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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

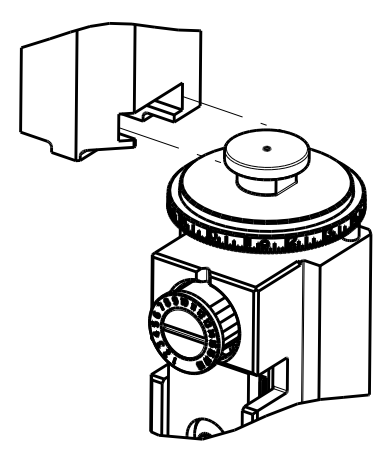
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151560-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151560-5

8-2151560-4

2119641-1

1901094-3

-

2119799-1

2-1752354-2

-

2063440-1

2168400-6 (QUANTITY 2)

-

2151560-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151560-5

8-2151560-4

2119653-1

1901094-3

-

-

2-1752354-2

-

-

2168400-6 (QUANTITY 2)

-

2151560-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

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

2151560-6

A

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹²

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2151560-7

A

FINE CRIMP HEIGHT ADJUST

NONE

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7-2151560-7

A

CRIMP TOOLING KIT

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APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 4.06 mm [1.60] F

INSUL 6.35 mm [1.250] O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: POWER QUADLOK BUCHSENKONTAKT, EDS

WIRE STRIP LENGTH 5.20-5.80 mm [1.205-.228 IN] INSULATION DIAMETER RANGE Ø4.00-6.00 mm [1.157-.236 IN]

TERMINAL APPLICATION SPECIFICATION 114-18141-1

TERMINALS APPLIED

TE TERMINAL TE TERMINAL TE SEAL TE SEAL

1719973-2 1719972-1

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING

6.00mm2 2.55+/-0.05 [1.00+/-0.002] 8.9

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: 8-2151560-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151560-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151560-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151560-6

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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.

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 3.25.

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.

APPLICATOR STYLE CONVERSION CHART

CONVERT TO

PART NUMBERS REQUIRED

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151560-5

8-2151560-4

2119641-1

1901094-3

-

2119799-1

2-1752354-2

-

2063440-1

2168400-6 (QUANTITY 2)

-

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151560-5

8-2151560-4

2119653-1

1901094-3

-

-

2-1752354-2

-

-

2168400-6 (QUANTITY 2)

-

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

1338685-1

1338685-1

5-18022-5

5-18022-5

2119653-1

2119641-1

-

2119799-1

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2063440-1

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-

APPLICATOR DATA

CRIMP SIZE TYPE

WIRE 4.06 mm [1.60] F

INSUL 6.35 mm [1.250] O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL TE CRIMP SPECIFICATION

TERMINAL NAME: POWER QUADLOK BUCHSENKONTAKT, EDS

WIRE STRIP LENGTH 5.20-5.80 mm [1.205-.228 IN] INSULATION DIAMETER RANGE Ø4.00-6.00 mm [1.157-.236 IN]

TERMINAL APPLICATION SPECIFICATION 114-18141-1

TERMINALS APPLIED

TE TERMINAL TE TERMINAL TE SEAL TE SEAL

1719973-2 1719972-1

WIRE SIZE CRIMP HEIGHT mm [INCH] CRIMP HEIGHT REFERENCE SETTING

6.00mm2 2.55+/-0.05 [1.00+/-0.002] 8.9

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: 8-2151560-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151560-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151560-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151560-6

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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.

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 3.25.

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.

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

REVISONS

DESCRIPTION

DATE

OWN

APVD

RELEASED

29APR2013

RK

GB

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2079988-1

BUSHING, LCH5-12, MISUMI

249

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1

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2119641-1

FEED CAM, AIR FEED

248

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1

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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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2161314-1

RAM, STEPPED, ATLANTIC, SF, NON-ADJ

245

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2119082-9

CAM, SNAIL, INSULATION ADJUSTMENT

244

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2079764-1

WASHER, WAVE SPRING, CREST-TO-CREST

243

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2119083-1

RETAINER, INSULATION DIAL

242

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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

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2

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21045-3

RING, RETAIN, EXTERN, 3/16 CRESCENT

172

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1

1

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1

994969-1

MAGNET, RARE EARTH HIGH ENERGY

166

-

REF

REF

REF

REF

REF

994970-2

COUNTER, MAGNETIC

164

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240638-1

SPRING, FEED FINGER

163

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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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1-455888-7

SPACER, CRIMPER

82

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1

1

1

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1

2119956-1

DOCUMENTATION PACKAGE

71

-

1

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1

1

2119740-1

TAG,IDENTIFICATION

67

-

2

2

2

2

2

2168078-1

SCREW, DRIVE, RH, RoHS, 2 x .188

66

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1

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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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1

1

1

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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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985575-3

SCR, FLT SKT HD CAP M3 X 10.0

57

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1338685-1

PAWL, FEED

56

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4

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4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

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2

2

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2

2

1-2168083-0

SCR, SKT HD CAP, RoHS, M4 X 10

53

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5018030-1

NUT, HEX, REG, RoHS, M3

52

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811242-5

BUMPER, HOLD DOWN

51

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690753-2

SPACER, TONKER

50

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18023-9

SCR, SKT HD CAP M4 X 6.0

49

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1

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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2161311-1

RAM, STEPPED, AMP STYLE, SIDE FEED

44

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1-2079383-5

SCR, BHSC, RoHS (M8 X 40)

41

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2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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2119957-1

APPLICATOR SHIM PACK

39

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2119644-3

RAM WASHER, PRECISION

38

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2119085-1

FA HEAD, ATLANTIC STYLE

37

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2119092-1

BOLT, ADJUSTMENT

35

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1-1752356-8

SUPPORT, TERMINAL

34

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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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1-1320908-8

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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3-22280-3

SPRING, COMPRESSION

12

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1-356885-4

STOP, SHEAR

11

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2119805-1

SHEAR HOLDER, FRONT

10

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318707-1

FLOATING SHEAR, FRONT

9

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1-1633138-5

ANVIL, COMBINATION

8

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2119781-1

DEPRESSOR, SHEAR

5

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238011-3

BLOCK, CRIMPER SPACER

4

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8-2119784-6

CRIMPER, INSULATION O PREMIUM

3

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455888-6

SPACER, CRIMPER

2

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2-1752057-5

CRIMPER, WIRE PREMIUM, STEPPED

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

APPLICATOR SHIM PACK

260

SPACER, PRECISION

259

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

252

PUSH ROD, AIR FEED

250

APPLICATOR SHIM PACK

260

SPACER, PRECISION

259

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

252

PUSH ROD, AIR FEED

250

APPLICATOR SHIM PACK

260

SPACER, PRECISION

259

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

252

PUSH ROD, AIR FEED

250

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE LATEST REVISIONS.

OWN T.YIN 04FEB2013

CHK G.BAILEY 04FEB2013

APVD S.XI 04FEB2013

DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±.02 2 PLC ±.02 3 PLC ±.005 4 PLC ±.0005 ANGLES ±.1

MATERIAL - FINISH -

PRODUCT SPEC -

APPLICATION SPEC -

WEIGHT -

Customer Accessible Production Drawing

SCALE 1:1

SHEET 1 OF 4

REV A

TE Connectivity

Harrisburg, PA 17105-3608

Ocean Side Feed

Applicator

SIZE CASE CODE DRAWING NO RESTRICTED TO

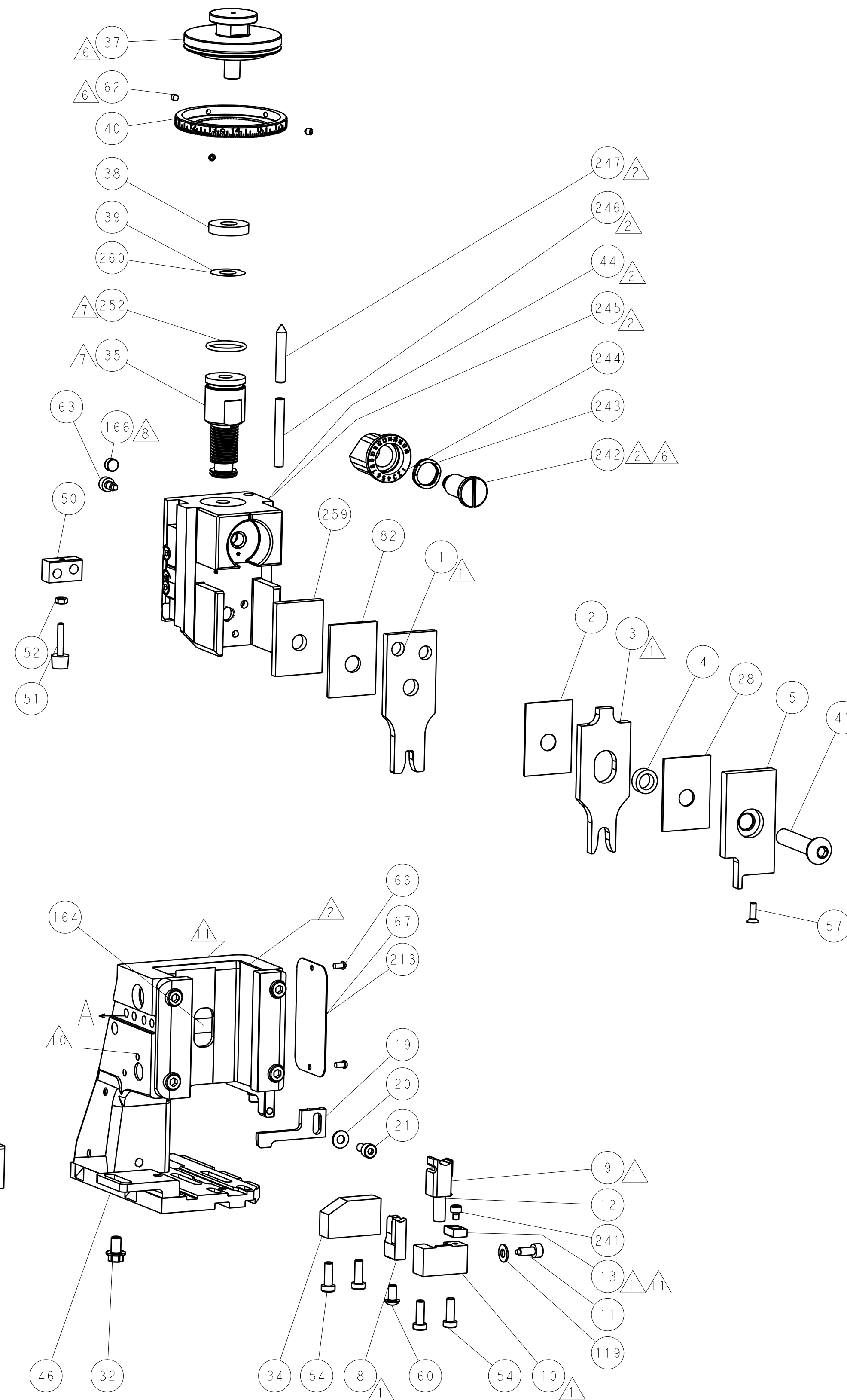
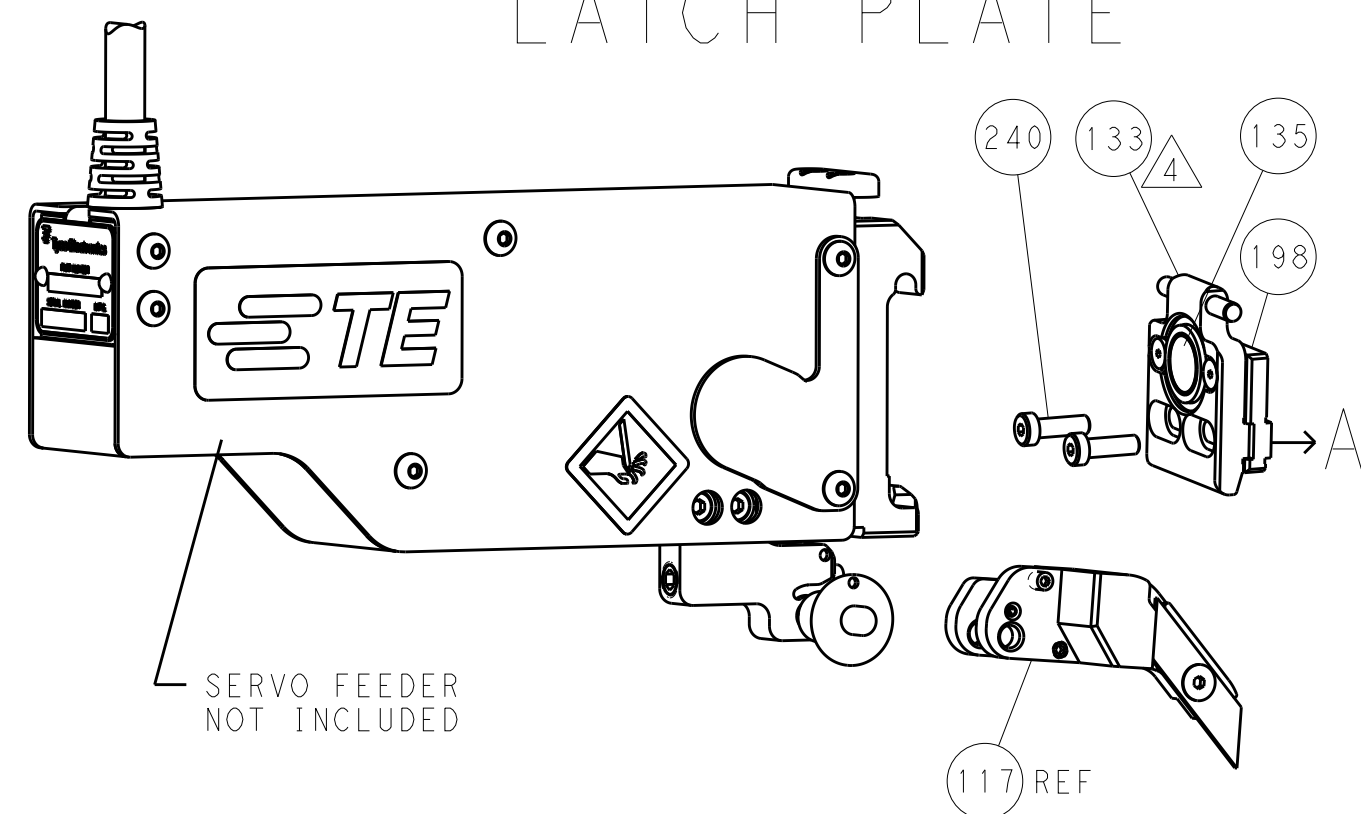
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SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

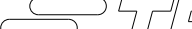
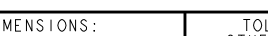
PNEUMATIC

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)

THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLS AND ENGINEERING ORGANIZATION RESERVE THE RIGHT TO MODIFY THIS DRAWING WITHOUT NOTICE		DWN Y YIN 04/26/2013 CHK G. BAILEY 04/26/2013 APPV S. XI 04/26/2013		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±.1		NAME Ocean Side Feed Applicator	
		PRODUCT SPEC - APPLICATION SPEC -		SIZE A 1	
MATERIAL -		FINISH -		CAGE CODE 00779	
WEIGHT -		DRAWING NO C=2151560		RESTRICTED TO -	
Customer Accessible Production Drawing				SCALE 1:1 SHEET 2 OF 4 REV A	

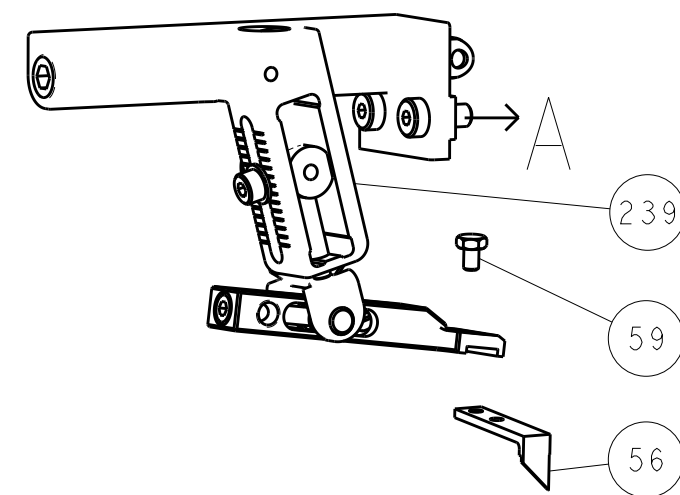
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

C

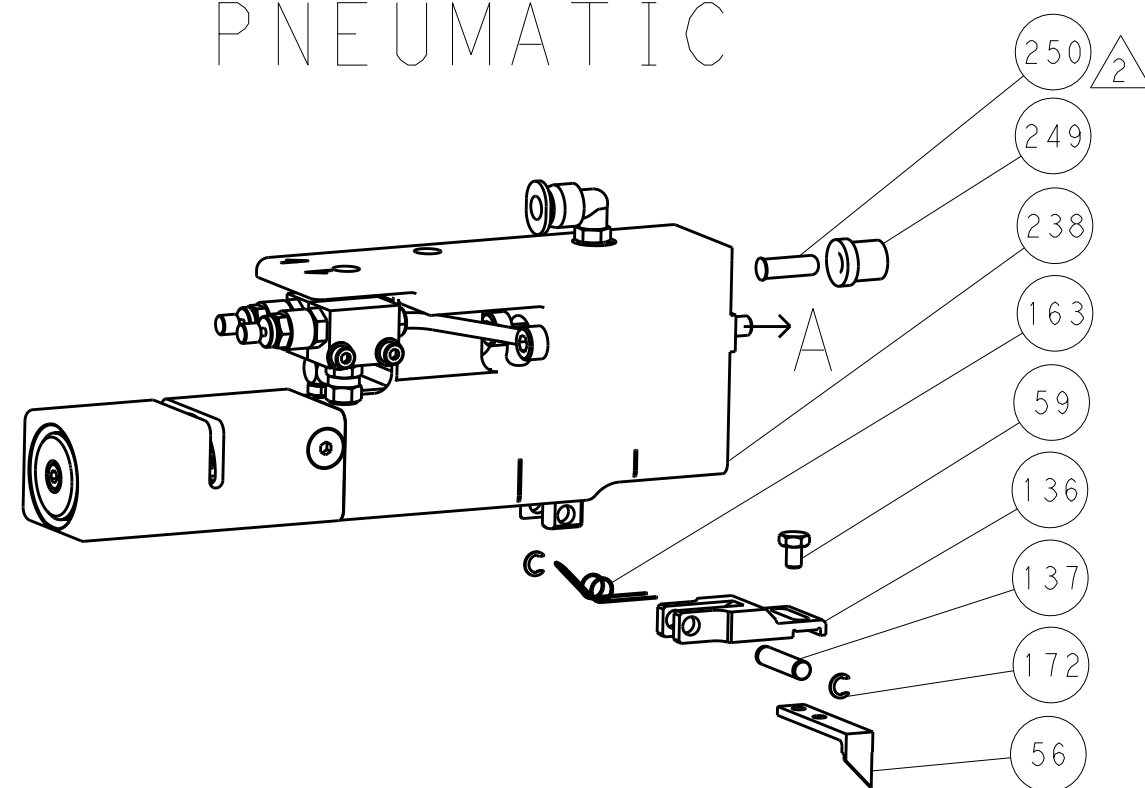
B

A

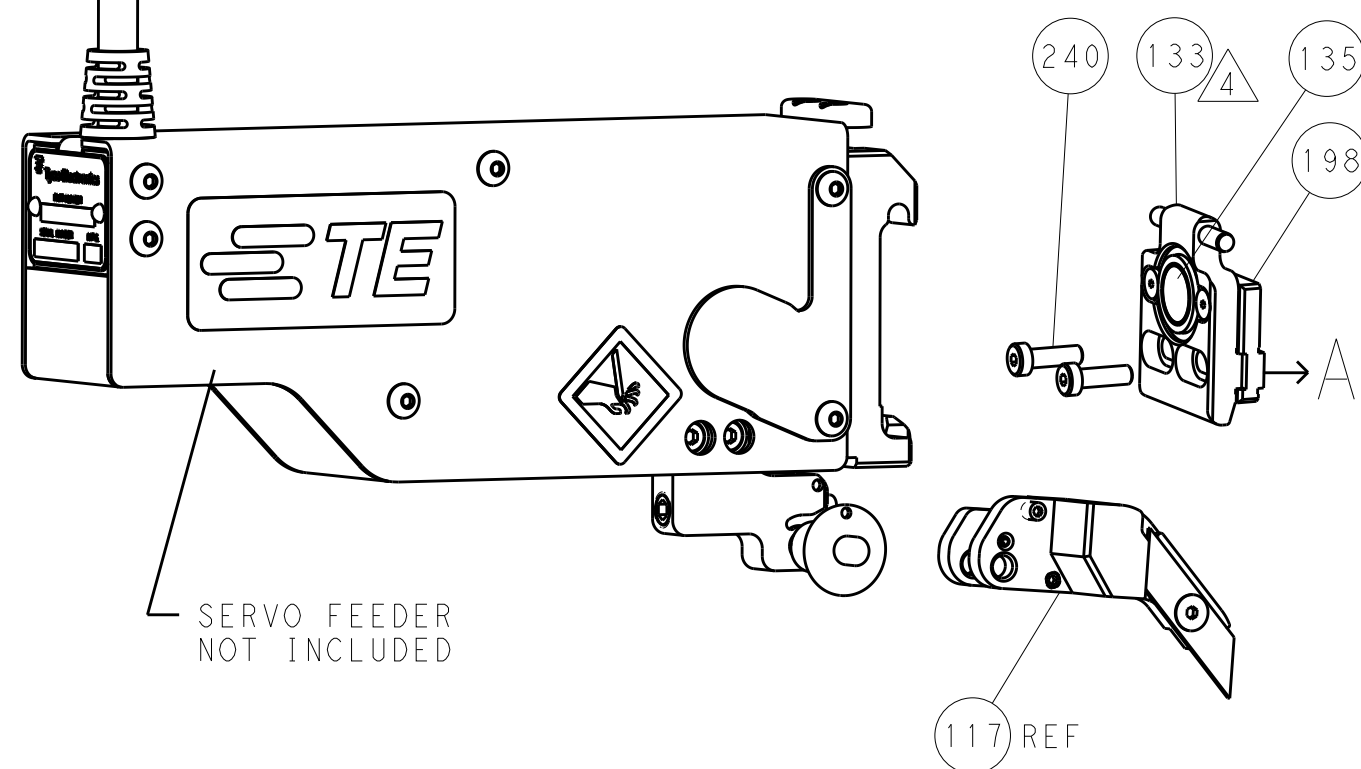
FEED TYPE MECHANICAL



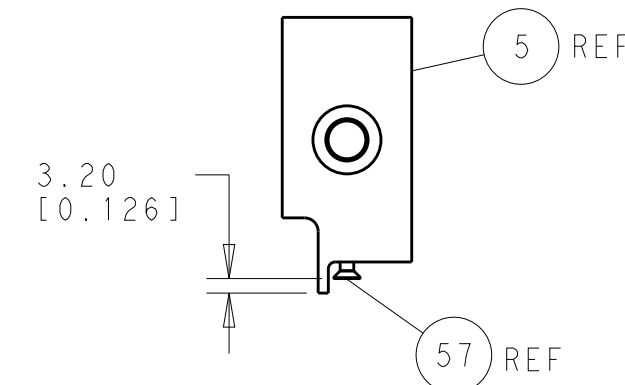
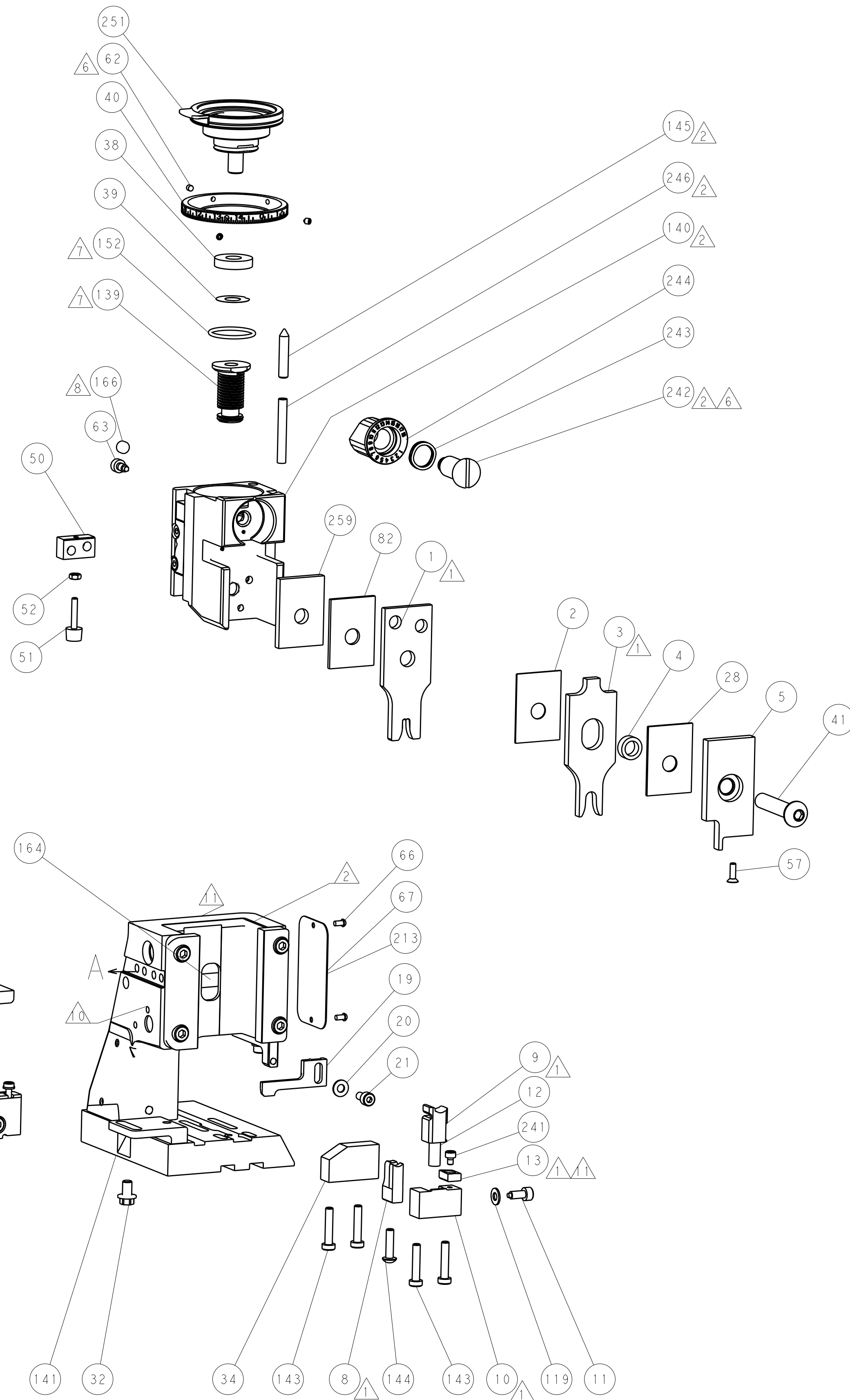
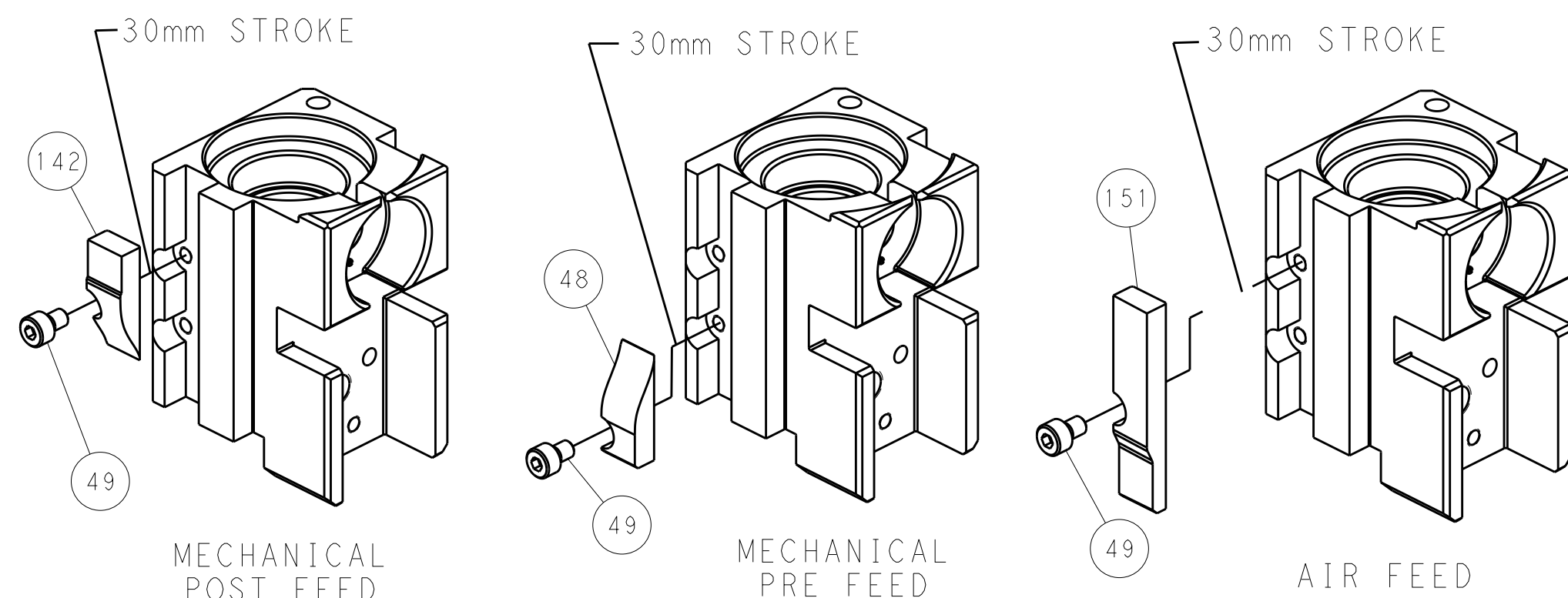
PNEUMATIC



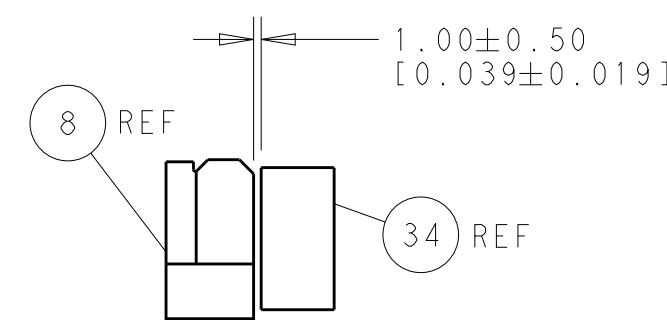
SERVO LATCH PLATE



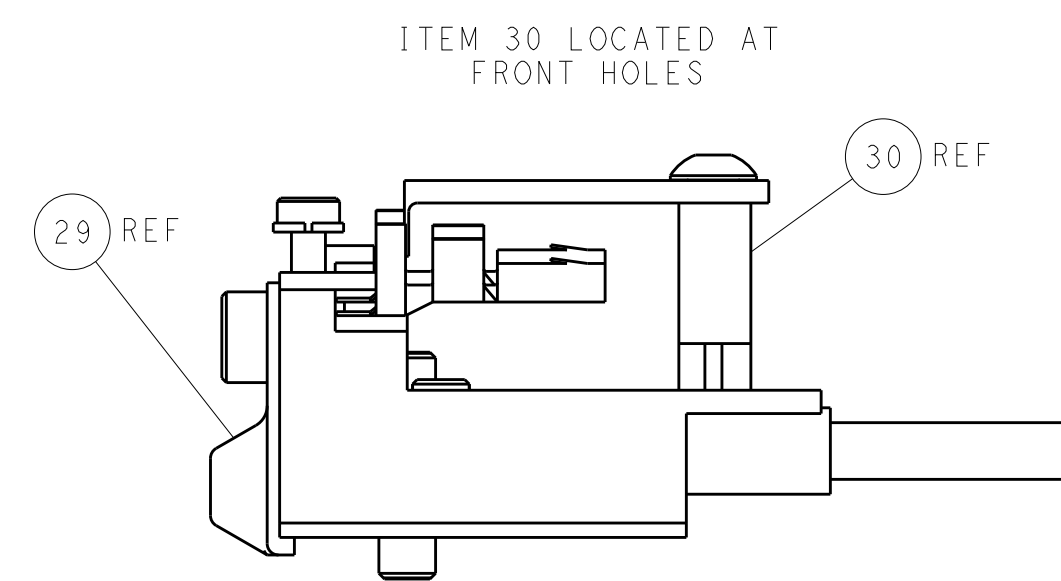
CAM POSITIONS



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 MUST BE APPROVED BY THE DESIGNING ORGANIZATION. NO PARTS OR SERVICES SHOULD BE ORDERED FOR THE LATEST EDITION.		OWN Y. YIN 04FEB2013	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 04FEB2013	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±.1		APVD S. XI 04FEB2013	PRODUCT SPEC APPLICATION SPEC	
MATERIAL		WEIGHT	SIZE A1	RESTRICTED TO
Customer Accessible Production Drawing		SCALE 1:1	CAGE CODE 00779	DRAWING NO. C=2151560
SHEET 4		OF 4	REV A	