

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151062-1	J	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	-	8-2151062-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151062-4	-	-	
	2151062-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151062-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151062-4	-	-	
	2151062-5	J	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	
2151062-6	J	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	-	-	-	-	-	-	-	
				-	-	-	-	-	-	-	
2151062-7	J	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151062-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP SIZE	TYPE	
WIRE 2.54 mm [.100]	F	
INSUL 3.56 mm [.140]	OV	

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR POWER TIME CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
3.80-4.40 mm [.150-.173 IN]		Ø2.20-3.00 mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18387	-	-
TERMINALS APPLIED			
TE TERMINAL (A) 1241390-1	TE TERMINAL (A) 1241390-2	TE TERMINAL (A) 1241390-3	TE TERMINAL

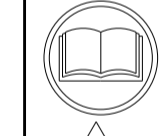
TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR POWER TIME CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.60mm [.157-.181 IN]		Ø 2.20-3.00mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18051	-	-
TERMINALS APPLIED			
TE TERMINAL 1-964296-3	TE TERMINAL 2-964296-1	TE TERMINAL 2-964296-2	TE TERMINAL

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR POWER TIME CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.60mm [.157-.181 IN]		Ø 2.20-3.00mm [.087-.118 IN]	
TERMINAL APPLICATION SPECIFICATION	114-18050	-	-
TERMINALS APPLIED			
TE TERMINAL 965999-1	TE TERMINAL 1-965999-1	TE TERMINAL 1241870-1	TE TERMINAL
TE TERMINAL 965999-2	TE TERMINAL 2-965999-1	TE TERMINAL 1241870-2	TE TERMINAL
TE TERMINAL 965999-6	TE TERMINAL 4-965999-1	TE TERMINAL 4-1241870-1	TE TERMINAL

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.76+/-0.05 [.069+/- .002]	8.0
2.00mm2	1.70+/-0.05 [.067+/- .002]	8.8
1.50mm2	1.47+/-0.05 [.058+/- .002]	11.2
1.25mm2	1.50+/-0.05 [.059+/- .002]	10.7

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.76+/-0.05 [.069+/- .002]	8.0
2.00mm2	1.70+/-0.05 [.067+/- .002]	8.8
1.50mm2	1.47+/-0.05 [.058+/- .002]	10.9
1.25mm2	1.48+/-0.05 [.058+/- .002]	10.9

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
2.50mm2	1.76+/-0.05 [.069+/- .002]	8.0
2.00mm2	1.70+/-0.05 [.067+/- .002]	8.8
1.50mm2	1.47+/-0.05 [.058+/- .002]	10.9



- 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: 8-2151062-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151062-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151062-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151062-6
- 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 ITEMS 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 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.

***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.

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

REV. NO.	DATE	BY	CHK	APP'D	DESCRIPTION
1	20060816	RS	LZ		DESCRIPTION
2					

REV. NO.	DATE	BY	CHK	APP'D	DESCRIPTION	ITEM NO.	
-	-	1	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	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	2119798-1	DETENT PIN	247
-	1	-	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	2119082-4	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
-	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
-	-	-	-	2	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	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
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-9	DEPRESSOR, WIRE	70
-	1	-	-	1	2119740-1	TAG, IDENTIFICATION	67
-	2	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
-	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53
-	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	811242-6	BUMPER, HOLD DOWN	51
-	1	1	1	1	690753-2	SPACER, TONKER	50
-	-	-	-	1	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	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	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
-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1-1752356-7	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1320908-2	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-5	SPACER, CRIMPER	28
-	1	1	1	1	1320928-1	STRIP GUIDE	24
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1	1	454276-5	FLOATING SHEAR, FRONT	9
-	1	1	1	1	4-1333206-3	ANVIL, COMBINATION .100	8
-	1	1	1	1	2119757-5	DEPRESSOR, SHEAR	5
-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
-	1	1	1	1	2119785-2	CRIMPER, INSULATION OVERLAP PREMIUM	3
-	1	1	1	1	1-456407-3	CRIMPER, WIRE PREMIUM	1

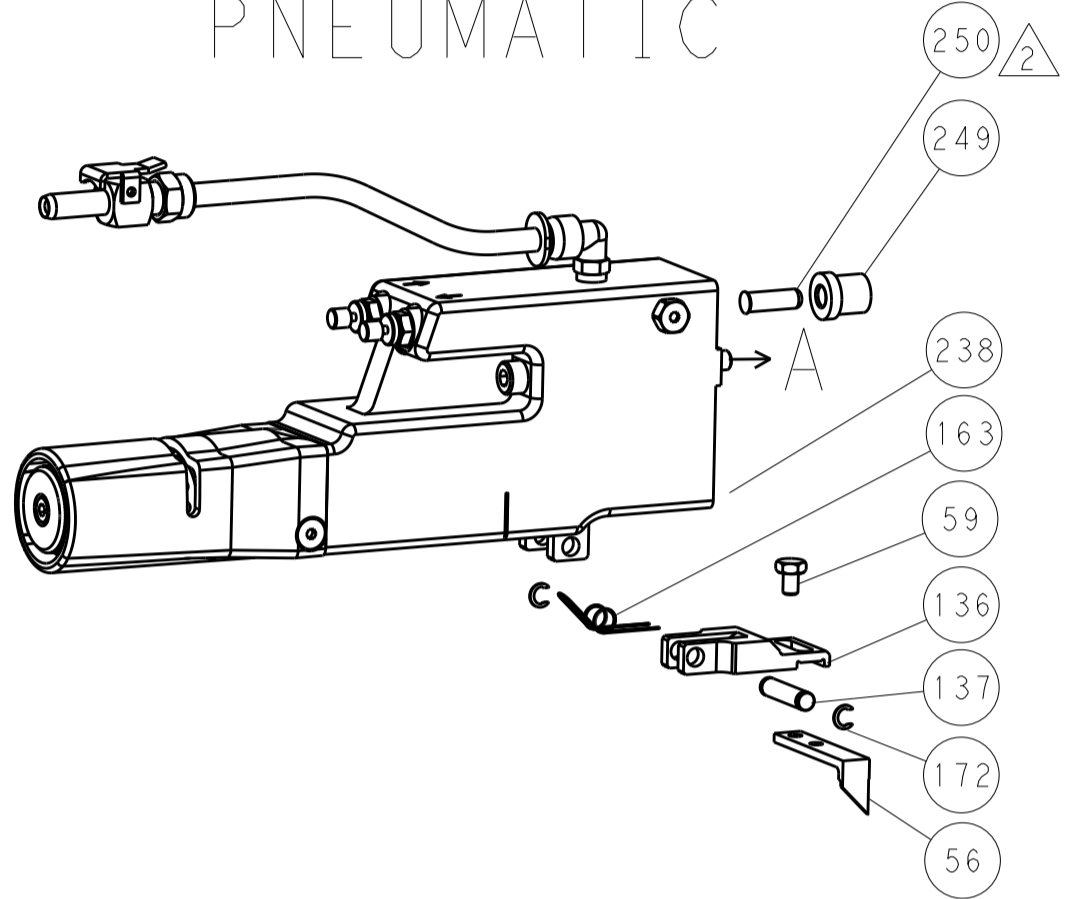
DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED:	OWN	CHK	APP'D	DATE	DESCRIPTION
mm	0 PLC ± 1 PLC ± 3 PLC ± 4 PLC ± ANGLES ±	C. CHEN	S. XI	J. CRUZ	15APR2011	TE Connectivity Ocean Side Feed Applicator
MATERIAL:	FINISH:	WEIGHT:	SCALE:	SHEET:	REV:	
			1:2	1 of 4	J1	

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

FEED TYPE MECHANICAL



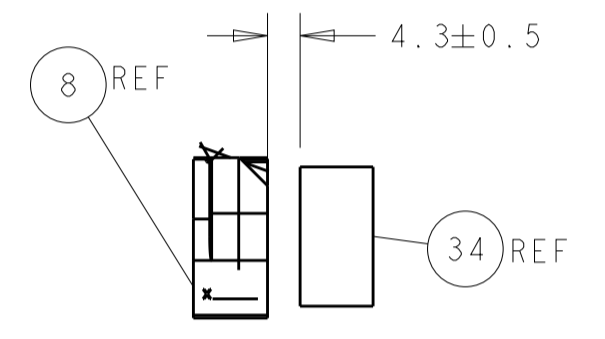
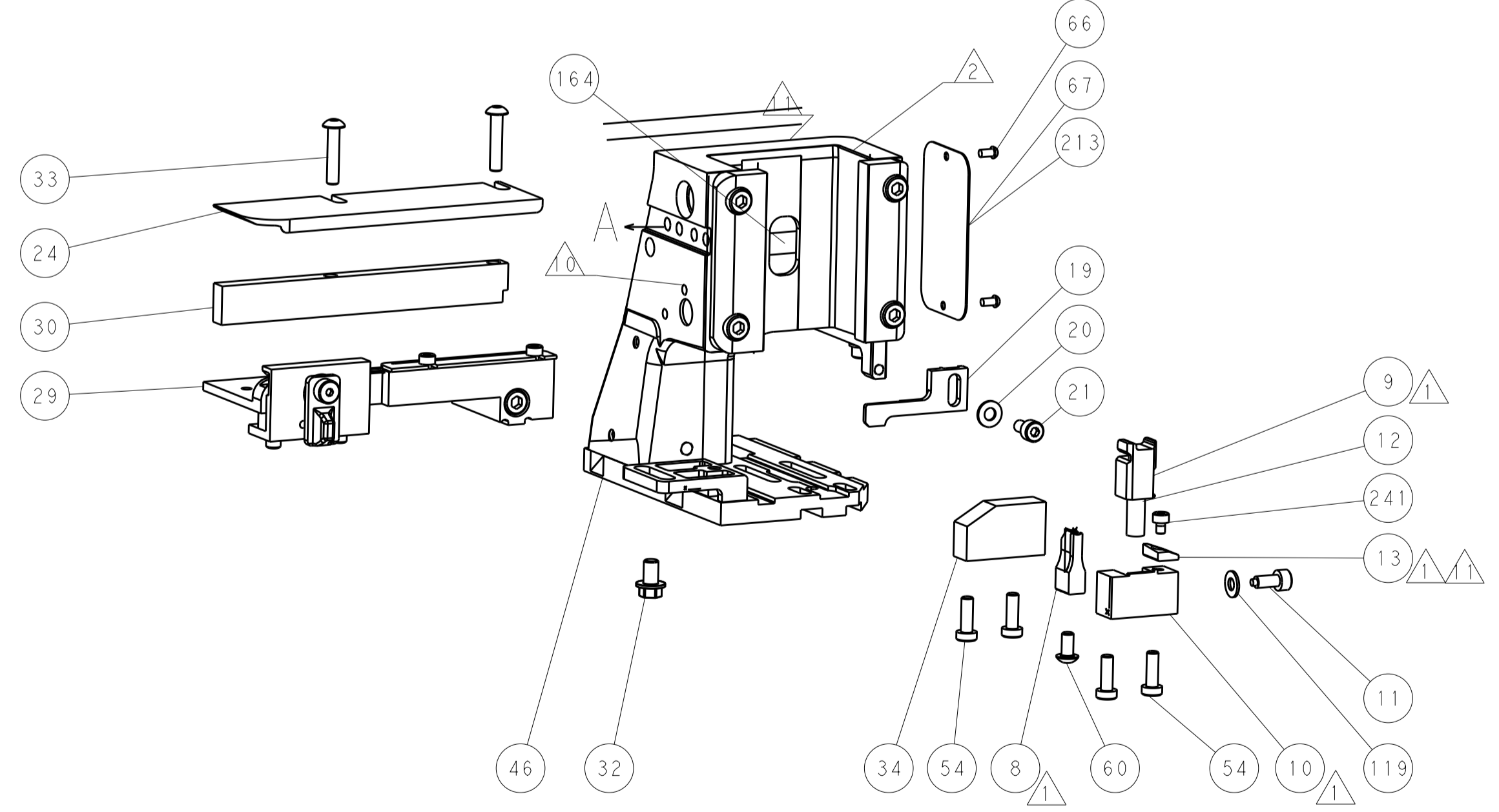
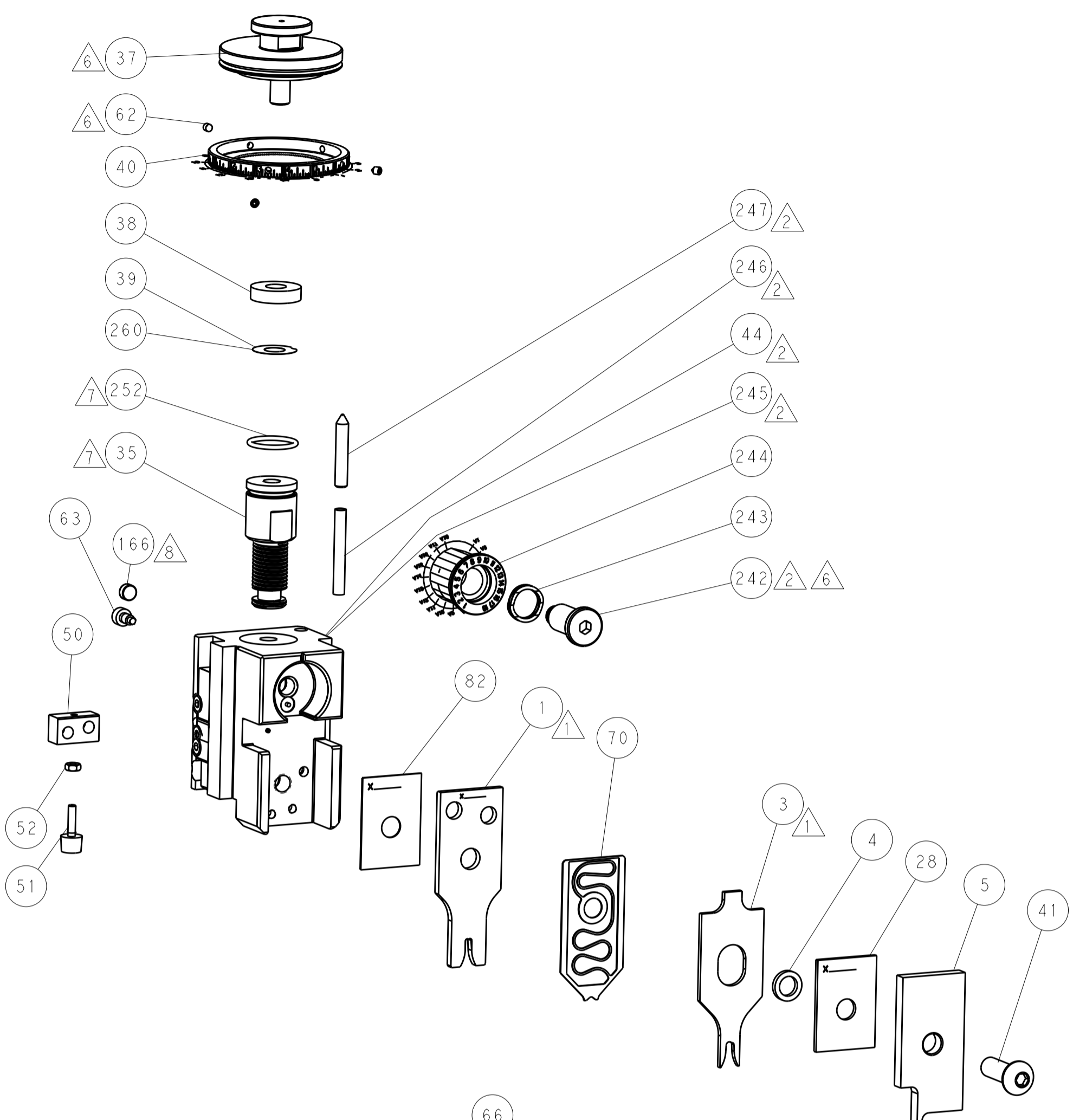
PNEUMATIC



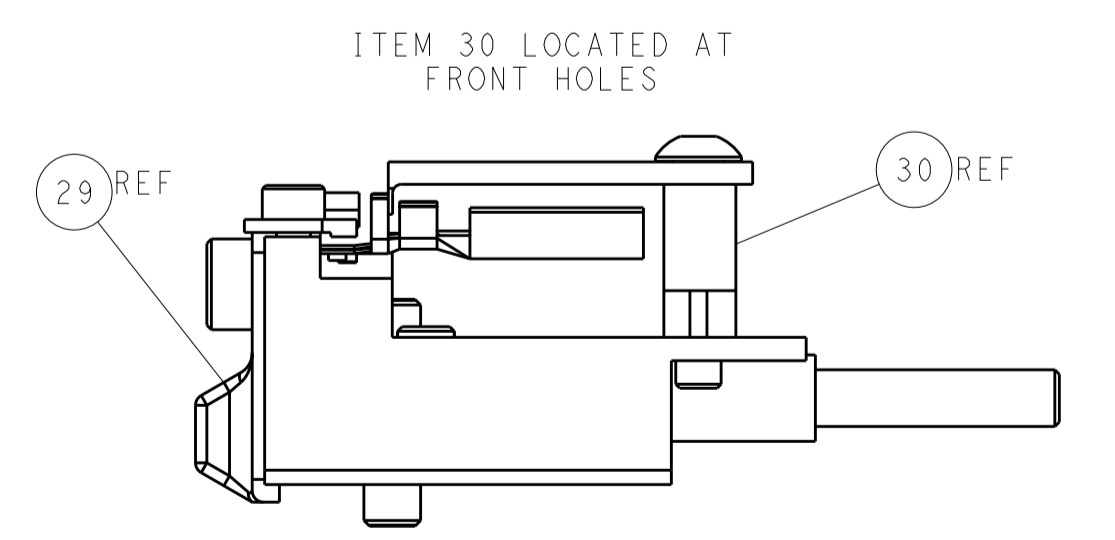
SERVO LATCH PLATE



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWN: C. CHEN 15APR2011		TE Connectivity	
mm	0 PLC ±	1 PLC ±	2 PLC ±	3 PLC ±	4 PLC ±	Harrisburg, PA 17105-3608	
MATERIAL:		FINISH:		CHK: S. XI 15APR2011		NAME: Ocean Side Feed Applicator	
				APVD: J. CRUZ 15APR2011		SIZE: CAGE CODE: DRAWING NO: A11 00779 ©=2151062	
				PRODUCT SPEC:		RESTRICTED TO:	
				APPLICATION SPEC:		Customer Accessible Production Drawing	
				WEIGHT:		SCALE: 1:2 SHEET 2 OF 4 REV J1	

APPLICATOR STYLE CONVERSION CHART. TABLE with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Includes a small diagram of the applicator head.

APPLICATOR DATA. TABLE with columns: CRIMP SIZE TYPE, WIRE SIZE, INSUL SIZE. Includes APPLICATOR INSTRUCTIONS 408-10389 and a small schematic diagram.

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

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WIRE SIZE CRIMP HEIGHT mm [INCH]. TABLE with columns: WIRE SIZE, CRIMP HEIGHT mm [INCH], CRIMP HEIGHT REFERENCE SETTING.

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- 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: 8-2151062-4 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151062-4 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151062-5
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. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 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.

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

REVISIONS. TABLE with columns: P, L, M, DESCRIPTION, DATE, DWN, APVD. Includes SET UP GAUGE 2119599-1 and DIST A 66.

Large assembly list table with columns: ITEM NO, PART NO, DESCRIPTION, ITEM NO. Includes a BOM for the applicator with various sub-components and their quantities.

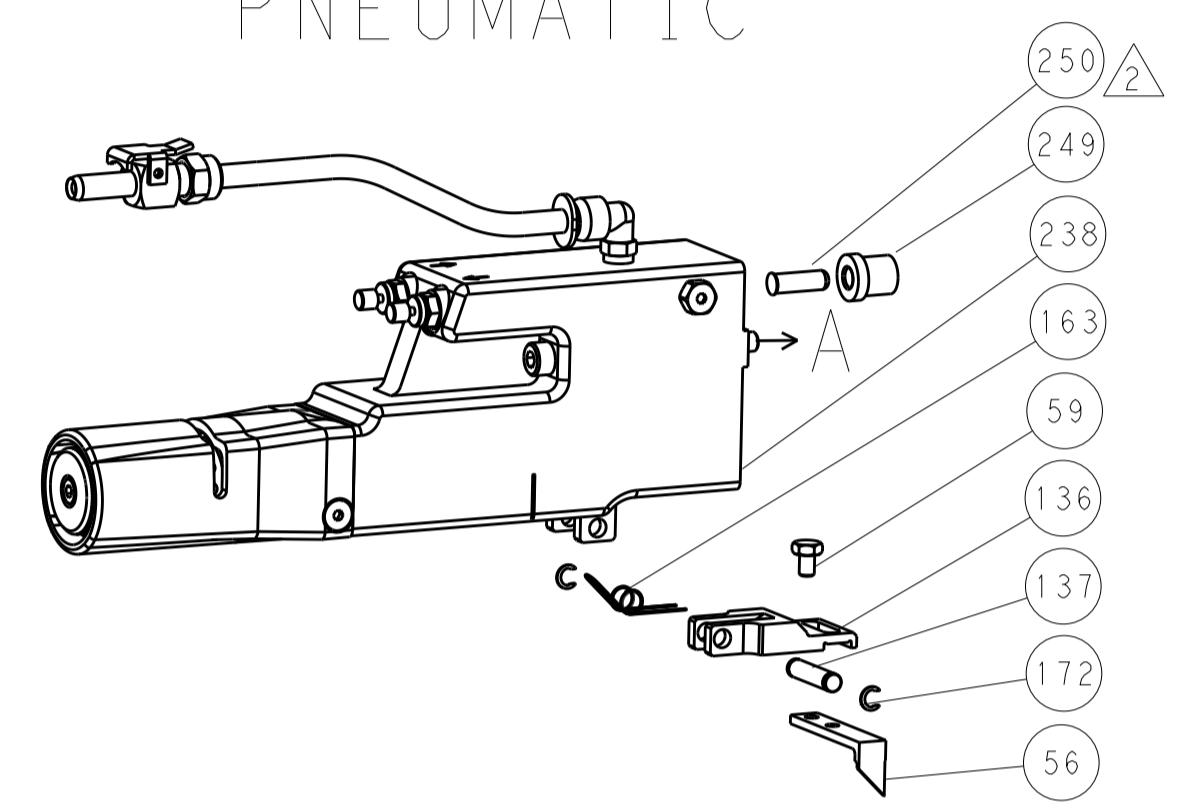
TE Connectivity logo and product information. Includes dimensions, tolerances, material, weight, and customer accessible production drawing information.

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

FEED TYPE MECHANICAL



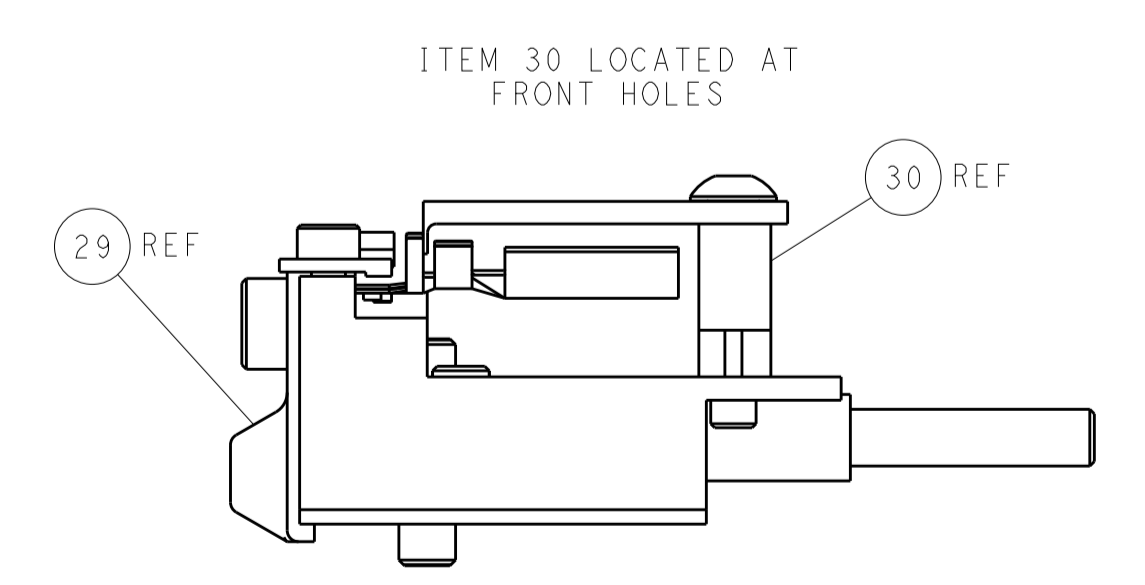
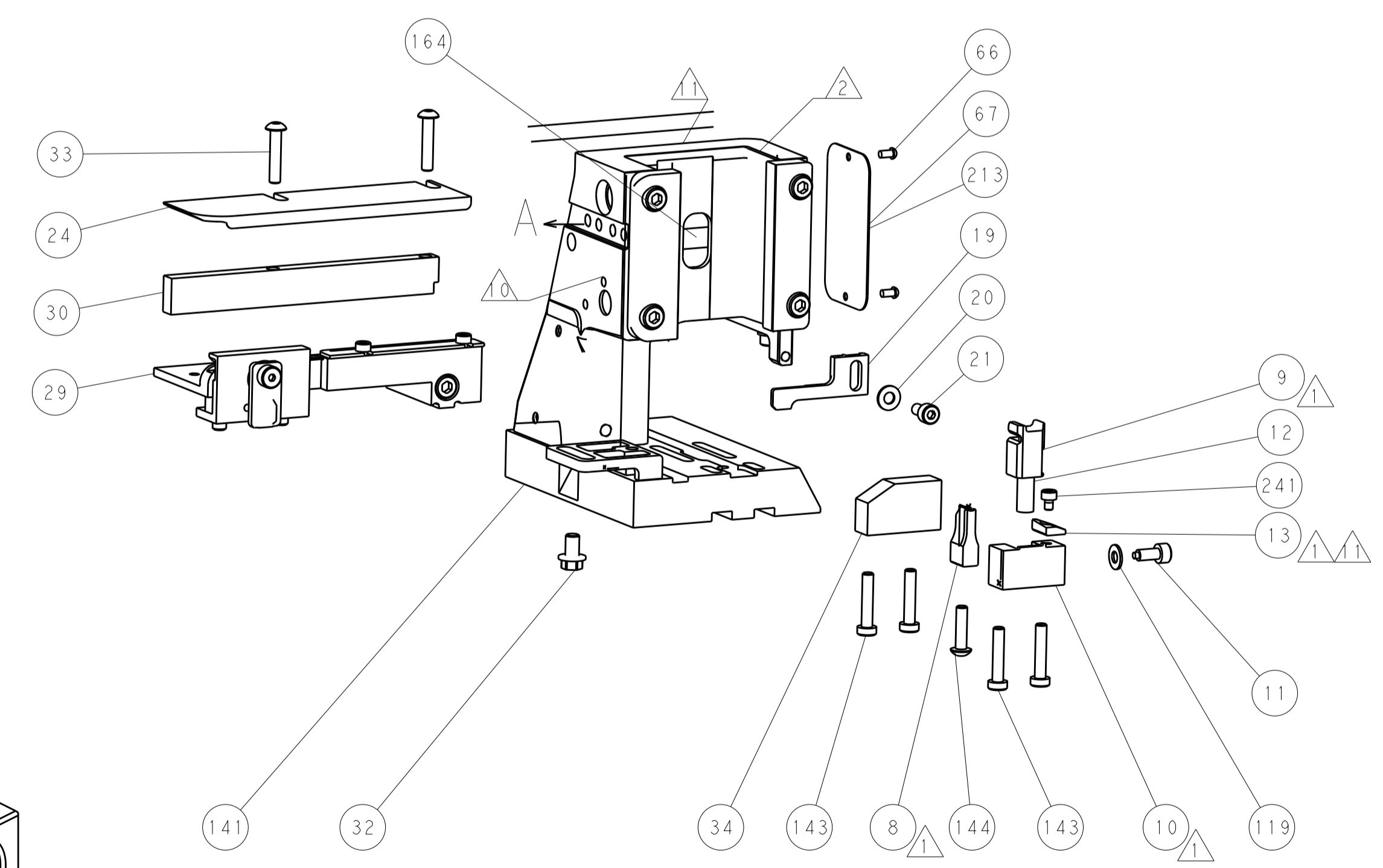
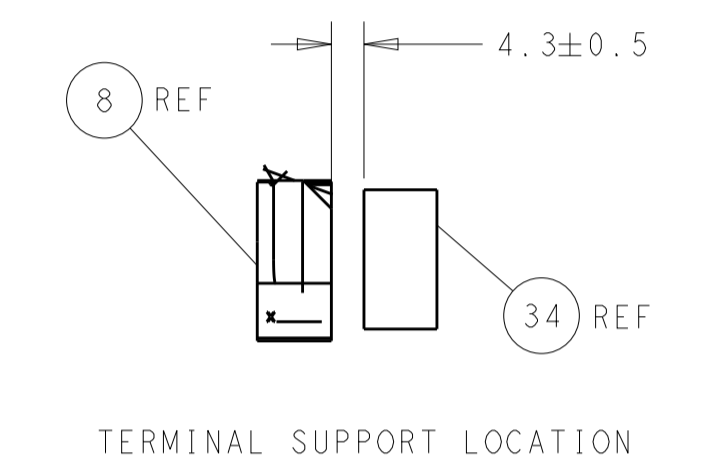
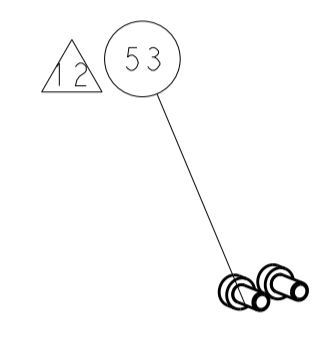
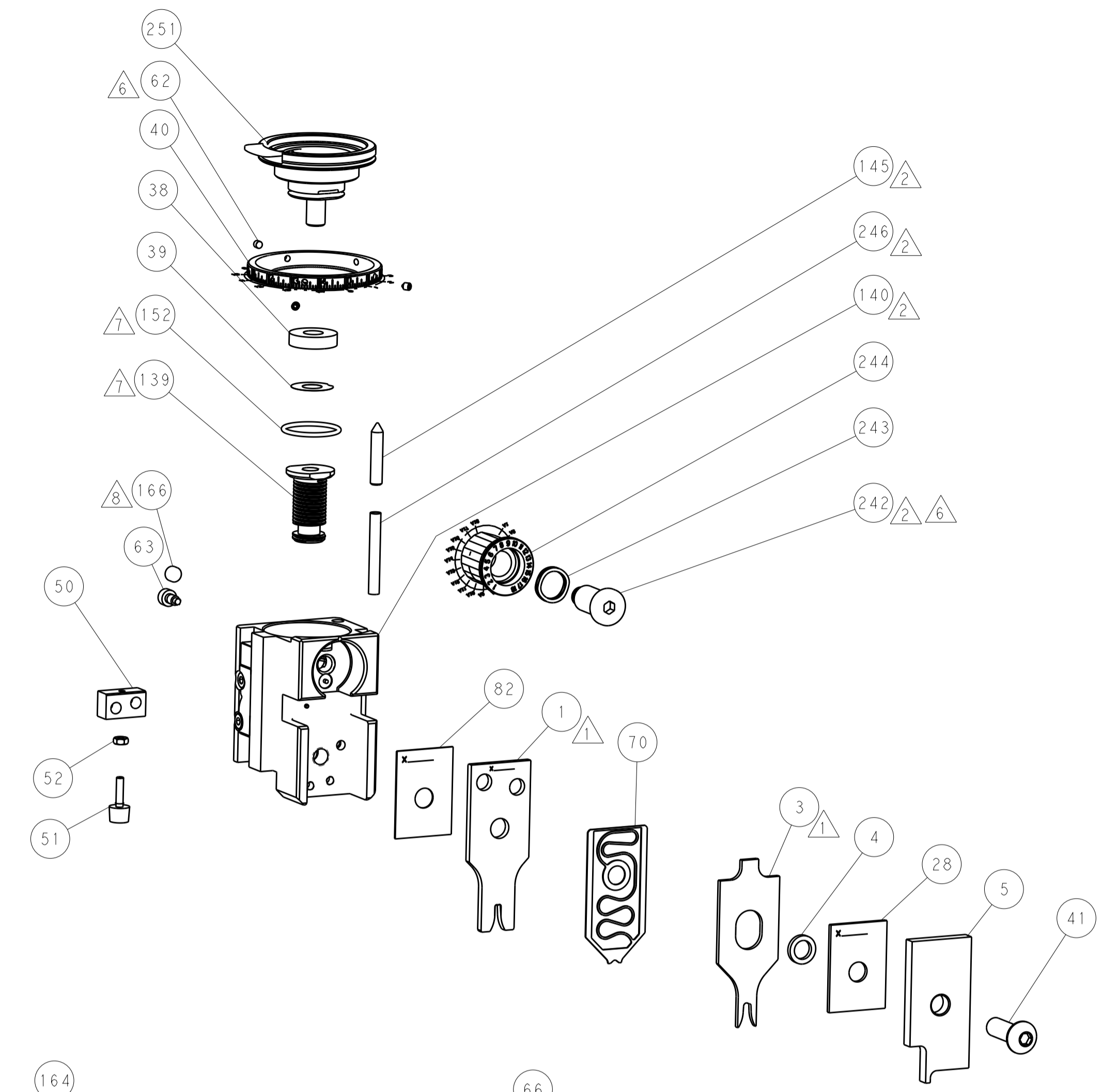
PNEUMATIC



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)

DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		DWG: C. CHEN 15APR2011		NAME: TE Connectivity	
mm	0 PLC	±		CHK: S. XI 15APR2011	Harrisburg, PA 17105-3608		
	1 PLC	±		APVD: J. CRUZ 15APR2011	PRODUCT SPEC		
	2 PLC	±			APPLICATION SPEC		
	3 PLC	±			SIZE: CAGE CODE: DRAWING NO:		
	4 PLC	±			RESTRICTED TO		
	ANGLES	±			A1 00779 ©=2151062		
MATERIAL:	FINISH:	WEIGHT:		Customer Accessible Production Drawing		SCALE: 1:2	SHEET 4 OF 4 REV J1