

REVISIONS			DATE	OWN	APVD
1	DEVELOPMENT		06JUN2012	CC	SX
2	REVISED		19DEC2014	XZ	UG
A	RELEASED		28OC2014	YY	UG

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
						2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151449-1	A	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	2119944-1	8-2151449-5	1901094-3	1976043-1	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151449-4	-	-	-
	2151449-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	2119944-1	8-2151449-5	1901094-3	1976043-1	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151449-4	-	-	-
	2151449-5	A	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
					-	-	-	-	-	-	-
	2151449-6	A	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-
					-	-	-	-	-	-	-
	2151449-7	A	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
					-	-	-	-	-	-	-
	7-2151449-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

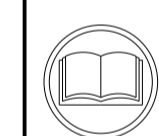
APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.00 mm [.079]	F
INSUL	3.40 mm [.134]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: FEMALE RECEPTACLE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-5.00 mm [.165-.197 IN]		Ø2.36-2.74 mm [.093-.108 IN]	
TERMINAL APPLICATION SPECIFICATION		MOLEX 63900-8400-C	
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949997-1	19420-0002	1949997-2	19420-0004

TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION			
TERMINAL NAME: FEMALE RECEPTACLE TERMINAL			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.20-5.00 mm [.165-.197 IN]		Ø 1.00 mm NOMINAL	
TERMINAL APPLICATION SPECIFICATION		MOLEX 63900-8400-C	
TERMINALS APPLIED			
TE TERMINAL	MOLEX TERMINAL	TE TERMINAL	MOLEX TERMINAL
1949997-1	19420-0002	1949997-2	19420-0004

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.20+/-0.05 [.047+/- .002]	6.3
20 AWG	1.15+/-0.05 [.045+/- .002]	7.0
22 AWG	1.10+/-0.05 [.043+/- .002]	7.1

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
24 AWG	1.05+/-0.05 [.041+/- .002]	7.6



- 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: 8-2151449-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151449-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151449-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151449-6
- 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 & 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 50 & 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

*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.

-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	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

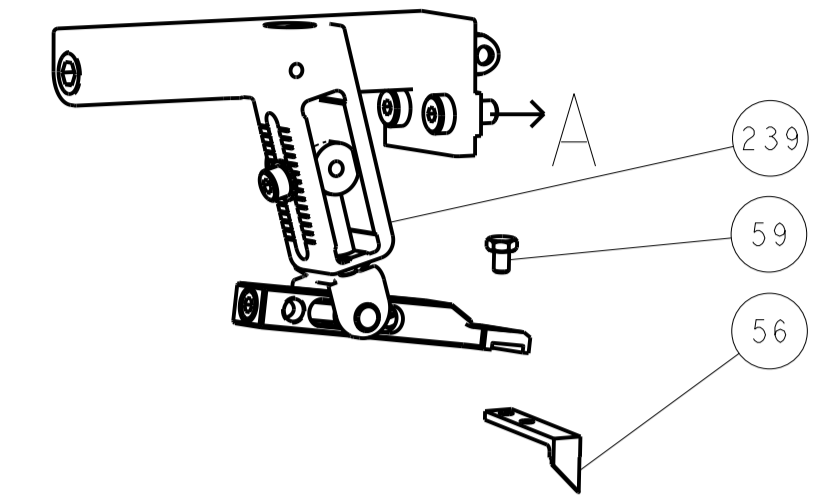
ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

P	L	M	D	DESCRIPTION	DATE	OWN	APVD	
-	-	-	-	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	2119082-8	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	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
-	1	1	1	1	1	993111-1	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	-	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
-	-	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	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	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	1	1	1	1	2-1752354-0	STANDOFF, HOLD-DOWN	50
-	-	-	-	1	2	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
-	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	1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1320908-1	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	1	1	1	1	1	1320928-1	STRIP GUIDE	24
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	2	2	2	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	1-1633620-4	ANVIL, COMBINATION	8
-	-	-	-	-	-	-	-	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	1	3-1633965-3	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	455888-4	SPACER, CRIMPER	2
-	1	1	1	1	1	4-1673600-5	CRIMPER, WIRE	1

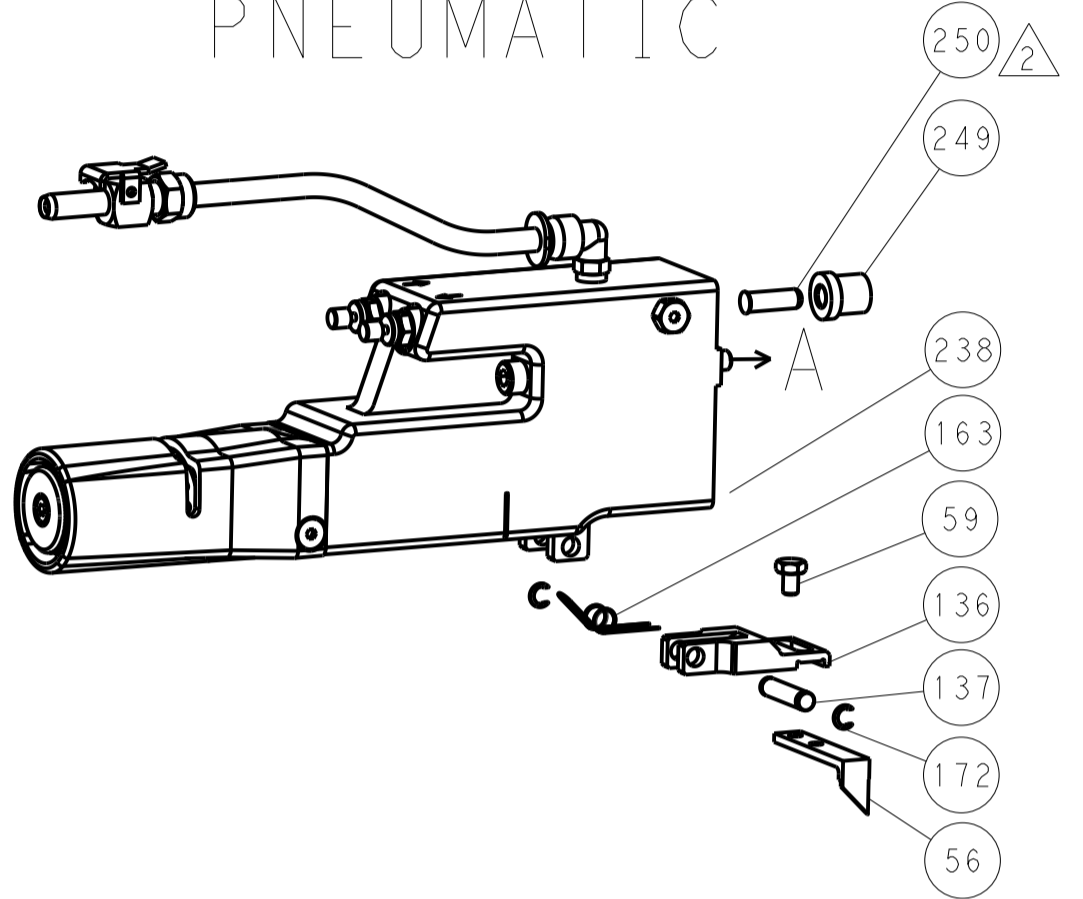
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN	CHK	DATE
mm	0 PLC ±.05	1 PLC ±.03	2 PLC ±.02	CC	CHEN	06JUN2012
	3 PLC ±.013	4 PLC ±.008	ANGLES ±.0001	SX	CHEN	06JUN2012
	FINISH			YY	CHEN	06JUN2012
MATERIAL				NAME	Ocean Side Feed Applicator	
				SIZE	CAGE CODE	DRAWING NO
				A1	00779	C=2151449
				Customer Accessible Production Drawing		
				SCALE	SHEET	1 OF 4
				REV	A	

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

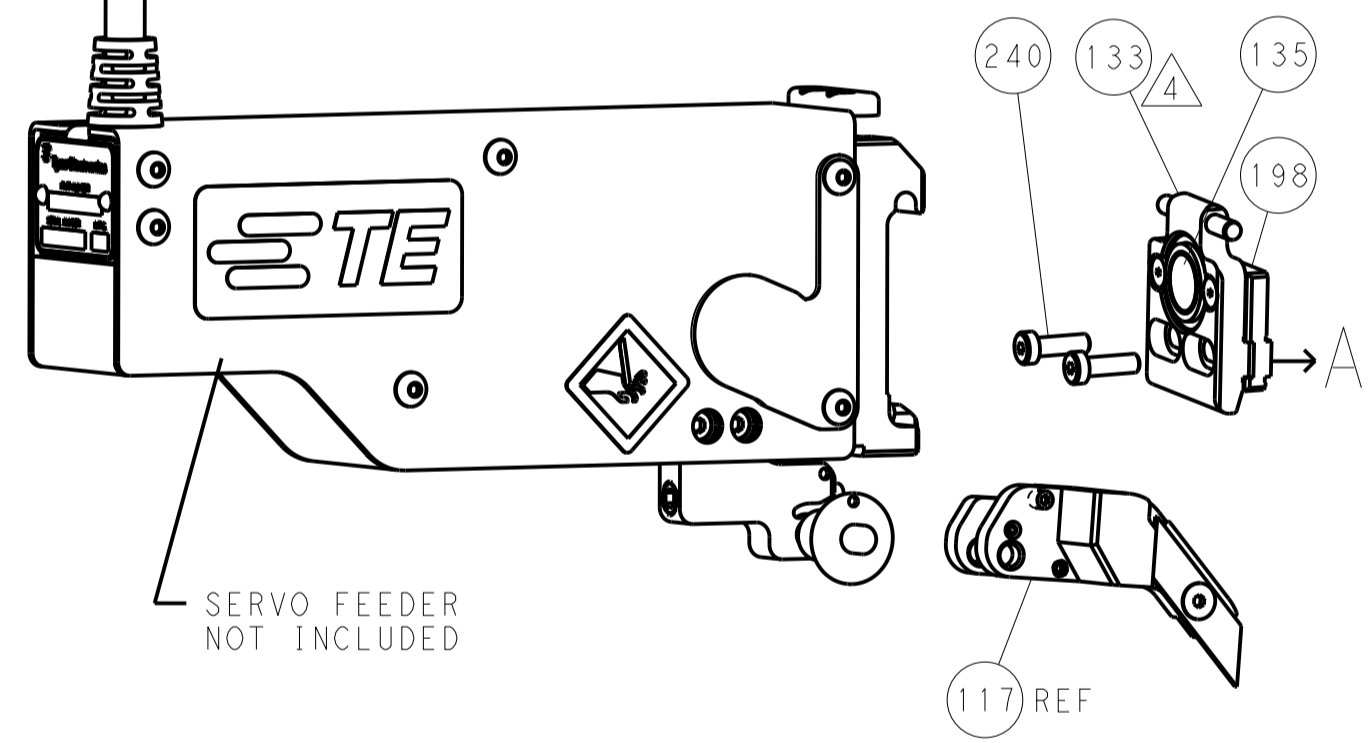
FEED TYPE MECHANICAL



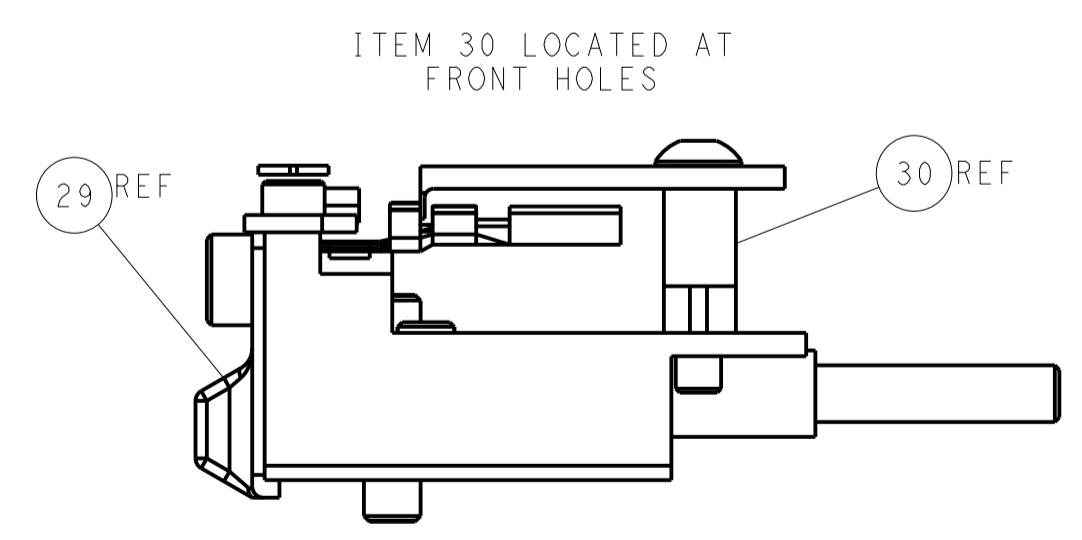
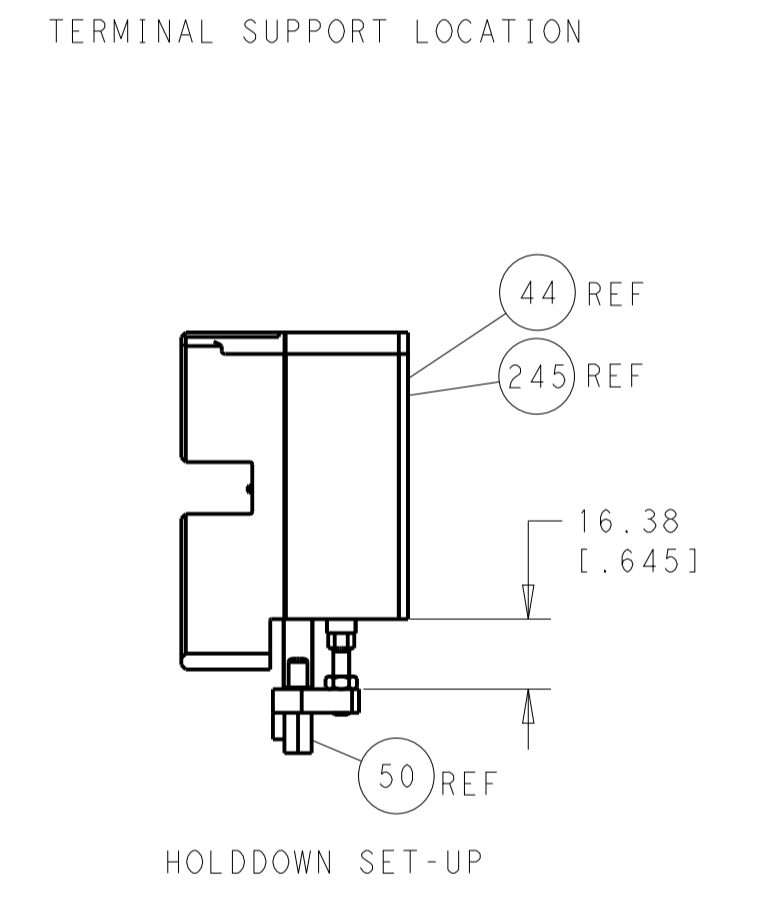
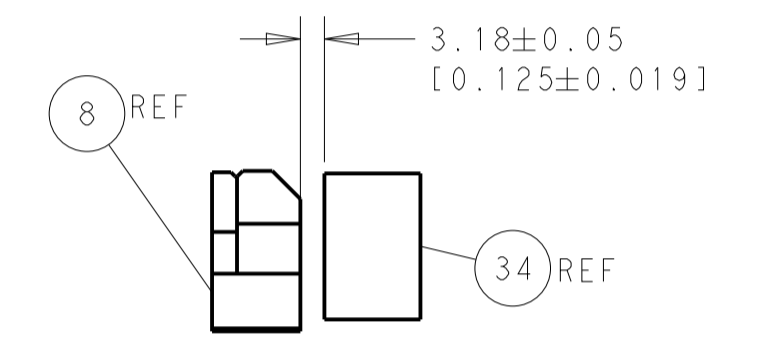
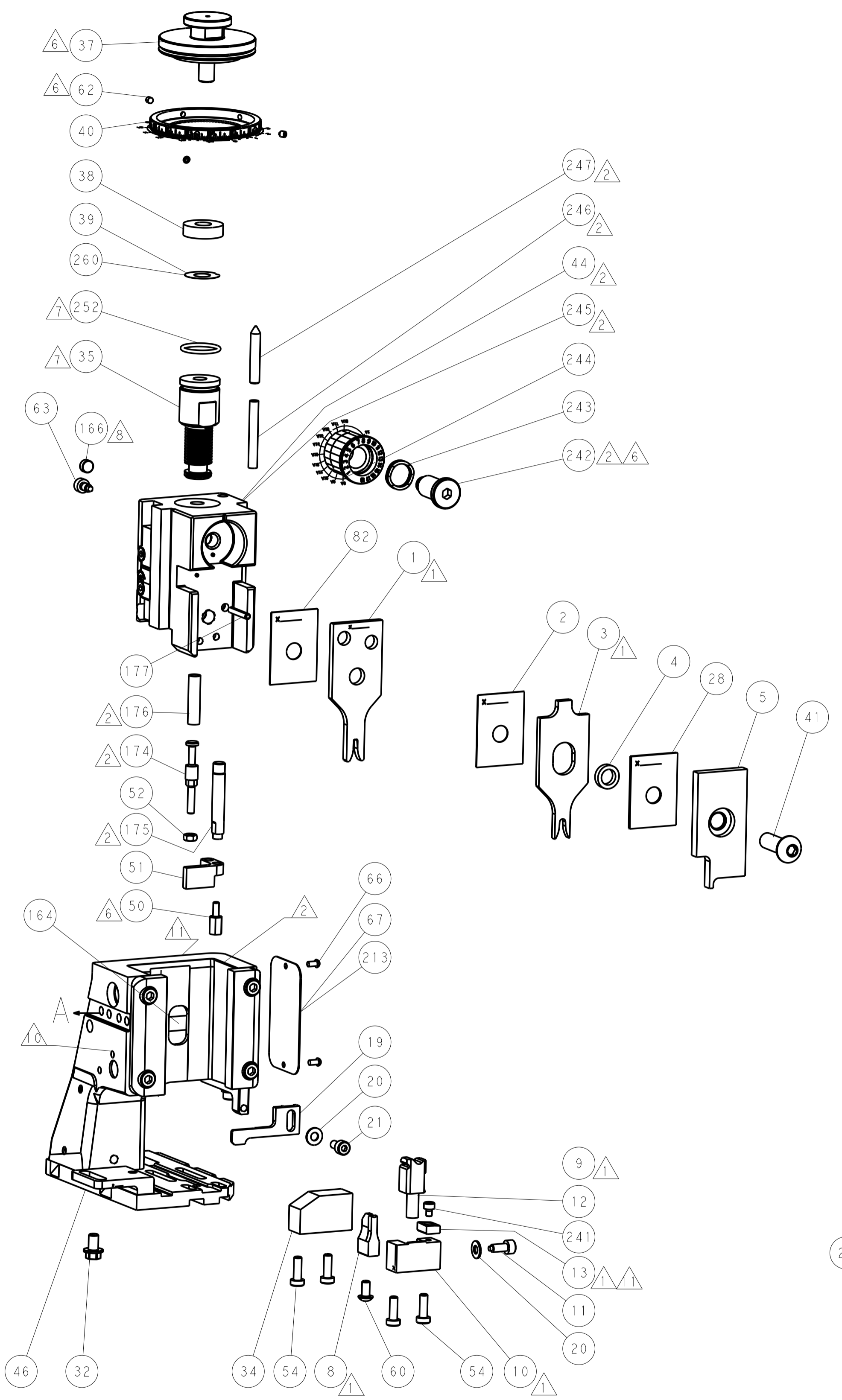
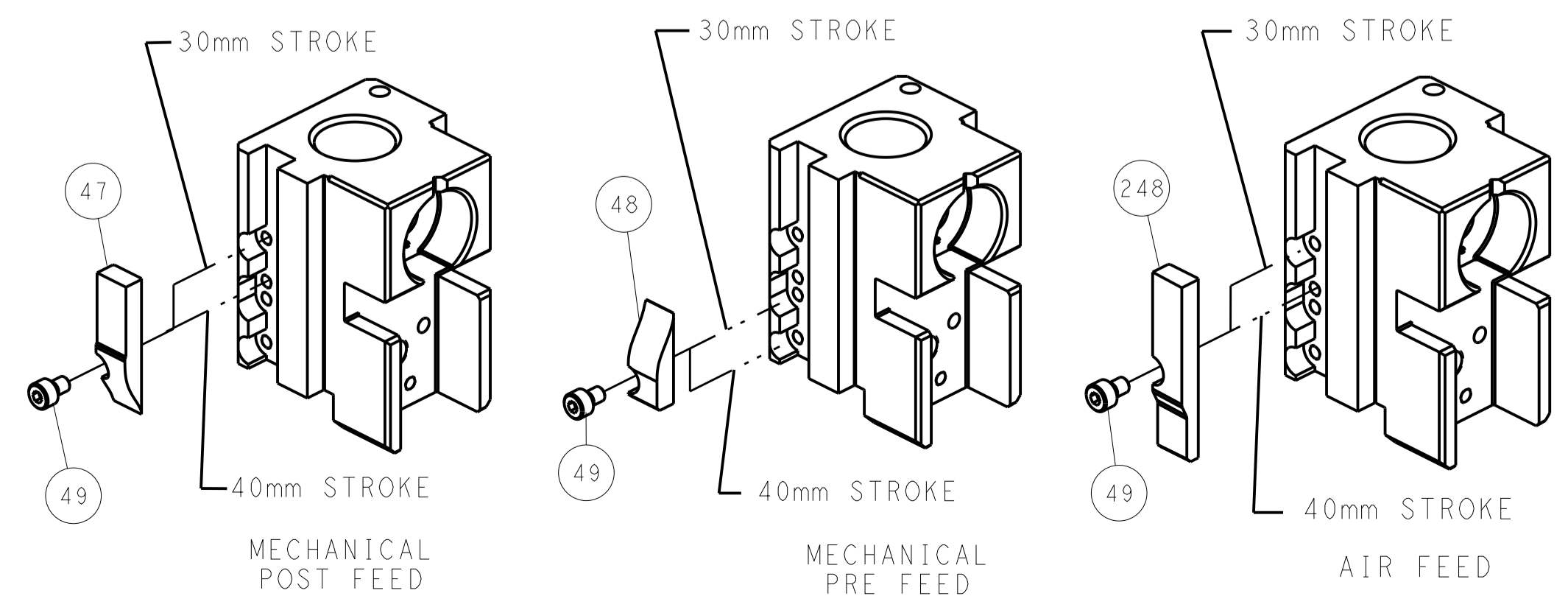
PNEUMATIC



SERVO LATCH PLATE



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 06 JUN 2012		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD 06 JUN 2012	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		PRODUCT SPEC		NAME	
				APPLICATION SPEC		Ocean Side Feed Applicator	
				WEIGHT		SIZE CAGE CODE DRAWING NO	
				A 00779		RESTRICTED TO	
				Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV A	

Table: APPLICATOR STYLE CONVERSION CHART. Columns include CONVERT TO, PART NUMBERS REQUIRED, and various part numbers like 2119950-1, 1338685-1, etc.

Table: APPLICATOR DATA. Columns include CRIMP SIZE, WIRE, INSUL, and APPLICATOR INSTRUCTIONS 408-10389.

Table: TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED.

Table: TERMINAL DATA: MOLEX TERMINAL MOLEX CRIMP SPECIFICATION. Includes WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED.

Table: WIRE SIZE vs CRIMP HEIGHT. Columns include WIRE SIZE (18 AWG, 20 AWG, 22 AWG) and CRIMP HEIGHT mm [INCH].

Table: WIRE SIZE vs CRIMP HEIGHT. Columns include WIRE SIZE (24 AWG) and CRIMP HEIGHT mm [INCH].

- 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...

*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. Includes entries for 2119782-1 FINE ADJUST HEAD ASM, PACIFIC STYLE and 2119640-1 PUSH ROD, AIR FEED.

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

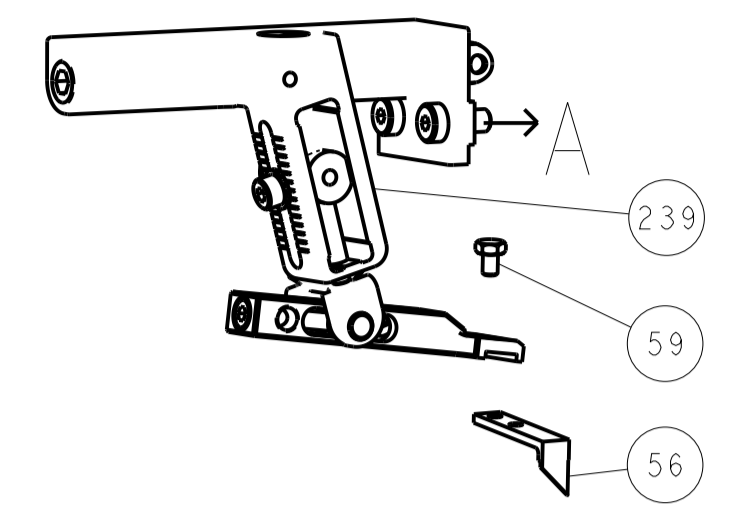
Table: REVISIONS. Columns include REV, LTR, DESCRIPTION, DATE, DWN, APVD. Includes revision 1 with description SEE SHEET 1.

Table: REVISIONS. Columns include REV, LTR, DESCRIPTION, DATE, DWN, APVD. Lists numerous revisions with descriptions like BUSHING, LCH5-12, MISUMI and SPRING, COMPRESSION.

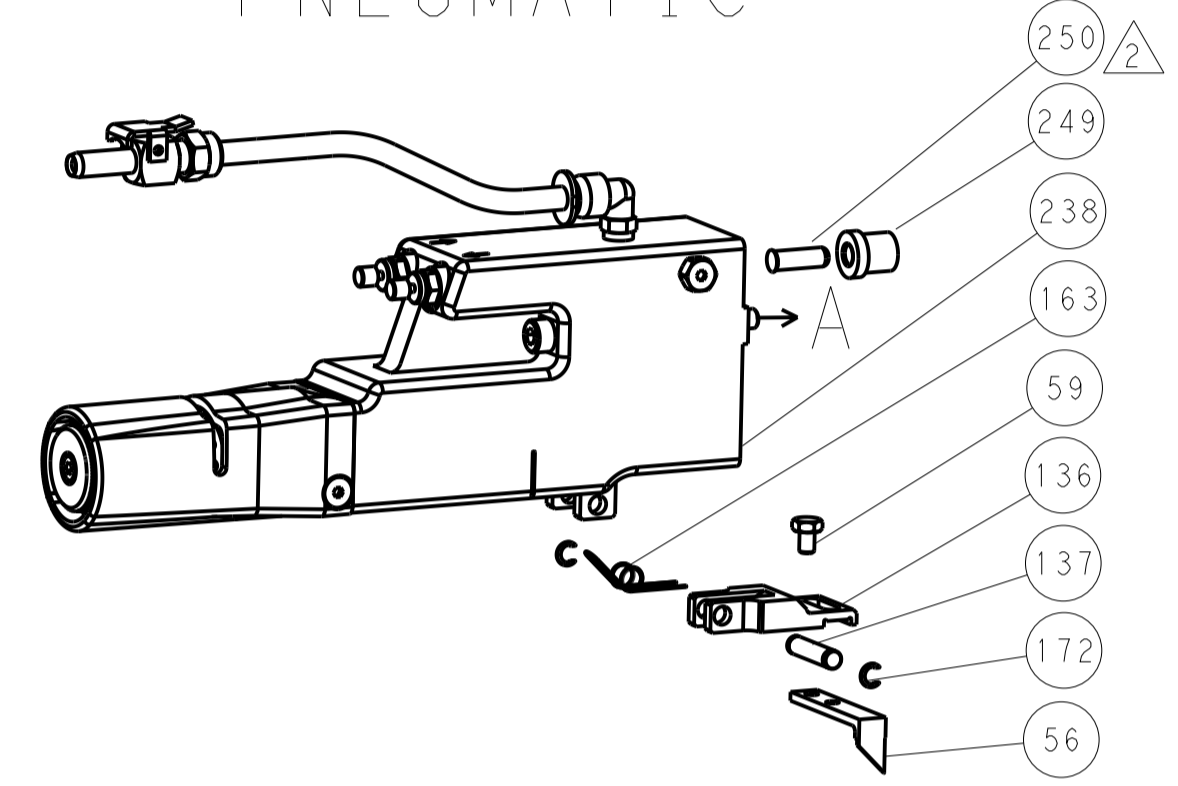
Table: DIMENSIONS, TOLERANCES, MATERIAL, FINISH, WEIGHT, SCALE. Includes technical drawing and material specifications.

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

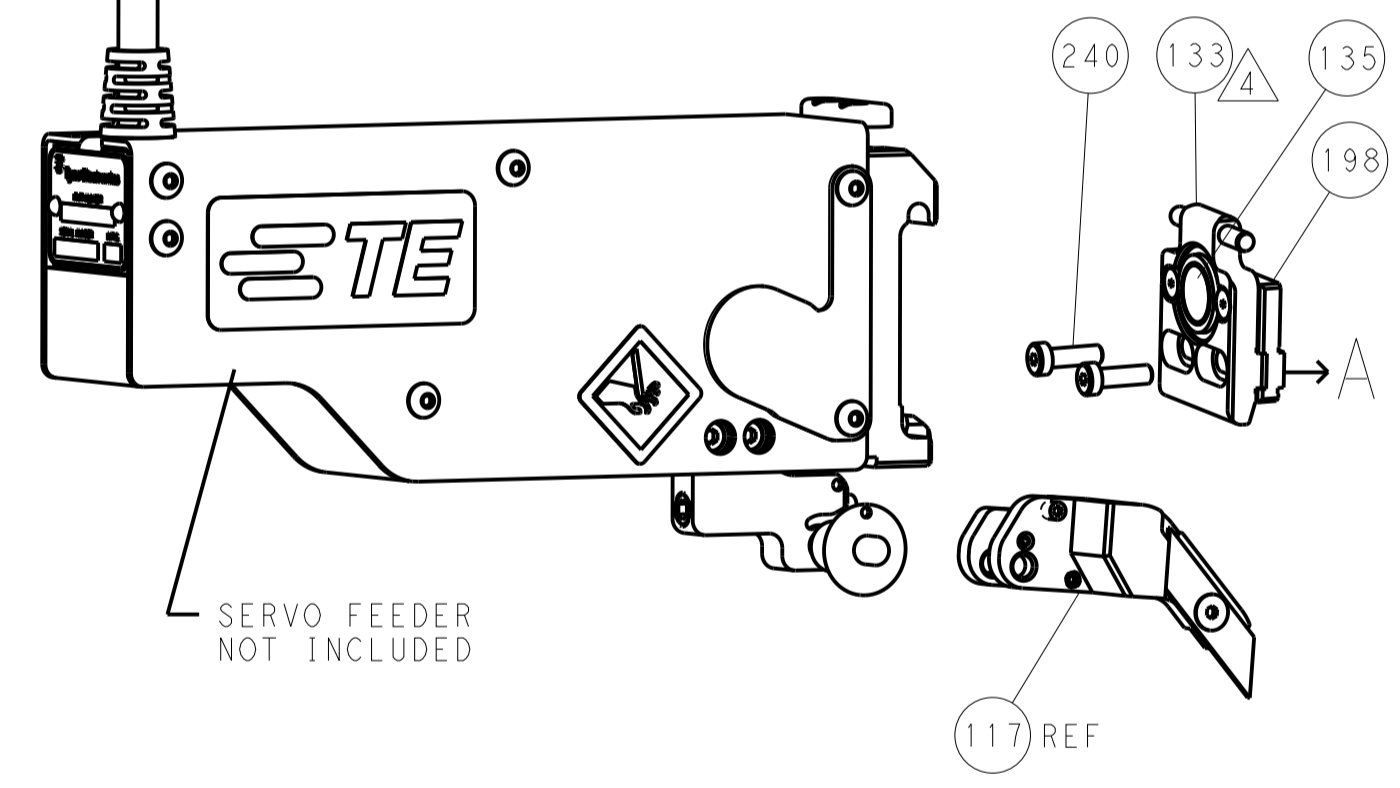
FEED TYPE MECHANICAL



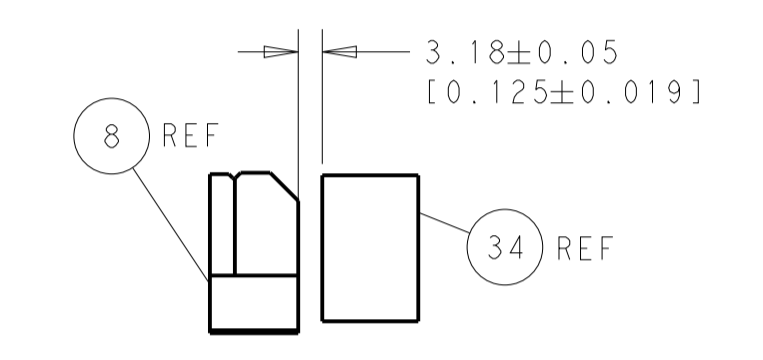
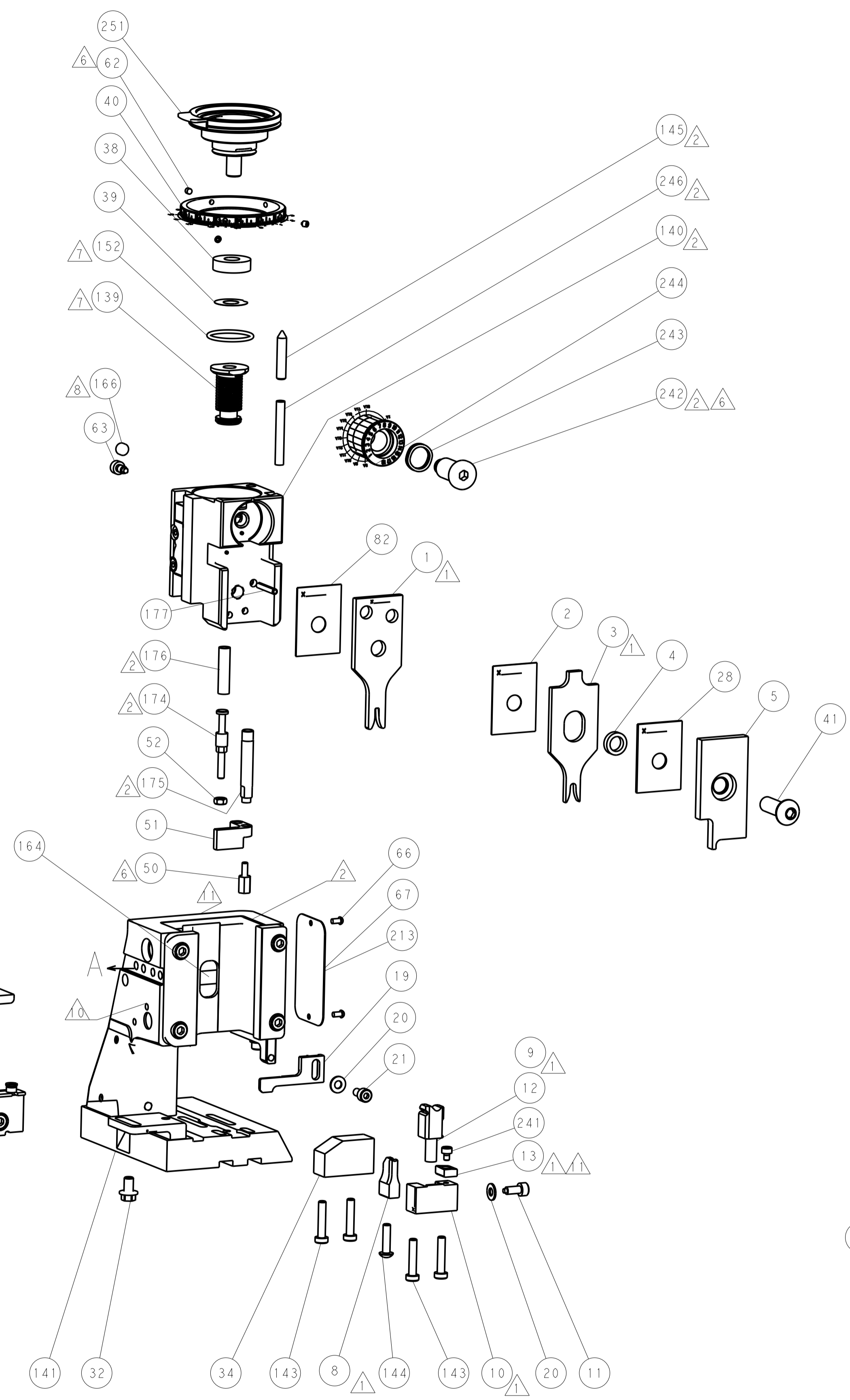
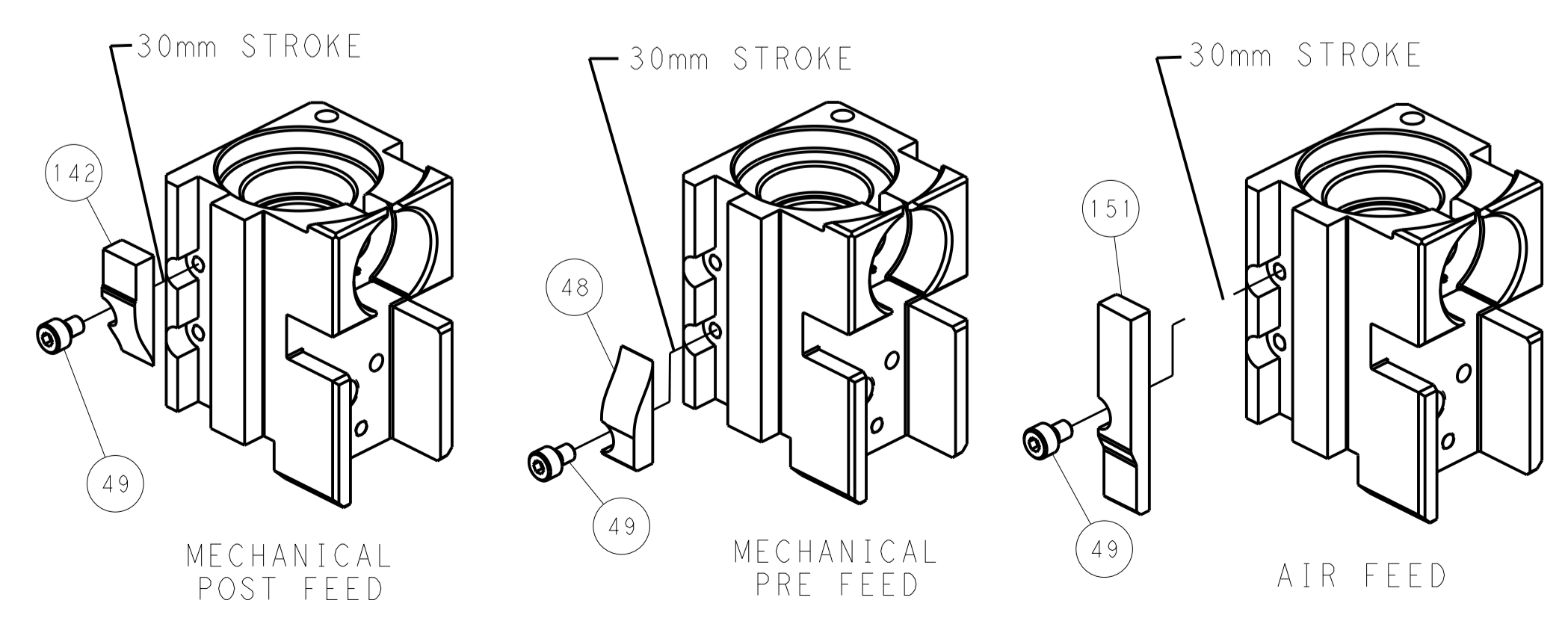
PNEUMATIC



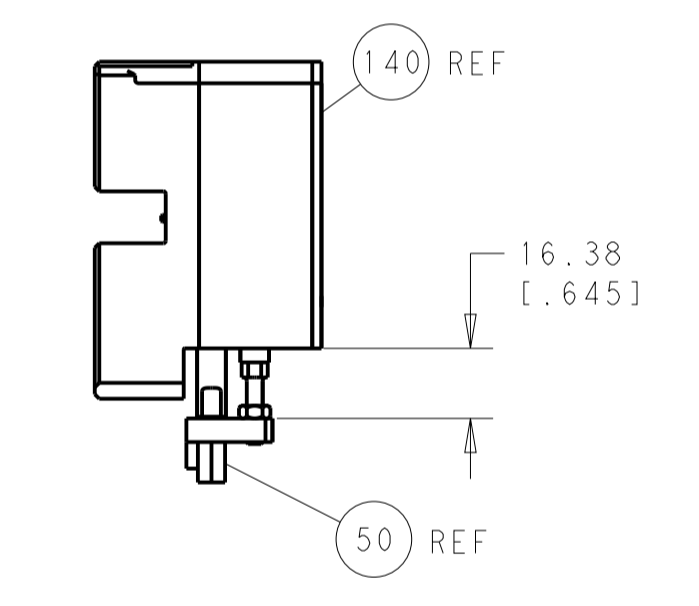
SERVO LATCH PLATE



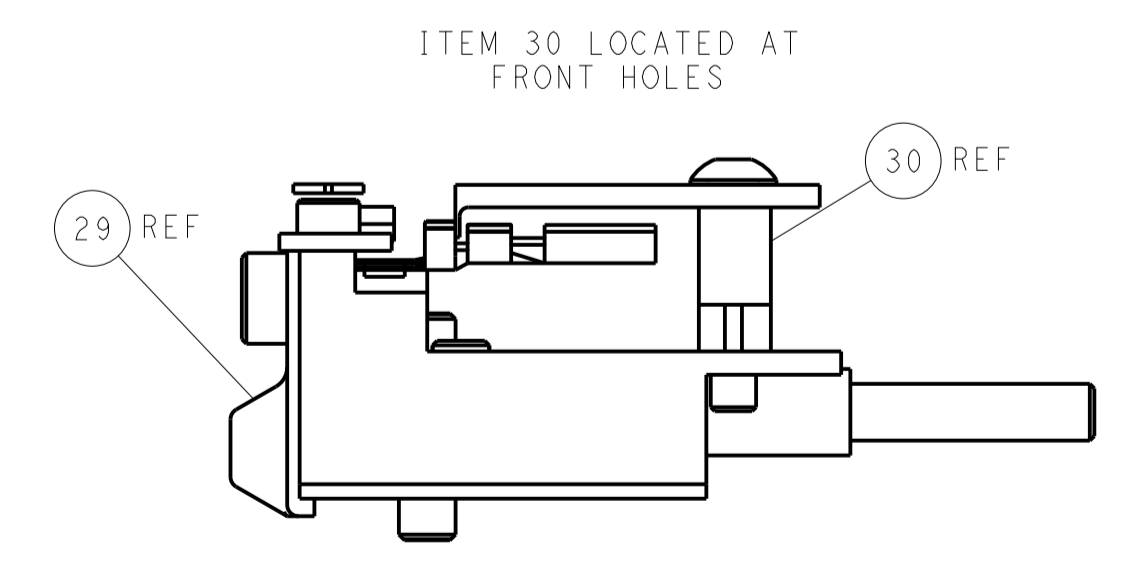
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

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

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: C. CHEN 06JUN2012		TE Connectivity	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD: S. XI 06JUN2012	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		PRODUCT SPEC:		NAME: Ocean Side Feed Applicator	
				APPLICATION SPEC:		SIZE: CAGE CODE: DRAWING NO: A1 00779 ©=2151449	
				WEIGHT:		RESTRICTED TO:	
				CUSTOMER ACCESSIBLE PRODUCTION DRAWING		SCALE: 1:2 SHEET 4 OF 4 REV A	