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20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

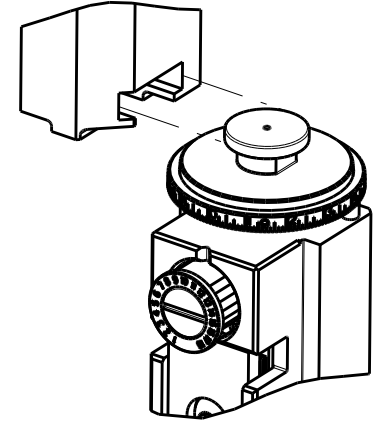
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151672-1

B

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED
SERVO LATCH PLATE
SMART APPLICATOR

2119950-1
2119951-1
2161326-1

1338685-1
-
-

5-18022-5
8-2151672-5
8-2151672-4

2119641-1
1901094-3
-

2119799-1
-
-

2063440-1
2168400-6 (QUANTITY 2)
-

2151672-2

B

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED
SERVO LATCH PLATE
SMART APPLICATOR

2119949-1
2119951-1
2161326-1

1338685-1
-
-

5-18022-5
8-2151672-5
8-2151672-4

2119653-1
1901094-3
-

-
-
-

2168400-6 (QUANTITY 2)
-

2151672-5

B

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

2151672-6

B

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹²

-
-

-
-

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-

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-

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-

2151672-7

B

FINE CRIMP HEIGHT ADJUST

NONE

-

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-

7-2151672-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

0.90 mm [.035]

F

INSUL

1.00 mm [.039]

O

APPLICATOR INSTRUCTIONS

408-10389



TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: CABLE PLUG CONTACT, 1.5CL WIRE TO BOARD CONNECTOR

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

1.10-1.50 mm [.043-.059 IN]

Ø0.80-1.00 mm [.031-.039 IN]

TERMINAL APPLICATION SPECIFICATION

114-99005

-

-

TERMINALS APPLIED

TE TERMINAL

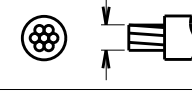
TE TERMINAL

TE TERMINAL

TE TERMINAL

2129408-1

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING⁹

24 AWG OR 0.20mm2

0.61+/-0.03 [.024+/- .001]

9.2

26 AWG OR 0.14mm2

0.56+/-0.03 [.022+/- .001]

9.7

28 AWG OR 0.09mm2

0.51+/-0.03 [.020+/- .001]

10.3



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: 8-2151672-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151672-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151672-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151672-6

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

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2

2

2

2

2

22283-1

SPRING, COMPRESSION

279

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2

2

2

2

2

2-18032-5

SCR, SET, FLT POINT M5 X 20.0

278

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1

1-22281-8

SPRING, COMPRESSION

277

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1

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1

1

1

2168083-6

SCR, SKT HD CAP, RoHS, M5 X 65

276

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1

1

1

1

1

980371-4

SCR, SKT HD SHLDR 5.0 DIA X 6.0

275

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1

1

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1

1

356835-1

LEVER, DRAG RELEASE

274

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240792-1

DRAG, TERMINAL

273

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2

2

2

2

2

2168083-1

SCR, SKT HD CAP, RoHS, M3 X 8.0

271

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1

1

1

1

1-690438-0

FRONT STRIP GUIDE

270

-

-

1

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-

-

2119957-2

APPLICATOR SHIM PACK

260

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1

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1

1

1

8-21084-0

O-RING, .676 ID, .070 DIA. MAT.

252

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1

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2119640-1

PUSH ROD, AIR FEED

250

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1

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2079988-1

BUSHING, LCH5-12, MISUMI

249

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1

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2119641-1

FEED CAM, AIR FEED

248

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1

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1

1

2119798-1

DETENT PIN

247

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1

1

1-22279-3

SPRING, COMPRESSION

246

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1

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2119758-1

RAM, AMP STYLE, SIDE FEED, NON-ADJ.

245

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1

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1

2119082-9

CAM, SNAIL, INSULATION ADJUSTMENT

244

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2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

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1

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1

2119083-1

RETAINER, INSULATION DIAL

242

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1

1

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1

7-18023-7

SCR, SKT HD CAP M3 X 4.0

241

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

SET UP GAUGE

2119599-1

LOC

A

DIST

66

REVISIONS

P

LTR

DESCRIPTION

DATE

DWN

APVD

A

RELEASE

27SEP2012

L.Z

S.X

B

ECR-12-017770

11OCT2012

BH

BH

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2

2

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2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

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-

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1

2119580-1

MECHANICAL FEED ASSEMBLY

239

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1

2063440-1

AIR FEED MODULE

238

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2

2

2

2

2

1-2079383-0

SCR, BHSC, RoHS (M3 X 6)

230

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1

1

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2119740-2

TAG, IDENTIFICATION

213

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1

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1901094-3

SPACER, FEEDER

198

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1

1

1

1

1

1-1976053-0

LOCATER BLOCK, TERMINAL

179

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1

1

1

1

1

993111-1

PIN, SLOTTED SPRING 3.0 X 20.0

177

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1

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1

8-22280-7

SPRING, COMPRESSION

176

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1752353-2

GUIDE PIN,HOLDDOWN

175

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1

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1

1901680-2

GUIDE PIN,HOLDDOWN

174

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-

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2

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21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

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1

1

1

1

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

REF

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

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-

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1

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240638-1

SPRING, FEED FINGER

163

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1

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3-23627-7

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

137

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2119799-1

HOLDER,FEED FINGER, AF

136

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REF

REF

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SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

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1633743-1

SERVO FEED LATCH ASM

133

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1-18028-2

WASHER, FLAT, REG M4

119

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REF

REF

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2119944-1

FEED FINGER ASSEMBLY,SF

117

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2119955-1

ASSY, LUBRICATOR, SIDE FEED

113

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2-455888-3

SPACER, CRIMPER

82

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5-547505-2

SPRING, COMPRESSION

77

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854769-4

HOLDER, INS

74

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2119956-1

DOCUMENTATION PACKAGE

71

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2119791-5

DEPRESSOR, WIRE

70

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1

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2119740-1

TAG,IDENTIFICATION

67

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2

2

2

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2

2168078-1

SCREW, DRIVE, RH, RoHS

66

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1

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1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

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3

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3

3

3

992763-5

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

62

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2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

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5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

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21028-2

PIN, SLOTTED SPRING .062 X .250

58

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1338685-1

PAWL, FEED

56

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4

4

4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

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1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

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1-1901681-0

HOLDDOWN, TERMINAL

51

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1752354-8

STANDOFF,HOLD-DOWN

50

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18023-9

SCR, SKT HD CAP M4 X 6.0

49

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1

2119652-1

FEED CAM, PRE FEED

48

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2119653-1

FEED CAM, POST FEED

47

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2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

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2119370-1

RAM, AMP STYLE, SIDE FEED

44

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2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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1

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2119957-1

APPLICATOR SHIM PACK

39

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2119644-1

RAM WASHER, PRECISION

38

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2119085-1

FA HEAD, ATLANTIC STYLE

37

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2119092-1

BOLT, ADJUSTMENT

35

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4-1752356-3

SUPPORT, TERMINAL

34

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2

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2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

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2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

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1320908-4

SPACER, STRIP GUIDE

30

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2-1901086-0

PLATE, STRIP GUIDE

29

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455888-3

SPACER, CRIMPER

28

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1320928-2

STRIP GUIDE

24

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2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

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1-18028-2

WASHER, FLAT, REG M4

20

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2119533-3

STRIPPER, SIDE FEED

19

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2119806-1

INSERT, SHEAR

13

-

1

1

1

1

1

3-22280-3

SPRING, COMPRESSION

12

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1

1

1

1

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1-356885-4

STOP, SHEAR

11

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1

1

1

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1

2119805-1

SHEAR HOLDER, FRONT

10

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1

1633861-1

SHEAR, FLOATING

9

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1633931-1

ANVIL, COMBINATION

8

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2119780-9

DEPRESSOR, SHEAR

5

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1-238011-6

BLOCK, CRIMPER SPACER

4

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2-1633962-4

CRIMPER, INSULATION F PREMIUM

3

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2-1633713-8

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

THIS IS SUBJECT TO CHANGE AND TO BE USED FOR THE PURPOSES OF THE DRAWING ONLY. FOR THE LATEST REVISIONS, CONTACT THE ORGANIZATION THAT ISSUED THIS DRAWING.

DWN

L.ZHANG

21MAY2012

CHK

L.ZHANG

21MAY2012

APVD

S.XI

21MAY2012

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2151672

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

B

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

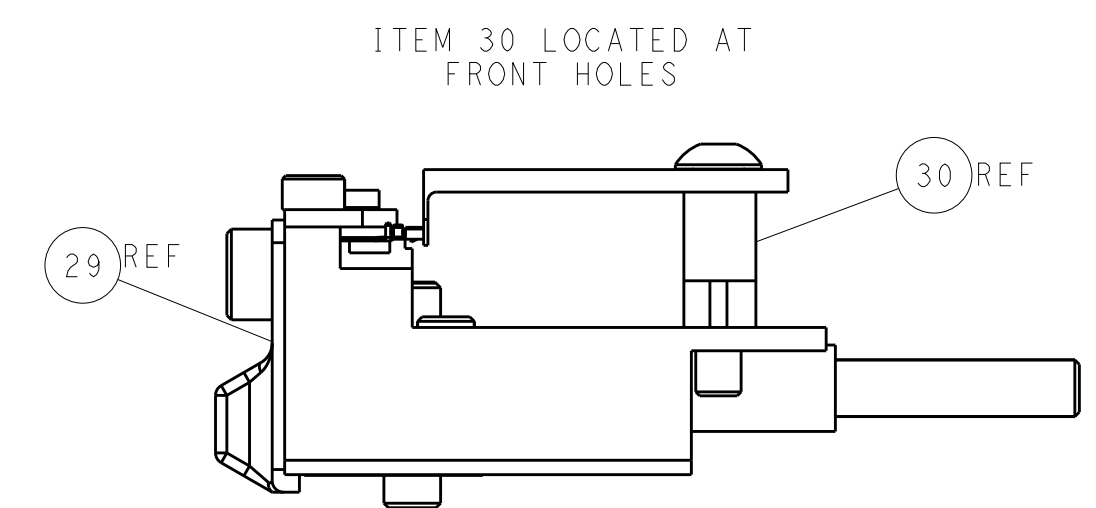
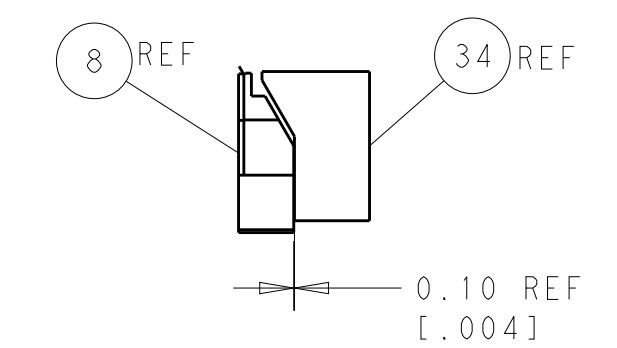
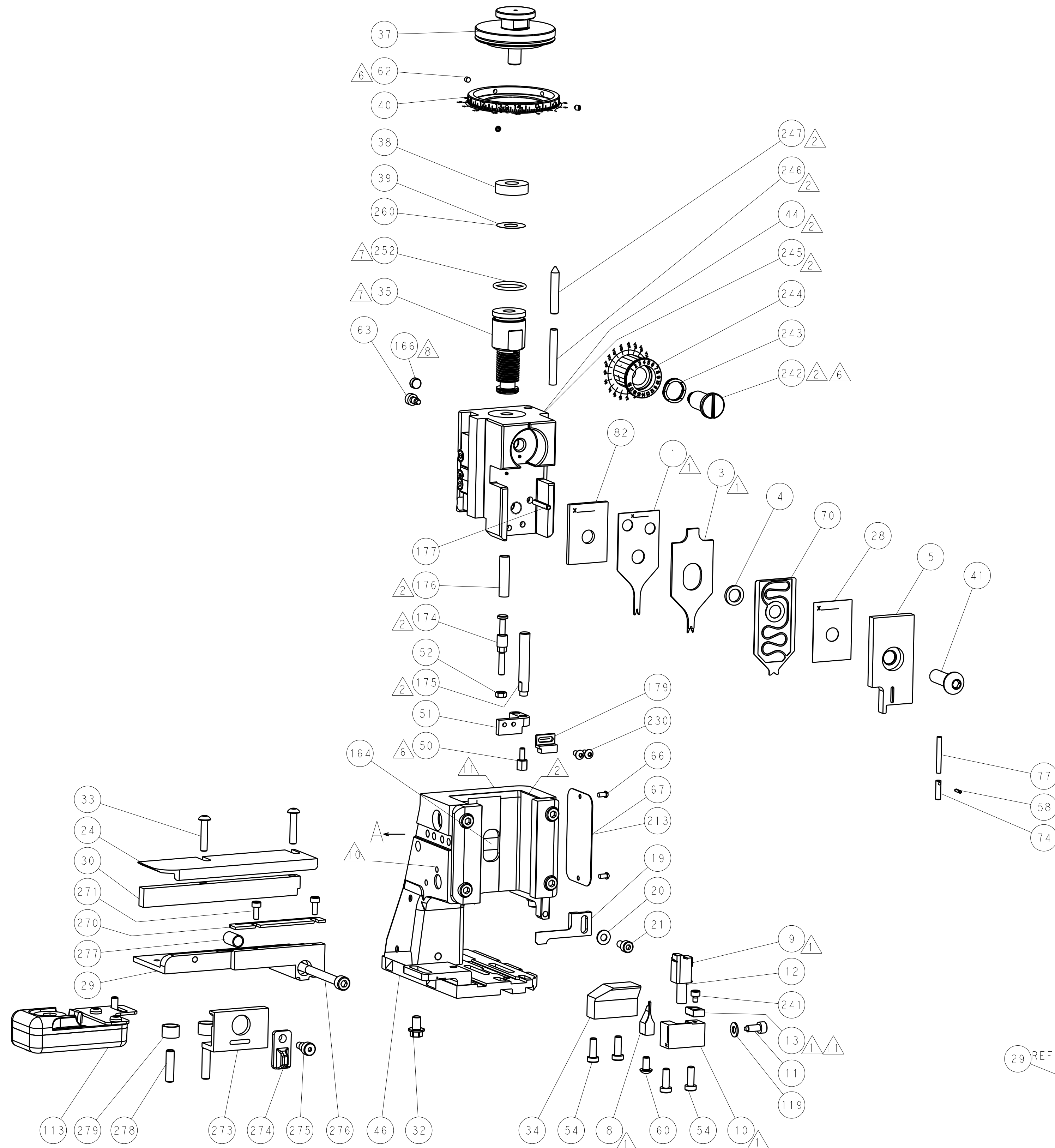
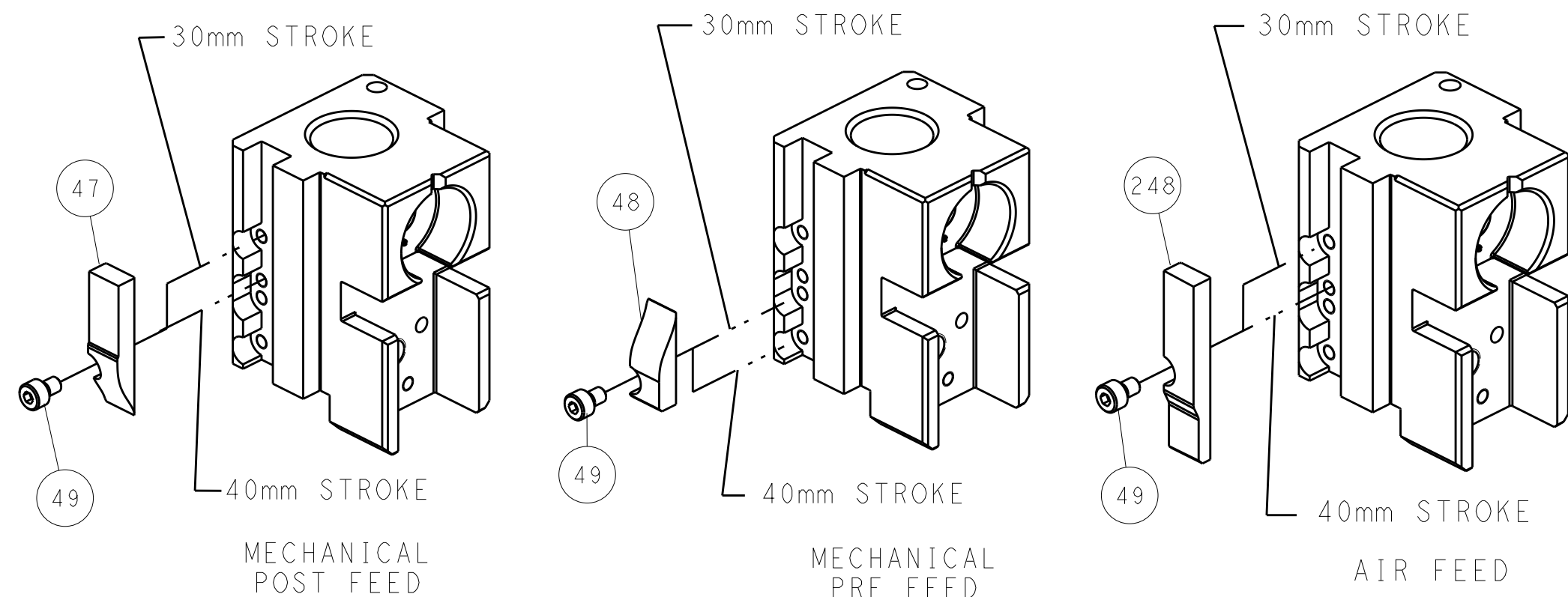
AMP 4805 REV 31MAR2000

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

PNEUMATIC

SERVO
LATCH PLATE

CAM POSITIONS



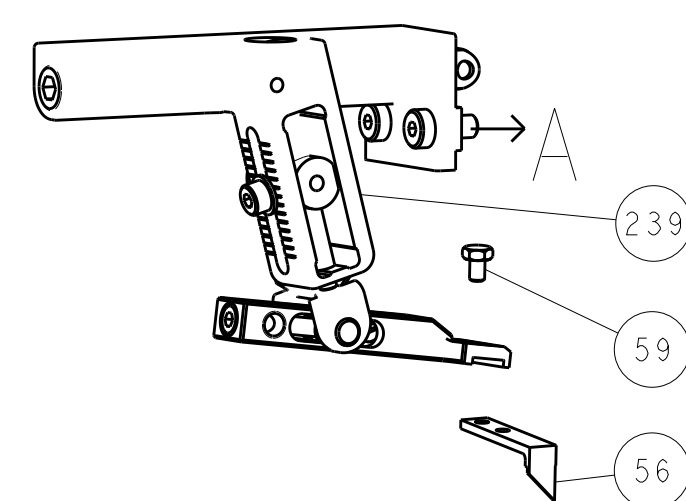
TERMINAL SUPPORT LOCATION

FEED TRACK POSITION
GUIDE BY TERMINAL BODY

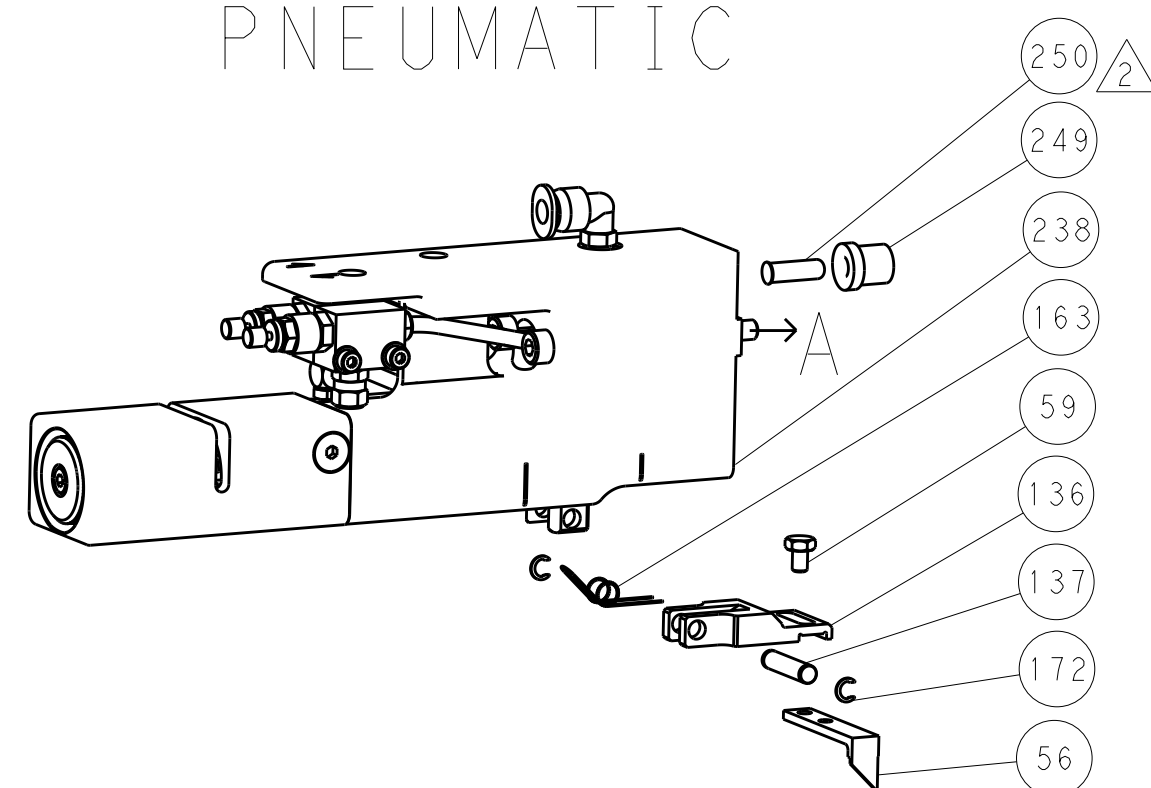
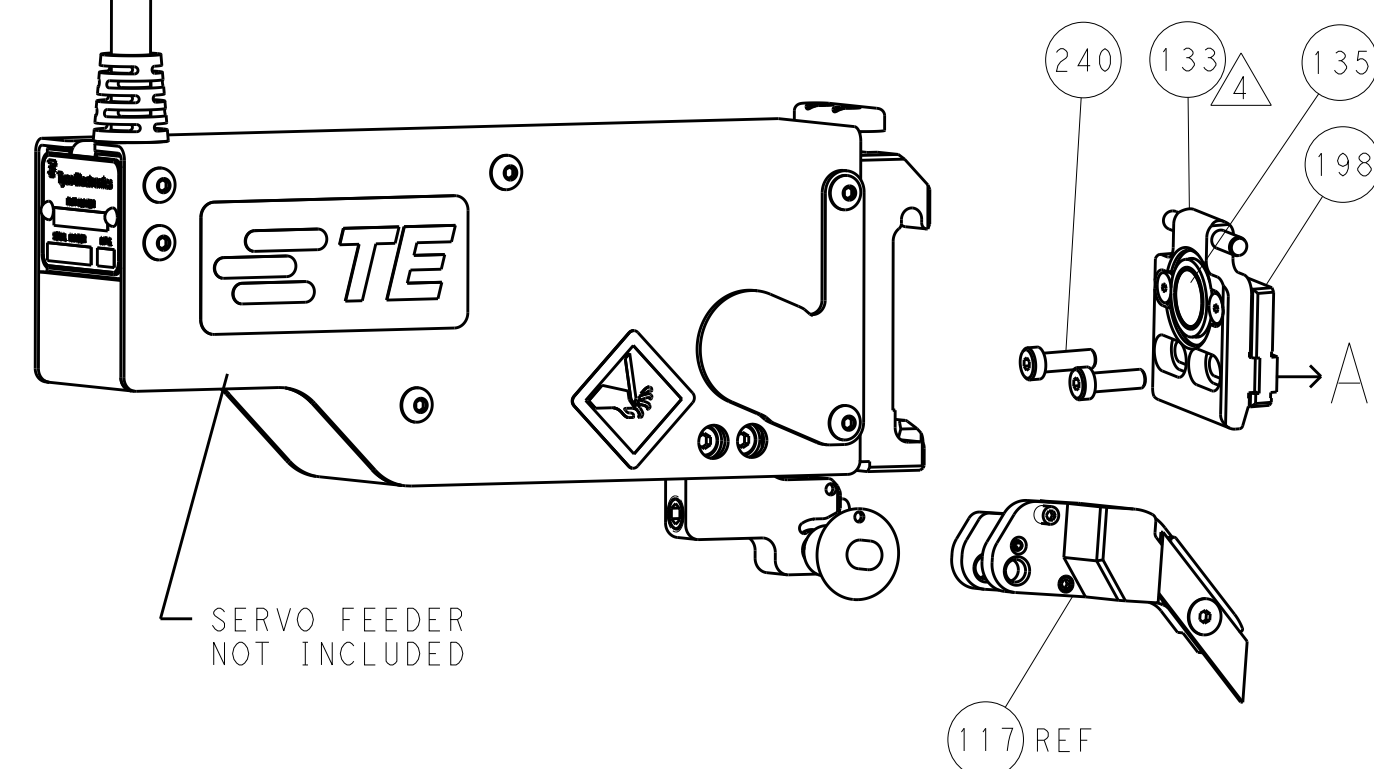
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE ENGINEERING CORPORATION IT IS SUBJECT TO CHANGES AND THE CONTROLLING ENGINEERING ORGANIZATION MAY BE CONTACTED FOR THE LATEST REVISION		DWN L ZHANG 21MAT2012				TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:		CHK L ZHANG 21MAT2012					
TOLERANCES UNLESS OTHERWISE SPECIFIED:		S X I 21MAT2012	NAME		Ocean Side Feed Applicator		
mm	0 PLC ±. 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001	PRODUCT SPEC	APPLICATION SPEC				
		SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO		
MATERIAL	FINISH	WEIGHT	A	00779	C=2151672	-	-
Customer Accessible Production Drawing			SCALE	1:2	SHEET	2 OF 4	REV B

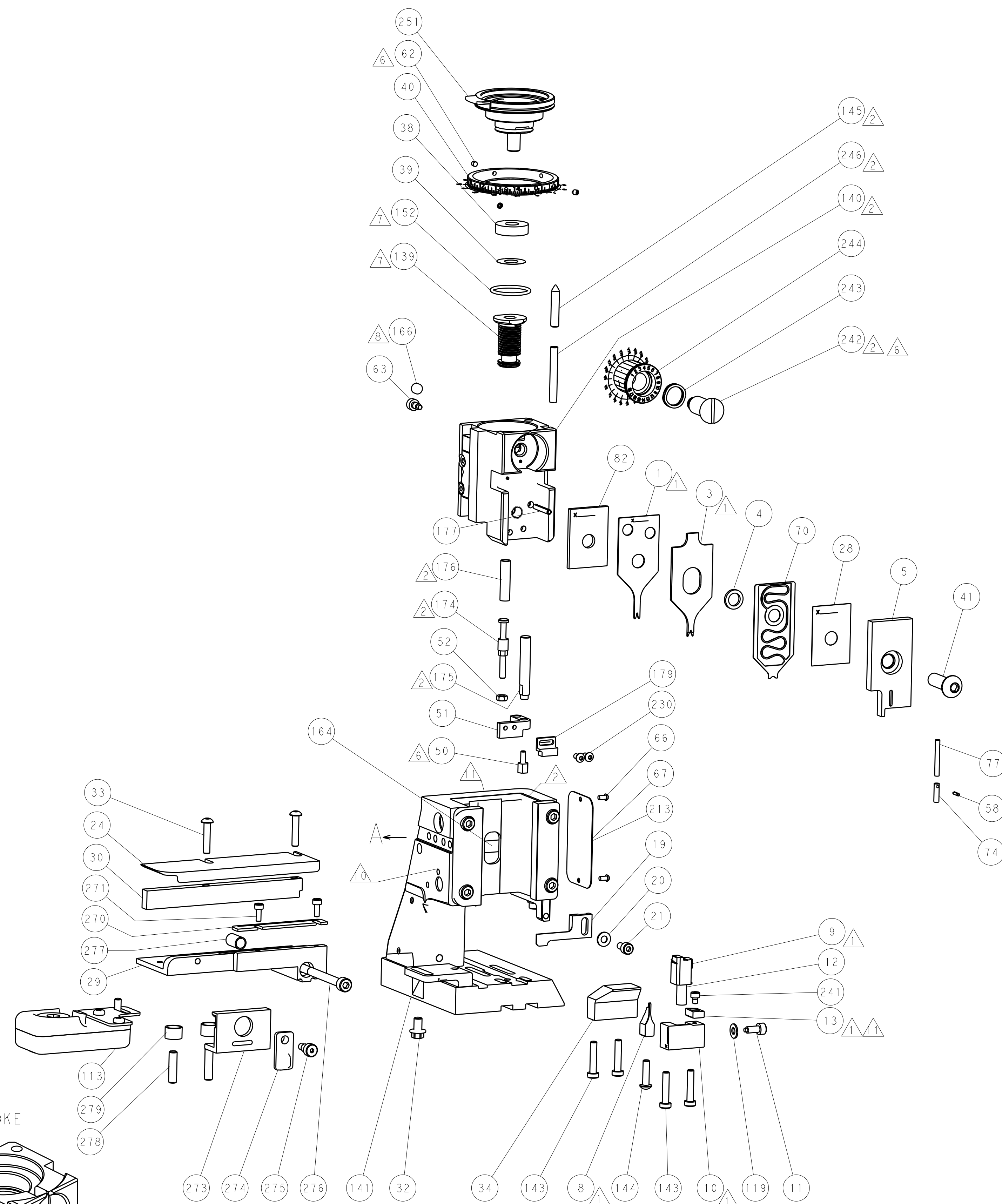
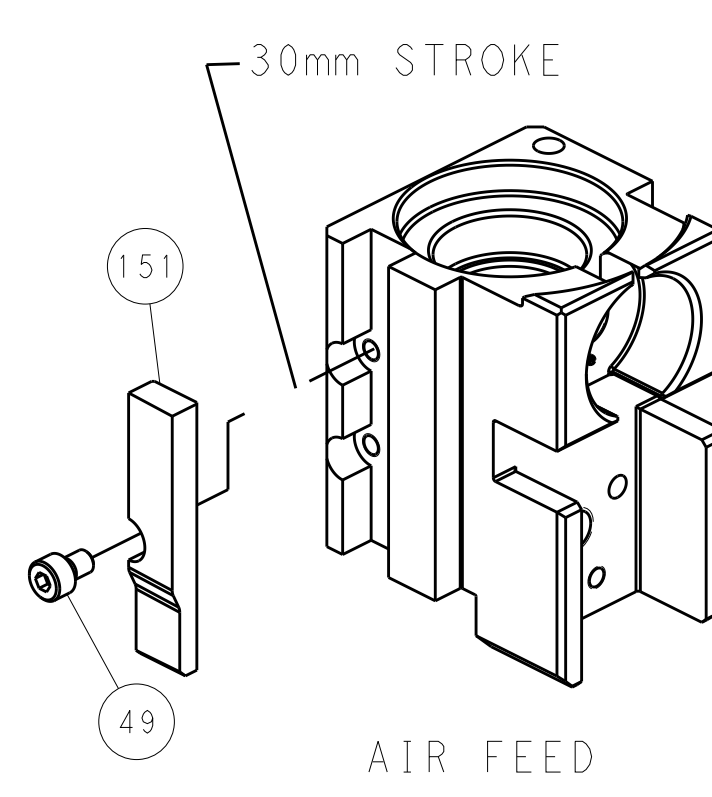
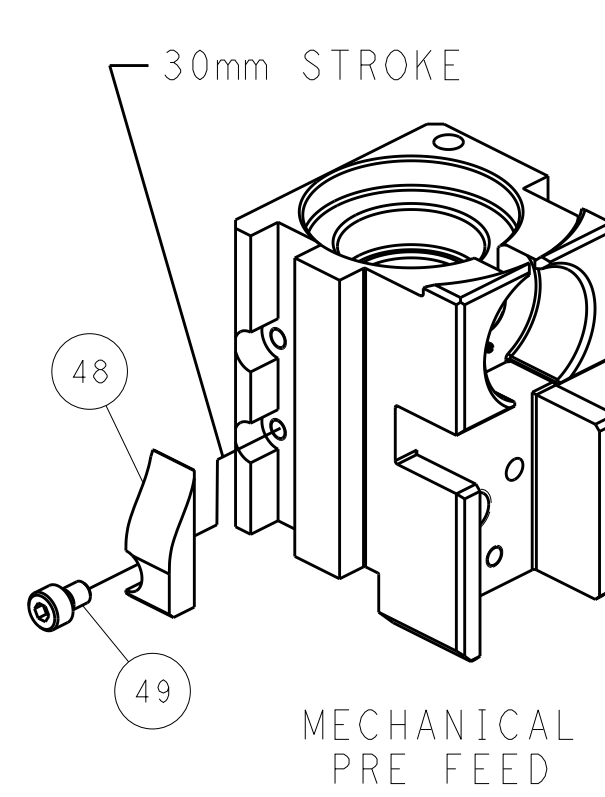
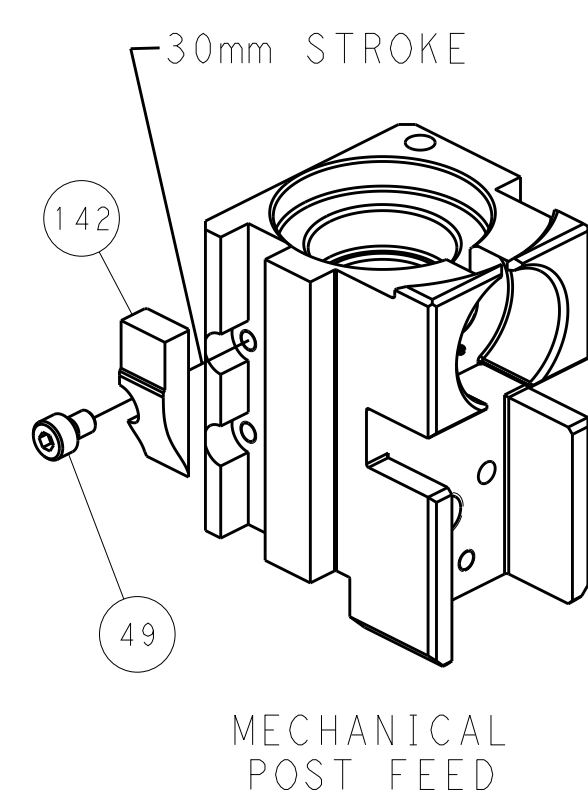
FEED TYPE
MECHANICAL



PNEUMATIC

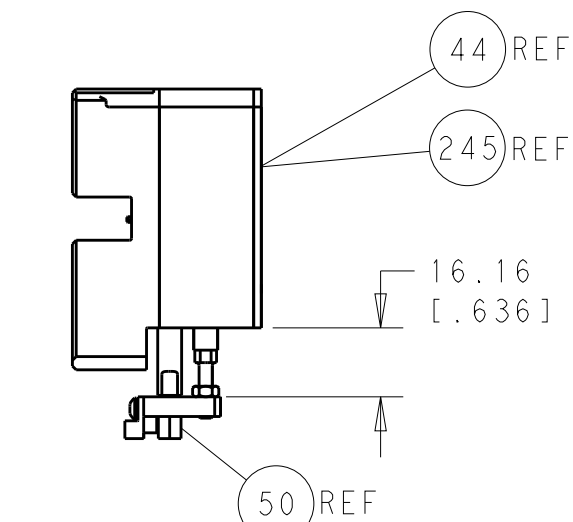
SERVO
LATCH PLATE

CAM POSITIONS

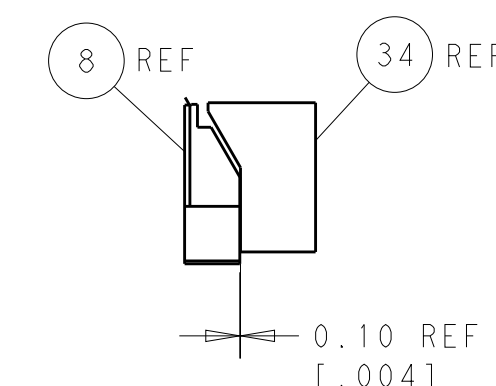


PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

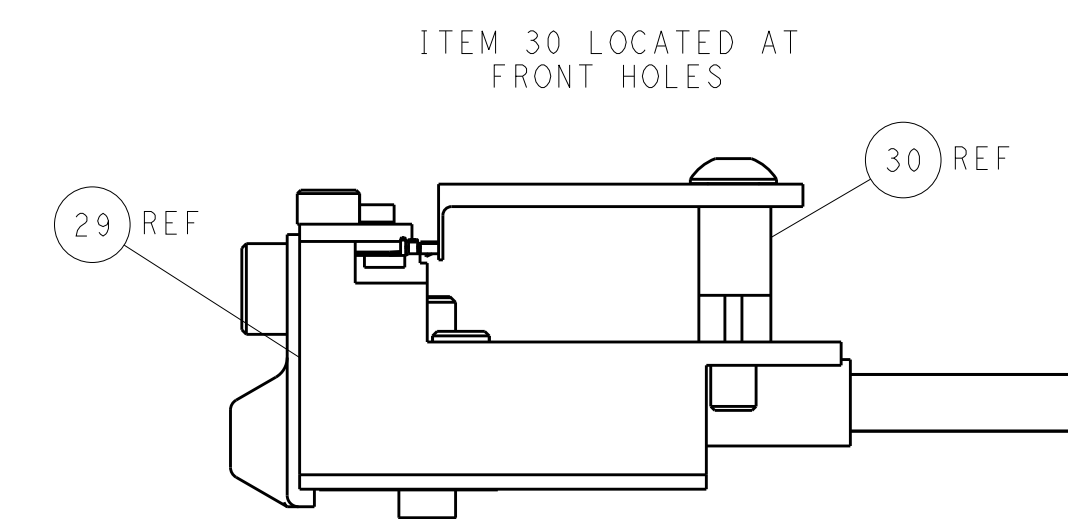
LOC		DIST		REVISIONS					
A		66		P	LTR	DESCRIPTION	DATE	DWN	APV
				-		SEE SHEET 1	-	-	-



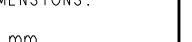
HOLDDOWN SET-UP



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY TERMINAL BODY

THIS DRAWING IS A CONTROLLED DOCUMENT FOR THE DEFENSES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION MAY BE CONTACTED FOR THE LATEST REVISION		DWN 21MAY2012 CHK L1ZHANG 21MAY2012 L1ZHANG 21MAY2012 SXY 21MAY2012		 TE Connectivity Morrisburg, PA 17105-3608	
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 ±		NAME Ocean Side Feed Applicator -	
MATERIAL -		PRODUCT SPEC APPLICATION SPEC -		SIZE A1 CAGE CODE 00779 DRAWING NO. C=2151672 RESTRICTED -	
FINISH -		WEIGHT -		SCALE 1:2 SHEET 1 OF 4 REV -	
Customer Accessible Production Drawing					