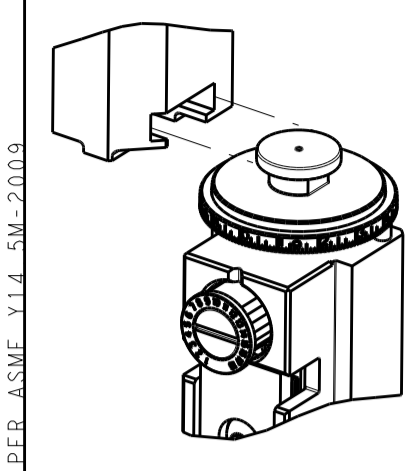


ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER  
PART NUMBER REVISION DESCRIPTION FEED TYPE  
CONVERT TO PART NUMBERS REQUIRED  
PNEUMATIC FEED 2119950-1 1338685-1 5-18022-5 2119641-1 2119799-1 2063440-1  
SERVO LATCH PLATE 2119951-1 8-2151981-5 1901094-3  
SMART APPLICATOR 2161326-1 8-2151981-4



APPLICATOR DATA  
CRIMP WIRE SIZE TYPE  
WIRE 1.57 mm [.062] F  
INSUL 3.18 mm [.125] O  
APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION  
TERMINAL NAME: MCP 1.2 -CB RECEPTACLE  
WIRE STRIP LENGTH INSULATION DIAMETER RANGE  
3.30-3.90 mm [.130-.154 IN] 1.40-1.90 mm [.055-.075 IN]  
TERMINAL APPLICATION SPECIFICATION 114-18464  
TERMINALS APPLIED  
TE TERMINAL TE SEAL TE SEAL  
1670146-1 1670146-2 967067-1 963142-2  
1670146-3 2098582-1

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING  
0.75mm2 0.95+/-0.03 [.037+/-0.001] 7.2  
0.5mm2 or 20AWG 0.84+/-0.03 [.033+/-0.001] 8.4

- RECOMMENDED SPARE PARTS
- GREASE BEARING SURFACES LIGHTLY
- LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
- APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:  
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151981-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151981-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151981-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151981-6
- 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. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.
- GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.
- MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.
- WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 4.85. 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.

\*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.

Table with 3 columns: PART NO, DESCRIPTION, ITEM NO  
2119957-2 APPLICATOR SHIM PACK 260  
8-21084-0 O-RING, .676 ID, .070 DIA. MAT. 252  
2119640-1 PUSH ROD, AIR FEED 250

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

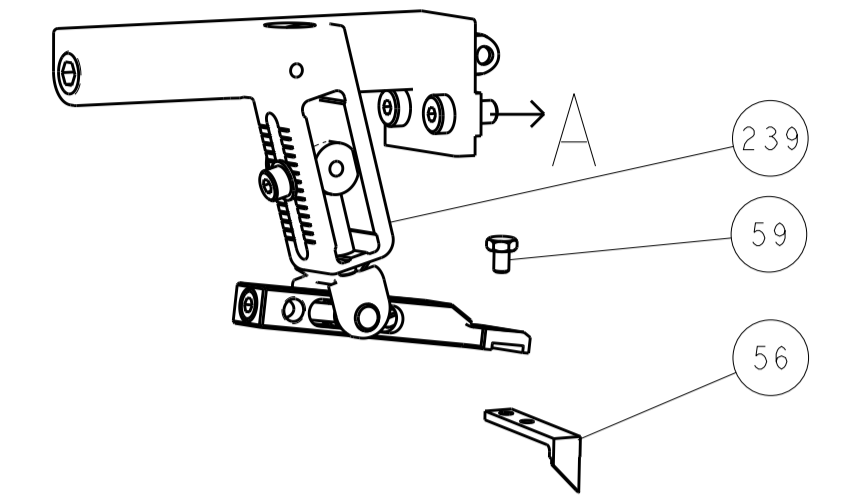
SET UP GAUGE 2119599-1  
LOC A DIST 66  
REVISIONS  
P LTR DESCRIPTION DATE DWN APVD  
A RELEASED 16JUL2013 CC TE  
A1 ECR-16-015635 4NOV2016 RS LZ

Table with 3 columns: PART NO, DESCRIPTION, ITEM NO  
2079988-1 BUSHING, LCH5-12, MISUMI 249  
2119641-1 FEED CAM, AIR FEED 248  
2119798-1 DETENT PIN 247  
1-22279-3 SPRING, COMPRESSION 246  
2119758-1 RAM, AMP STYLE, SIDE FEED, NON-ADJ. 245  
2119082-9 CAM, SNAIL, INSULATION ADJUSTMENT 244  
2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST 243  
2119083-1 RETAINER, INSULATION DIAL 242  
7-18023-7 SCR, SKT HD CAP M3 X 4.0 241  
2168400-6 SHCS, LOW HEAD, RoHS, M5 X 16 240  
2119580-1 MECHANICAL FEED ASSEMBLY 239  
2063440-1 AIR FEED MODULE 238  
2119740-2 TAG, IDENTIFICATION 213  
1901094-3 SPACER, FEEDER 198  
21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT 172  
994969-1 MAGNET, RARE EARTH HIGH ENERGY 166  
994970-2 COUNTER, MAGNETIC 164  
240638-1 SPRING, FEED FINGER 163  
3-23627-7 PIN, RETAIN, GRVD, 3/16 X .854 137  
2119799-1 HOLDER, FEED FINGER, AF 136  
SEE NOTE 4 MEMORY CHIP, PROGRAMMED 135  
1633743-1 SERVO FEED LATCH ASM 133  
1-18028-2 WASHER, FLAT, REG M4 119  
2119944-1 FEED FINGER ASSEMBLY, SF 117  
455888-4 SPACER, CRIMPER 82  
2119956-1 DOCUMENTATION PACKAGE 71  
2119740-1 TAG, IDENTIFICATION 67  
2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188 66  
2119793-1 LIMITER, ADJUSTMENT BOLT 63  
992763-5 SCR, SET, SOC, CONE POINT, M3 x 4.0 62  
2079383-4 SCR, BHSC, RoHS (M4 X 8) 60  
5-18022-5 SCR, HEX HD CAP, M4 X 6.0 59  
985575-3 SCR, FLT SKT HD CAP M3 X 10.0 57  
1338685-1 PAWL, FEED 56  
2168400-1 SHCS, LOW HEAD, RoHS, M4 X 12 54  
2168083-8 SCR, SKT HD CAP, RoHS, M4 X 16 53  
5018030-1 NUT, HEX, REG, RoHS, M3 52  
811242-5 BUMPER, HOLD DOWN 51  
690753-2 SPACER, TONKER 50  
18023-9 SCR, SKT HD CAP M4 X 6.0 49  
2119652-1 FEED CAM, PRE FEED 48  
2119653-1 FEED CAM, POST FEED 47  
2119656-9 APPLICATOR BASIC ASSEMBLY, SF 46  
2119370-1 RAM, AMP STYLE, SIDE FEED 44  
2079383-7 SCR, BHSC, RoHS (M8 X 25) 41  
2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT 40  
2119957-1 APPLICATOR SHIM PACK 39  
2119644-1 RAM WASHER, PRECISION 38  
2119085-1 FA HEAD, ATLANTIC STYLE 37  
2119092-1 BOLT, ADJUSTMENT 35  
3-1752356-3 SUPPORT, TERMINAL 34  
2079383-5 SCR, BHSC, RoHS (M4 X 20) 33  
2161328-1 HEX HEAD, FLANGED, M5 x 8mm LONG 32  
1-1320908-0 SPACER, STRIP GUIDE 30  
2119959-2 ASSEMBLY, STRIP GUIDE 29  
455888-3 SPACER, CRIMPER 28  
1320928-2 STRIP GUIDE 24  
2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0 21  
1-18028-2 WASHER, FLAT, REG M4 20  
2119533-1 STRIPPER, SIDE FEED 19  
2119806-1 INSERT, SHEAR 13  
3-22280-3 SPRING, COMPRESSION 12  
1-356885-4 STOP, SHEAR 11  
2119805-1 SHEAR HOLDER, FRONT 10  
318707-1 FLOATING SHEAR, FRONT 9  
4-1333202-8 ANVIL, COMBINATION 8  
5-240641-0 SPACER 7  
6 6  
2119781-1 DEPRESSOR, SHEAR 5  
238011-4 BLOCK, CRIMPER SPACER 4  
1633965-1 CRIMPER, INSULATION O PREMIUM 3  
455888-7 SPACER, CRIMPER 2  
1-1752057-8 CRIMPER, WIRE PREMIUM, STEPPED 1  
-77 -7 -6 -5 -2 -1 PART NO DESCRIPTION ITEM NO

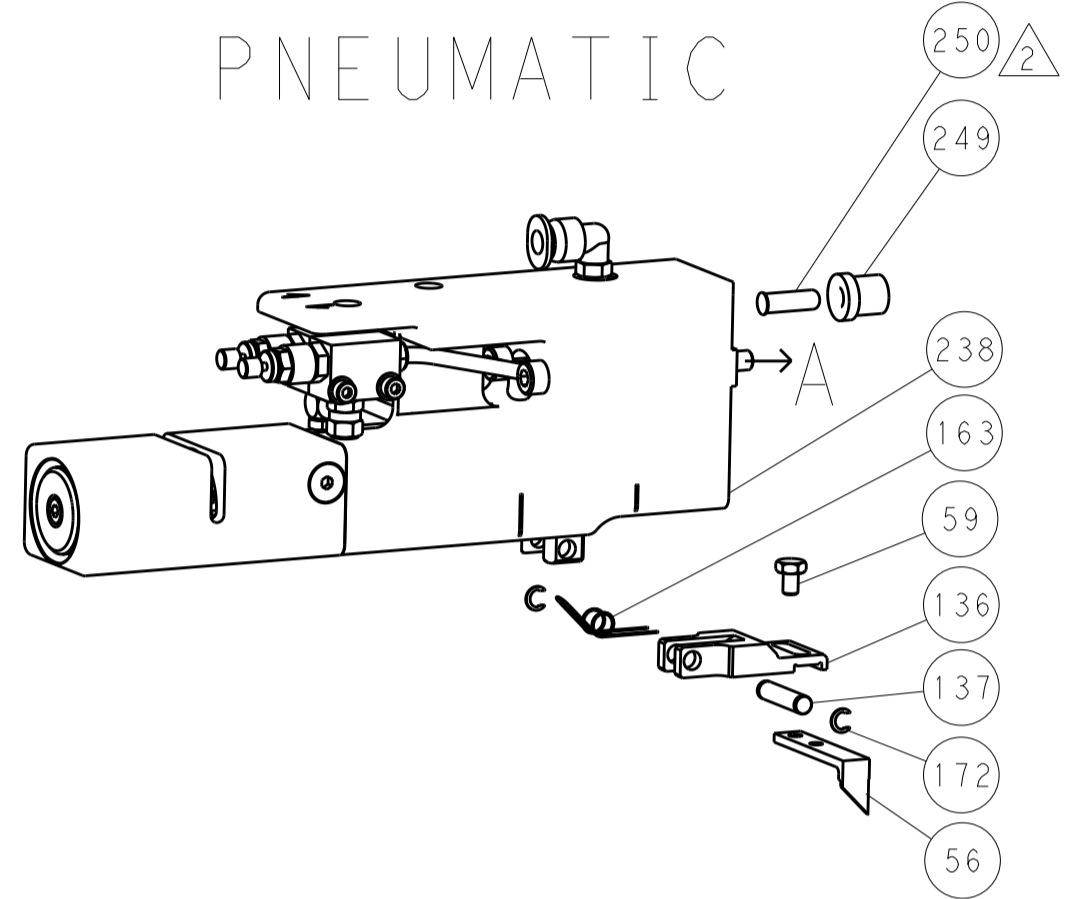
TE Connectivity  
Ocean Side Feed Applicator  
Customer Accessible Production Drawing  
SCALE 1:2 SHEET 1 OF 4 REV A1  
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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

### FEED TYPE MECHANICAL



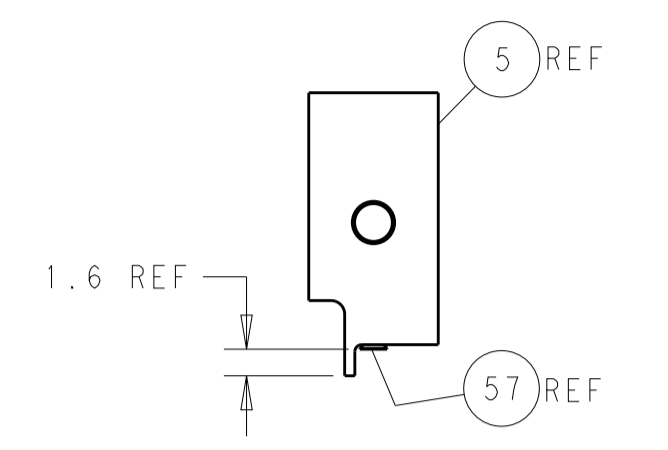
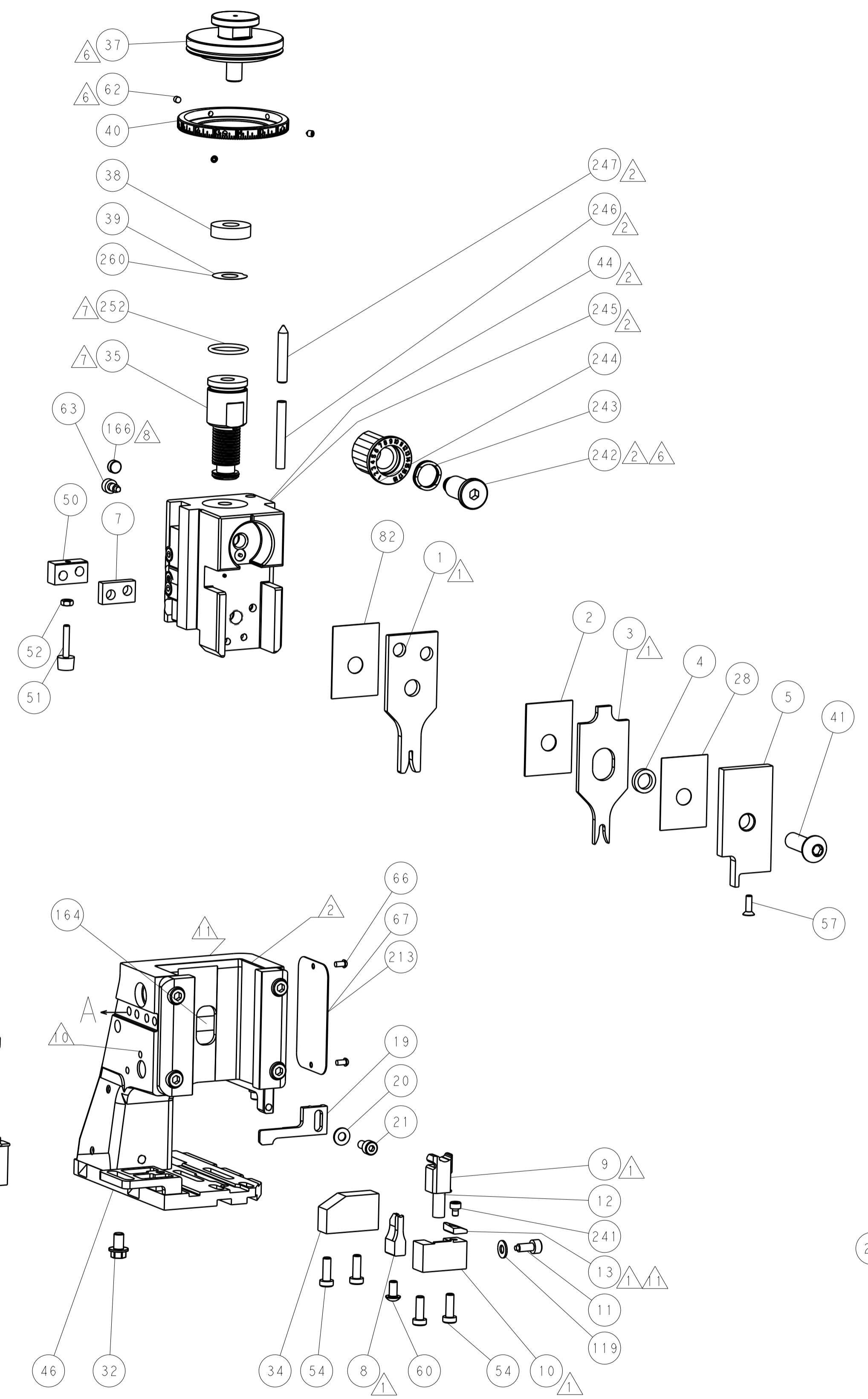
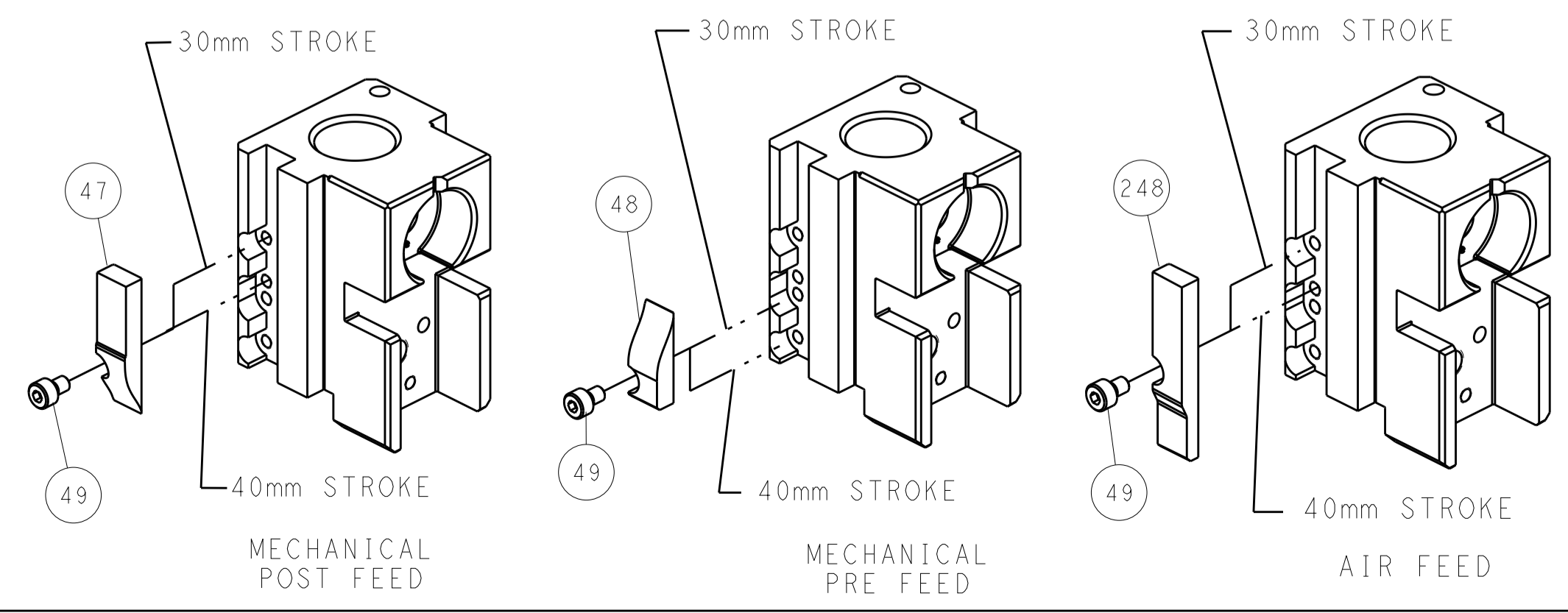
### PNEUMATIC



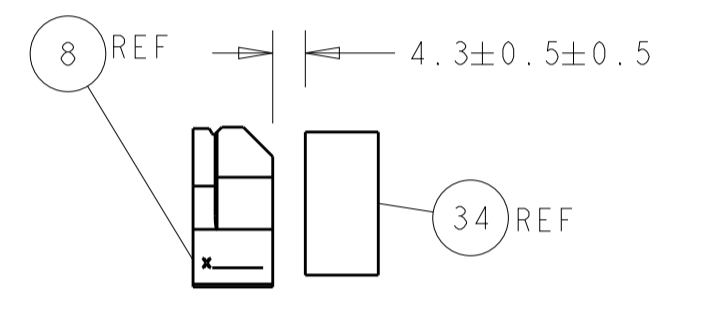
### SERVO LATCH PLATE



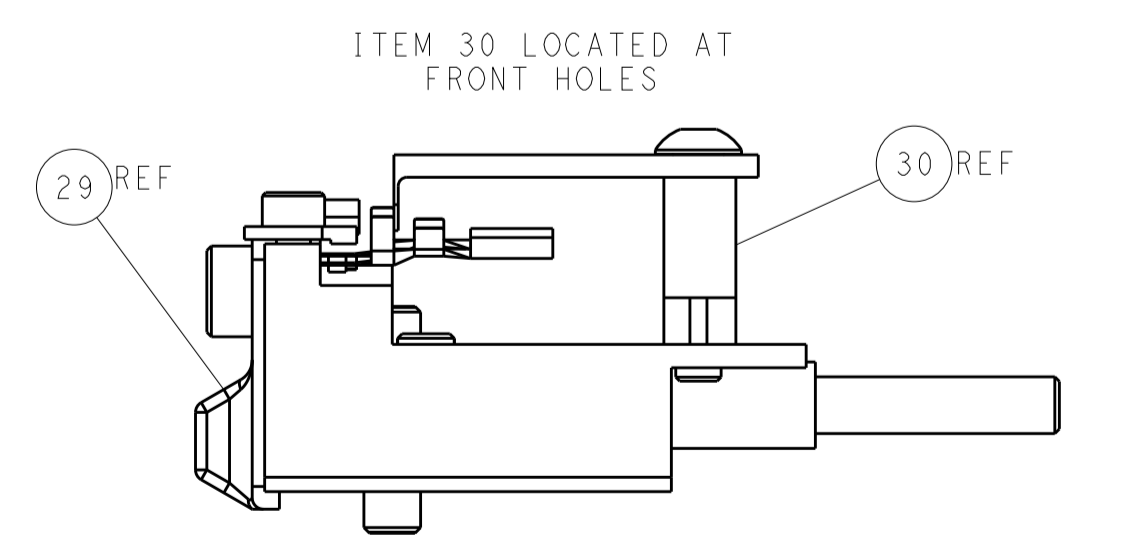
### CAM POSITIONS



SHEAR DEPRESSOR DETAIL



TERMINAL SUPPORT LOCATION



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)

|  |         |   |  |
|--|---------|---|--|
| <small>THE INFORMATION CONTAINED HEREON IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION AND IS LOANED TO YOUR ORGANIZATION UNDER THE PROVISIONS OF A LICENSE. IT IS TO BE CONTROLLED AND NOT REPRODUCED OR DISSEMINATED OUTSIDE YOUR ORGANIZATION WITHOUT THE WRITTEN PERMISSION OF TYCO ELECTRONICS CORPORATION.</small> |         | DWN: C. CHEN 18JUN2013<br>CHK: U. GUO 18JUN2013<br>APVD: J. CRUZ 18JUN2013              | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±  | FINISH: | NAME: Ocean Side Feed Applicator<br>SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: 2151981 | RESTRICTED TO:                               |
| MATERIAL:  |         | WEIGHT:   | SCALE: 1:2<br>SHEET 2 OF 4<br>REV A1         |

APPLICATOR STYLE CONVERSION CHART. Table with columns: CONVERT TO, PART NUMBERS REQUIRED, PNEUMATIC FEED, SERVO LATCH PLATE, SMART APPLICATOR, MECHANICAL FEED, etc.

APPLICATOR DATA. Table with columns: CRIMP SIZE TYPE, WIRE, INSUL. APPLICATOR INSTRUCTIONS 408-10389.

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION. WIRE STRIP LENGTH 3.30-3.90 mm. INSULATION DIAMETER RANGE Ø1.40-1.90 mm. TERMINAL APPLICATION SPECIFICATION 114-18464. TERMINALS APPLIED table.

WIRE SIZE CRIMP HEIGHT mm [INCH]. Table with rows for 0.75mm2 and 0.5mm2 or 20AWG.



- RECOMMENDED SPARE PARTS
GREASE BEARING SURFACES LIGHTLY
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.
APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER: MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151981-4 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151981-4 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151981-5
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 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.

\*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.

Table with columns: PART NO, DESCRIPTION, ITEM NO. Row 1: 2119782-1 FINE ADJUST HEAD ASM, PACIFIC STYLE 251

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 2119599-1. REVISIONS table with columns: P, L, M, DESCRIPTION, DATE, DWN, APVD.

Main parts list table with columns: P, L, M, DESCRIPTION, DATE, DWN, APVD. Includes items like PUSH ROD, AIR FEED, BUSHING, LCH5-12, MISUMI, SPRING, COMPRESSION, etc.

Product information block including dimensions, tolerances, material, finish, weight, scale, and drawing number A1 00779 C=2151981.

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

# FEED TYPE MECHANICAL



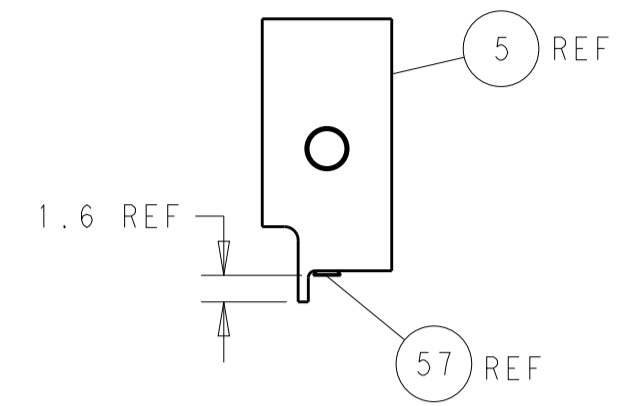
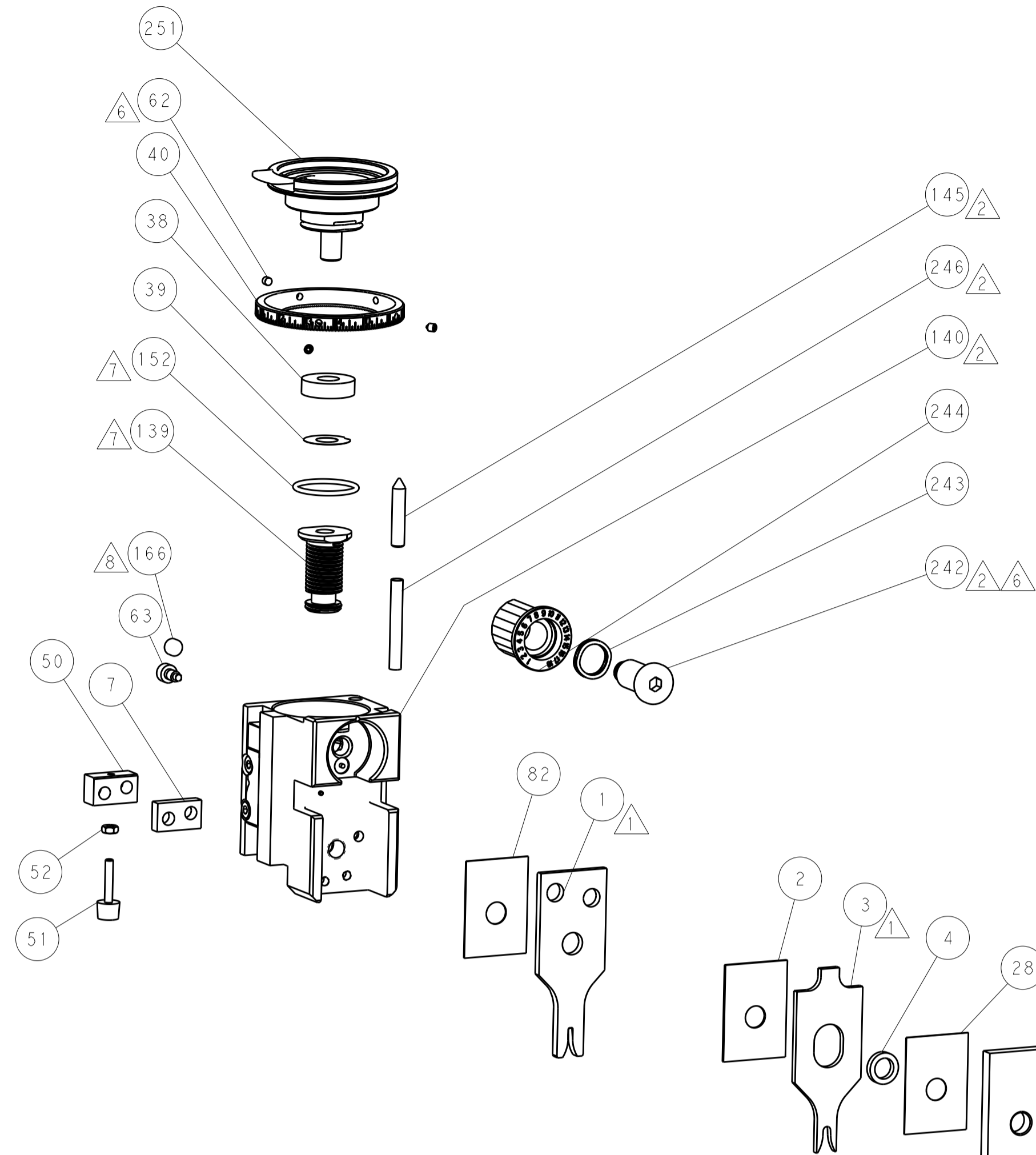
# PNEUMATIC



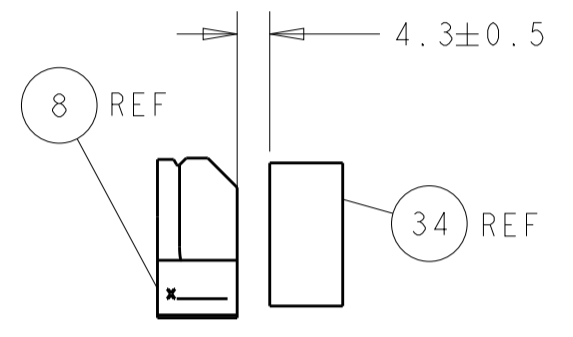
# SERVO LATCH PLATE



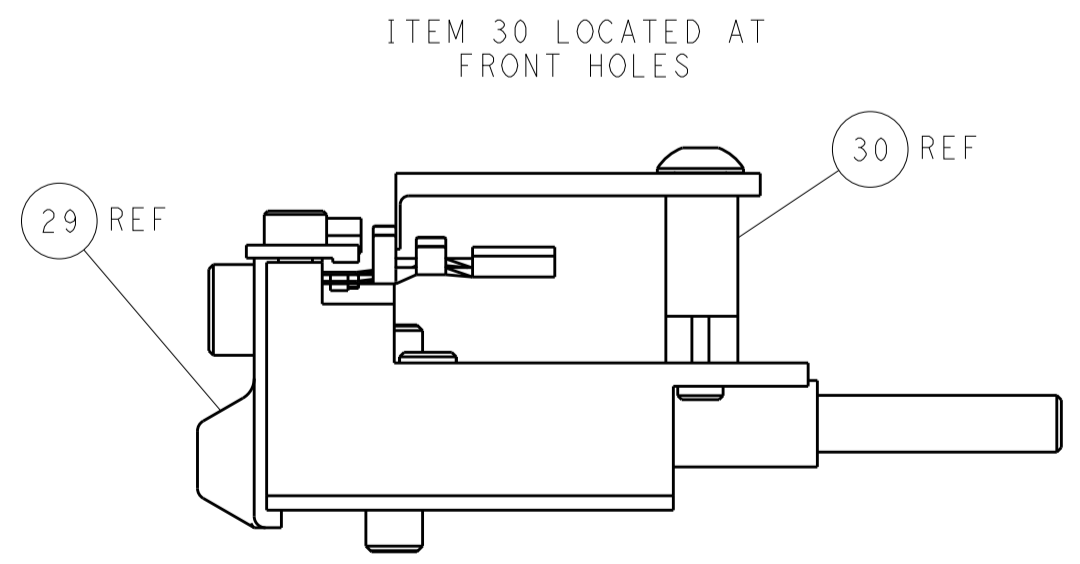
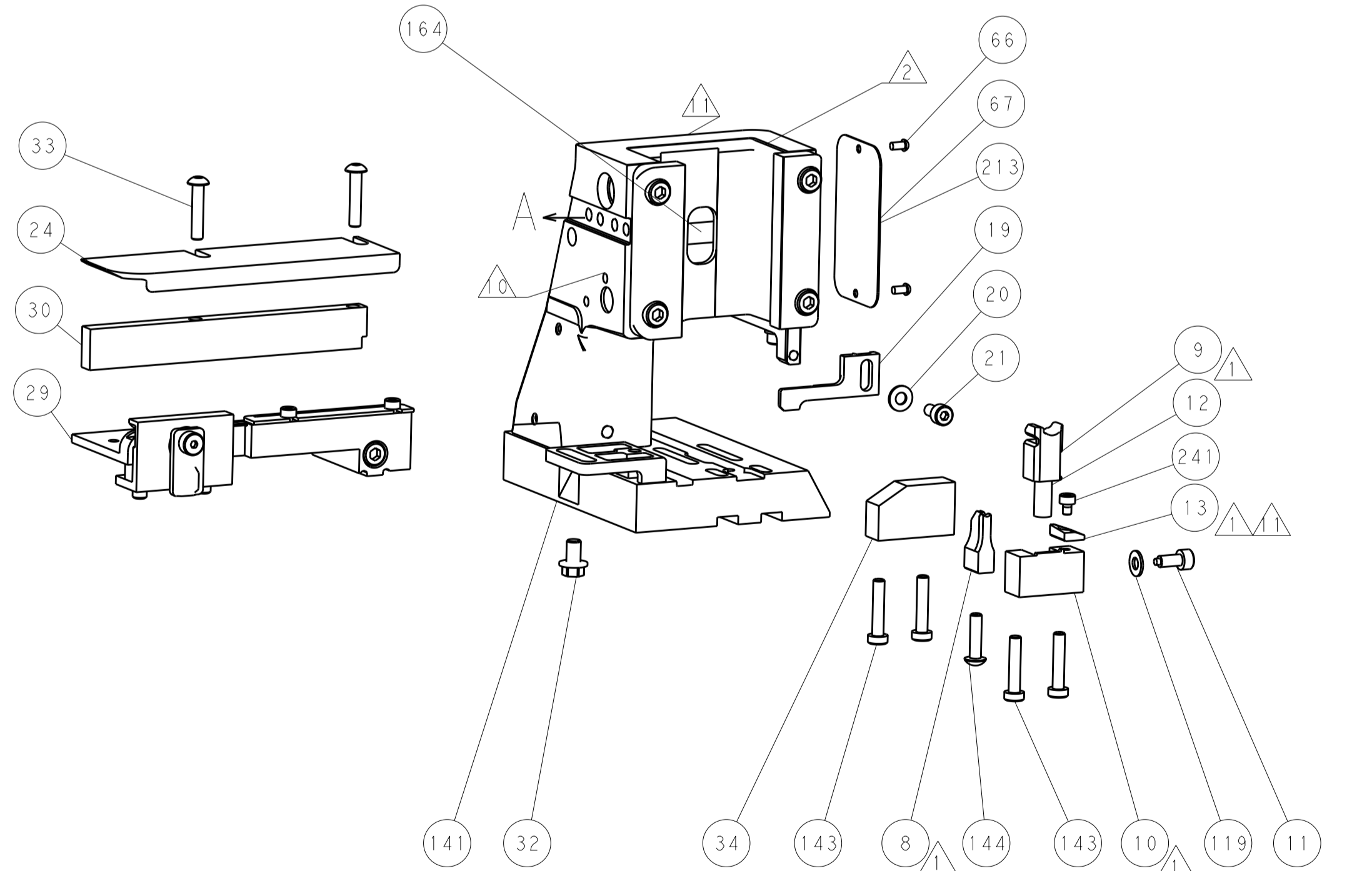
# CAM POSITIONS



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)

|   |   |  |  |
|---|---|--|--|
| <small>THIS DRAWING IS UNPUBLISHED. IT IS THE PROPERTY OF TYCO ELECTRONICS CORPORATION. IT IS TO BE USED ONLY FOR THE PURPOSES AND IN THE QUANTITIES SPECIFIED IN THE ORDER. IT IS TO BE RETURNED TO TYCO ELECTRONICS CORPORATION UPON THE COMPLETION OF THE PROJECT.</small> |   | DWN: C. CHEN 18JUN2013<br>CHK: U. GUO 18JUN2013<br>APVD: J. CRUZ 18JUN2013 | NAME: TE Connectivity<br>Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>MATERIAL: -<br>FINISH: -   | PRODUCT SPEC: -<br>APPLICATION SPEC: -<br>WEIGHT: -<br>SCALE: 1:2 | SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: 2151981                        | RESTRICTED TO: -<br>SHEET: 4 OF 4<br>REV: A1       |