

8

7

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1

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20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

2151757-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

2151757-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2151757-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

2151757-6

A

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴¹²

2151757-7

A

FINE CRIMP HEIGHT ADJUST

NONE

7-2151757-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.94 mm [.155]	F

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: CONTACT .125 BLADE

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1217071-1	1217716-1	1217076-1	

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

16 AWG	1.78+/-0.05 [.070+/- .002]	7.7
18 AWG	1.65+/-0.05 [.065+/- .002]	9.1
20 AWG	1.55+/-0.05 [.061+/- .002]	10.1

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: 8-2151757-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151757-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151757-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151757-6

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 50, 62 & 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37, 50 & 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

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	-	8-2151757-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151757-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
SERVO LATCH PLATE	2119951-1	-	8-2151757-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151757-4	-	-	-
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
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-

SET UP GAUGE
2119599-1

LOC
A

DIST
66

P	LTR	DESCRIPTION	DATE	OWN	APVD
	A	RELEASED	26OCT2012	LG	TE

1

1

1

1

1

1

2119083-1

RETAINER, INSULATION DIAL

242

1

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

1

993111-1

PIN, SLOTTED SPRING 3.0 X 20.0

177

1

1

1

1

1

1

8-22280-7

SPRING, COMPRESSION

176

1

1

1

1

1

1

1752353-2

GUIDE PIN,HOLDDOWN

175

1

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

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

REF

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

1-18028-2

WASHER, FLAT, REG M4

119

-

REF

REF

-

-

-

2119944-1

FEED FINGER ASSEMBLY,SF

117

1

1

1

1

 1 | 1 | 455888-5 | SPACER, CRIMPER | 82 || 1 | 1 | 1 | 1 | 1 | 1 | 22278-8 | SPRING, COMPRESSION | 77 |
1	1	1	1	1	1	854769-4	HOLDER, INS	74
1	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
1	1	1	1	1	1	1-2119791-0	DEPRESSOR, WIRE	70
1	1	1	1	1	1	2119943-1	WASHER, SPACER	69
1	-	-	-	1	1	2119740-1	TAG, IDENTIFICATION	67
2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS	66
1	-	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	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	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
-	-	-	-	1	1	1338685-1	PAWL, FEED	56
4	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
1	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
1	1	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
1	1	1	1	1	1	1-1752354-9	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	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
1	-	1	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
1	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
1	-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
1	-	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
1	1	1	1	1	1	2119644-2	RAM WASHER, PRECISION	38
1	1	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
1	-	1	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
1	1	1	1	1	1	1752356-3	SUPPORT, TERMINAL	34
2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
1	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
1	1	1	1	1	1	1-1320908-2	SPACER, STRIP GUIDE	30
1	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
1	1	1	1	1	1	455888-4	SPACER, CRIMPER	28
1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
1	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
1	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	1	3-22280-3	SPRING, COMPRESSION	12
1	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	1633922-9	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
1	1	1	1	1	1	1-2119780-1	DEPRESSOR, SHEAR	5
1	1	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	3-2119582-6	CRIMPER, INSULATION F PREMIUM	3
-	-	-	-	-	-	-	-	2
1	1	1	1	1	1	1-456407-3	CRIMPER, WIRE PREMIUM	1
-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)

THIS IS SUBJECT TO CHANGE AND TO BE USED FOR THE PURPOSES OF THE DRAWING ONLY. IT IS SUBJECT TO CHANGE AND TO BE USED FOR THE PURPOSES OF THE DRAWING ONLY. IT IS SUBJECT TO CHANGE AND TO BE USED FOR THE PURPOSES OF THE DRAWING ONLY.

CHK
G. BAILEY

31AUG2012

DIMENSIONS:
mm

0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

±

±0.1

±0.02

±0.005

±0.0005

±

TOLERANCES UNLESS OTHERWISE SPECIFIED:

FINISH

MATERIAL

APVD
T. ELBIN

31AUG2012

PRODUCT SPEC

APPLICATION SPEC

WEIGHT

Customer Accessible Production Drawing

SCALE
1:1

SHEET
1

OF
4

REV
A

OWN
M. STAKEM

31AUG2012

NAME
Ocean Side Feed
Applicator

SIZE
A

CAGE CODE
00779

DRAWING NO
©=2151757

RESTRICTED TO

Customer Accessible Production Drawing

SCALE
1:1

SHEET
1

OF
4

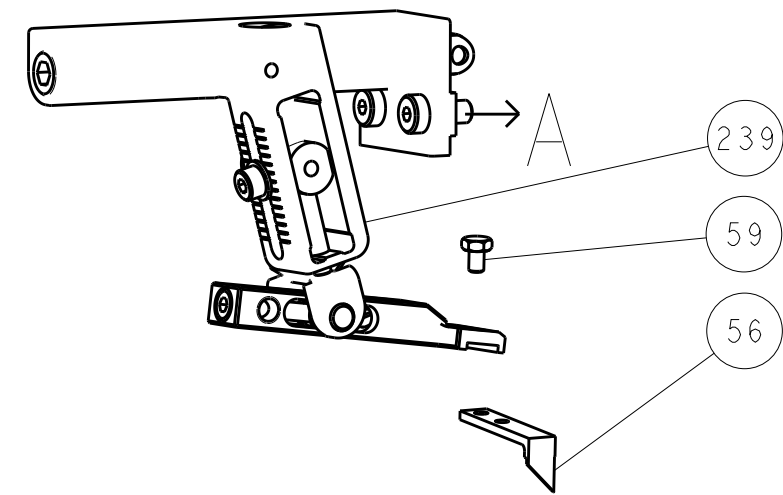
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AMP 4805 REV 31MAR2000

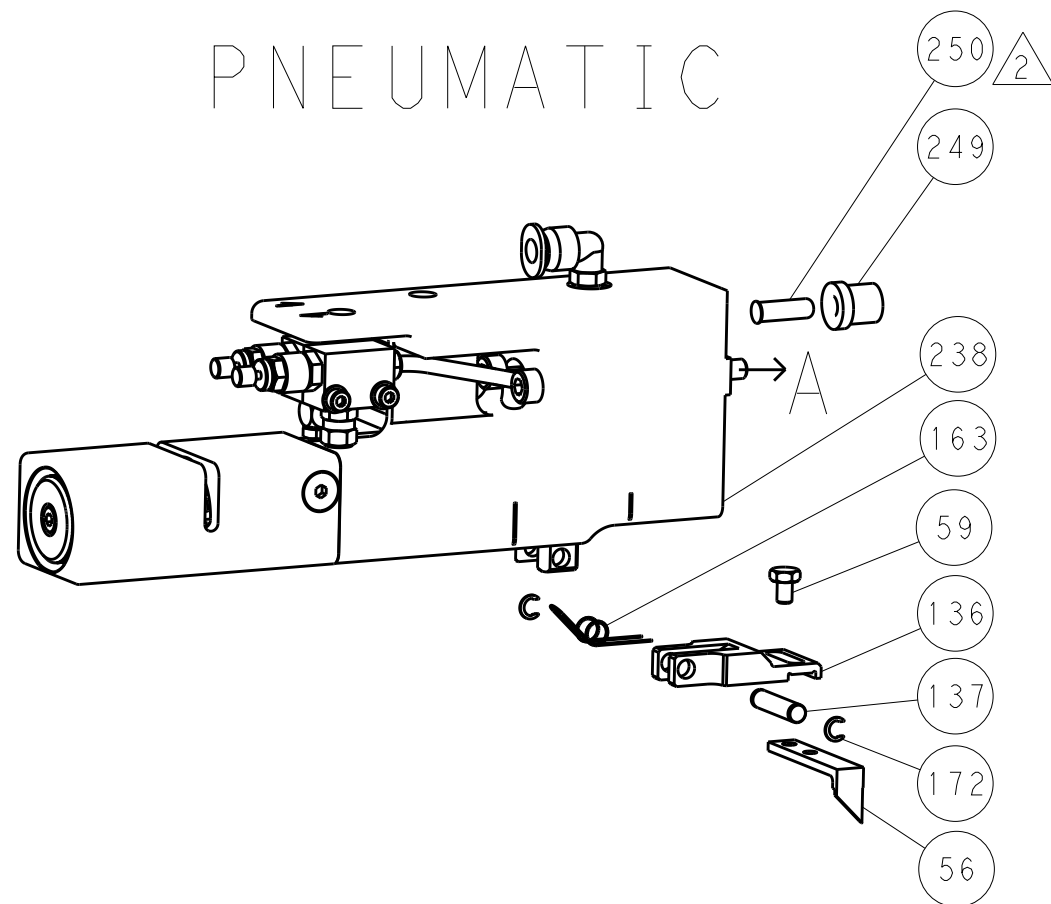
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

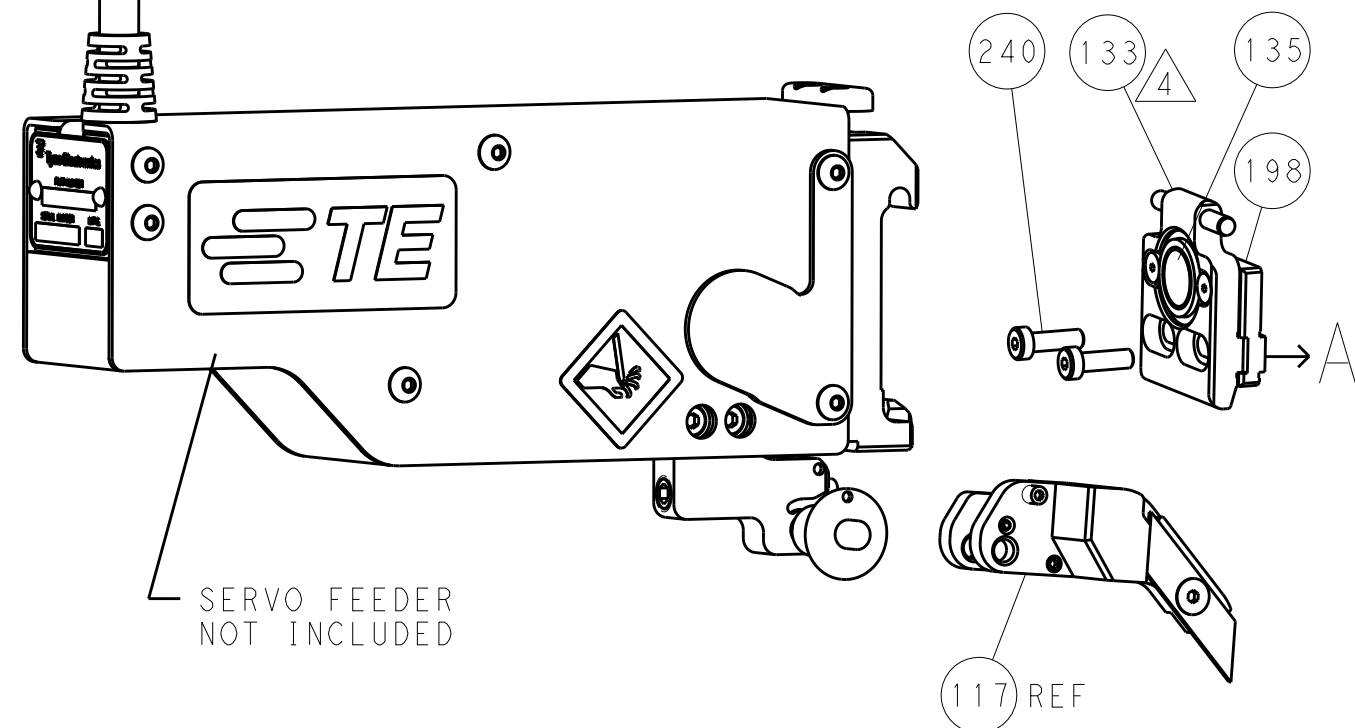
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MECHANICAL



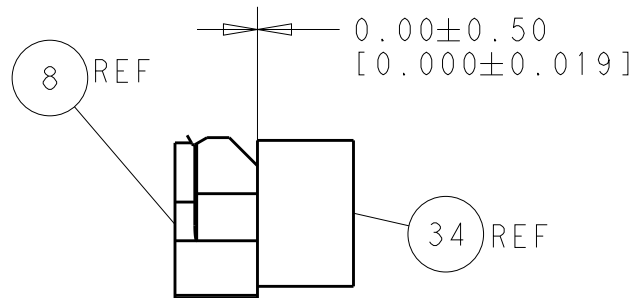
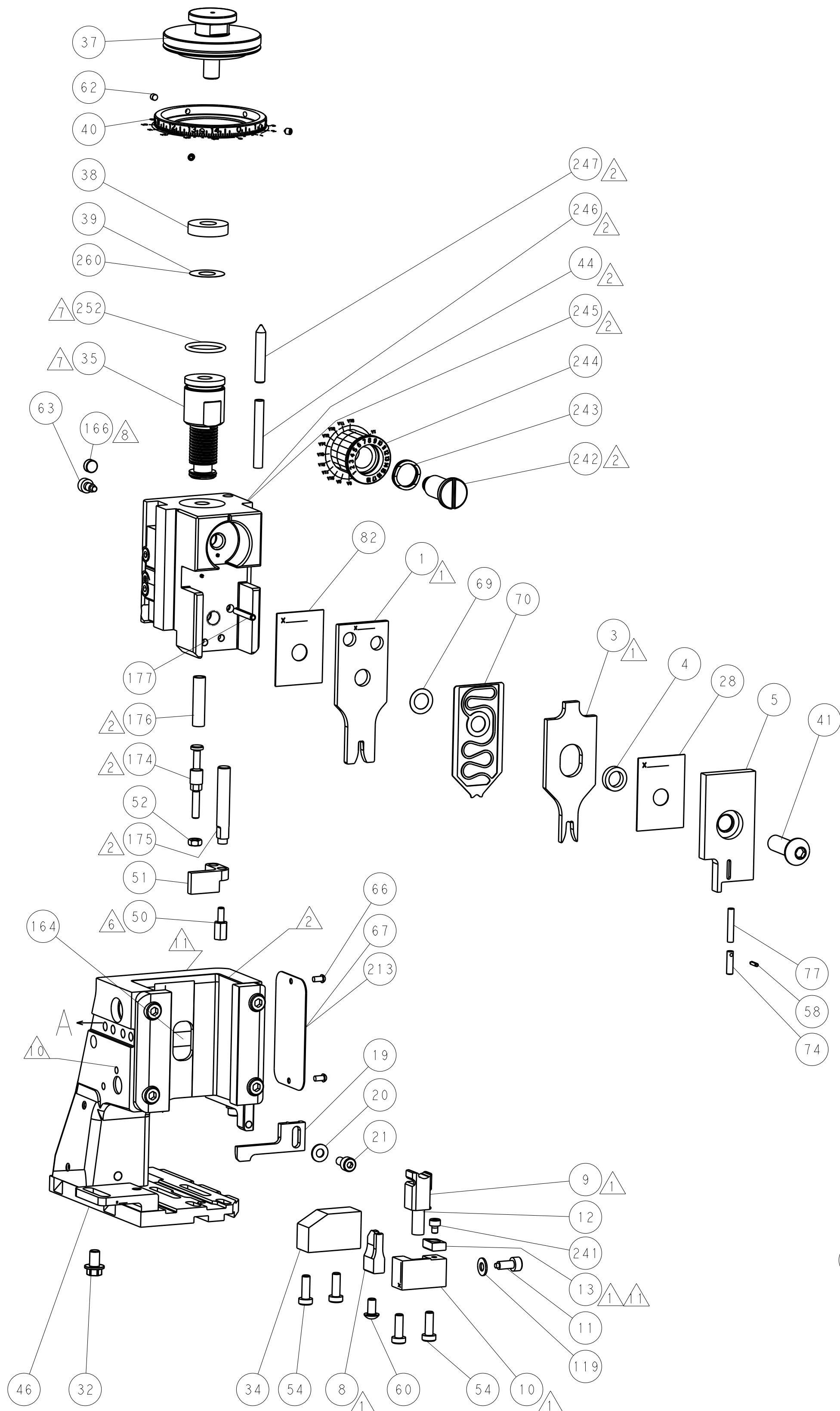
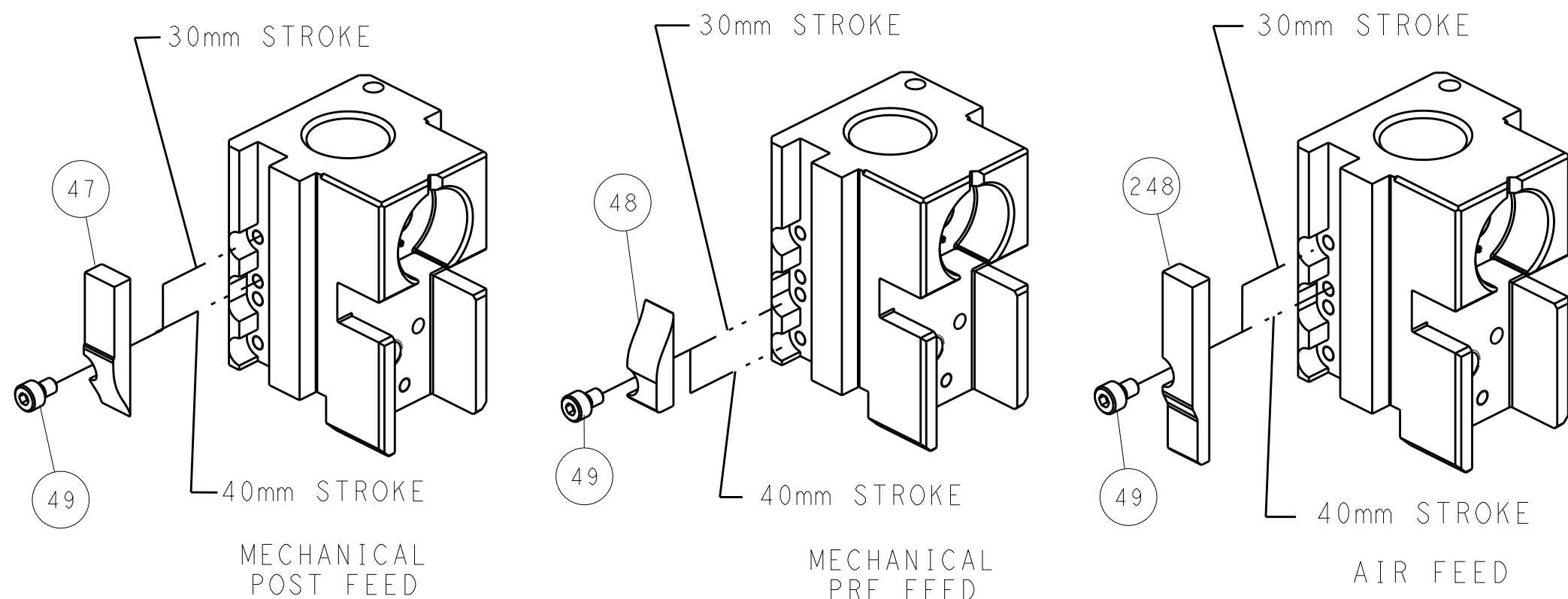
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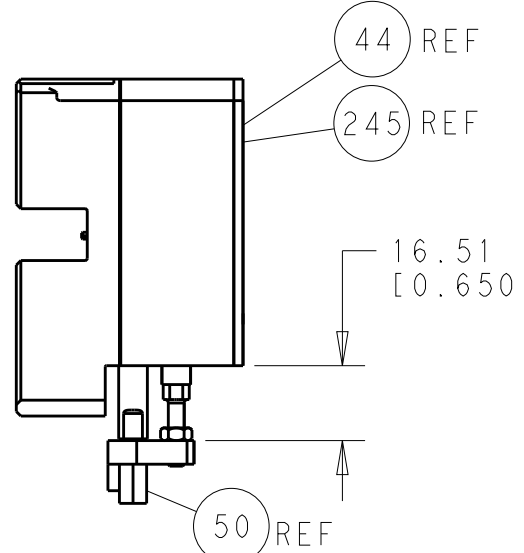
SERVO
LATCH PLATE



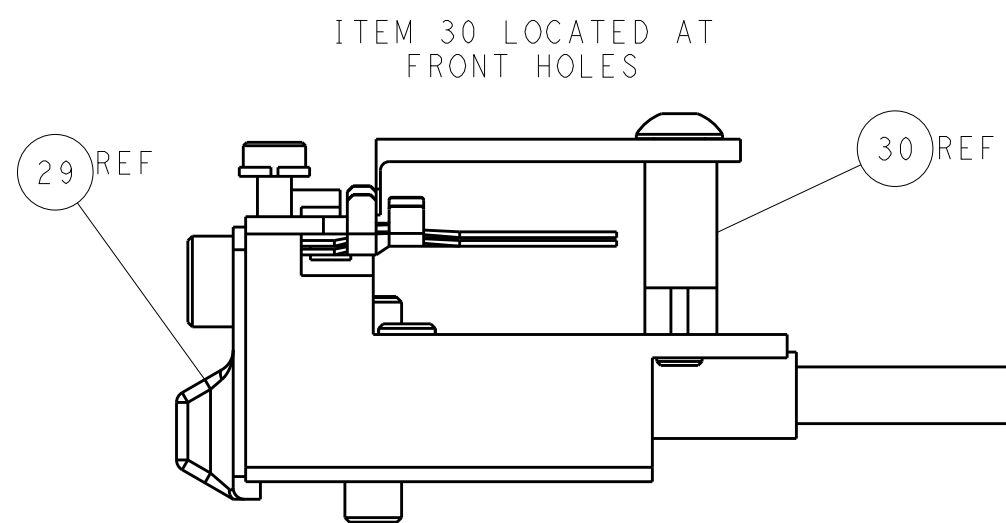
CAM POSITIONS



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: 31AUG2012		REV: 66	
mm		0 PLC ±.1		CHK: 31AUG2012		APVD: 31AUG2012	
MATERIAL:		FINISH:		PRODUCT SPEC:		NAME:	
				APPLICATION SPEC:		SIZE: CAGE CODE: DRAWING NO:	
				WEIGHT:		A1 00779 ©=2151757	
				Customer Accessible Production Drawing		SCALE: 1:1 SHEET 2 OF 4 REV A	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

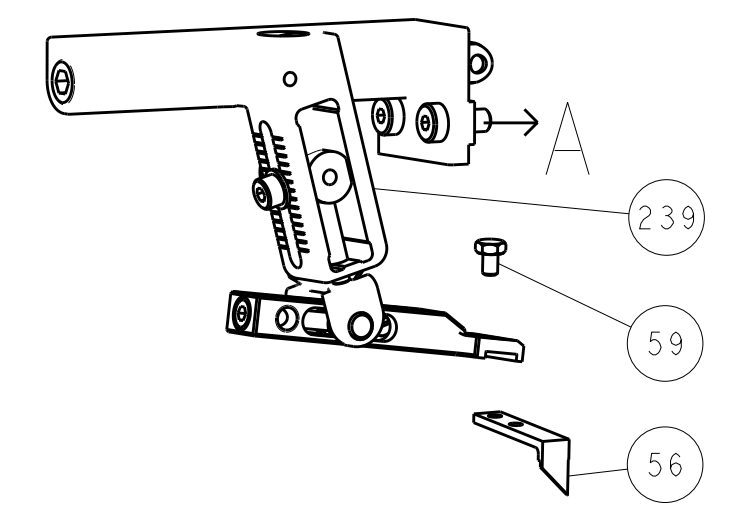
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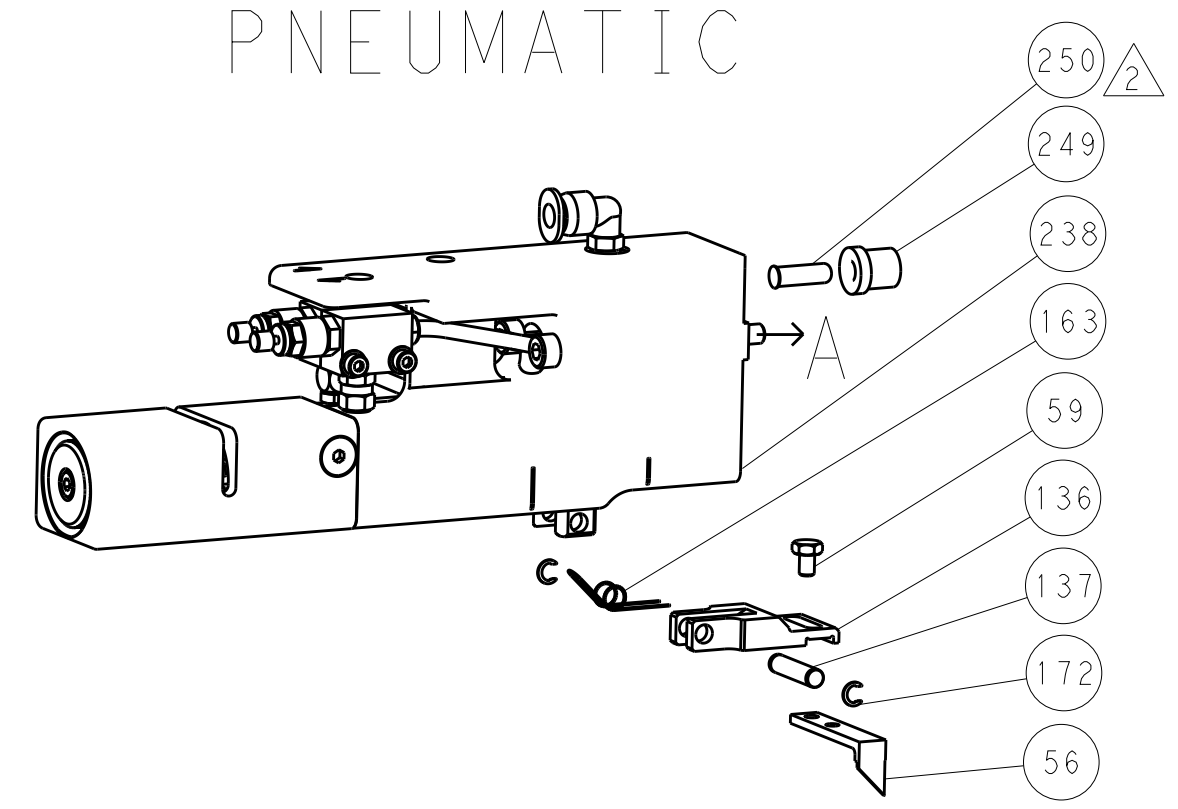
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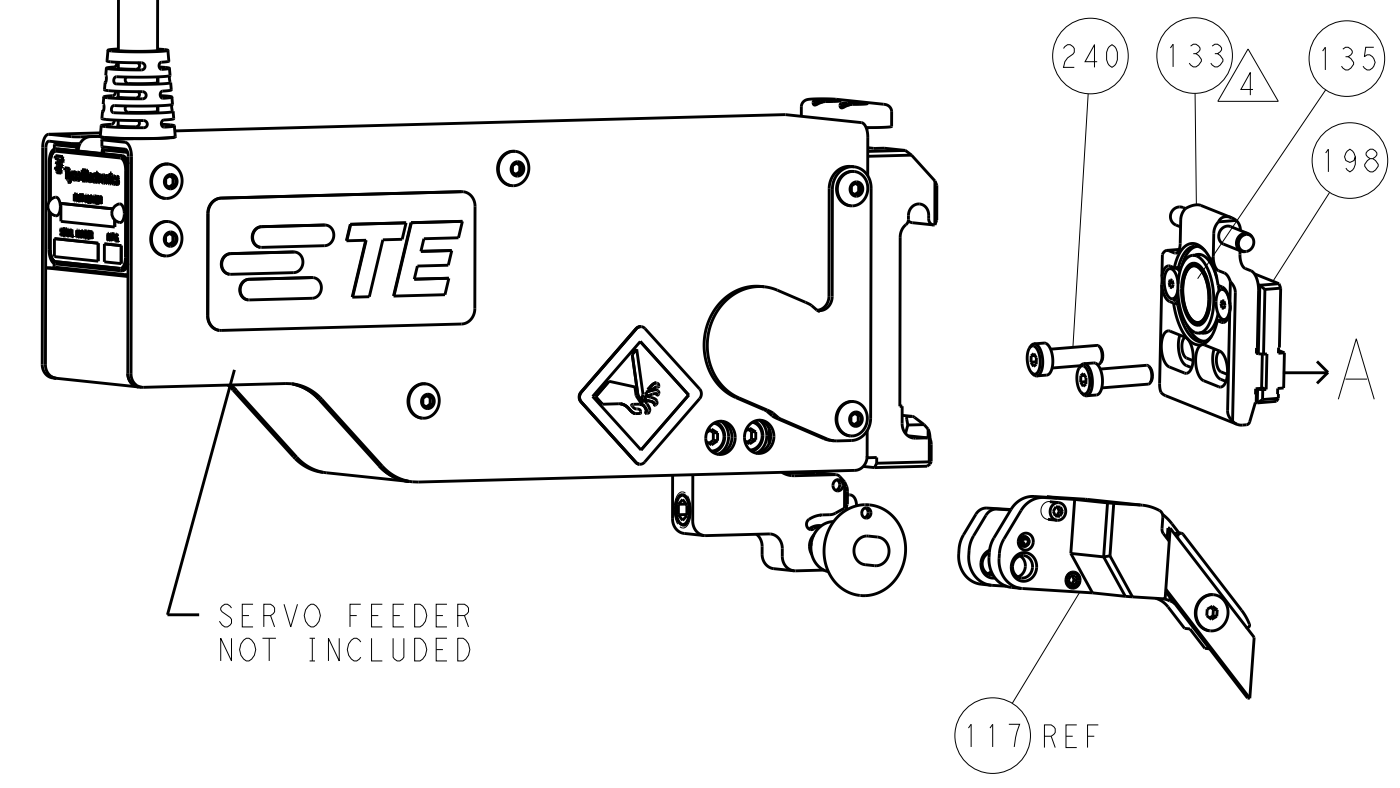
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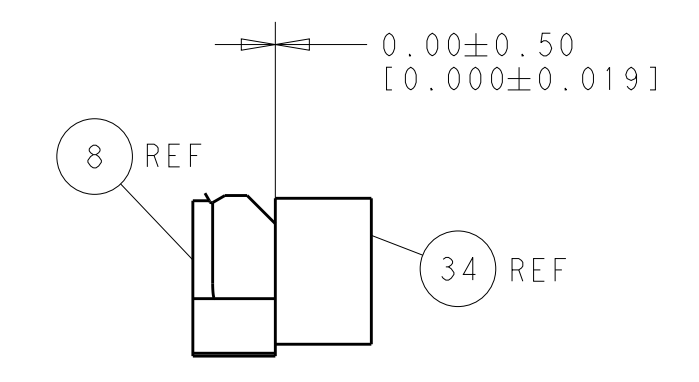
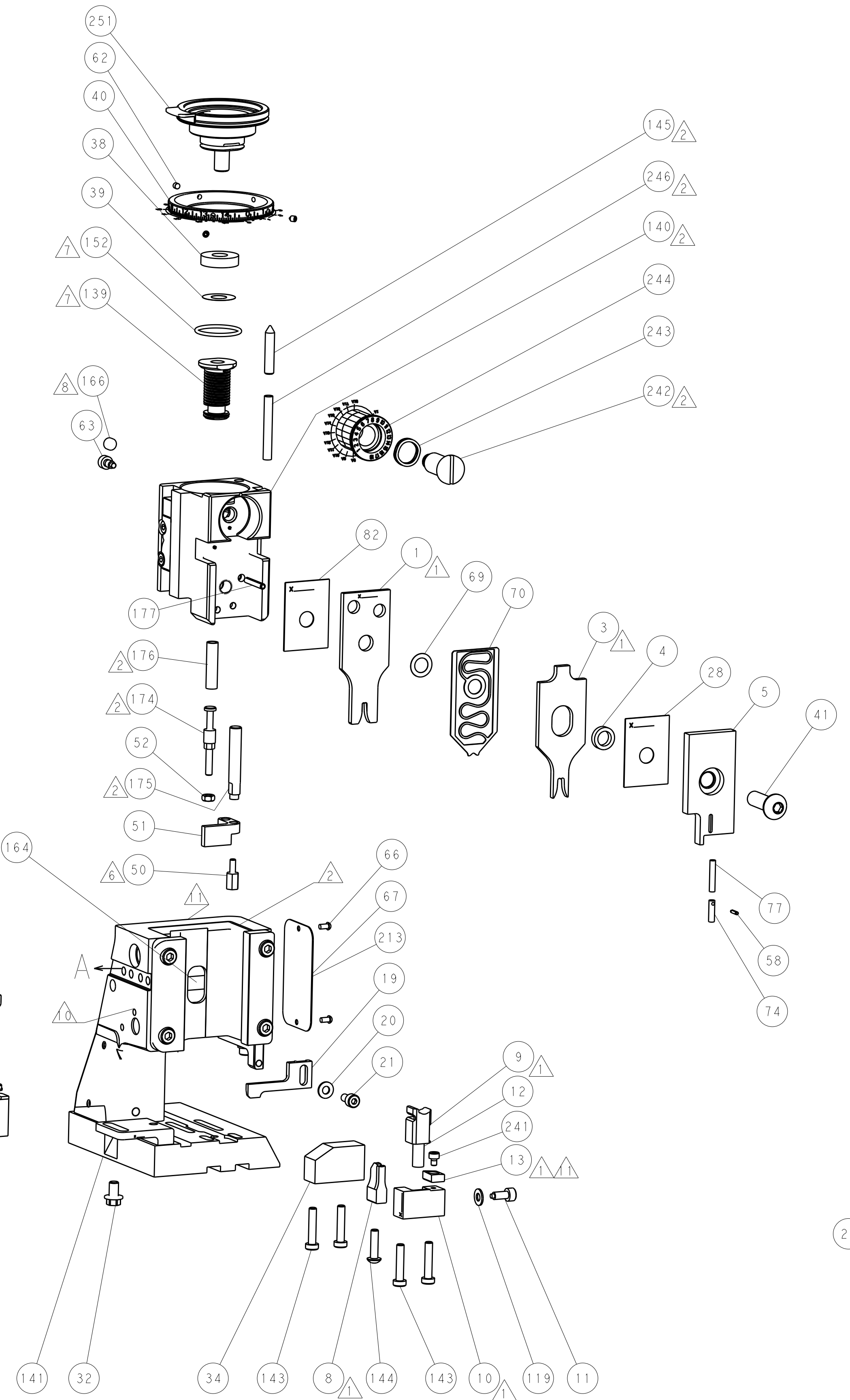
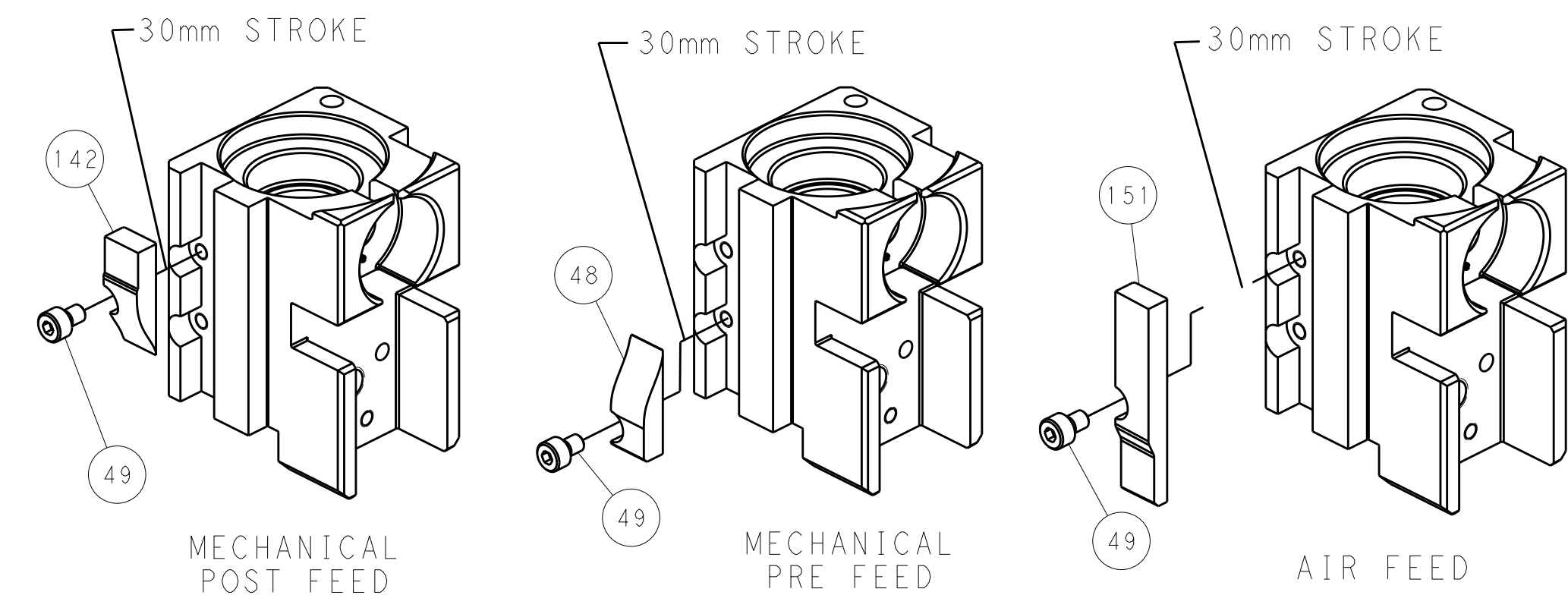
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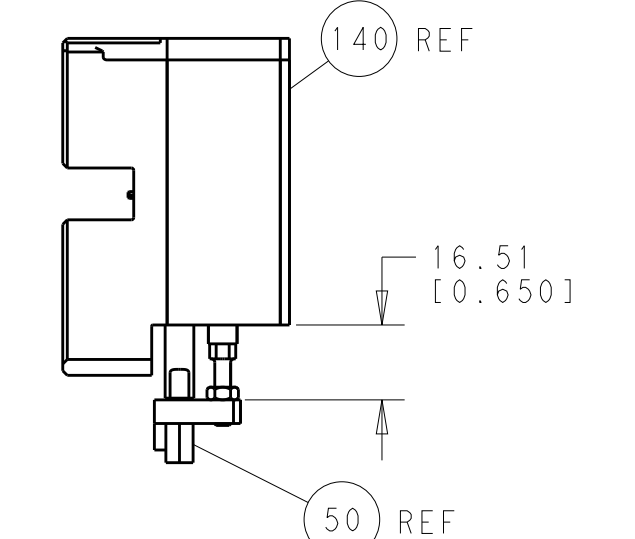
SERVO LATCH PLATE



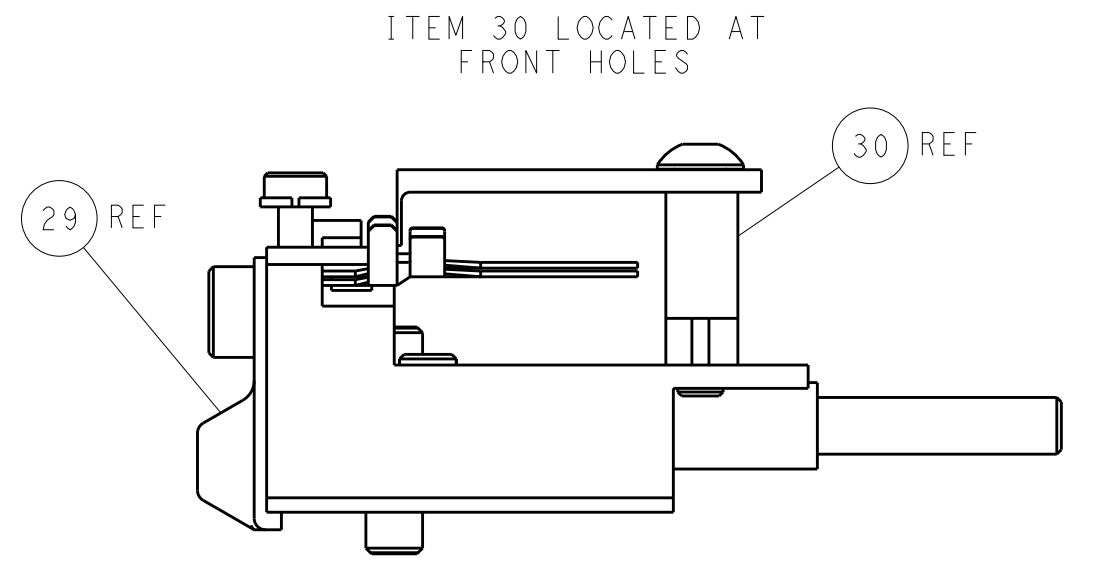
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION.		OWN: 31AUG2012	STE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK: 31AUG2012		
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0 PLC ±.1		APVD: 31AUG2012		
1 PLC ±0.1		PRODUCT SPEC	SIZE: CAGE CODE: DRAWING NO: 00779 ©=2151757	
2 PLC ±0.02		APPLICATION SPEC		
3 PLC ±0.005		WEIGHT	Customer Accessible Production Drawing	
4 PLC ±0.0005		SCALE: 1:1		
ANGLES FINISH		SHEET: 4 OF 4	REV: A	
MATERIAL		REV: A		