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20

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

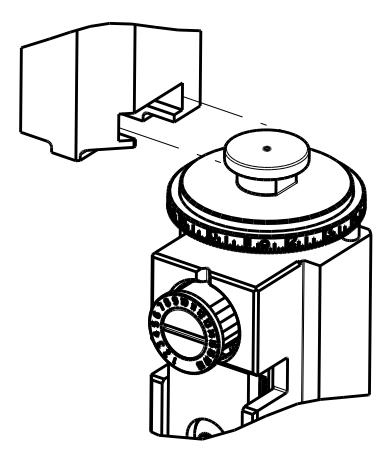
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151552-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151552-5

8-2151552-4

2119641-1

1901094-3

-

2119799-1

-

-

2063440-1

2168400-6 (QUANTITY 2)

-

2151552-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151552-5

8-2151552-4

2119653-1

1901094-3

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-

2151552-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

-

1338685-1

-

-

5-18022-5

5-18022-5

-

2119653-1

2119641-1

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2151552-6

A

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹¹

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2151552-7

A

FINE CRIMP HEIGHT ADJUST

NONE

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7-2151552-7

A

CRIMP TOOLING KIT

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.15 mm [.085]

F

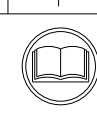
INSUL

2.29 mm [.090]

F

APPLICATOR INSTRUCTIONS

408-10389



TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: CONTACT, BOBBIN COIL ANTENNA

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.14-4.52 mm [.163-.178 IN]

Ø1.40-2.06 mm [.055-.081 IN]

TERMINAL APPLICATION SPECIFICATION

114-13013

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

1832379-5

1832379-6

-

-

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

18 AWG

1.37+/-0.05 [.054+/- .002]

4.6

20 AWG

1.21+/-0.05 [.048+/- .002]

6.6



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: 8-2151552-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151552-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151552-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151552-6

5

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

6

GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

7

MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

8

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.

9

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

10

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.

11

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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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

-

-

-

-

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

-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

OWN

APVD

1

DEVELOPMENT

06JAN2012

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XX

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RELEASED

06SEP2012

YY

XX

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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

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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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-

-

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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

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

-

3-23627-7

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

137

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1

-

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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2

2

2

2

2

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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2

2

2

2

2

1-2079383-0

SCR, BHSC, RoHS (M3 X 6)

101

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1633782-3

FENCE

100

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1-690438-0

FRONT STRIP GUIDE

96

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2

2

2

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2168083-1

SCR, SKT HD CAP, RoHS, M3 X 8.0

95

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455888-5

SPACER, CRIMPER

82

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2119956-1

DOCUMENTATION PACKAGE

71

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1

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2119740-1

TAG, IDENTIFICATION

67

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2

2

2

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2

2168078-1

SCREW, DRIVE, RH, RoHS

66

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1

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1

1

1

2119793-1

LIMITER, ADJUSTMENT BOLT

63

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3

-

3

3

3

992763-5

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

62

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2

2

2

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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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5-18022-5

SCR, HEX HD CAP, M4 X 6.0

59

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1

1338685-1

PAWL, FEED

56

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4

4

4

4

4

2168400-1

SHCS, LOW HEAD, RoHS, M4 X 12

54

-

2

2

2

2

2

2168083-3

SCR, SKT HD CAP, RoHS, M4 X 12.0

53

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1

1

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1

5018030-1

NUT, HEX, REG, RoHS, M3

52

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1

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1

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1

811242-5

BUMPER, HOLD DOWN

51

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1

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690753-2

SPACER, TONKER

50

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1

2

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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1

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2119370-1

RAM, AMP STYLE, SIDE FEED

44

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1

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2079383-7

SCR, BHSC, RoHS (M8 X 25)

41

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2

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2

2

2

2119645-1

DISC, NUMBERED FA WIRE ADJUSTMENT

40

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2

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2

2

2

2119957-1

APPLICATOR SHIM PACK

39

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2119644-1

RAM WASHER, PRECISION

38

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1

2119085-1

FA HEAD, ATLANTIC STYLE

37

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1

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2119092-1

BOLT, ADJUSTMENT

35

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1

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1

1752356-1

SUPPORT, TERMINAL

34

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2

2

2

2

2

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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1320908-3

SPACER, STRIP GUIDE

30

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2119959-3

ASSEMBLY, STRIP GUIDE

29

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1-455888-0

SPACER, CRIMPER

28

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2

2

2

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2

22283-1

SPRING, COMPRESSION

27

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1

1

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1

356835-1

LEVER, DRAG RELEASE

26

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240792-1

DRAG, TERMINAL

25

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1320928-2

STRIP GUIDE

24

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980371-4

SCR, SKT HD SHLDR 5.0 DIA X 6.0

23

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2168083-2

SCR, SKT HD CAP, RoHS, M4 X 8.0

21

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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

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1-356885-4

STOP, SHEAR

11

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1

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1

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2119805-1

SHEAR HOLDER, FRONT

10

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1

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462006-6

FLOATING SHEAR, FRONT

9

1

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5-1633620-4

ANVIL, COMBINATION

8

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5-240641-8

SPACER

7

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2119757-9

DEPRESSOR, SHEAR

5

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1-238011-8

BLOCK, CRIMPER SPACER

4

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3-2119582-7

CRIMPER, INSULATION F PREMIUM

3

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455888-8

SPACER, CRIMPER

2

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5-1633609-8

CRIMPER, WIRE

1

-77

-7

-6

-5

-2

-1

PART NO

DESCRIPTION

ITEM NO

THIS IS SUBJECT TO CHANGE WITHOUT NOTICE. THE CUSTOMER'S RESPONSIBILITY IS TO CONTACT THE MANUFACTURING ORGANIZATION TO VERIFY THE LATEST REVISIONS SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS:

mm

0 PLC ±.1

1 PLC ±0.1

2 PLC ±0.02

3 PLC ±0.005

4 PLC ±0.0005

ANGLES ±.1

FINISH

TOLERANCES UNLESS OTHERWISE SPECIFIED:

±.1

±0.1

±0.02

±0.005

±0.0005

±.1

MATERIAL

FINISH

Customer Accessible Production Drawing

SCALE

6:1

SHEET

1

OF

4

REV

A

DWN

T. YIN

06JAN2012

CHK

G. BAILEY

06JAN2012

APVD

S. XI

06JAN2012

NAME

Ocean Side Feed Applicator

SIZE

CAGE CODE

DRAWING NO

00779

©=2151552

RESTRICTED TO

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER

PART
NUMBER

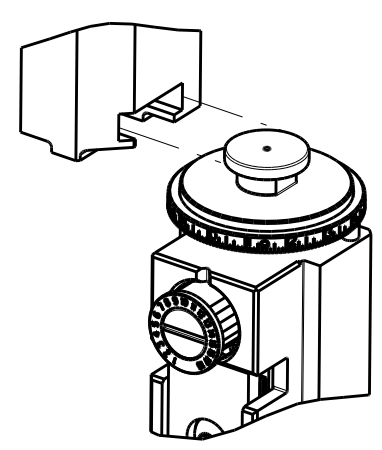
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151552-1

A

FINE CRIMP HEIGHT ADJUST

MECHANICAL

PNEUMATIC FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119950-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151552-5

8-2151552-4

2119641-1

1901094-3

-

2119799-1

-

-

2063440-1

2168400-6 (QUANTITY 2)

-

2151552-2

A

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

MECHANICAL FEED

SERVO LATCH PLATE

SMART APPLICATOR

2119949-1

2119951-1

2161326-1

1338685-1

-

-

5-18022-5

8-2151552-5

8-2151552-4

2119653-1

1901094-3

-

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-

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-

-

-

-

2151552-5

A

FINE CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴

MECHANICAL FEED

PNEUMATIC FEED

2119949-1

2119950-1

-

1338685-1

-

-

5-18022-5

5-18022-5

-

2119653-1

2119641-1

-

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2151552-6

A

NON-CRIMP HEIGHT ADJUST

SERVO
LATCH PLATE⁴¹¹

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2151552-7

A

FINE CRIMP HEIGHT ADJUST

NONE

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7-2151552-7

A

CRIMP TOOLING KIT

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APPLICATOR DATA

CRIMP

SIZE

TYPE

WIRE

2.15 mm [.085]

F

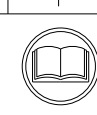
INSUL

2.29 mm [.090]

F

APPLICATOR INSTRUCTIONS

408-10389



TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: CONTACT, BOBBIN COIL ANTENNA

WIRE STRIP LENGTH

INSULATION DIAMETER RANGE

4.14-4.52 mm [.163-.178 IN]

Ø1.40-2.06 mm [.055-.081 IN]

TERMINAL APPLICATION SPECIFICATION

114-13013

-

-

TERMINALS APPLIED

TE TERMINAL

TE TERMINAL

TE TERMINAL

TE TERMINAL

1832379-5

1832379-6

-

-

WIRE SIZE

CRIMP HEIGHT mm [INCH]

CRIMP HEIGHT REFERENCE SETTING

18 AWG

1.37+/-0.05 [.054+/- .002]

4.6

20 AWG

1.21+/-0.05 [.048+/- .002]

6.6



1

RECOMMENDED SPARE PARTS

2

GREASE BEARING SURFACES LIGHTLY

3

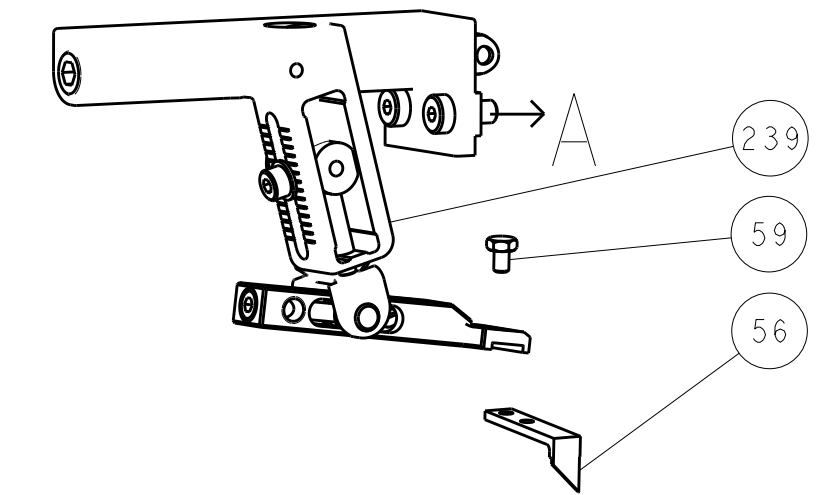
LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

4

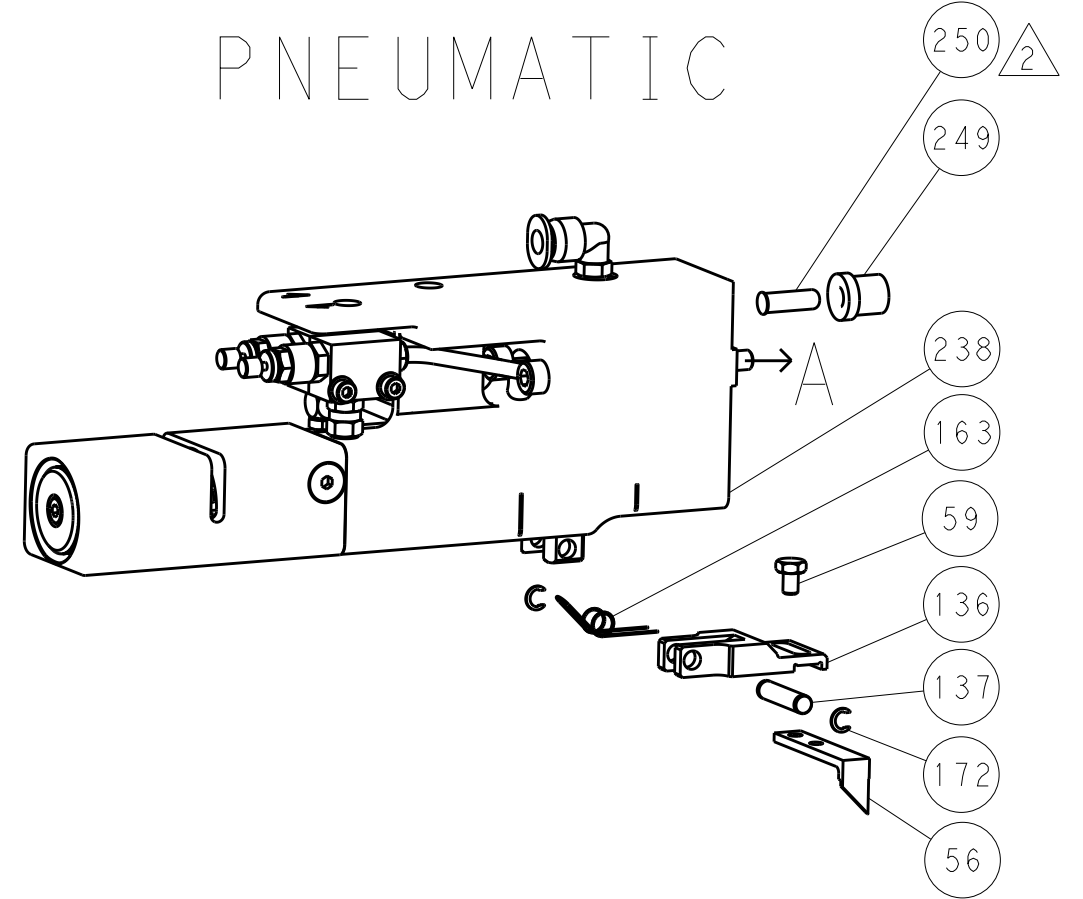
APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151552-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151552-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST":

DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

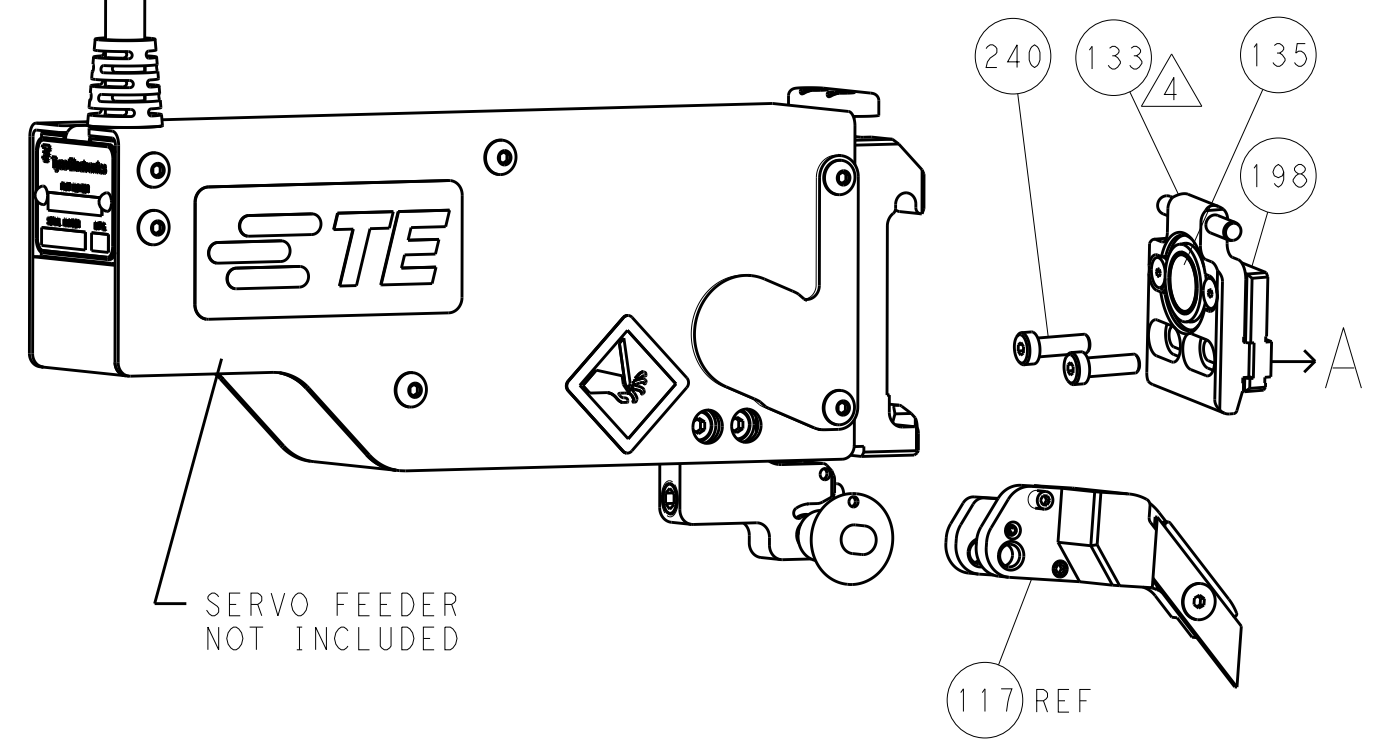
FEED TYPE MECHANICAL



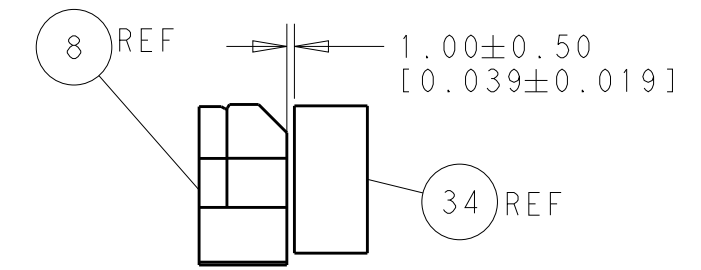
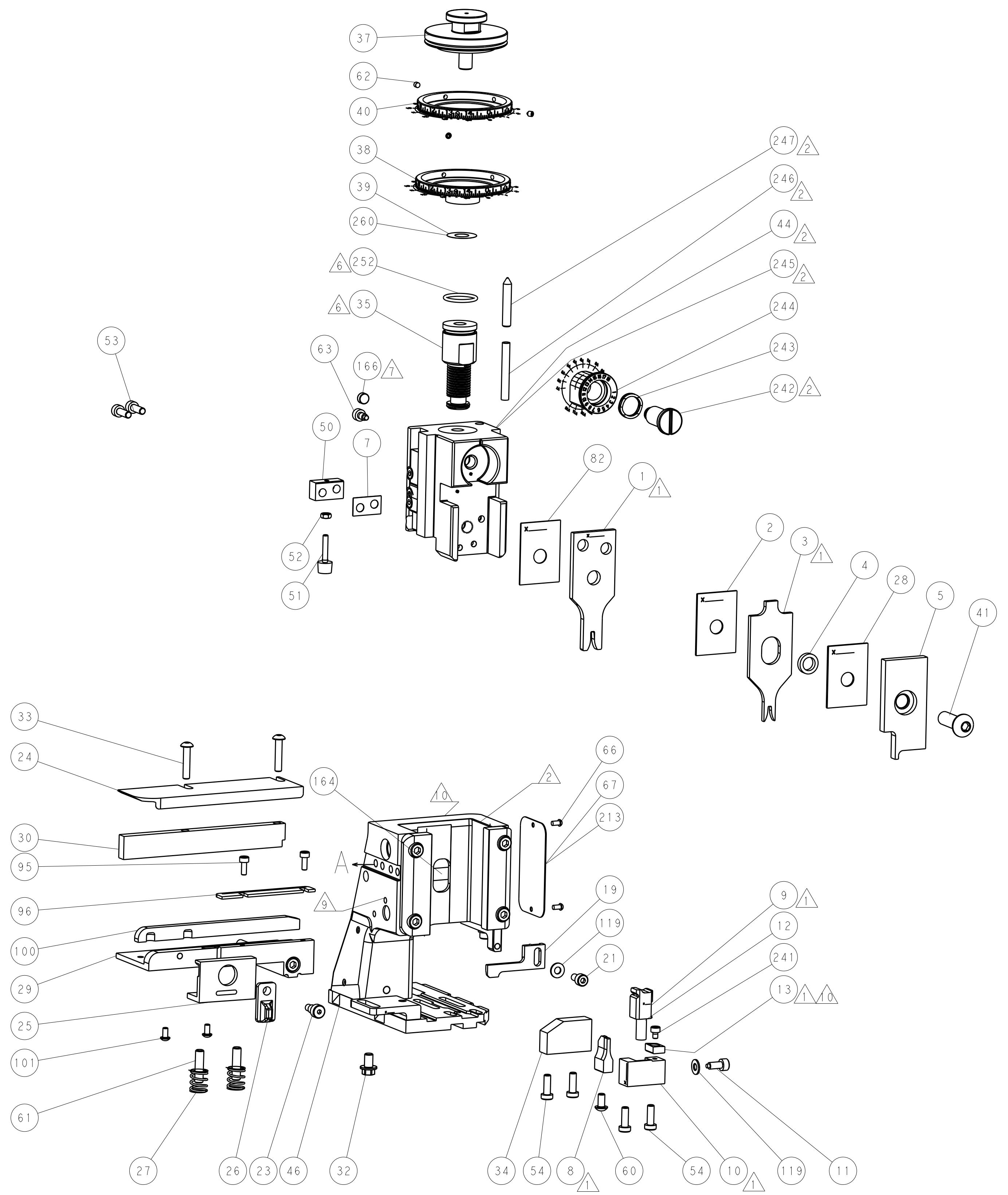
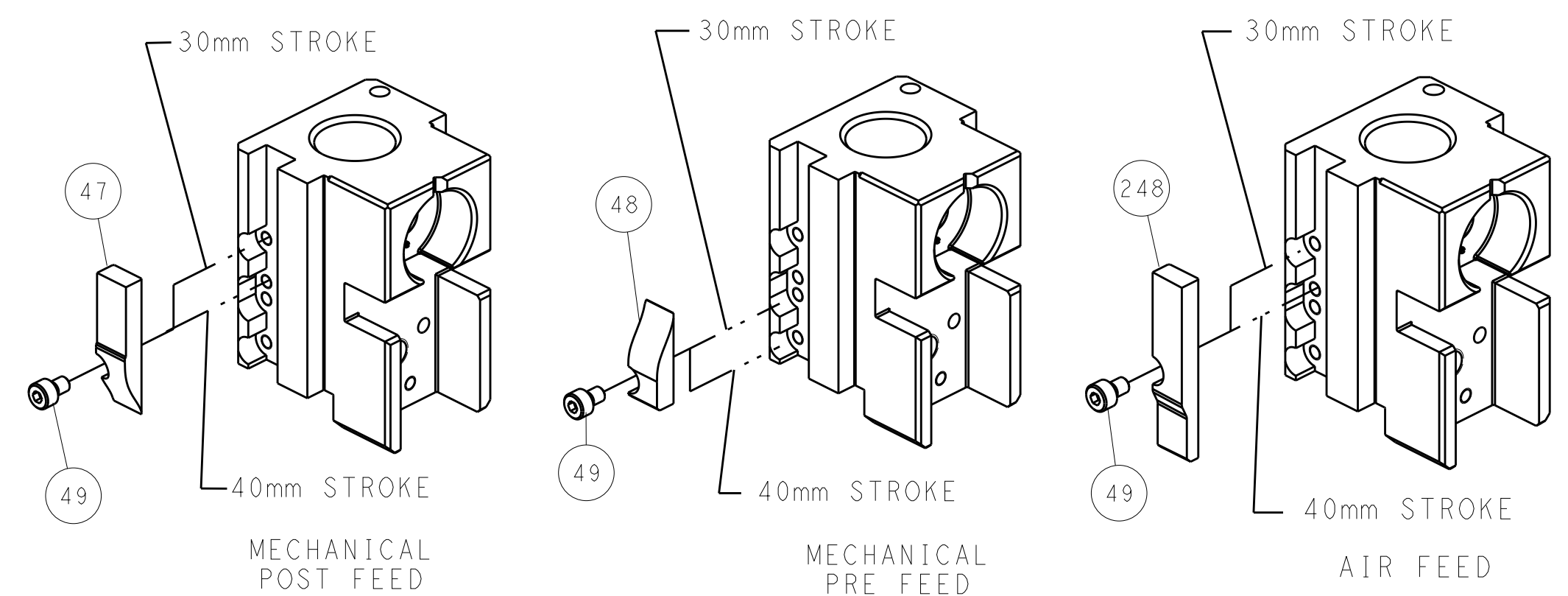
PNEUMATIC



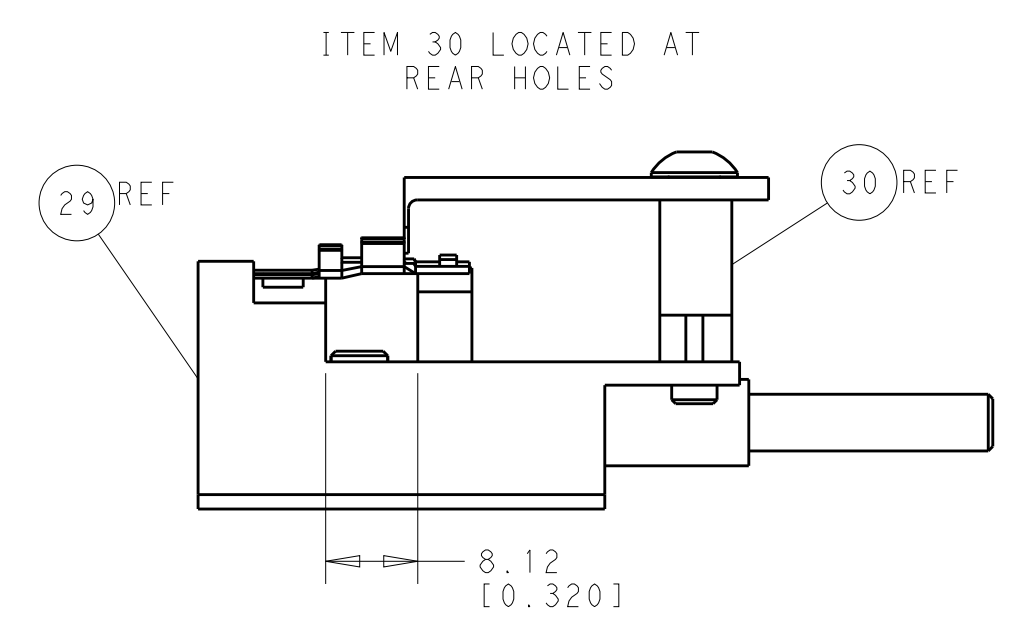
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



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)

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DIMENSIONS: mm		CHK G. BAILEY 06JAN2012	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 06JAN2012	SIZE A1 00779 C=2151552	
MATERIAL -		FINISH -	RESTRICTED TO -	
Customer Accessible Production Drawing		SCALE 6:1	SHEET 2 OF 4	REV A

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

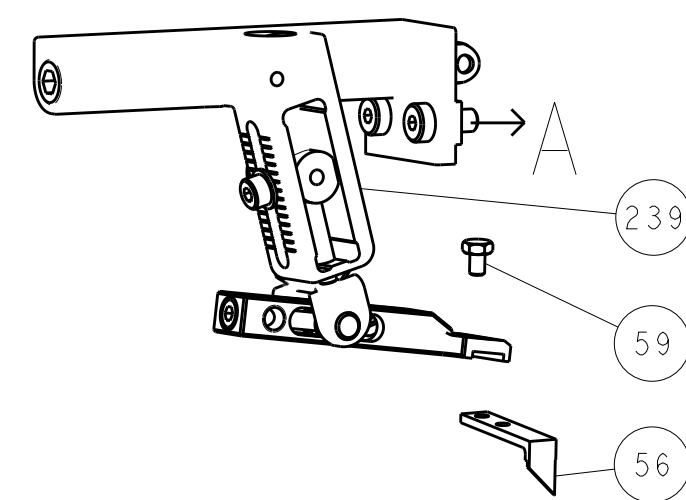
DIMENSIONING AND TOLERANCING PER ASME Y14.5M-2003

C

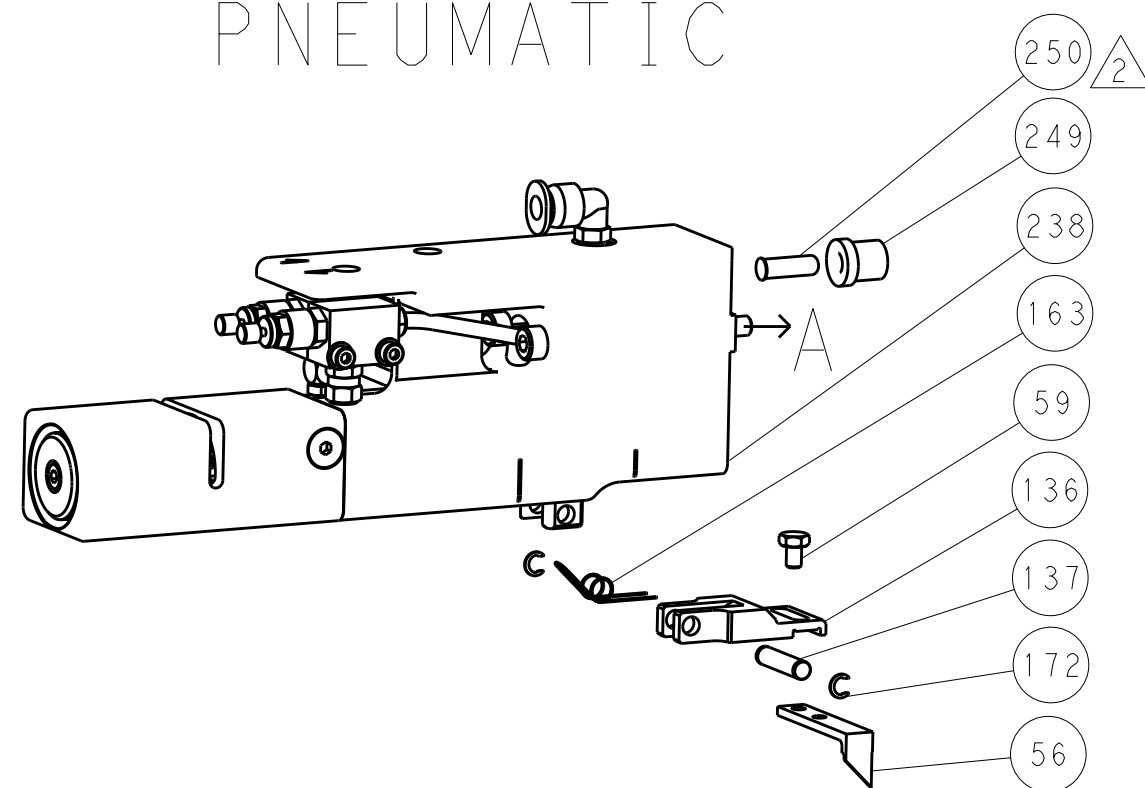
B

A

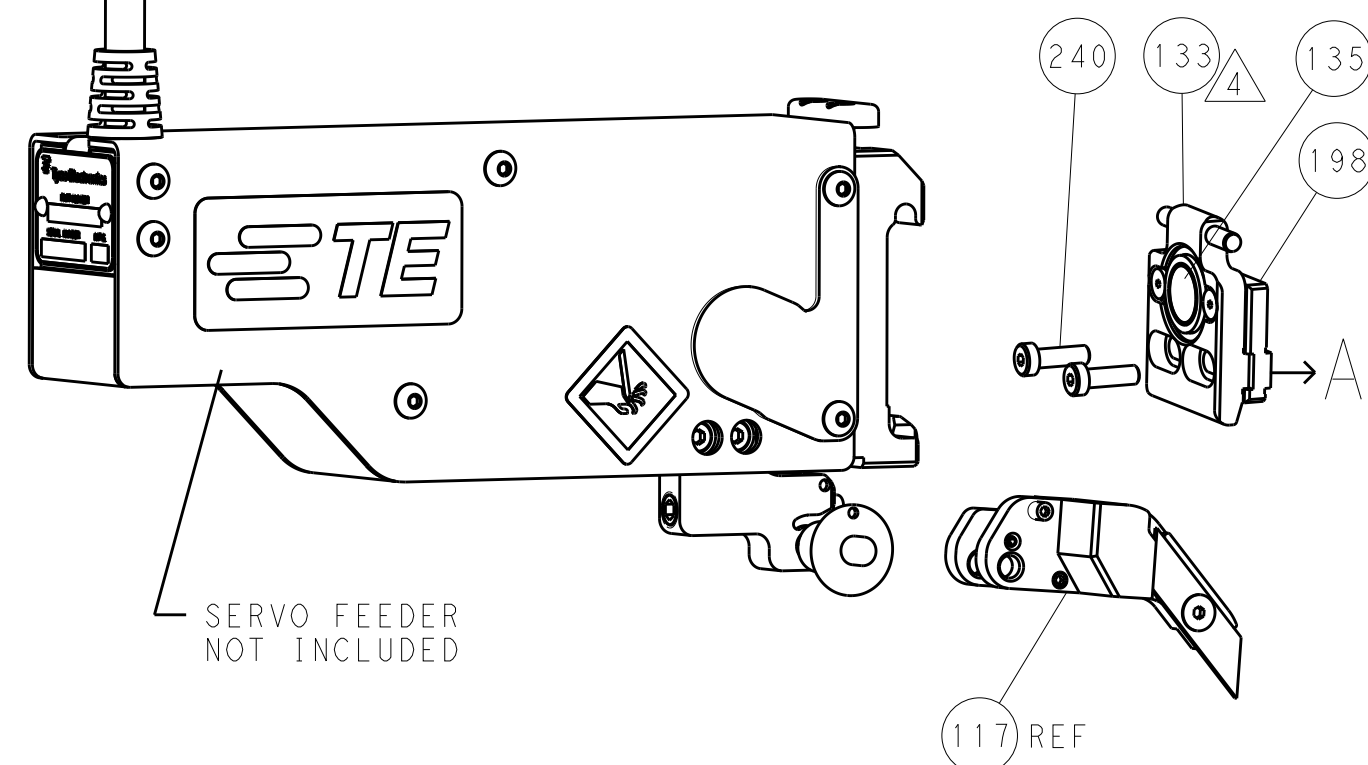
FEED TYPE MECHANICAL



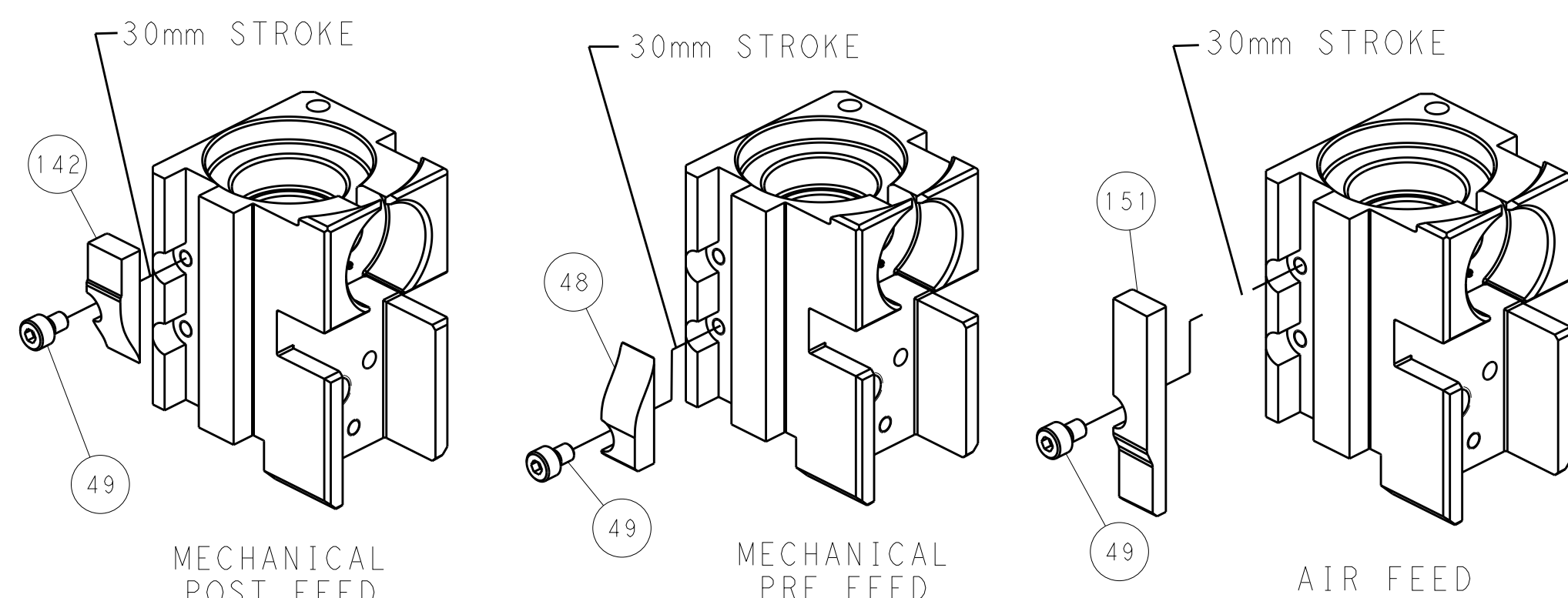
PNEUMATIC



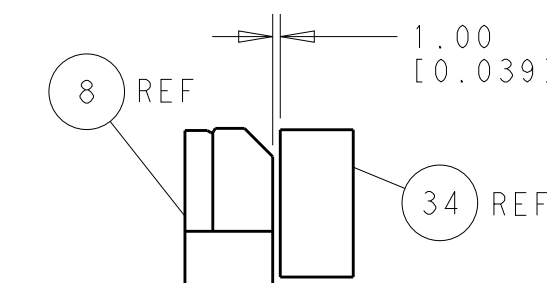
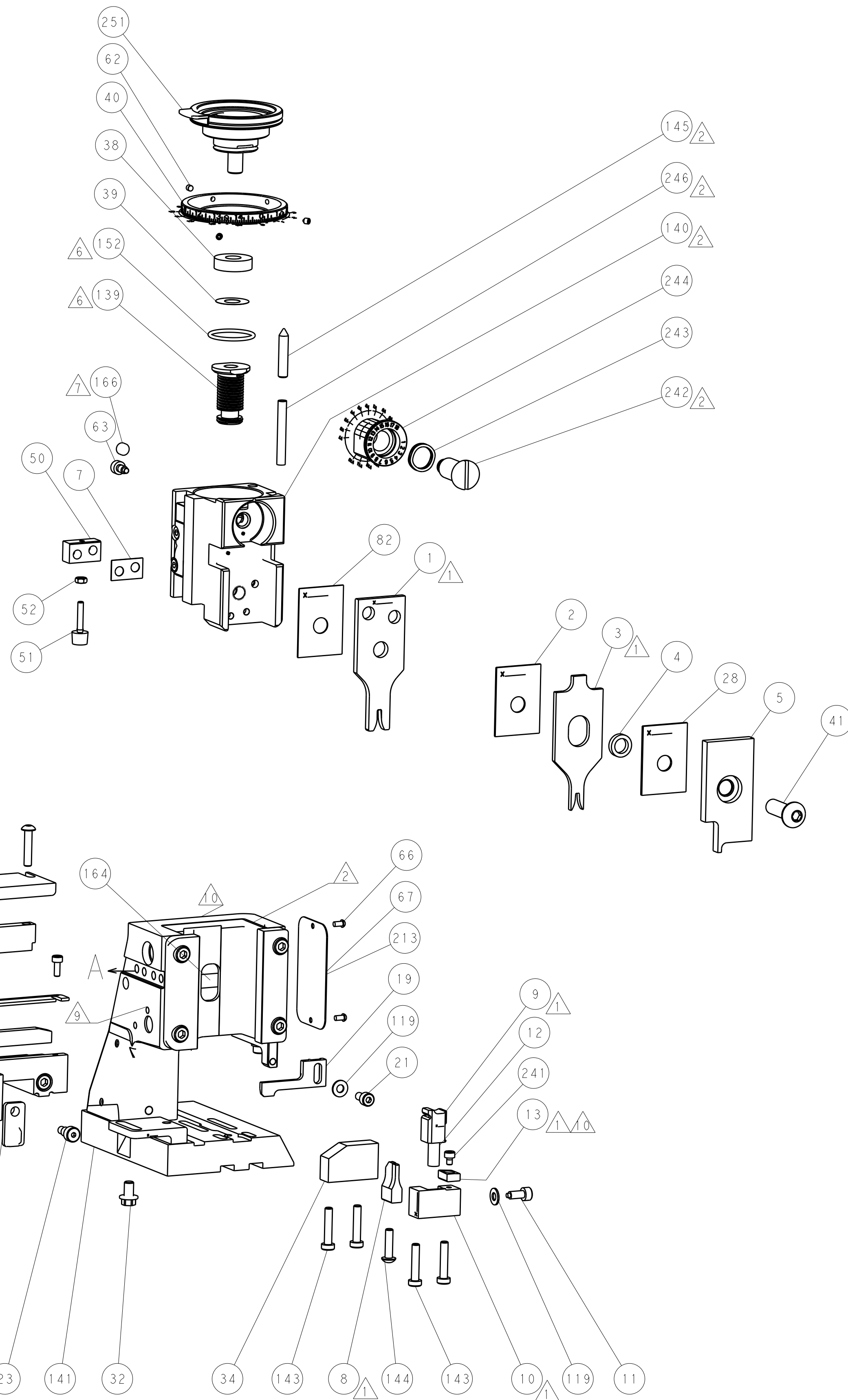
SERVO LATCH PLATE



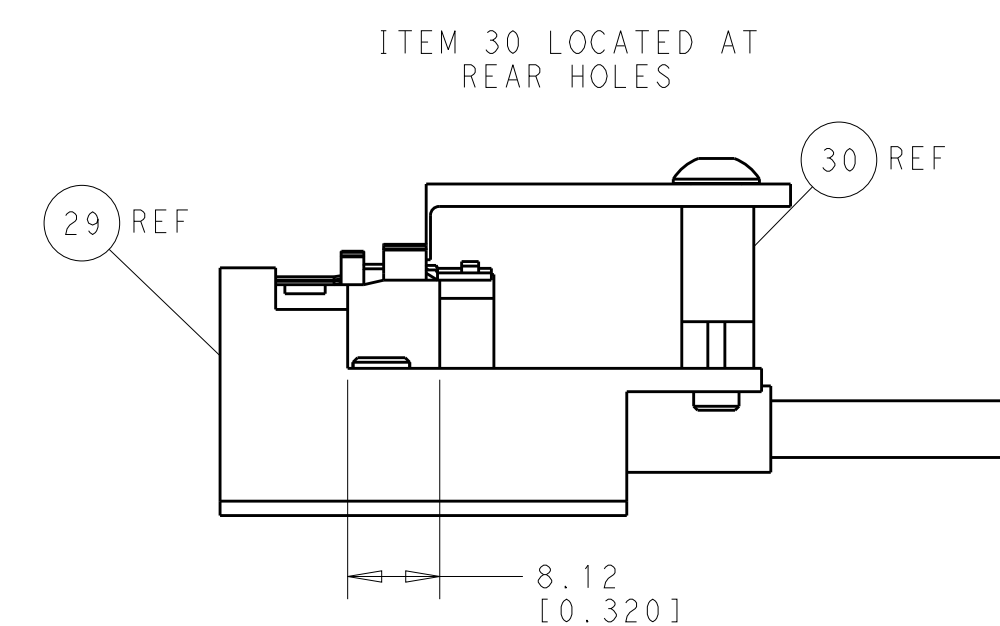
CAM POSITIONS



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



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY WIRE BARREL

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN		TE Connectivity	
mm		0 PLC ±0.1		Y. YIN		Harrisburg, PA 17105-3608	
		1 PLC ±0.02		G. BAILEY		NAME	
		2 PLC ±0.005		S. XI		Ocean Side Feed	
		3 PLC ±0.0005		APVD		Applicator	
		4 PLC ±0.0005		S. XI		-	
		ANGLES		PRODUCT SPEC		SIZE	
		FINISH		APPLICATION SPEC		CAGE CODE	
				WEIGHT		DRAWING NO	
				Customer Accessible Production Drawing		00779	
				SCALE		SHEET	
				6:1		4 OF 4	
						REV	
						A	