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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

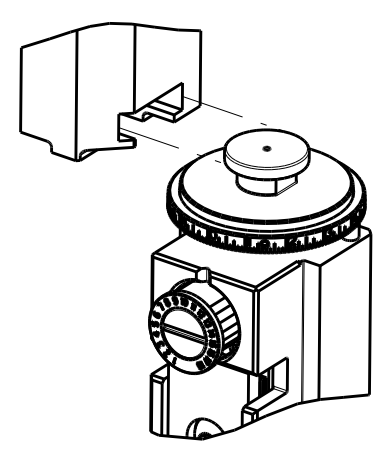
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151747-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151747-5

8-2151747-4

2119641-1

1901094-3

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2119799-1

-

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2063440-1

2168400-6 (QUANTITY 2)

-

2151747-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151747-5

8-2151747-4

2119653-1

1901094-3

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2151747-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

-

1338685-1

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5-18022-5

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2119653-1

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2151747-6

A

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹²

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2151747-7

A

FINE CRIMP HEIGHT ADJUST

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7-2151747-7

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CRIMP TOOLING KIT

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.97 mm [1.117]

F

INSUL

3.70 mm [1.146]

F

APPLICATOR INSTRUCTIONS

408-10389



TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION

TERMINAL NAME: FEMALE METRI-PACK 280

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.85-5.23 mm [1.91-.206 IN]

Ø2.48-3.97 mm [1.098-.156 IN]

TERMINAL APPLICATION SPECIFICATION

DELPHI Rev A

-

-

TERMINALS APPLIED

TE TERMINAL

DELPHI TERMINAL

TE TERMINAL

DELPHI TERMINAL

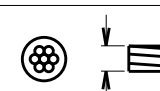
1949894-1

12191479

-

-

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING⁹

2.00mm2

1.65+/-0.05 [1.065+/-0.002]

13.7

1.00mm2

1.55+/-0.05 [1.061+/-0.002]

14.7



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: 8-2151747-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151747-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151747-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151747-6

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

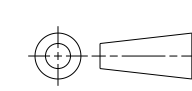
TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12

WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 0.508mm.

THIS IS SUBJECT TO CHANGE AND TO BE USED FOR THE LATEST REVISION ONLY. ANY OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:
mm



MATERIAL
-

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
-

0 PLC ±.1
1 PLC ±0.1
2 PLC ±0.02
3 PLC ±0.005
4 PLC ±0.0005
ANGLES ±.1

FINISH
-

WEIGHT
-

Customer Accessible Production Drawing

OWN
BOB HIGMAN
CHK
G.BAILEY
APVD
G.BAILEY

1ZSEPT2012
1ZSEPT2012
1ZSEPT2012

NAME
Ocean Side Feed
Applicator

SIZE
A1

CAGE CODE
00779

DRAWING NO
©=2151747

RESTRICTED TO
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OF
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REVISIONS

DESCRIPTION

DATE

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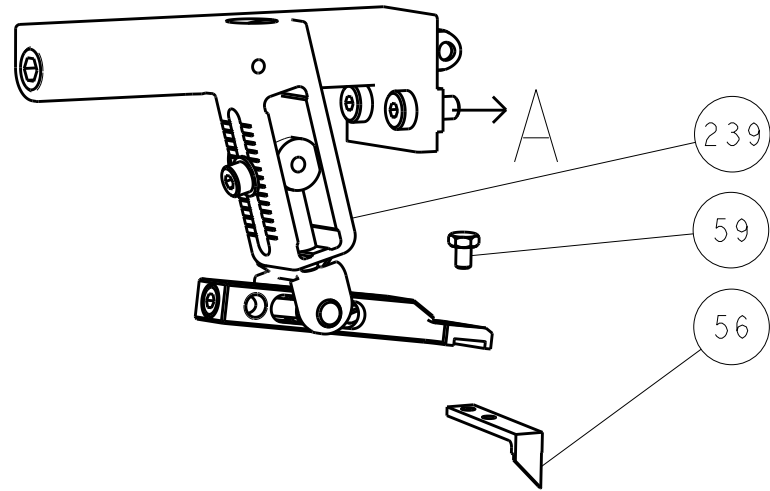
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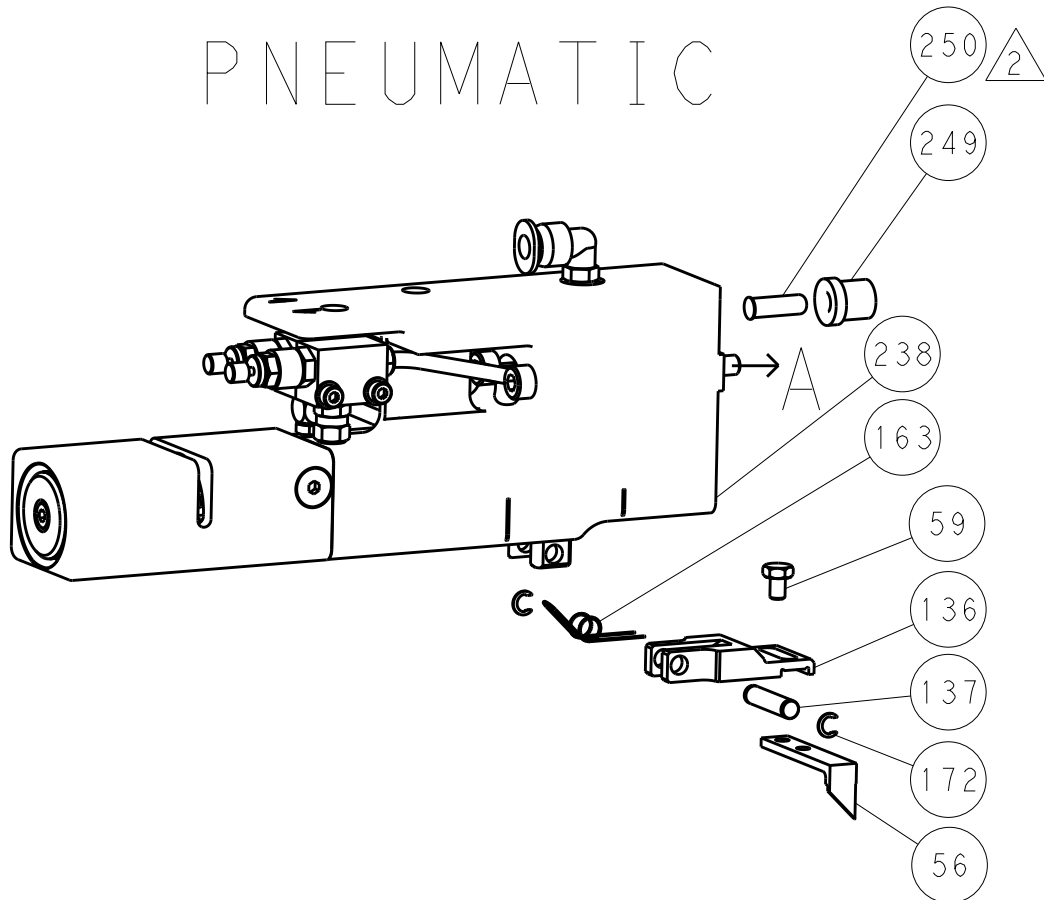
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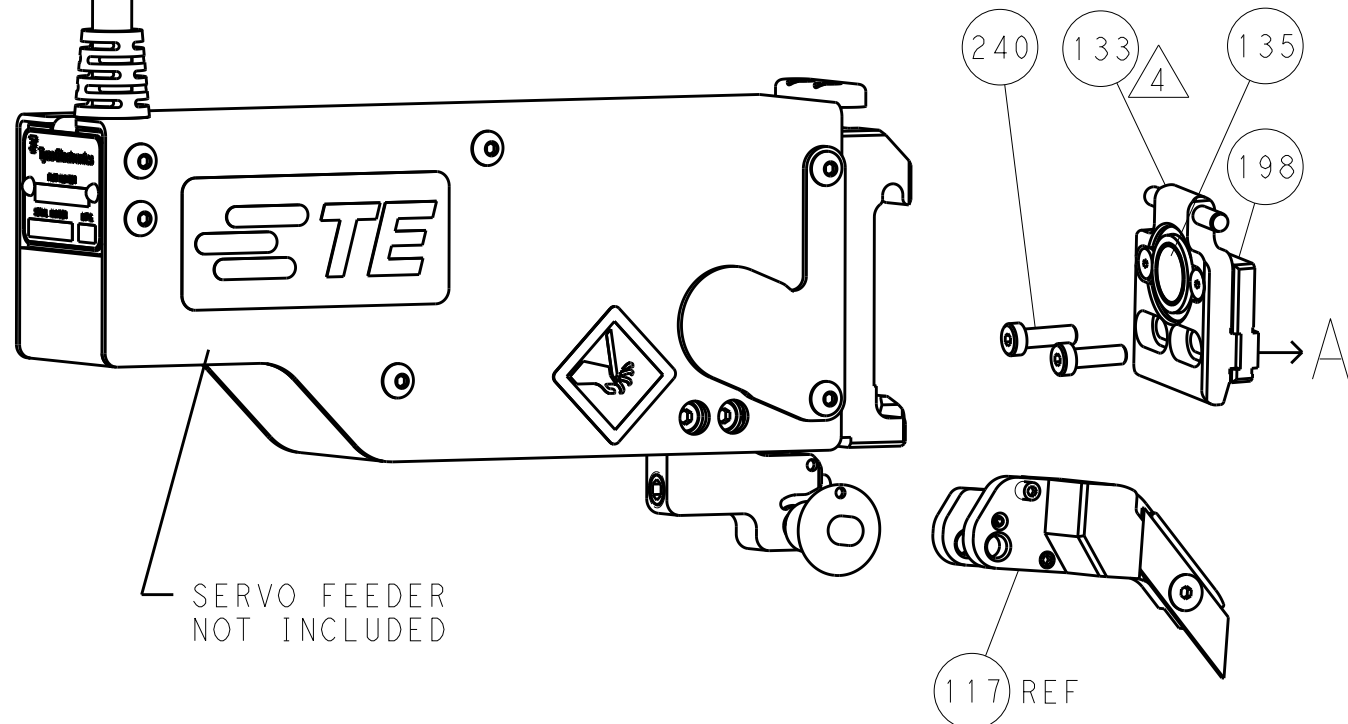
FEED TYPE
MECHANICAL



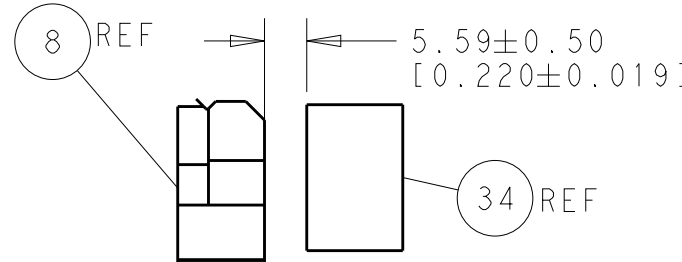
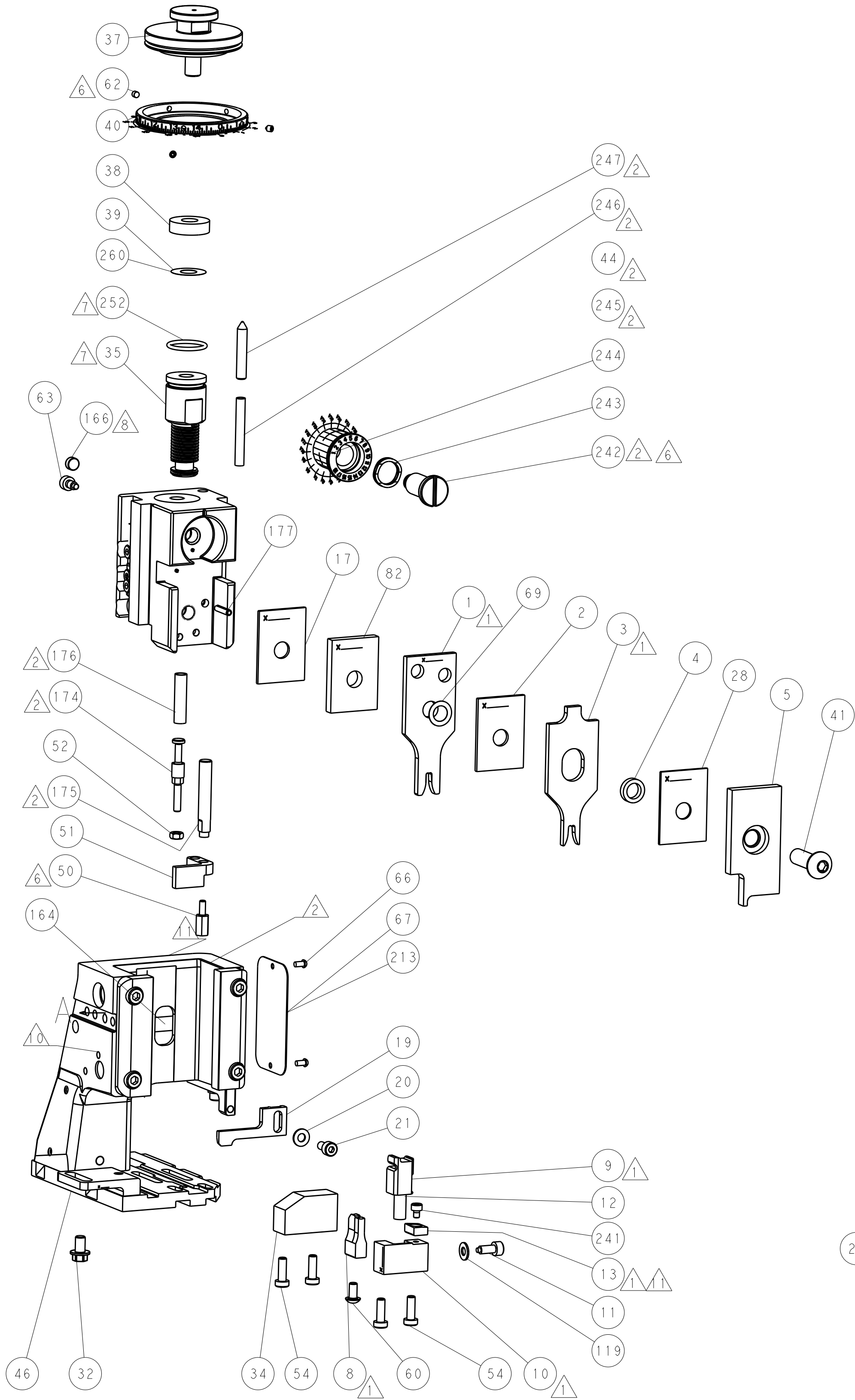
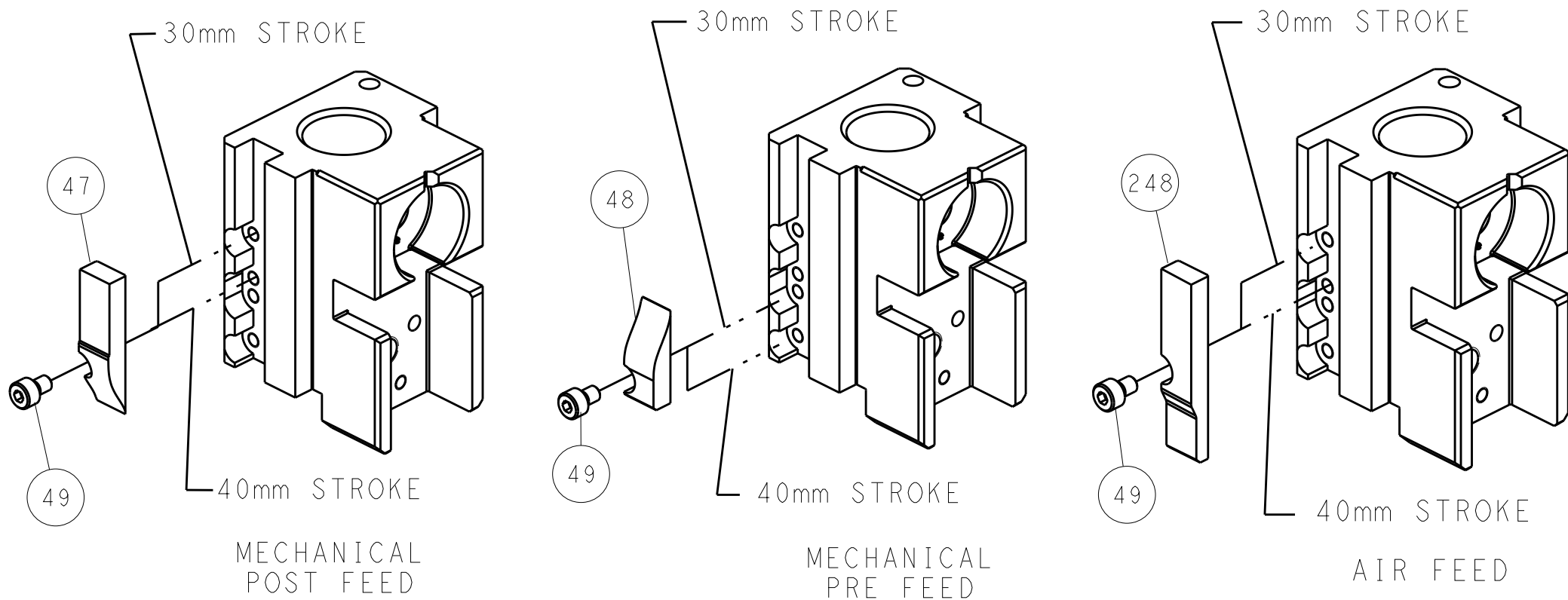
PNEUMATIC



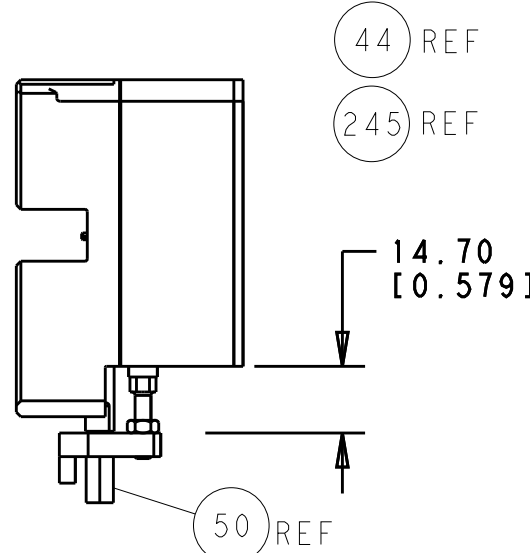
SERVO
LATCH PLATE



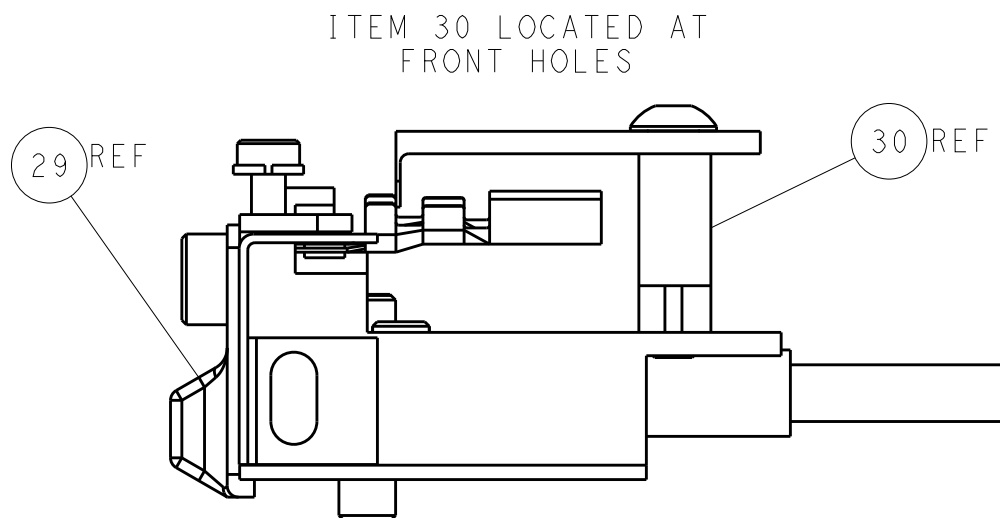
CAM POSITIONS



TERMINAL SUPPORT LOCATION

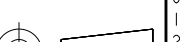


HOLDDOWN SET-UP



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)

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		CHK: G. BAILEY 12SEPT2012		Harrisburg, PA 17105-3608	
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME	
mm		0 PLC ±.1		Ocean Side Feed	
		1 PLC ±0.1		Applicator	
		2 PLC ±0.02		-	
		3 PLC ±0.005		SIZE	
		4 PLC ±0.0005		CAGE CODE	
ANGLES		FINISH		DRAWING NO	
-		-		A1 00779 C=2151747	
MATERIAL		WEIGHT		RESTRICTED TO	
-		-		-	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 2 OF 4 REV A	

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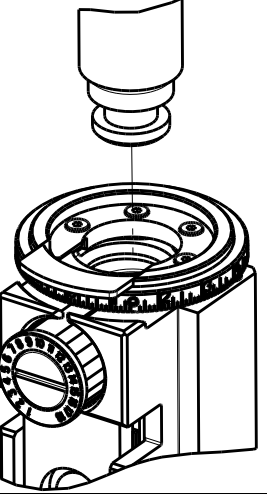
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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2151747-1

REVISION

A

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

CONVERT TO

PNEUMATIC FEED

PART NUMBERS REQUIRED

2119950-1

2-2151747-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1

2-2151747-5

A

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

MECHANICAL FEED

2119949-1

2-2151747-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

2119950-1

7-2151747-7

A

CRIMP TOOLING KIT

-

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APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.97 mm [.117]	F
INSUL	3.70 mm [.146]	F

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: DELPHI TERMINAL DELPHI CRIMP SPECIFICATION

TERMINAL NAME: FEMALE METRI-PACK 280

WIRE STRIP LENGTH

4.85-5.23 mm [.191-.206 IN]

INSULATION DIAMETER RANGE

Ø2.48-3.97 mm [.098-.156 IN]

TERMINAL APPLICATION SPECIFICATION

DELPHI Rev A

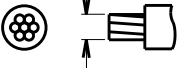
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TERMINALS APPLIED

TE TERMINAL	DELPHI TERMINAL	TE TERMINAL	DELPHI TERMINAL
1949894-1	12191479		

WIRE SIZE



CRIMP HEIGHT

mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

9

2.00mm2

1.65+/-0.05 [.065+/- .002]

13.7

1.00mm2

1.55+/-0.05 [.061+/- .002]

14.7

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: 8-2151747-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151747-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151747-5

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.

7

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

8

MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

APPLICATOR STYLE CONVERSION CHART

CONVERT TO	PART NUMBERS REQUIRED
PNEUMATIC FEED	2119950-1
SERVO LATCH PLATE	2119951-1
SMART APPLICATOR	2161326-1
MECHANICAL FEED	2119949-1
SERVO LATCH PLATE	2119951-1
SMART APPLICATOR	2161326-1
MECHANICAL FEED	2119949-1
PNEUMATIC FEED	2119950-1
-	-
-	-

2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
2119640-1	PUSH ROD, AIR FEED	250
2079988-1	BUSHING, LCH5-12, MISUMI	249
1-22279-3	SPRING, COMPRESSION	246
2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77-27-25-22-21	PART NO	DESCRIPTION
ITEM NO		

SET UP GAUGE

2119599-1

LOC

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DIST

66

REVISIONS

P	LTR	DESCRIPTION	DATE	OWN	APVD
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2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

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2119083-1

RETAINER, INSULATION DIAL

242

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7-18023-7

SCR, SKT HD CAP M3 X 4.0

241

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2

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2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

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2119580-1

MECHANICAL FEED ASSEMBLY

239

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2063440-1

AIR FEED MODULE

238

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2119740-2

TAG, IDENTIFICATION

213

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1901094-3

SPACER, FEEDER

198

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6-993111-6

PIN, SLOTTED SPRING 3.0 X 14.0

177

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8-22280-7

SPRING, COMPRESSION

176

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1752353-2

GUIDE PIN, HOLDDOWN

175

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1901680-2

GUIDE PIN, HOLDDOWN

174

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21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

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994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

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REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

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240638-1

SPRING, FEED FINGER

163

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8-21084-1

O-RING, .801 ID, .070 DIA. MAT.

152

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2119641-2

FEED CAM, AIR FEED

151

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2119798-2

DETENT PIN

145

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2079383-8

SCR, BHSC, RoHS (M4 X 16)

144

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2168400-5

SHCS, LOW HEAD, RoHS, M4 X 20

143

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2119653-2

FEED CAM, POST FEED

142

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1-2119656-0

APPLICATOR BASIC ASSEMBLY, SF

141

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2119650-1

RAM, ASIAN STYLE, SIDE FEED

140

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1

 1 | 2119092-2 | BOLT, ADJUSTMENT | 139 || - | - | - | 1 | - | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
-	-	-	-	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	-	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135	
-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133	
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY, SF	117	
-	1	1	1	1	2-455888-9	SPACER, CRIMPER	82	
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
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-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62	
-	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1	1338685-1	PAWL, FEED	56
-	1	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
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-	1	1	1	1	1	2-1752354-5	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	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	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1	1752356-3	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	1320908-7	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	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
-	1	1	1	1	1	1-455888-4	SPACER, CRIMPER	17
-	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	454276-5	FLOATING SHEAR, FRONT	9
-	1	1	1	1	1	2-1633927-2	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	5-1633961-5	CRIMPER, INSULATION F PREMIUM	3
-	1	1	1	1	1	1-455888-6	SPACER, CRIMPER	2
-	1	1	1	1	1	9-1633305-6	CRIMPER, WIRE PREMIUM	1
-77-27-25-22-21	PART NO					DESCRIPTION	ITEM NO	

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TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4

(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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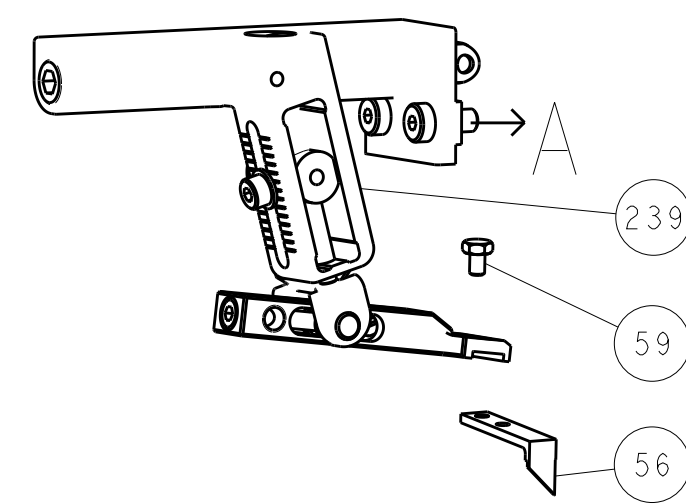
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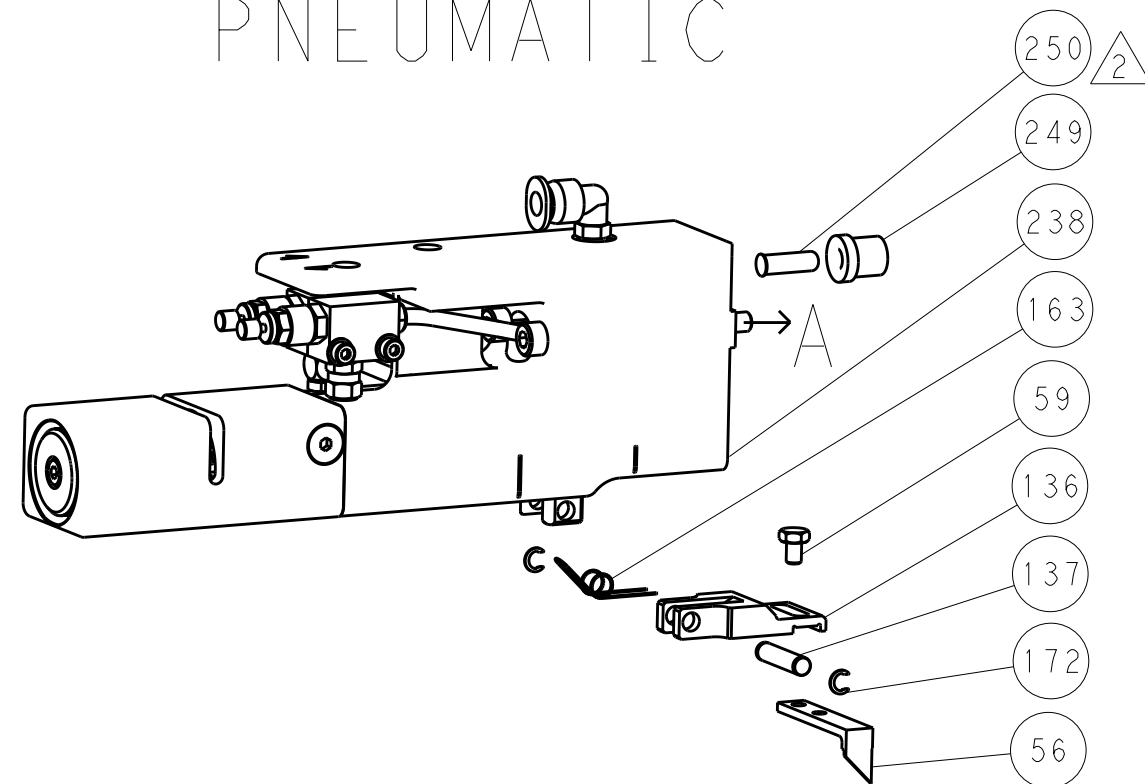
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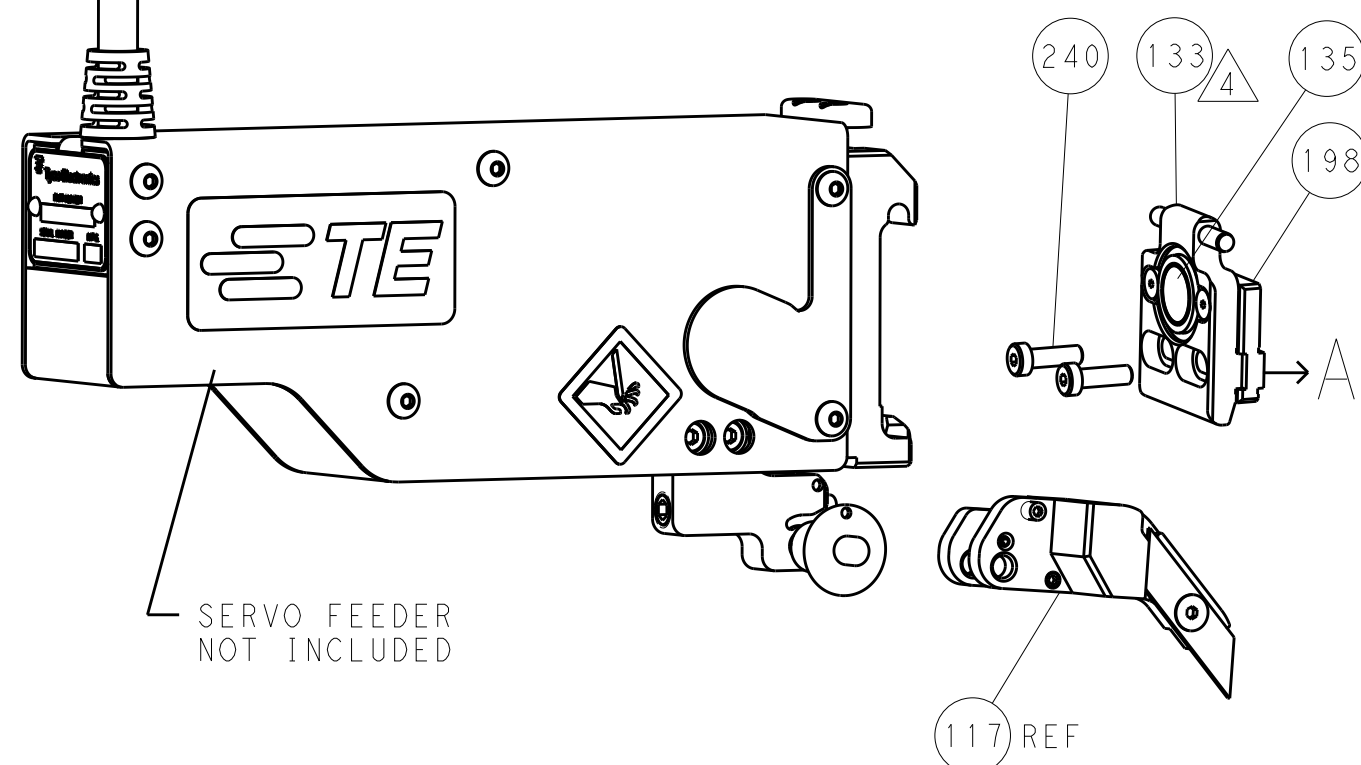
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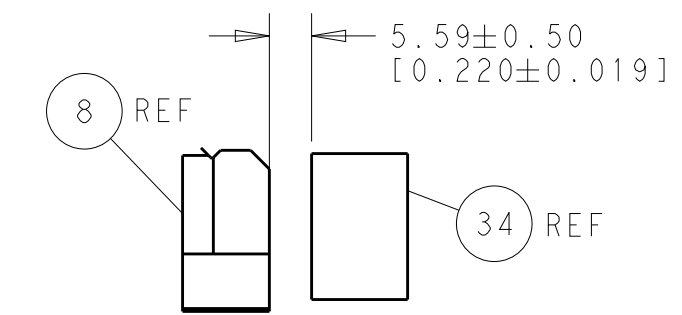
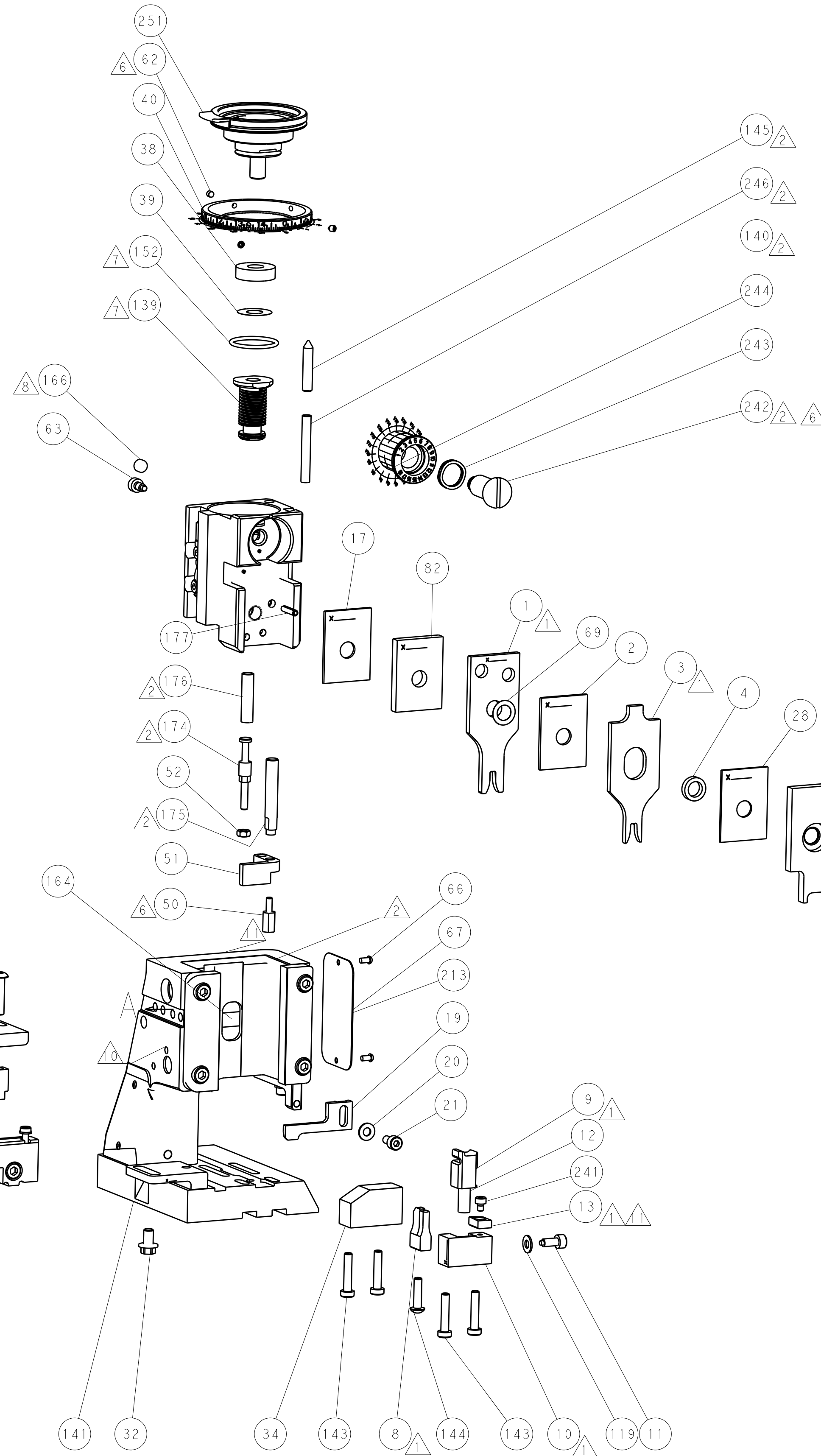
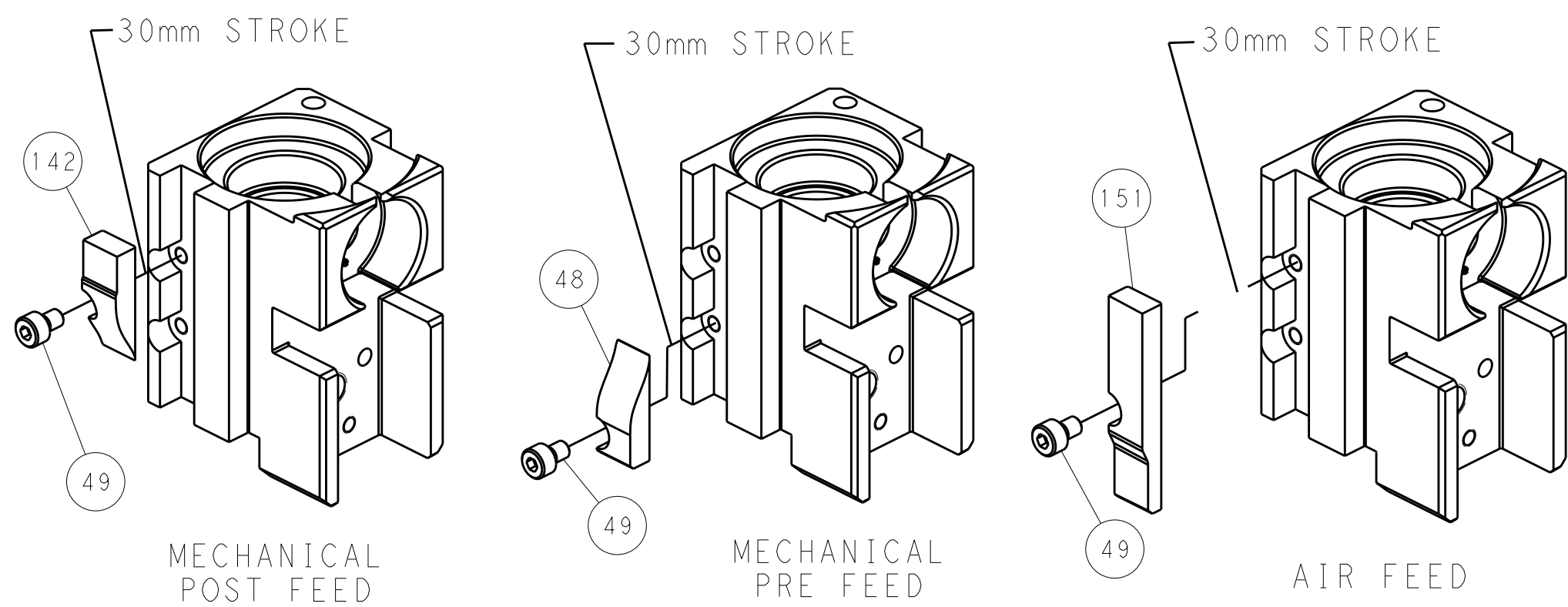
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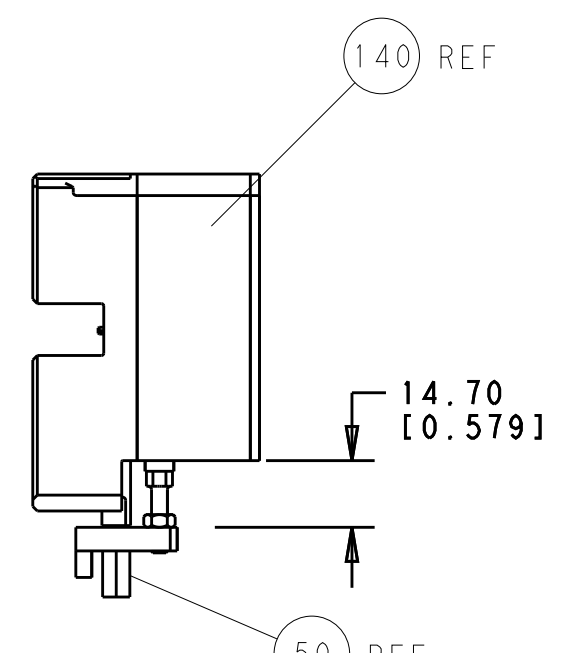
SERVO LATCH PLATE



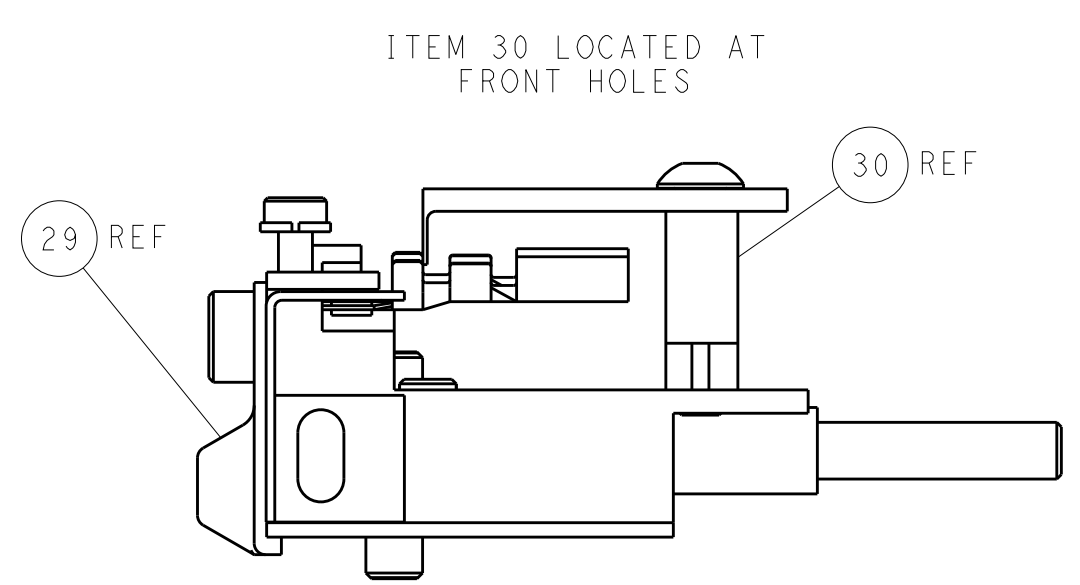
CAM POSITIONS



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)

1ST PUBLISHED: 12 SEP 2012 2ND PUBLISHED: 12 SEP 2012 3RD PUBLISHED: 12 SEP 2012 4TH PUBLISHED: 12 SEP 2012 5TH PUBLISHED: 12 SEP 2012 6TH PUBLISHED: 12 SEP 2012 7TH PUBLISHED: 12 SEP 2012 8TH PUBLISHED: 12 SEP 2012 9TH PUBLISHED: 12 SEP 2012 10TH PUBLISHED: 12 SEP 2012 11TH PUBLISHED: 12 SEP 2012 12TH PUBLISHED: 12 SEP 2012 13TH PUBLISHED: 12 SEP 2012 14TH PUBLISHED: 12 SEP 2012 15TH PUBLISHED: 12 SEP 2012 16TH PUBLISHED: 12 SEP 2012 17TH PUBLISHED: 12 SEP 2012 18TH PUBLISHED: 12 SEP 2012 19TH PUBLISHED: 12 SEP 2012 20TH PUBLISHED: 12 SEP 2012 21TH PUBLISHED: 12 SEP 2012 22TH PUBLISHED: 12 SEP 2012 23TH PUBLISHED: 12 SEP 2012 24TH PUBLISHED: 12 SEP 2012 25TH PUBLISHED: 12 SEP 2012 26TH PUBLISHED: 12 SEP 2012 27TH PUBLISHED: 12 SEP 2012 28TH PUBLISHED: 12 SEP 2012 29TH PUBLISHED: 12 SEP 2012 30TH PUBLISHED: 12 SEP 2012 31TH PUBLISHED: 12 SEP 2012 32TH PUBLISHED: 12 SEP 2012 33TH PUBLISHED: 12 SEP 2012 34TH PUBLISHED: 12 SEP 2012 35TH PUBLISHED: 12 SEP 2012 36TH PUBLISHED: 12 SEP 2012 37TH PUBLISHED: 12 SEP 2012 38TH PUBLISHED: 12 SEP 2012 39TH PUBLISHED: 12 SEP 2012 40TH PUBLISHED: 12 SEP 2012 41TH PUBLISHED: 12 SEP 2012 42TH PUBLISHED: 12 SEP 2012 43TH PUBLISHED: 12 SEP 2012 44TH PUBLISHED: 12 SEP 2012 45TH PUBLISHED: 12 SEP 2012 46TH PUBLISHED: 12 SEP 2012 47TH PUBLISHED: 12 SEP 2012 48TH PUBLISHED: 12 SEP 2012 49TH PUBLISHED: 12 SEP 2012 50TH PUBLISHED: 12 SEP 2012 51TH PUBLISHED: 12 SEP 2012 52TH PUBLISHED: 12 SEP 2012 53TH PUBLISHED: 12 SEP 2012 54TH PUBLISHED: 12 SEP 2012 55TH PUBLISHED: 12 SEP 2012 56TH PUBLISHED: 12 SEP 2012 57TH PUBLISHED: 12 SEP 2012 58TH PUBLISHED: 12 SEP 2012 59TH PUBLISHED: 12 SEP 2012 60TH PUBLISHED: 12 SEP 2012 61TH PUBLISHED: 12 SEP 2012 62TH PUBLISHED: 12 SEP 2012 63TH PUBLISHED: 12 SEP 2012 64TH PUBLISHED: 12 SEP 2012 65TH PUBLISHED: 12 SEP 2012 66TH PUBLISHED: 12 SEP 2012 67TH PUBLISHED: 12 SEP 2012 68TH PUBLISHED: 12 SEP 2012 69TH PUBLISHED: 12 SEP 2012 70TH PUBLISHED: 12 SEP 2012 71TH PUBLISHED: 12 SEP 2012 72TH PUBLISHED: 12 SEP 2012 73TH PUBLISHED: 12 SEP 2012 74TH PUBLISHED: 12 SEP 2012 75TH PUBLISHED: 12 SEP 2012 76TH PUBLISHED: 12 SEP 2012 77TH PUBLISHED: 12 SEP 2012 78TH PUBLISHED: 12 SEP 2012 79TH PUBLISHED: 12 SEP 2012 80TH PUBLISHED: 12 SEP 2012 81TH PUBLISHED: 12 SEP 2012 82TH PUBLISHED: 12 SEP 2012 83TH PUBLISHED: 12 SEP 2012 84TH PUBLISHED: 12 SEP 2012 85TH PUBLISHED: 12 SEP 2012 86TH PUBLISHED: 12 SEP 2012 87TH PUBLISHED: 12 SEP 2012 88TH PUBLISHED: 12 SEP 2012 89TH PUBLISHED: 12 SEP 2012 90TH PUBLISHED: 12 SEP 2012 91TH PUBLISHED: 12 SEP 2012 92TH PUBLISHED: 12 SEP 2012 93TH PUBLISHED: 12 SEP 2012 94TH PUBLISHED: 12 SEP 2012 95TH PUBLISHED: 12 SEP 2012 96TH PUBLISHED: 12 SEP 2012 97TH PUBLISHED: 12 SEP 2012 98TH PUBLISHED: 12 SEP 2012 99TH PUBLISHED: 12 SEP 2012 100TH PUBLISHED: 12 SEP 2012		DWN: BOB HIGMAN 12SEP2012 CHK: G. BAILEY 12SEP2012 APVD: G. BAILEY 12SEP2012 PRODUCT SPEC: - APPLICATION SPEC: - WEIGHT: - Customer Accessible Production Drawing		NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: 2151747 SCALE: 1:1 SHEET: 4 OF 4 REV: A		TE Connectivity Harrisburg, PA 17105-3608	
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