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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION  
TERMINATOR  
INTERFACE ADAPTER

PART  
NUMBER

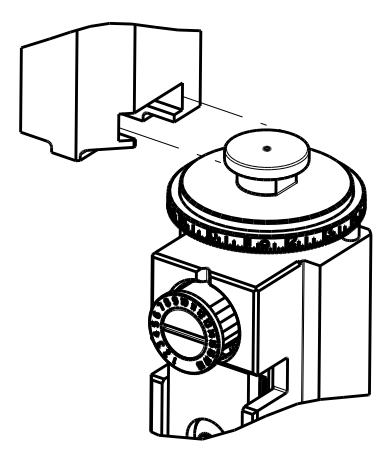
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151673-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED  
SERVO LATCH PLATE  
SMART APPLICATOR

2119950-1  
2119951-1  
2161326-1

1338685-1  
-  
-

5-18022-5  
8-2151673-5  
8-2151673-4

2119641-1  
1901094-3  
-

2119799-1  
-  
-

2063440-1  
2168400-6 (QUANTITY 2)  
-

2151673-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED  
SERVO LATCH PLATE  
SMART APPLICATOR

2119949-1  
2119951-1  
2161326-1

1338685-1  
-  
-

5-18022-5  
8-2151673-5  
8-2151673-4

2119653-1  
1901094-3  
-

-  
-  
-

2151673-5

A

FINE CRIMP HEIGHT ADJUST

SERVO  
LATCH PLATE<sup>4</sup>

MECHANICAL FEED  
PNEUMATIC FEED

2119949-1  
2119950-1

1338685-1  
1338685-1

5-18022-5  
5-18022-5

2119653-1  
2119641-1

-  
2119799-1

-  
2063440-1

2151673-6

A

NON-CRIMP HEIGHT ADJUST

SERVO  
LATCH PLATE<sup>4</sup><sup>12</sup>

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-

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2151673-7

A

FINE CRIMP HEIGHT ADJUST

NONE

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-

7-2151673-7

A

CRIMP TOOLING KIT

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

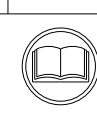
2.54 mm [1.00]

F

INSUL

APPLICATOR INSTRUCTIONS

408-10389

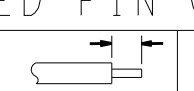


TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: STAMPED PIN CONTACT FOR NECTOR CONN.

WIRE STRIP LENGTH



INSULATION DIAMETER RANGE

4.90-5.10 mm [1.93-2.01 IN]

Ø 0-3.20 mm [0-.126 IN]

TERMINAL APPLICATION SPECIFICATION

114-20165

-

-

TERMINALS APPLIED

TE TERMINAL

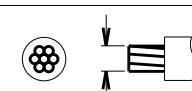
TE TERMINAL

TE TERMINAL

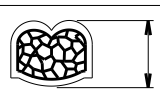
TE TERMINAL

293644-1

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING

2.50mm2

1.97+/-0.03 [1.078+/-0.001]

6.5

1.50mm2

1.67+/-0.03 [1.066+/-0.001]

9.5



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: 8-2151673-4  
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151673-4  
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151673-5  
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151673-6

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 ITEM 50.

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

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1

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2119957-2

APPLICATOR SHIM PACK

260

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1

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1

1

1

8-21084-0

O-RING, .676 ID, .070 DIA. MAT.

252

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-

-

-

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

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

ATLANTIC VERSION

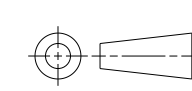
Shown on sheets 1 of 4 & 2 of 4

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

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DIMENSIONS:

mm



0 PLC ±.5

1 PLC ±0.13

2 PLC ±0.13

3 PLC ±0.13

4 PLC ±.5

ANGLES ±.00 30°

FINISH

MATERIAL

-

DRAWN  
T. ELBIN

25MAY2012

CHK  
T. ELBIN

25MAY2012

APVD  
T. ELBIN

25MAY2012

NAME

Ocean Side Feed  
Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2151673

-

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

REV

A

REVISIONS

P

LTR

DESCRIPTION

DATE

DWN

APVD

1

ORIGINAL

24MAY2012

GH

TE

A

RELEASED

13JUL2012

GH

GB

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1

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2119798-1

DETENT PIN

247

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1-22279-3

SPRING, COMPRESSION

246

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1

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2119758-1

RAM, AMP STYLE, SIDE FEED, NON-ADJ.

245

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1

1

1

1

1

7-18023-7

SCR, SKT HD CAP M3 X 4.0

241

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2

2

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2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

-

-

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1

2119580-1

MECHANICAL FEED ASSEMBLY

239

-

-

-

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1

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2063440-1

AIR FEED MODULE

238

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-

1

1

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2119740-2

TAG, IDENTIFICATION

213

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1

1

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1901094-3

SPACER, FEEDER

198

-

1

1

1

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1

993111-1

PIN, SLOTTED SPRING 3.0 X 20.0

177

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1

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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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2

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21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

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1

1

1

1

1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

REF

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

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1

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240638-1

SPRING, FEED FINGER

163

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1

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3-23627-7

PIN, RETAIN, GRVD, 3/16 X .854

137

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2119799-1

HOLDER, FEED FINGER, AF

136

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REF

REF

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SEE NOTE 4

MEMORY CHIP, PROGRAMMED

135

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1

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1633743-1

SERVO FEED LATCH ASM

133

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1-18028-2

WASHER, FLAT, REG M4

119

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REF

REF

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2119944-1

FEED FINGER ASSEMBLY, SF

117

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1

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455888-5

SPACER, CRIMPER

82

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22278-8

SPRING, COMPRESSION

77

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854769-4

HOLDER, INS

74

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2119956-1

DOCUMENTATION PACKAGE

71

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2119740-1

TAG, IDENTIFICATION

67

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2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS

66

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1

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1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

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3

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3

3

3

992763-5

SCR, SET, SOC, CONE POINT, M3 x 4.0

62

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2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

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5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

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21028-2

PIN, SLOTTED SPRING .062 X .250

58

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1338685-1

PAWL, FEED

56

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4

4

4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

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1-5018030-0

NUT, HEX, REG, RoHS, M3.5

52

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1901681-1

HOLDDOWN, TERMINAL

51

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1

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1-1752354-9

STANDOFF, HOLD-DOWN

50

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2

18023-9

SCR, SKT HD CAP M4 X 6.0

49

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2119652-1

FEED CAM, PRE FEED

48

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2119653-1

FEED CAM, POST FEED

47

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2119656-9

APPLICATOR BASIC ASSEMBLY, SF

46

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2119370-1

RAM, AMP STYLE, SIDE FEED

44

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2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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1

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1

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2119957-1

APPLICATOR SHIM PACK

39

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2119644-2

RAM WASHER, PRECISION

38

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1

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2119085-1

FA HEAD, ATLANTIC STYLE

37

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2119092-1

BOLT, ADJUSTMENT

35

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1752356-2

SUPPORT, TERMINAL

34

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2

2

2

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2079383-5

SCR, BHSC, RoHS (M4 X 20)

33

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2161328-1

HEX HEAD, FLANGED, M5 x 8mm LONG

32

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1320908-6

SPACER, STRIP GUIDE

30

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2119959-1

ASSEMBLY, STRIP GUIDE

29

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1-455888-0

SPACER, CRIMPER

28

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1320928-2

STRIP GUIDE

24

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2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

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1-18028-2

WASHER, FLAT, REG M4

20

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2119533-1

STRIPPER, SIDE FEED

19

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2119806-1

INSERT, SHEAR

13

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1

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3-22280-3

SPRING, COMPRESSION

12

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1-356885-4

STOP, SHEAR

11

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1

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2119805-1

SHEAR HOLDER, FRONT

10

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1

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1

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462006-6

FLOATING SHEAR, FRONT

9

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1-1633733-4

ANVIL, WIRE

8

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1-2119780-3

DEPRESSOR, SHEAR

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3-456407-3

CRIMPER, WIRE PREMIUM

1

-77

-7

-6

-5

-2

-1

PART NO

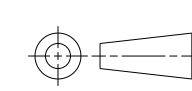
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ITEM NO

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DIMENSIONS:

mm



0 PLC ±.5

1 PLC ±0.13

2 PLC ±0.13

3 PLC ±0.13

4 PLC ±.5

ANGLES ±.00 30°

FINISH

MATERIAL

-

DRAWN  
T. ELBIN

25MAY2012

CHK  
T. ELBIN

25MAY2012

APVD  
T. ELBIN

25MAY2012

NAME

Ocean Side Feed  
Applicator

SIZE

CAGE CODE

DRAWING NO

RESTRICTED TO

00779

©=2151673

-

Customer Accessible Production Drawing

SCALE

1:1

SHEET

1

OF

4

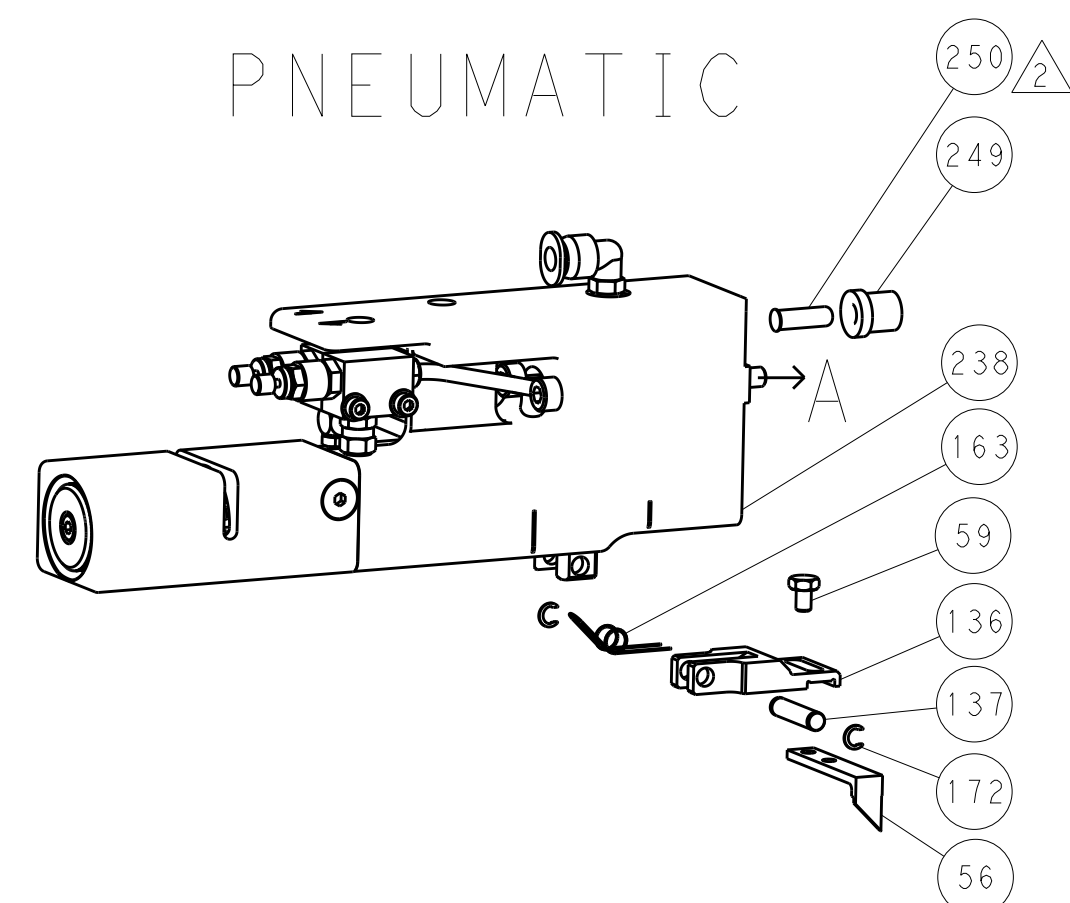
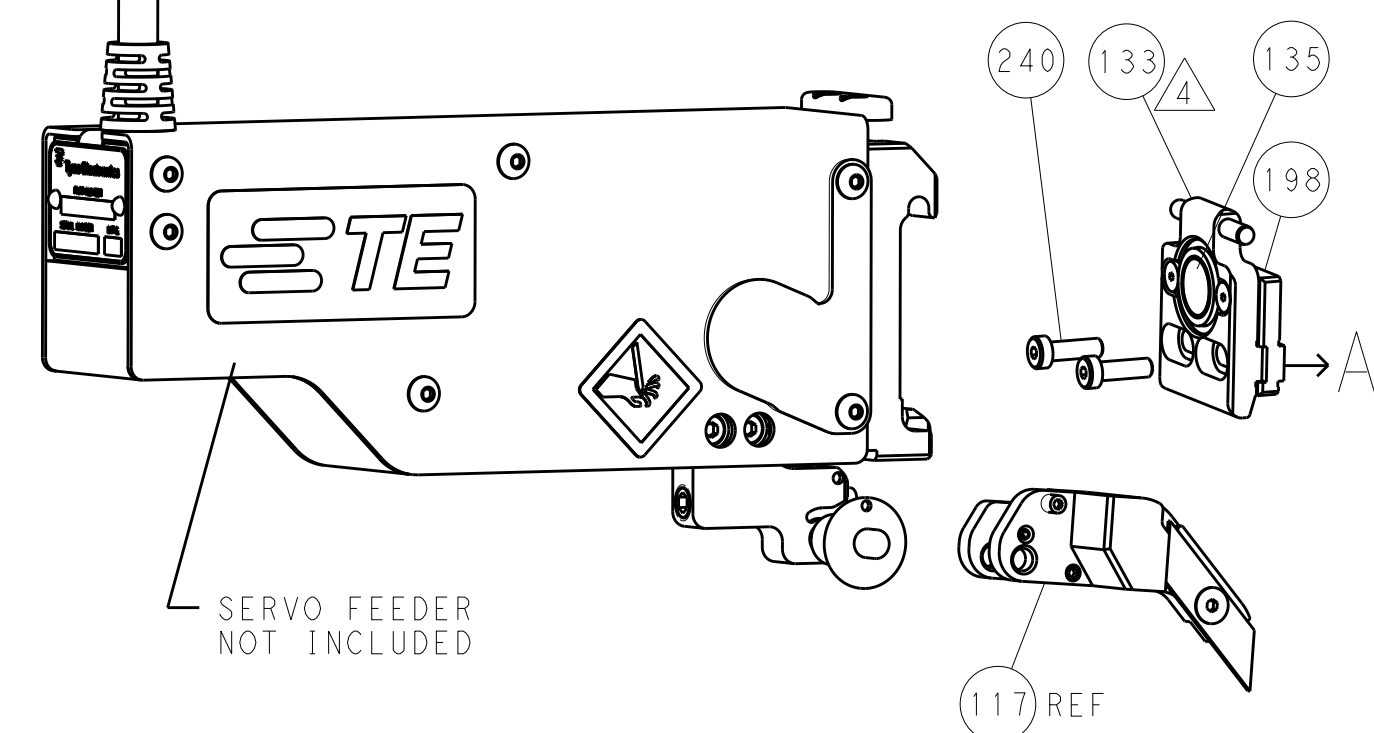
REV

A

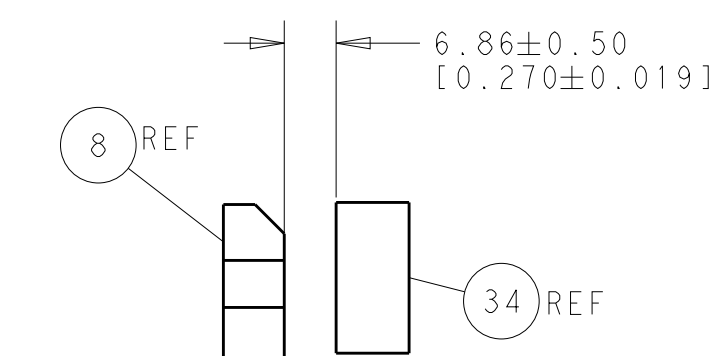
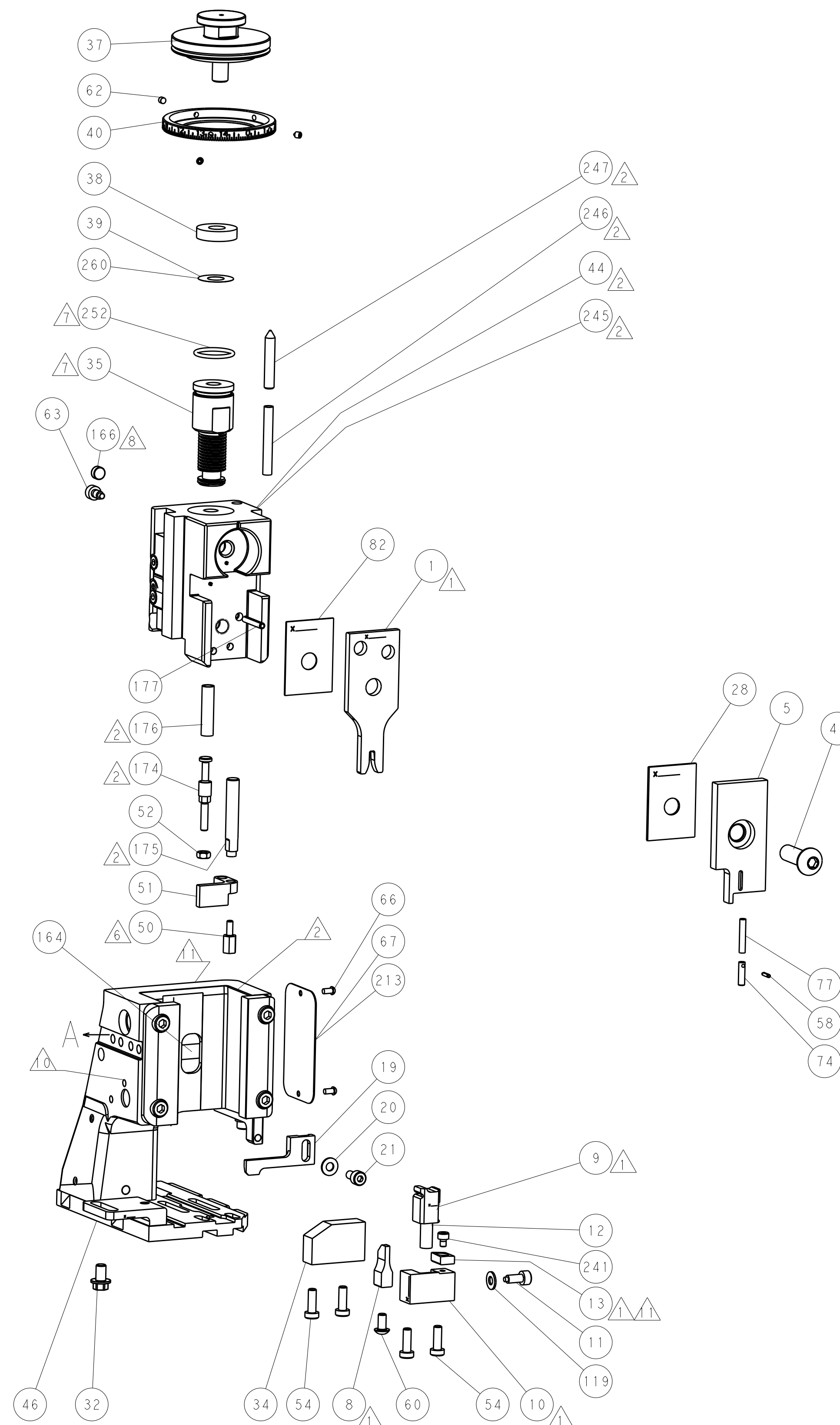
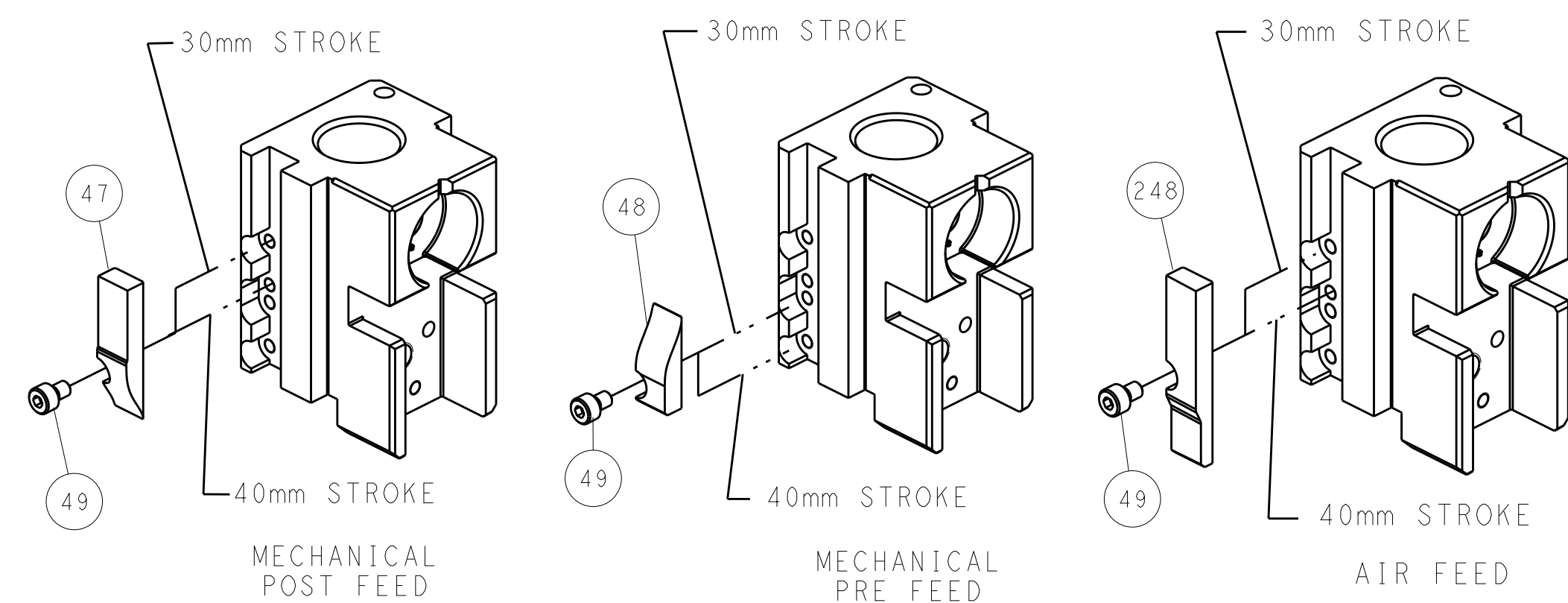
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION



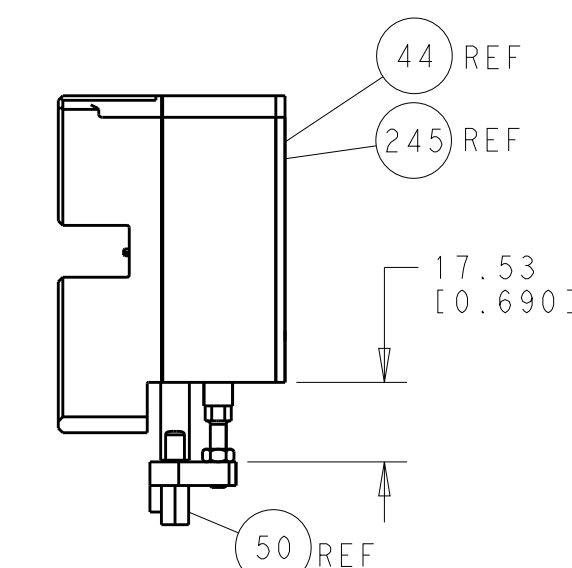
## PNEUMATIC

SERVO  
LATCH PLATE

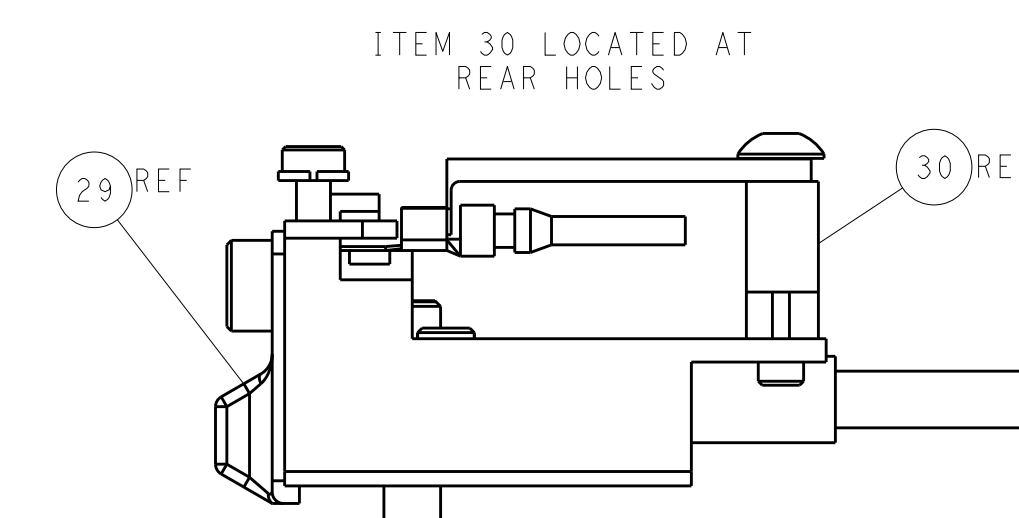
## CAM POSITIONS



TERMINAL SUPPORT LOCATION



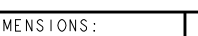
HOLDDOWN SET-UP



FEED TRACK POSITION  
GUIDE BY WIRE BARREL

## ATLANTIC VERSION

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

|                                                                                                                                                                                                                                   |  |                                                                                                                                    |  |                                                                                                                                    |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------|--|
| <small>THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION<br/>         IT IS SUBJECT TO CHANGE AND THE CONTROLS AND ENGINEERING ORGANIZATION<br/>         SHALL BE NOTIFIED FOR THE LATEST REVISIONS</small> |  | DWN<br><b>HOFNER</b> 24MAY2012<br>CHK<br><b>ELBIN</b> 25MAY2012                                                                    |  |  TE Connectivity<br>Harrisburg, PA 17105-3608 |  |
| DIMENSIONS:<br>mm                                                                                                                                                                                                                 |  | TOLERANCES UNLESS<br>OTHERWISE SPECIFIED:<br>0 PLC ±.1<br>1 PLC ±0.5<br>2 PLC ±0.13<br>3 PLC ±0.013<br>4 PLC ±.1<br>ANGLES 40° 30° |  | NAME<br>OCEAN SIDE FEED<br>APPLICATOR                                                                                              |  |
|                                                                                                                                              |  | APPLICATOR<br><b>ELBIN</b> 25MAY2012<br>PRODUCT SPEC<br>-<br>APPLICATION SPEC<br>-                                                 |  | SIZE<br>A 1                                                                                                                        |  |
| MATERIAL<br>-                                                                                                                                                                                                                     |  | FINISH<br>-                                                                                                                        |  | CAGE CODE<br>00779                                                                                                                 |  |
| WEIGHT<br>-                                                                                                                                                                                                                       |  | RESTRICTED TO<br>-                                                                                                                 |  | DRAWING NO<br>C=2151673                                                                                                            |  |
| Customer Accessible Production Drawing                                                                                                                                                                                            |  |                                                                                                                                    |  | SCALE 1:1 SHEET 2 OF 4 REV A                                                                                                       |  |



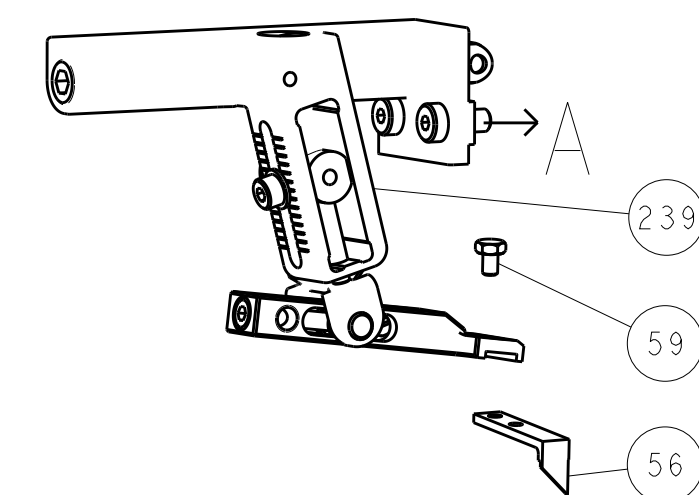




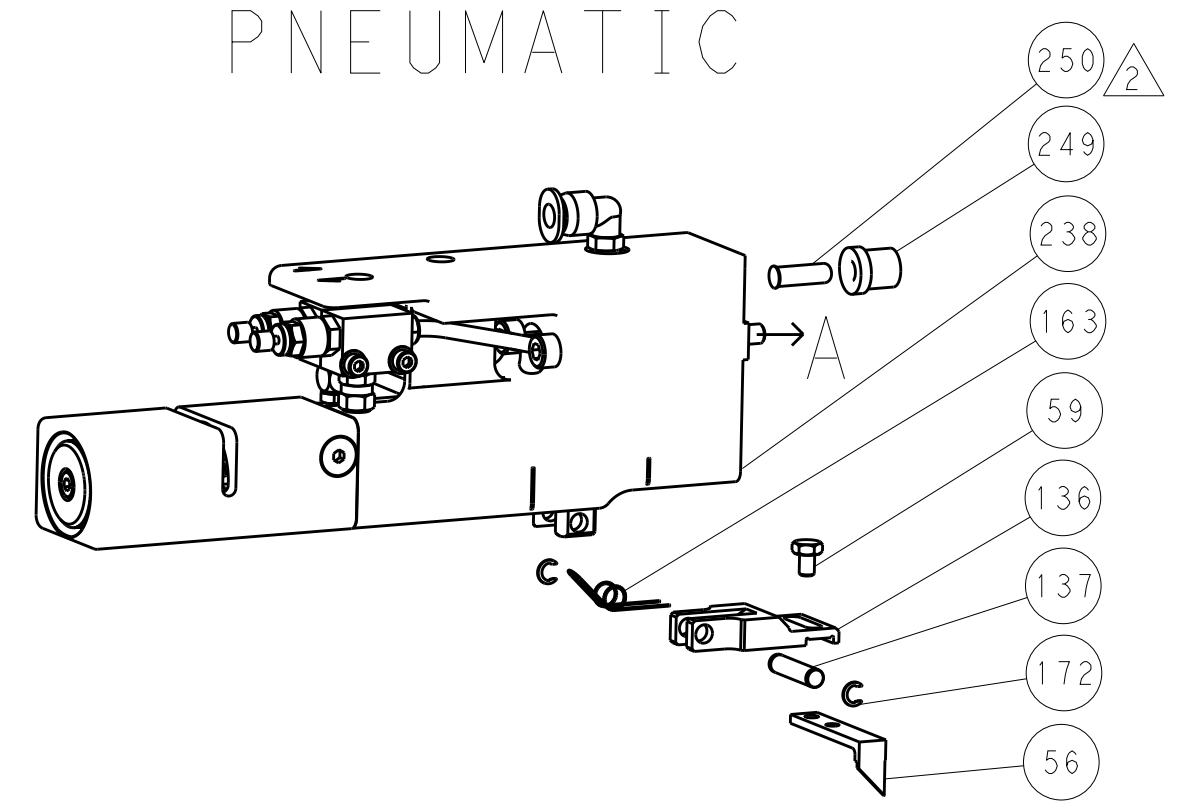
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

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

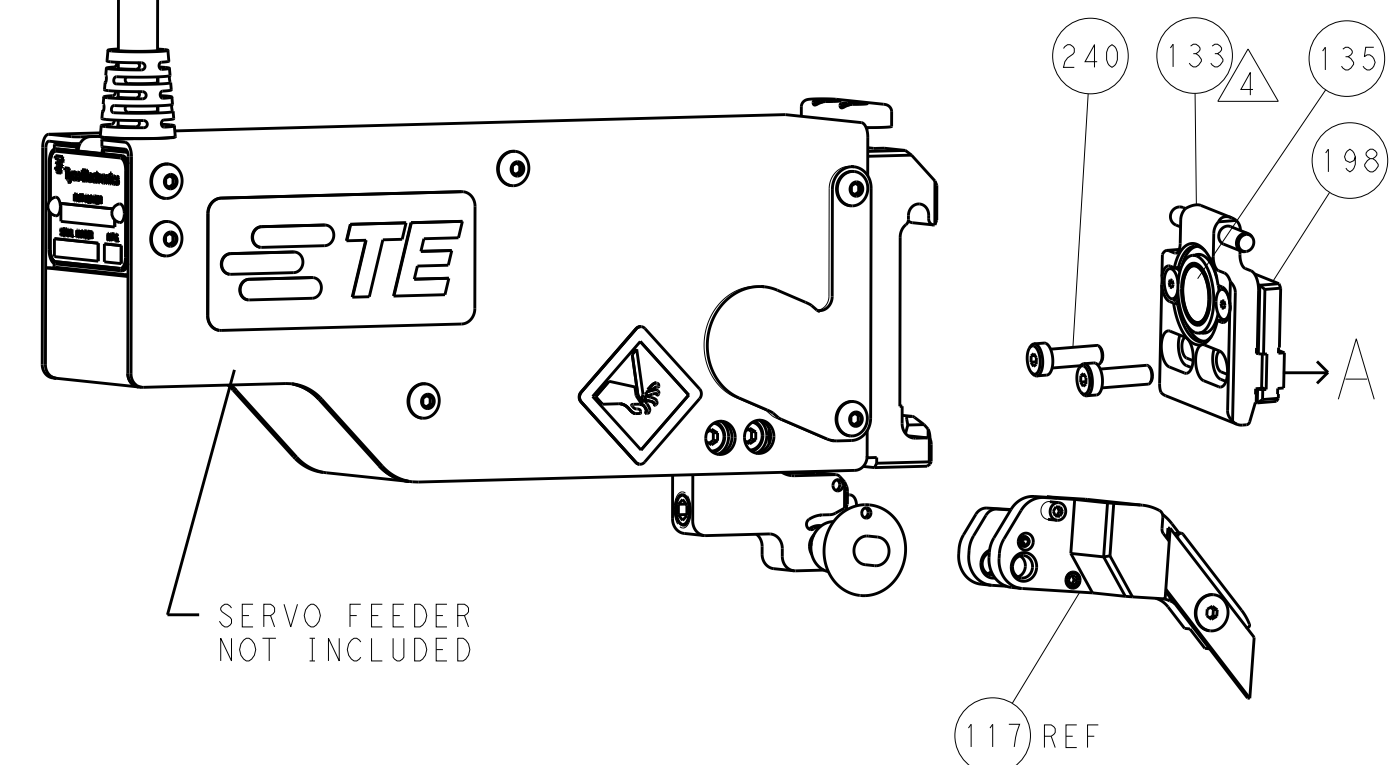
# FEED TYPE MECHANICAL



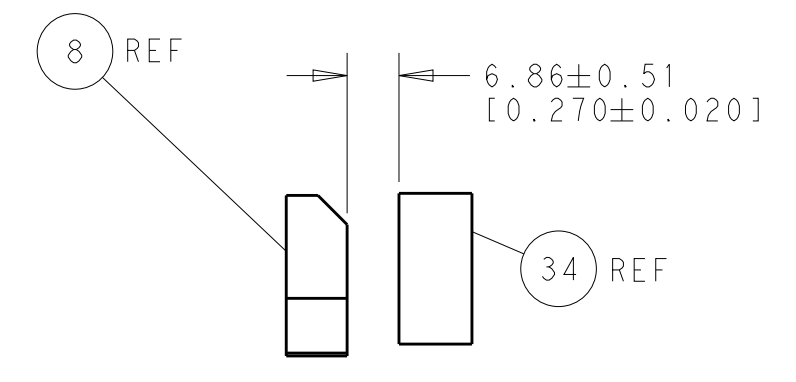
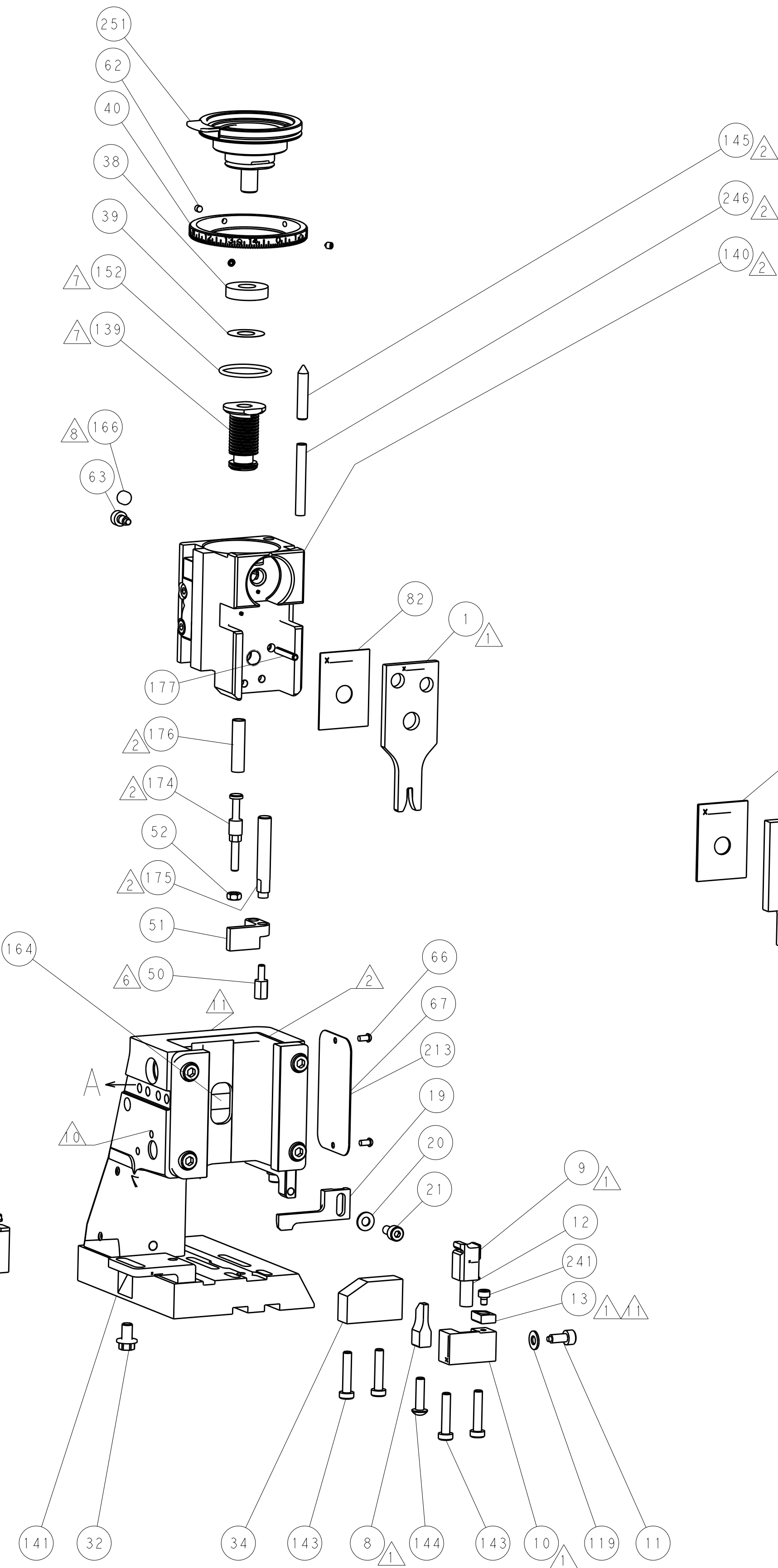
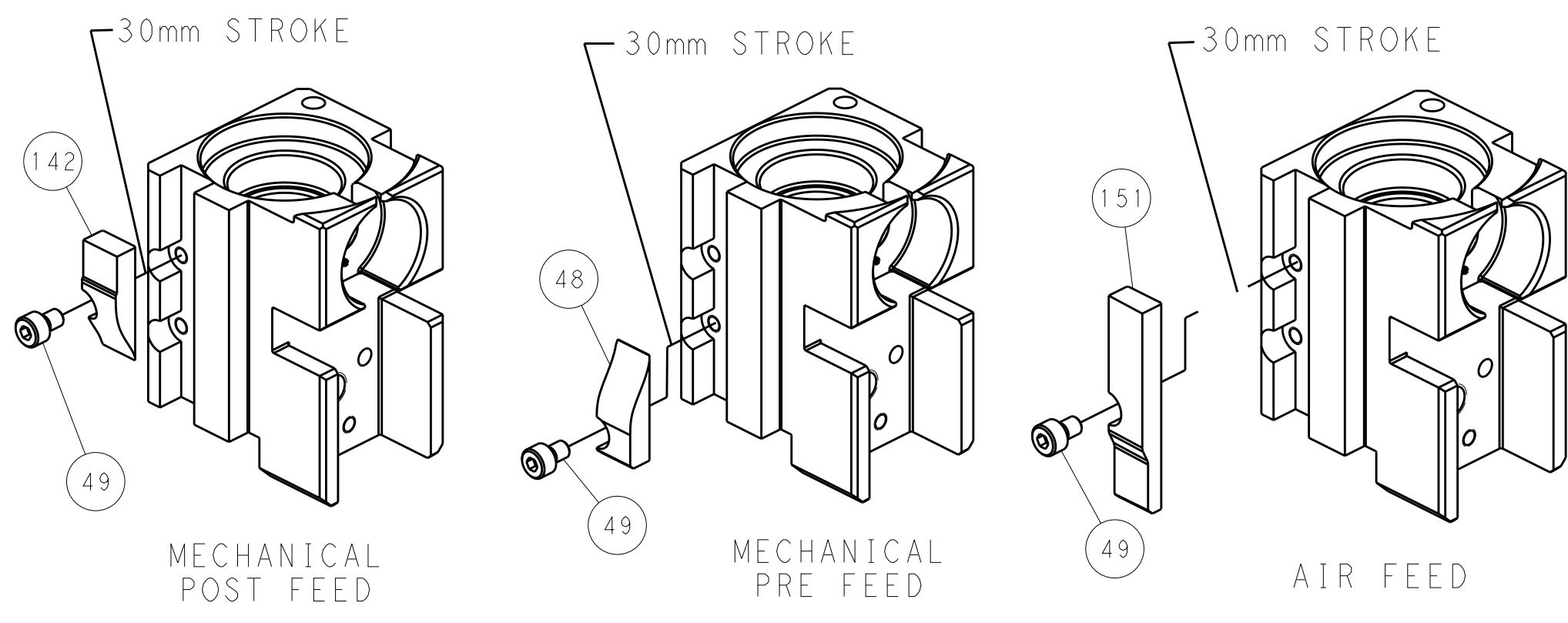
# PNEUMATIC



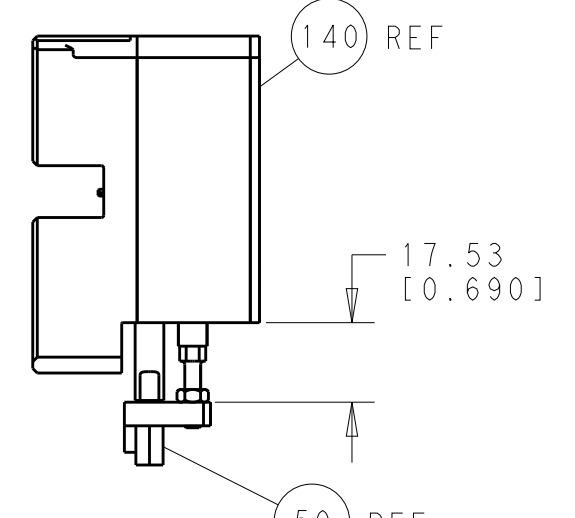
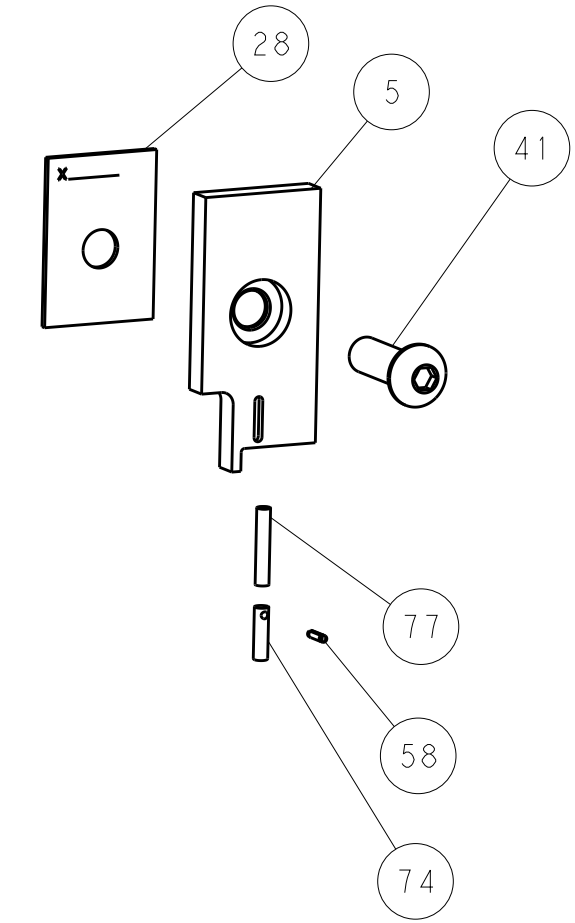
# SERVO LATCH PLATE



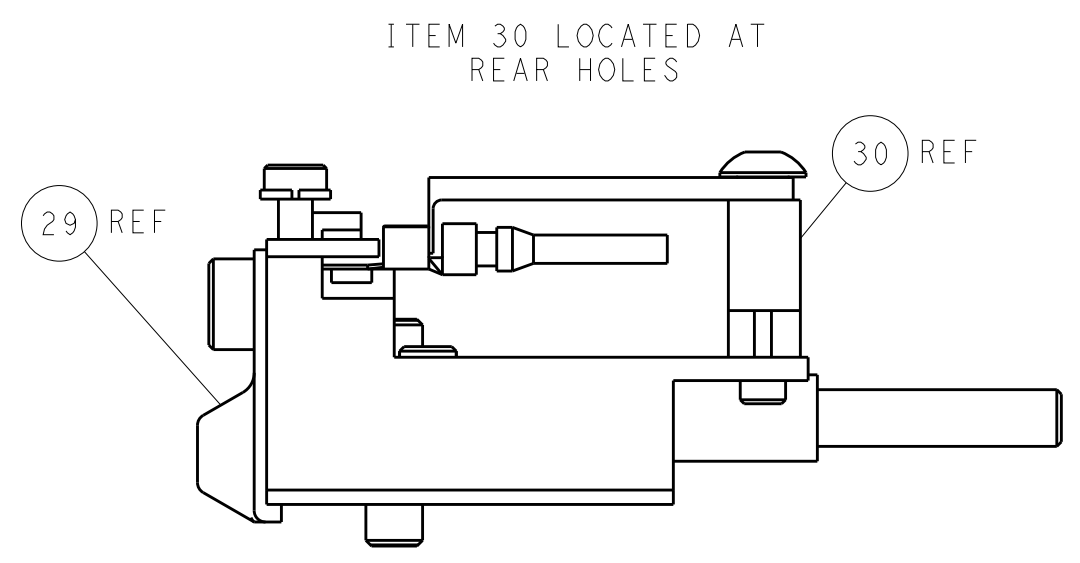
# CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION  
GUIDE BY WIRE BARREL

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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| DIMENSIONS:<br>mm                                                                                                                                                                                |  | PRODUCT SPEC<br>APPLICATION SPEC                                            | NAME<br>Ocean Side Feed<br>Applicator        |  |
| TOLERANCES UNLESS<br>OTHERWISE SPECIFIED:<br>0 PLC ±.5<br>1 PLC ±0.5<br>2 PLC ±0.13<br>3 PLC ±0.13<br>4 PLC ±.5<br>ANGLES ±0° 30'                                                                |  | SIZE<br>CAGE CODE<br>DRAWING NO.                                            | RESTRICTED TO                                |  |
| MATERIAL                                                                                                                                                                                         |  | WEIGHT                                                                      | A 00779 ©=2151673                            |  |
| Customer Accessible Production Drawing                                                                                                                                                           |  | SCALE 1:1                                                                   | SHEET 4 OF 4 REV A                           |  |