

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER. PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED.

APPLICATOR DATA. CRIMP SIZE, WIRE, INSUL, APPLICATOR INSTRUCTIONS 408-10389.

TERMINAL DATA: ETCO TERMINAL, TE CRIMP SPECIFICATION. WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, TERMINAL APPLICATION SPECIFICATION, TERMINALS APPLIED.

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

- 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.

*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. Rows include items like APPLICATOR SHIM PACK, SPACER, PRECISION, O-RING, PUSH ROD, AIR FEED, etc.

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

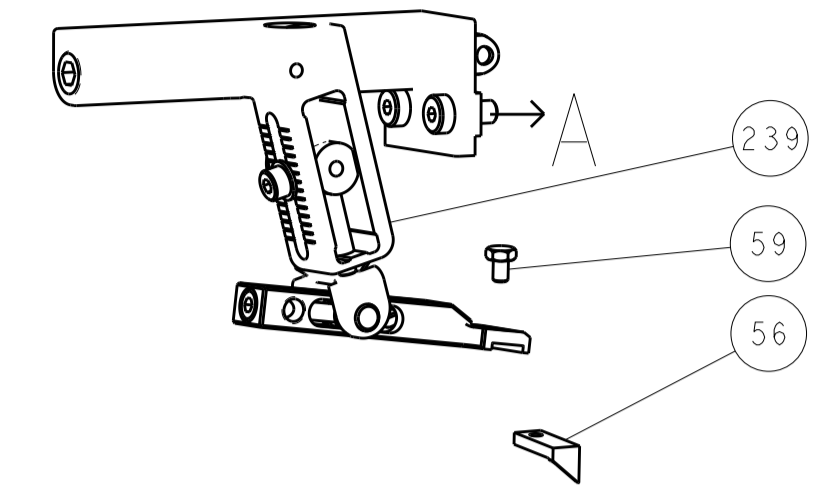
SET UP GAUGE 2119599-1, LOC A, DIST 66. REVISIONS table with columns: P, LTR, DESCRIPTION, DATE, DWN, APVD.

Main parts list table with columns: QTY, PART NO, DESCRIPTION, ITEM NO. Includes parts like WASHER, WAVE SPRING, CREST-TO-CREST, RETAINER, INSULATION DIAL, SCR, SKT HD CAP, etc.

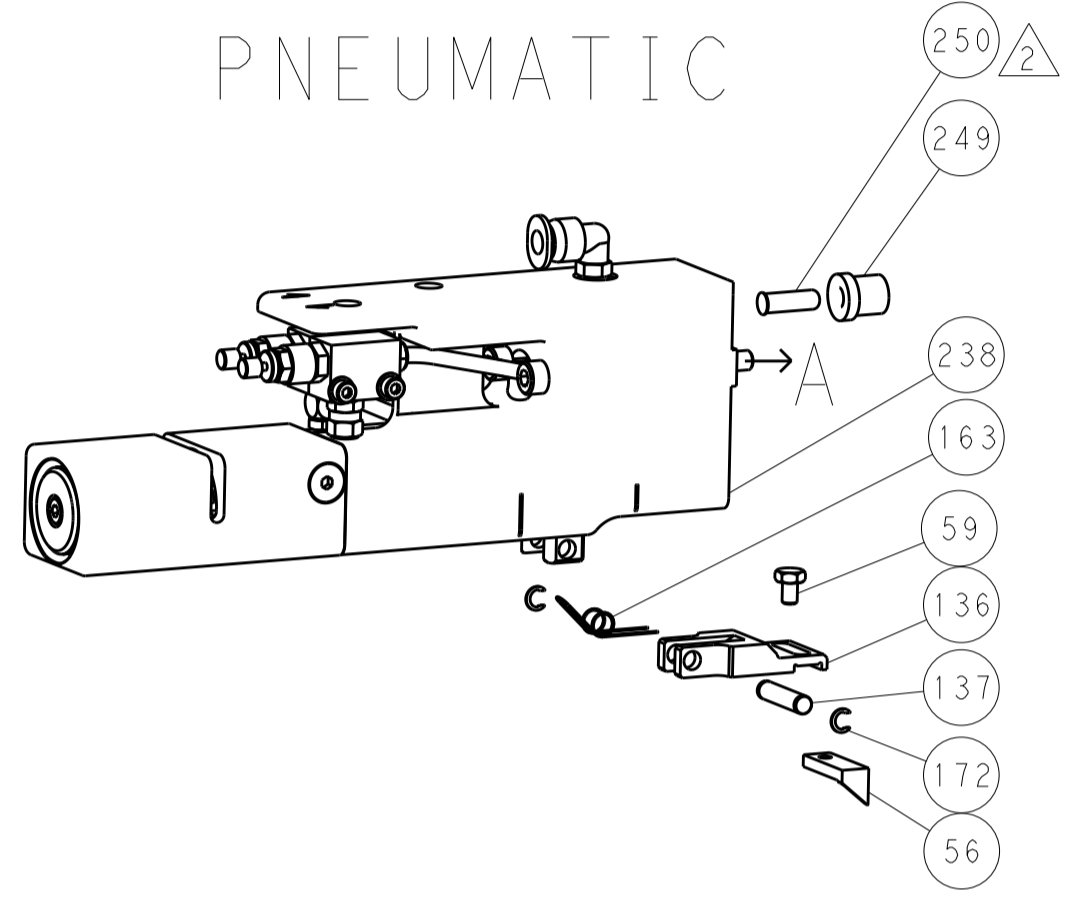
Customer Accessible Production Drawing form. Includes fields for DIMENSIONS, TOLERANCES UNLESS OTHERWISE SPECIFIED, MATERIAL, FINISH, WEIGHT, SCALE 1:1, SHEET 1 OF 4, REV A.

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

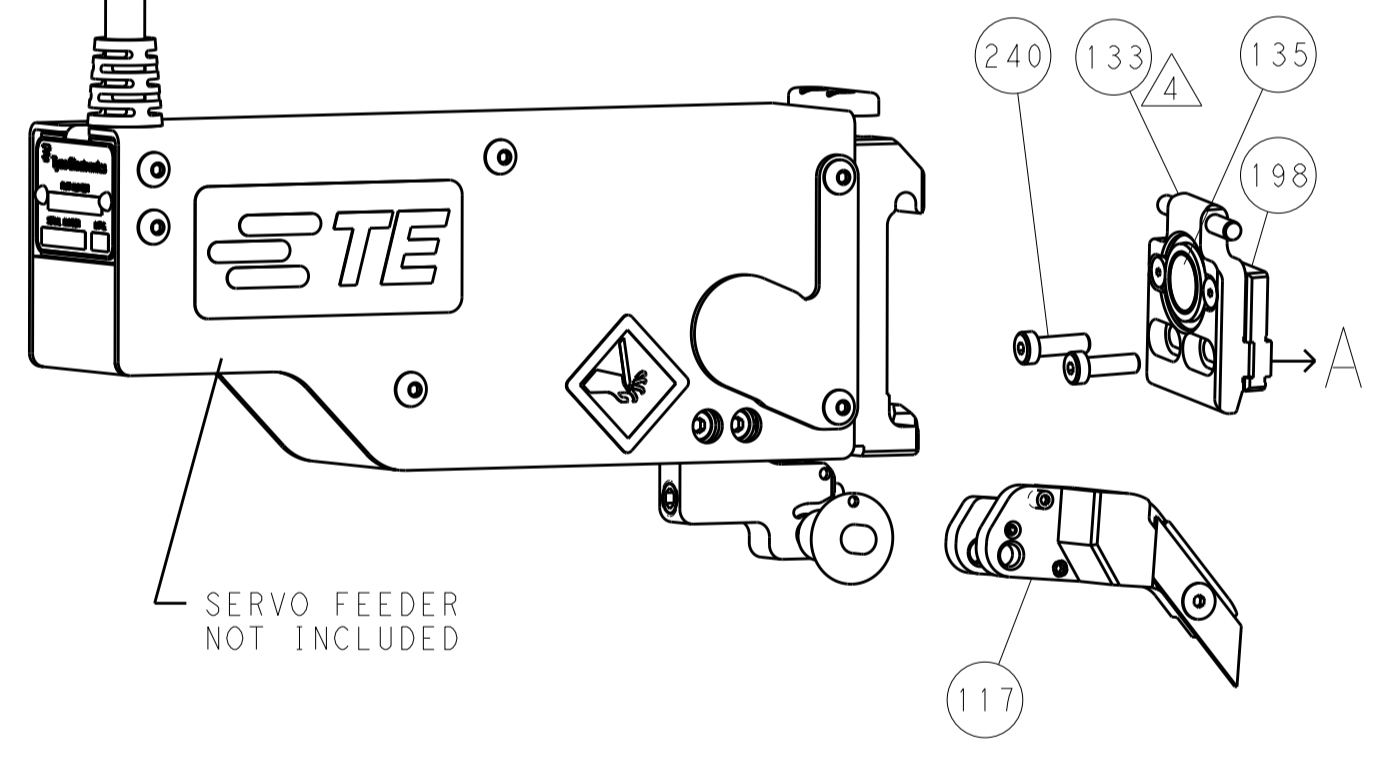
FEED TYPE MECHANICAL



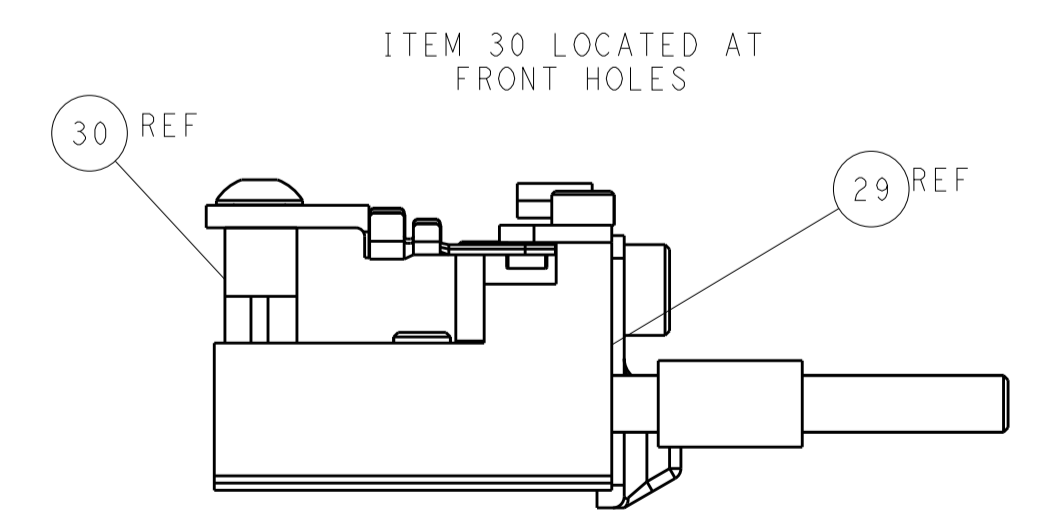
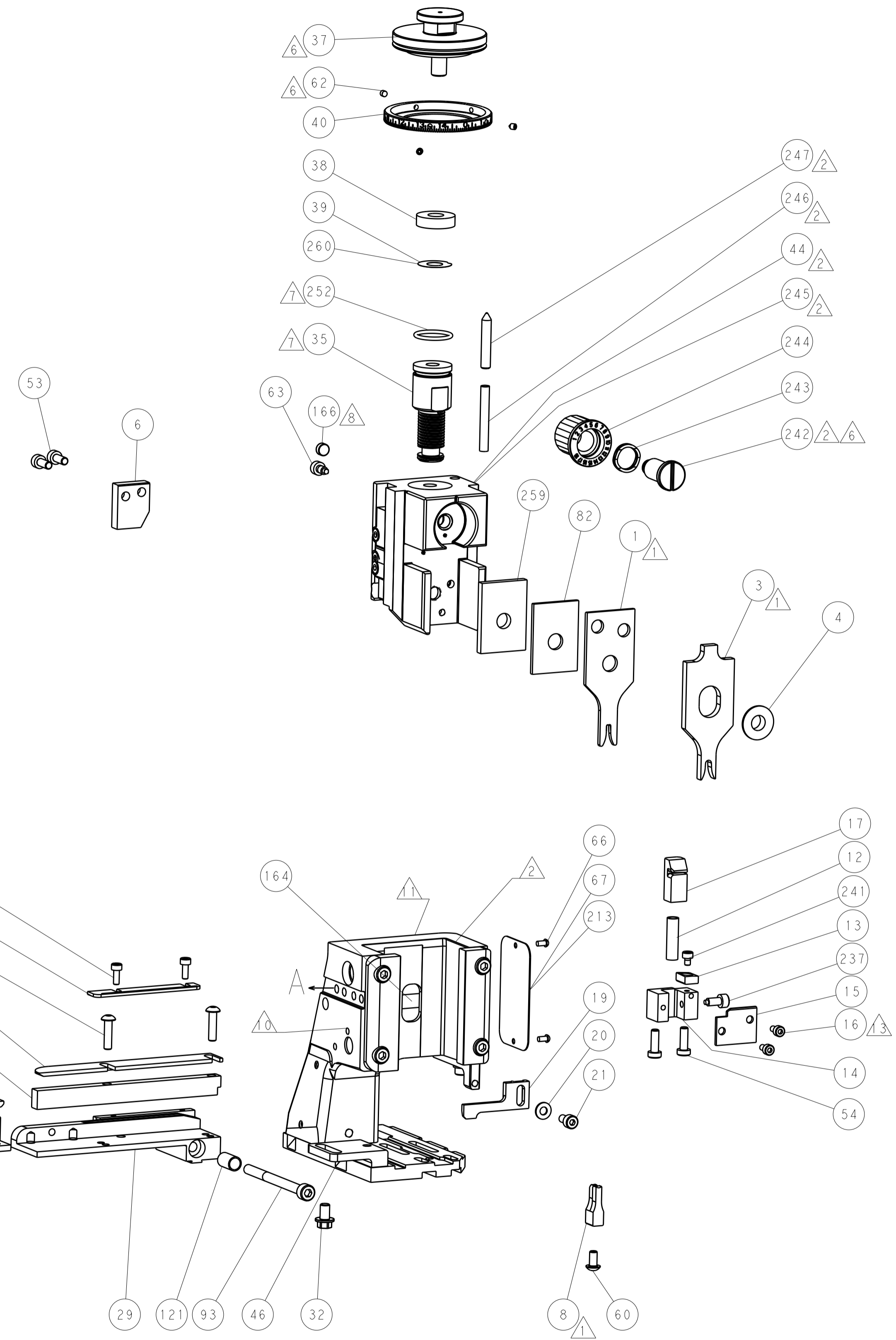
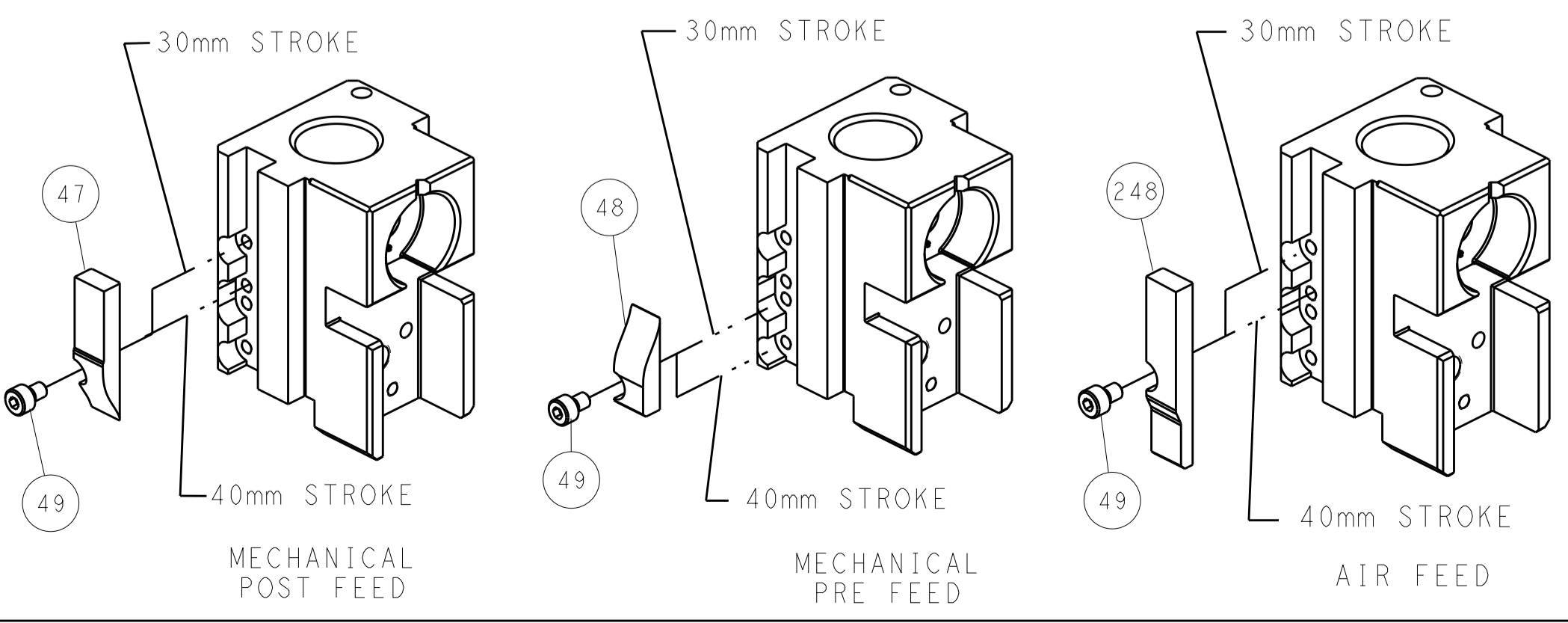
PNEUMATIC



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 R. O. WILSON 02APR2013		TE Connectivity	
mm	0 PLC ±0.1	1 PLC ±0.1	2 PLC ±0.02	3 PLC ±0.005	4 PLC ±0.0005	APVD T. J. ELBIN 12APR2013	Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		NAME Ocean Side Feed Applicator		RESTRICTED TO	
				SIZE CAGE CODE DRAWING NO. A1 00779 ©=2151917		SCALE 1:1 SHEET 2 OF 4 REV A	

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART							
					CONVERT TO	PART NUMBERS REQUIRED						
	2-2151917-1	A	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	1901092-1	8-2151917-5	1901094-3	-	2168400-6 (QUANTITY 2)	
	2-2151917-2	A	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-	
					SERVO LATCH PLATE	2119951-1	1901092-1	8-2151917-5	1901094-3	-	2168400-6 (QUANTITY 2)	
2-2151917-5	A	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE ⁴	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-		
2-2151917-7	A	FINE CRIMP HEIGHT ADJUST	NONE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1		
7-2151917-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-		

CRIMP WIRE	SIZE	TYPE
	.091 [2.31 mm]	F
INSUL	.140 [3.56 mm]	F

APPLICATOR INSTRUCTIONS
408-10389

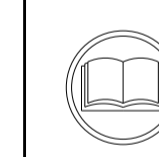
TERMINAL DATA: ETCO TERMINAL TE CRIMP SPECIFICATION

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
.109-.124 IN [2.77-3.15 mm]	∅.060-.075 IN [1.52-1.91 mm]

TERMINAL APPLICATION SPECIFICATION: NONE

TE TERMINAL	ETCO TERMINAL	TE TERMINAL	ETCO TERMINAL
1949601-1	R16-4-THB	1949601-7	R16-2-NPS
1949601-2	R16-4-HB	1949601-8	R16-099-HB
1949601-3	R16-4-NPS	1949601-9	R16-066-HB
1949601-4	R16-125-HB	1-1949601-0	R16-6-THB
1949601-5	R16-2-THB	1-1949601-1	R16-6-HB
1949601-6	R16-2-HB	-	-

WIRE SIZE	CRIMP HEIGHT INCH [mm]	CRIMP HEIGHT REFERENCE SETTING
20 AWG	0.061+/-0.002 [1.55+/-0.05]	6.2
22 AWG	0.058+/-0.002 [1.47+/-0.05]	6.8
24 AWG	0.056+/-0.002 [1.42+/-0.05]	7.3



- 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: 8-2151917-4
 - PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151917-4
 - SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151917-5
- 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 & 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.
- CUT TO LENGTH 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.

-	1	1	1	1	1803078-3	SPACER, PRECISION	259
-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-9	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
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

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

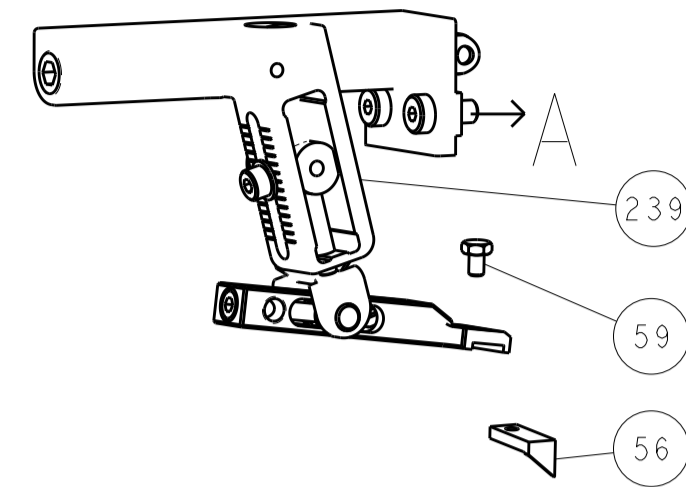
SET UP GAUGE 2119599-1		LOC A	DIST 66	REVISIONS			
P	LTM	DESCRIPTION	DATE	OWN	APVD		
-	-	SEE SHEET 1					
-	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0		241
-	-	2	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16		240
-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY		239
-	-	-	1	2063440-1	AIR FEED MODULE		238
-	1	1	1	356885-4	STOP, SHEAR		237
-	-	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	994969-1	MAGNET, RARE EARTH HIGH ENERGY		166
-	REF	REF	REF	994970-2	COUNTER, MAGNETIC		164
-	-	-	1	240638-1	SPRING, FEED FINGER		163
-	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	2119798-2	DETENT PIN		145
-	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)		144
-	2	2	2	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20		143
-	-	-	-	2119653-2	FEED CAM, POST FEED		142
-	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF		141
-	1	1	1	2161312-1	RAM, STEPPED, ASIAN STYLE, SIDE FEED		140
-	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	1-22281-8	SPRING, COMPRESSION		121
-	-	1	-	1901092-1	FEED FINGER ASSEMBLY, SF		117
-	1	1	1	1-690438-0	FRONT STRIP GUIDE		96
-	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0		95
-	1	1	1	2168083-6	SCR, SKT HD CAP, RoHS, M5 X 65		93
-	1	1	1	1-455888-8	SPACER, CRIMPER		82
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE		71
-	1	-	1	2119740-1	TAG, IDENTIFICATION		67
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188		66
-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT		63
-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 X 4.0		62
-	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0		61
-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0		59
-	-	-	1	1338683-2	FEED PAWL		56
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10		53
-	-	-	1	18023-9	SCR, SKT HD CAP M4 X 6.0		49
-	-	-	-	2119652-1	FEED CAM, PRE FEED		48
-	1	1	1	1-2079383-5	SCR, BHSC, RoHS (M8 X 40)		41
-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT		40
-	1	1	1	2119957-1	APPLICATOR SHIM PACK		39
-	1	1	1	1-2119644-2	RAM WASHER, PRECISION		38
-	2	2	2	2079383-8	SCR, BHSC, RoHS (M4 X 16)		33
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 X 8mm LONG		32
-	1	1	1	1-1320908-6	SPACER, STRIP GUIDE		30
-	1	1	1	1803089-1	PLATE, REAR STRIP GUIDE		29
-	2	2	2	22283-1	SPRING, COMPRESSION		27
-	1	1	1	356885-1	LEVER, DRAG RELEASE		26
-	1	1	1	240792-1	DRAG, TERMINAL		25
-	1	1	1	1633630-2	PLATE, STRIP GUIDE		24
-	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0		23
-	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0		21
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4		20
-	1	1	1	2119533-1	STRIPPER, SIDE FEED		19
-	1	1	1	690463-1	FLOATING SHEAR, REAR		17
-	2	2	2	1-2168083-1	SCR, SKT HD CAP, RoHS, M3 X 6		16
-	1	1	1	690464-4	SHEAR PLATE, REAR		15
-	1	1	1	2119862-1	SHEAR HOLDER, REAR		14
-	1	1	1	2119806-1	INSERT, SHEAR		13
-	1	1	1	3-22280-3	SPRING, COMPRESSION		12
-	-	-	-	-	-		10
-	-	-	-	-	-		9
-	1	1	1	1	4-1633927-2	ANVIL, COMBINATION	8
-	-	-	-	-	-		7
-	1	1	1	1	690468-1	DEPRESSOR SHEAR, REAR	6
-	-	-	-	-	-		5
-	1	1	1	1	3-238009-9	BLOCK, FL CRIMPER SPACER	4
-	1	1	1	1	3-2119784-9	CRIMPER, INSULATION O PREMIUM	3
-	-	-	-	-	-		2
-	1	1	1	1	1633609-5	CRIMPER, WIRE	1
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		OWN R.O. WILSON 02APR2013	TE Connectivity Harrisburg, PA 17105-3608
mm		0 PLC ±.1		CHK K.J. STAKEM 12APR2013	NAME Ocean Side Feed Applicator
		1 PLC ±0.1		APVD T.L. ELBIN 12APR2013	SIZE CASE CODE DRAWING NO A 00779 C=2151917
		2 PLC ±0.02		RESTRICTED TO	
		3 PLC ±0.005			
		4 PLC ±0.0005		Customer Accessible Production Drawing	
MATERIAL		FINISH		SCALE 1:1 SHEET 3 of 4 REV A	

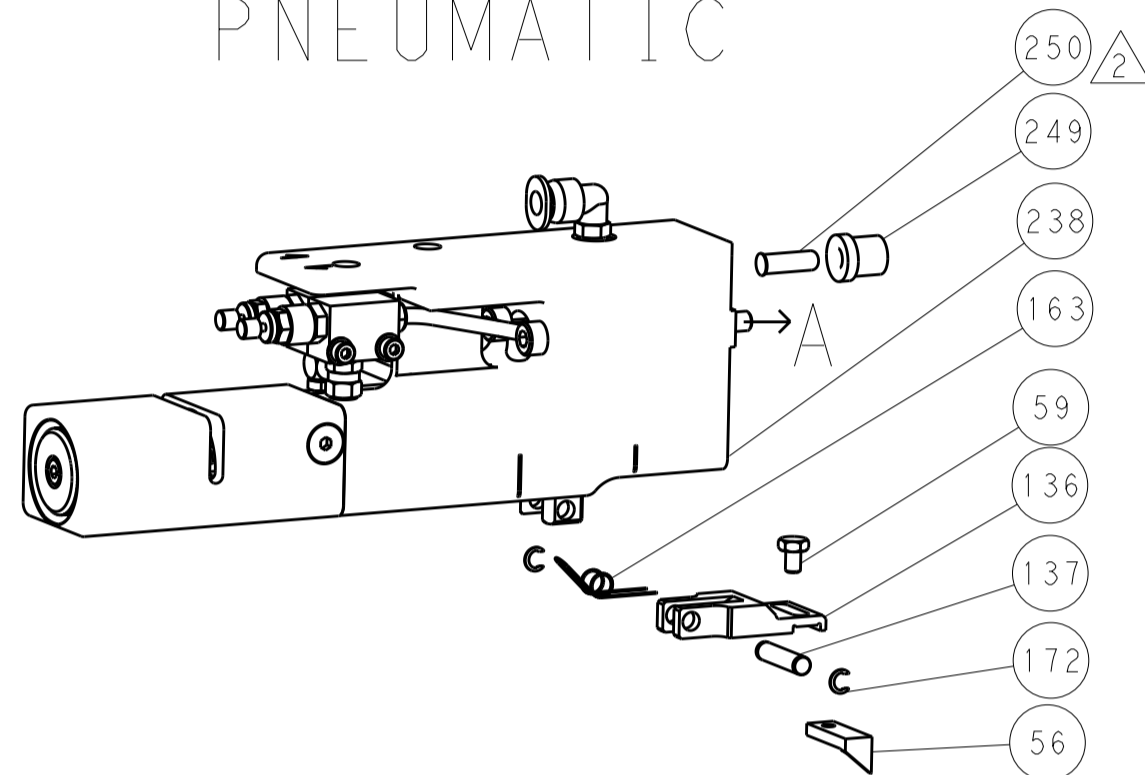
LOC		DIST		REVISIONS			
A	66	P	LTM	DESCRIPTION	DATE	DWN	APVD
		-	-	SEE SHEET 1	-	-	-

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

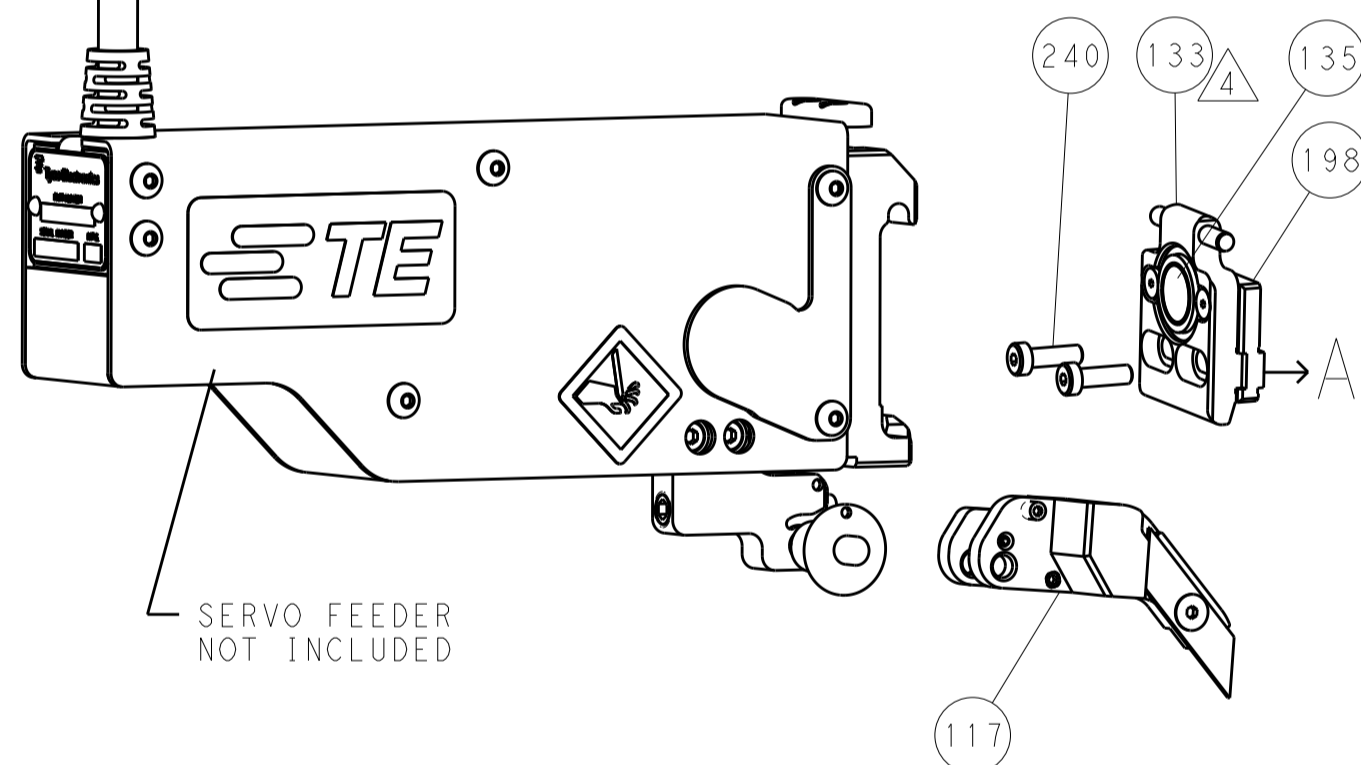
FEED TYPE MECHANICAL



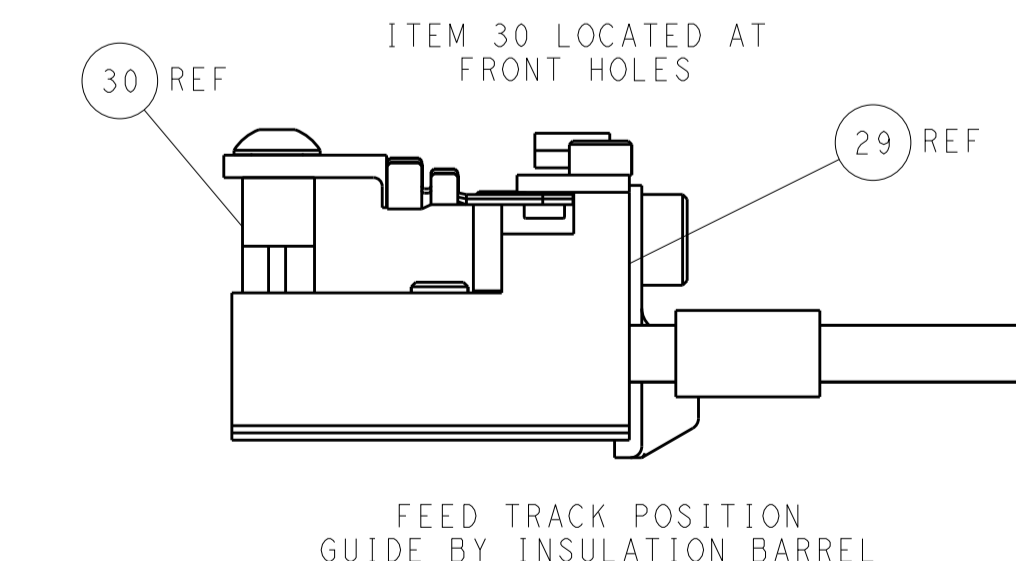
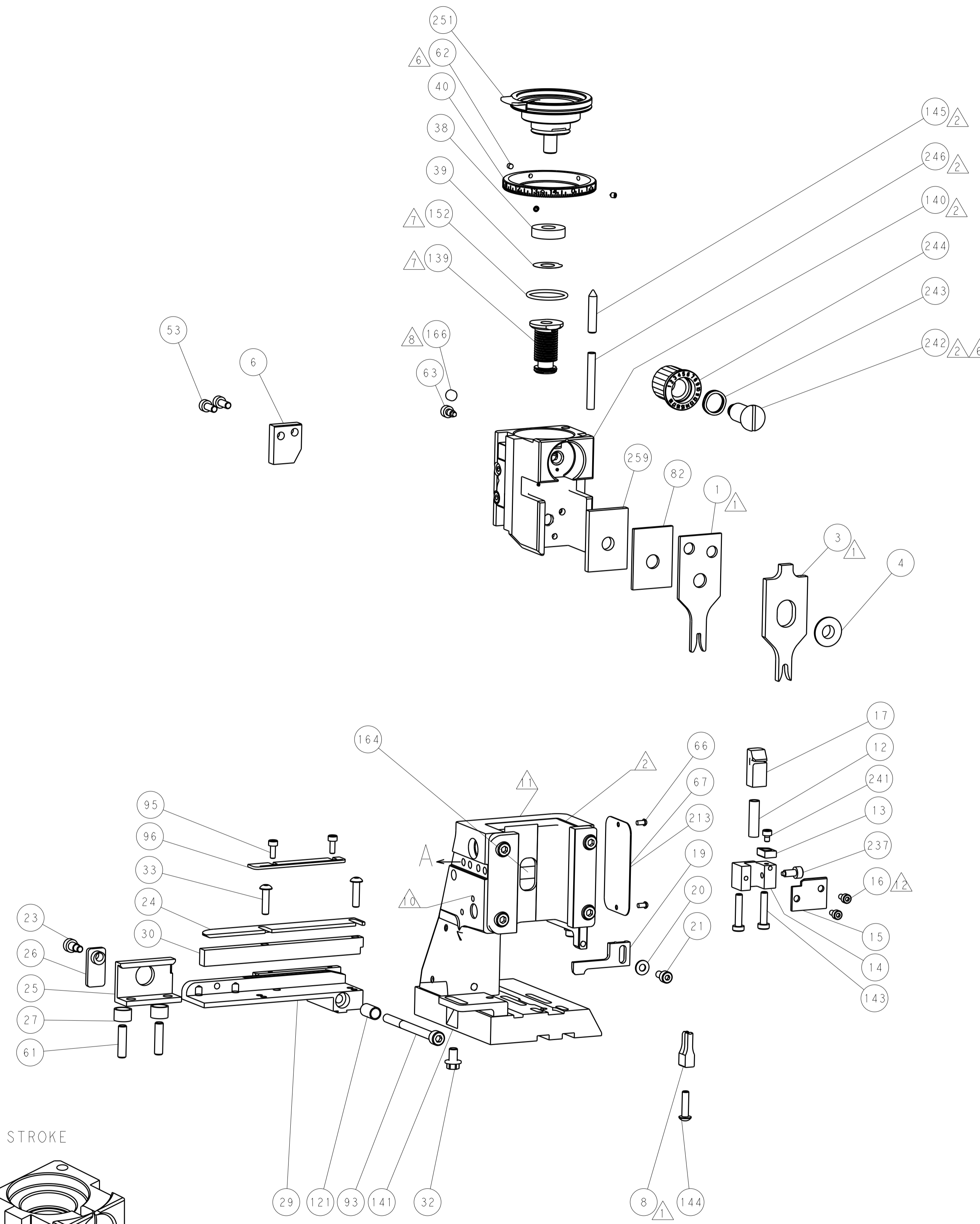
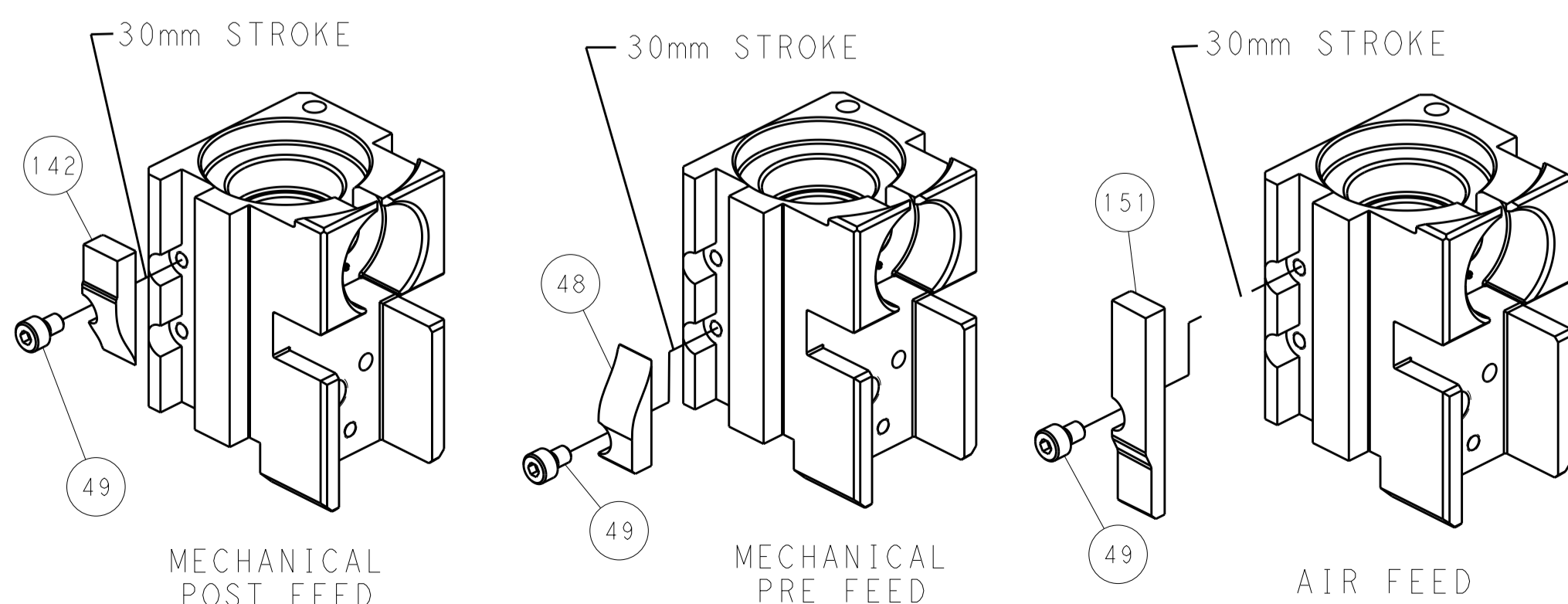
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±0.1 1 PLC ±0.1 2 PLC ±0.02 3 PLC ±0.005 4 PLC ±0.0005 ANGLES ±	FINISH:	PRODUCT SPEC: APPLICATION SPEC: WEIGHT:	SIZE: CAGE CODE DRAWING NO. RESTRICTED TO: A1 00779 C=2151917 Customer Accessible Production Drawing SCALE 1:1 SHEET 4 OF 4 REV A