

8

7

6

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4

3

2

1

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20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

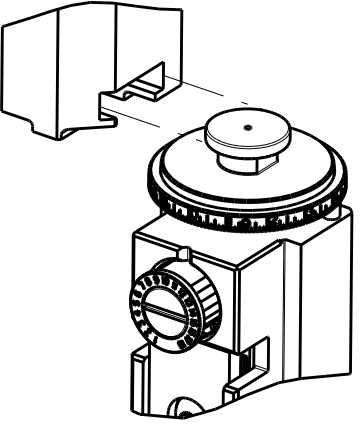
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151613-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED
SERVO LATCH PLATE
SMART APPLICATOR

2119950-1
2119951-1
2161326-1

1338685-1
-
-

5-18022-5
8-2151613-5
8-2151613-4

2119641-1
1901094-3
-

2119799-1
-
-

2063440-1
2168400-6 (QUANTITY 2)
-

2151613-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED
SERVO LATCH PLATE
SMART APPLICATOR

2119949-1
2119951-1
2161326-1

1338685-1
-
-

5-18022-5
8-2151613-5
8-2151613-4

2119653-1
1901094-3
-

-
-
-

2168400-6 (QUANTITY 2)
-

2151613-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

MECHANICAL FEED
PNEUMATIC FEED

2119949-1
2119950-1

1338685-1
1338685-1

5-18022-5
5-18022-5

2119653-1
2119641-1

-
2119799-1

-
2063440-1

2151613-6

A

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹²

-
-

-
-

-
-

-
-

-
-

2151613-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2151613-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 1.91 mm [.075] F

INSUL 2.79 mm [.110] OV

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: KOSTAL TERMINAL KOSTAL CRIMP SPECIFICATION

TERMINAL NAME: KOSTAL SLK 2.8 PIN/RECEPTACAL

WIRE STRIP LENGTH 4.00-4.60 mm [.157-.181 IN] INSULATION DIAMETER RANGE Ø1.40-2.00 mm [.055-.079 IN]

TERMINAL APPLICATION SPECIFICATION KOSTAL SPECIFICATION

TERMINALS APPLIED

TE TERMINAL KOSTAL TERMINAL TE TERMINAL KOSTAL TERMINAL

1572790-1 10124499090 1572789-1 22140472970

1572089-1 10140499090 1572789-2 22124472970

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING

0.75mm2 1.32+/-0.03 [.052+/- .001] 4.4

0.50mm2 1.20+/-0.03 [.047+/- .001] 5.6

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: 8-2151613-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151613-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151613-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151613-6

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

6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.

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

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

9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12 WHEN ASSEMBLING -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 CUT TO LENGTH AT ASSEMBLY.

AM 4805 REV 31MAR2000

*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	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
-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-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

DESCRIPTION

DATE

DWN

APVD

18023-1

SCR, SKT HD CAP M3 X 5.0

241

2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

2119580-1

MECHANICAL FEED ASSEMBLY

239

2063440-1

AIR FEED MODULE

238

2119740-2

TAG, IDENTIFICATION

213

1901094-3

SPACER, FEEDER

198

21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

994970-2

COUNTER, MAGNETIC

164

240638-1

SPRING, FEED FINGER

163

3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

2119799-1

HOLDER, FEED FINGER, AF

136

SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

1633743-1

SERVO FEED LATCH ASM

133

1-22281-8

SPRING, COMPRESSION

121

1-18028-2

WASHER, FLAT, REG M4

119

2119944-1

FEED FINGER ASSEMBLY, SF

117

2168083-6

SCR, SKT HD CAP, RoHS, M5 X 65

93

455888-5

SPACER, CRIMPER

82

2119956-1

DOCUMENTATION PACKAGE

71

2168083-1

SCR, SKT HD CAP, RoHS, M3 X 8.0

69

2-690438-2

FRONT STRIP GUIDE

68

2119740-1

TAG, IDENTIFICATION

67

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

2119793-1

LIMITER, ADJUSTMENT BOLT

63

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

2-18032-5

SCR, SET, FLT POINT M5 X 20.0

61

2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

1338685-1

PAWL, FEED

56

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

2168083-8

SCR, SKT HD CAP, RoHS, M4 X 16

53

5018030-1

NUT, HEX, REG, RoHS, M3

52

811242-5

BUMPER, HOLD DOWN

51

690753-2

SPACER, TONKER

50

18023-9

SCR, SKT HD CAP M4 X 6.0

49

2119652-1

FEED CAM, PRE FEED

48

2119653-1

FEED CAM, POST FEED

47

2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

2119370-1

RAM, AMP STYLE, SIDE FEED

44

2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

2119957-1

APPLICATOR SHIM PACK

39

2119644-1

RAM WASHER, PRECISION

38

2119085-1

FA HEAD, ATLANTIC STYLE

37

2119092-1

BOLT, ADJUSTMENT

35

1752356-5

SUPPORT, TERMINAL

34

2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

1-1320908-0

SPACER, STRIP GUIDE

30

1901086-1

PLATE, STRIP GUIDE

29

1-455888-0

SPACER, CRIMPER

28

22281-8

SPRING, COMPRESSION

27

356835-1

LEVER, DRAG RELEASE

26

240792-1

DRAG, TERMINAL

25

1320928-6

STRIP GUIDE

24

980371-4

SCR, SKT HD SHLDR 5.0 DIA X 6.0

23

2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

1-18028-2

WASHER, FLAT, REG M4

20

2119533-1

STRIPPER, SIDE FEED

19

2119806-1

INSERT, SHEAR

13

3-22280-3

SPRING, COMPRESSION

12

1-356885-4

STOP, SHEAR

11

2119805-1

SHEAR HOLDER, FRONT

10

454276-5

FLOATING SHEAR, FRONT

9

1633138-4

ANVIL, COMBINATION

8

4-240641-1

SPACER

7

-

-

6

2119757-4

DEPRESSOR, SHEAR

5

1-238011-7

BLOCK, CRIMPER SPACER

4

1-2119785-0

CRIMPER, INSULATION OVERLAP PREMIUM

3

455888-6

SPACER, CRIMPER

2

1673600-6

CRIMPER, WIRE

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

111 IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS OF THIS DRAWING.

CHG
S.XI
APVD
S.XI

15FEB2012
15FEB2012
15FEB2012

DIMENSIONS:
mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±.5
1 PLC ±0.13
2 PLC ±0.13
3 PLC ±0.13
4 PLC ±0.0001
ANGLES ±.5

MATERIAL
FINISH

DWN
R. HUANG
S.XI
APVD
S.XI

15FEB2012
15FEB2012
15FEB2012

TE Connectivity
Harrisburg, PA 17105-3608

NAME
Ocean Side Feed
Applicator

SIZE
A1

CAGE CODE
00779

DRAWING NO
©=2151613

RESTRICTED TO
-

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

SCALE
1:2

SHEET
1

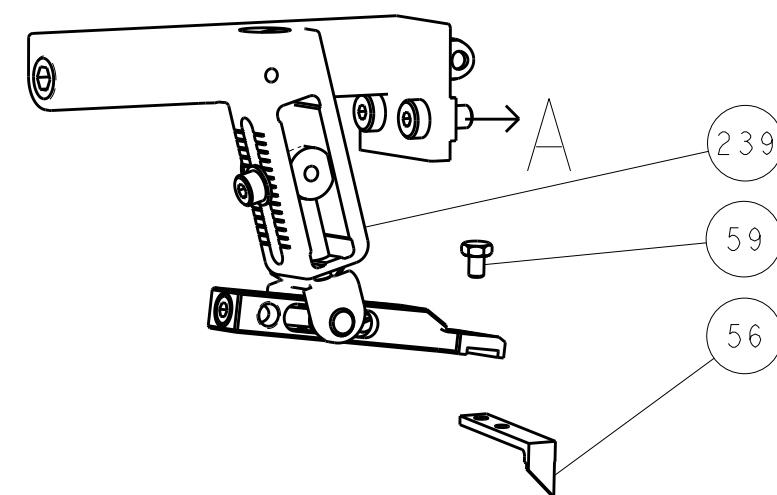
OF
4

REV
A1

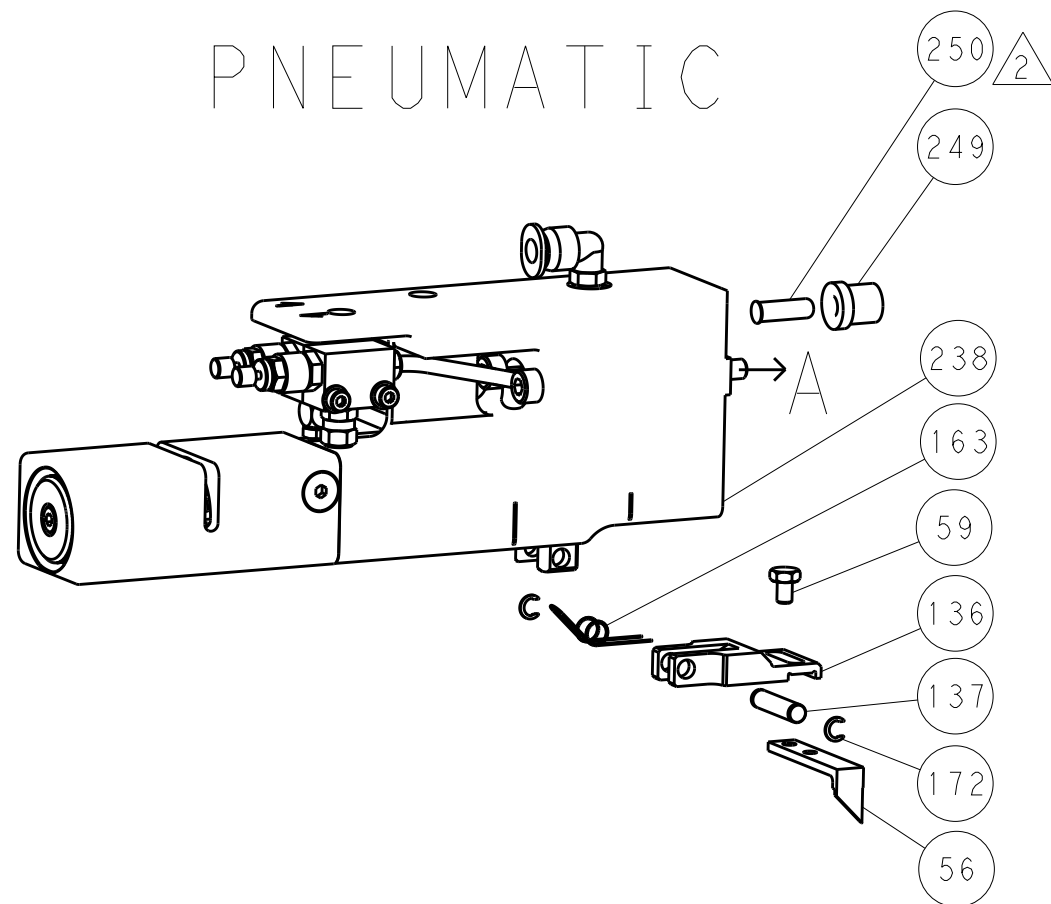
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

FEED TYPE MECHANICAL



PNEUMATIC



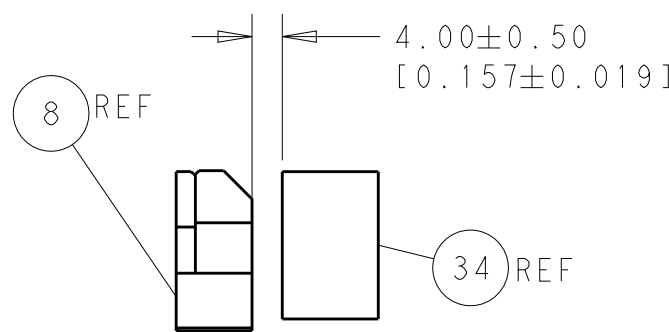
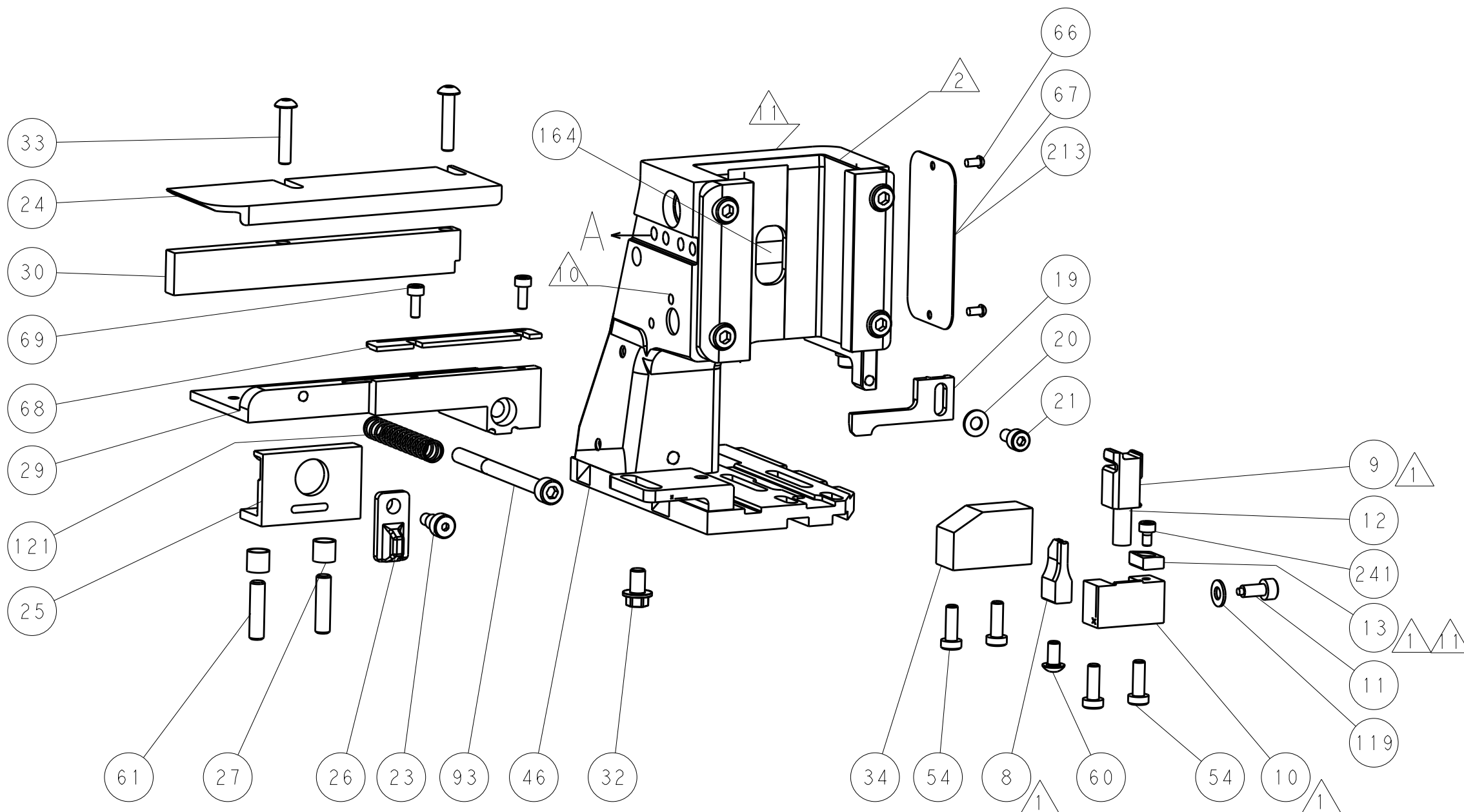
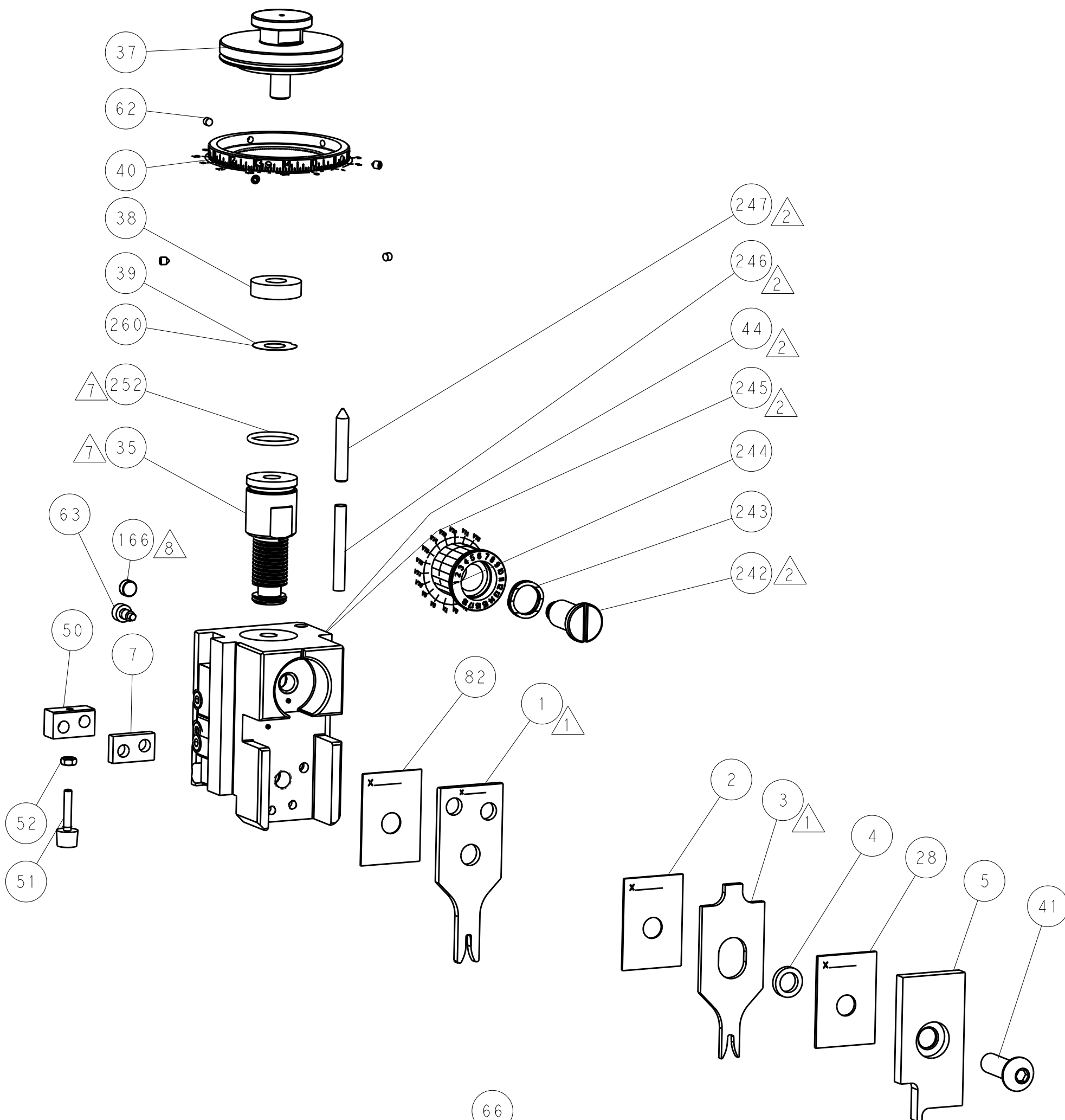
SERVO LATCH PLATE



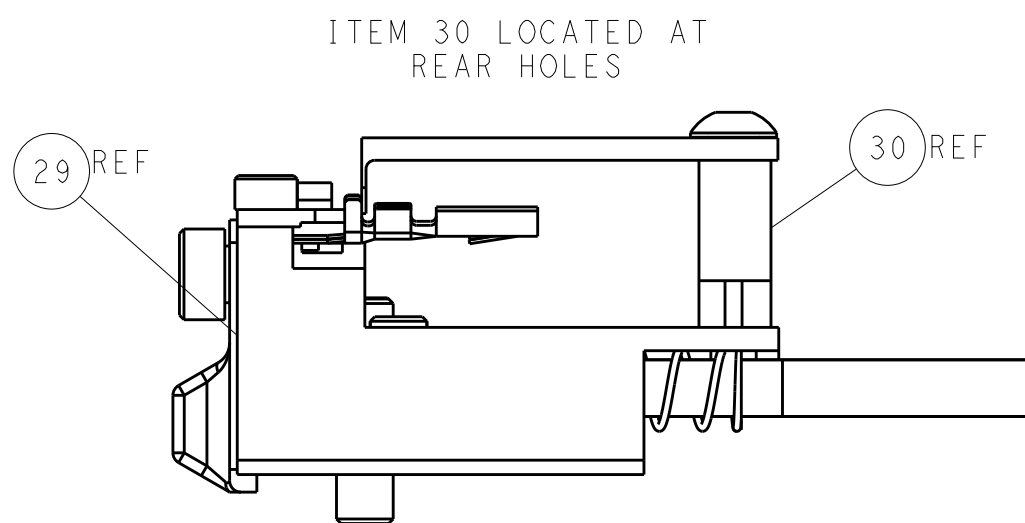
CAM POSITIONS



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



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

1ST PUBLISHED BY: COMPANY LOGO FOR THE COMPANY'S CORPORATION IT IS SUBJECT TO CHANGE AND THE COMPANY'S CORPORATION SHOULD BE CONTACTED FOR THE LATEST POSITION.		DWN K. HUANG 15FEB2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK S. XI 15FEB2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.13 4 PLC ±0.0001 ANGLES ±.5		APVD S. XI 15FEB2012	SIZE A1	
MATERIAL -		FINISH -	CAGE CODE 00779	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE 1:2	SHEET 2 OF 4	
			REV A1	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

D

C

B

A

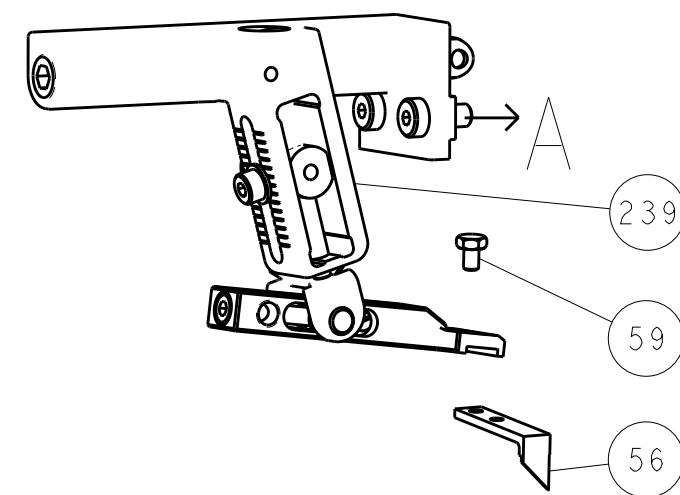
D

C

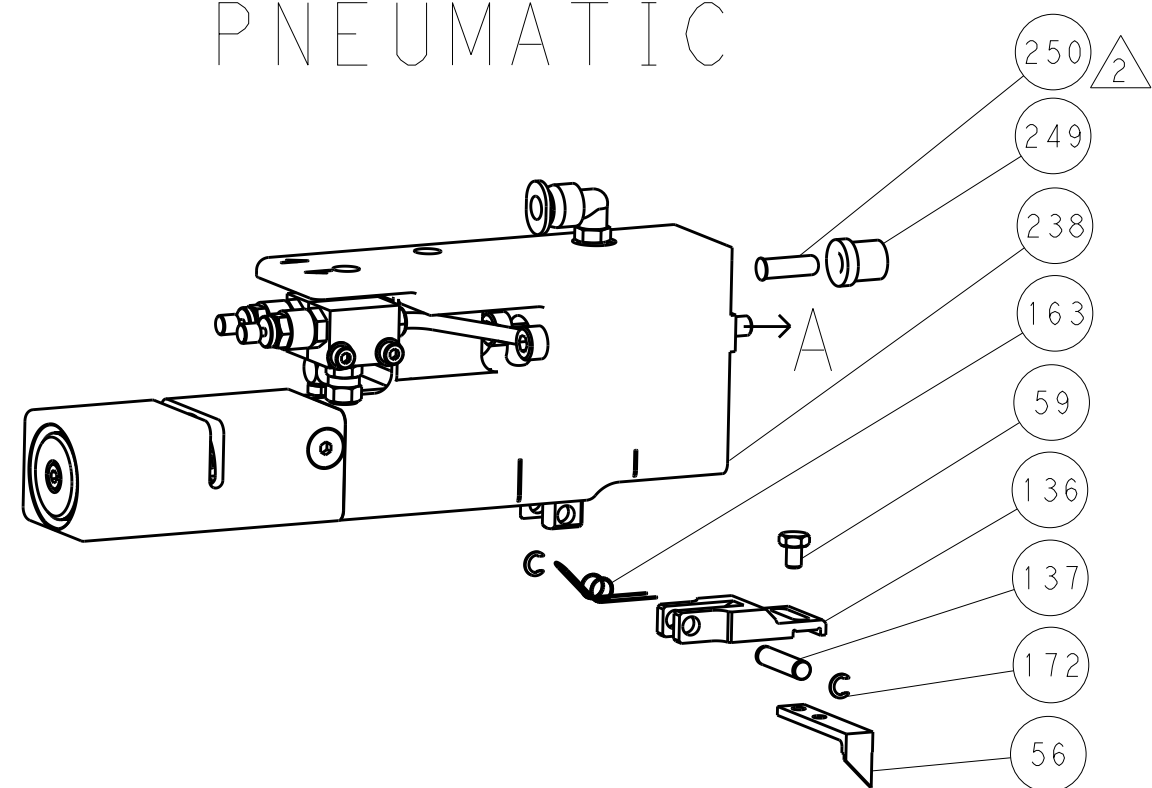
B

A

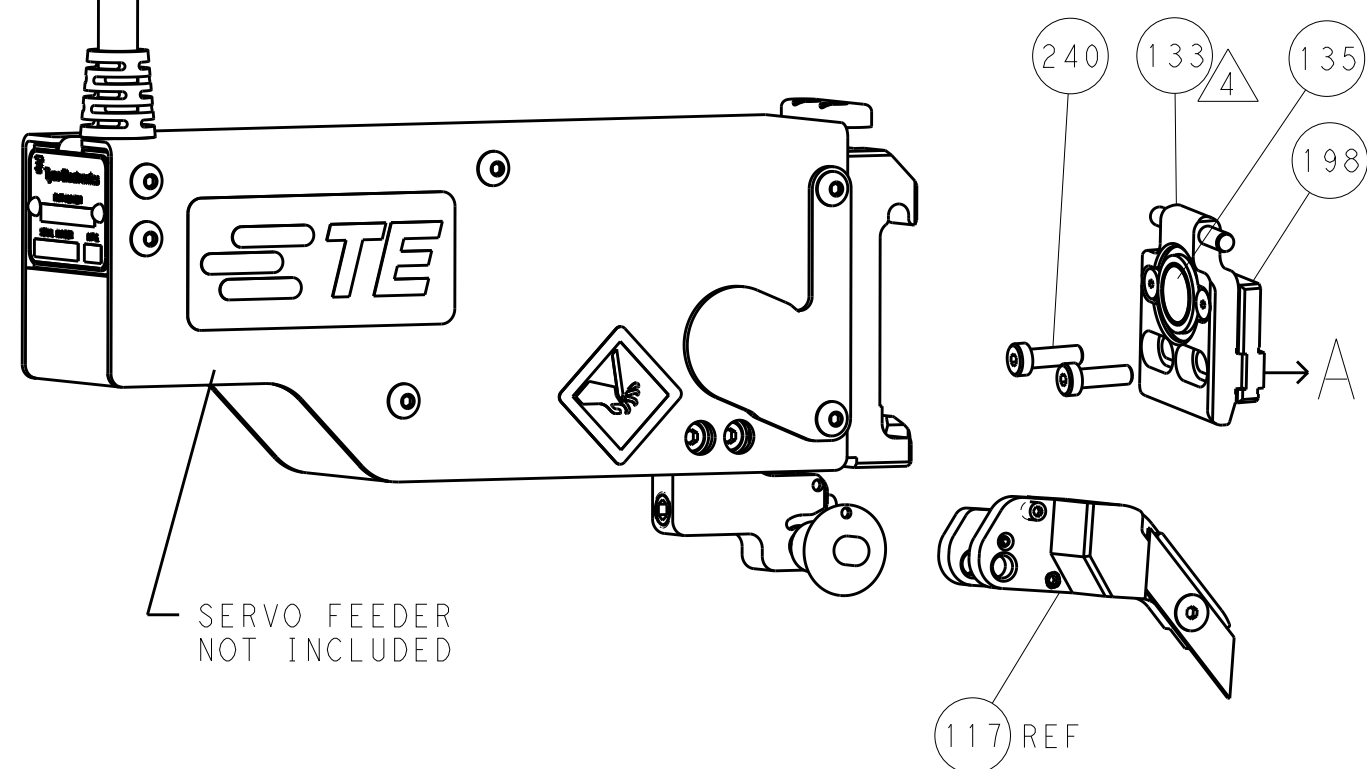
FEED TYPE MECHANICAL



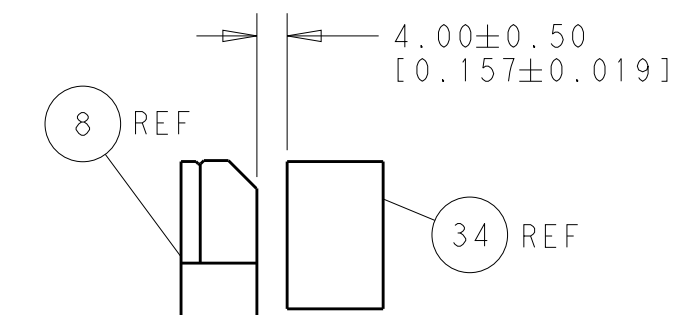
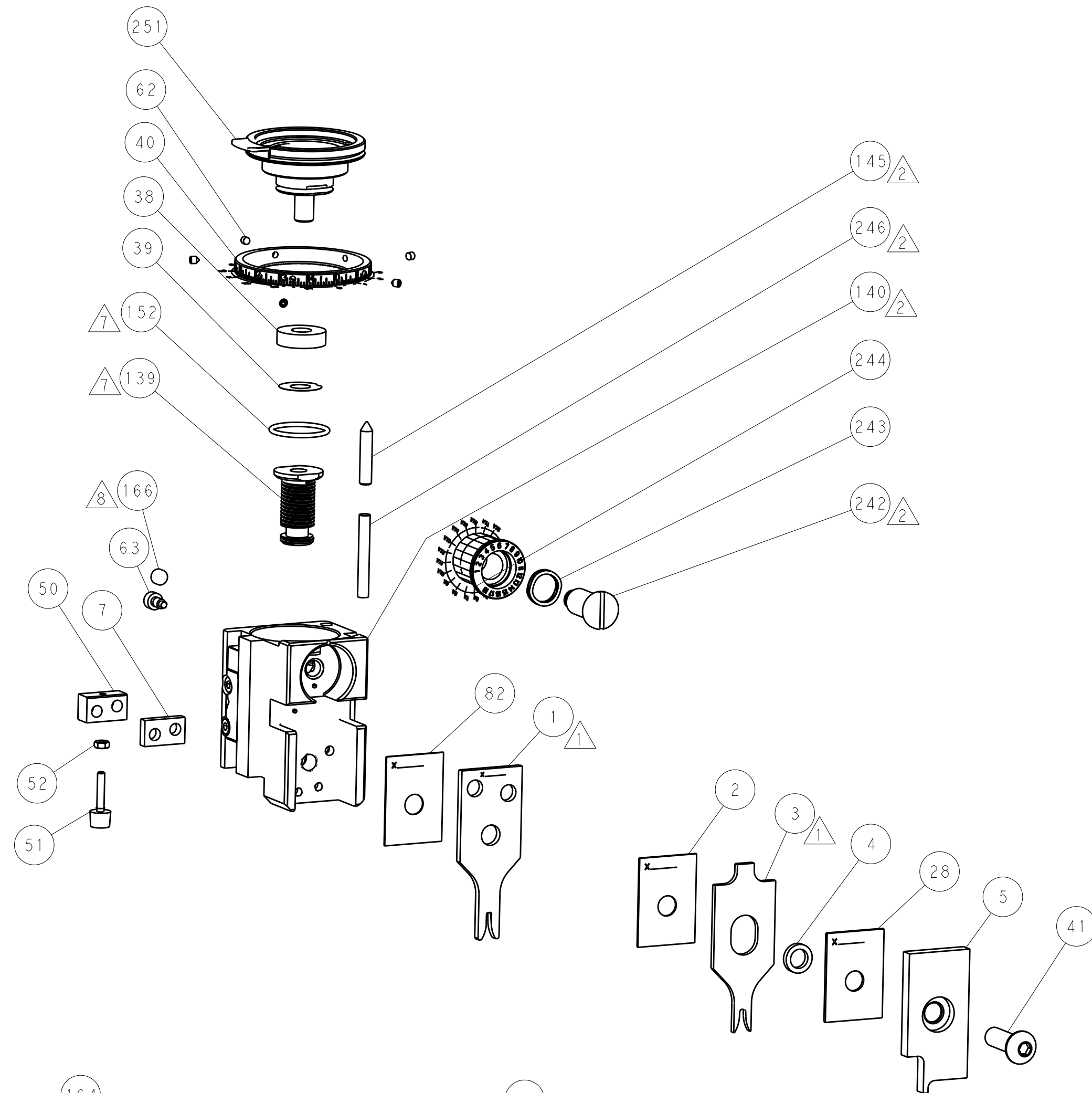
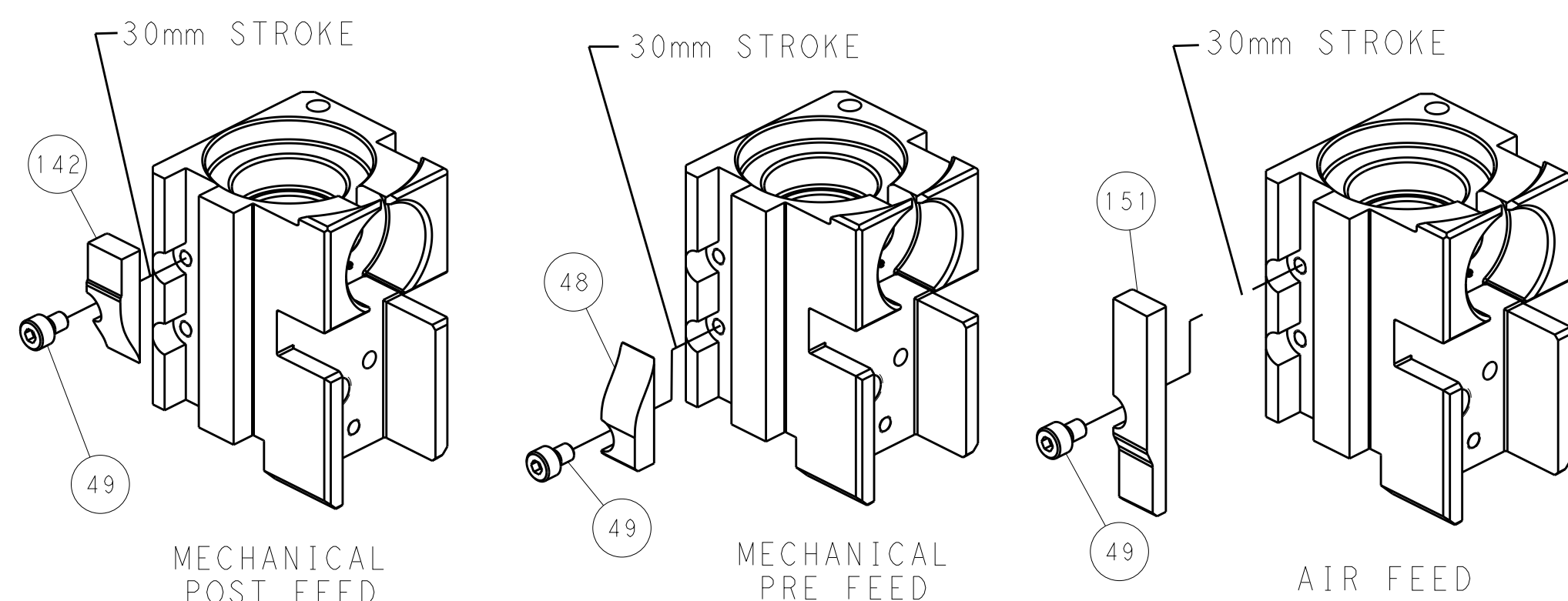
PNEUMATIC



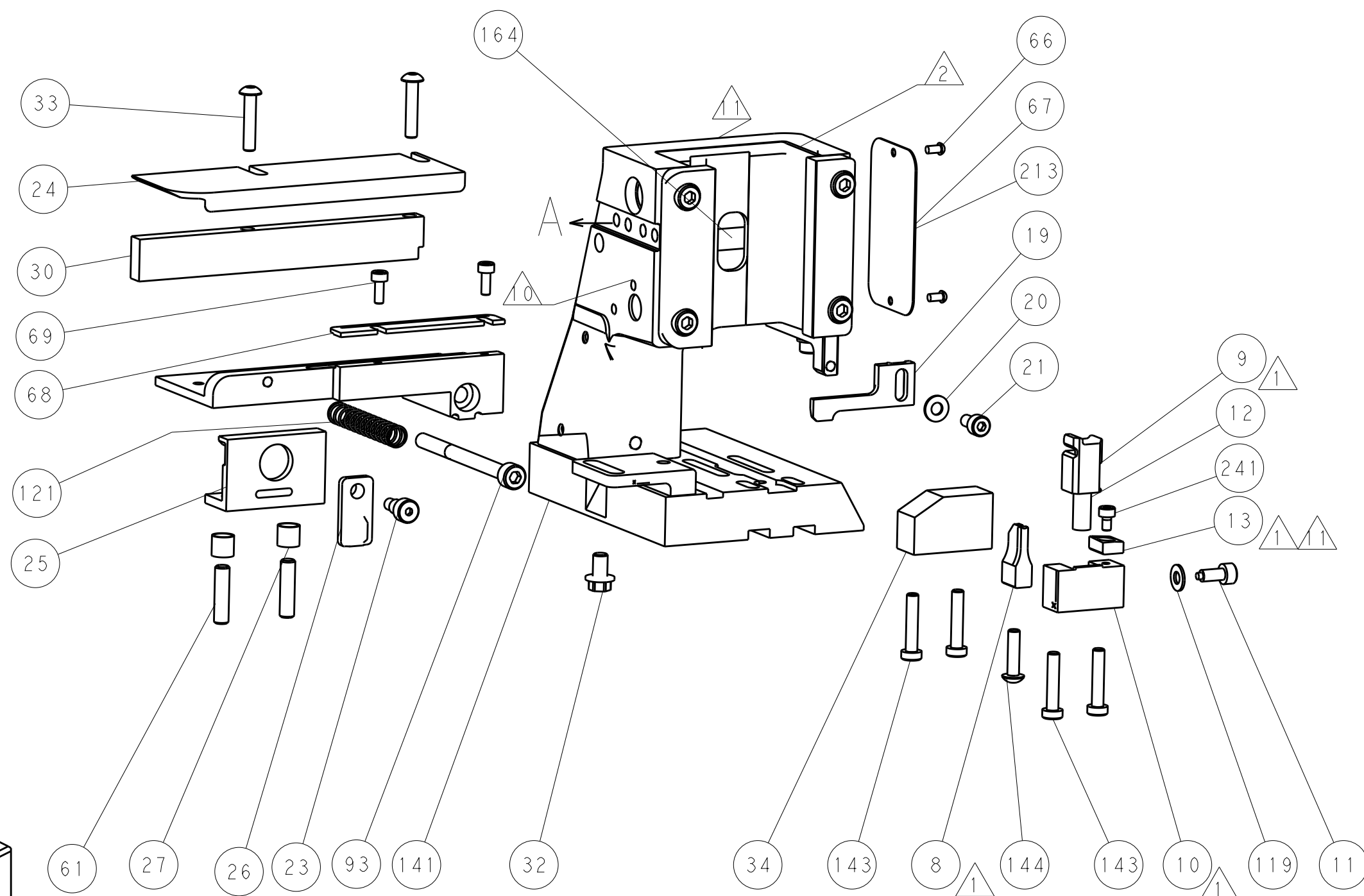
SERVO LATCH PLATE



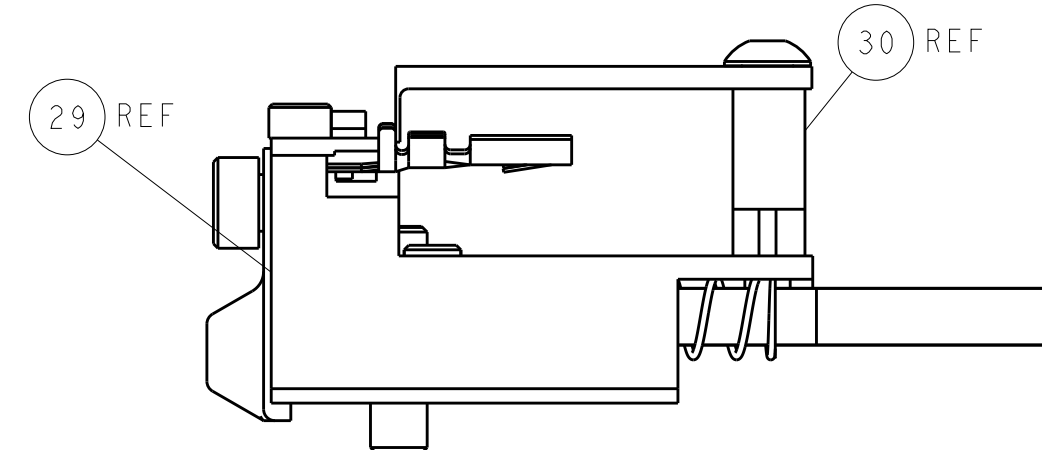
CAM POSITIONS



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT
REAR HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		CHK		APVD		NAME	
mm		0 PLC ±.5		K. HUANG		S. XI		S. XI		Ocean Side Feed	
1 PLC ±0.13		2 PLC ±0.13		15FEB2012		15FEB2012		15FEB2012		Applicator	
3 PLC ±0.013		4 PLC ±0.0001		PRODUCT SPEC		APPLICATION SPEC		SIZE		CAGE CODE	
MATERIAL		FINISH		WEIGHT		CUSTOMER ACCESSIBLE		PRODUCTION DRAWING		SCALE	
-		-		-		-		-		1:2	
-		-		-		-		-		SHEET 4 OF 4	
-		-		-		-		-		REV A1	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION