

8

7

6

5

4

3

2

1

THIS DRAWING IS UNPUBLISHED.

RELEASED FOR PUBLICATION

20

© COPYRIGHT 20

BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.

ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

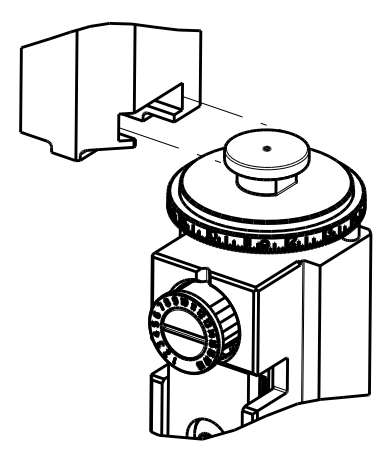
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151858-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED
SERVO LATCH PLATE
SMART APPLICATOR

2119950-1
2119951-1
2161326-1

1338685-1
-
-

5-18022-5
8-2151858-5
8-2151858-4

2119641-1
1901094-3
-

2119799-1
3-1752354-3
-

2063440-1
2168400-6 (QUANTITY 2)
-

2151858-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED
SERVO LATCH PLATE
SMART APPLICATOR

2119949-1
2119951-1
2161326-1

1338685-1
-
-

5-18022-5
8-2151858-5
8-2151858-4

2119653-1
1901094-3
-

-
3-1752354-3
-

-
2168400-6 (QUANTITY 2)
-

2151858-5

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

2151858-6

A

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹²

-
-

-
-

-
-

-
-

-
-

2151858-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

-

7-2151858-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 3.20 mm [1.26] F

INSUL 4.50 mm [1.77] F

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION

TERMINAL NAME: MINI FIT SR TERMINAL

WIRE STRIP LENGTH 4.25-4.75 mm [1.67-.187 IN] INSULATION DIAMETER RANGE 3.33 mm MAX [1.31 IN]

TERMINAL APPLICATION SPECIFICATION 63891-2000 Rev C

TERMINALS APPLIED

TE TERMINAL MOLEX TERMINAL TE TERMINAL MOLEX TERMINAL

1949242-1 42815-0041 1949243-3 42817-0141

1949242-2 42815-0042 1949243-4 42817-0142

1949242-3 42815-0040 1949243-5 42817-0040

1949242-4 42815-0049 1949243-6 42817-0049

1949243-1 42817-0041 1949243-7 42817-0140

1949243-2 42817-0042 1949243-8 42817-0149

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

14 AWG 1.94+/-0.05 [1.076+/-0.002] 6.2

16 AWG 1.87+/-0.05 [1.074+/-0.002] 6.9

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: 8-2151858-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151858-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151858-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151858-6

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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.86.

13 CUT TO LENGTH AT ASSEMBLY.

APPLICATOR STYLE CONVERSION CHART

PART NUMBERS REQUIRED

2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1

2119951-1 - 8-2151858-5 1901094-3 3-1752354-3 2168400-6 (QUANTITY 2)

2161326-1 - 8-2151858-4 - - -

2119949-1 1338685-1 5-18022-5 2119653-1 - - -

2119951-1 - 8-2151858-5 1901094-3 3-1752354-3 2168400-6 (QUANTITY 2)

2161326-1 - 8-2151858-4 - - -

2119949-1 1338685-1 5-18022-5 2119653-1 - - -

2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1

- - - - - - -

- - - - - - -

- - - - - - -

- - - - - - -

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

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

3 - - - - 1 2119580-1 MECHANICAL FEED ASSEMBLY 239

4 - - - - 1 2063440-1 AIR FEED MODULE 238

5 - - 1 1 - - 2119740-2 TAG, IDENTIFICATION 213

6 - - 1 1 - - 1901094-3 SPACER, FEEDER 198

7 - - - - 2 21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT 172

8 1 1 1 1 1 994969-1 MAGNET, RARE EARTH HIGH ENERGY 166

9 REF REF REF REF REF 994970-2 COUNTER, MAGNETIC 164

10 - - - - 1 240638-1 SPRING, FEED FINGER 163

11 - - - - 1 3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854 137

12 - - - - 1 2119799-1 HOLDER, FEED FINGER, AF 136

13 - - REF REF - - SEE NOTE 4 MEMORY CHIP, PROGRAMMED 135

14 - 1 1 - - 1633743-1 SERVO FEED LATCH ASM 133

15 1 1 1 1 1 1-18028-2 WASHER, FLAT, REG M4 119

16 - - REF REF - - 2119944-1 FEED FINGER ASSEMBLY, SF 117

17 1 1 1 1 1 1-690438-0 FRONT STRIP GUIDE 96

18 2 2 2 2 2 2168083-1 SCR, SKT HD CAP, RoHS, M3 X 8.0 95

19 1 1 1 1 1 455888-7 SPACER, CRIMPER 82

20 1 1 1 1 1 2119956-1 DOCUMENTATION PACKAGE 71

21 1 1 1 1 1 2119791-9 DEPRESSOR, WIRE 70

22 1 1 1 1 1 2119943-1 WASHER, SPACER 69

23 1 - - 1 1 2119740-1 TAG, IDENTIFICATION 67

24 2 2 2 2 2 2168078-1 SCREW, DRIVE, RH, RoHS 66

25 1 - 1 1 1 2119793-1 LIMITER, ADJUSTMENT BOLT 63

26 3 - 3 3 3 992763-5 SCR, SET, SOC, CONE POINT, M3 x 4.0 62

27 2 2 2 2 2 2-18032-5 SCR, SET, FLT POINT M5 X 20.0 61

28 1 1 1 1 1 2079383-4 SCR, BHSC, RoHS (M4 X 8) 60

29 - - - - 1 1 5-18022-5 SCR, HEX HD CAP, M4 X 6.0 59

30 - - - - 1 1 1338685-1 PAWL, FEED 56

31 4 4 4 4 4 2168400-1 SHCS, LOW HEAD, RoHS, M4 X 12 54

32 2 2 2 2 2 2168083-9 SCR, SKT HD CAP, RoHS, M4 X 20 53

33 1 1 1 1 1 5018030-1 NUT, HEX, REG, RoHS, M3 52

34 1 1 1 1 1 1-811242-0 BUMPER, HOLD DOWN 51

35 1 1 1 1 1 690753-2 SPACER, TONKER 50

36 - - - - 1 2 18023-9 SCR, SKT HD CAP M4 X 6.0 49

37 - - - - 1 2119652-1 FEED CAM, PRE FEED 48

38 - - - - 1 2119653-1 FEED CAM, POST FEED 47

39 1 1 1 1 1 2119656-9 APPLICATOR BASIC ASSEMBLY, SF 46

40 1 - 1 1 1 2119370-1 RAM, AMP STYLE, SIDE FEED 44

41 1 1 1 1 1 2079383-7 SCR, BHSC, RoHS (M8 X 25) 41

42 1 - 1 1 1 1 2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT 40

43 1 - 1 1 1 1 2119957-1 APPLICATOR SHIM PACK 39

44 1 1 1 1 1 2119644-2 RAM WASHER, PRECISION 38

45 1 1 1 1 1 2119085-1 FA HEAD, ATLANTIC STYLE 37

46 1 - 1 1 1 1 2119092-1 BOLT, ADJUSTMENT 35

47 1 1 1 1 1 1752356-3 SUPPORT, TERMINAL 34

48 2 2 2 2 2 2079383-5 SCR, BHSC, RoHS (M4 X 20) 33

49 1 1 1 1 1 2161328-1 HEX HEAD, FLANGED, M5 x 8mm LONG 32

50 1 1 1 1 1 1-1320908-8 SPACER, STRIP GUIDE 30

51 1 1 1 1 1 2119959-3 ASSEMBLY, STRIP GUIDE 29

52 1 1 1 1 1 1-455888-0 SPACER, CRIMPER 28

53 2 2 2 2 2 22283-1 SPRING, COMPRESSION 27

54 1 1 1 1 1 356835-1 LEVER, DRAG RELEASE 26

55 1 1 1 1 1 240792-2 DRAG, TERMINAL 25

56 1 1 1 1 1 1320928-6 STRIP GUIDE 24

57 1 1 1 1 1 980371-4 SCR, SKT HD SHLDR 5.0 DIA X 6.0 23

58 1 1 1 1 1 2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0 21

59 1 1 1 1 1 1-18028-2 WASHER, FLAT, REG M4 20

60 1 1 1 1 1 2119533-1 STRIPPER, SIDE FEED 19

61 1 1 1 1 1 2119806-1 INSERT, SHEAR 13

62 1 1 1 1 1 3-22280-3 SPRING, COMPRESSION 12

63 1 1 1 1 1 1-356885-4 STOP, SHEAR 11

64 1 1 1 1 1 2119805-1 SHEAR HOLDER, FRONT 10

65 1 1 1 1 1 462006-6 FLOATING SHEAR, FRONT 9

66 1 1 1 1 1 3-1633927-1 ANVIL, COMBINATION 8

67 1 1 1 1 1 2-240641-3 SPACER 7

68 - - - - - - - 6

69 1 1 1 1 1 1-2119757-1 DEPRESSOR, SHEAR 5

70 1 1 1 1 1 238011-8 BLOCK, CRIMPER SPACER 4

71 1 1 1 1 1 7-2119582-1 CRIMPER, INSULATION F PREMIUM 3

72 1 1 1 1 1 1-455888-0 SPACER, CRIMPER 2

73 1 1 1 1 1 4-1633738-8 CRIMPER, WIRE 1

74 -77 -7 -6 -5 -2 -1 PART NO DESCRIPTION ITEM NO

111 IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE MANUFACTURING ORGANIZATION. ANY CHANGES TO THIS DRAWING MUST BE CONTROLLED BY THE MANUFACTURING ORGANIZATION. NO CHANGES TO THIS DRAWING SHALL BE CONTACTED FOR THE LATEST EDITION.

DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±.1 FINISH

MATERIAL

DWN 30JAN2013

CHK T.ELBIN

APVD T.ELBIN 31JAN2013

PRODUCT SPEC

APPLICATION SPEC

WEIGHT

Customer Accessible Production Drawing

SCALE 1:1

SHEET 1 OF 4

REV A

NAME Ocean Side Feed Applicator

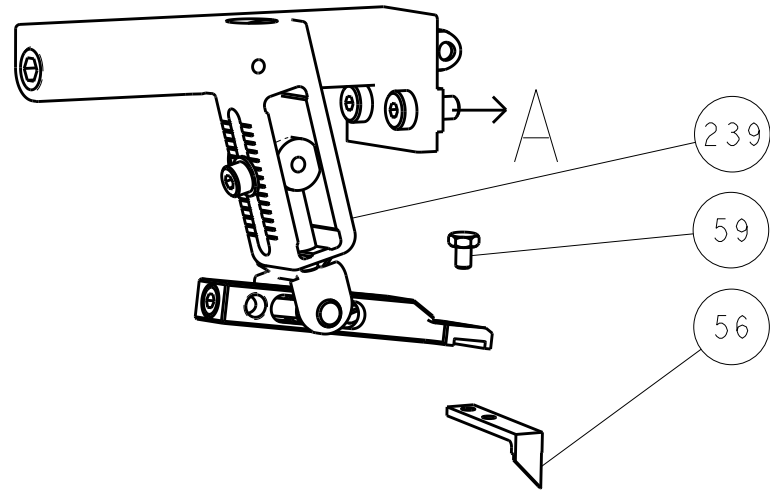
SIZE CAGE CODE DRAWING NO 00779 ©=2151858

RESTRICTED TO

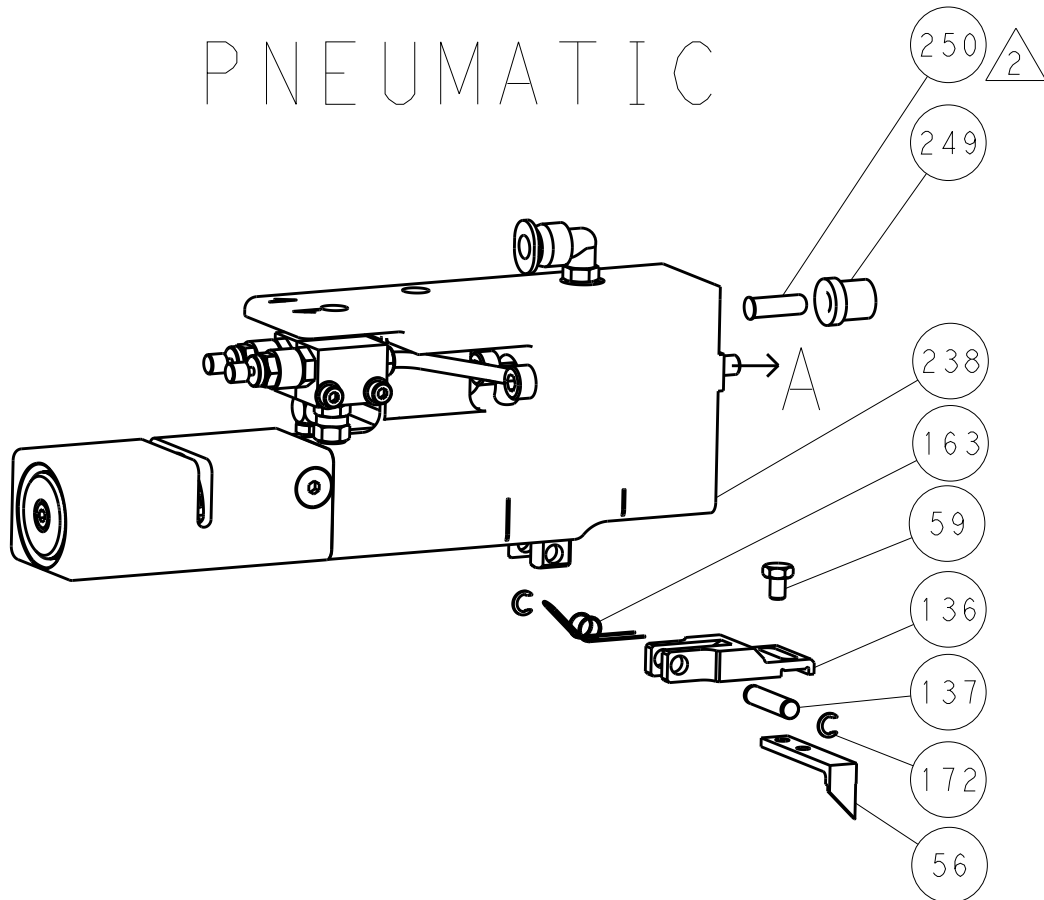
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

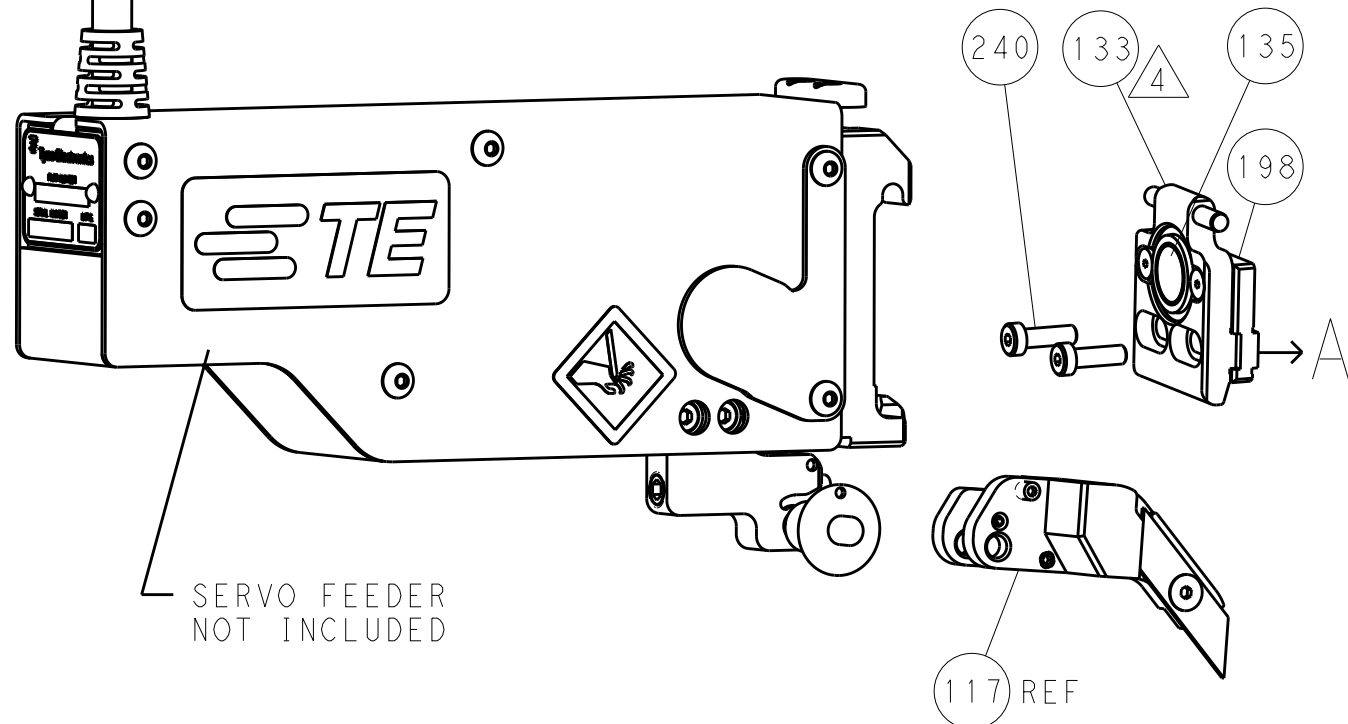
FEED TYPE
MECHANICAL



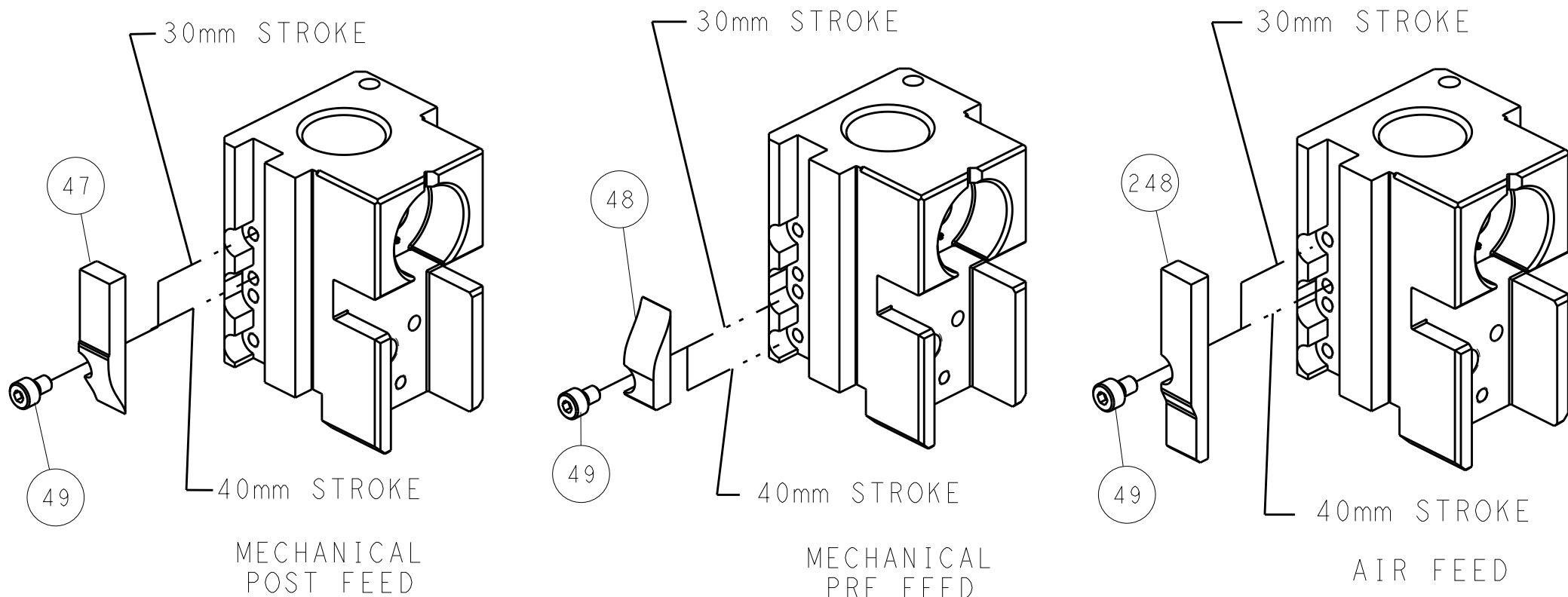
PNEUMATIC



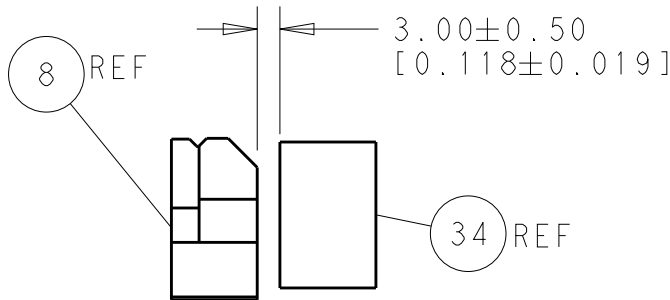
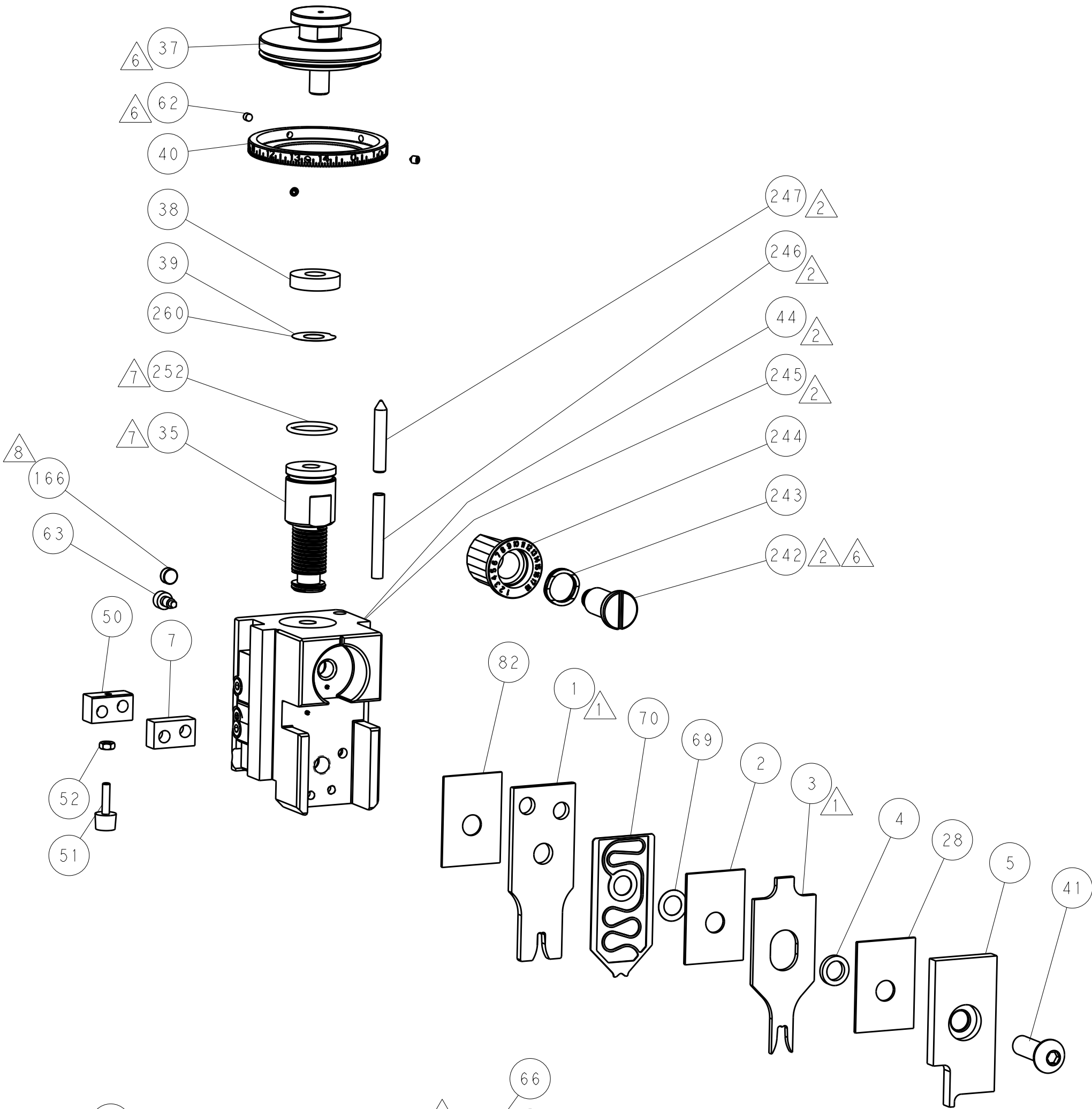
SERVO
LATCH PLATE



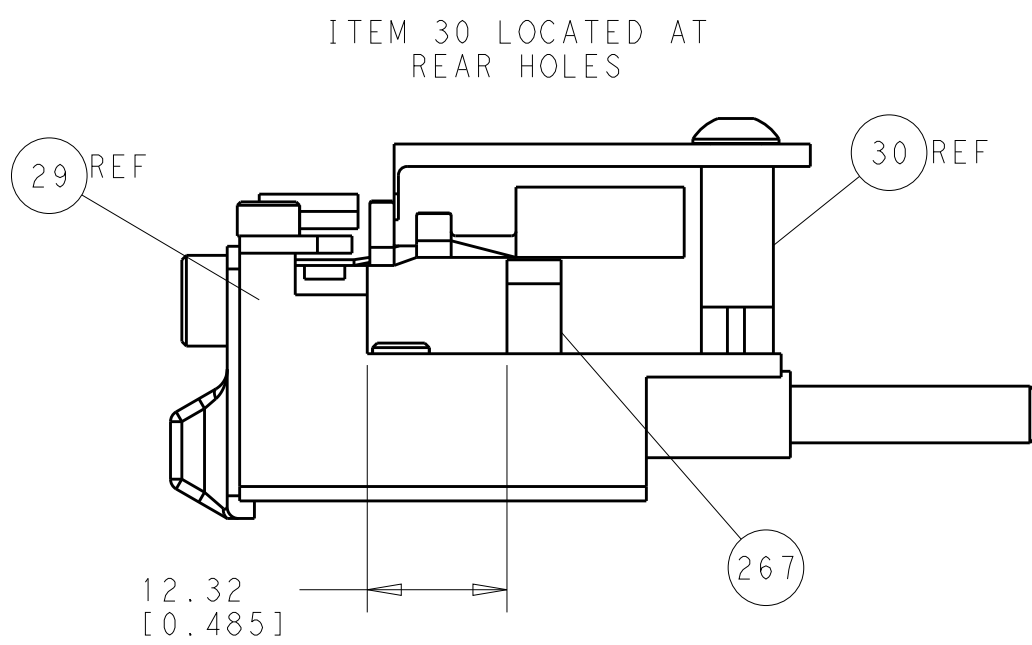
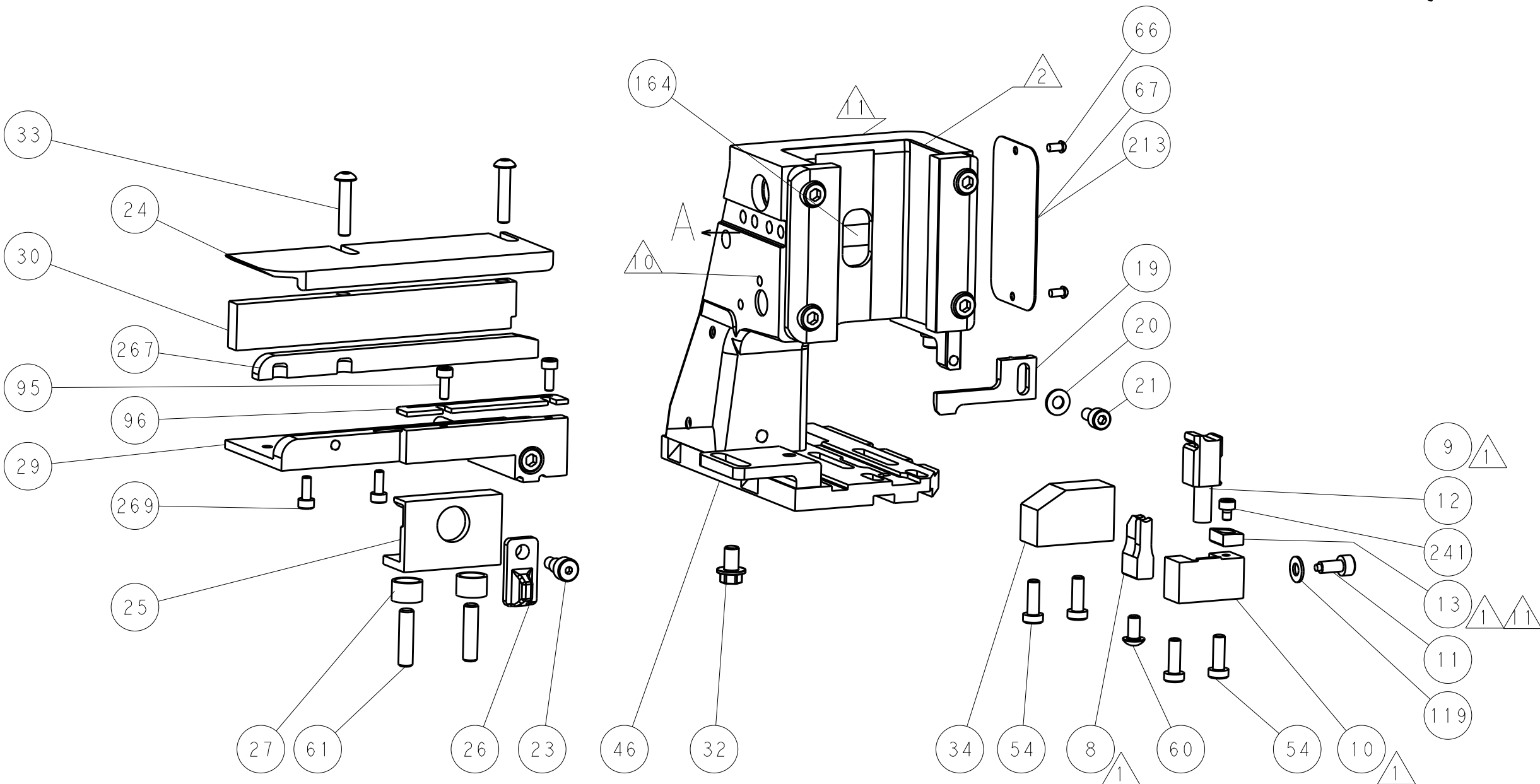
CAM POSITIONS



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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: HOFFNER 30JAN2013		TE Connectivity	
mm		0 PLC ±0.1		CHK: TELBIN 31JAN2013		Harrisburg, PA 17105-3608	
APVD: TELBIN 31JAN2013		1 PLC ±0.02		NAME: Ocean Side Feed		APVD: TELBIN 31JAN2013	
MATERIAL: -		2 PLC ±0.005		PRODUCT SPEC: -		SIZE: CAGE CODE: DRAWING NO: 00779	
		3 PLC ±0.0005		APPLICATION SPEC: -		RESTRICTED TO: -	
		4 PLC ±0.0005		WEIGHT: -		SCALE: 1:1	
		FINISH: -		Customer Accessible Production Drawing		SHEET 2 OF 4	
						REV A	

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

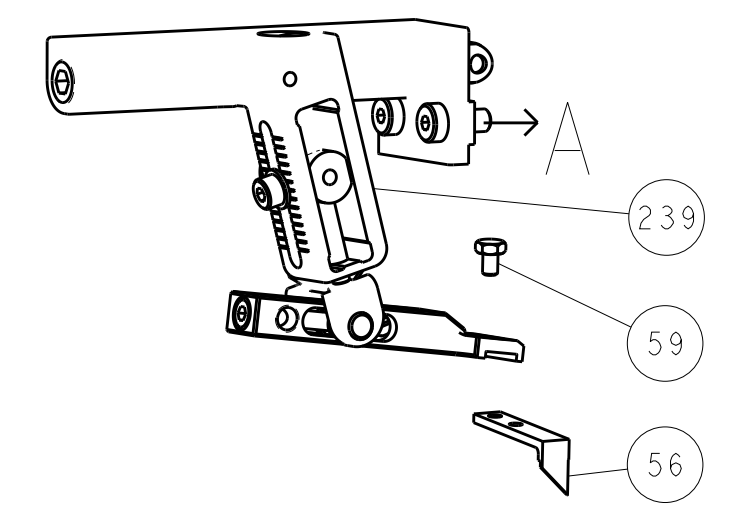
A

B

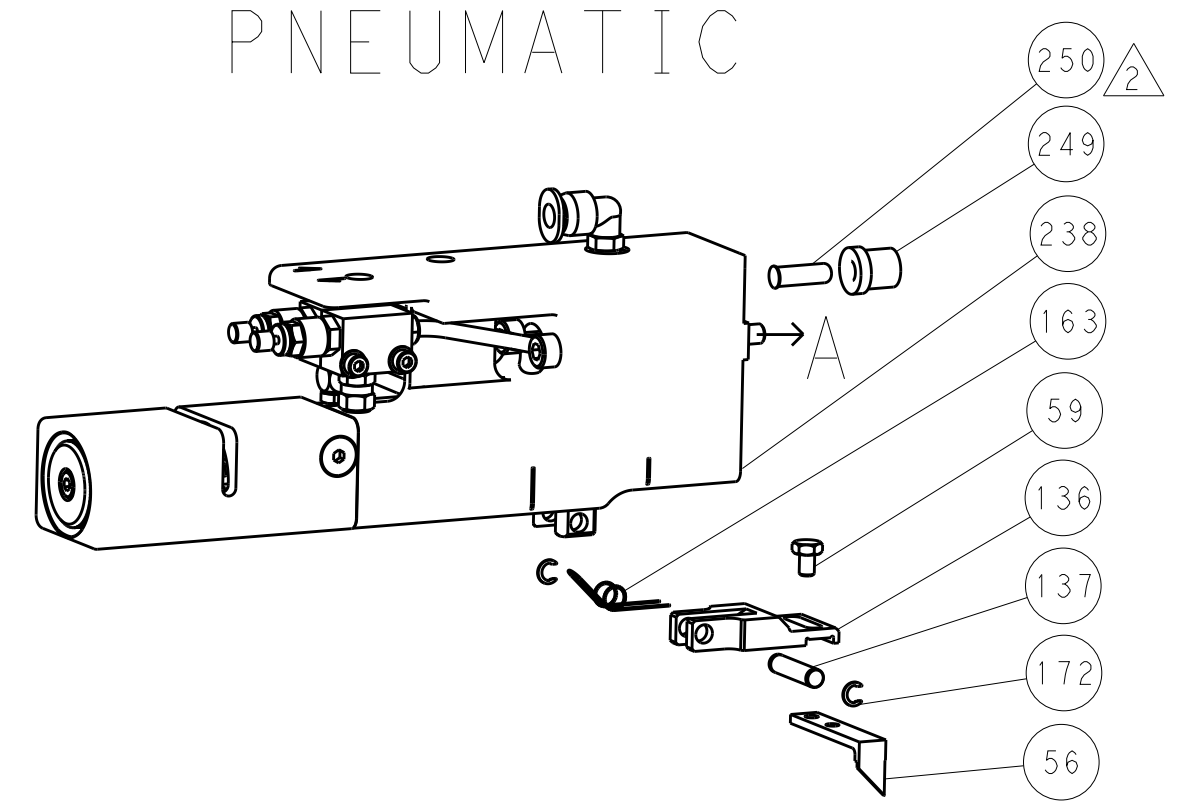
C

D

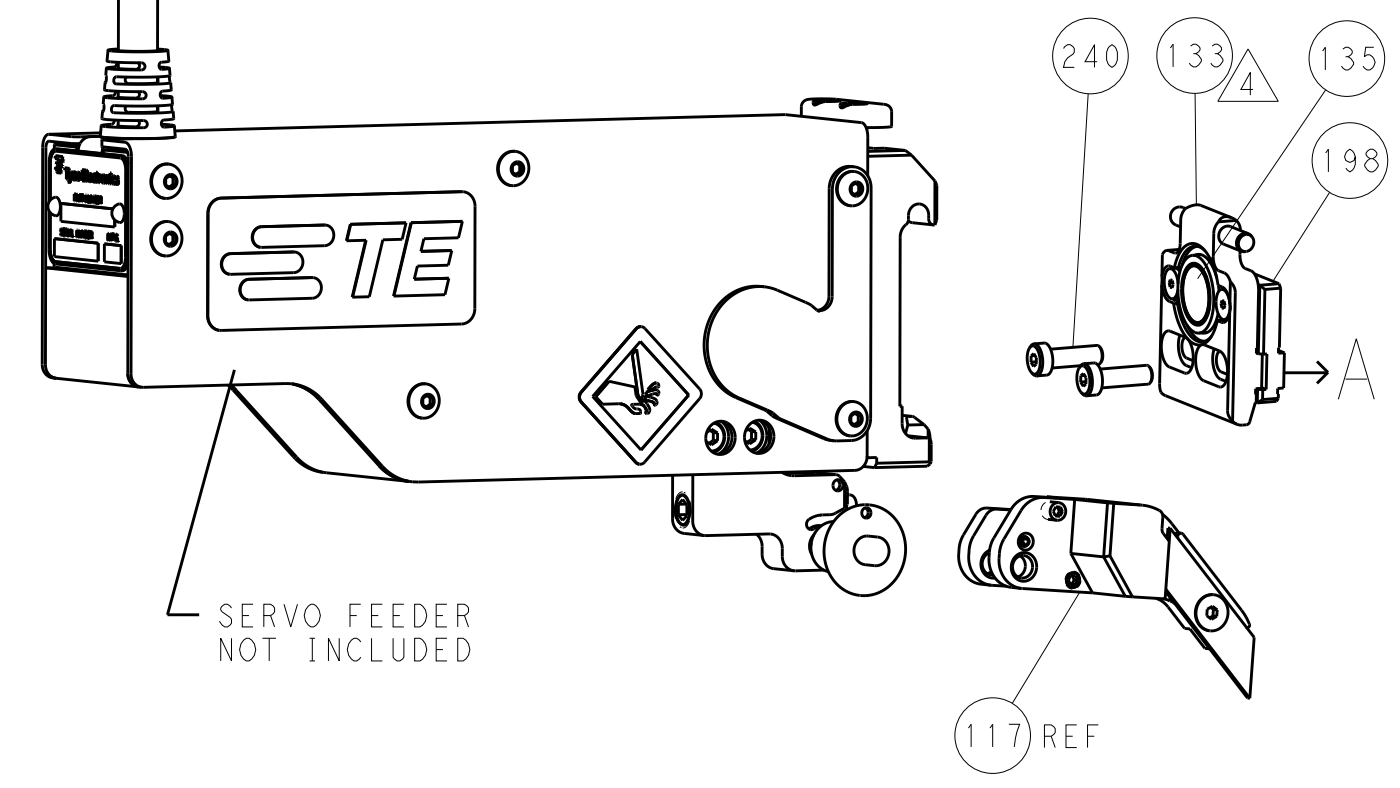
FEED TYPE MECHANICAL



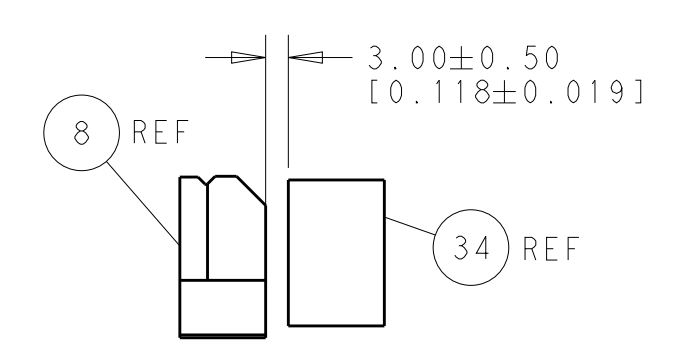
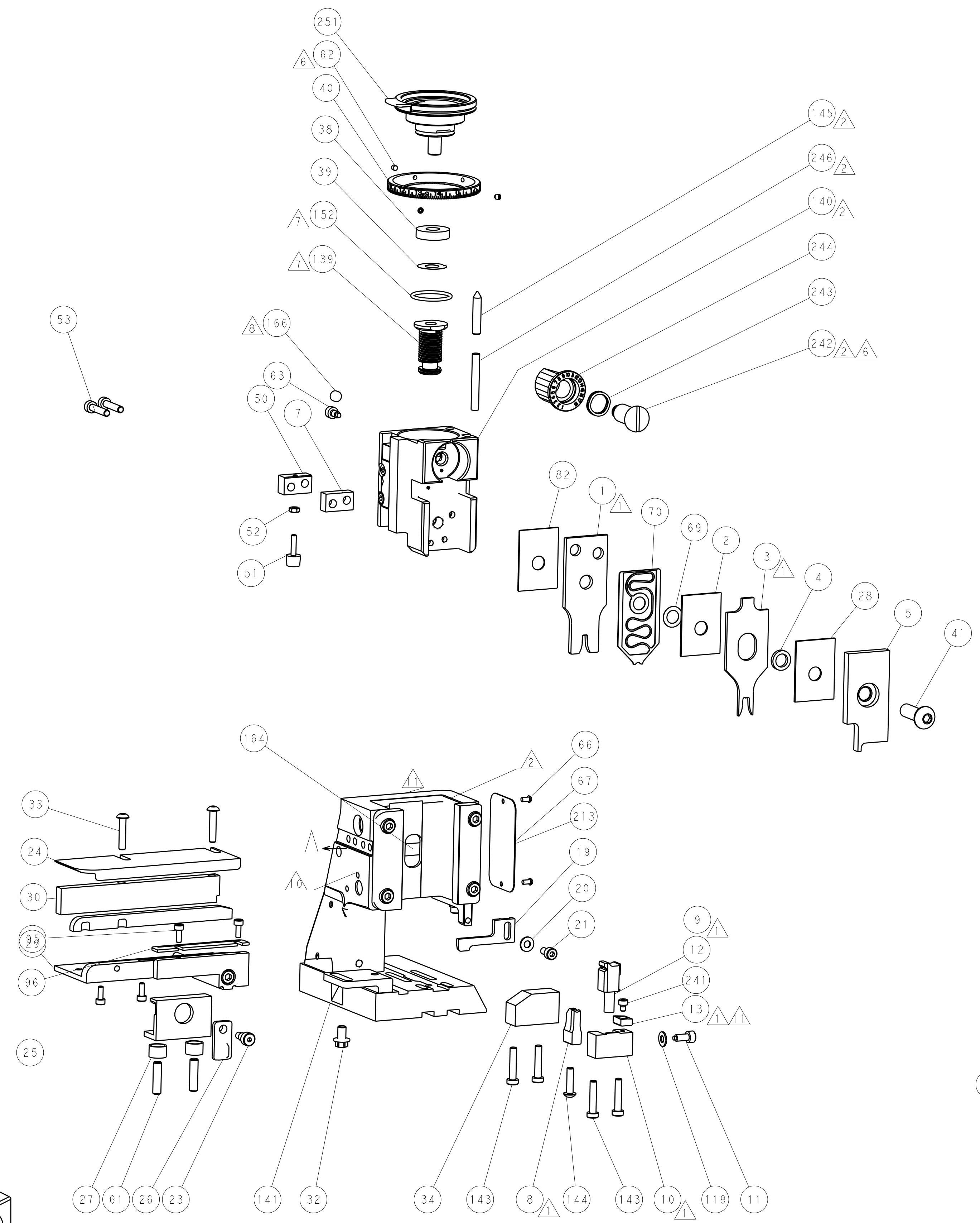
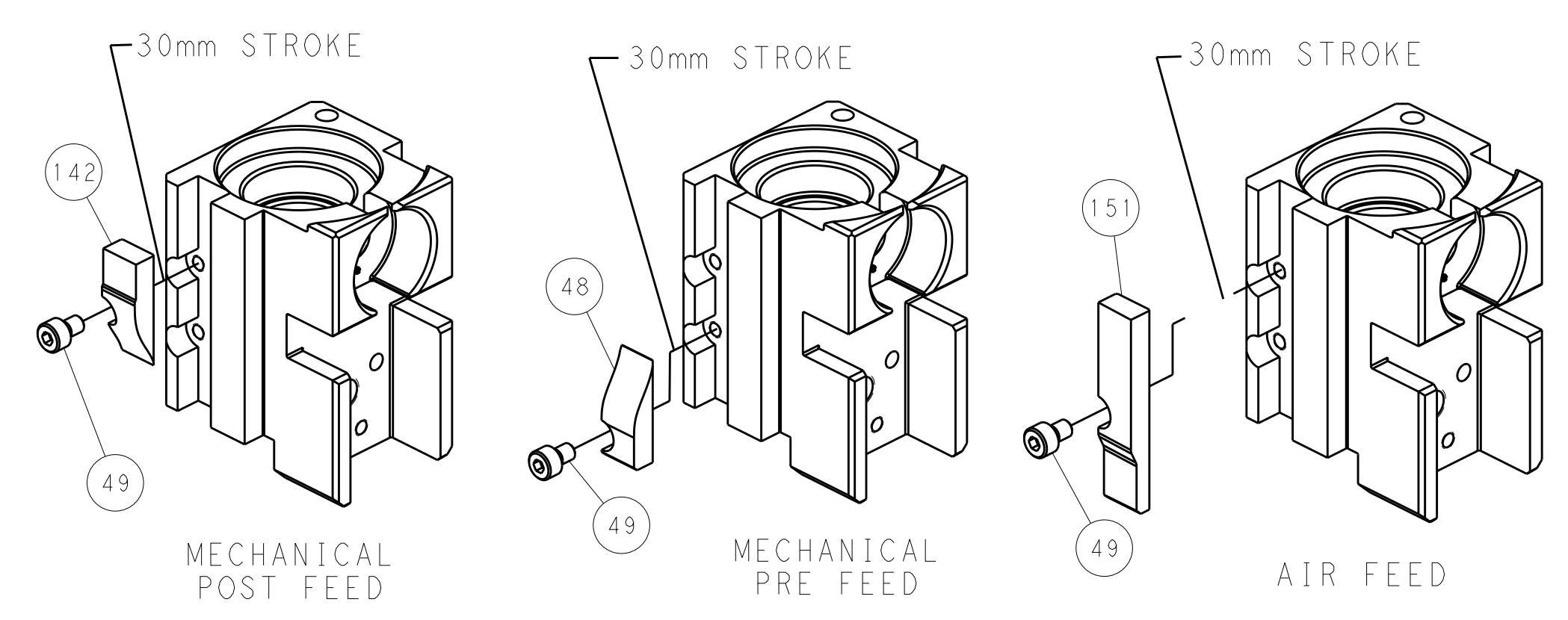
PNEUMATIC



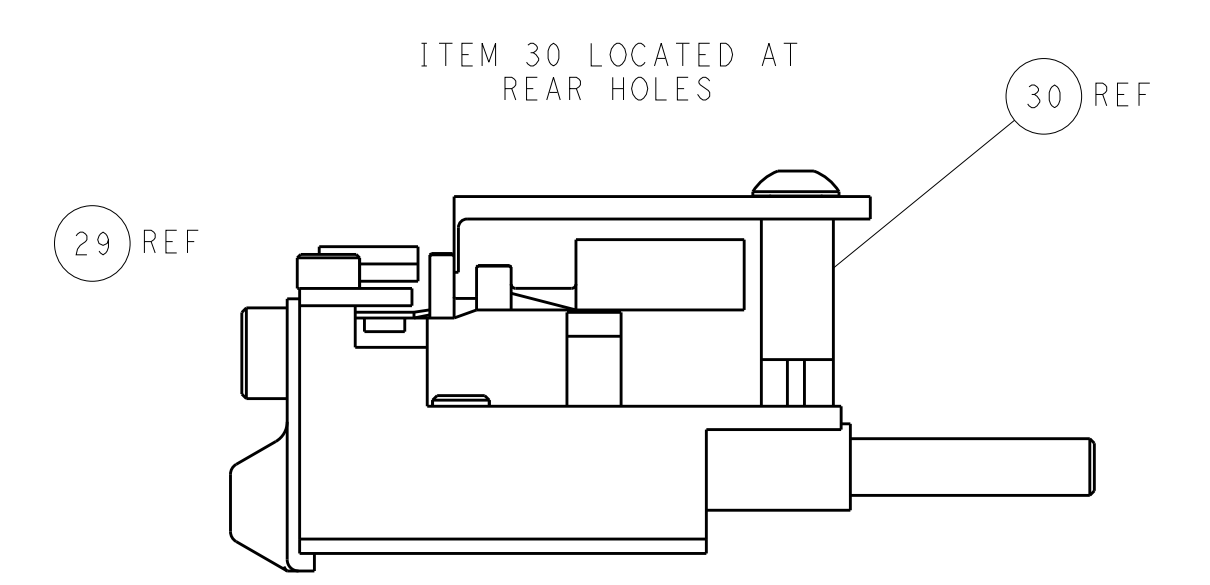
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



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:		OWN: HOFFNER 30JAN2013		TE Connectivity	
mm		0 PLC ±0.1		CHK: T.ELBIN 31JAN2013		Harrisburg, PA 17105-3608	
Ø		1 PLC ±0.02		APVD: T.ELBIN 31JAN2013		NAME: Ocean Side Feed Applicator	
MATERIAL: -		2 PLC ±0.005		PRODUCT SPEC: -		SIZE: CAGE CODE: DRAWING NO: 00779 ©=2151858	
FINISH: -		3 PLC ±0.0005		APPLICATION SPEC: -		RESTRICTED TO: -	
ANGLES: -		4 PLC ±0.0005		WEIGHT: -		Customer Accessible Production Drawing	
SCALE: 1:1		SHEET: 4 OF 4		REV: A		REV: A	