

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2151092-1	C	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
	2151092-2	C	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151092-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151092-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
	2151092-5	C	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SERVO LATCH PLATE	2119951-1	-	8-2151092-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151092-4	-	-	
					MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
2151092-6	C	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1	
				-	-	-	-	-	-	-	
2151092-7	C	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-	
7-2151092-7	A	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-	

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.79 mm [.110]	OV

APPLICATOR INSTRUCTIONS
408-10389

TERMINAL DATA: TE TERMINAL	TE CRIMP SPECIFICATION
TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT	
WIRE STRIP LENGTH 3.70-4.30 mm [.146-.169 IN]	INSULATION DIAMETER RANGE Ø1.40-2.30 mm [.055-.091 IN]
TERMINAL APPLICATION SPECIFICATION 114-18050	
TERMINALS APPLIED	
TE TERMINAL	TE TERMINAL
965901-1	965901-2
928810-3	9-965901-1
	928810-1

TERMINAL DATA: TE TERMINAL	TE CRIMP SPECIFICATION
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TERMINAL APPLICATION SPECIFICATION 114-18050	
TERMINALS APPLIED	
TE TERMINAL	TE TERMINAL
927771-1	927771-3
927771-9	927771-6
	927771-8
	1-927771-1
	2-927771-1
	2-927771-2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.36+/-0.05 [.054+/- .002]	4.6
0.75mm2	1.27+/-0.05 [.050+/- .002]	5.5
0.50mm2	1.18+/-0.05 [.046+/- .002]	6.4

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.20+/-0.05 [.047+/- .002]	6.2
0.75mm2	1.18+/-0.05 [.046+/- .002]	6.4
0.50mm2	1.15+/-0.05 [.045+/- .002]	6.7

- 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: 8-2151092-4
 PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151092-4
 SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151092-5
 SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151092-6
- 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 & 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37 & 242.
- 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

***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)

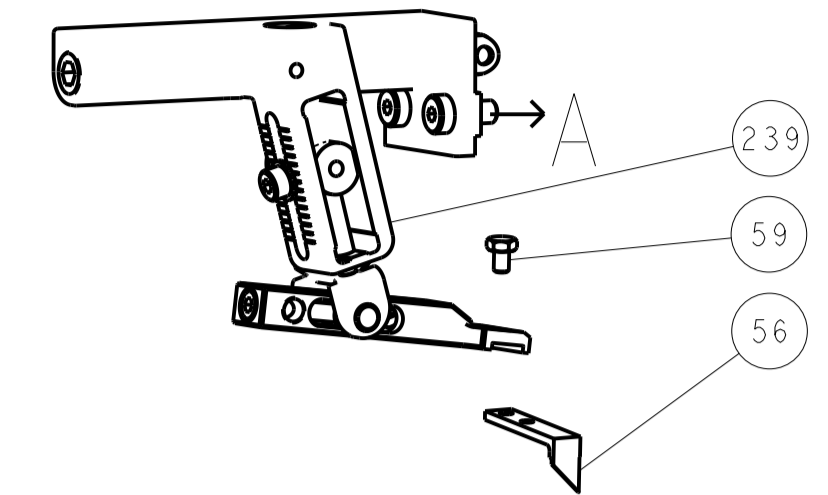
SET UP GAUGE	LOC	DIST	REVISIONS			
2119599-1	A	66	REV	DATE	BY	APPV
			B	11APR2013	LG	GB
			C	28JAN2014	KH	UG

REV	DATE	BY	APPV	DESCRIPTION	ITEM NO		
-	-	1	-	2119957-2	APPLICATOR SHIM PACK	260	
-	1	-	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252	
-	-	-	-	2119640-1	PUSH ROD, AIR FEED	250	
-	-	-	-	2079988-1	BUSHING, LCH5-12, MISUMI	249	
-	-	-	-	2119641-1	FEED CAM, AIR FEED	248	
-	1	-	1	2119798-1	DETENT PIN	247	
-	1	-	1	1-22279-3	SPRING, COMPRESSION	246	
-	-	1	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245	
-	1	1	1	2119082-9	CAM, SNAIL, INSULATION ADJUSTMENT	244	
-	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243	
-	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242	
-	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	
-	-	-	-	2119580-1	MECHANICAL FEED ASSEMBLY	239	
-	-	-	-	2063440-1	AIR FEED MODULE	238	
-	-	1	1	2119740-2	TAG, IDENTIFICATION	213	
-	-	1	1	1901094-3	SPACER, FEEDER	198	
-	-	-	-	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	
-	-	-	-	240638-1	SPRING, FEED FINGER	163	
-	-	-	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137	
-	-	-	-	2119799-1	HOLDER, FEED FINGER, AF	136	
-	-	REF	REF	-	SEE NOTE 4	135	
-	-	1	1	1633743-1	SERVO FEED LATCH ASM	133	
-	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119	
-	-	REF	REF	-	2119944-1	FEED FINGER ASSEMBLY, SF	117
-	1	1	1	455888-6	SPACER, CRIMPER	82	
-	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71	
-	1	-	-	2119740-1	TAG, IDENTIFICATION	67	
-	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66	
-	1	-	-	2119793-1	LIMITER, ADJUSTMENT BOLT	63	
-	3	-	-	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62	
-	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60	
-	-	-	-	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59	
-	-	-	-	1338685-1	PAWL, FEED	56	
-	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54	
-	2	2	2	1-2168083-0	SCR, SKT HD CAP, RoHS, M4 X 10	53	
-	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52	
-	1	1	1	811242-5	BUMPER, HOLD DOWN	51	
-	1	1	1	690753-2	SPACER, TONKER	50	
-	-	-	-	18023-9	SCR, SKT HD CAP M4 X 6.0	49	
-	-	-	-	2119652-1	FEED CAM, PRE FEED	48	
-	-	-	-	2119653-1	FEED CAM, POST FEED	47	
-	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46	
-	1	-	-	2119370-1	RAM, AMP STYLE, SIDE FEED	44	
-	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41	
-	1	-	-	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40	
-	1	-	-	2119957-1	APPLICATOR SHIM PACK	39	
-	1	1	1	2119644-1	RAM WASHER, PRECISION	38	
-	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37	
-	1	-	-	2119092-1	BOLT, ADJUSTMENT	35	
-	1	1	1	1-1752356-8	SUPPORT, TERMINAL	34	
-	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33	
-	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32	
-	1	1	1	1320908-3	SPACER, STRIP GUIDE	30	
-	1	1	1	2119959-1	ASSEMBLY, STRIP GUIDE	29	
-	1	1	1	455888-3	SPACER, CRIMPER	28	
-	1	1	1	1320928-2	STRIP GUIDE	24	
-	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	2119806-1	INSERT, SHEAR	13	
-	1	1	1	3-22280-3	SPRING, COMPRESSION	12	
-	1	1	1	1-356885-4	STOP, SHEAR	11	
-	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10	
-	1	1	1	462006-6	FLOATING SHEAR, FRONT	9	
-	1	1	1	1338693-2	ANVIL, COMBINATION .080	8	
-	1	1	1	2119757-8	DEPRESSOR, SHEAR	5	
-	1	1	1	238011-7	BLOCK, CRIMPER SPACER	4	
-	1	1	1	2119785-5	CRIMPER, INSULATION OVERLAP PREMIUM	3	
-	1	1	1	455888-4	SPACER, CRIMPER	2	
-	1	1	1	1-456405-5	CRIMPER, WIRE PREMIUM	1	

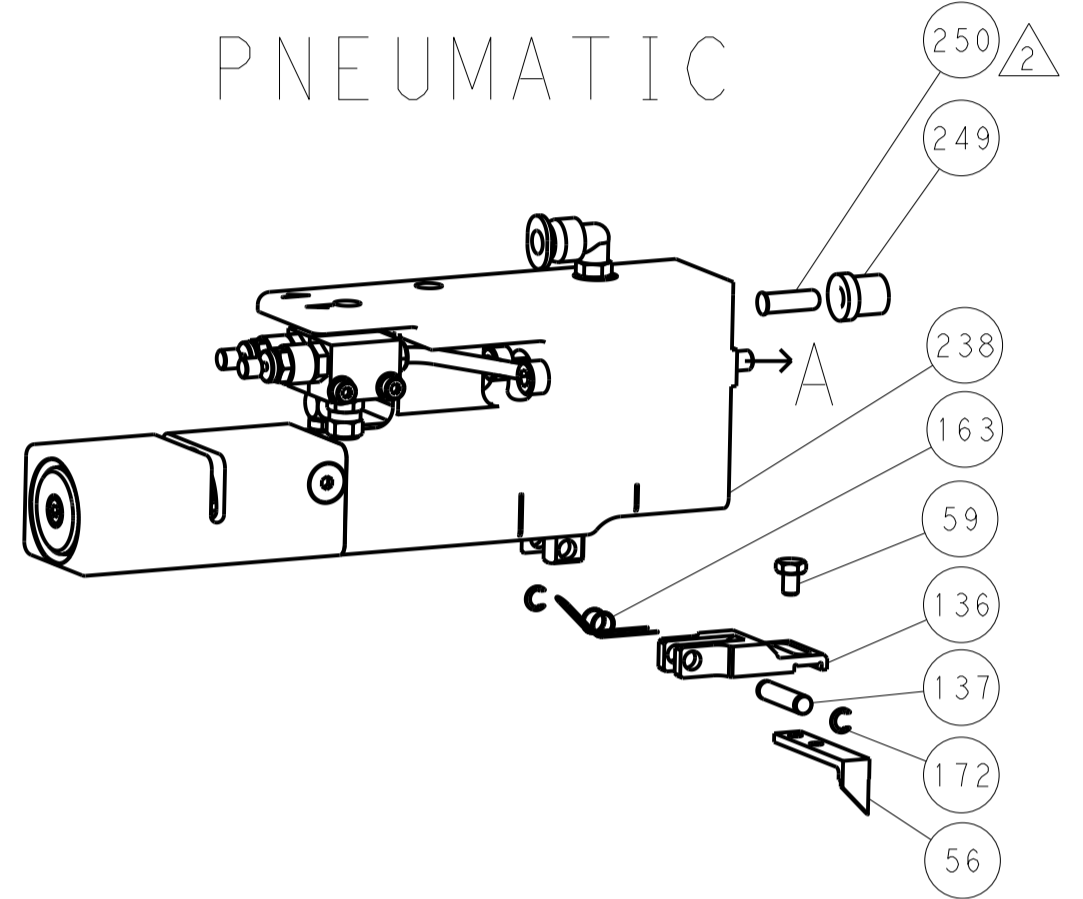
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.05 1 PLC ±.05 2 PLC ±.03 3 PLC ±.013 4 PLC ±.0013 ANGLES ±.0001		DWG: H. HUANG 23SEP2011 CHK: S. XI 23SEP2011 APVD: J. CRUZ 23SEP2011	TE Connectivity Harrisburg, PA 17105-3608
MATERIAL:		FINISH:		PRODUCT SPEC:	NAME: Ocean Side Feed Applicator
WEIGHT:		SCALE: 1:2		SHEET: 1 of 4	REV: C

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

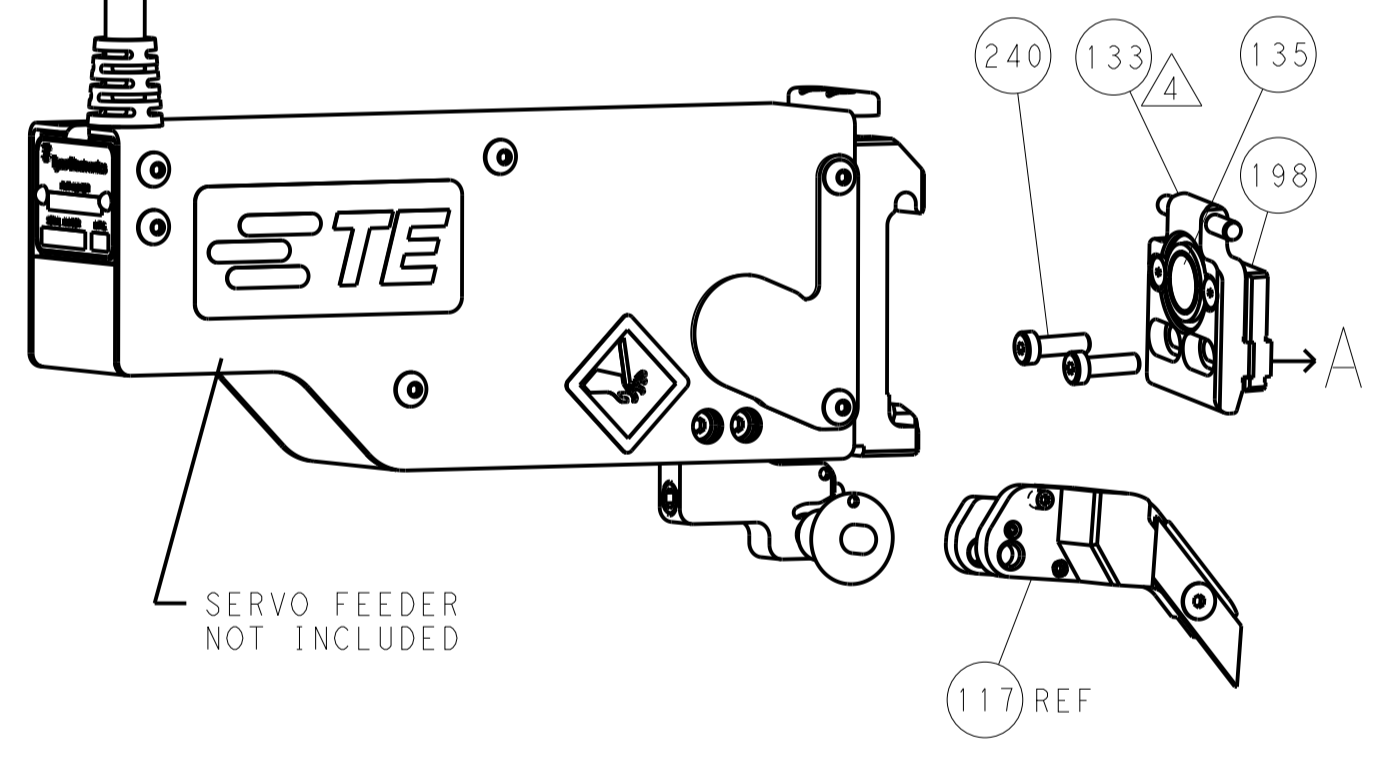
FEED TYPE MECHANICAL



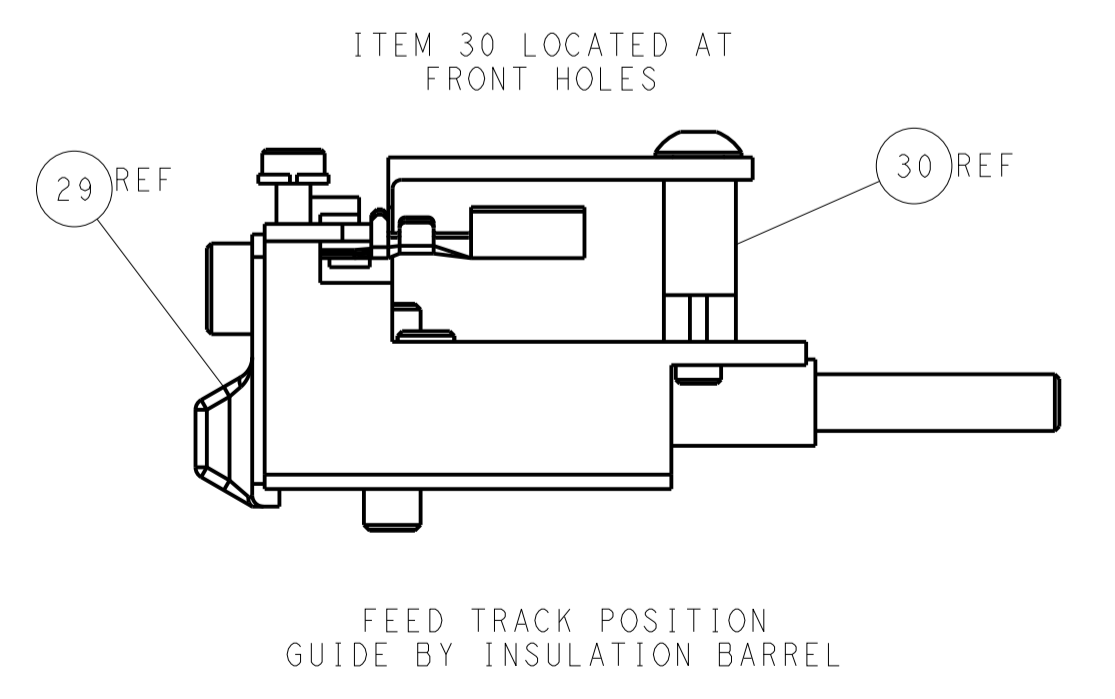
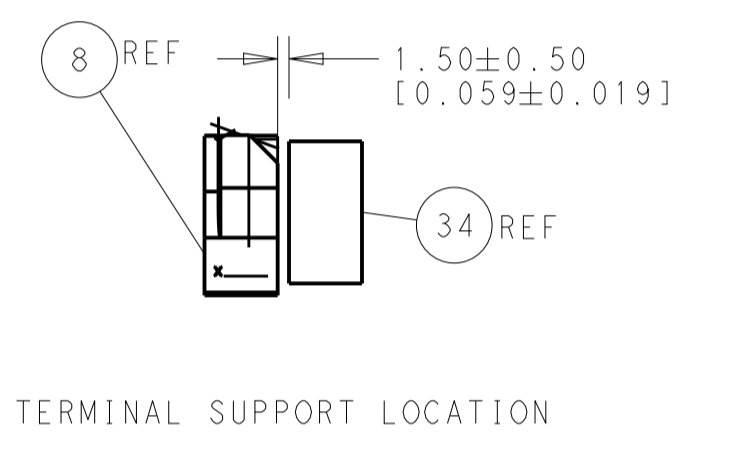
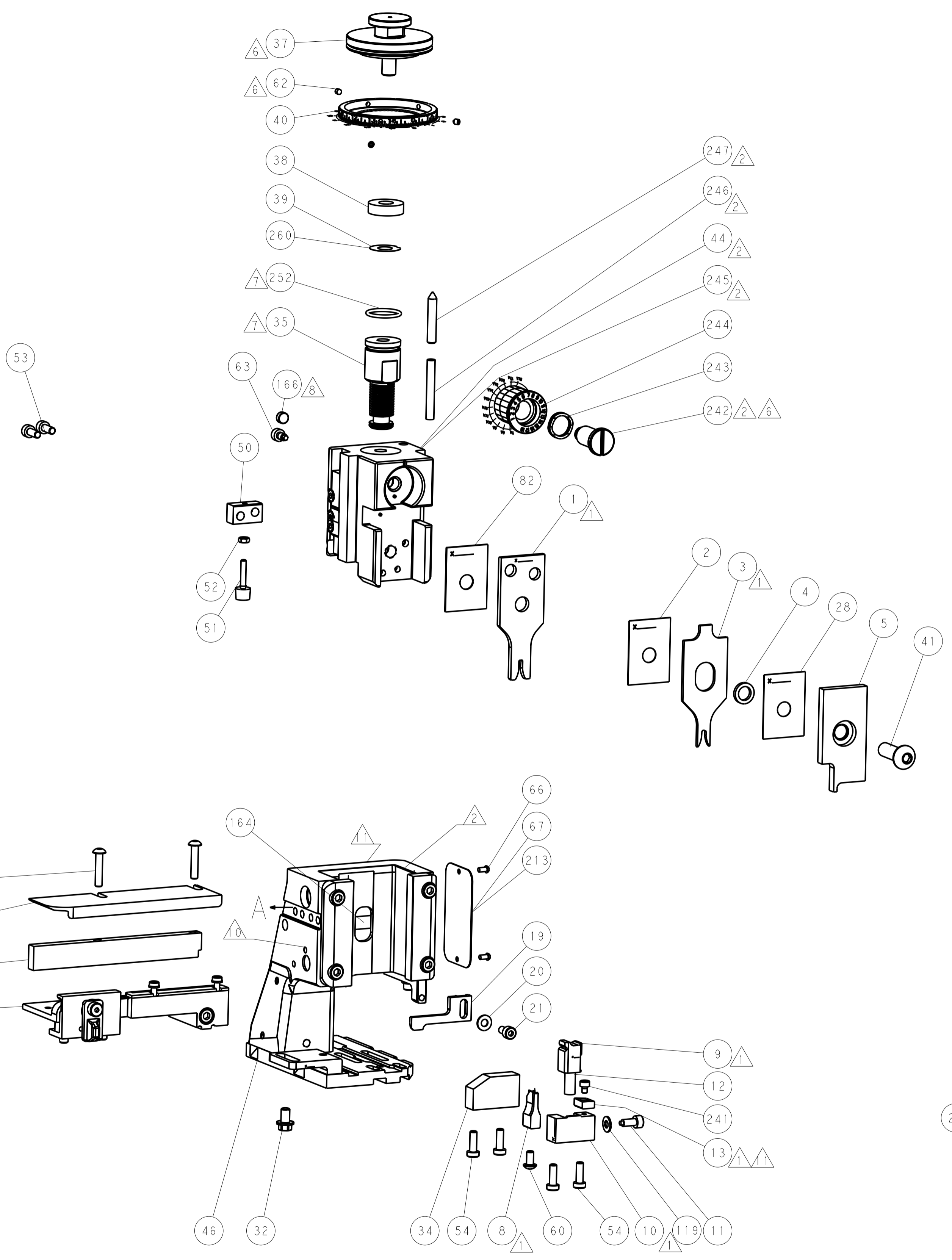
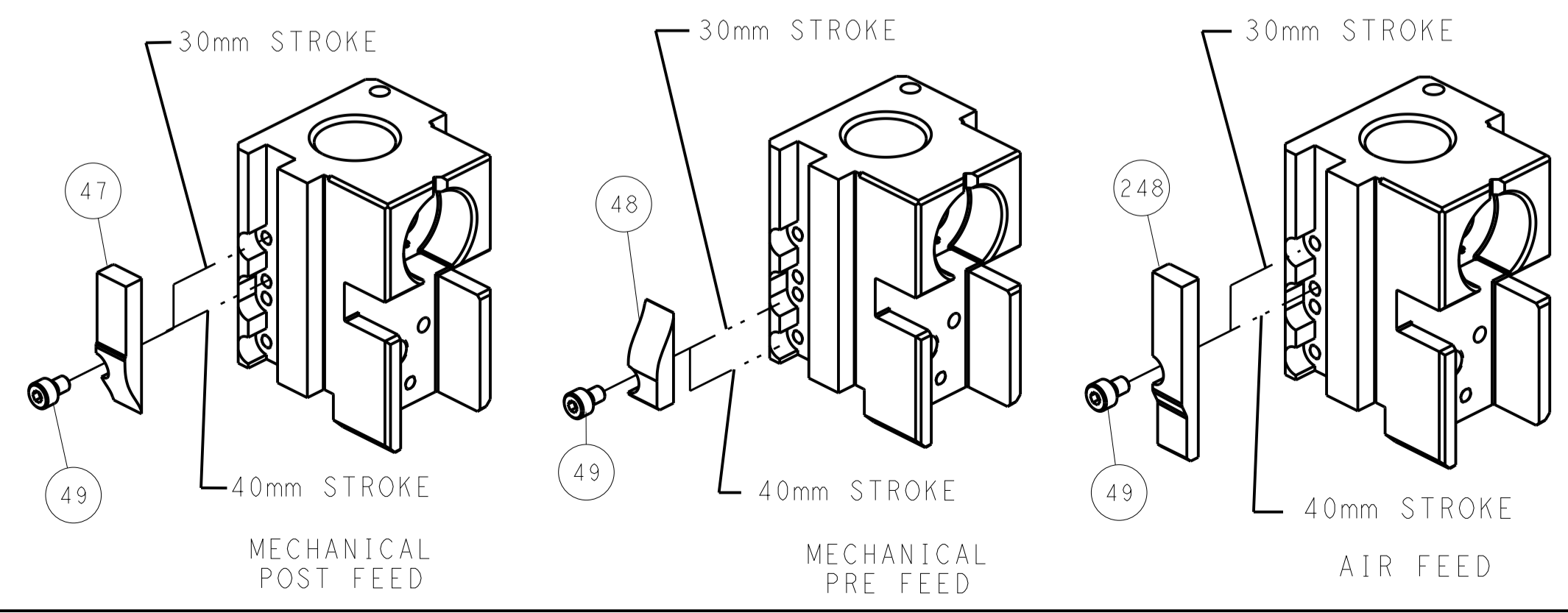
PNEUMATIC



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 H. HUANG 23SEP2011		TE Connectivity Harrisburg, PA 17105-3608	
mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.0001	NAME	Ocean Side Feed Applicator
ANGLES	FINISH	WEIGHT	Customer Accessible Production Drawing	SCALE	1:2	SIZE	A1
				CAGE CODE	00779	DRAWING NO	2151092
				SHEET	2	OF	4
				REV	C		

Table with columns: PART NUMBER, REVISION, DESCRIPTION, FEED TYPE, CONVERT TO, PART NUMBERS REQUIRED. Includes a diagram of the applicator.

APPLICATOR DATA table with columns: CRIMP, SIZE, TYPE. Includes APPLICATOR INSTRUCTIONS 408-10389.

Terminal data table for TE CRIMP SPECIFICATION. Includes columns for WIRE STRIP LENGTH, INSULATION DIAMETER RANGE, and TERMINALS APPLIED.

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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...

*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)

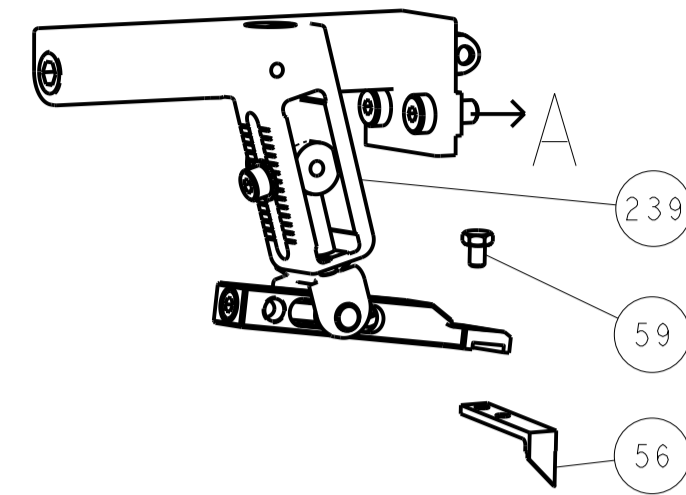
REVISIONS table with columns: P, LTM, DESCRIPTION, DATE, DWN, APVD.

Large table listing parts with columns: QTY, PART NO, DESCRIPTION, ITEM NO. Includes various components like FINE ADJUST HEAD ASM, PUSH ROD, BUSHING, etc.

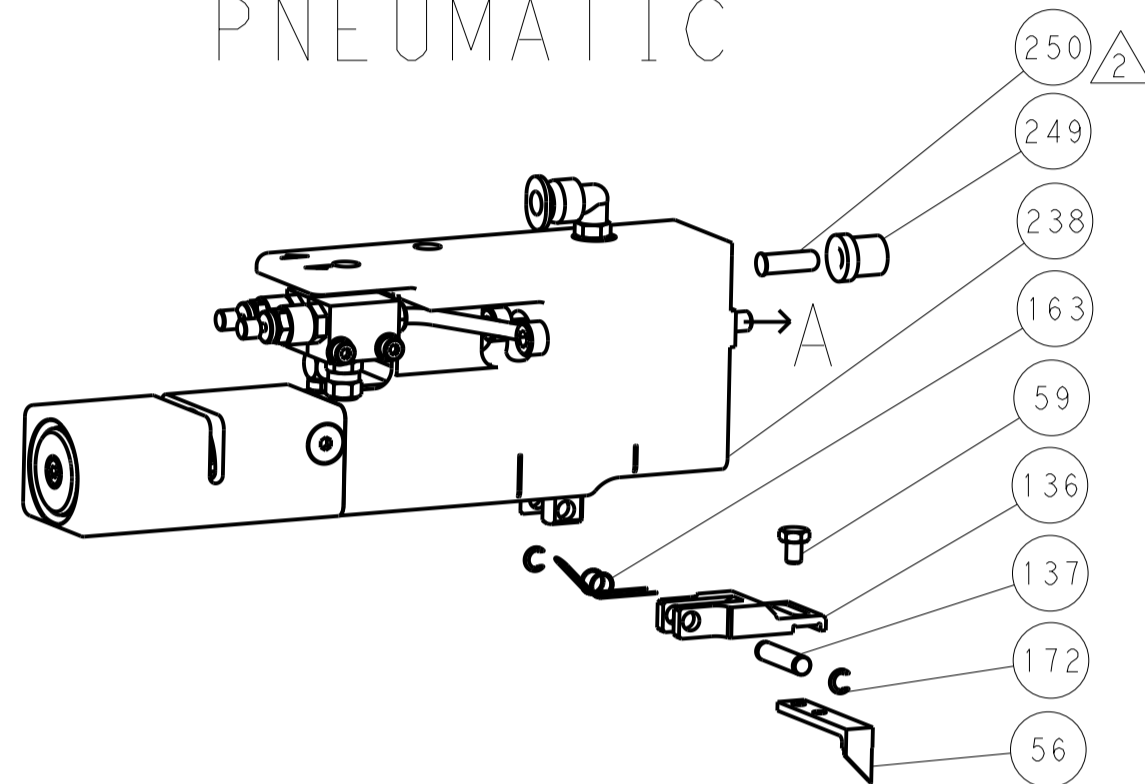
Technical drawing information table including DIMENSIONS, TOLERANCES, MATERIAL, FINISH, WEIGHT, SCALE, SHEET 3 OF 4.

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

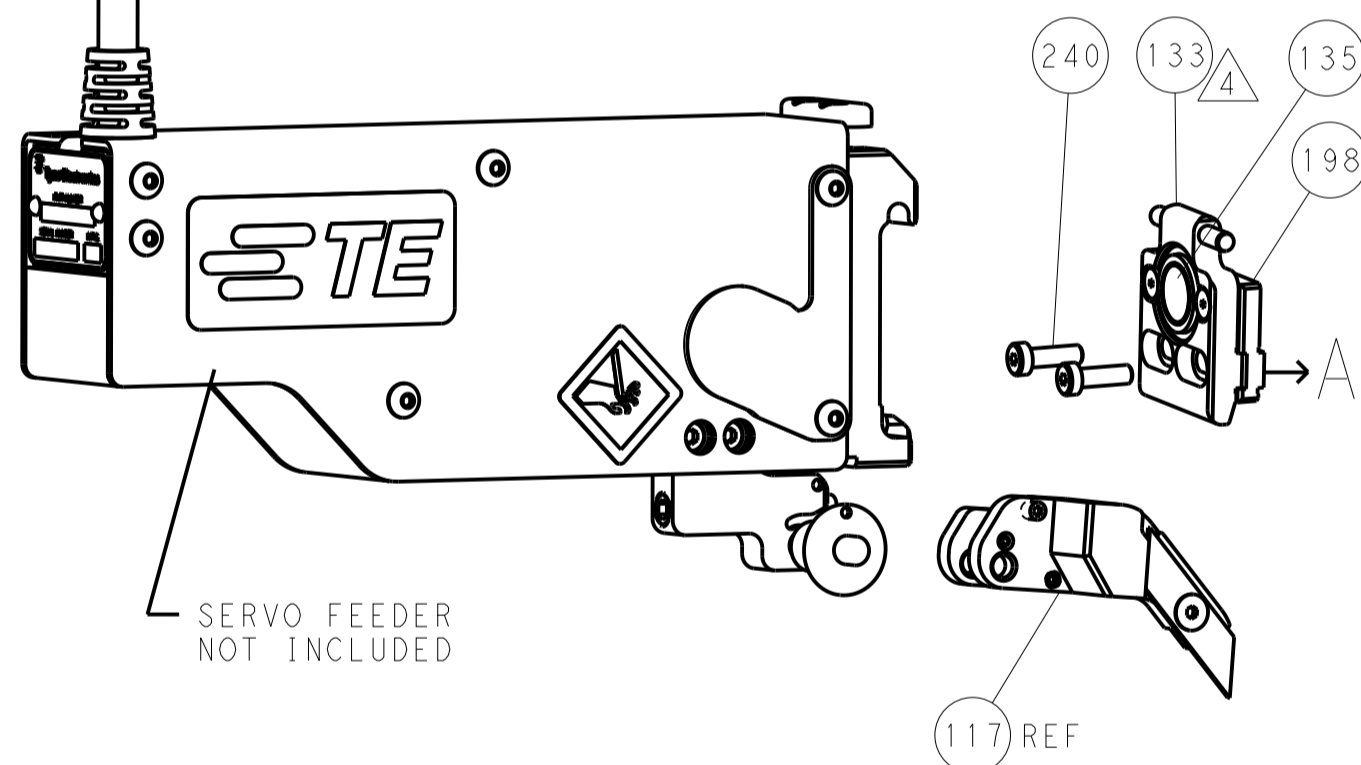
FEED TYPE MECHANICAL



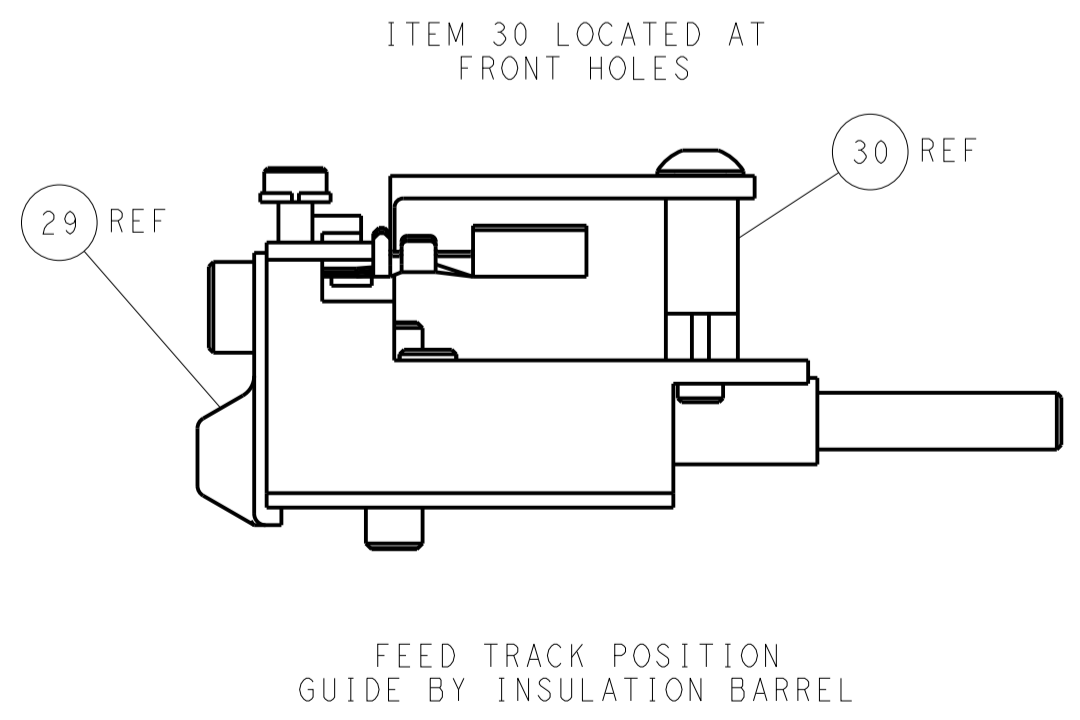
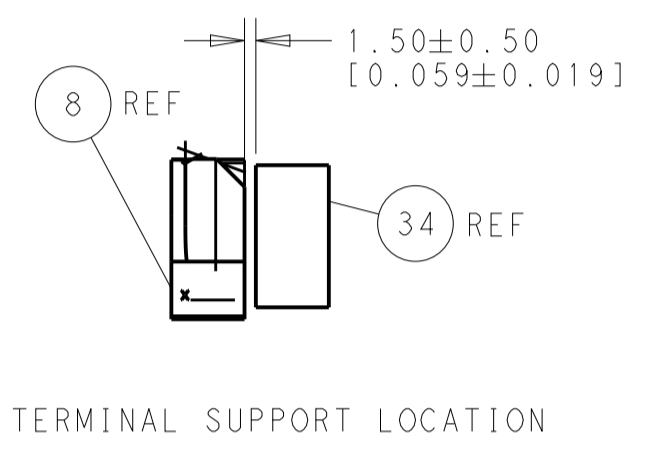
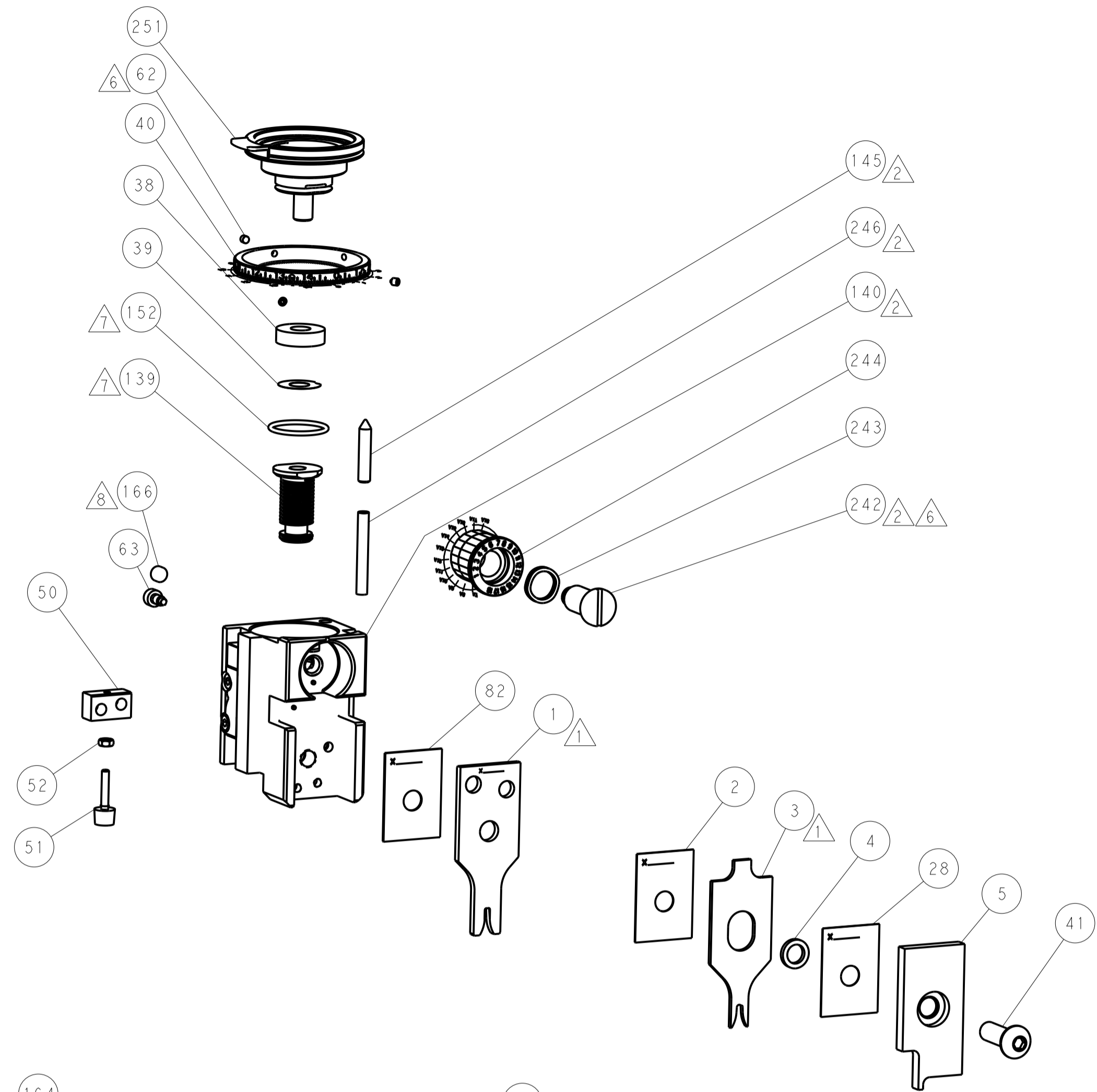
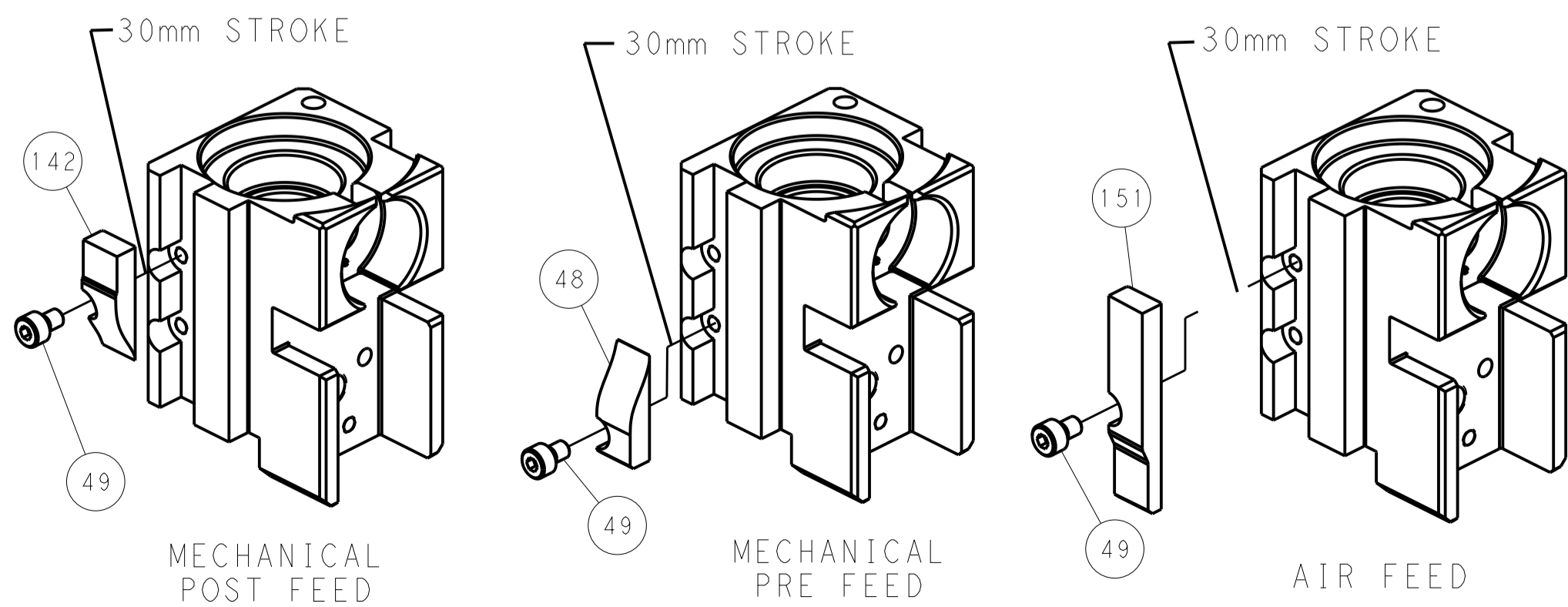
PNEUMATIC



SERVO LATCH PLATE



CAM POSITIONS



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 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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mm	0 PLC ±0.5	1 PLC ±0.5	2 PLC ±0.13	3 PLC ±0.013	4 PLC ±0.001	APVD S. XI 23SEP2011	NAME Ocean Side Feed Applicator
MATERIAL	FINISH	WEIGHT	ANGLES	SCALE	1:2	SIZE A	CAGE CODE 00779
Customer Accessible Production Drawing				SHEET	4	OF	4
				REV	C		