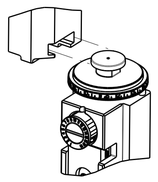
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SET UP GAUGE 2119599-1 | LOC A | DIST 66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	1	DEVELOPMENT	02NOV2011	YY	SX
	A	RELEASED	27DEC2013	YY	UG

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2151186-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
	2151186-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2151186-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4
	2151186-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4 12
	2151186-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-2151186-7	A	CRIMP TOOLING KIT	-

APPLICATOR STYLE CONVERSION CHART

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	-	8-2151186-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151186-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
SERVO LATCH PLATE	2119951-1	-	8-2151186-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151186-4	-	-	-
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
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.00 mm [.118]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION
TERMINAL NAME: .040 III SEALED CONTACT		
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]	INSULATION DIAMETER RANGE Ø 3	
TERMINAL APPLICATION SPECIFICATION	114-5227	- -
	-	- -

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
316832-1	316833-2	286912-1	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING 9
0.50mm2	1.03+/-0.05 [.041+/-.002]	6.9
0.30mm2	0.94+/-0.05 [.037+/-.002]	7.9

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: 8-2151186-4
- PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151186-4
- SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151186-5
- SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151186-6

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

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

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. THE INSULATION RANGE FOR THE SEAL IS Ø1.40-1.70mm.

14 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.

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	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

ATLANTIC VERSION

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

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	-	-	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	2119082-3	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	455888-4	SPACER, CRIMPER	82
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	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
6	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
14	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
-	2	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	690753-2	SPACER, TONKER	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
6	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	1752356-3	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	455888-3	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	1	1	1	1	1	318707-1	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1333225-6	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119781-1	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	3-2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	2
1	1	1	1	1	1	409414-1	WIRE CRIMPER	1

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DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±-
1 PLC ±0.5
2 PLC ±0.13
3 PLC ±0.013
4 PLC ±0.0001
ANGLES ±-

MATERIAL -
FINISH -

DWN Y YIN 02NOV2011
CHK G BAILEY 02NOV2011
APVD S X I 02NOV2011
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

TE Connectivity
Harrisburg, PA 17105-3608

NAME Ocean Side Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2151186	-

Customer Accessible Production Drawing | SCALE 1:2 | SHEET 1 OF 4 | REV A

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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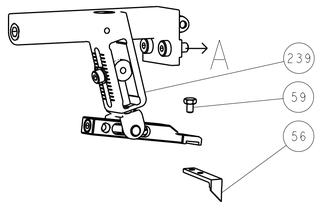
LOC	DIST
A	66

REVISIONS

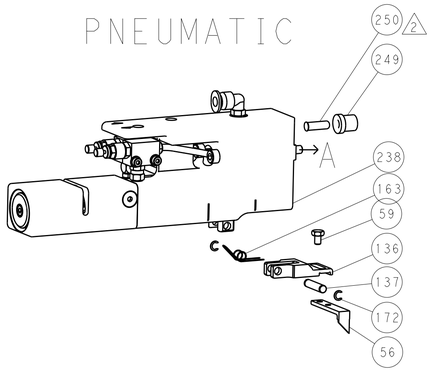
P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

FEED TYPE

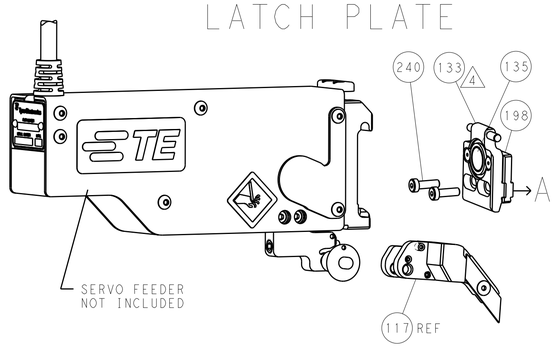
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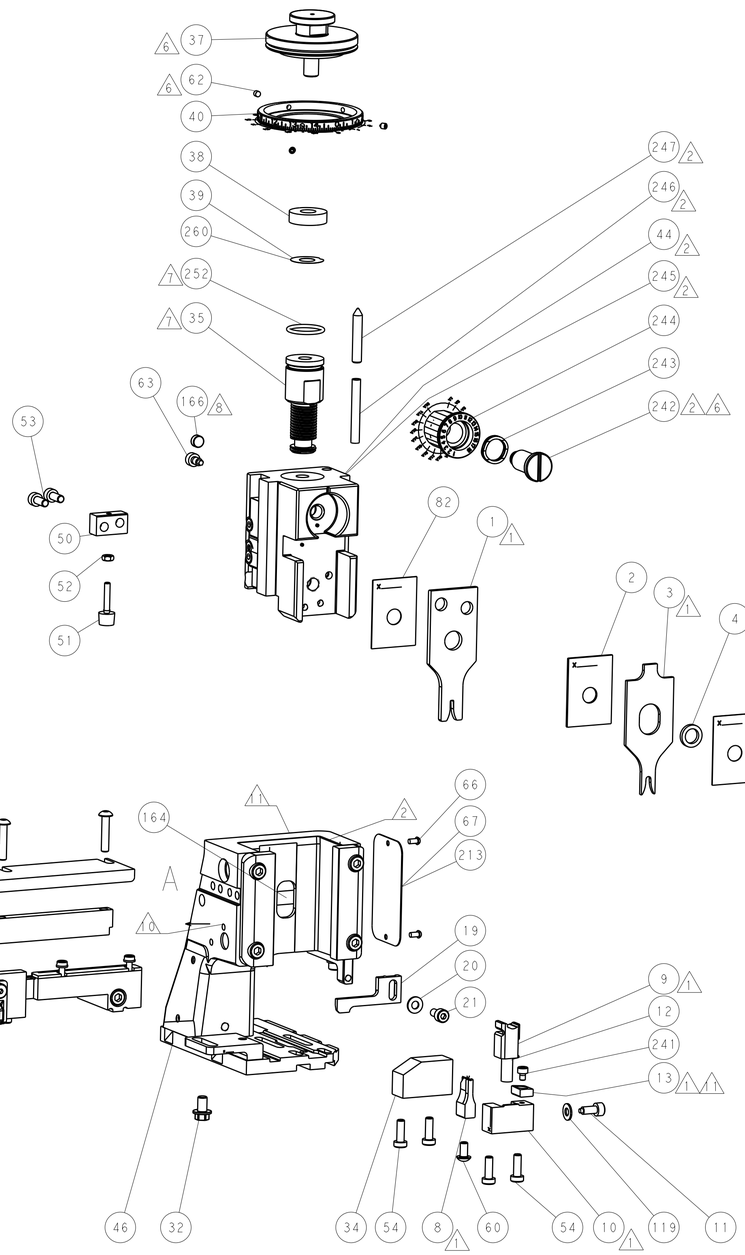


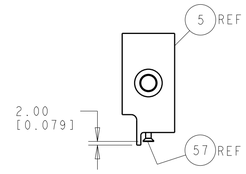
PNEUMATIC



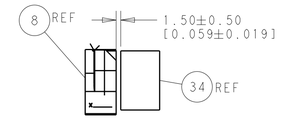
SERVO LATCH PLATE





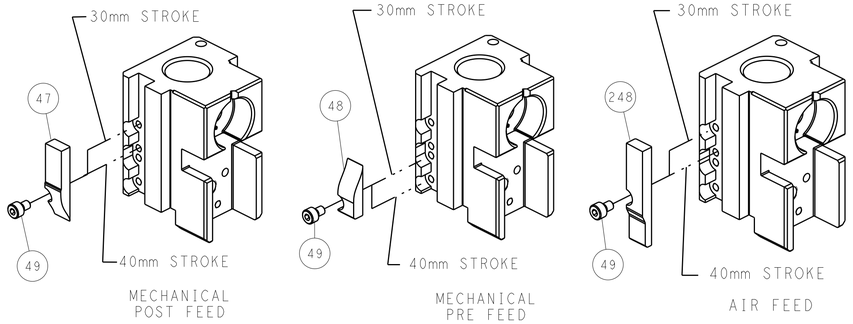


SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION

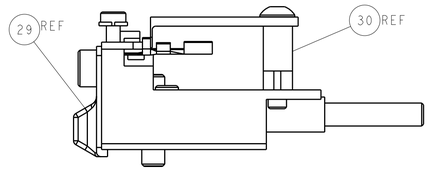
CAM POSITIONS



ATLANTIC VERSION

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

ITEM 30 LOCATED AT FRONT HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±0.5
2 PLC ±0.13
3 PLC ±0.013
4 PLC ±0.0001
ANGLES ±

MATERIAL -
FINISH -

DWN	Y.YIN	02NOV2011
CHK	G.BAILEY	02NOV2011
APVD	S.XI	02NOV2011
PRODUCT SPEC	-	
APPLICATION SPEC	-	
WEIGHT	-	

TE Connectivity
Harrisburg, PA 17105-3608

NAME: Ocean Side Feed Applicator

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2151186	-

Customer Accessible Production Drawing | SCALE 1:2 | SHEET 2 OF 4 | REV A

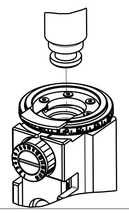
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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SET UP GAUGE	LOC	DIST
2119599-1	A	66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2151186-1	A	FINE CRIMP HEIGHT ADJUST	MECHANICAL
	2-2151186-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2151186-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4
	2-2151186-7	A	FINE CRIMP HEIGHT ADJUST	NONE
	7-21511867	A	CRIMP TOOLING KIT	-

APPLICATOR STYLE CONVERSION CHART

CONVERT TO	PART NUMBERS REQUIRED					
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
SERVO LATCH PLATE	2119951-1	-	8-2151186-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151186-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
SERVO LATCH PLATE	2119951-1	-	8-2151186-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151186-4	-	-	-
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
-	-	-	-	-	-	-
-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [.070]	F
INSUL	3.00 mm [.118]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL			TE CRIMP SPECIFICATION
TERMINAL NAME: .040 III SEALED CONTACT			
WIRE STRIP LENGTH 4.00-4.50 mm [.157-.177 IN]		INSULATION DIAMETER RANGE Ø 12	
TERMINAL APPLICATION SPECIFICATION	114-5227	-	-
	-	-	-

TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE SEAL	TE SEAL
316832-1	316833-2	286912-1	-

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING 9
0.50mm2	1.03+/-0.05 [.041+/-.002]	6.9
0.30mm2	0.94+/-0.05 [.037+/-.002]	7.9

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: 8-2151186-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151186-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151186-5

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

6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62 & 242.

7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

8 MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12 THIS APPLICATOR APPLIES TERMINAL WITH A SEAL. THE INSULATION RANGE FOR THE SEAL IS Ø1.40-1.70mm.

13 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.

-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-3	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6 -	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
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-	-	-	1	-	2063440-1	AIR FEED MODULE	238
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-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
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-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)

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DIMENSIONS: mm
TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±-
1 PLC ±0.5
2 PLC ±0.13
3 PLC ±0.013
4 PLC ±0.0001
ANGLES ±-
MATERIAL -
FINISH -

DWN	Y YIN	02NOV2011
CHK	G BAILEY	02NOV2011
APVD	S XI	02NOV2011
PRODUCT SPEC	-	
APPLICATION SPEC	-	
WEIGHT	-	

TE Connectivity
Harrisburg, PA 17105-3608

NAME: Ocean Side Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2151186	-

Customer Accessible Production Drawing | SCALE 1:2 | SHEET 3 OF 4 | REV A

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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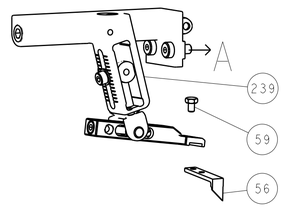
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A	66

REVISIONS

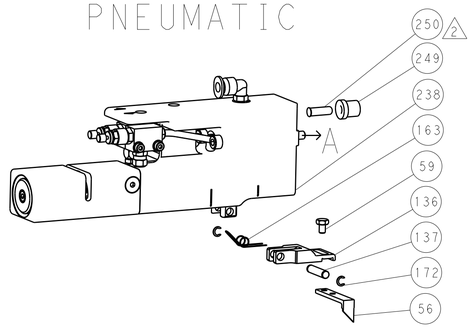
P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

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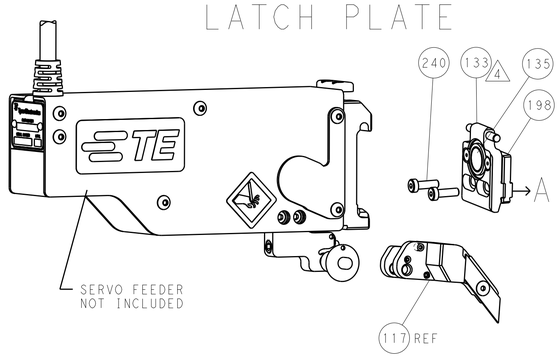
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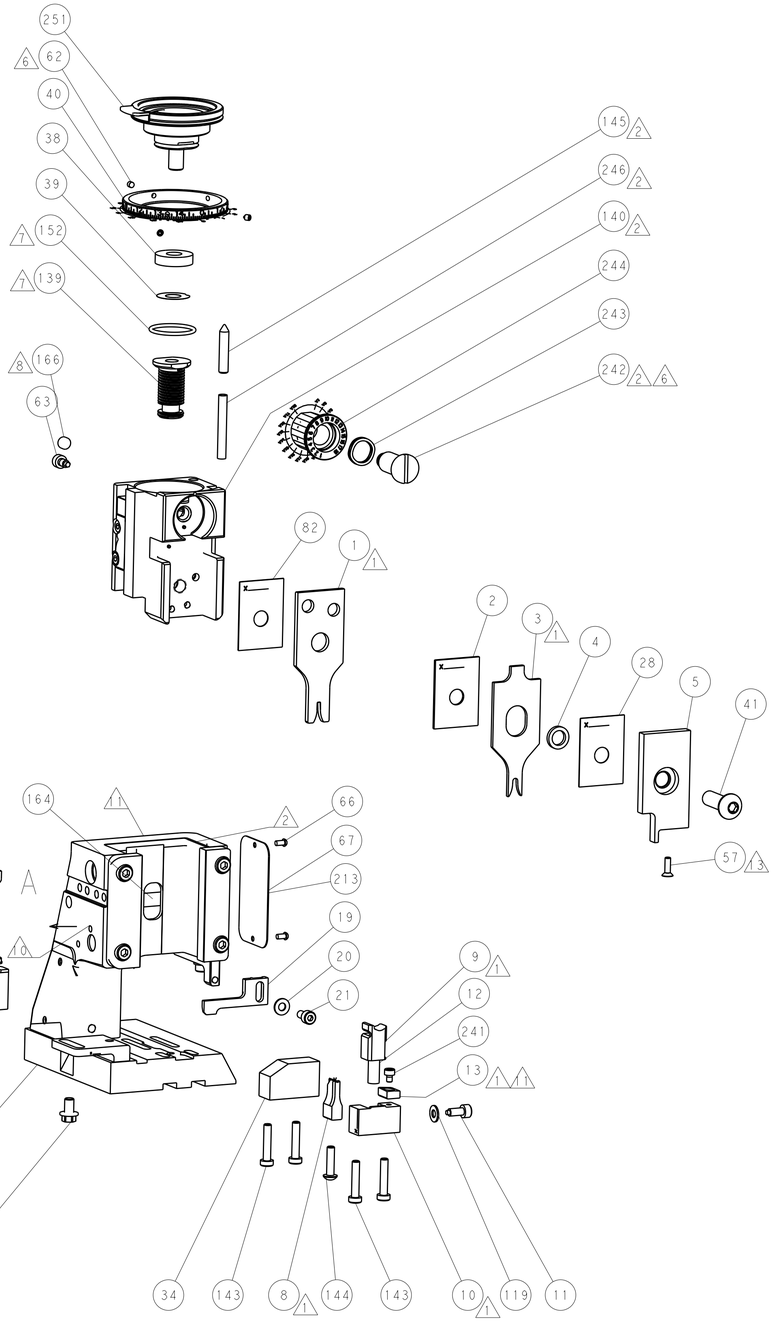


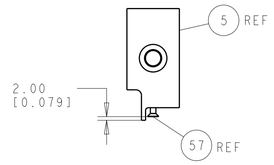
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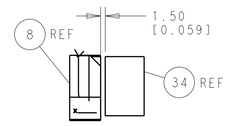
SERVO LATCH PLATE





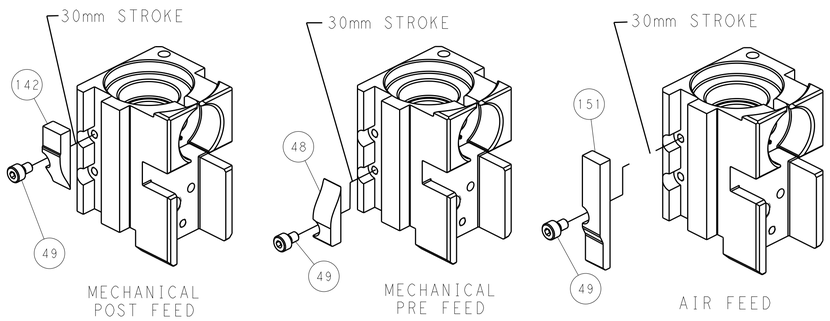


SHEAR DEPRESSOR DETAIL

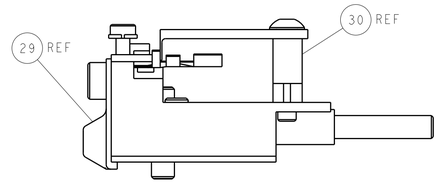


TERMINAL SUPPORT LOCATION

CAM POSITIONS



ITEM 30 LOCATED AT
FRONT HOLES



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

PACIFIC VERSION

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TE Connectivity
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