

8

7

6

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4

3

2

1

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RELEASED FOR PUBLICATION

20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

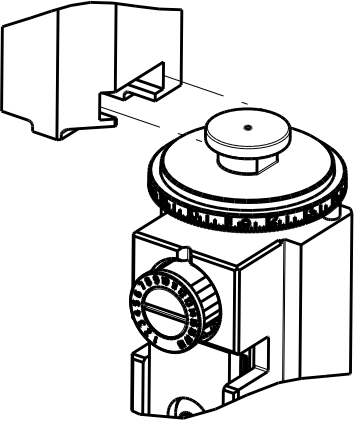
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151613-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

5-18022-5

2119641-1

2119799-1

2063440-1

2151613-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

5-18022-5

2119653-1

-

2168400-6 (QUANTITY 2)

2151613-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

1338685-1

5-18022-5

2119653-1

2119641-1

2119799-1

2063440-1

2151613-6

A

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹²

-

-

-

-

-

-

-

2151613-7

A

FINE CRIMP HEIGHT ADJUST

NONE

-

-

-

-

-

-

-

7-2151613-7

A

CRIMP TOOLING KIT

-

-

-

-

-

-

-

APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

1.91 mm [.075]

F

INSUL

2.79 mm [.110]

OV

APPLICATOR INSTRUCTIONS

408-10389



TERMINAL DATA: KOSTAL TERMINAL KOSTAL CRIMP SPECIFICATION

TERMINAL NAME: KOSTAL SLK 2.8 PIN/RECEPTACAL

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.00-4.60 mm [.157-.181 IN]

Ø1.40-2.00 mm [.055-.079 IN]

TERMINAL APPLICATION SPECIFICATION

KOSTAL SPECIFICATION

TERMINALS APPLIED

TE TERMINAL

KOSTAL TERMINAL

TE TERMINAL

KOSTAL TERMINAL

1572790-1

10124499090

1572789-1

22140472970

1572089-1

10140499090

1572789-2

22124472970

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



0.75mm2

1.32+/-0.03 [.052+/- .001]

4.4

0.50mm2

1.20+/-0.03 [.047+/- .001]

5.6



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: 8-2151613-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151613-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151613-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151613-6

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 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 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

13 CUT TO LENGTH AT ASSEMBLY.

AM 4805 REV 31MAR2000

-	-	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
-	-	-	-	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	2119082-9	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
-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)

SET UP GAUGE
2119599-1

LOC
A

DIST
66

REVISIONS

P

LTR

DESCRIPTION

DATE

DWN

APVD

A

RELEASED

09APR2012

KH

SX

A1

ECR-14-0011491

31JUL2014

XZ

TE

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1

1

18023-1

SCR, SKT HD CAP M3 X 5.0

241

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-

2

2

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-

2168400-6

SHCS, LOW HEAD, RoHS, M5 X 16

240

-

-

-

-

-

1

2119580-1

MECHANICAL FEED ASSEMBLY

239

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-

-

-

1

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2063440-1

AIR FEED MODULE

238

-

-

1

1

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-

2119740-2

TAG, IDENTIFICATION

213

-

-

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

-

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

-

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

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-

1633743-1

SERVO FEED LATCH ASM

133

-

1

1

1

1

1

1-22281-8

SPRING, COMPRESSION

121

-

1

1

1

1

1

1-18028-2

WASHER, FLAT, REG M4

119

-

-

REF

REF

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2119944-1

FEED FINGER ASSEMBLY, SF

117

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1

1

1

1

1

2168083-6

SCR, SKT HD CAP, RoHS, M5 X 65

93

-

1

1

1

1

1

455888-5

SPACER, CRIMPER

82

-

1

1

1

1

1

2119956-1

DOCUMENTATION PACKAGE

71

-

2

2

2

2

2

2168083-1

SCR, SKT HD CAP, RoHS, M3 X 8.0

69

-

1

1

1

1

1

2-690438-2

FRONT STRIP GUIDE

68

-

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

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

-

5

-

5

5

5

992763-5

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

62

-

2

2

2

2

2

2-18032-5

SCR, SET, FLT POINT M5 X 20.0

61

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2079383-4

SCR, BHSC, RoHS (M4 X 8)

60

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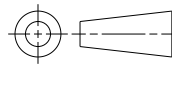
1

 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
-	2	2	2	2	2	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	53
-	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	1	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	1752356-5	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	1-1320908-0	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	1901086-1	PLATE, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	2	22281-8	SPRING, COMPRESSION	27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1	1320928-6	STRIP GUIDE	24
-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	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	454276-5	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1633138-4	ANVIL, COMBINATION	8
-	1	1	1	1	1	4-240641-1	SPACER	7
-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1-238011-7	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	1-2119785-0	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1	455888-6	SPACER, CRIMPER	2
1	1	1	1	1	1	1673600-6	CRIMPER, WIRE	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

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DIMENSIONS:

mm



TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±.5

1 PLC ±0.13

2 PLC ±0.13

3 PLC ±0.013

4 PLC ±0.0001

ANGLES ±.5

FINISH

MATERIAL

-

DWN
K. HUANG

15FEB2012

CHK
S. XI

15FEB2012

APVD
S. XI

15FEB2012

NAME
Ocean Side Feed
Applicator

SIZE
A1

CAGE CODE
00779

DRAWING NO
©=2151613

RESTRICTED TO
-

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

SCALE
1:2

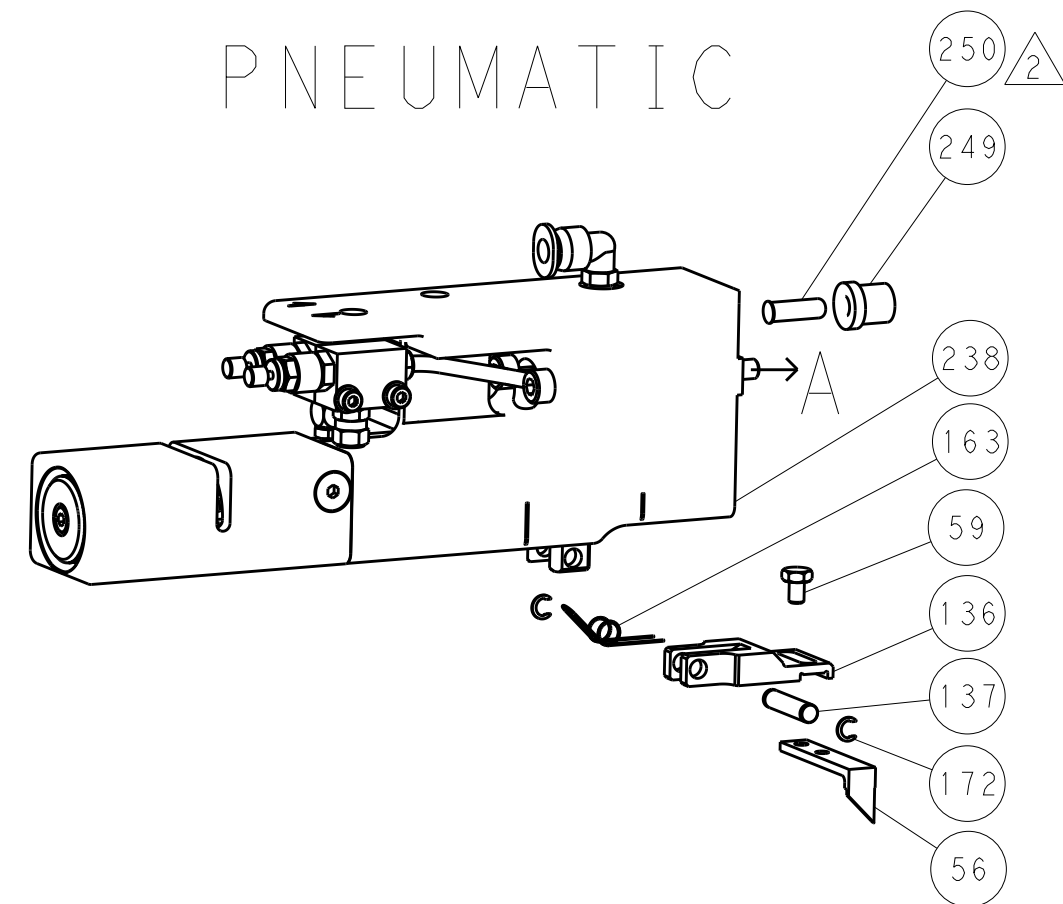
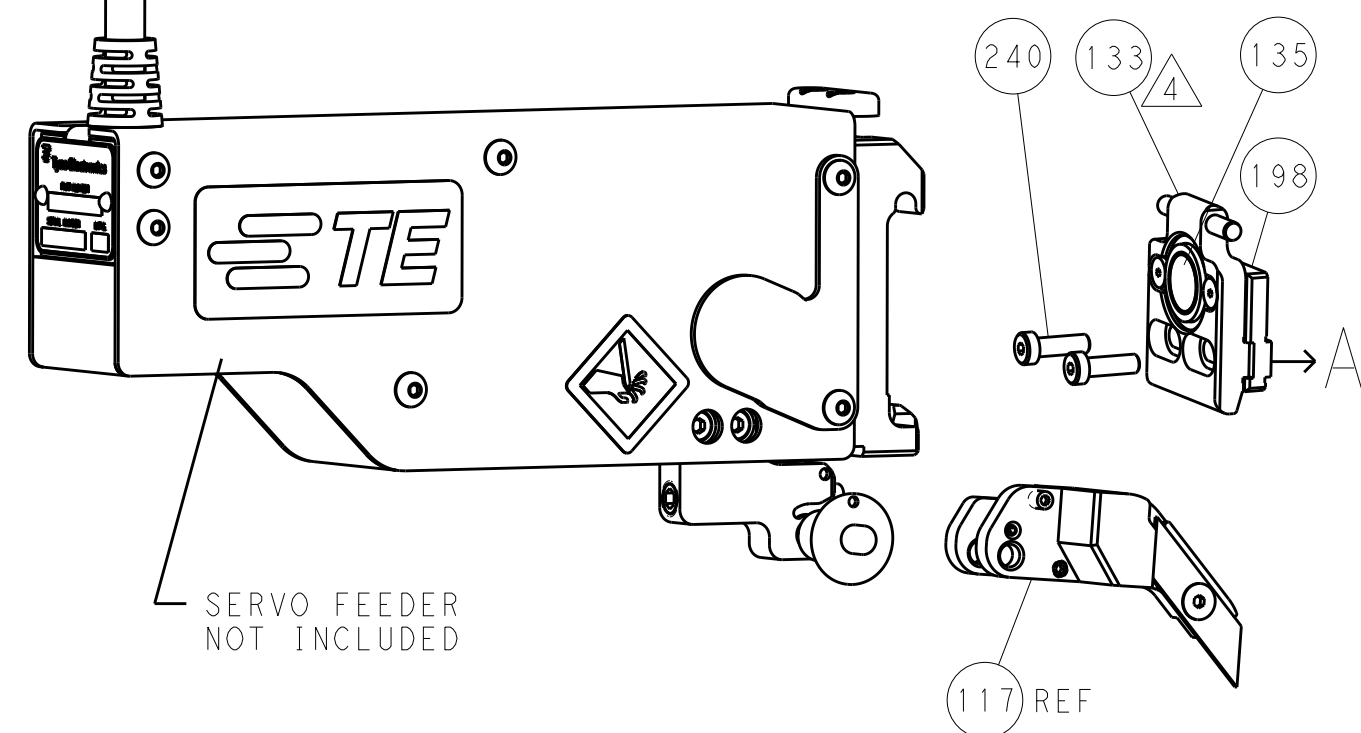
SHEET
1

OF
4

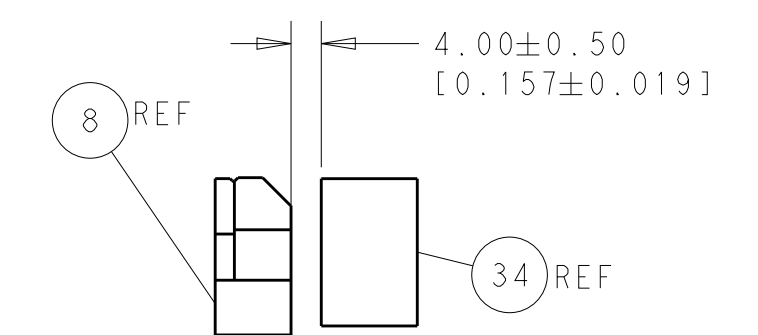
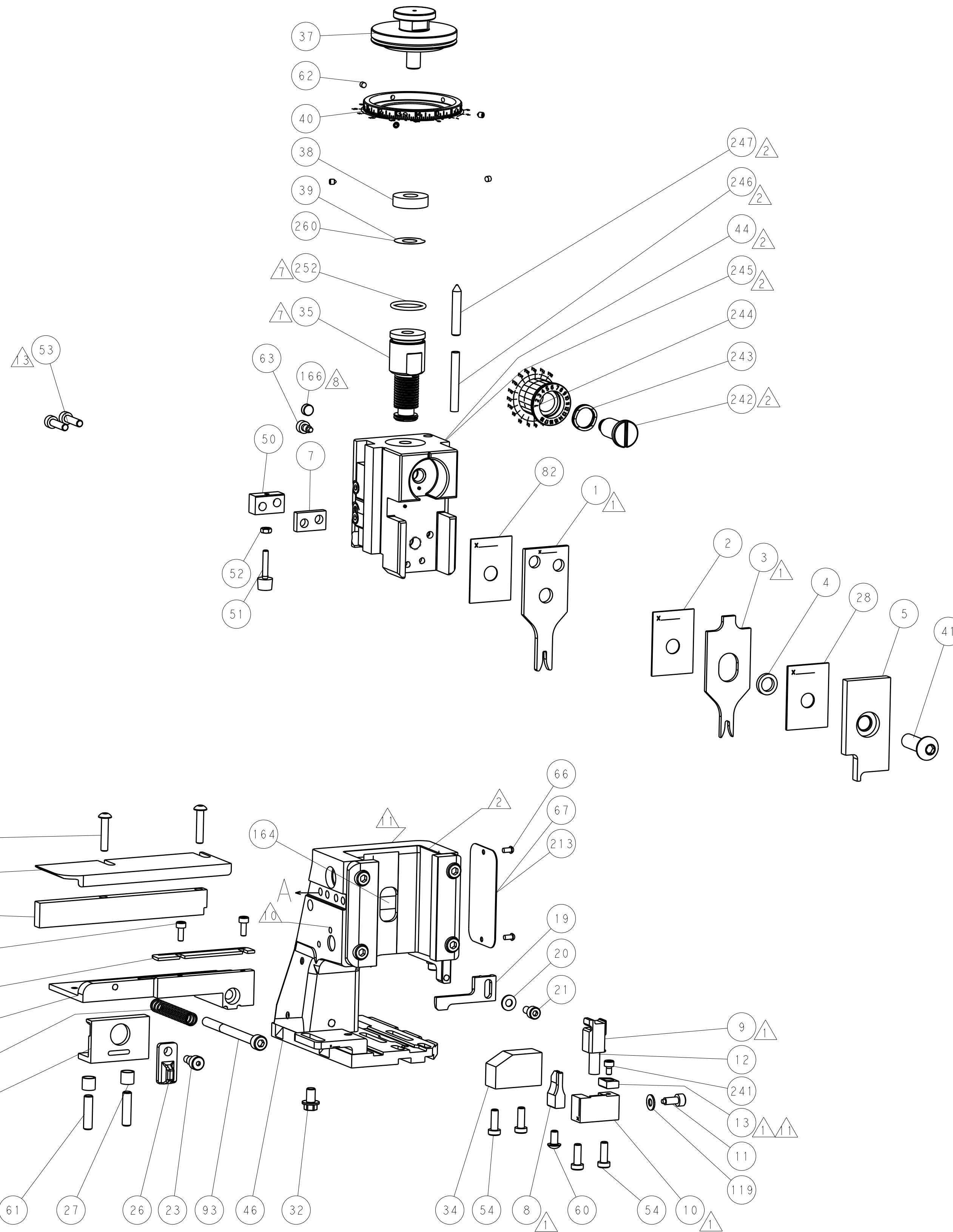
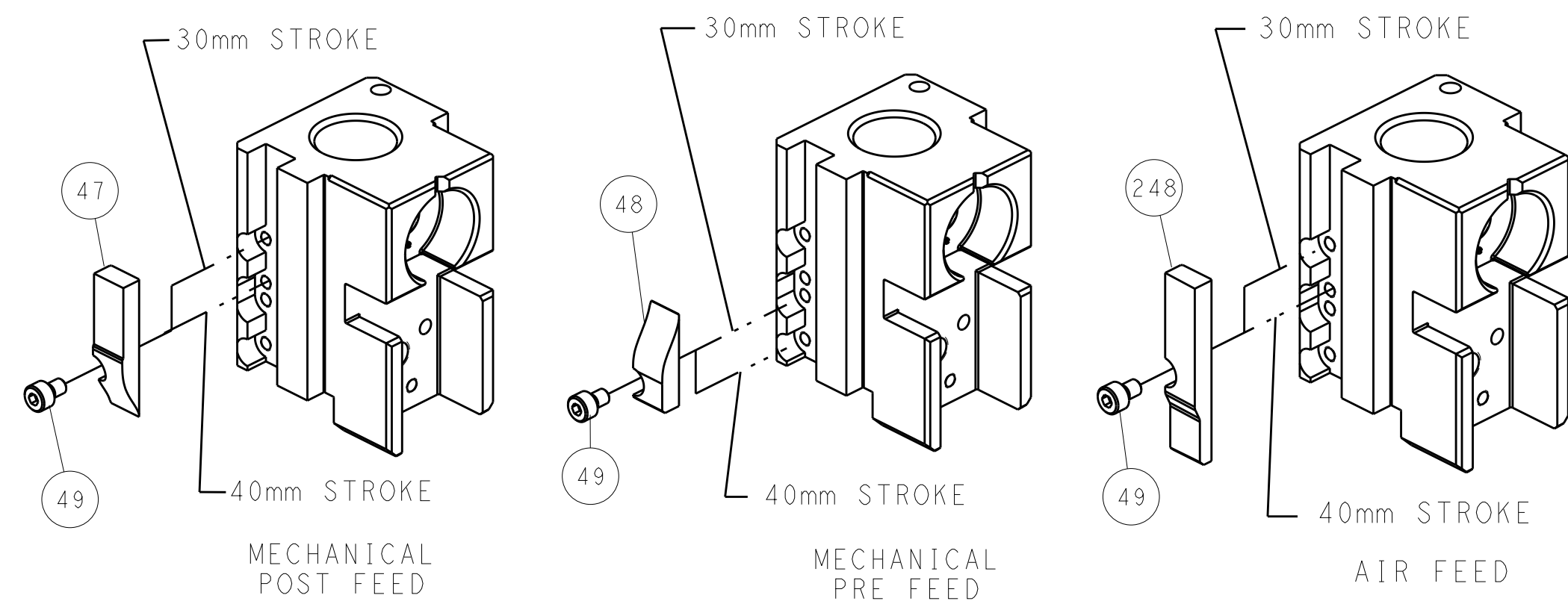
REV
A1

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

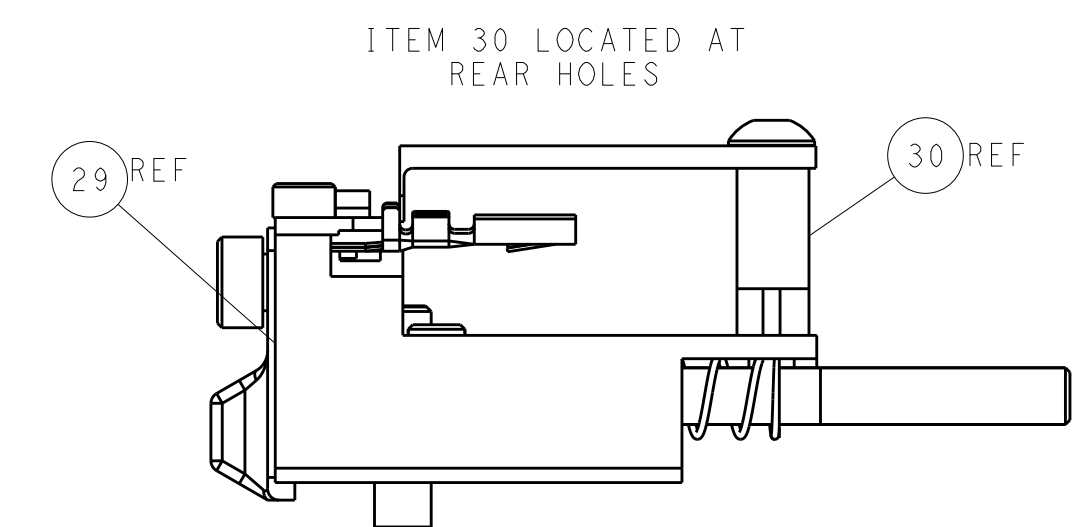
PNEUMATIC

SERVO
LATCH PLATE

CAM POSITIONS



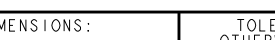
TERMINAL SUPPORT LOCATION



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)

THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION MAY BE REQUIRED TO MODIFY THIS DRAWING FOR THE TFCO DESIGN		DWN W. HUANG 15FEB2012 CHK S. XI 15FEB2012 APPV S. XI 15FEB2012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.01 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 ANGLES ±0.0001		NAME Ocean Side Feed Applicator -	
		PRODUCT SPEC -		SIZE A	
MATERIAL -		APPLICATION SPEC -		CASE CODE 00779	
FINISH -		WEIGHT -		DRAWING NO C=2151613	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING				SCALE 1:2 SHEET 2 of 4 REV A	

PNEUMATIC

250
249
238
163
59
136
137
172
56

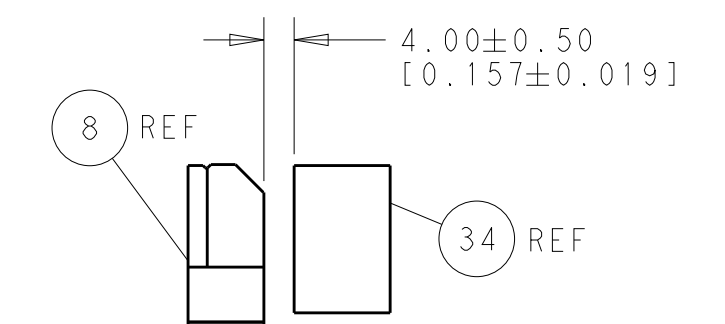
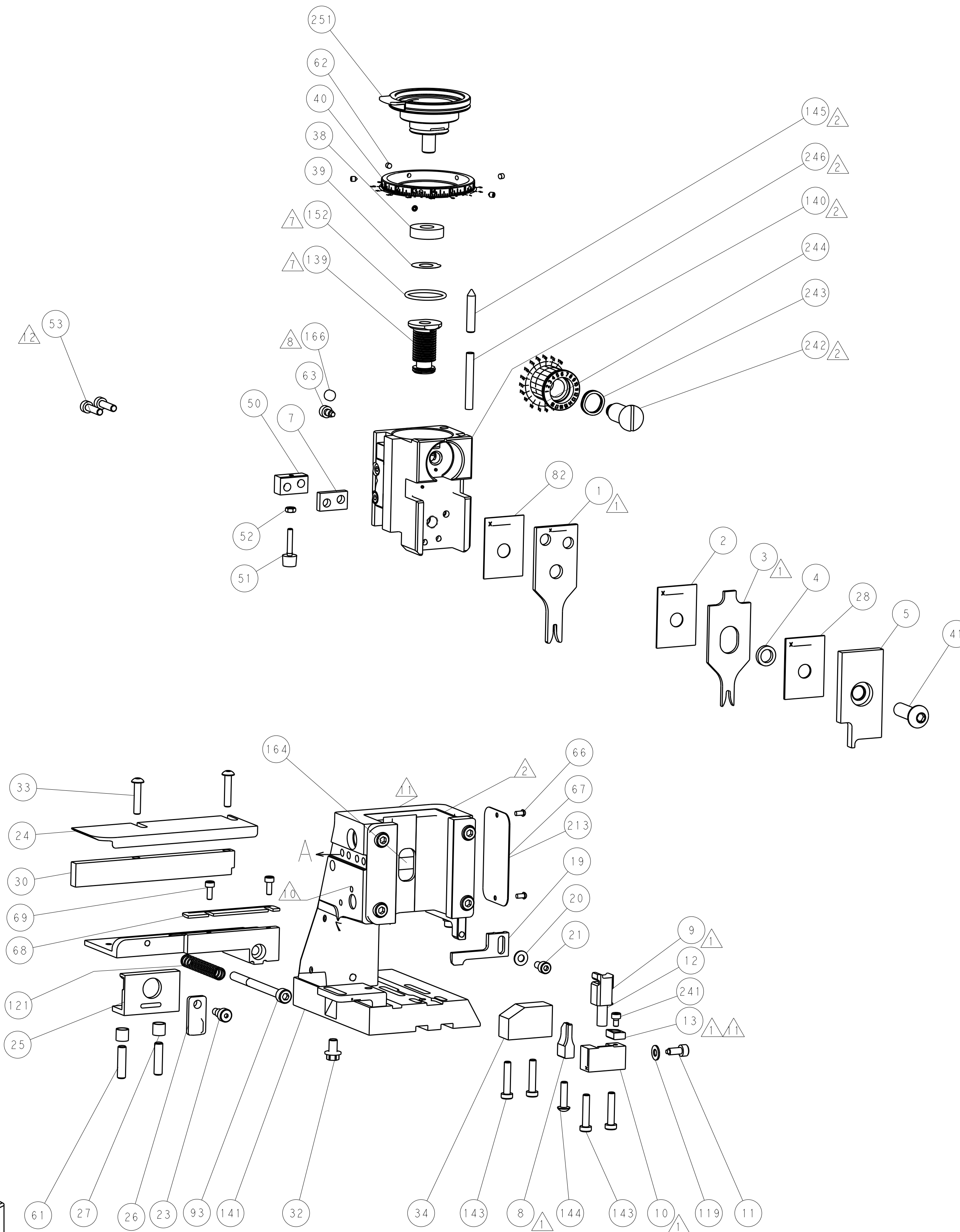
SERVO FEEDER
NOT INCLUDED

240 133 135 198

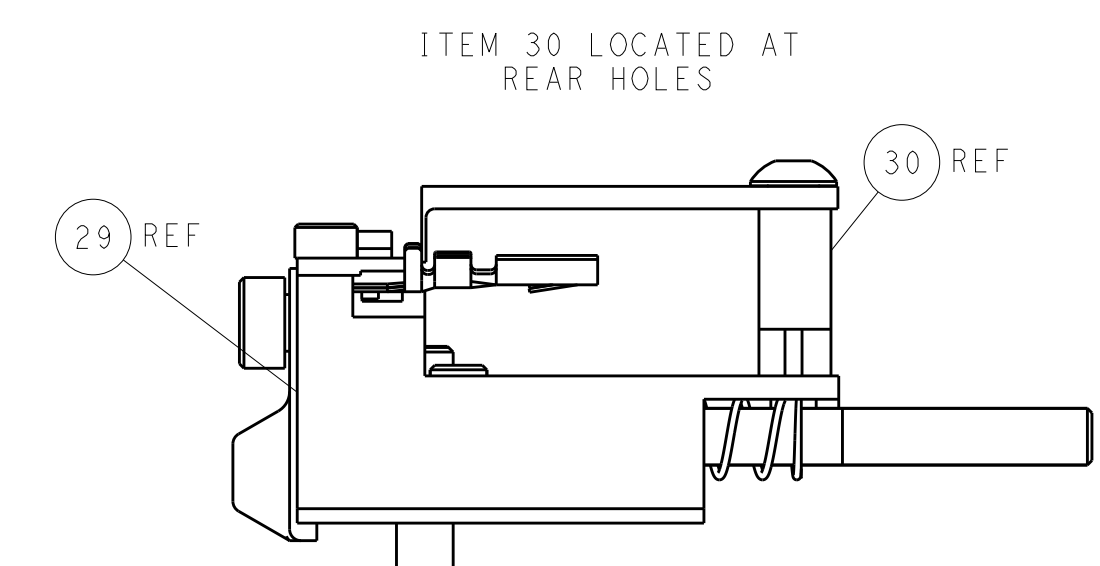
117 REF

The diagrams illustrate three types of mechanical feed systems:

- MECHANICAL POST FEED:** Shows a feed mechanism with a 30mm stroke and a 49mm distance from the tool tip to the feed point.
- MECHANICAL PRE FEED:** Shows a feed mechanism with a 30mm stroke and a 49mm distance from the tool tip to the feed point.
- AIR FEED:** Shows a feed mechanism with a 30mm stroke and a 49mm distance from the tool tip to the feed point.

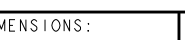


TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 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 MAKE ANY CHANGES WITHOUT THE USER'S REVIEW		DWN CHUANG 15FEB2012 CHK S.XI 15FEB2012 APPV S.XI 15FEB2012		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.1 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±.		NAME Ocean Side Feed Applicator -	
MATERIAL -		FINISH -		SIZE A 00779 C=2151613	
WEIGHT -		APPLICATION SPEC -		CAGE CODE -	
DRAWING NO -		RESTRICTED TO -		SCALE 1:2 SHEET A OF A REV A	
CUSTOMER ACCESSIBLE PRODUCTION DRAWING					

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION