

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
					CONVERT TO	PART NUMBERS REQUIRED						
	2151200-1	F	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
	2151200-2	F	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151200-5	1901094-3	-	2168400-6 (QUANTITY 2)	
					SMART APPLICATOR	2161326-1	-	8-2151200-4	-	-		
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-	
	2151200-5	F	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE $\Delta$	SERVO LATCH PLATE $\Delta$	SERVO LATCH PLATE	2119951-1	-	8-2151200-5	1901094-3	-	2168400-6 (QUANTITY 2)
						SMART APPLICATOR	2161326-1	-	8-2151200-4	-	-	
						MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151200-6	F	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE $\Delta$	SERVO LATCH PLATE $\Delta$	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
					-	-	-	-	-	-	-	
2151200-7	F	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	-	
7-2151200-7	C	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.78 mm [ .070 ]	F
INSUL	2.29 mm [ .090 ]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: AMP MCP4.8K			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.00-3.60 mm [ .118-.142 IN ]		$\varnothing$ 1.10-1.60 mm [ .043-.063 IN ]	
TERMINAL APPLICATION SPECIFICATION	114-18388 $\Delta$		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
1241400-1			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: STANDARD POWER TIMER CONTACT TYPE A			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
2.90-3.50 mm [ .114-.138 IN ]		$\varnothing$ 1.15-1.60 mm [ .045-.063 IN ]	
TERMINAL APPLICATION SPECIFICATION	114-18037 $\Delta$		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
964322-1			

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING $\Delta$
0.50mm $^2$	1.26+/-0.05 [ .050+/- .002 ]	3.6
0.35mm $^2$	1.19+/-0.03 [ .047+/- .001 ]	4.4
0.25mm $^2$	1.15+/-0.03 [ .045+/- .001 ]	4.8
0.20mm $^2$	1.13+/-0.03 [ .044+/- .001 ]	5.0

WIRE SIZE	CRIMP HEIGHT mm [ INCH ]	CRIMP HEIGHT REFERENCE SETTING $\Delta$
0.50mm $^2$	1.26+/-0.03 [ .050+/- .001 ]	3.6
0.35mm $^2$	1.19+/-0.03 [ .047+/- .001 ]	4.4
0.25mm $^2$	1.15+/-0.03 [ .045+/- .001 ]	4.8
0.20mm $^2$	1.13+/-0.03 [ .044+/- .001 ]	5.0

**\*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.

- $\Delta$  RECOMMENDED SPARE PARTS
- $\Delta$  GREASE BEARING SURFACES LIGHTLY
- 3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- $\Delta$  APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151200-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151200-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151200-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151200-6
- 5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- $\Delta$  APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 50, 62. 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 ITEMS 37, 50.
- $\Delta$  GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- $\Delta$  MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- $\Delta$  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.
- $\Delta$  SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- $\Delta$  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.
- $\Delta$  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
- $\Delta$  FEED REQUIRES ADJUSTMENT WHEN CHANGING TERMINALS.  
TERMINAL 1241400 FEED: 17mm [ .669 IN ]  
TERMINAL 964322 FEED: 16mm [ .630 IN ]

-	-	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
-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	LOC	DIST	REVISIONS					
2119599-1	A	66	R	LTN	DESCRIPTION	DATE	OWN	APVD
			D		ECR-13-004944	19MAR2013	RK	GB
			E		ECR-14-006386	30APR2014	JH	TE
			F		ECR-15-004484	20MAR2015	JH	JT

-	-	-	-	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	2119082-5	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
$\Delta$	-	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
-	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	1	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
-	-	-	-	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	455888-5	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
$\Delta$	-	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
-	-	-	-	-	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
$\Delta$	-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
$\Delta$	-	1	1	1	1	3-1752354-4	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	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
$\Delta$	-	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	1-1752356-5	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	1320908-3	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	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
$\Delta$	-	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
$\Delta$	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
$\Delta$	-	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
$\Delta$	1	1	1	1	1	7-1333203-2	ANVIL, COMBINATION	8
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-9	BLOCK, CRIMPER SPACER	4
$\Delta$	1	1	1	1	1	1-2119784-8	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	1-455888-1	SPACER, CRIMPER	2
$\Delta$	1	1	1	1	1	3-456404-2	CRIMPER, WIRE PREMIUM	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	DATE	NAME	SIZE	CASE CODE	DRAWING NO	RESTRICTED TO
mm		0 PLC	$\pm$	C. MOYER	23AUG2011					
		1 PLC	$\pm 0.5$	T. ELBIN	23AUG2011					
MATERIAL		2 PLC	$\pm 0.13$							
		3 PLC	$\pm 0.013$							
		4 PLC	$\pm 0.001$							
		ANGLES	$\pm 0.0001$							
		FINISH								

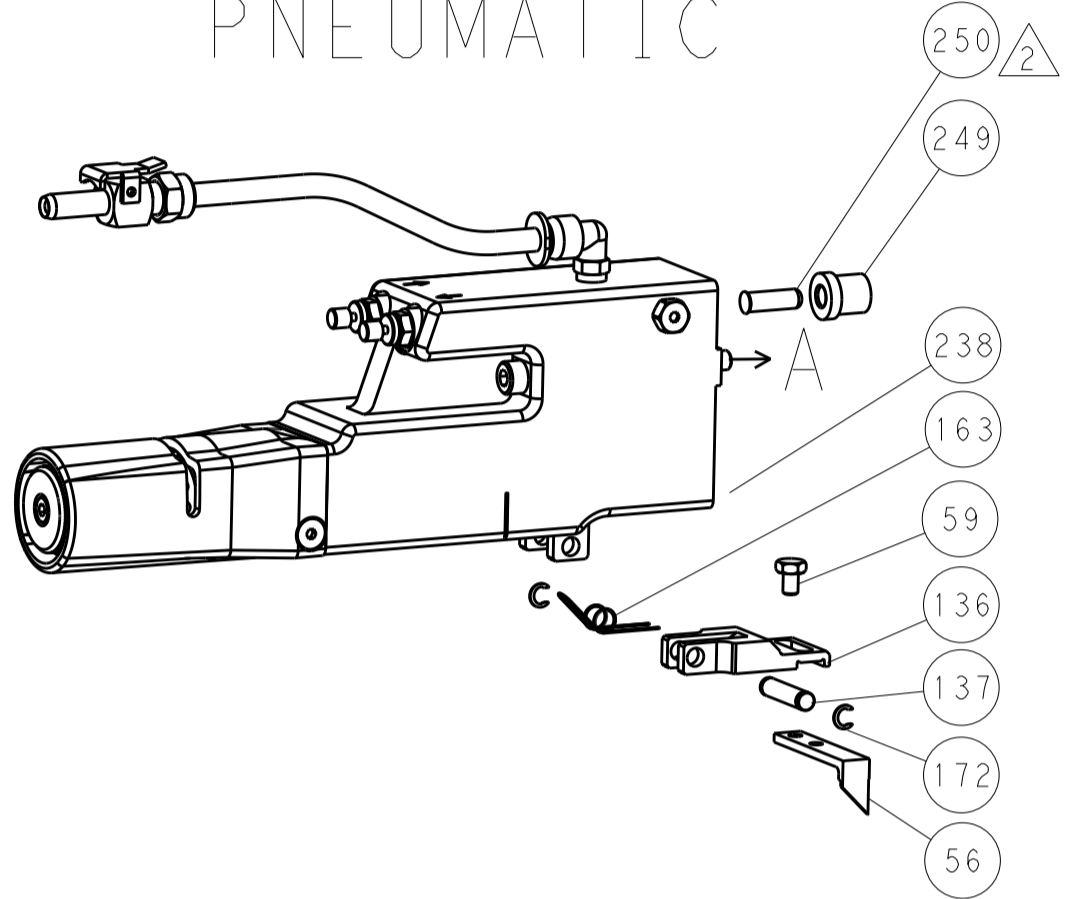
Customer Accessible Production Drawing SCALE 1:2 SHEET 1 OF 4

LOC	DIST	REV	DATE	BY	APPV
A	66				
REVISIONS			DATE	BY	APPV
- SEE SHEET 1			-	-	-

### FEED TYPE MECHANICAL



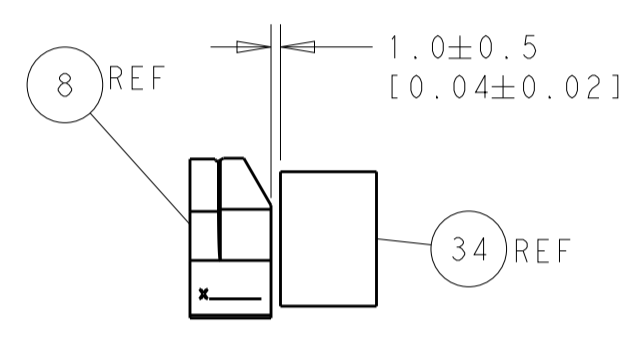
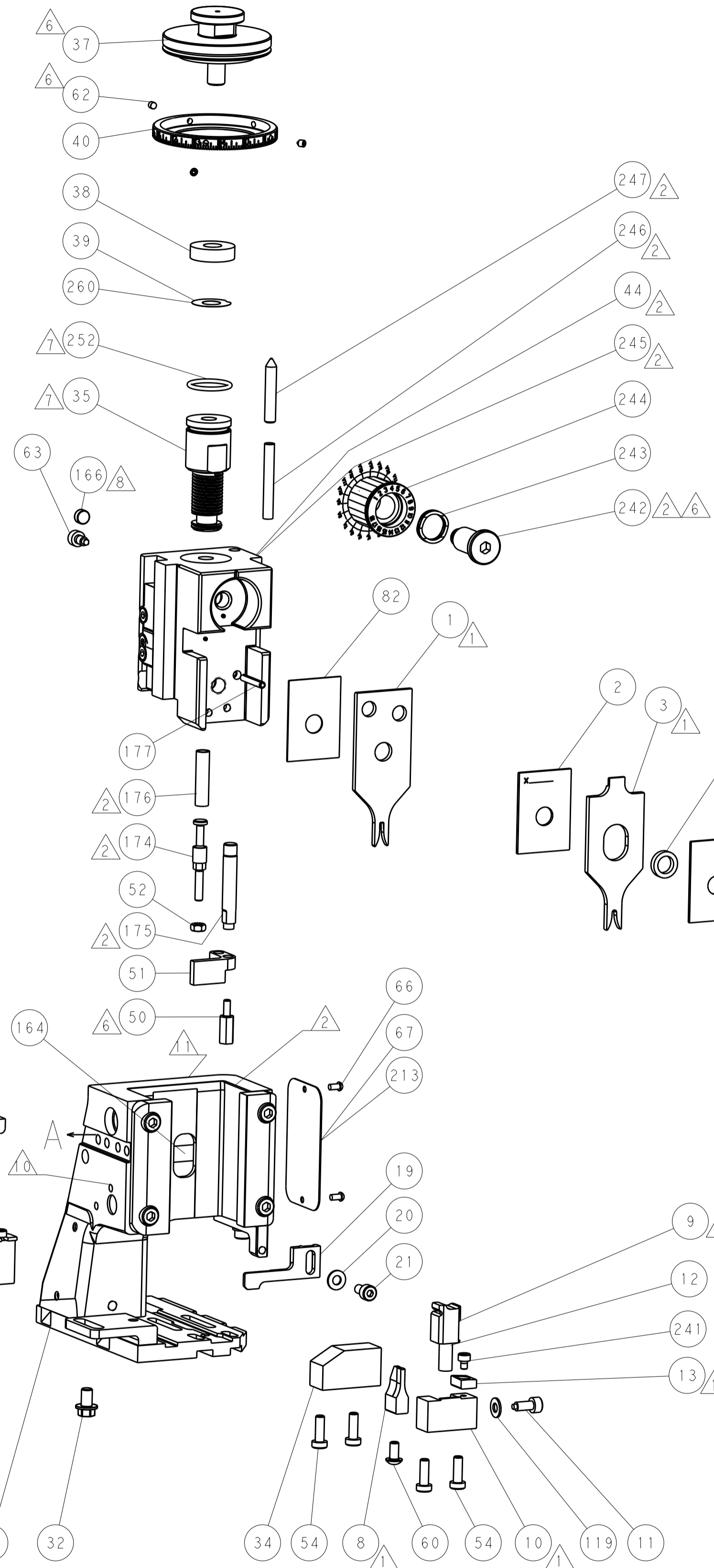
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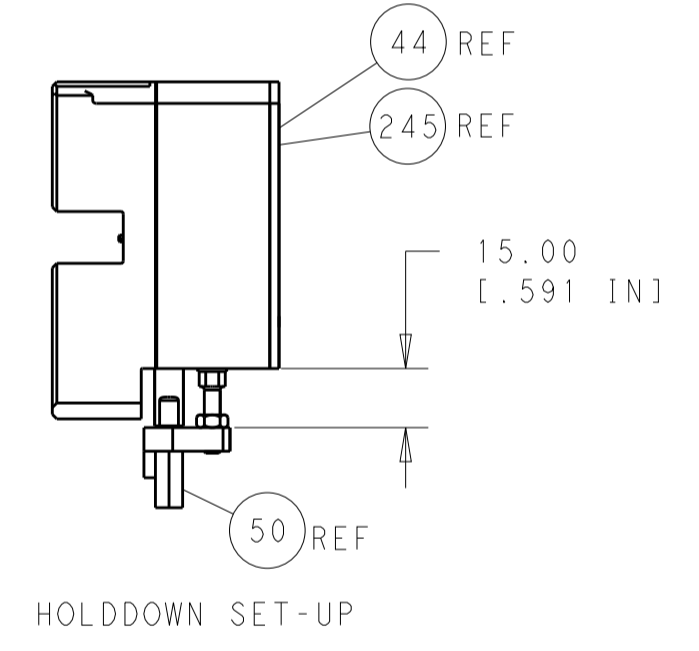
### SERVO LATCH PLATE



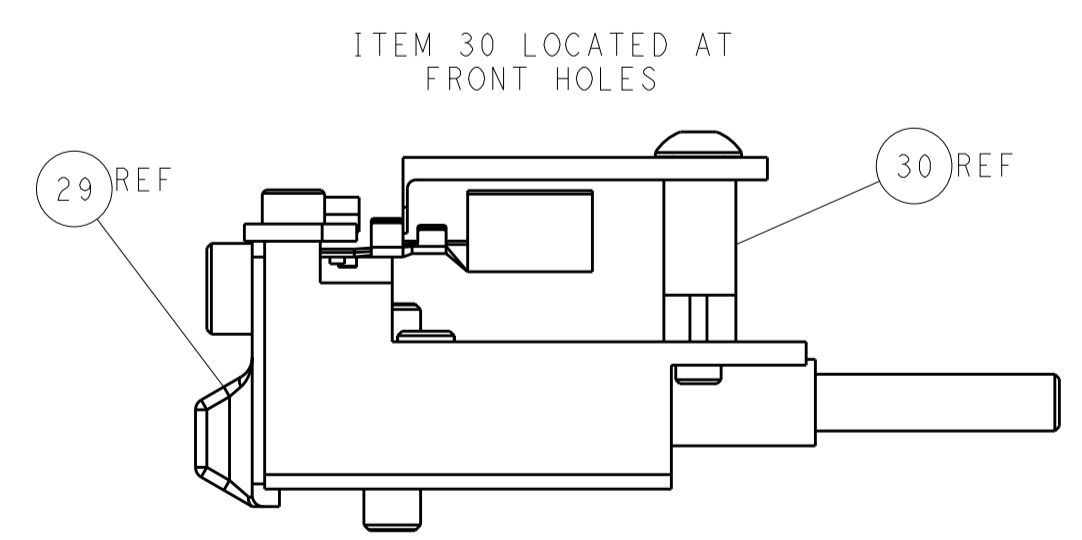
### CAM POSITIONS



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 C. MOYER 23AUG2011		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0013	APVD T. ELBIN 23AUG2011	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME Ocean Side Feed Applicator		RESTRICTED TO	
Customer Accessible Production Drawing		SCALE 1:2		SHEET 2 of 4		REV F	

APPLICATOR STYLE CONVERSION CHART table with columns for CONVERT TO, PART NUMBERS REQUIRED, and various part numbers.

APPLICATOR DATA table with columns for CRIMP, SIZE, TYPE and APPLICATOR INSTRUCTIONS.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION table with columns for WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION table with columns for WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED.

WIRE SIZE, CRIMP HEIGHT, CRIMP HEIGHT REFERENCE SETTING table with columns for wire size and crimp height.

WIRE SIZE, CRIMP HEIGHT, CRIMP HEIGHT REFERENCE SETTING table with columns for wire size and crimp height.

- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY...

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

SET UP GAUGE, REVISIONS table with columns for P, LTM, DESCRIPTION, DATE, DWN, APVD.

Main parts list table with columns for part numbers, descriptions, and item numbers.

TE Connectivity logo, dimensions, tolerances, material, weight, and drawing information.

LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	OWN	APVD
		-	-	SEE SHEET 1			

# FEED TYPE MECHANICAL



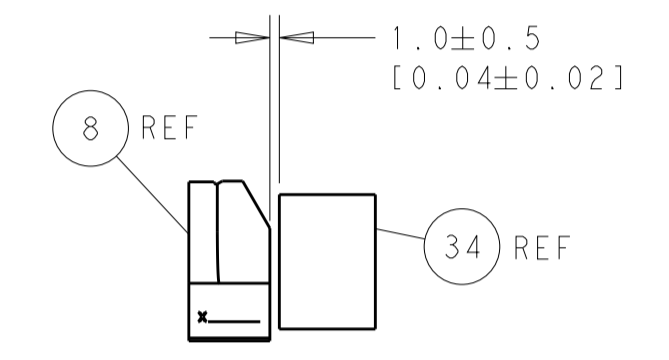
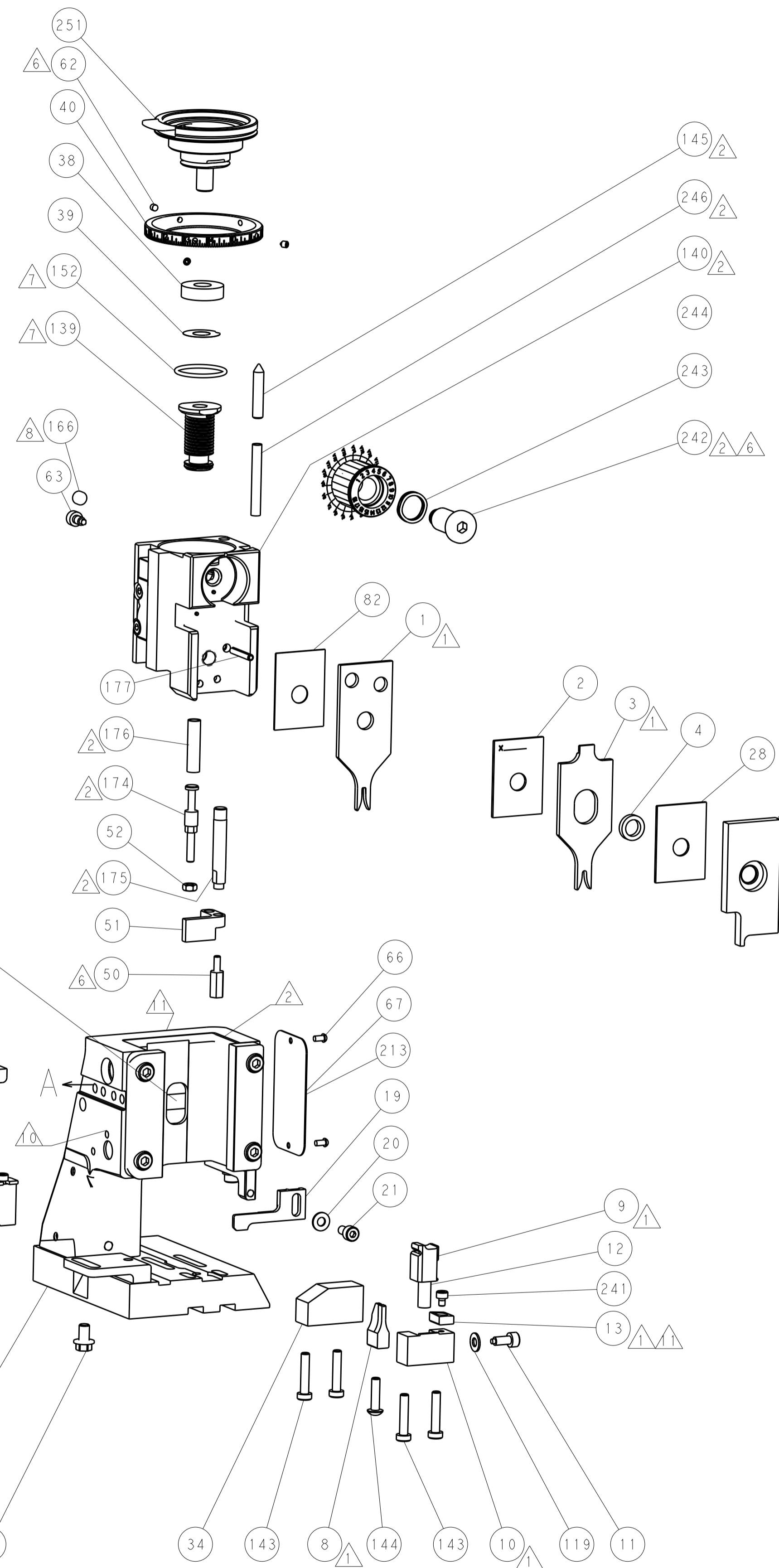
# PNEUMATIC



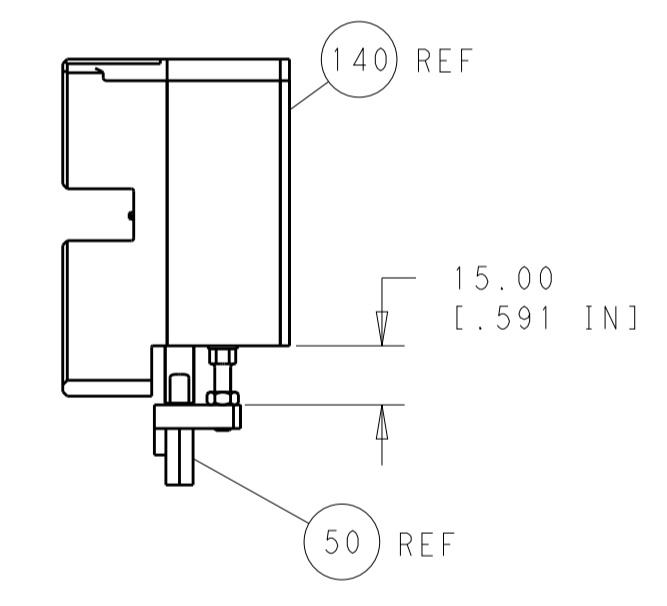
# SERVO LATCH PLATE



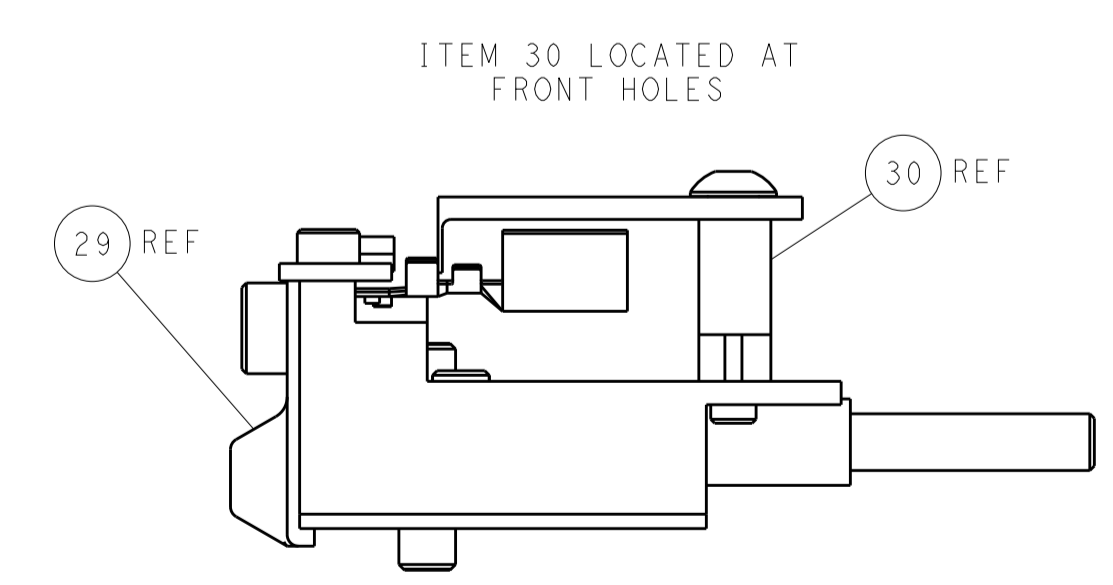
# CAM POSITIONS



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:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN C. MOYER 23AUG2011		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD T. ELBIN 23AUG2011	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME		Ocean Side Feed Applicator	
				SIZE CAGE CODE DRAWING NO		RESTRICTED TO	
				A1 00779 C=2151200		Customer Accessible Production Drawing	
				SCALE 1:2		SHEET 4 OF 4 REV F	