

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THIS DRAWING IS UNPUBLISHED.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

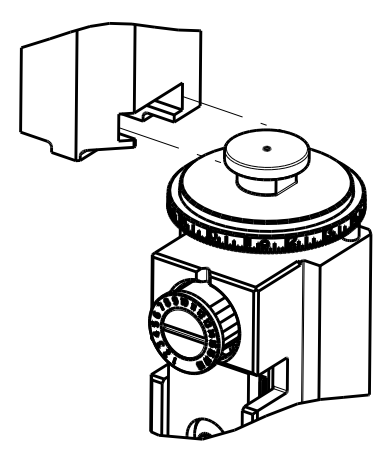
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151060-1

E

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

2119950-1 2119951-1 2161326-1

1338685-1

5-18022-5

2119641-1 2119799-1

2063440-1

2151060-2

E

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

2119949-1 2119951-1 2161326-1

1338685-1

5-18022-5

2119653-1

-

-

2151060-5

E

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

MECHANICAL FEED

2119949-1 2119950-1

1338685-1

5-18022-5

2119653-1 2119641-1

-

2119799-1

2063440-1

2151060-6

E

NON-CRIMP HEIGHT ADJUST

SERVO LATCH PLATE

4

12

-

-

-

-

-

-

2151060-7

E

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

7-2151060-7

E

CRIMP TOOLING KIT

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.03 mm [ .080 ]

F

INSUL

4.06 mm [ 1.60 ]

O

APPLICATOR INSTRUCTIONS

408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

3.70-4.30 mm [ .146-.169 IN ]

Ø1.40-2.70 mm [ .055-.106 IN ]

TERMINAL APPLICATION SPECIFICATION

(C) 114-18387

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE SEAL

TE SEAL

CABLE DIAMETER

(C) 1241394-1

(C) 1241394-3

963294-1

Ø1.2-2.0

(C) 1241394-2

963293-1

Ø2.0-2.7

WIRE SIZE

CRIMP HEIGHT mm [ INCH ]

CRIMP HEIGHT REFERENCE SETTING

1.00mm2

1.20+/-0.05 [ .047+/- .002 ]

6.5

0.75mm2

1.18+/-0.05 [ .046+/- .002 ]

6.9

0.50mm2

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

7.2

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: 8-2151060-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151060-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151060-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151060-6

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.  
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 -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ALIGN APPLICATOR'S MAXIMUM WIRE CRIMP HEIGHT AT NORMAL TERMINATOR SHUT HEIGHT

13

THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.

14

APPLY TORQ-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.  
APPLY #1-23419-5 LOC-TITE TO THREADS.

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.20-4.80 mm [ .165-.189 IN ]

Ø1.40-2.70 mm [ .055-.106 IN ]

TERMINAL APPLICATION SPECIFICATION

(A) 114-18050

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE SEAL

TE SEAL

CABLE DIAMETER

(A) 964286-1

(A) 6-964286-6

963294-1

Ø1.2-2.0

(A) 964286-2

(B) 1-964300-3

963293-1

Ø2.0-2.7

(A) 1-964286-1

(B) 2-964300-1

(A) 2-964286-1

(B) 4-964300-1

(A) 4-964286-1

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

-

-

1

-

-

-

2119957-2

APPLICATOR SHIM PACK

260

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

11415 IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE MANUFACTURING ORGANIZATION. NO OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:

mm

0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

TOLERANCES UNLESS OTHERWISE SPECIFIED:

±

±

±

±

±

±

DRAWING NO

00779

©=2151060

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

E

REVISIONS

SET UP GAUGE

2119599-1

LOC

A

DIST

66

P

LTR

DESCRIPTION

DATE

DWN

APVD

D

ECR-13-000080

03JAN2013

RK

JB

D1

ECR-15-001855

05FEB2015

KH

JT

E

ECR-16-008801

17JUN2016

MZ

JDG

-

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

2119082-7

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

-

-

-

-

1

-

2063440-1

AIR FEED MODULE

238

-

-

1

1

-

-

2119740-2

TAG,IDENTIFICATION

213

-

-

1

1

-

-

1901094-3

SPACER, FEEDER

198

-

-

-

-

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

-

3

-

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

1

1

1

1

985575-3

SCR, FLT SKT HD CAP M3 X 10.0

57

-

-

-

-

1

1

1338685-1

PAWL, FEED

56

-

4

4

4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

-

2

2

2

2

2

2168083-3

SCR, SKT HD CAP, RoHS, M4 X 12.0

53

-

1

1

1

1

1

5018030-1

NUT, HEX, REG, RoHS, M3

52

-

1

1

1

1

1

811242-5

BUMPER, HOLD DOWN

51

-

1

1

1

1

1

690753-2

SPACER, TONKER

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

-

1

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

1-1752356-7

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

1-1320908-2

SPACER, STRIP GUIDE

30

-

1

1

1

1

1

2119959-2

ASSEMBLY, STRIP GUIDE

29

-

1

1

1

1

1

455888-4

SPACER, CRIMPER

28

-

1

1

1

1

1

1320928-6

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

318707-1

FLOATING SHEAR, FRONT

9

-

1

1

1

1

1

1333204-4

ANVIL, COMBINATION

8

-

1

1

1

1

1

2119781-1

DEPRESSOR, SHEAR

5

-

1

1

1

1

1

238011-9

BLOCK, CRIMPER SPACER

4

-

1

1

1

1

1

3-2119784-1

CRIMPER, INSULATION O PREMIUM

3

-

1

1

1

1

1

455888-5

SPACER, CRIMPER

2

-

1

1

1

1

1

1803125-9

CRIMPER, WIRE

1

11415 IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE MANUFACTURING ORGANIZATION. NO OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:

mm

0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

TOLERANCES UNLESS OTHERWISE SPECIFIED:

±

±

±

±

±

±

DRAWING NO

00779

©=2151060

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

E

REVISIONS

SET UP GAUGE

2119599-1

LOC

A

DIST

66

P

LTR

DESCRIPTION

DATE

DWN

APVD

D

ECR-13-000080

03JAN2013

RK

JB

D1

ECR-15-001855

05FEB2015

KH

JT

E

ECR-16-008801

17JUN2016

MZ

JDG

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

-

-

1

-

-

-

2119957-2

APPLICATOR SHIM PACK

260

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

11415 IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE MANUFACTURING ORGANIZATION. NO OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:

mm

0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

TOLERANCES UNLESS OTHERWISE SPECIFIED:

±

±

±

±

±

±

DRAWING NO

00779

©=2151060

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

E

REVISIONS

SET UP GAUGE

2119599-1

LOC

A

DIST

66

P

LTR

DESCRIPTION

DATE

DWN

APVD

D

ECR-13-000080

03JAN2013

RK

JB

D1

ECR-15-001855

05FEB2015

KH

JT

E

ECR-16-008801

17JUN2016

MZ

JDG

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

-

-

1

-

-

-

2119957-2

APPLICATOR SHIM PACK

260

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

11415 IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE MANUFACTURING ORGANIZATION. NO OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:

mm

0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

TOLERANCES UNLESS OTHERWISE SPECIFIED:

±

±

±

±

±

±

DRAWING NO

00779

©=2151060

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

E

REVISIONS

SET UP GAUGE

2119599-1

LOC

A

DIST

66

P

LTR

DESCRIPTION

DATE

DWN

APVD

D

ECR-13-000080

03JAN2013

RK

JB

D1

ECR-15-001855

05FEB2015

KH

JT

E

ECR-16-008801

17JUN2016

MZ

JDG

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

-

-

1

-

-

-

2119957-2

APPLICATOR SHIM PACK

260

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

11415 IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE MANUFACTURING ORGANIZATION. NO OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:

mm

0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

TOLERANCES UNLESS OTHERWISE SPECIFIED:

±

±

±

±

±

±

DRAWING NO

00779

©=2151060

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

E

REVISIONS

SET UP GAUGE

2119599-1

LOC

A

DIST

66

P

LTR

DESCRIPTION

DATE

DWN

APVD

D

ECR-13-000080

03JAN2013

RK

JB

D1

ECR-15-001855

05FEB2015

KH

JT

E

ECR-16-008801

17JUN2016

MZ

JDG

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

-

-

1

-

-

-

2119957-2

APPLICATOR SHIM PACK

260

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

11415 IS SUBJECT TO CHANGE AND TO BE CONTROLLED BY THE MANUFACTURING ORGANIZATION. NO OTHER REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:

mm

0 PLC

1 PLC

2 PLC

3 PLC

4 PLC

ANGLES

FINISH

TOLERANCES UNLESS OTHERWISE SPECIFIED:

±

±

±

±

±

±

DRAWING NO

00779

©=2151060

Customer Accessible Production Drawing

SCALE

1:2

SHEET

1

OF

4

REV

E

REVISIONS

SET UP GAUGE

2119599-1

LOC

A

DIST

66

P

LTR

DESCRIPTION

DATE

DWN

APVD

D

ECR-13-000080

03JAN2013

RK

JB

D1

ECR-15-001855

05FEB2015

KH

JT

E

ECR-16-008801

17JUN2016

MZ

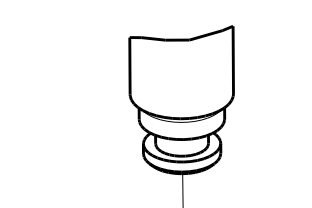
JDG

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4



| <div>PACIFIC VERSION<br/>TERMINATOR<br/>INTERFACE ADAPTER</div> <div></div> | PART<br>NUMBER | REVISION | DESCRIPTION              | FEED TYPE                         | APPLICATOR STYLE CONVERSION CHART |                       |           |             |           |           |                        |   |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|----------|--------------------------|-----------------------------------|-----------------------------------|-----------------------|-----------|-------------|-----------|-----------|------------------------|---|
|                                                                                                                                                             |                |          |                          |                                   | CONVERT TO                        | PART NUMBERS REQUIRED |           |             |           |           |                        |   |
|                                                                                                                                                             |                |          |                          |                                   |                                   |                       |           |             |           |           |                        |   |
|                                                                                                                                                             | 2-2151060-1    | E        | 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             | -         | 8-2151060-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |   |
|                                                                                                                                                             |                |          |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151060-4 | -         | -         | -                      |   |
|                                                                                                                                                             | 2-2151060-2    | E        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC                         | MECHANICAL FEED                   | 2119949-1             | 1338685-1 | 5-18022-5   | 2119653-2 | -         | -                      |   |
|                                                                                                                                                             |                |          |                          |                                   | SERVO LATCH PLATE                 | 2119951-1             | -         | 8-2151060-5 | 1901094-3 | -         | 2168400-6 (QUANTITY 2) |   |
|                                                                                                                                                             |                |          |                          |                                   | SMART APPLICATOR                  | 2161326-1             | -         | 8-2151060-4 | -         | -         | -                      |   |
|                                                                                                                                                             | 2-2151060-5    | E        | FINE CRIMP HEIGHT ADJUST | SERVO<br>LATCH PLATE <sup>4</sup> | 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              |   |
|                                                                                                                                                             | 2-2151060-7    | E        | FINE CRIMP HEIGHT ADJUST | NONE                              | -                                 | -                     | -         | -           | -         | -         | -                      | - |
|                                                                                                                                                             | 7-2151060-7    | E        | CRIMP TOOLING KIT        | -                                 | -                                 | -                     | -         | -           | -         | -         | -                      | - |

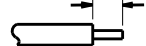
| APPLICATOR DATA                      |                |      |
|--------------------------------------|----------------|------|
| CRIMP                                | SIZE           | TYPE |
| WIRE                                 | 2.03 mm [.080] | F    |
| INSUL                                | 4.06 mm [.160] | O    |
| APPLICATOR INSTRUCTIONS<br>408-10389 |                |      |

|                                                                                                                      |               |                                                                                                             |         |                |
|----------------------------------------------------------------------------------------------------------------------|---------------|-------------------------------------------------------------------------------------------------------------|---------|----------------|
| TERMINAL DATA: TE TERMINAL                                                                                           |               | TE CRIMP SPECIFICATION                                                                                      |         |                |
| TERMINAL NAME: AMP MCP 2.8K FLAT TYPE RECEPTACLE                                                                     |               |                                                                                                             |         |                |
| WIRE STRIP LENGTH                   |               | INSULATION DIAMETER RANGE  |         |                |
| 3.70-4.30 mm [.146-.169 IN]                                                                                          |               | Ø1.40-2.70 mm [.055-.106 IN]                                                                                |         |                |
| TERMINAL APPLICATION SPECIFICATION  | (C) 114-18387 | -                                                                                                           | -       | -              |
| TERMINALS APPLIED                                                                                                    |               |                                                                                                             |         |                |
| TE TERMINAL                                                                                                          | TE TERMINAL   | TE SEAL                                                                                                     | TE SEAL | CABLE DIAMETER |
| (C) 1241394-1                                                                                                        | (C) 1241394-3 | 963294-1                                                                                                    |         | Ø1.2-2.0       |
| (C) 1241394-2                                                                                                        |               | 963293-1                                                                                                    |         | Ø2.0-2.7       |

|           |                            |                                |
|-----------|----------------------------|--------------------------------|
| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
| 1.00mm2   | 1.20+/-0.05 [.047+/-0.002] | 6.5                            |
| 0.75mm2   | 1.18+/-0.05 [.046+/-0.002] | 6.9                            |
| 0.50mm2   | 1.15+/-0.05 [.045+/-0.002] | 7.2                            |



- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151060-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151060-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151060-5
5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.
- APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62.  
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.
- MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.
- 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.
- SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- 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.
- THIS APPLICATOR APPLIES TERMINAL WITH A SEAL.
- APPLY TORO-SEAL IN ALLEN SOCKET TO FILL HOLE AFTER FLAT HD HAS BEEN ADJUSTED TO CORRECT HEIGHT AT QUALIFICATION.  
APPLY #1-23419-5 LOC-TITE TO THREADS.

|                                                                                                                        |                |                                                                                                               |         |                |
|------------------------------------------------------------------------------------------------------------------------|----------------|---------------------------------------------------------------------------------------------------------------|---------|----------------|
| TERMINAL DATA: TE TERMINAL                                                                                             |                | TE CRIMP SPECIFICATION                                                                                        |         |                |
| TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT                                                                              |                |                                                                                                               |         |                |
| WIRE STRIP LENGTH                   |                | INSULATION DIAMETER RANGE  |         |                |
| 4.20-4.80 mm [.165-.189 IN]                                                                                            |                | Ø1.40-2.70 mm [.055-.106 IN]                                                                                  |         |                |
| TERMINAL APPLICATION SPECIFICATION  | (A) 114-18050  | -                                                                                                             | -       |                |
|                                                                                                                        | (B) 114-18051  | -                                                                                                             | -       |                |
| TERMINALS APPLIED                                                                                                      |                |                                                                                                               |         |                |
| TE TERMINAL                                                                                                            | TE TERMINAL    | TE SEAL                                                                                                       | TE SEAL | CABLE DIAMETER |
| (A) 964286-1                                                                                                           | (A) 6-964286-6 | 963294-1                                                                                                      |         | Ø 1.2-2.0      |
| (A) 964286-2                                                                                                           | (B) 1-964300-3 | 963293-1                                                                                                      |         | Ø 2.0-2.7      |
| (A) 1-964286-1                                                                                                         | (B) 2-964300-1 |                                                                                                               |         |                |
| (A) 2-964286-1                                                                                                         | (B) 4-964300-1 |                                                                                                               |         |                |
| (A) 4-964286-1                                                                                                         |                |                                                                                                               |         |                |

\*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<br>2119599-1 | LOC<br>A | DIS<br>66 | REVISIONS |     |             |      |     |      |
|---------------------------|----------|-----------|-----------|-----|-------------|------|-----|------|
|                           |          |           | P         | LTR | DESCRIPTION | DATE | OWN | APVD |
|                           |          |           | -         | -   | SEE SHEET 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 |
| - | 1   | 1   | 1   | 1   | 1-22279-3   | SPRING, COMPRESSION                 | 246 |
| - | 1   | 1   | 1   | 1   | 2119082-7   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | 1   | 1   | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1   | 1   | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| - | 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 |
| - | -   | -   | 2   | -   | 21045-3     | RING, RETAIN, EXTERN, 3/16 CRESCENT | 172 |
| - | 1   | 1   | 1   | 1   | 994969-1    | MAGNET, RARE EARTH HIGH ENERGY      | 166 |
| - | REF | REF | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| - | -   | -   | 1   | -   | 240638-1    | SPRING, FEED FINGER                 | 163 |
| - | 1   | 1   | 1   | 1   | 8-21084-1   | O-RING, .801 ID, .070 DIA. MAT.     | 152 |
| - | -   | -   | 1   | -   | 2119641-2   | FEED CAM, AIR FEED                  | 151 |
| - | 1   | 1   | 1   | 1   | 2119798-2   | DETENT PIN                          | 145 |
| - | 1   | 1   | 1   | 1   | 2079383-8   | SCR, BHSC, RoHS (M4 X 16)           | 144 |
| - | 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   | 1-2119656-0 | APPLICATOR BASIC ASSEMBLY, SF       | 141 |
| - | 1   | 1   | 1   | 1   | 2119650-1   | RAM, ASIAN STYLE, SIDE FEED         | 140 |
| - | 1   | 1   | 1   | 1   | 2119092-2   | BOLT, ADJUSTMENT                    | 139 |
| - | -   | -   | 1   | -   | 3-23627-7   | PIN, RETAIN, GRVD, 3/16 X .854      | 137 |
| - | -   | -   | 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   | 1-18028-2   | WASHER, FLAT, REG M4                | 119 |
| - | -   | REF | -   | -   | 2119944-1   | FEED FINGER ASSEMBLY,SF             | 117 |
| - | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1   | 1   | 1   | 2119956-1   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | -   | 1   | 1   | 2119740-1   | TAG,IDENTIFICATION                  | 67  |
| - | 2   | 2   | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
| - | 1   | 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  |
| - | -   | -   | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | 1   | 1   | 1   | 1   | 985575-3    | SCR, FLT SKT HD CAP M3 X 10.0       | 57  |
| - | -   | -   | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 2   | 2   | 2   | 2   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 53  |
| - | 1   | 1   | 1   | 1   | 5018030-1   | NUT, HEX, REG, RoHS, M3             | 52  |
| - | 1   | 1   | 1   | 1   | 811242-5    | BUMPER, HOLD DOWN                   | 51  |
| - | 1   | 1   | 1   | 1   | 690753-2    | SPACER, TONKER                      | 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   | 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   | 2119644-1   | RAM WASHER, PRECISION               | 38  |
| - | 1   | 1   | 1   | 1   | 1-1752356-7 | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2   | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | 1   | 1   | 1   | 1   | 2161328-1   | HEX HEAD, FLANGED, M5 x 8mm LONG    | 32  |
| - | 1   | 1   | 1   | 1   | 1-1320908-2 | SPACER, STRIP GUIDE                 | 30  |
| - | 1   | 1   | 1   | 1   | 2119959-2   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1   | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 28  |
| - | 1   | 1   | 1   | 1   | 1320928-6   | STRIP GUIDE                         | 24  |
| - | 1   | 1   | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 1   | 1   | 1   | 1   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | 1   | 1   | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
| - | 1   | 1   | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | 1   | 1   | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| - | 1   | 1   | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11  |
| - | 1   | 1   | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| - | 1   | 1   | 1   | 1   | 318707-1    | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1   | 1   | 1   | 1333204-4   | ANVIL, COMBINATION                  | 8   |
| - | 1   | 1   | 1   | 1   | 2119781-1   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 1   | 1   | 1   | 238011-9    | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1   | 1   | 1   | 3-2119784-1 | CRIMPER, INSULATION O PREMIUM       | 3   |
| - | 1   | 1   | 1   | 1   | 455888-5    | SPACER, CRIMPER                     | 2   |
| - | 1   | 1   | 1   | 1   | 1803125-9   | CRIMPER, WIRE                       | 1   |

|                                                                                                                                                                                                                |  |                                        |           |                                              |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------|-----------|----------------------------------------------|--|
| THIS DOCUMENT IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND TO BE OBSOLETE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE AND TO BE OBSOLETE WITHOUT NOTICE. IT IS SUBJECT TO CHANGE AND TO BE OBSOLETE WITHOUT NOTICE. |  | OWN<br>OFFNER                          | 26AUG2011 | TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| DIMENSIONS:                                                                                                                                                                                                    |  | CHK<br>T.ELBIN                         | 29AUG2011 |                                              |  |
| mm                                                                                                                                                                                                             |  | APVD<br>T.ELBIN                        | 29AUG2011 | NAME<br>Ocean Side Feed<br>Applicator        |  |
|                                                                                                                                                                                                                |  | TOLERANCES UNLESS OTHERWISE SPECIFIED: |           | PRODUCT SPEC                                 |  |
|                                                                                                                                                                                                                |  |                                        |           | APPLICATION SPEC                             |  |
|                                                                                                                                                                                                                |  |                                        |           | SIZE                                         |  |
|                                                                                                                                                                                                                |  |                                        |           | CAGE CODE                                    |  |
|                                                                                                                                                                                                                |  |                                        |           | DRAWING NO                                   |  |
|                                                                                                                                                                                                                |  |                                        |           | RESTRICTED TO                                |  |
|                                                                                                                                                                                                                |  |                                        |           | A1 00779 ©=2151060                           |  |
|                                                                                                                                                                                                                |  |                                        |           | Customer Accessible Production Drawing       |  |
|                                                                                                                                                                                                                |  |                                        |           | SCALE                                        |  |
|                                                                                                                                                                                                                |  |                                        |           | 1:2                                          |  |
|                                                                                                                                                                                                                |  |                                        |           | SHEET                                        |  |
|                                                                                                                                                                                                                |  |                                        |           | 3 of 4                                       |  |
|                                                                                                                                                                                                                |  |                                        |           | REV                                          |  |
|                                                                                                                                                                                                                |  |                                        |           | E                                            |  |

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

D

C

B

A

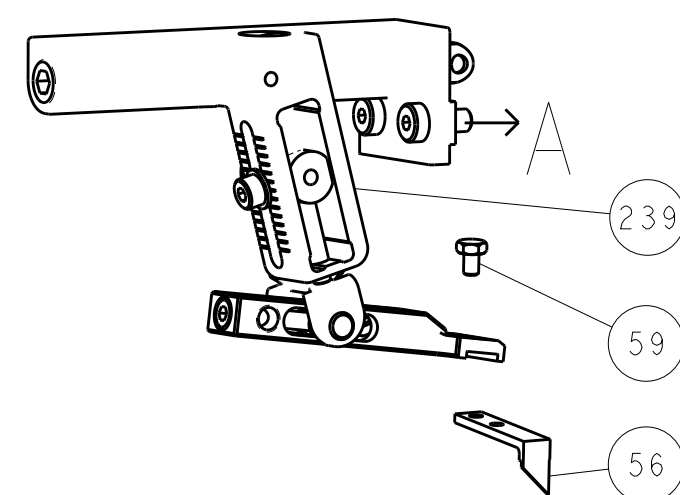
D

C

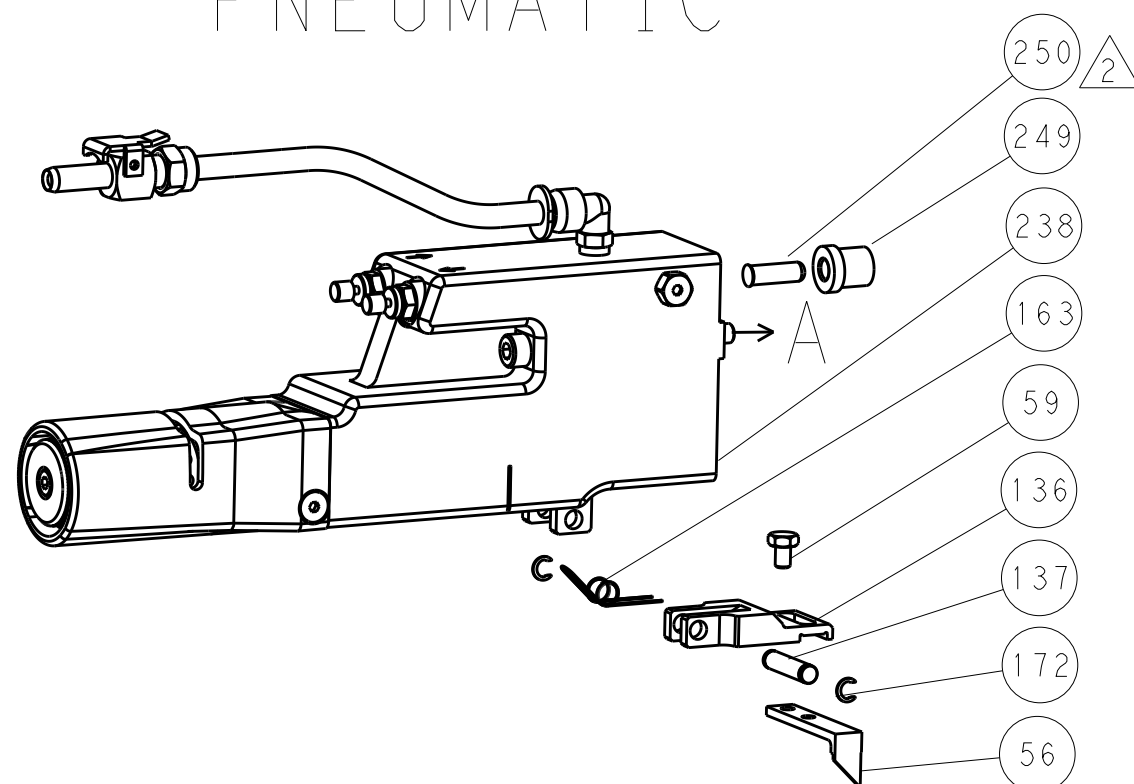
B

A

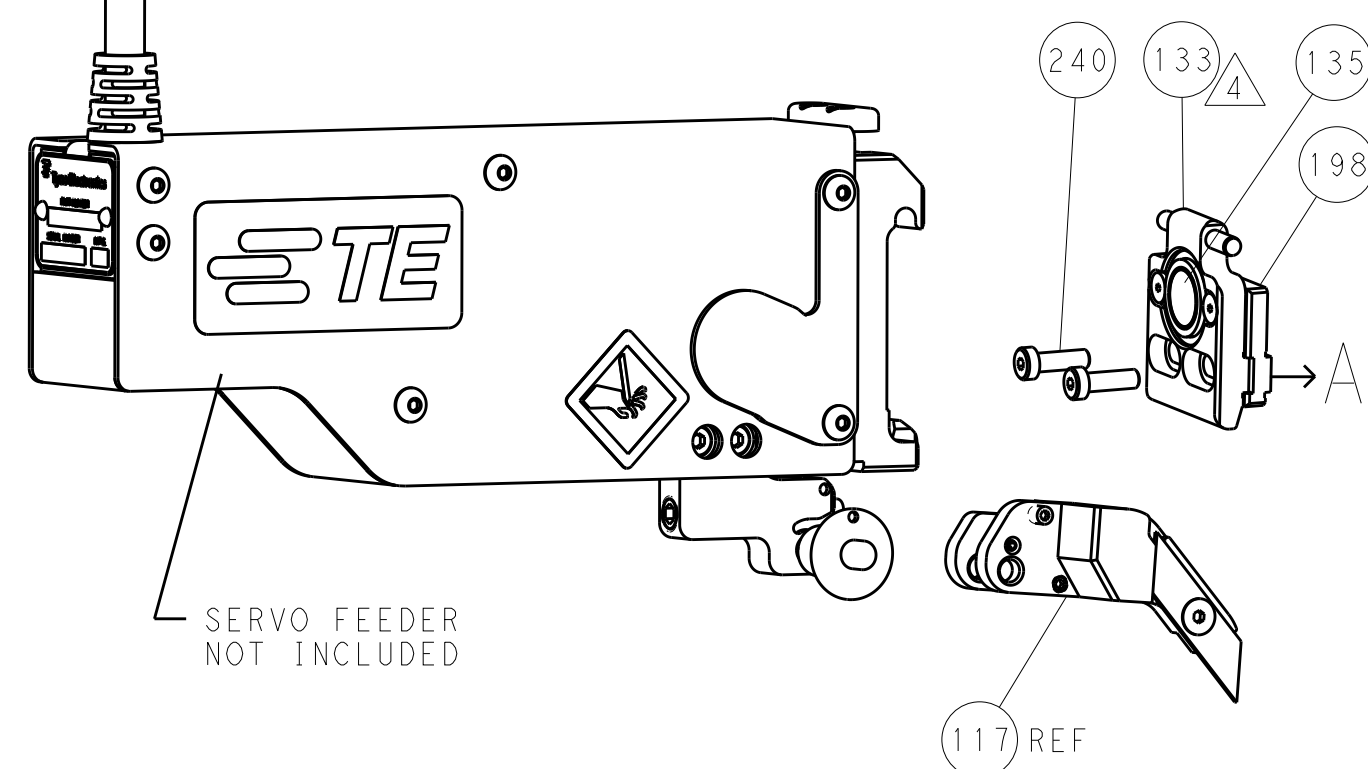
## FEED TYPE MECHANICAL



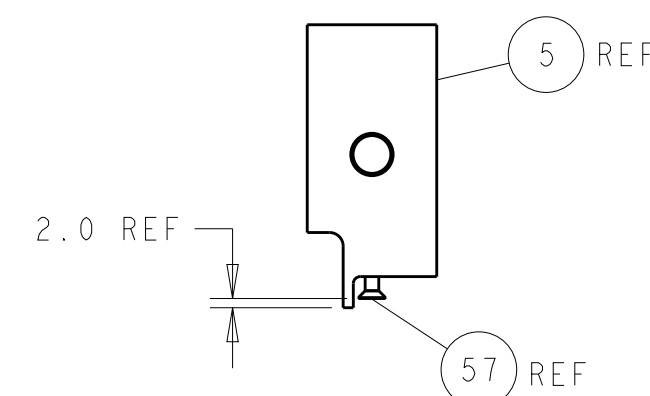
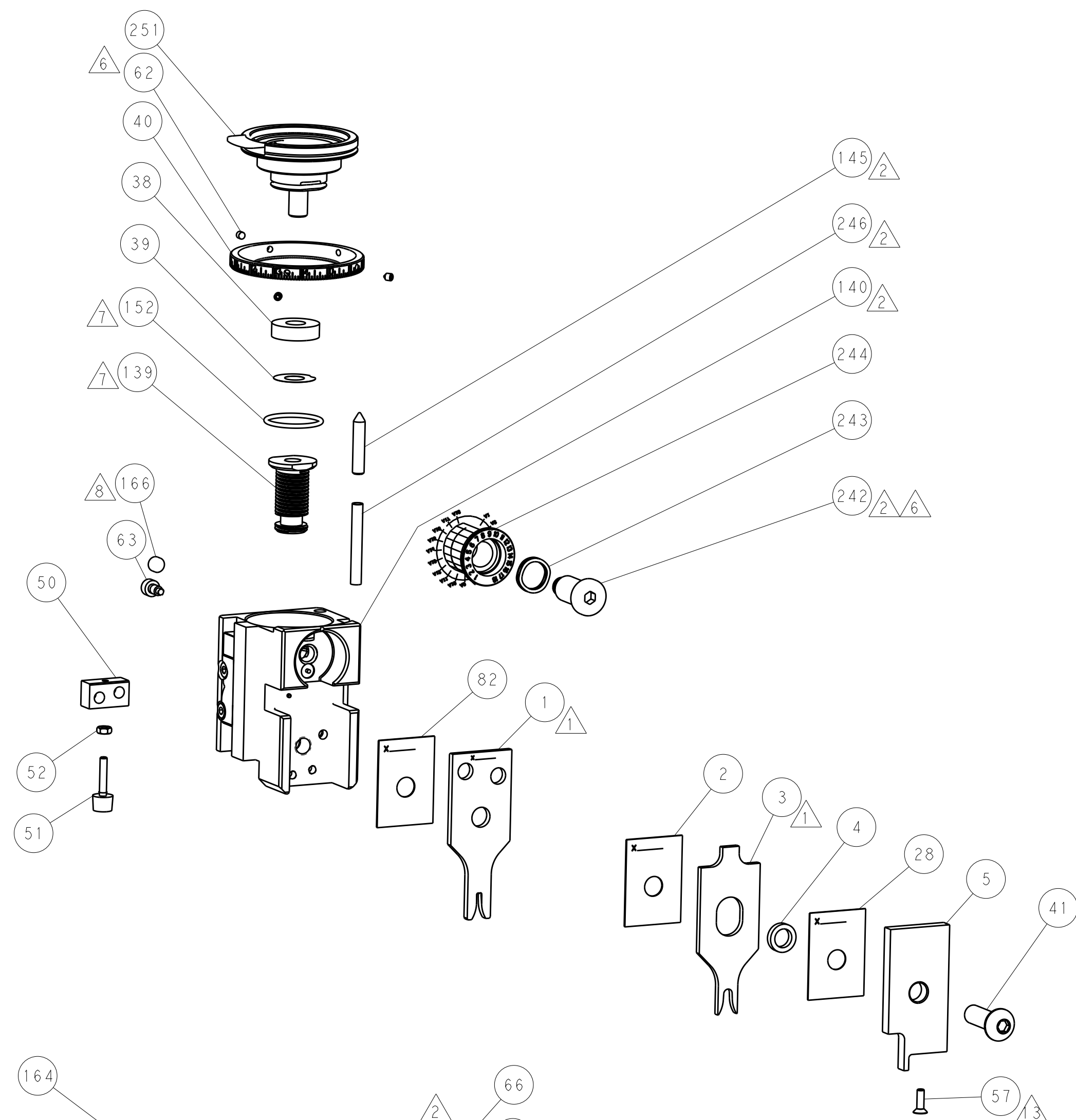
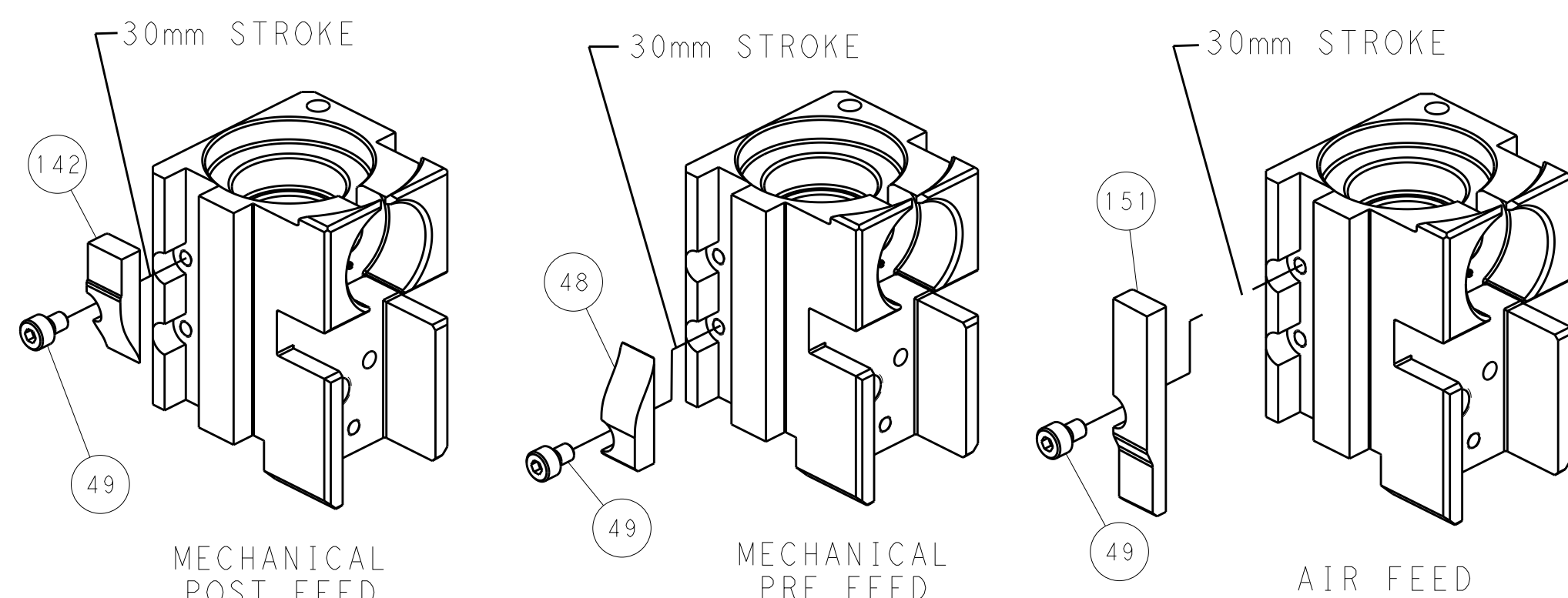
## PNEUMATIC



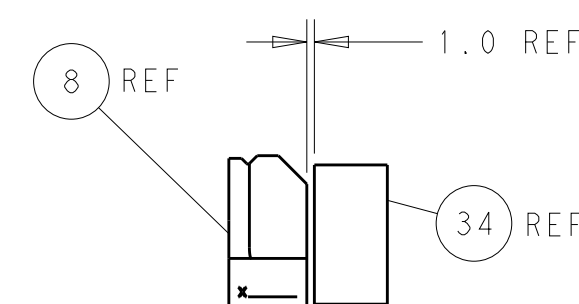
## SERVO LATCH PLATE



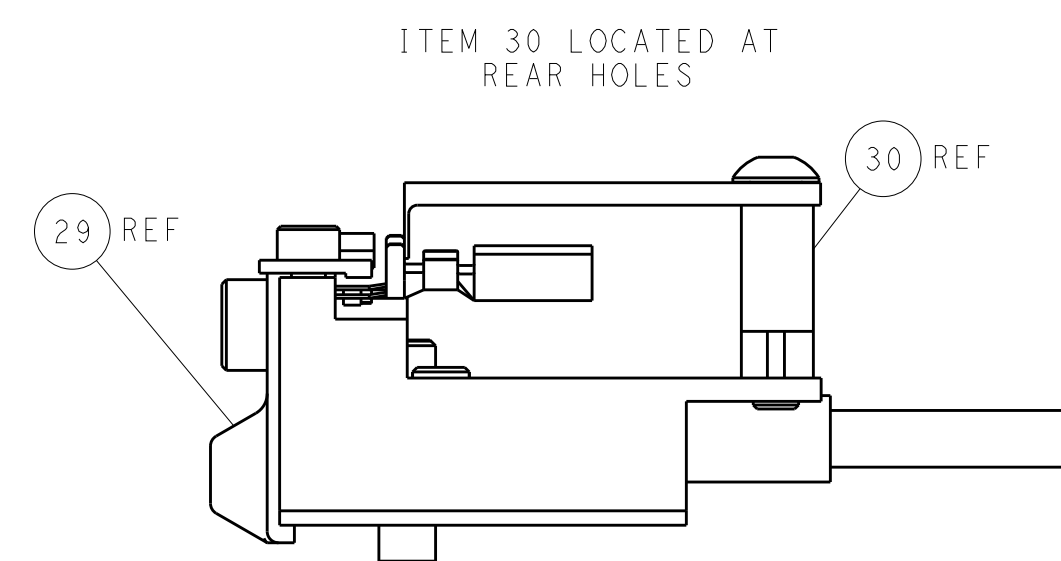
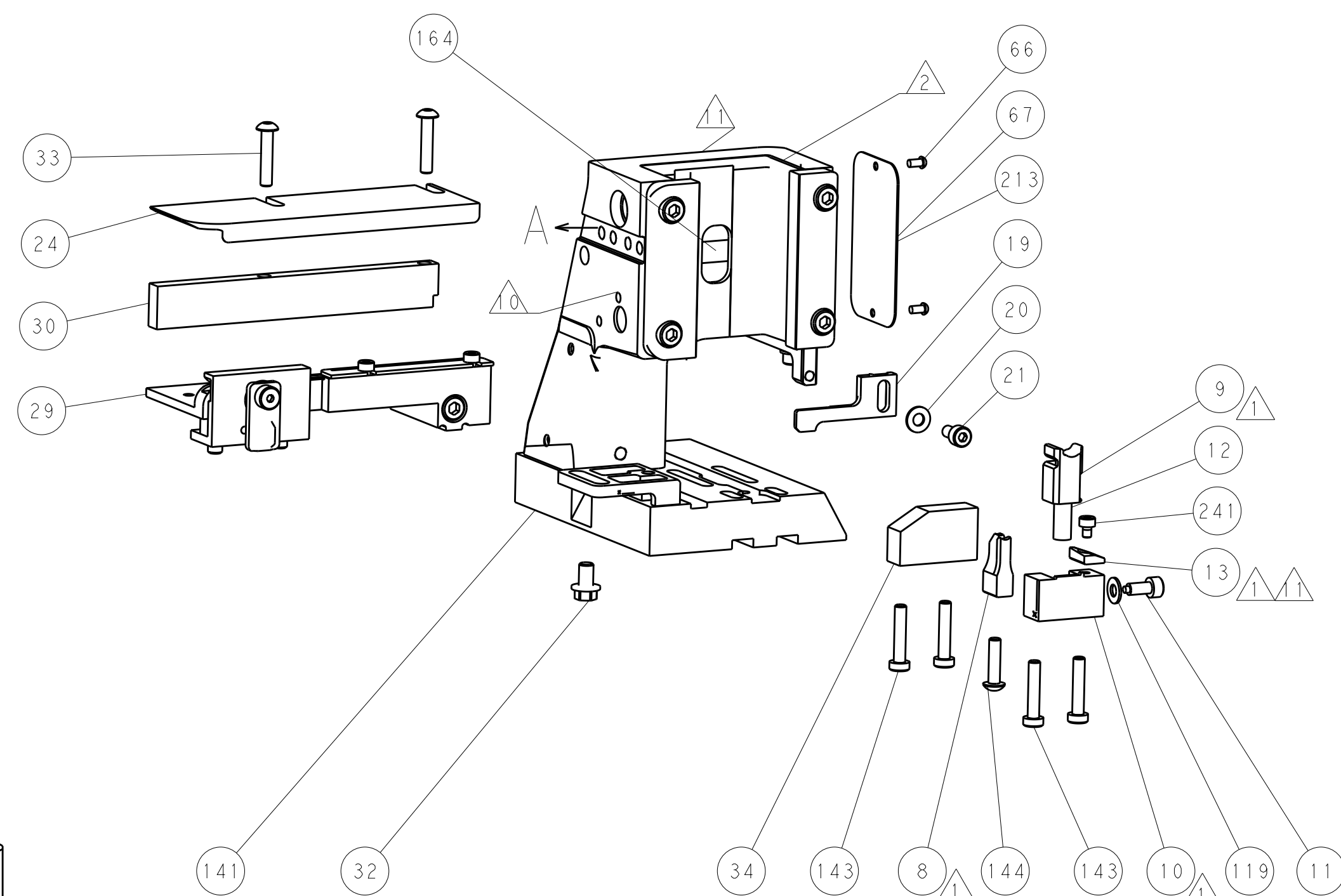
## CAM POSITIONS



SHEAR DEPRESSOR DETAIL



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)

|                                                                                                                                               |  |                                        |           |                                               |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------|--|----------------------------------------|-----------|-----------------------------------------------|--|
| THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST REVISION. |  | OWN: HOFFNER                           | 26AUG2011 | STE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| DIMENSIONS:                                                                                                                                   |  | CHK: TELBIN                            | 29AUG2011 |                                               |  |
| mm                                                                                                                                            |  | APVD: TELBIN                           | 29AUG2011 | NAME: Ocean Side Feed Applicator              |  |
| TOLERANCES UNLESS OTHERWISE SPECIFIED:                                                                                                        |  | PRODUCT SPEC                           |           | SIZE: CAGE CODE: DRAWING NO:                  |  |
|                                                                                                                                               |  | APPLICATION SPEC                       |           | RESTRICTED TO:                                |  |
| MATERIAL:                                                                                                                                     |  | WEIGHT:                                |           | A1 00779 C=2151060                            |  |
| FINISH:                                                                                                                                       |  | Customer Accessible Production Drawing |           | SCALE: 1:2 SHEET 4 OF 4 REV E                 |  |

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION