335-1	THREAD BOLT GEWINDEBOLZEN	31
	-	1	1	1	1320908-2	SPACER, STRIP GUIDE	30
	-	1	1	1	1901086-1	PLATE, STRIP GUIDE	29
	-	1	1	1	455888-3	SPACER, CRIMPER	28
	-	2	2	2	22283-1	SPRING, COMPRESSION	27
	-	1	1	1	356835-1	LEVER, DRAG RELEASE	26
	-	1	1	1	1803142-1	DRAG, TERMINAL	25
	-	1	1	1	1320928-2	STRIP GUIDE	24
	-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
	-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
	-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
	-	1	1	1	2119533-1	STRIPPER, SIDE FEED	19

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TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH -		NAME Ocean Side Feed Applicator -		SIZE CAGE CODE DRAWING NO RESTRICTED TO A1 00779 C-2151523 -	
PRODUCT SPEC - APPLICATION SPEC - WEIGHT -		Customer Accessible Production Drawing SCALE 1:2 SHEET 3 OF 4 REV D1			

```
*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	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-77	-27	-25	-22	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)

THIS DRAWING IS A COMPUTER GENERATED DOCUMENT FOR TFCO ELECTRONICS CORPORATION NO OTHER DIMENSIONS OR TOLERANCES ARE TO BE USED UNLESS SPECIFIED OTHERWISE. DIMENSIONS AND TOLERANCES ARE SUBJECT TO THE LATEST REVISION.		PWN BOB HIGMAN CHK G BAILEY	09MAY2013 09MAY2013	 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	NAME	Ocean Side Feed Applicator		
mm		APVD M CLIFFORD			
	0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ±°	PRODUCT SPEC -			
		APPLICATION SPEC -			
MATERIAL	FINISH	WEIGHT	SIZE	CAGE CODE	DRAWING NO
-	-	-	A	00779	C=2151523
					RESTRICTED TO -
Customer Accessible Production Drawing			SCALE	SHEET	REV(D)
			1:2	4 OF 4	