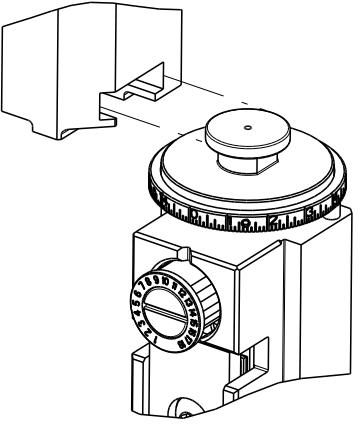
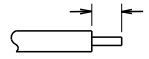


8	7	6	5	4	3	I
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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART	
	2151791-1	D	FINE CRIMP HEIGHT ADJUST	MECHANICAL	CONVERT TO	PART NUMBERS REQUIRED
					PNEUMATIC FEED	2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1
					SERVO LATCH PLATE	2119951-1 - 8-2151791-5 1901094-3 - 2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1 - 8-2151791-4 - -
	2151791-2	D	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1 1338685-1 5-18022-5 2119653-1 - -
					SERVO LATCH PLATE	2119951-1 - 8-2151791-5 1901094-3 - 2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1 - 8-2151791-4 - -
2151791-5	D	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	4	MECHANICAL FEED	2119949-1 1338685-1 5-18022-5 2119653-1 - -
					PNEUMATIC FEED	2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1
2151791-6	D	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	4	-	- - - - -
					-	- - - - -
2151791-7	D	FINE CRIMP HEIGHT ADJUST	NONE		-	- - - - -
7-2151791-7	A	CRIMP TOOLING KIT	-		-	- - - - -

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.37 mm [.054]	F
INSUL	1.40 mm [.055]	F
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: JST TERMINAL		JST CRIMP SPECIFICATION
TERMINAL NAME: TERMINAL, INTERLOCK		
WIRE STRIP LENGTH 2.10-2.10 mm [.083-.083 IN]		INSULATION DIAMETER RANGE Ø1.00-1.50 mm [.039-.059 IN]
TERMINAL APPLICATION SPECIFICATION	HM-0003(CHM-1-070) Rev R6	-
TERMINALS APPLIED		
TE TERMINAL	JST TERMINAL	TE TERMINAL
286828-1	SPHD-001T-P0.5	

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
22 AWG		0.75+/-0.05 [.030+/- .002]		8.2
24 AWG		0.70+/-0.05 [.028+/- .002]		8.7
26 AWG		0.65+/-0.05 [.026+/- .002]		9.2



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: 8-2151791-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151791-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151791-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151791-6
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

*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.

2	-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
7	-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
	-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)

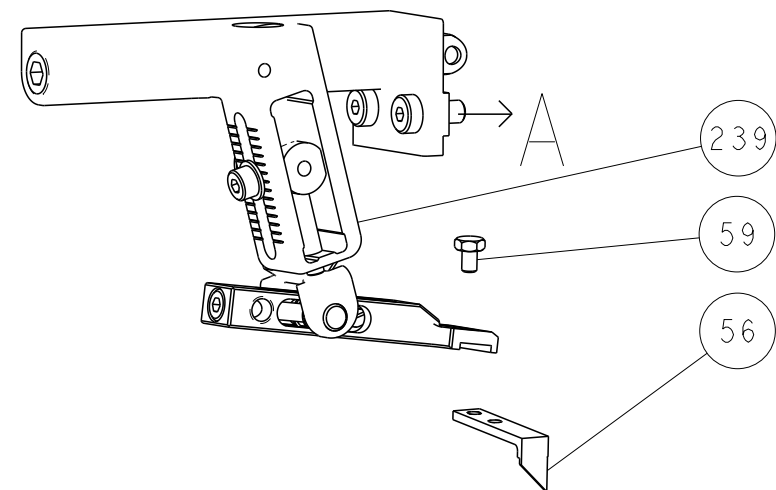
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISIONS			
			P	LTR	DESCRIPTION	DATE
				D	ECR-16-015375	31OCT2016
						MR
						CT

-	-	-	-	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	2119082-5	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
-	-	-	-	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	455888-9	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	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	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	-	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	1-2168083-4	SCR, SKT HD CAP, RoHS, M4 X 5	53
-	-	-	-	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	2-1752356-6	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	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-2	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	2-690518-4	HOLD DOWN, TERMINAL	18
-	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	1633861-1	SHEAR, FLOATING	9
1	1	1	1	1	1	2-1633927-5	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1-2119757-0	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1-238011-0	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	2-1633962-8	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	2
1	1	1	1	1	1	4-1633738-6	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

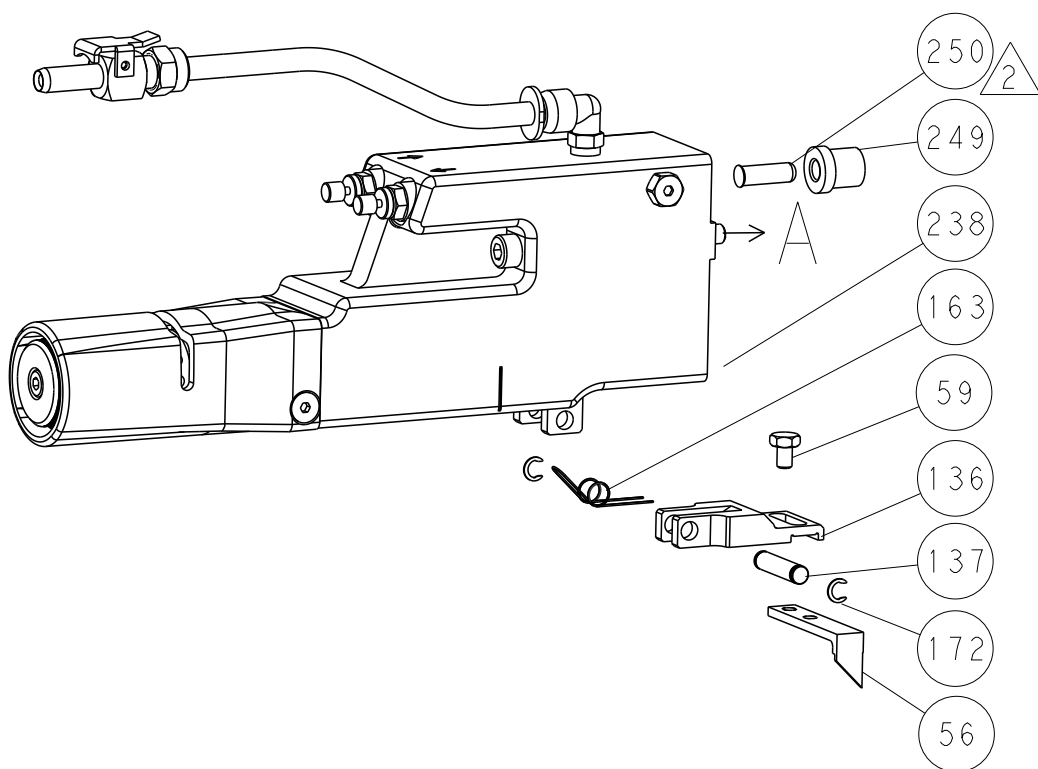
THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER'S ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST EDITION.		DWN L. ZHANG	12OCT2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK L. ZHANG	12OCT2012	NAME	
mm		APP'D S. XI	12OCT2012	Ocean Side Feed Applicator - SIZE CAGE CODE DRAWING NO A 00779 C=2151791 RESTRICTED TO - Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4 REV D	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC			
0 PLC ±		APPLICATION SPEC			
1 PLC ±					
2 PLC ±					
3 PLC ±					
4 PLC ±					
ANGLES					
FINISH					
MATERIAL		WEIGHT			
-		-			

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

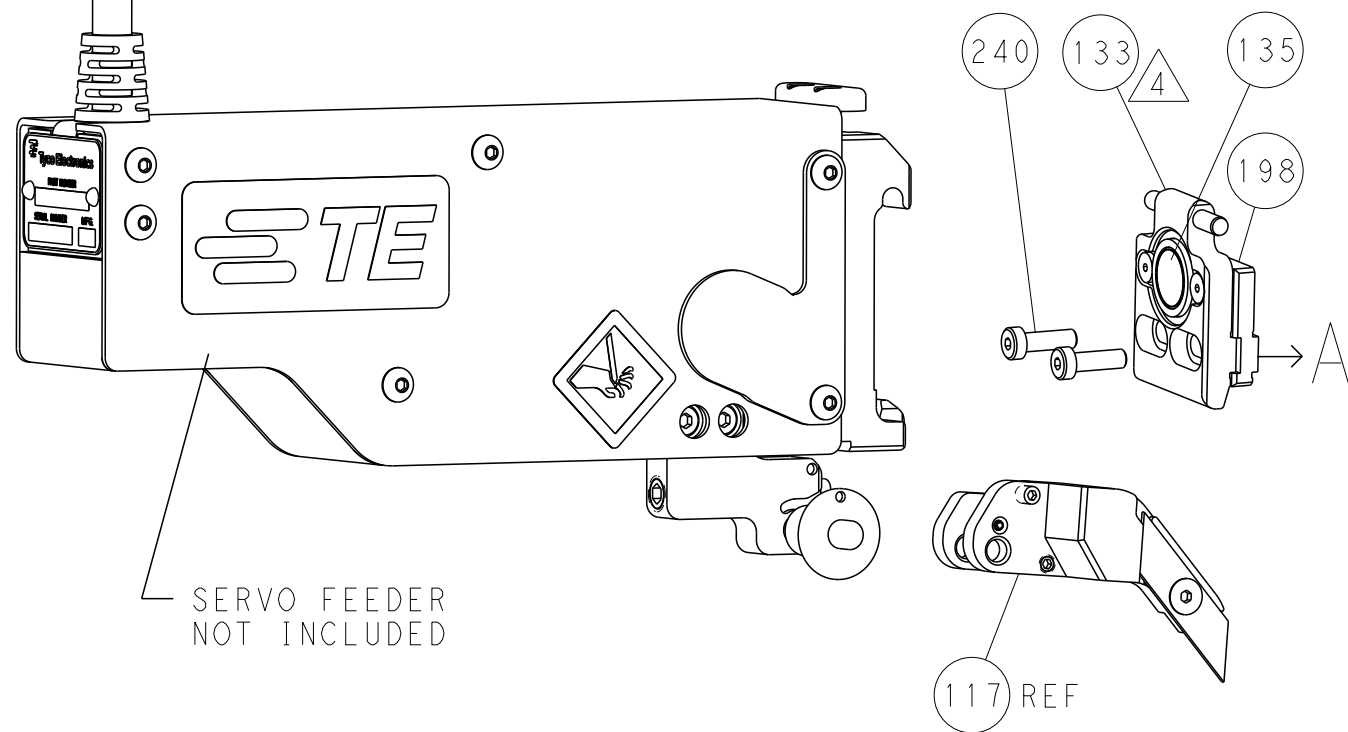
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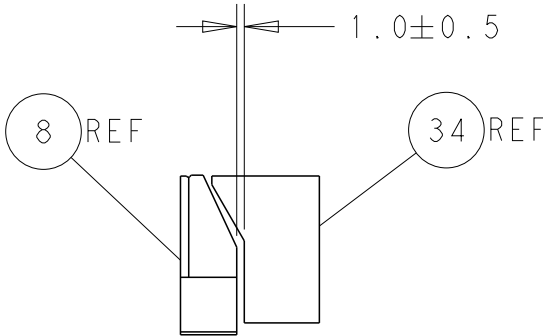
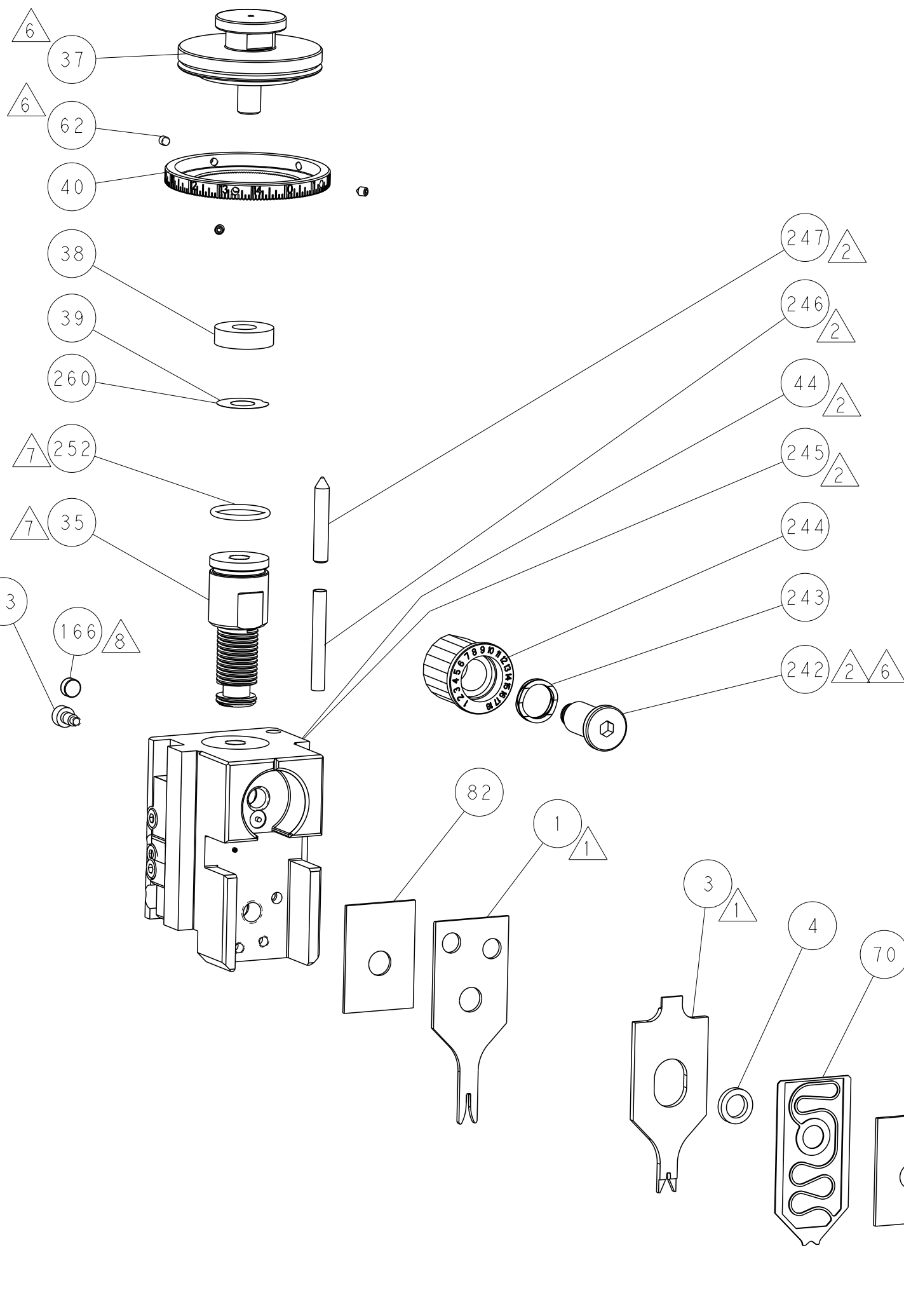
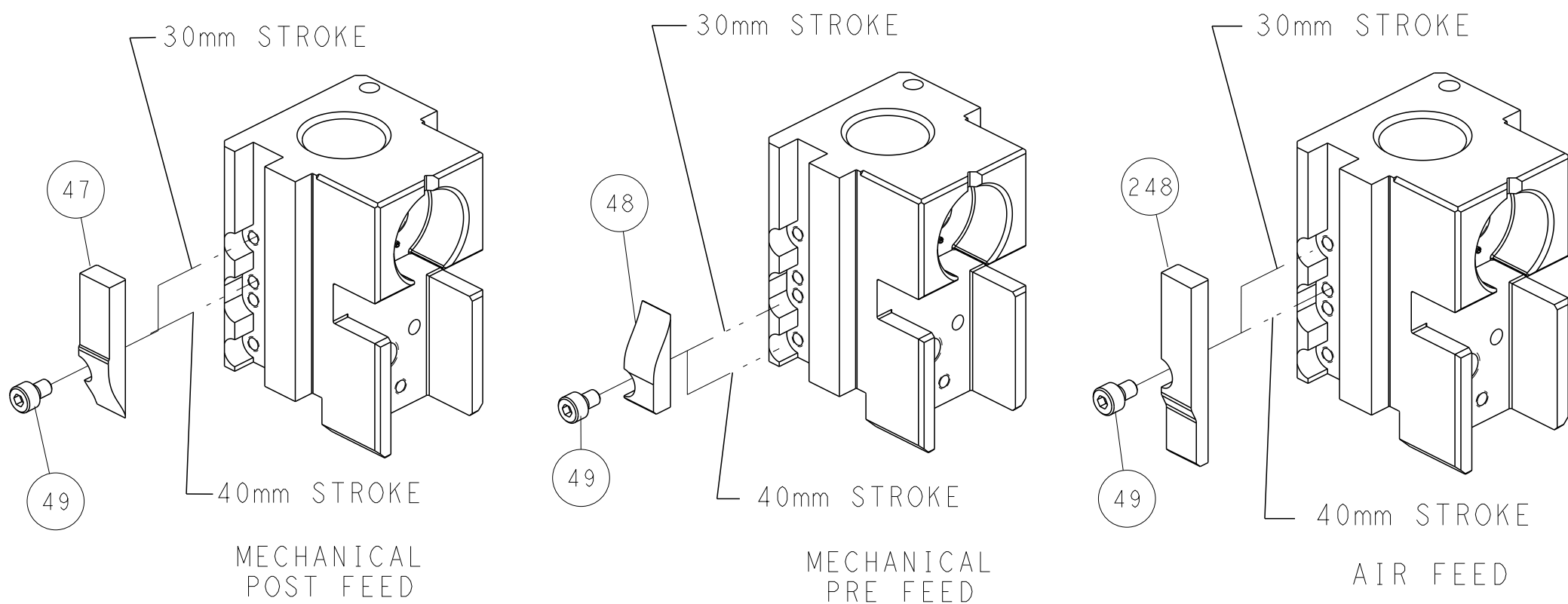
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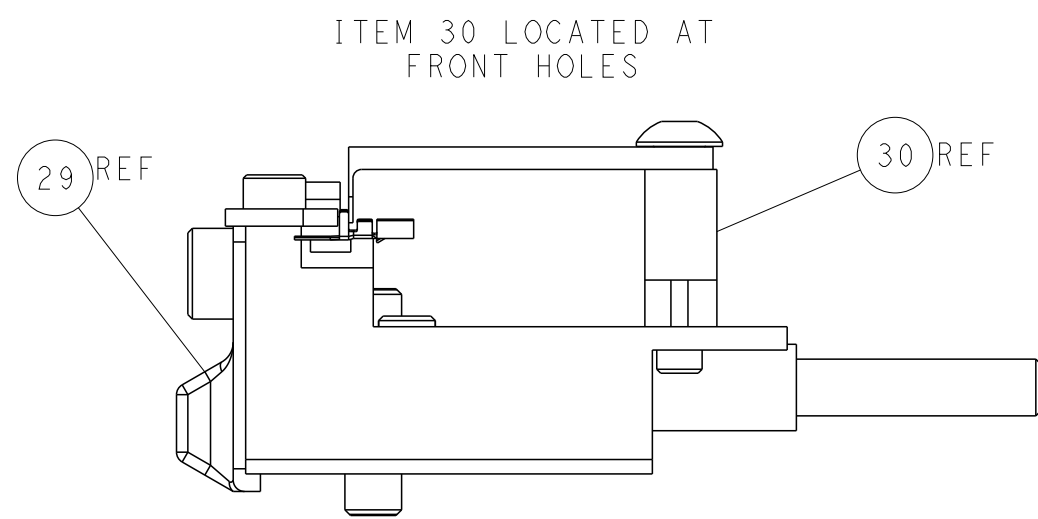
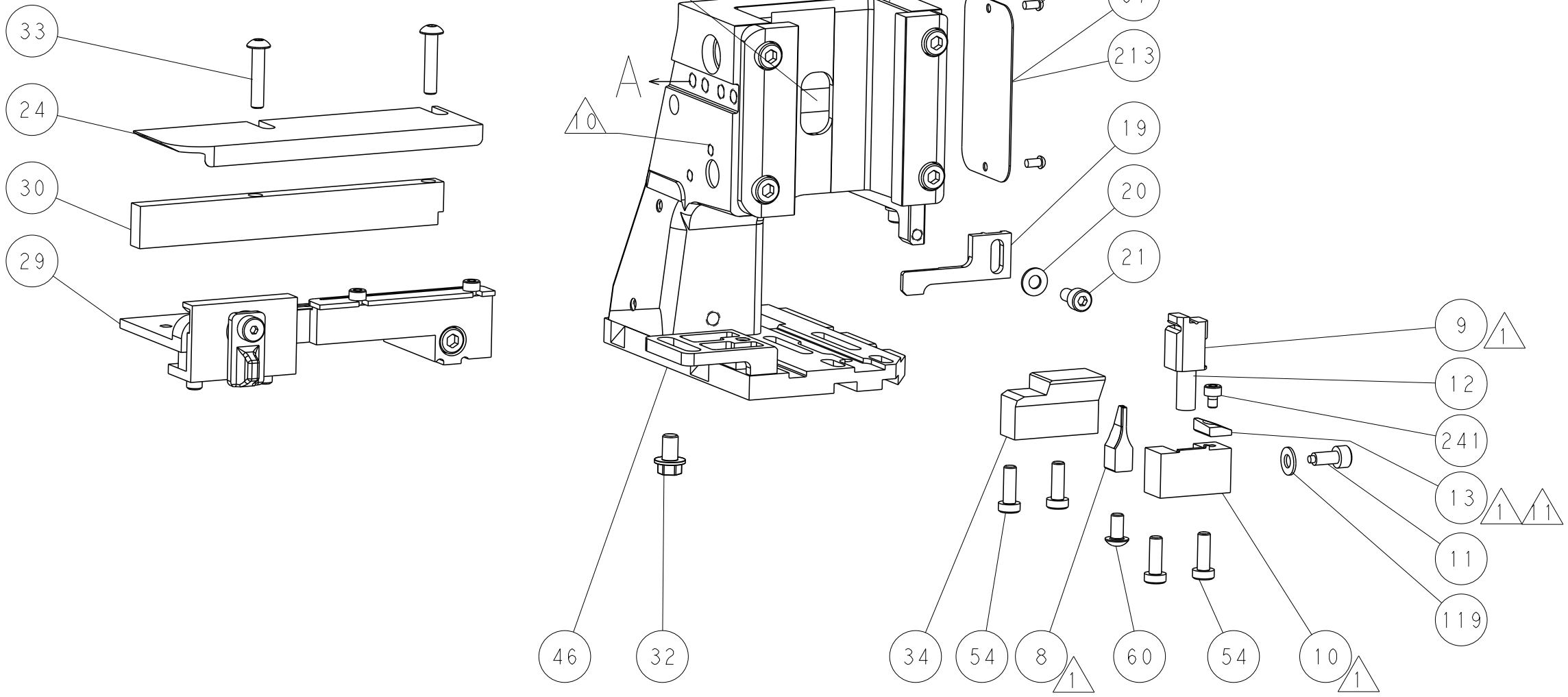
SERVO LATCH PLATE



CAM POSITIONS

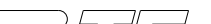


TERMINAL SUPPORT LOCATION



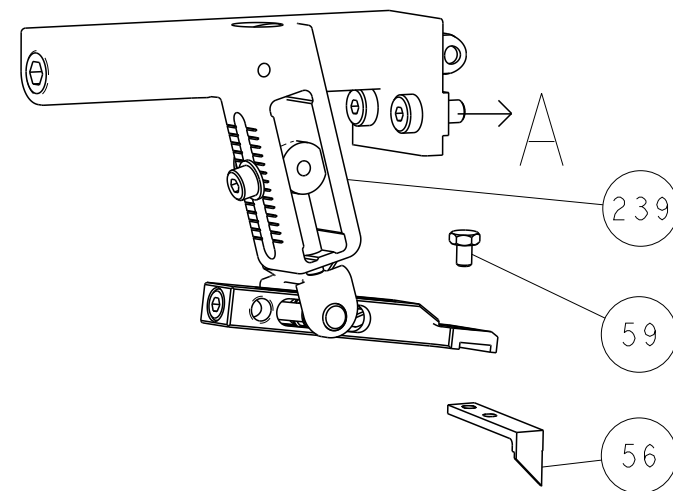
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

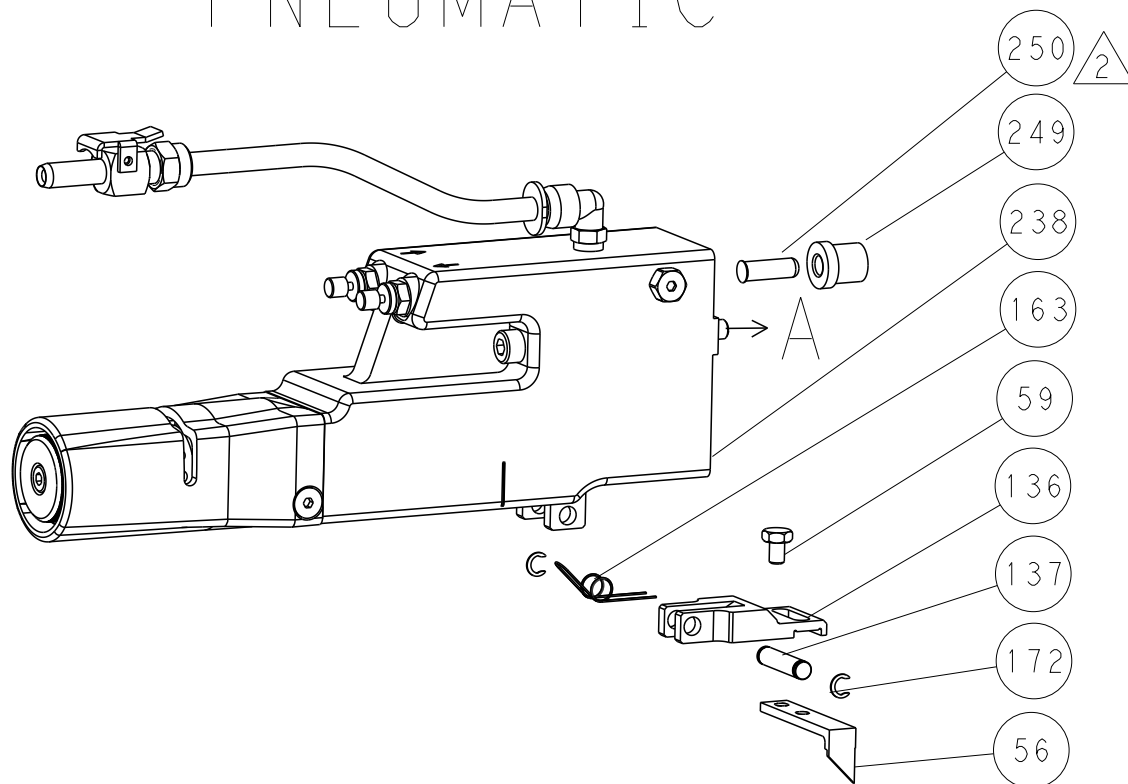
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				CHK	L. ZHANG	12OCT2012				
				APVD	S. XI	12OCT2012	NAME			
				PRODUCT SPEC			Ocean Side Feed Applicator			
				APPLICATION SPEC						
				WEIGHT			RESTRICTED TO			
				Customer Accessible Production Drawing			-			

DIMENSIONS:		TOLERANCES, UNLESS OTHERWISE SPECIFIED:	
mm			
	0 PLC	±	
	1 PLC	±	
	2 PLC	±	
	3 PLC	±	
	4 PLC	±	
ANGLES		±	
FINISH			
MATERIAL	-		
	-		

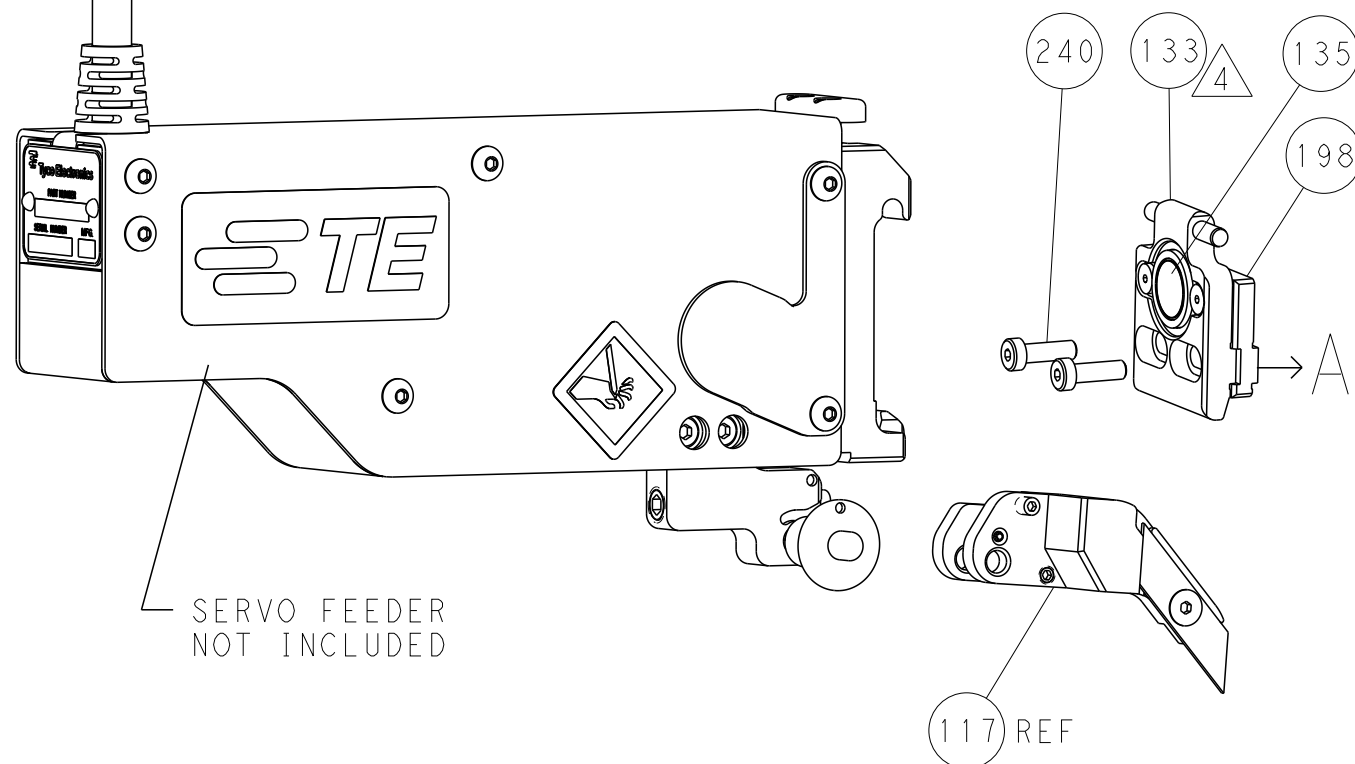
FEED TYPE MECHANICAL



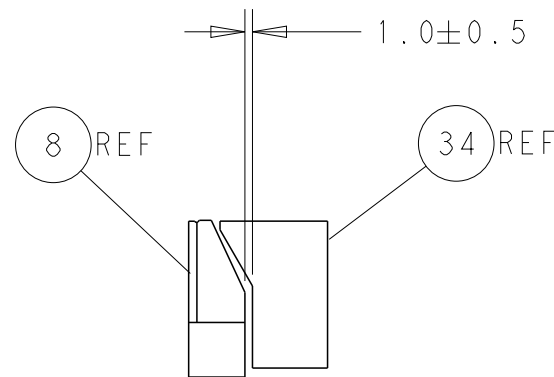
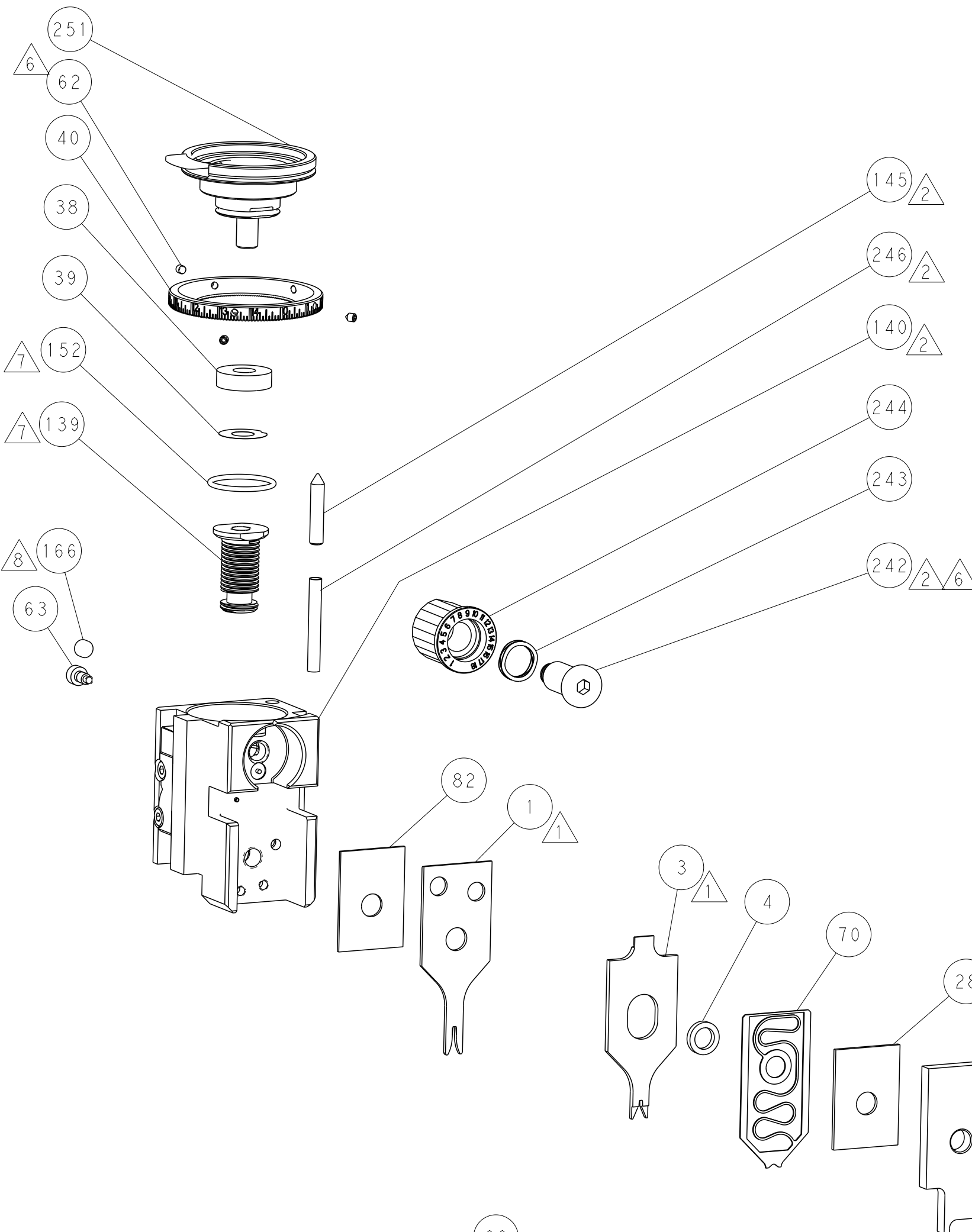
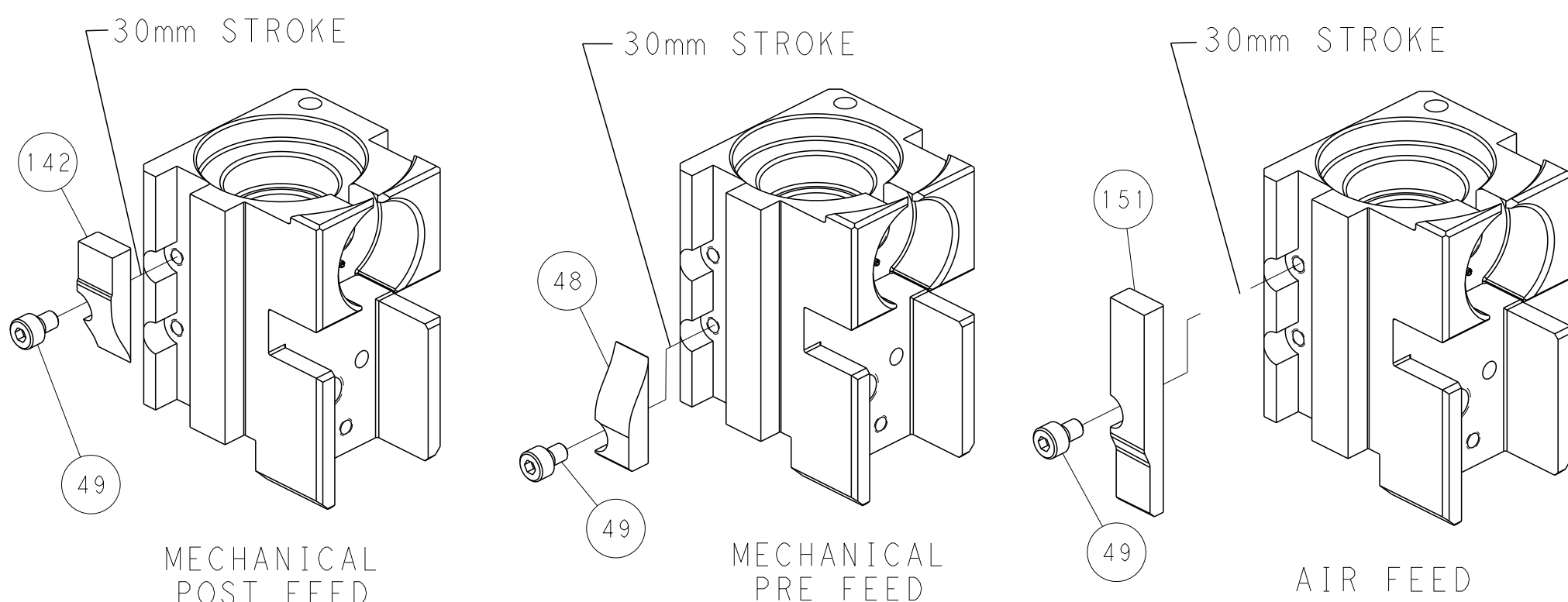
PNEUMATIC



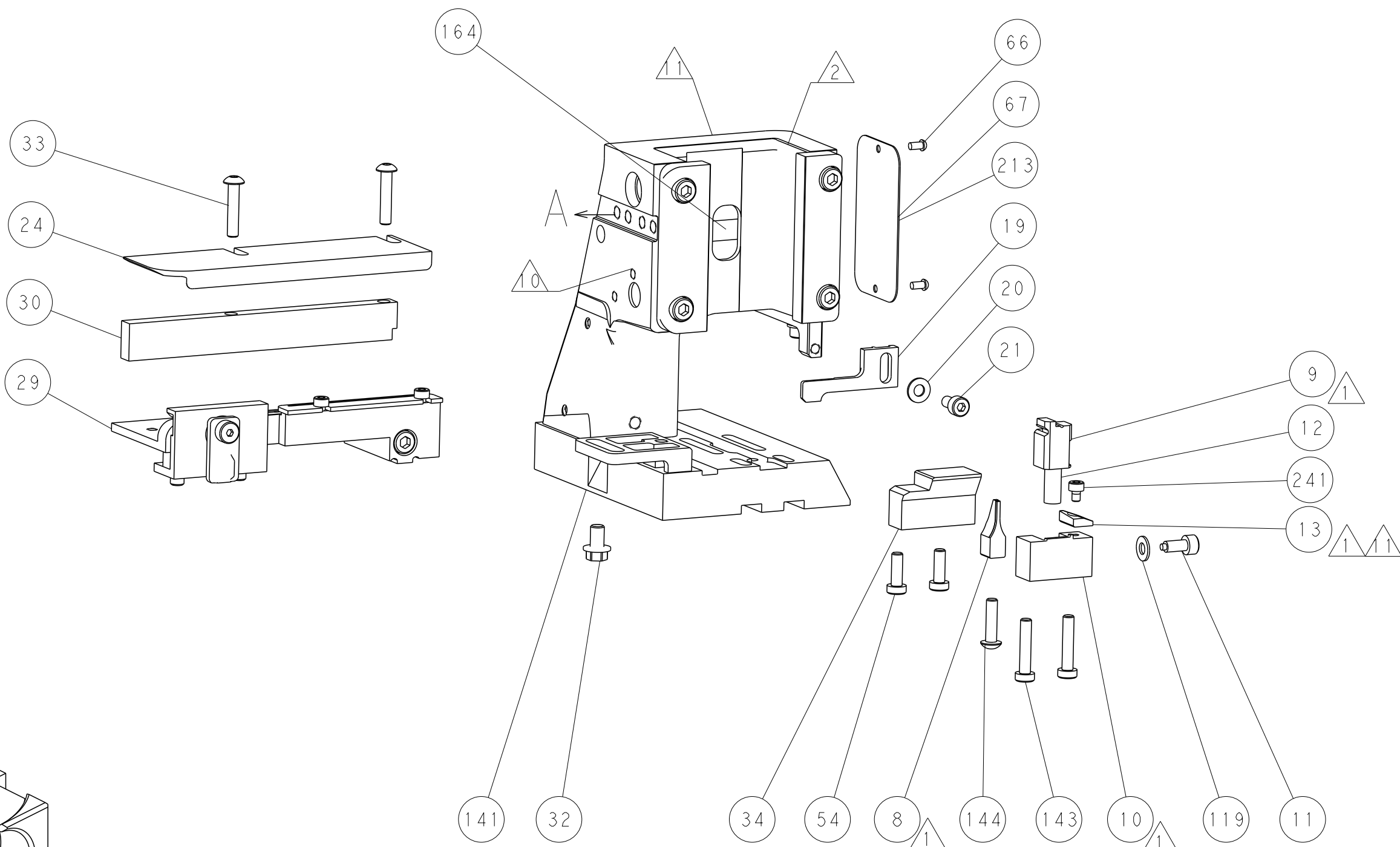
SERVO LATCH PLATE



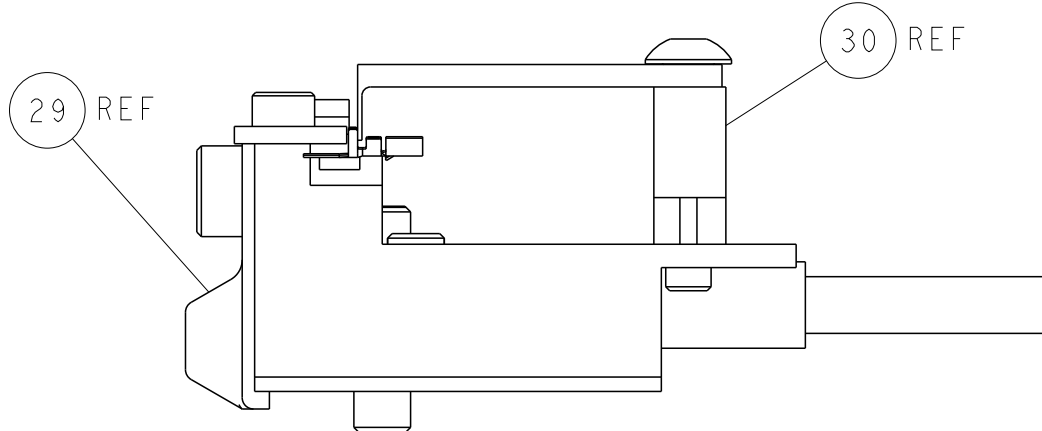
CAM POSITIONS



TERMINAL SUPPORT LOCATION



ITEM 30 LOCATED AT
FRONT 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)

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. IT IS THE RESPONSIBILITY OF THE CUSTOMER TO VERIFY THE DRAWING IS THE LATEST VERSION.		OWN L. ZHANG 12OCT2012	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK L. ZHANG 12OCT2012	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.1 2 PLC ±.1 3 PLC ±.1 4 PLC ±.1 ANGLES ±.1 FINISH		APVD S. X1 12OCT2012	SIZE A1 00779 C=2151791	
MATERIAL -		PRODUCT SPEC APPLICATION SPEC WEIGHT -	RESTRICTED TO Customer Accessible Production Drawing	
		SCALE 1:2	SHEET 4 OF 4 REV D	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION