

| ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | | | |
|---|-------------|--------------------------|--------------------------------------|-------------------|-----------------------------------|-----------------------|-------------|-------------|-------------|------------------------|------------------------|---|---|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | | | |
| | | | | | | | | | | | | | |
| | 2151832-1 | D | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | | |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151832-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) | | |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151832-4 | - | - | - | | |
| | | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | | |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | | |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151832-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) | | |
| | 2151832-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SMART APPLICATOR | 2161326-1 | - | 8-2151832-4 | - | - | - | - | |
| | | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | | |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | | |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151832-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) | | |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151832-4 | - | - | - | | |
| | | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | | |
| 2151832-5 | D | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | - | | |
| | | | | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | | | |
| | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | | | |
| 2151832-6 | D | NON-CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | - | - | - | - | - | - | - | - | | |
| | | | | - | - | - | - | - | - | - | - | - | - |
| 2151832-7 | D | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | - | | |
| | | | | - | - | - | - | - | - | - | - | - | - |
| 3-2151832-2 | D | FINE CRIMP HEIGHT ADJUST | DOUBLE ACTING PNEUMATIC WITH SENSORS | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-1 | - | - | - | | |
| | | | | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-1 | 2119799-1 | 2063440-1 | | | |
| 7-2151832-7 | A | CRIMP TOOLING KIT | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151832-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) | | | |
| | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151832-4 | - | - | - | | | |

| APPLICATOR DATA | | |
|-----------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.12 mm [.044] | F |
| INSUL | 1.57 mm [.062] | O |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|----------------------------|------------------------------|-------------|
| TERMINAL NAME: CONTACT, MALE, GENERATION Y, 0.64 | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.00-4.50 mm [1.57-.177 IN] | | Ø0.85-1.05 mm [.033-.041 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-13183 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1924968-8 | 2035334-8 | 1924275-8 | 1456841-8 |
| 2098753-4 | 1924727-4 | 1456574-8 | 1456968-8 |
| 1924955-8 | 2035170-4 | 2098762-4 | 2138699-4 |
| WIRE SIZE | CRIMP HEIGHT | CRIMP HEIGHT | |
| 2x0.13 OR 2X26 AWG | 0.84+/-0.02 [.033+/-0.001] | REFERENCE SETTING | 8.8 |

- 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: 8-2151832-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151832-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151832-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151832-6
- 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 4.96.
- 13 THIS APPLICATOR HAS BEEN DESIGNED TO APPLY WIRES WITH THIN WALL (FLR) INSULATION.
- 14 THIS APPLICATOR EQUIPPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 248.

***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 | - | - | - | - | - | 1803430-1 | AIR FEED MODULE | 290 |
| - | - | - | 1 | - | - | - | 2119957-2 | APPLICATOR SHIM PACK | 260 |
| - | 1 | 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 |
| -77 | -32 | -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)

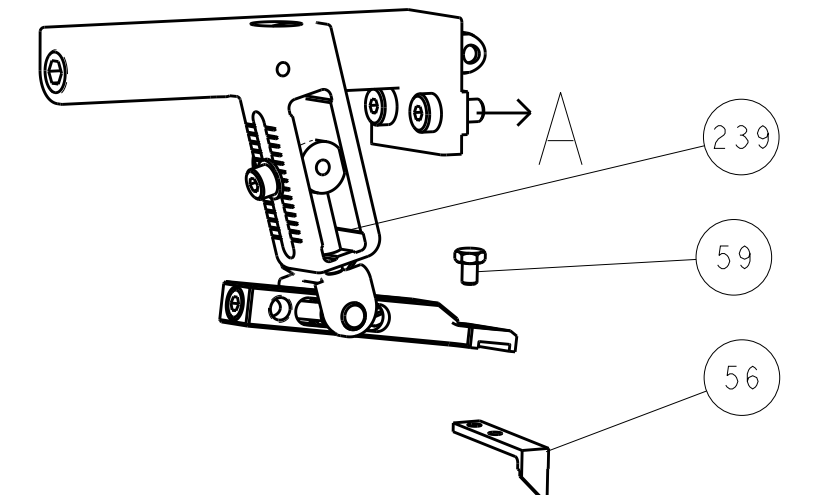
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|---------------|----------|-------|
| 2119599-1 | A | 66 | REV | DATE | BY | APPV |
| | | | D1 | ECR-16-015428 | 7NOV2016 | RS LZ |

| | | | | | | | | | |
|-----|-----|-----|-----|-----|-----|-----|-------------|-------------------------------------|---------|
| - | 1 | 1 | - | 1 | 1 | 1 | 2119798-1 | DETENT PIN | 247 |
| - | 1 | 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 | 1 | 2119082-8 | CAM, SNAIL, INSULATION ADJUSTMENT | 244 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2079764-1 | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119083-1 | RETAINER, INSULATION DIAL | 242 |
| - | 1 | 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 |
| - | - | - | - | - | - | - | 2063440-1 | AIR FEED MODULE | 238 |
| - | - | - | 1 | 1 | - | - | 2119740-2 | TAG, IDENTIFICATION | 213 |
| - | 1 | - | 1 | 1 | - | - | 1901094-3 | SPACER, FEEDER | 198 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-1752354-6 | STANDOFF, HOLD-DOWN | 180 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 9931111-1 | PIN, SLOTTED SPRING 3.0 X 20.0 | 177 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 8-22280-7 | SPRING, COMPRESSION | 176 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1752353-2 | GUIDE PIN, HOLDDOWN | 175 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1901680-2 | GUIDE PIN, HOLDDOWN | 174 |
| - | 2 | - | - | - | 2 | - | 21045-3 | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 994969-1 | MAGNET, RARE EARTH HIGH ENERGY | 166 |
| - | REF | REF | REF | REF | REF | REF | 994970-2 | COUNTER, MAGNETIC | 164 |
| - | 1 | - | - | - | 1 | - | 240638-1 | SPRING, FEED FINGER | 163 |
| - | 1 | - | - | - | 1 | - | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
| - | 1 | - | - | - | 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 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | - | REF | REF | - | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | 117 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 455888-4 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 70 |
| - | 1 | 1 | - | - | 1 | 1 | 2119740-1 | TAG, IDENTIFICATION | 67 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 2168078-1 | SCREW, DRIVE, RH, RoHS, 2 x .188 | 66 |
| - | 1 | 1 | - | 1 | 1 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| - | 3 | 3 | - | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 x 4.0 | 62 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2079383-4 | SCR, BHSC, RoHS (M4 X 8) | 60 |
| - | 1 | - | - | - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | - | - | - | - | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 4 | 4 | 4 | 4 | 4 | 4 | 2168400-1 | SHCS, LOW HEAD, RoHS, M4 X 12 | 54 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1901681-1 | HOLDDOWN, TERMINAL | 51 |
| - | - | - | - | - | - | 1 | 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 | 1 | 2119656-9 | APPLICATOR BASIC ASSEMBLY, SF | 46 |
| - | 1 | 1 | - | 1 | 1 | 1 | 2119370-1 | RAM, AMP STYLE, SIDE FEED | 44 |
| - | 1 | 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 | 1 | 2119644-1 | RAM WASHER, PRECISION | 38 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119085-1 | FA HEAD, ATLANTIC STYLE | 37 |
| - | 1 | 1 | - | 1 | 1 | 1 | 2119092-1 | BOLT, ADJUSTMENT | 35 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1752356-1 | SUPPORT, TERMINAL | 34 |
| - | 2 | 2 | 2 | 2 | 2 | 2 | 2079383-5 | SCR, BHSC, RoHS (M4 X 20) | 33 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2161328-1 | HEX HEAD, FLANGED, M5 x 8mm LONG | 32 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1320908-6 | SPACER, STRIP GUIDE | 30 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119959-7 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1320928-2 | STRIP GUIDE | 24 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2168083-2 | SCR, SKT HD CAP, RoHS, M4 X 8.0 | 21 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-18028-2 | WASHER, FLAT, REG M4 | 20 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119533-1 | STRIPPER, SIDE FEED | 19 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119806-1 | INSERT, SHEAR | 13 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 3-22280-3 | SPRING, COMPRESSION | 12 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-356885-4 | STOP, SHEAR | 11 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119805-1 | SHEAR HOLDER, FRONT | 10 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1803095-1 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1803058-6 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 3-238011-1 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 1-1803019-1 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 455888-1 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 1 | 1 | 3-1633860-6 | CRIMPER, WIRE | 1 |
| -77 | -32 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

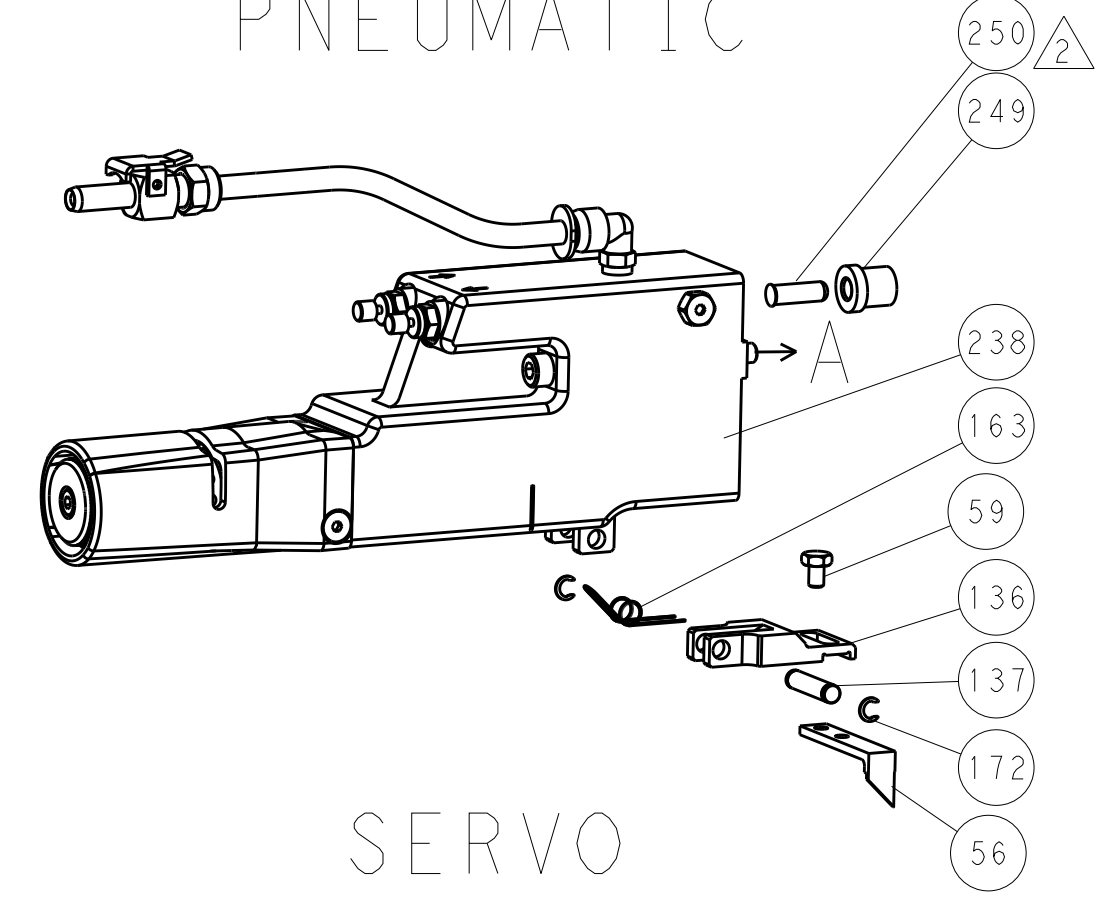
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| mm | 0 PLC | ± | | 26APR2010 | CHK |
| | 1 PLC | ± | | 26APR2010 | CHK |
| | 2 PLC | ± | | | |
| | 3 PLC | ± | | | |
| | 4 PLC | ± | | | |
| | ANGLES | ± | | | |
| MATERIAL | FINISH | | | APVD | U. GUO 26APR2010 |
| | | | | PRODUCT SPEC | |
| | | | | APPLICATION SPEC | |
| | | | | WEIGHT | |
| | | | | SIZE | CAGE CODE DRAWING NO |
| | | | | A1 | 00779 ©=2151832 |
| | | | | Customer Accessible Production Drawing | |
| | | | | SCALE | 1:2 SHEET 1 OF 4 REV D1 |

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

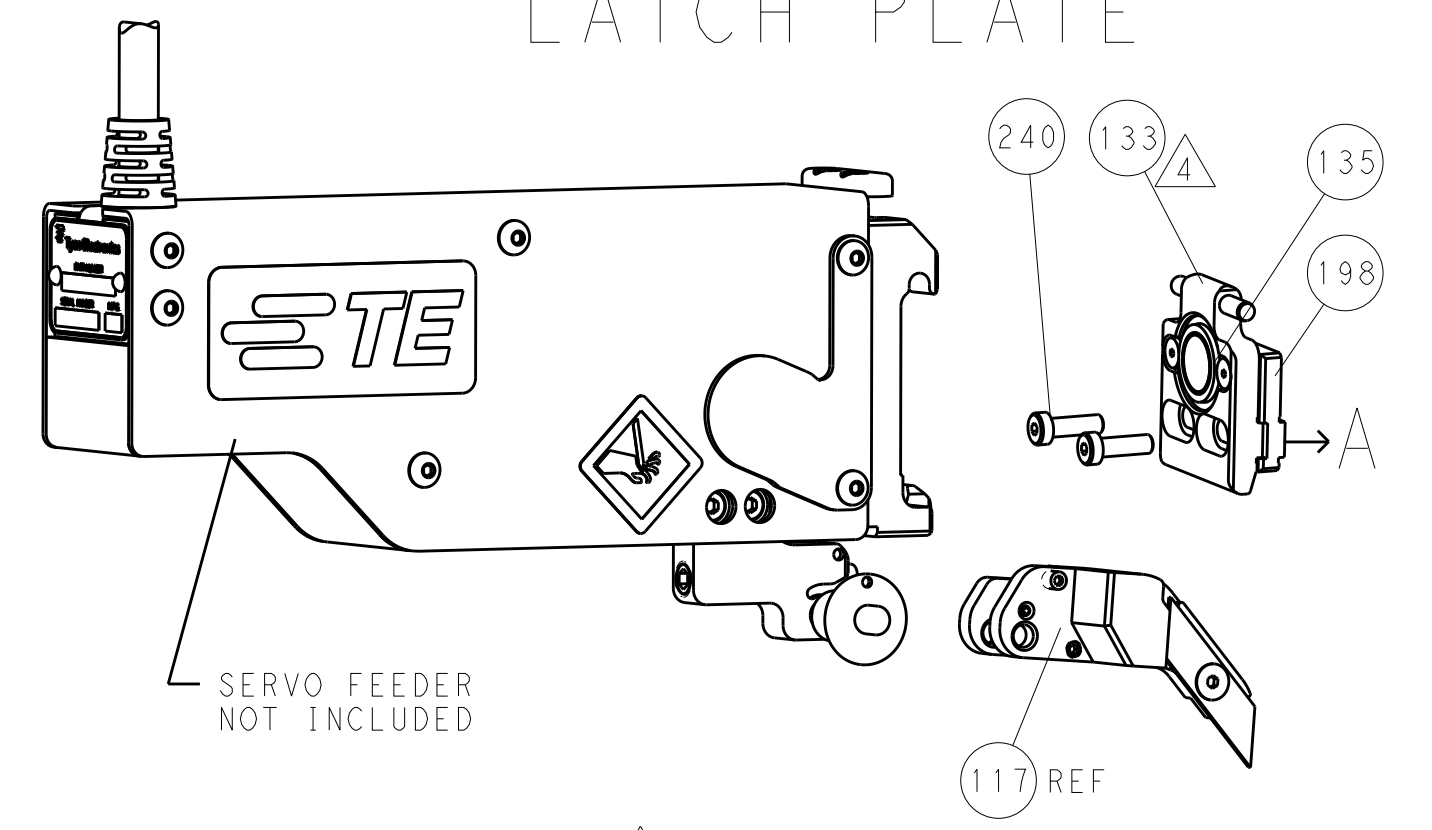
FEED TYPE MECHANICAL



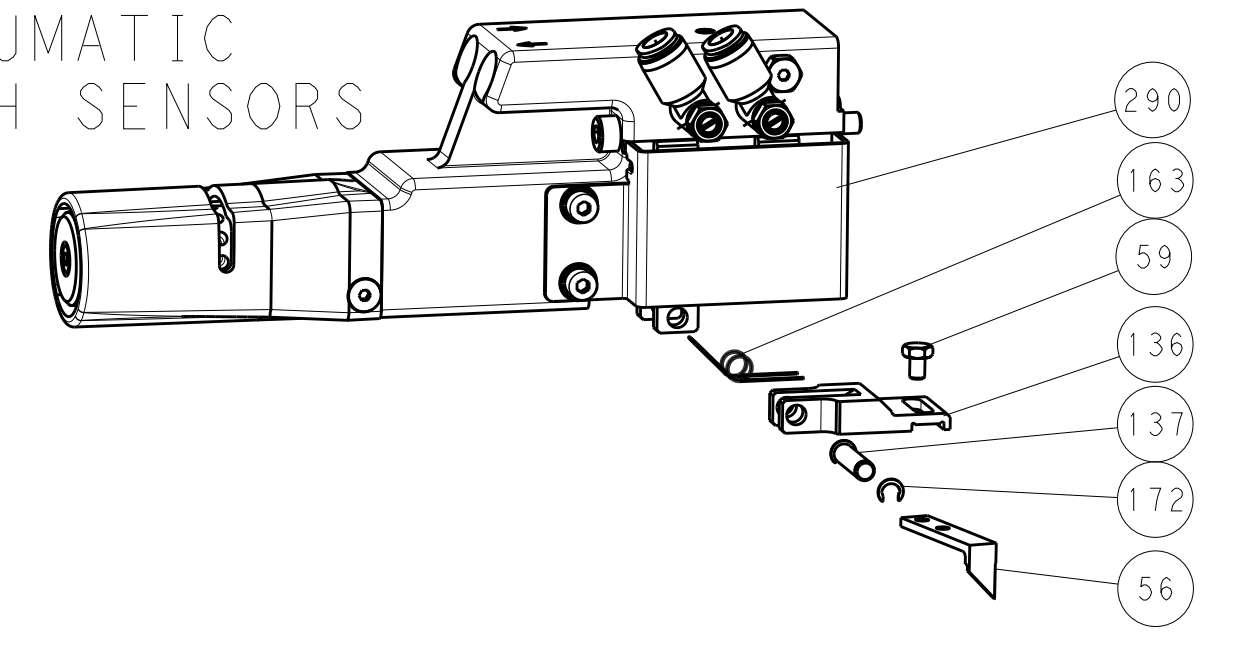
PNEUMATIC



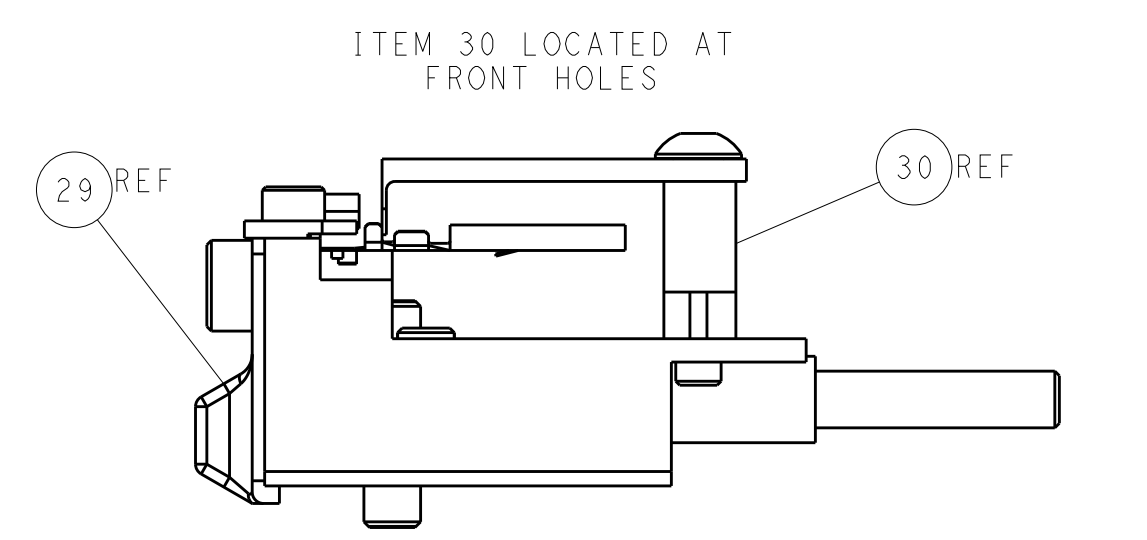
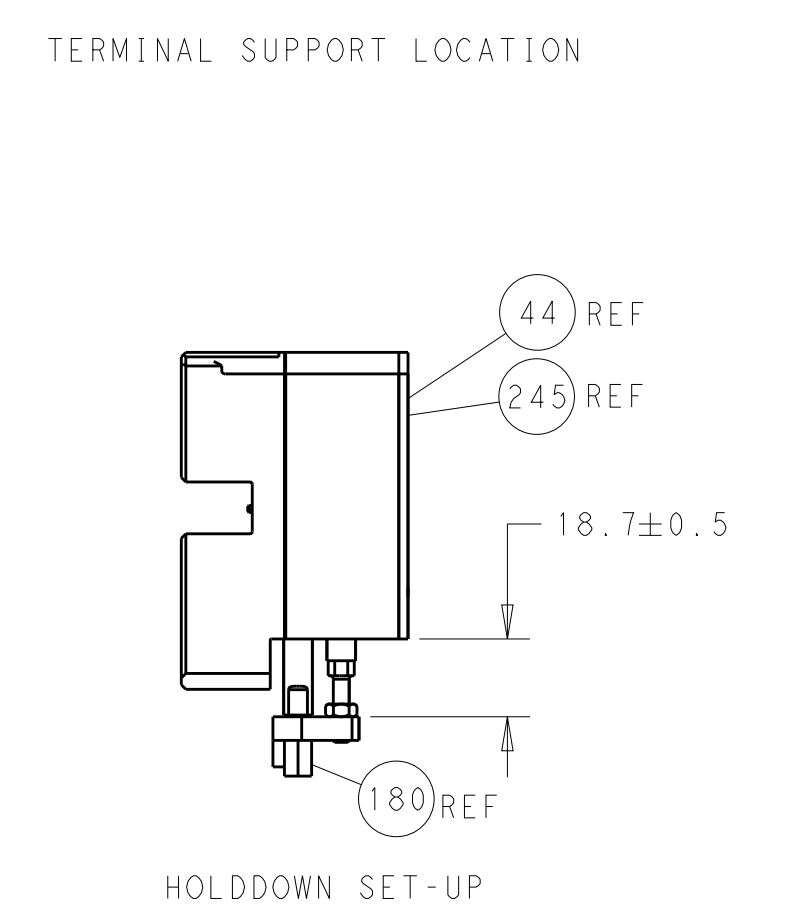
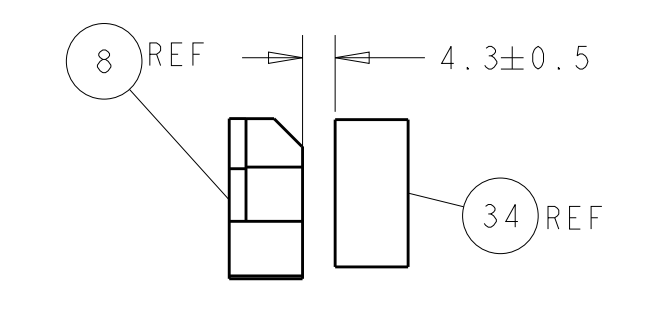
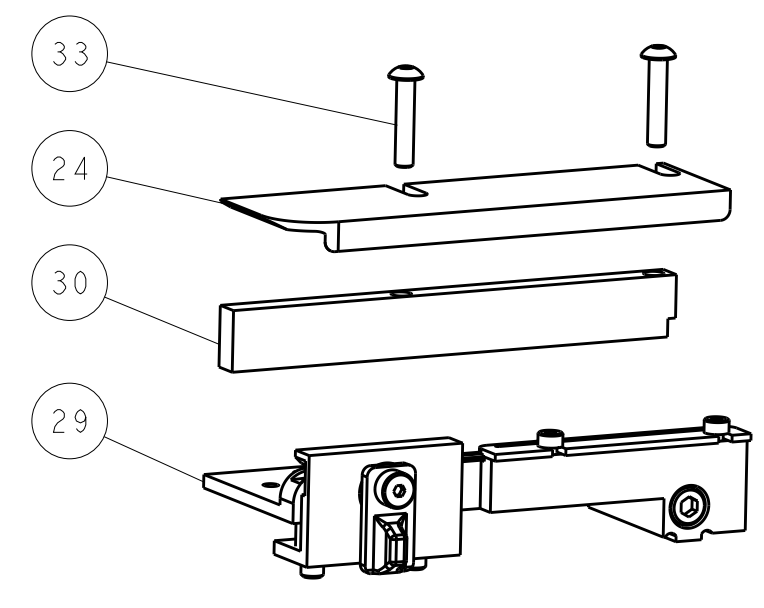
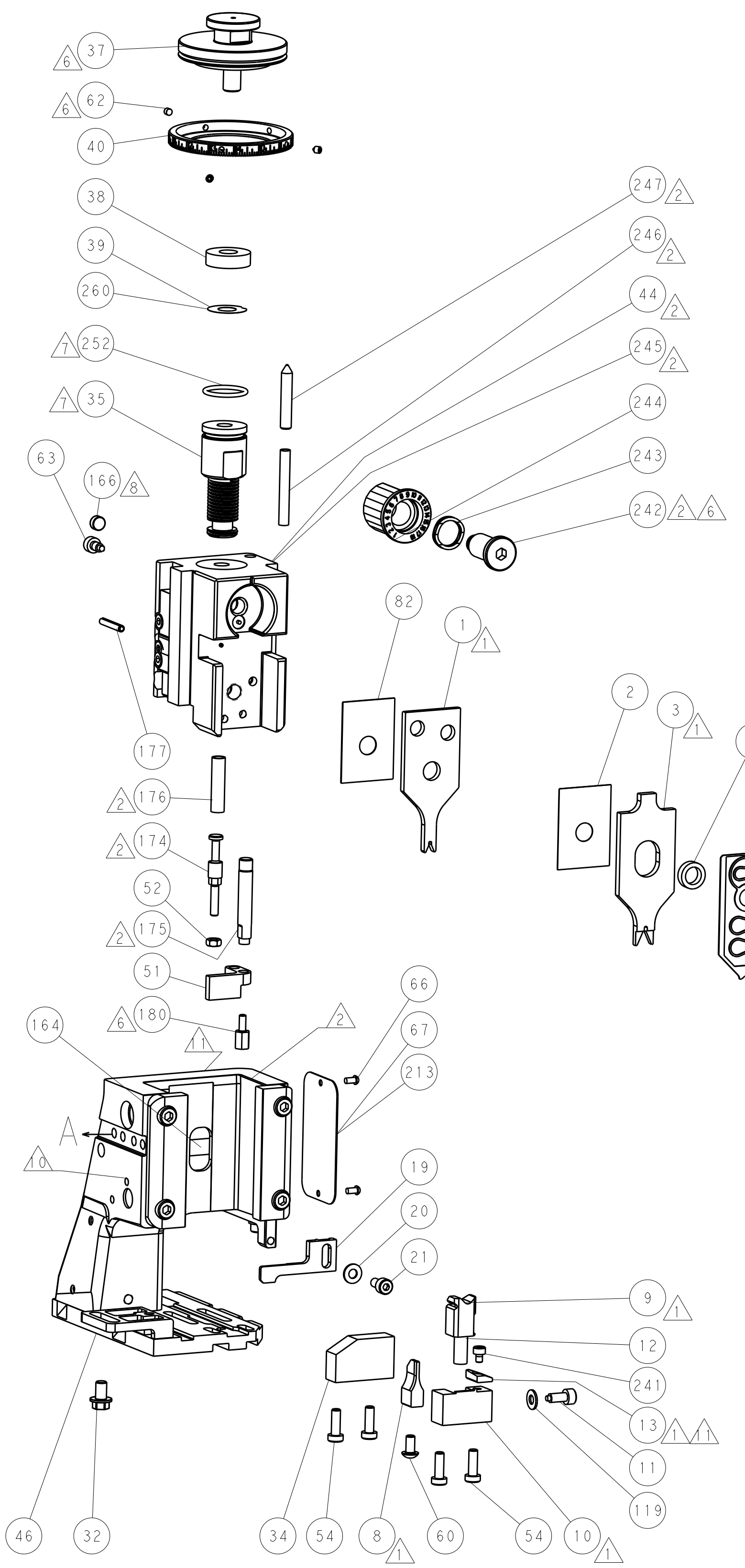
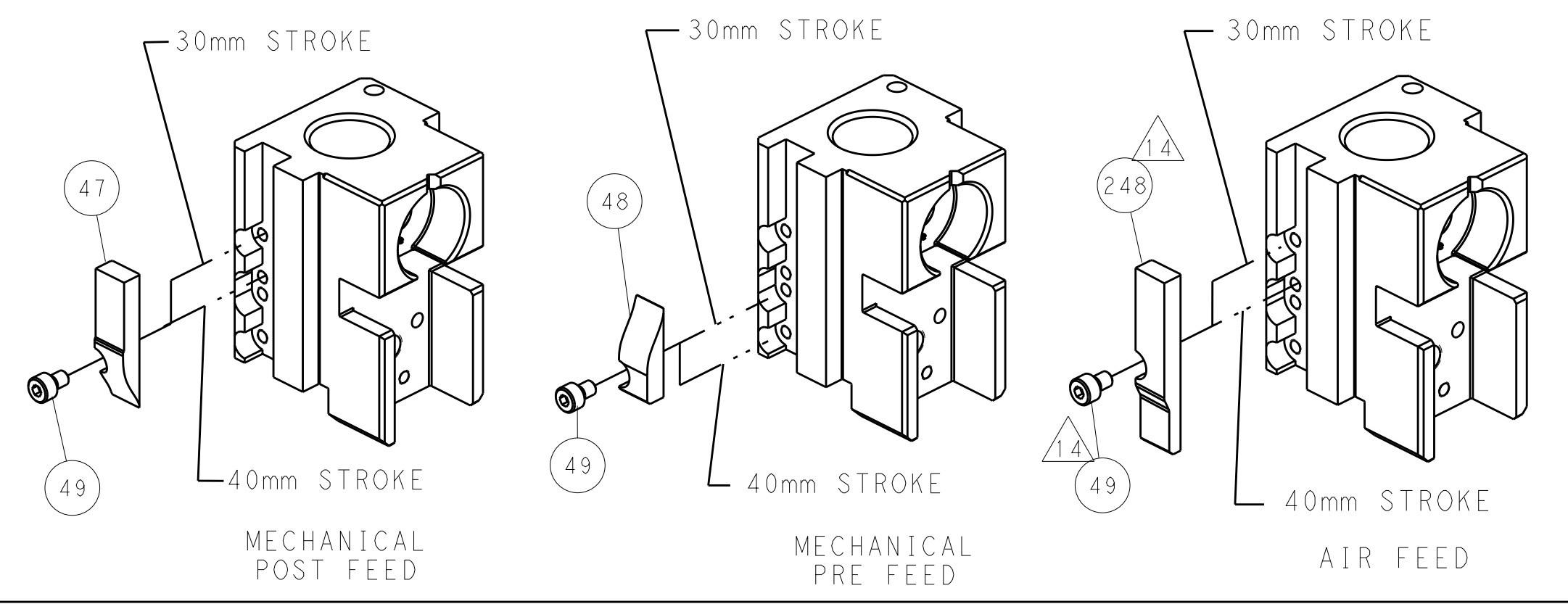
SERVO LATCH PLATE



DOUBLE ACTING PNEUMATIC WITH SENSORS



CAM POSITIONS



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: H. HUANG 26APR2010 | | TE Connectivity | |
| mm | 0 PLC ± | 1 PLC ± | 2 PLC ± | 3 PLC ± | 4 PLC ± | Harrisburg, PA 17105-3608 | |
| MATERIAL: | | FINISH: | | CHK: L. ZHANG 26APR2010 | | NAME: Ocean Side Feed Applicator | |
| | | | | APVD: H. GUO 26APR2010 | | SIZE: CAGE CODE: DRAWING NO: A1 00779 ©=2151832 | |
| | | | | WEIGHT: | | RESTRICTED TO: Customer Accessible Production Drawing | |
| | | | | SCALE: 1:2 | | SHEET 2 OF 4 REV D1 | |

| PACIFIC VERSION TERMINATOR INTERFACE ADAPTER | PART NUMBER | REVISION | DESCRIPTION | FEED TYPE | APPLICATOR STYLE CONVERSION CHART | | | | | | | |
|--|-------------|--------------------------|--------------------------------------|-------------------|-----------------------------------|-----------------------|-------------|-------------|-------------|------------------------|------------------------|---|
| | | | | | CONVERT TO | PART NUMBERS REQUIRED | | | | | | |
| | | | | | | | | | | | | |
| | 2-2151832-1 | D | FINE CRIMP HEIGHT ADJUST | MECHANICAL | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 | |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151832-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) | |
| | | | | | SMART APPLICATOR | 2161326-1 | - | 8-2151832-4 | - | - | - | |
| | | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - | |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151832-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) | |
| | 2-2151832-2 | D | FINE CRIMP HEIGHT ADJUST | PNEUMATIC | SMART APPLICATOR | 2161326-1 | - | 8-2151832-4 | - | - | - | - |
| | | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | |
| | | | | | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - | |
| | | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151832-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) | |
| | | | | | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 | |
| | | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | |
| 2-2151832-5 | D | FINE CRIMP HEIGHT ADJUST | SERVO LATCH PLATE | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | - | | |
| | | | | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 | | |
| | | | | DOUBLE ACTING | 2119950-2 | 1338685-1 | 5-18022-5 | - | 2119799-1 | 1803430-1 | | |
| 2-2151832-7 | D | FINE CRIMP HEIGHT ADJUST | NONE | - | - | - | - | - | - | - | | |
| | | | | - | - | - | - | - | - | - | | |
| 4-2151832-2 | D | FINE CRIMP HEIGHT ADJUST | DOUBLE ACTING PNEUMATIC WITH SENSORS | MECHANICAL FEED | 2119949-1 | 1338685-1 | 5-18022-5 | 2119653-2 | - | 2168400-6 (QUANTITY 2) | | |
| | | | | PNEUMATIC FEED | 2119950-1 | 1338685-1 | 5-18022-5 | 2119641-2 | 2119799-1 | 2063440-1 | | |
| | | | | SERVO LATCH PLATE | 2119951-1 | - | 8-2151832-5 | 1901094-3 | 1-1752354-6 | 2168400-6 (QUANTITY 2) | | |
| 7-2151832-7 | A | CRIMP TOOLING KIT | - | - | - | - | - | - | - | - | | |
| | | | | - | - | - | - | - | - | - | | |

| APPLICATOR DATA | | |
|--------------------------------------|----------------|------|
| CRIMP | SIZE | TYPE |
| WIRE | 1.12 mm [.044] | F |
| INSUL | 1.57 mm [.062] | O |
| APPLICATOR INSTRUCTIONS 408-10389 | | |

| TERMINAL DATA: TE TERMINAL | | TE CRIMP SPECIFICATION | |
|--|----------------------------|------------------------------|-------------------|
| TERMINAL NAME: CONTACT, MALE, GENERATION Y, 0.64 | | | |
| WIRE STRIP LENGTH | | INSULATION DIAMETER RANGE | |
| 4.00-4.50 mm [.157-.177 IN] | | Ø0.85-1.05 mm [.033-.041 IN] | |
| TERMINAL APPLICATION SPECIFICATION | 114-13183 | | |
| TERMINALS APPLIED | | | |
| TE TERMINAL | TE TERMINAL | TE TERMINAL | TE TERMINAL |
| 1924968-8 | 2035334-8 | 1924275-8 | 1456841-8 |
| 2098753-4 | 1924727-4 | 1456574-8 | 1456968-8 |
| 1924955-8 | 2035170-4 | 2098762-4 | 2138699-4 |
| WIRE SIZE | CRIMP HEIGHT | CRIMP HEIGHT | CRIMP HEIGHT |
| 2x0.13 OR 2X26 AWG | mm [INCH] | mm [INCH] | REFERENCE SETTING |
| | 0.84+/-0.02 [.033+/-0.001] | | 8.8 |

- 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: 8-2151832-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151832-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151832-5
- 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 62 & 180
 APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.
- 12. THIS APPLICATOR HAS BEEN DESIGNED TO APPLY WIRES WITH THIN WALL (FLR) INSULATION.
- 13. THIS APPLICATOR EQUIPPED WITH THE DOUBLE ACTING PNEUMATIC FEED WITH SENSORS, AND IS APPLICATION SPECIFIC AND DOES NOT REQUIRE ITEMS 49 & 151.

***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 | - | - | - | - | 1803430-1 | AIR FEED MODULE | 290 |
| - | 1 | 1 | 1 | 1 | 1 | 2119782-1 | FINE ADJUST HEAD ASM, PACIFIC STYLE | 251 |
| - | - | - | - | 1 | - | 2119640-1 | PUSH ROD, AIR FEED | 250 |
| - | - | - | - | 1 | - | 2079988-1 | BUSHING, LCH5-12, MISUMI | 249 |
| -77 | -42 | -27 | -25 | -22 | -21 | PART NO | DESCRIPTION | ITEM NO |

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

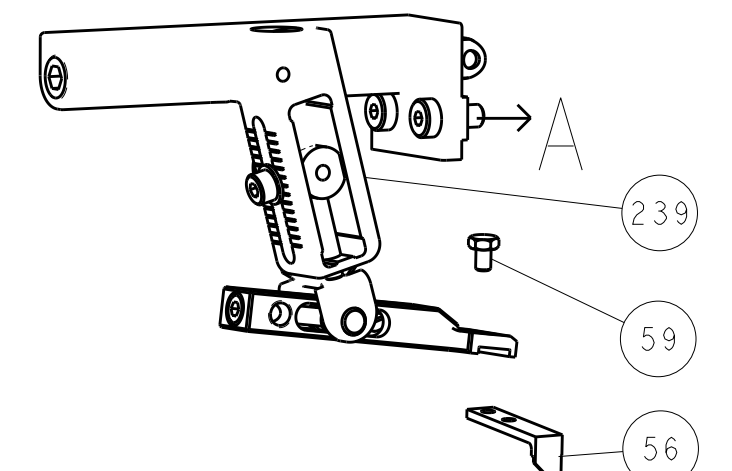
| SET UP GAUGE | LOC | DIST | REVISIONS | | | |
|--------------|-----|------|-----------|-------------|----|------|
| 2119599-1 | A | 66 | REV | DATE | BY | APPV |
| | | | - | SEE SHEET 1 | | |

| | | | | | | | | |
|---|-----|-----|-----|-----|-----|-------------|-------------------------------------|-----|
| - | 1 | 1 | 1 | 1 | 1 | 1-22279-3 | SPRING, COMPRESSION | 246 |
| - | 1 | 1 | 1 | 1 | 1 | 2119082-8 | 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 | - | - | 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 | - | - | 2119740-2 | TAG, IDENTIFICATION | 213 |
| - | - | - | 1 | - | - | 1901094-3 | SPACER, FEEDER | 198 |
| - | 1 | 1 | 1 | 1 | 1 | 1-1752354-6 | STANDOFF, HOLD-DOWN | 180 |
| - | 1 | 1 | 1 | 1 | 1 | 9931111-1 | 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 | - | - | 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 | - | - | 1 | - | 240638-1 | SPRING, FEED FINGER | 163 |
| - | 1 | 1 | 1 | 1 | 1 | 8-21084-1 | O-RING, .801 ID, .070 DIA. MAT. | 152 |
| - | 1 | - | - | 1 | - | 2119641-2 | FEED CAM, AIR FEED | 151 |
| - | 1 | 1 | 1 | 1 | 1 | 2119798-2 | DETENT PIN | 145 |
| - | 1 | 1 | 1 | 1 | 1 | 2079383-8 | SCR, BHSC, RoHS (M4 X 16) | 144 |
| - | 4 | 4 | 4 | 4 | 4 | 2168400-5 | SHCS, LOW HEAD, RoHS, M4 X 20 | 143 |
| - | - | - | - | - | 1 | 2119653-2 | FEED CAM, POST FEED | 142 |
| - | 1 | 1 | 1 | 1 | 1 | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF | 141 |
| - | 1 | 1 | 1 | 1 | 1 | 2119650-1 | RAM, ASIAN STYLE, SIDE FEED | 140 |
| - | 1 | 1 | 1 | 1 | 1 | 2119092-2 | BOLT, ADJUSTMENT | 139 |
| - | 1 | - | - | 1 | - | 3-23627-7 | PIN, RETAIN, GRVD, 3/16 X .854 | 137 |
| - | 1 | - | - | 1 | - | 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 | 1-18028-2 | WASHER, FLAT, REG M4 | 119 |
| - | - | - | REF | - | - | 2119944-1 | FEED FINGER ASSEMBLY, SF | 117 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-4 | SPACER, CRIMPER | 82 |
| - | 1 | 1 | 1 | 1 | 1 | 2119956-1 | DOCUMENTATION PACKAGE | 71 |
| - | 1 | 1 | 1 | 1 | 1 | 2119791-9 | DEPRESSOR, WIRE | 70 |
| - | 1 | 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 | 1 | 2119793-1 | LIMITER, ADJUSTMENT BOLT | 63 |
| - | 3 | 3 | 3 | 3 | 3 | 992763-5 | SCR, SET, SOC, CONE POINT, M3 X 4.0 | 62 |
| - | 1 | - | - | 1 | 1 | 5-18022-5 | SCR, HEX HD CAP, M4 X 6.0 | 59 |
| - | 1 | - | - | 1 | 1 | 1338685-1 | PAWL, FEED | 56 |
| - | 1 | 1 | 1 | 1 | 1 | 1-5018030-0 | NUT, HEX, REG, RoHS, M3.5 | 52 |
| - | 1 | 1 | 1 | 1 | 1 | 1901681-1 | HOLDDOWN, TERMINAL | 51 |
| - | - | - | - | 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 | 1752356-1 | 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 | 2119959-7 | ASSEMBLY, STRIP GUIDE | 29 |
| - | 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 | 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 | 1803095-1 | FLOATING SHEAR, FRONT | 9 |
| - | 1 | 1 | 1 | 1 | 1 | 1803058-6 | ANVIL, COMBINATION | 8 |
| - | - | - | - | - | - | - | - | 7 |
| - | - | - | - | - | - | - | - | 6 |
| - | 1 | 1 | 1 | 1 | 1 | 2119757-8 | DEPRESSOR, SHEAR | 5 |
| - | 1 | 1 | 1 | 1 | 1 | 3-238011-1 | BLOCK, CRIMPER SPACER | 4 |
| - | 1 | 1 | 1 | 1 | 1 | 1-1803019-1 | CRIMPER, INSULATION O | 3 |
| - | 1 | 1 | 1 | 1 | 1 | 455888-1 | SPACER, CRIMPER | 2 |
| - | 1 | 1 | 1 | 1 | 1 | 3-1633860-6 | CRIMPER, WIRE | 1 |

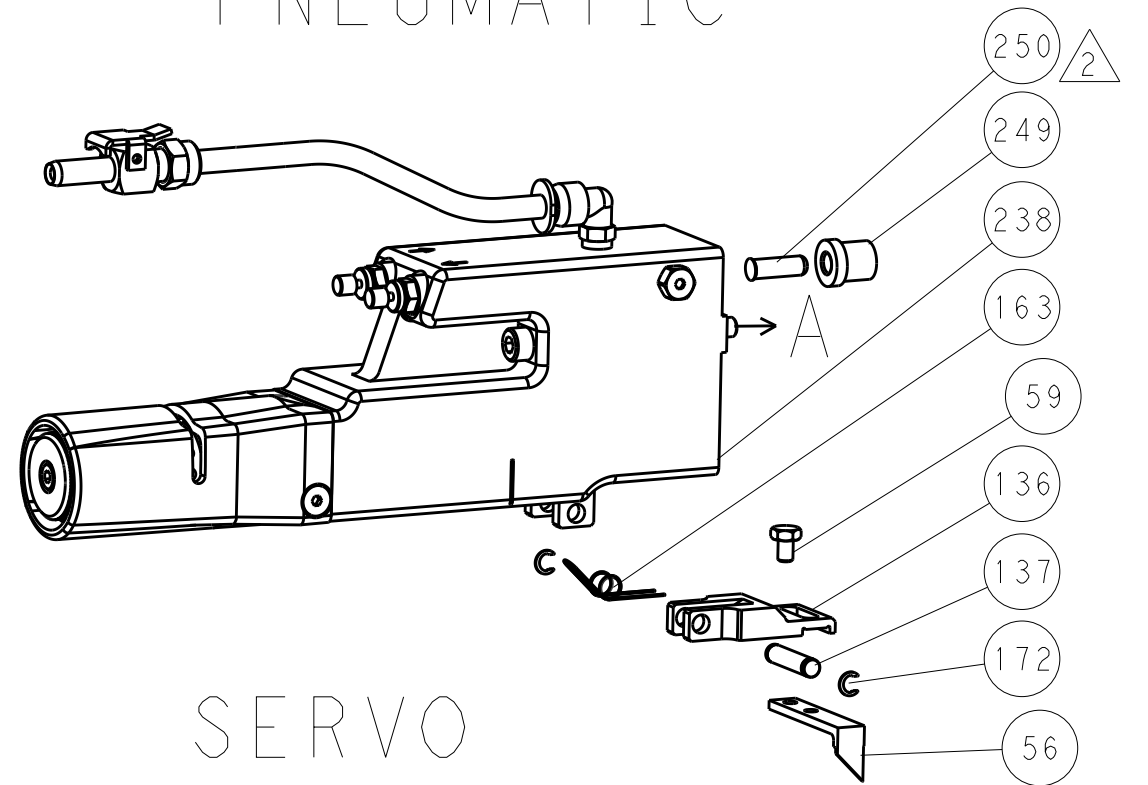
| DIMENSIONS: | | TOLERANCES UNLESS OTHERWISE SPECIFIED: | | DWG | | REV | |
|-------------|--------|--|--|------------------|-----------|------------------|-----------|
| mm | 0 PLC | ± | | CH | 26APR2010 | CH | 26APR2010 |
| | 1 PLC | ± | | L | | L | |
| | 2 PLC | ± | | Z | | Z | |
| | 3 PLC | ± | | APVD | | APVD | |
| | 4 PLC | ± | | U | 26APR2010 | U | |
| | ANGLES | ± | | PRODUCT SPEC | | PRODUCT SPEC | |
| | FINISH | ± | | APPLICATION SPEC | | APPLICATION SPEC | |
| MATERIAL | | | | WEIGHT | | WEIGHT | |
| | | | | SCALE | 1:2 | SCALE | 1:2 |
| | | | | SHEET | 3 | SHEET | 3 |
| | | | | REV | 1 | REV | 1 |

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

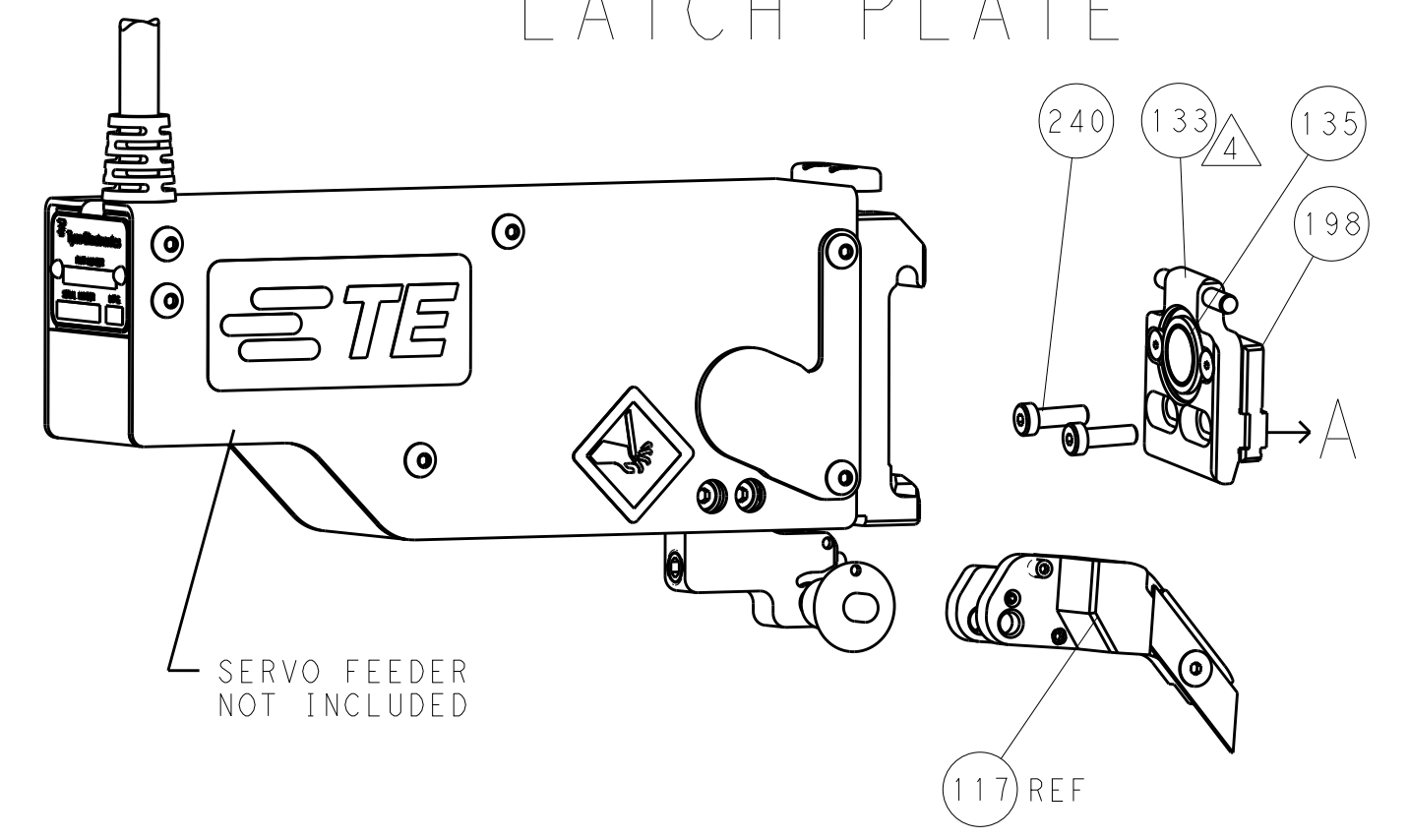
FEED TYPE MECHANICAL



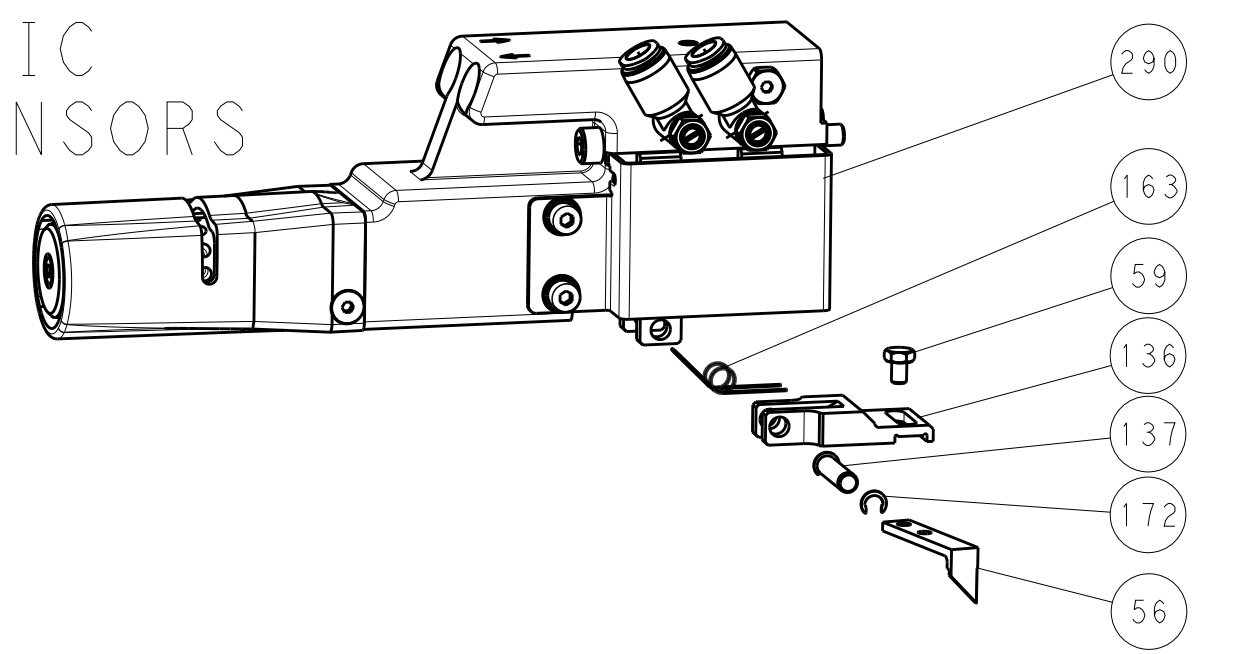
PNEUMATIC



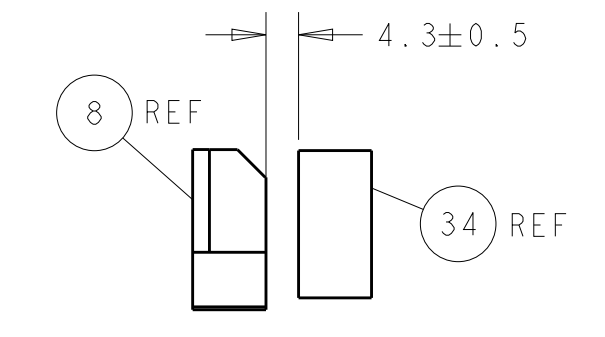
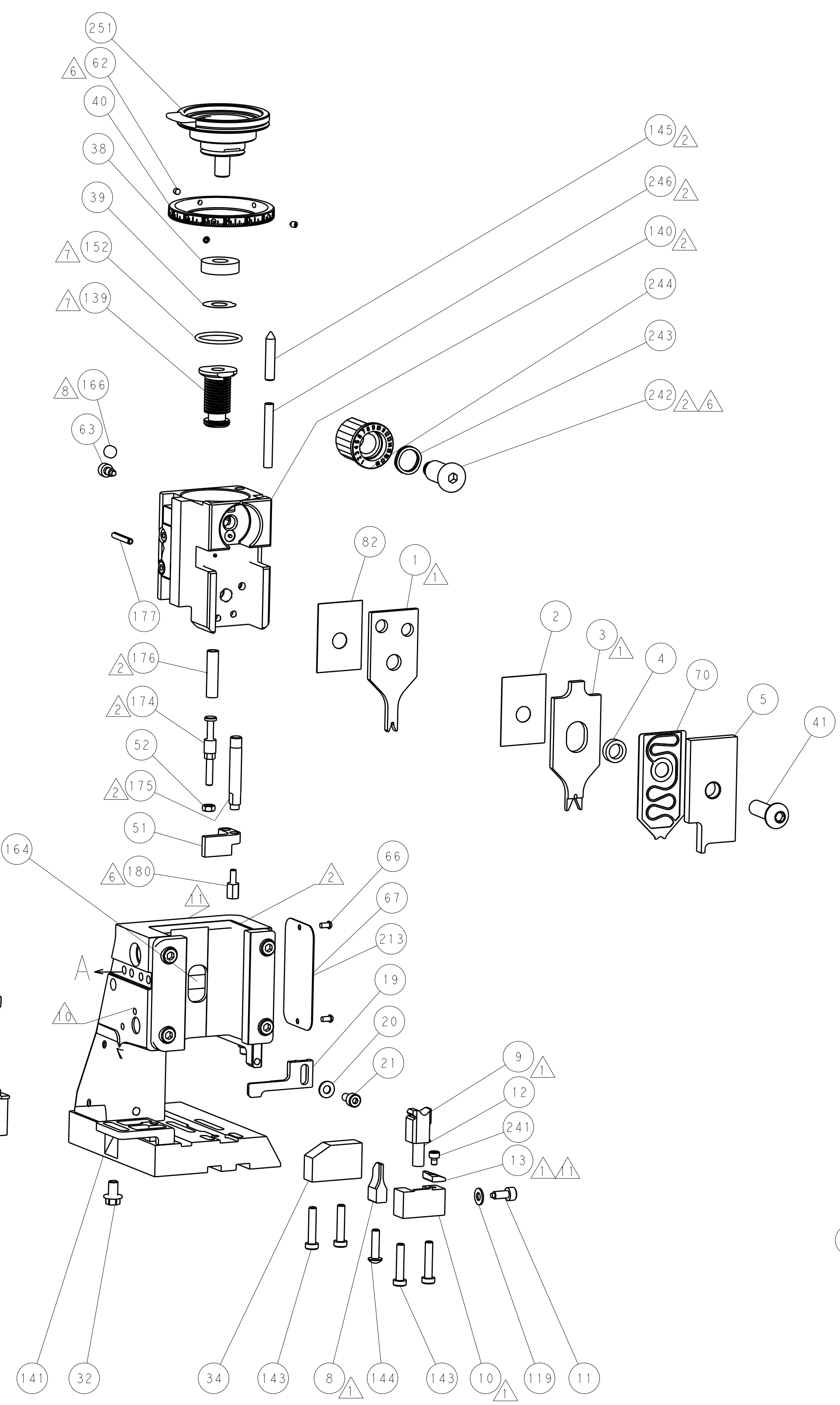
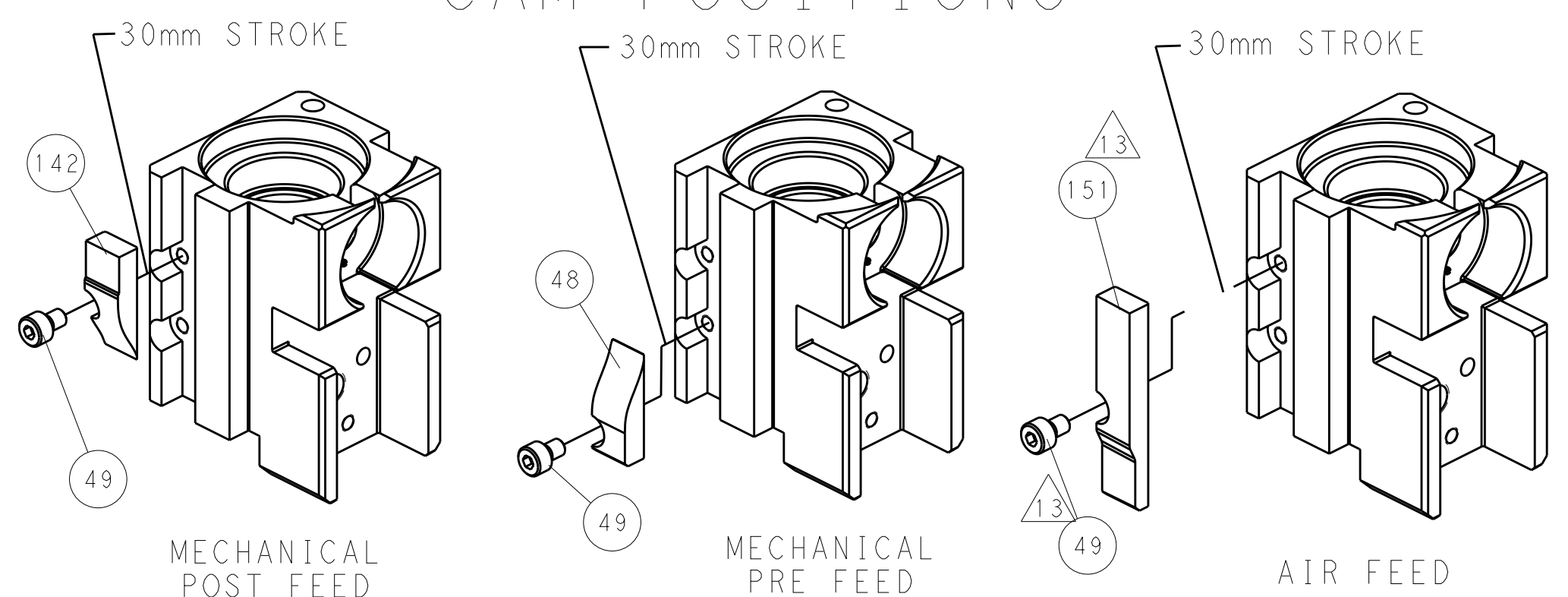
SERVO LATCH PLATE



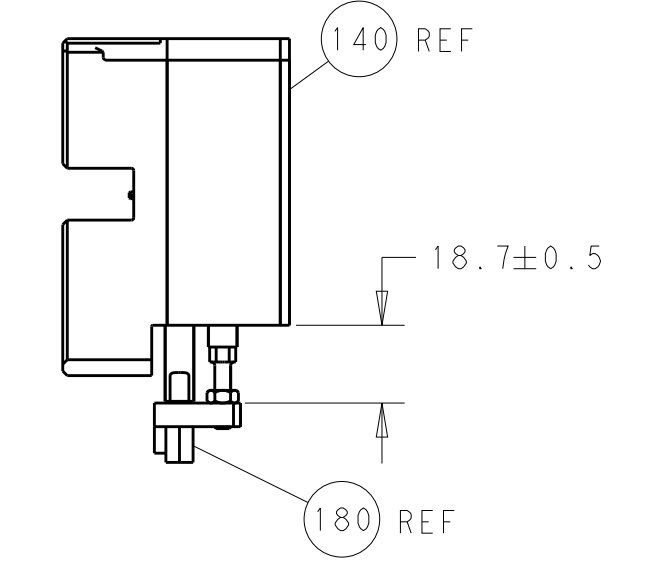
DOUBLE ACTING PNEUMATIC WITH SENSORS



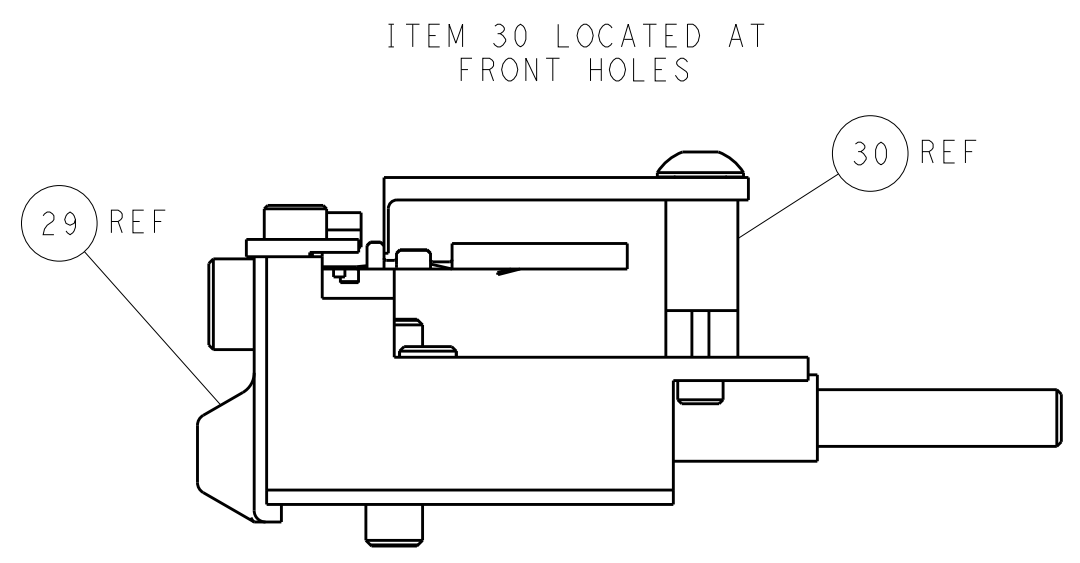
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



ITEM 30 LOCATED AT FRONT HOLES

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: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± | | DWN: H. HUANG 26APR2010 CHK: L. ZHANG 26APR2010 APVD: H. GUO 26APR2010 NAME: Ocean Side Feed Applicator SIZE: A1 CAGE CODE: 00779 DRAWING NO: C=2151832 SCALE: 1:2 SHEET: 4 of 4 REV: D1 | | STE TE Connectivity Harrisburg, PA 17105-3608 RESTRICTED TO | |
| MATERIAL: | | FINISH: | | WEIGHT: | | Customer Accessible Production Drawing | |