

8

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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

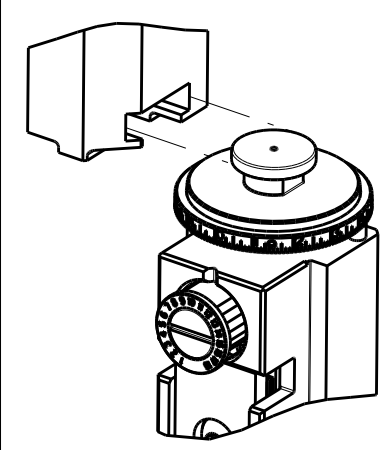
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151944-1

B

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151944-5

8-2151944-4

2119641-1

1901094-3

-

2119799-1

1-1752354-8

-

2063440-1

2168400-6 (QUANTITY 2)

-

2151944-2

B

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151944-5

8-2151944-4

2119653-1

1901094-3

-

-

-

-

-

-

-

-

-

-

2168400-6 (QUANTITY 2)

-

-

2151944-5

B

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

-

1338685-1

-

-

5-18022-5

5-18022-5

-

2119653-1

2119641-1

-

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-

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2063440-1

-

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2151944-6

B

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

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2151944-7

B

FINE CRIMP HEIGHT ADJUST

NONE

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7-2151944-7

A

CRIMP TOOLING KIT

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-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.70 mm [.067]

F

INSUL

2.10 mm [.083]

O

APPLICATOR INSTRUCTIONS

408-10389



TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION

TERMINAL NAME: TAXI TERM F OCS 1.2

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

3.77-3.79 mm [.149-.149 IN]

Ø1.86-2.40 mm [.073-.094 IN]

TERMINAL APPLICATION SPECIFICATION

13627887 Rev -

-

-

TERMINALS APPLIED

TE TERMINAL

DELPHI TERMINAL

TE TERMINAL

DELPHI TERMINAL

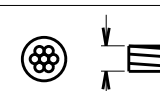
2113341-1

13627887

-

-

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



1.00mm2

1.15+/-0.05 [.045+/- .002]

5.6

0.80mm2

1.05+/-0.05 [.041+/- .002]

6.8



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: 8-2151944-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151944-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151944-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151944-6

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 62,180
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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 A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.65.

*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.

-	-	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
-	-	-	-	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	2119082-4	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
-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

OWN

APVD

A

RELEASED

24MAY2013

RW

TE

B

ECR-15-006686

23APR2015

KH

UG

-

-

-

-

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

1-1752354-8

STANDOFF,HOLD-DOWN

180

-

1

1

1

1

1

993111-1

PIN, SLOTTED SPRING 3.0 X 20.0

177

-

1

1

1

1

1

8-22280-7

SPRING, COMPRESSION

176

-

1

1

1

1

1

1752353-2

GUIDE PIN,HOLDDOWN

175

-

1

1

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1

1

1901680-2

GUIDE PIN,HOLDDOWN

174

-

-

-

-

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

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-

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1

-

240638-1

SPRING, FEED FINGER

163

-

-

-

-

1

-

3-23627-7

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

137

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1

-

2119799-1

HOLDER,FEED FINGER, AF

136

-

-

REF

REF

-

-

SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

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-

1

1

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1633743-1

SERVO FEED LATCH ASM

133

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1

1

1

1

1

1-22281-8

SPRING, COMPRESSION

121

-

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

1-690438-0

FRONT STRIP GUIDE

96

-

2

2

2

2

2

2168083-1

SCR, SKT HD CAP, RoHS, M3 X 8.0

95

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1

1

1

1

1

2168083-6

SCR, SKT HD CAP, RoHS, M5 X 65

93

-

1

1

1

1

1

455888-5

SPACER, CRIMPER

82

-

1

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

1

1

1

1

2119791-5

DEPRESSOR, WIRE

70

-

1

-

-

1

1

2119740-1

TAG,IDENTIFICATION

67

-

2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

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1

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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

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2

2

2

2

2

2-18032-5

SCR, SET, FLT POINT M5 X 20.0

61

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1

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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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-

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1

1

1338685-1

PAWL, FEED

56

-

4

4

4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

-

1

1

1

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1

1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

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1

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1

1901681-1

HOLDDOWN, TERMINAL

51

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2

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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1

2119653-1

FEED CAM, POST FEED

47

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2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

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1

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2119370-1

RAM, AMP STYLE, SIDE FEED

44

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1

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2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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1

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2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

-

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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1

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2119092-1

BOLT, ADJUSTMENT

35

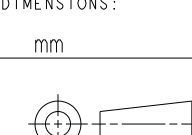
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1

 1 | 1 | 1 | 1 | 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	1901086-1	PLATE, STRIP GUIDE	29
-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	240792-5	DRAG, TERMINAL	25
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	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	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	1803095-3	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1-1803054-1	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	5-238011-5	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	2-1633966-0	CRIMPER, INSULATION O	3
-	1	1	1	1	1	455888-8	SPACER, CRIMPER	2
1	1	1	1	1	1	7-568176-7	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

THIS IS SUBJECT TO CHANGE AND DOES NOT CONSTITUTE A COMMITMENT. ANY CHANGES TO THIS DRAWING WILL BE NOTIFIED BY A REVISION. FOR THE LATEST REVISION, CONTACT YOUR SELLER OR THE ORGANIZATION THAT ISSUED THIS DRAWING.

DIMENSIONS:
mm



0 PLC
1 PLC
2 PLC
3 PLC
4 PLC
ANGLES

±.5
±0.13
±0.013
±0.0001

±.

MATERIAL

-

FINISH

-

DRAWN

R.O.WILSON

01MAY2013

CHEK

K.J.STAKEM

01MAY2013

APVD

T.L.FLIN

01MAY2013

NAME

Ocean Side Feed
Applicator

PRODUCT SPEC

-

APPLICATION SPEC

-

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

A1

00779

©=2151944

-

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

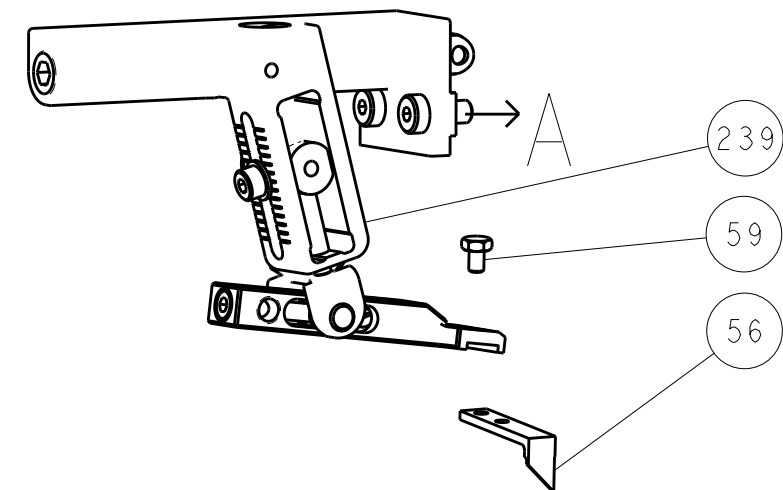
REV

B

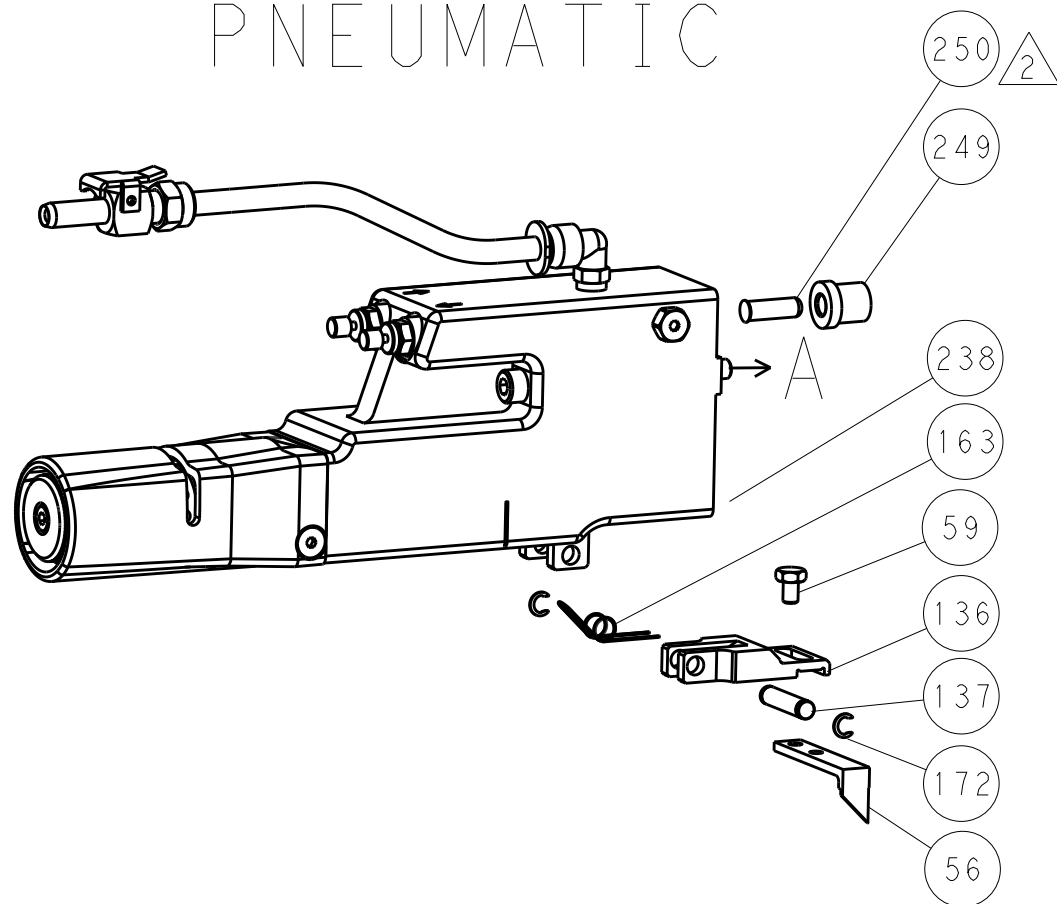
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

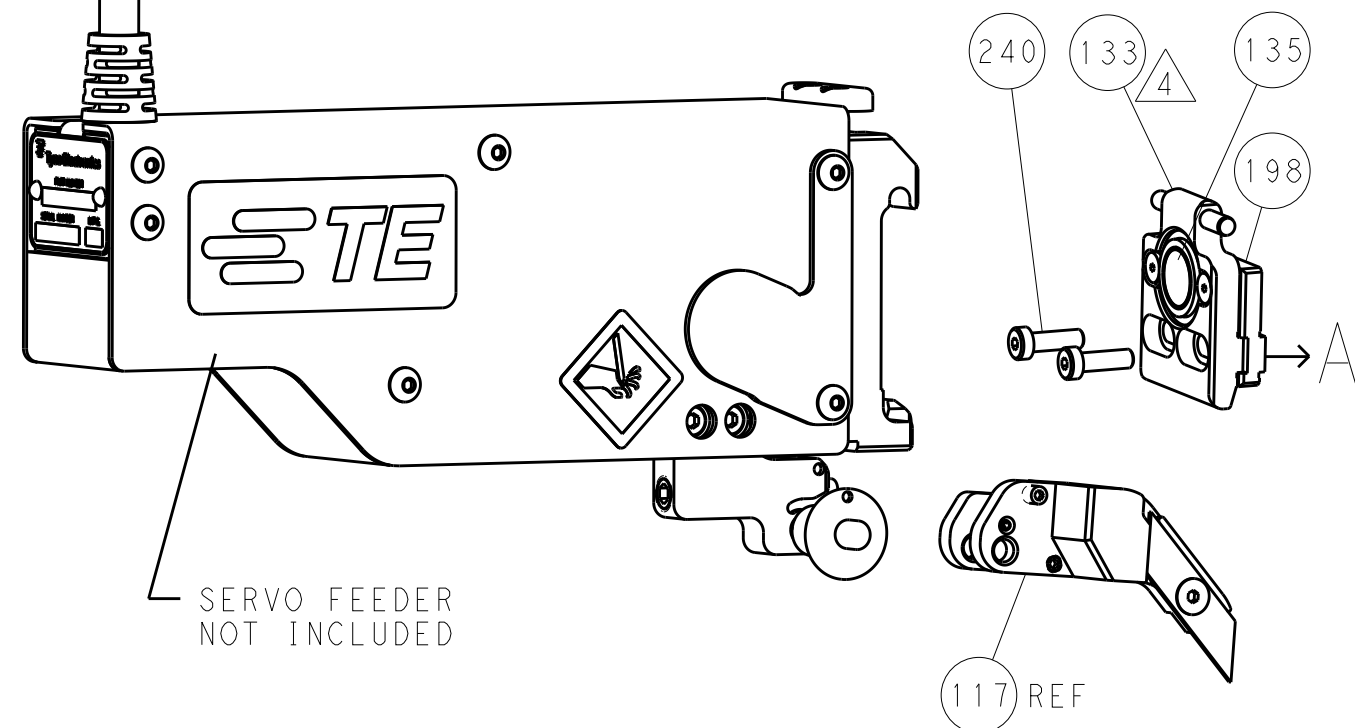
FEED TYPE
MECHANICAL



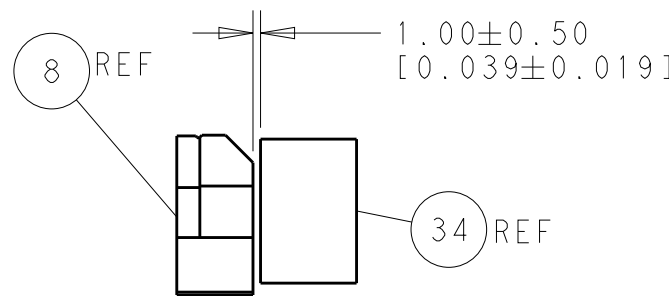
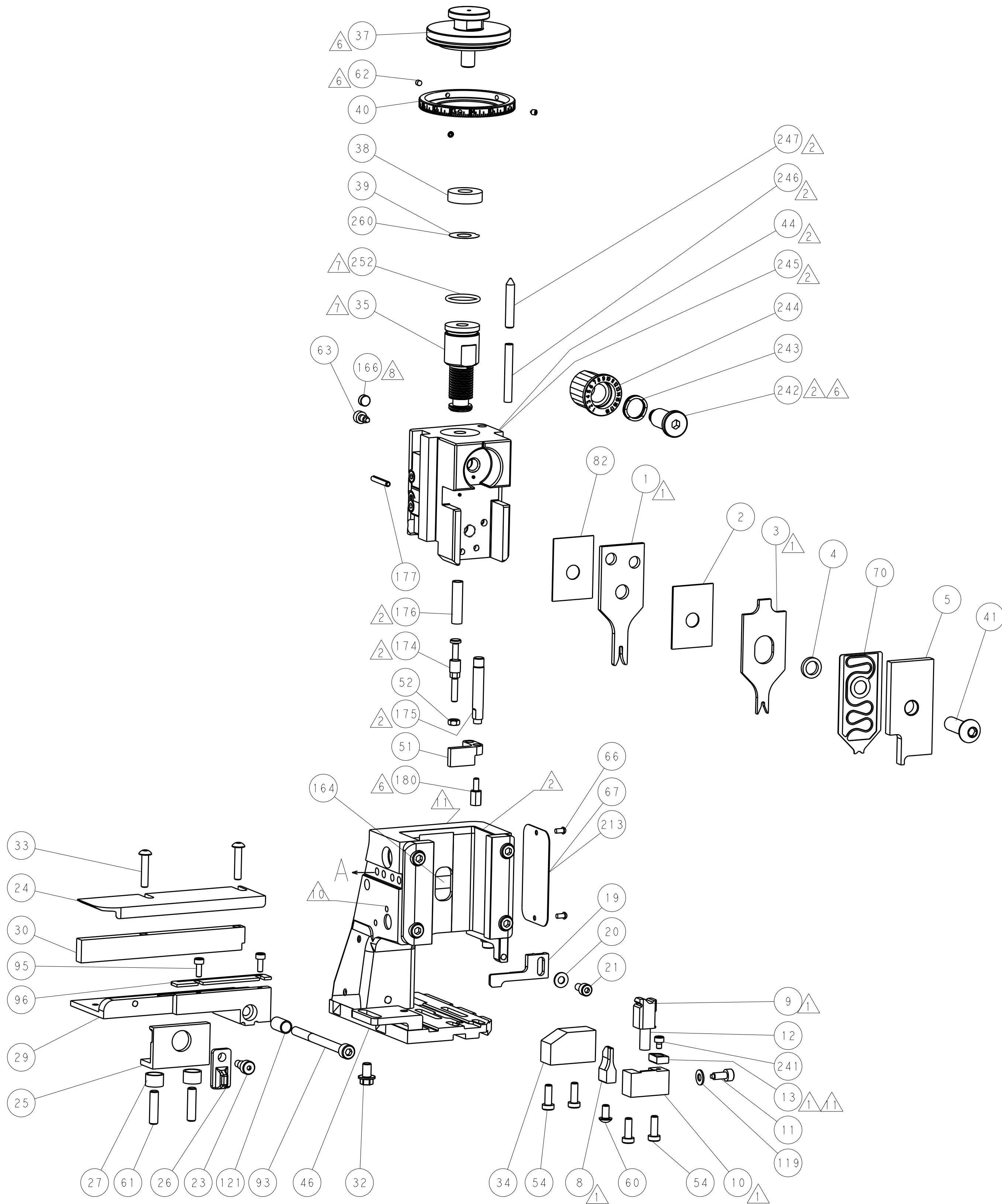
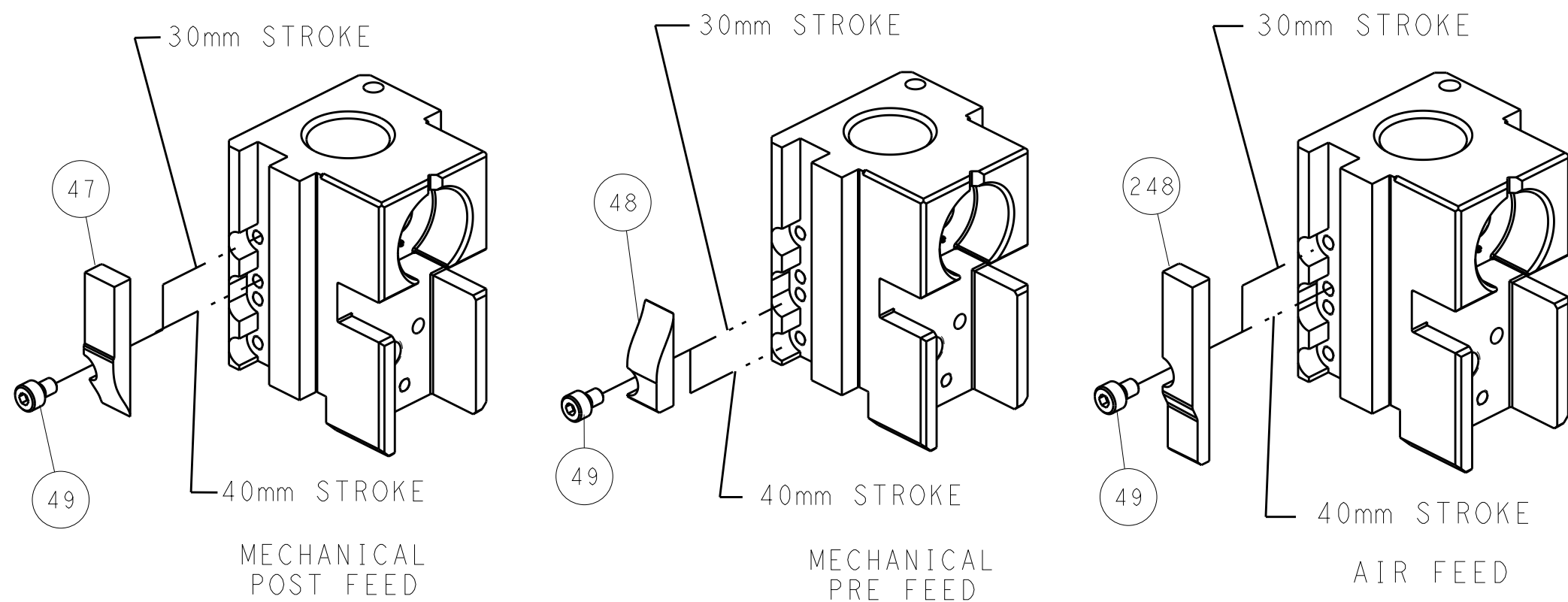
PNEUMATIC



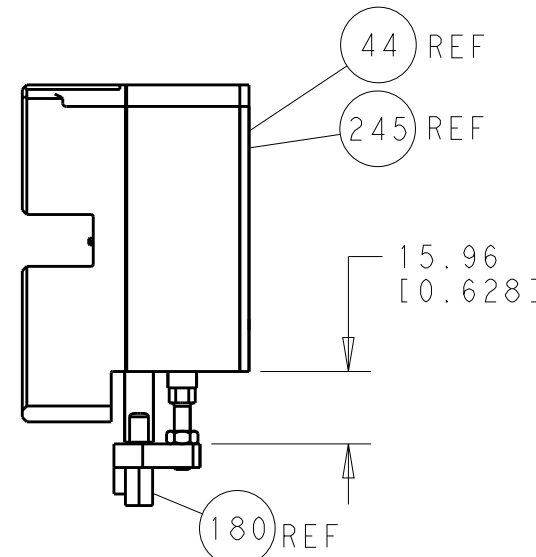
SERVO
LATCH PLATE



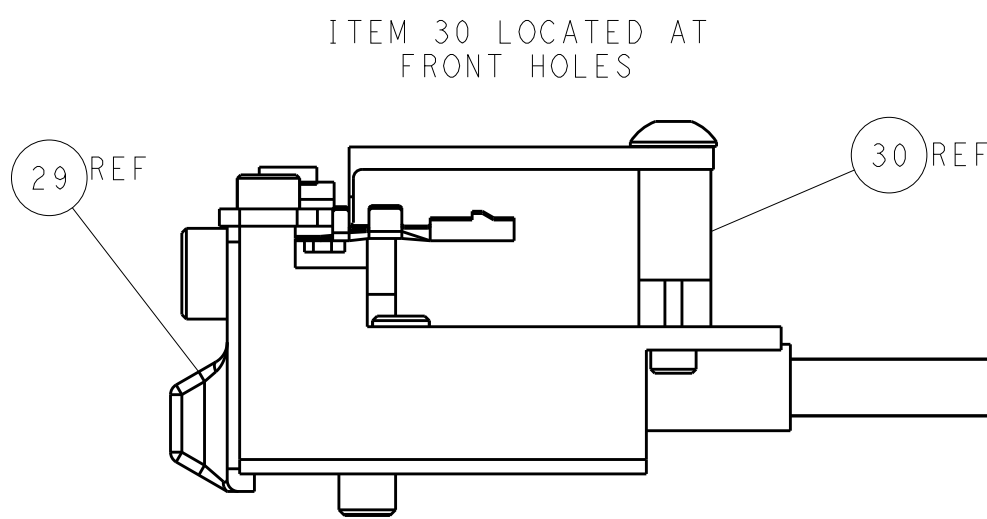
CAM POSITIONS



TERMINAL SUPPORT LOCATION

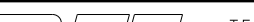


HOLDDOWN SET-UP



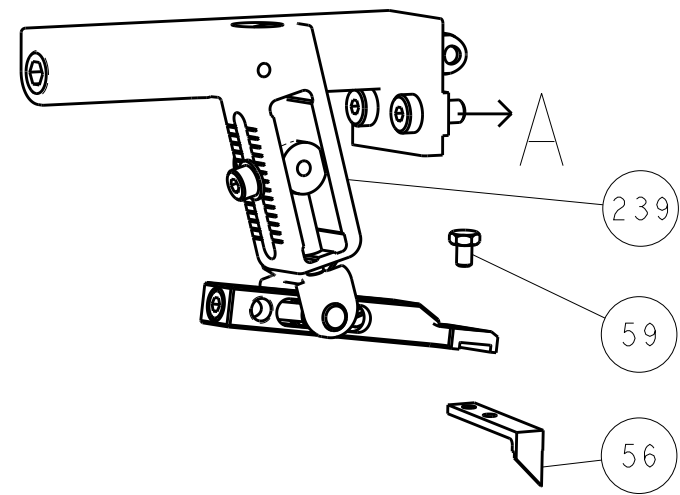
FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

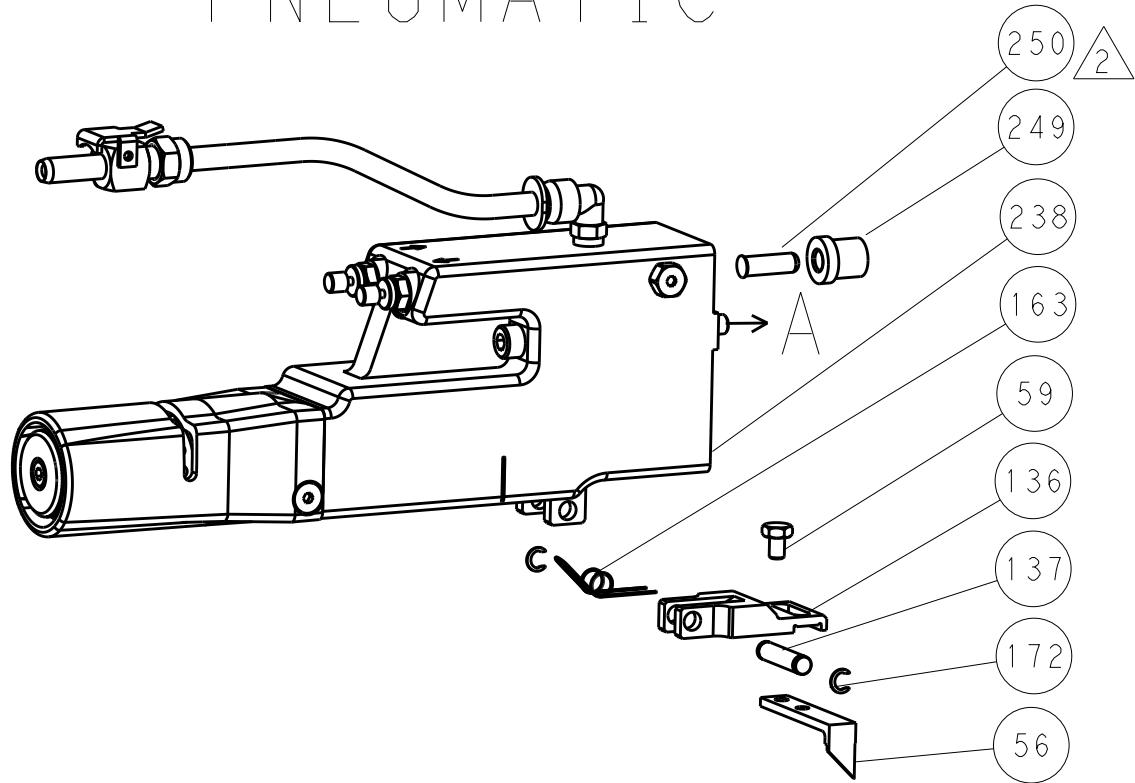
THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.				OWN: R. O. WILSON 01MAY2013 CHK: K. J. STAKEM 01MAY2013 APVD: T. L. ELGIN 01MAY2013		 TE Connectivity Harrisburg, PA 17105-3608			
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC		NAME		RESTRICTED TO	
mm		0 PLC ±0.5 1 PLC ±0.13 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001		APPLICATION SPEC		Ocean Side Feed Applicator		-	
		FINISH		WEIGHT		SIZE		CAGE CODE	
MATERIAL		-		-		A1		00779	
Customer Accessible Production Drawing				SCALE		1:2		SHEET 2 of 4	
								REV B	

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

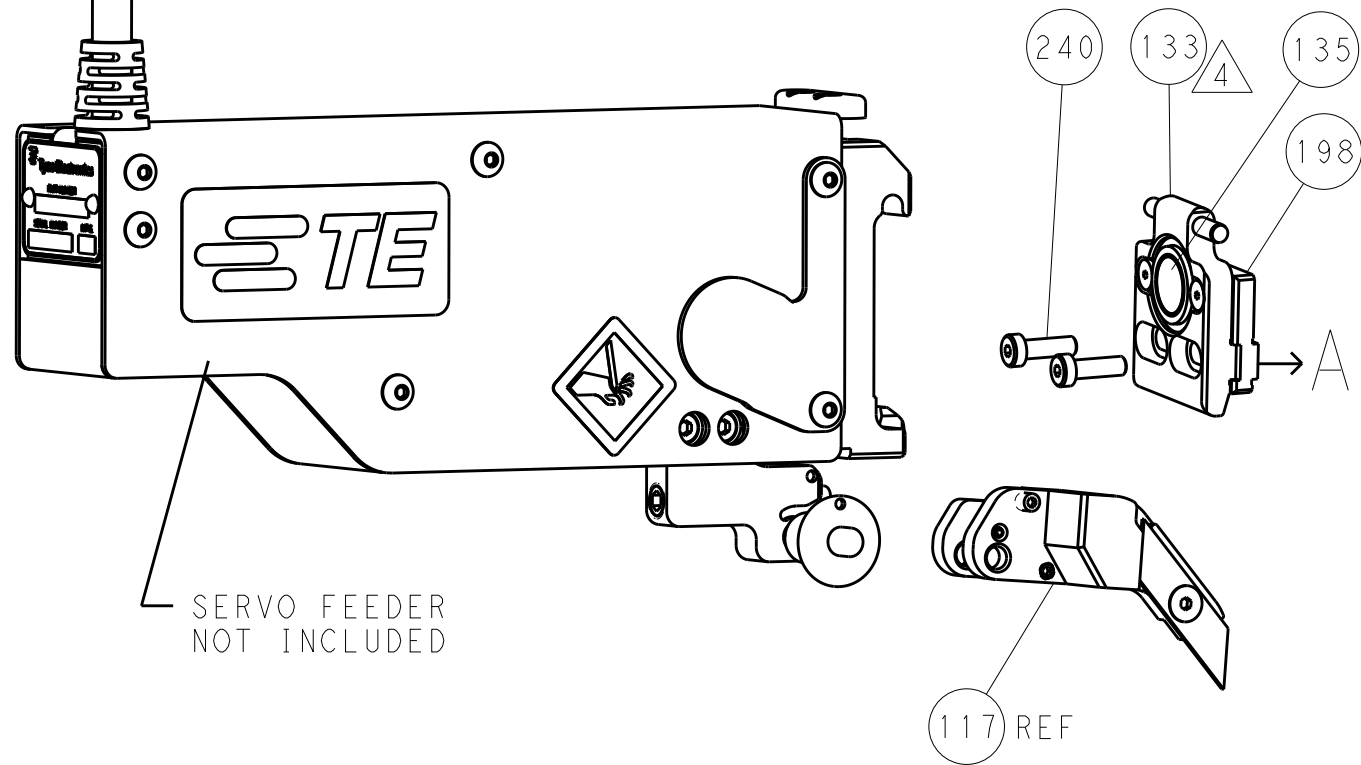
FEED TYPE MECHANICAL



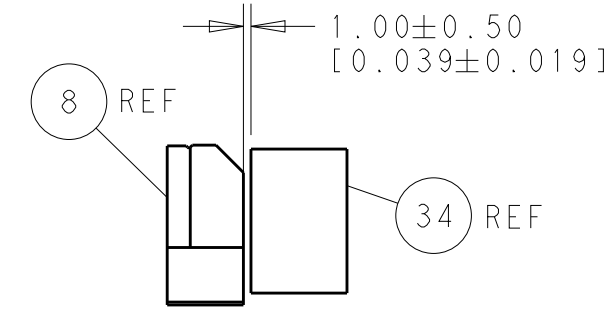
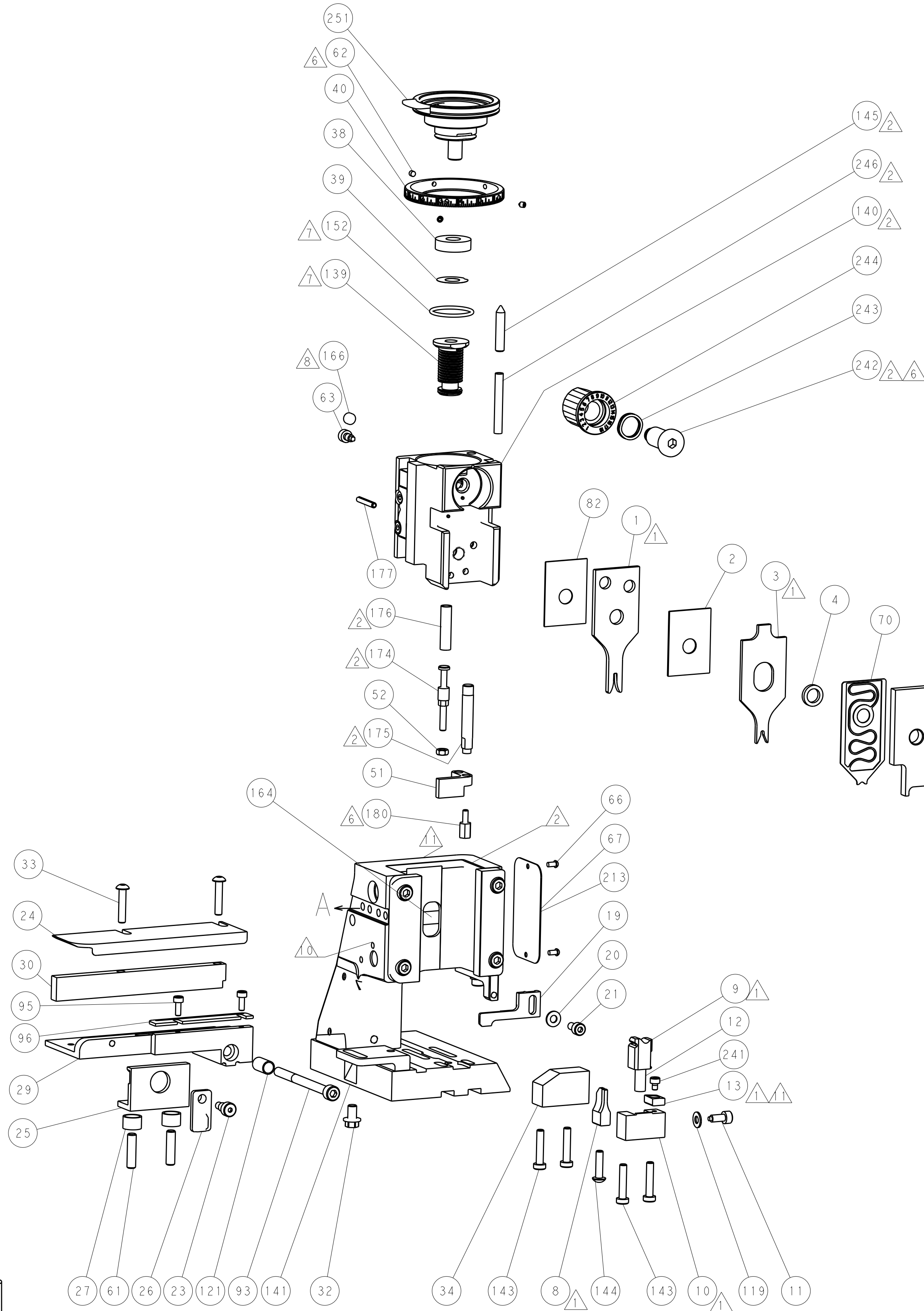
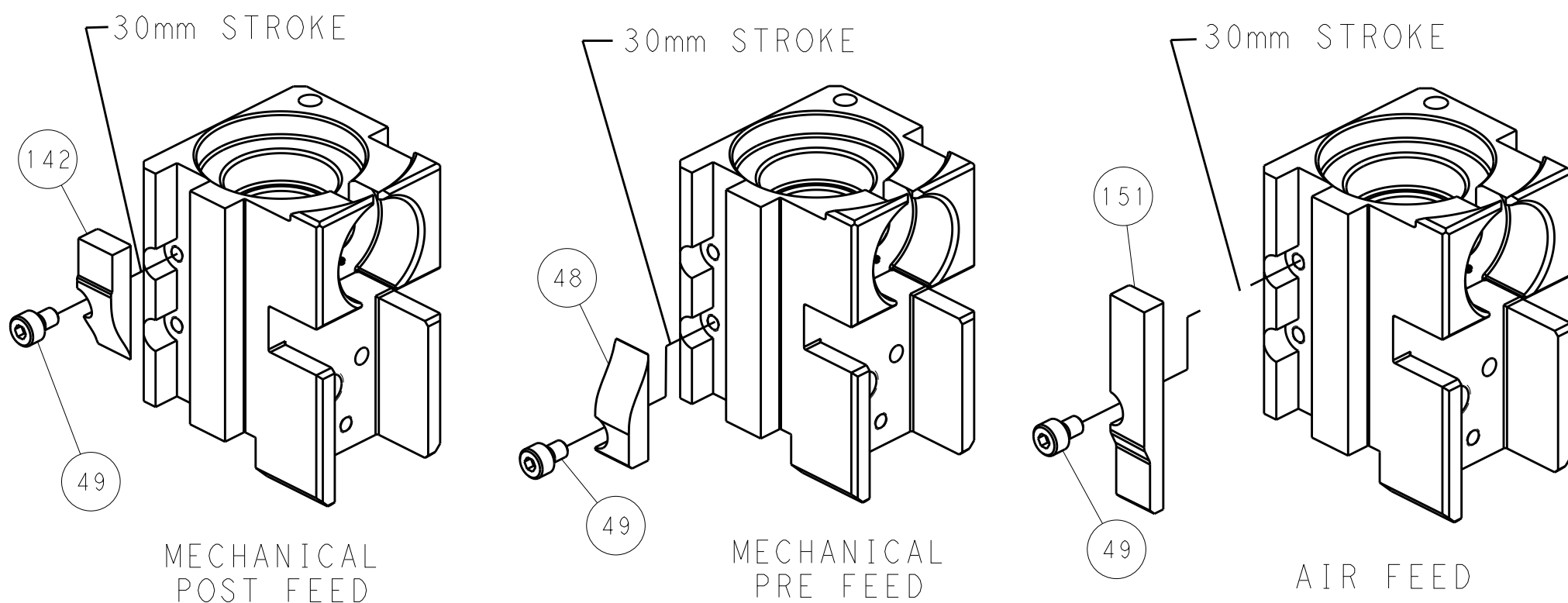
PNEUMATIC



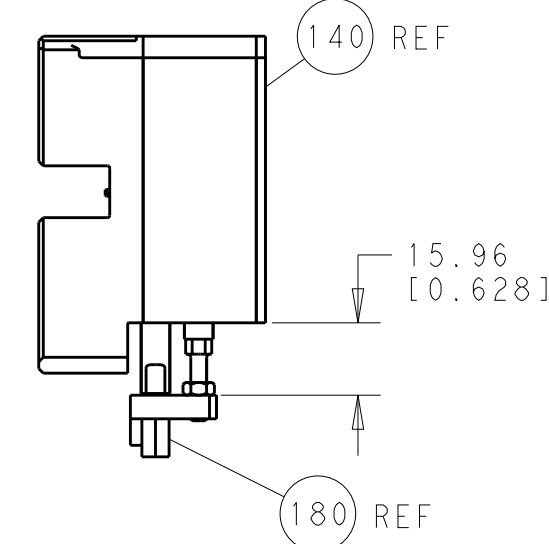
SERVO LATCH PLATE



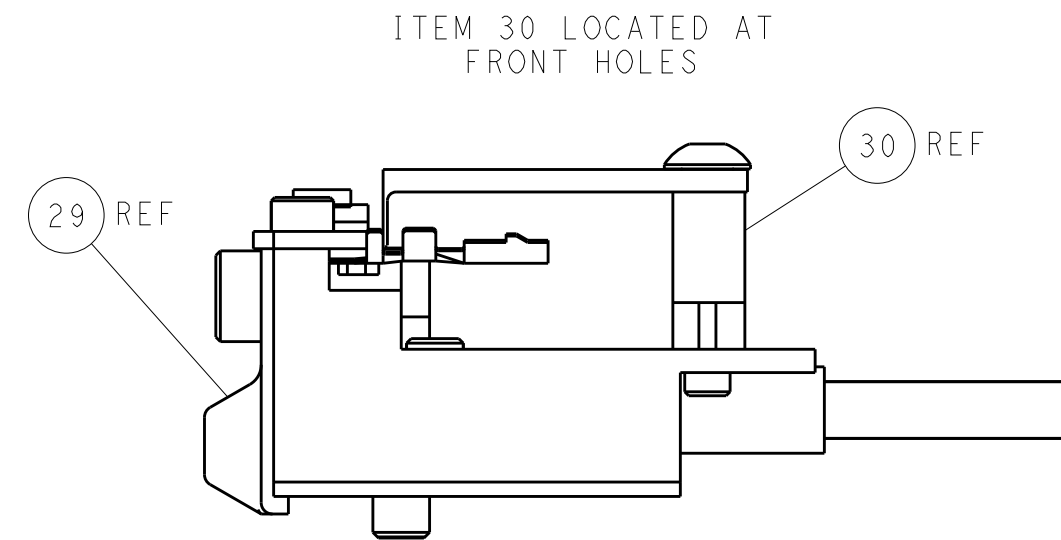
CAM POSITIONS



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)

DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN R.O. WILSON 01MAY2013		CHK K.J. STAKEM 01MAY2013		APVD T.L. ELBIN 01MAY2013		NAME Ocean Side Feed Applicator	
0 PLC ±.5		1 PLC ±0.13		2 PLC ±0.13		3 PLC ±0.013		4 PLC ±0.0001		SIZE A1	
MATERIAL		FINISH		WEIGHT		Customer Accessible Production Drawing		SCALE 1:2		SHEET 4	
										REV B	