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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

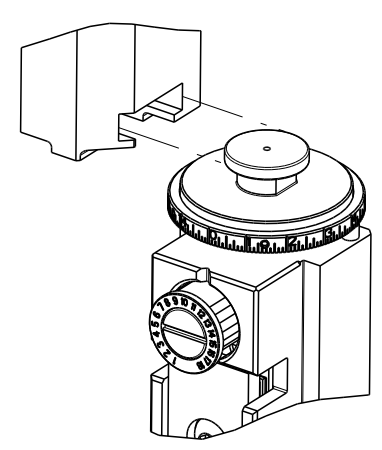
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151099-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
2151099-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151099-5	1901094-3	-	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2151099-4	-	-	
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	
				SERVO LATCH PLATE	2119951-1	-	8-2151099-5	1901094-3	-	2168400-6 (QUANTITY 2)
2151099-5	K	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SMART APPLICATOR	2161326-1	-	8-2151099-4	-	-	
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	
2151099-6	K	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
				-	-	-	-	-	-	-
2151099-7	K	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
				-	-	-	-	-	-	-
7-2151099-7	H	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.55 mm [1.00]	OV

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.70-4.30 mm [1.46-.169 IN]	Ø1.40-2.10 mm [1.055-.083 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.50-4.10mm [1.38-.161 IN]	Ø1.40-2.10 mm [1.055-.083 IN]

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TERMINALS APPLIED

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TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.50-4.10mm [1.38-.161 IN]	Ø1.40-2.10 mm [1.055-.083 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.20+/-0.05 [1.047+/-0.002]	5.5
0.75mm2	1.18+/-0.05 [1.046+/-0.002]	5.7
0.50mm2	1.15+/-0.05 [1.045+/-0.002]	5.8

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.20+/-0.05 [1.047+/-0.002]	5.5
0.75mm2	1.18+/-0.05 [1.046+/-0.002]	5.7
0.50mm2	1.15+/-0.05 [1.045+/-0.002]	5.8

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35 + 0.35	1.18+/-0.05 [1.046+/-0.002]	5.7

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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: 8-2151099-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151099-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151099-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151099-6

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 ITEM 50 & 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.

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

MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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

THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

*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	-	-	-	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
-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

P	LTR	DESCRIPTION	DATE	DWN	APVD
	K	ECR-15-004756	21MAR2015	MR	JT

- 1 - 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 1 2119082-4 CAM, SNAIL, INSULATION ADJUSTMENT 244

- 1 1 1 1 1 1 2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST 243

- 1 1 1 1 1 1 2119083-1 RETAINER, INSULATION DIAL 242

- 1 1 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

- 1 1 1 1 1 1 993111-1 PIN, SLOTTED SPRING 3.0 X 20.0 177

- 1 1 1 1 1 1 8-22280-7 SPRING, COMPRESSION 176

- 1 1 1 1 1 1 1752353-2 GUIDE PIN, HOLDDOWN 175

- 1 1 1 1 1 1 1901680-2 GUIDE PIN, HOLDDOWN 174

- - - - 2 - 21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT 172

- 1 1 1 1 1 1 994969-1 MAGNET, RARE EARTH HIGH ENERGY 166

- REF 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 1 1-18028-2 WASHER, FLAT, REG M4 119

- - REF REF - - 2119944-1 FEED FINGER ASSEMBLY, SF 117

- 1 1 1 1 1 1 455888-5 SPACER, CRIMPER 82

- 1 1 1 1 1 1 5-547505-2 SPRING, COMPRESSION 77

- 1 1 1 1 1 1 854769-4 HOLDER, INS 74

- 1 1 1 1 1 1 2119956-1 DOCUMENTATION PACKAGE 71

- 1 - - 1 1 1 2119740-1 TAG, IDENTIFICATION 67

- 2 2 2 2 2 2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188 66

- 1 - 1 1 1 1 2119793-1 LIMITER, ADJUSTMENT BOLT 63

- 3 - 3 3 3 992763-5 SCR, SET, SOC, CONE POINT, M3 x 4.0 62

- 1 1 1 1 1 1 2079383-4 SCR, BHSC, RoHS (M4 X 8) 60

- - - - 1 1 5-18022-5 SCR, HEX HD CAP, M4 X 6.0 59

- 1 1 1 1 1 1 21028-2 PIN, SLOTTED SPRING .062 X .250 58

- - - - 1 1 1338685-1 PAWL, FEED 56

- 4 4 4 4 4 2168400-1 SHCS, LOW HEAD, RoHS, M4 X 12 54

- 1 1 1 1 1 1 1-5018030-0 NUT, HEX, REG, RoHS, M3.5 52

- 1 1 1 1 1 1 1901681-1 HOLDDOWN, TERMINAL 51

- 1 1 1 1 1 1 2-1752354-4 STANDOFF, HOLD-DOWN 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 1 2119656-9 APPLICATOR BASIC ASSEMBLY, SF 46

- 1 - 1 1 1 1 2119370-1 RAM, AMP STYLE, SIDE FEED 44

- 1 1 1 1 1 1 2079383-7 SCR, BHSC, RoHS (M8 X 25) 41

- 1 - 1 1 1 1 2119645-1 DISC, NUMBERED FA WIRE ADJUSTMENT 40

- 1 - 1 1 1 1 2119957-1 APPLICATOR SHIM PACK 39

- 1 1 1 1 1 1 2119644-1 RAM WASHER, PRECISION 38

- 1 1 1 1 1 1 2119085-1 FA HEAD, ATLANTIC STYLE 37

- 1 - 1 1 1 1 2119092-1 BOLT, ADJUSTMENT 35

- 1 1 1 1 1 1 1752356-4 SUPPORT, TERMINAL 34

- 2 2 2 2 2 2079383-5 SCR, BHSC, RoHS (M4 X 20) 33

- 1 1 1 1 1 1 2161328-1 HEX HEAD, FLANGED, M5 x 8mm LONG 32

- 1 1 1 1 1 1 1-1320908-0 SPACER, STRIP GUIDE 30

- 1 1 1 1 1 1 2119959-2 ASSEMBLY, STRIP GUIDE 29

- 1 1 1 1 1 1 455888-5 SPACER, CRIMPER 28

- 1 1 1 1 1 1 1320928-2 STRIP GUIDE 24

- 1 1 1 1 1 1 2168083-2 SCR, SKT HD CAP, RoHS, M4 X 8.0 21

- 1 1 1 1 1 1 1-18028-2 WASHER, FLAT, REG M4 20

- 1 1 1 1 1 1 2119533-1 STRIPPER, SIDE FEED 19

- 1 1 1 1 1 1 2119806-1 INSERT, SHEAR 13

- 1 1 1 1 1 1 3-22280-3 SPRING, COMPRESSION 12

- 1 1 1 1 1 1 1-356885-4 STOP, SHEAR 11

- 1 1 1 1 1 1 2119805-1 SHEAR HOLDER, FRONT 10

- 1 1 1 1 1 1 1803095-1 FLOATING SHEAR, FRONT 9

1 1 1 1 1 1 1333204-2 ANVIL, COMBINATION 8

- 1 1 1 1 1 1 2119780-7 DEPRESSOR, SHEAR 5

- 1 1 1 1 1 1 2-238011-2 BLOCK, CRIMPER SPACER 4

1 1 1 1 1 1 2119785-4 CRIMPER, INSULATION OVERLAP PREMIUM 3

- 1 1 1 1 1 1 455888-5 SPACER, CRIMPER 2

1 1 1 1 1 1 1803125-2 CRIMPER, WIRE 1

| -77 | -7 | -6 | -5 | -2 | -1 | PART NO | DESCRIPTION | ITEM NO |

TE Connectivity

Harrisburg, PA 17105-3608

Ocean Side Feed Applicator

00779 ©=2151099

Customer Accessible Production Drawing

SCALE 1:2

SHEET 1 OF 4

REV K1

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ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER

PART NUMBER

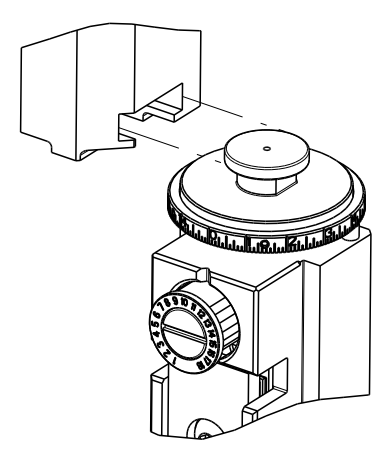
REVISION

DESCRIPTION

FEED TYPE

CONVERT TO

PART NUMBERS REQUIRED



2151099-1	K	FINE CRIMP HEIGHT ADJUST	MECHANICAL	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
2151099-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	SERVO LATCH PLATE	2119951-1	-	8-2151099-5	1901094-3	-	2168400-6 (QUANTITY 2)
				SMART APPLICATOR	2161326-1	-	8-2151099-4	-	-	
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	
				SERVO LATCH PLATE	2119951-1	-	8-2151099-5	1901094-3	-	2168400-6 (QUANTITY 2)
2151099-5	K	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	SMART APPLICATOR	2161326-1	-	8-2151099-4	-	-	
				MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	
2151099-6	K	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE	PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
				-	-	-	-	-	-	-
2151099-7	K	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
				-	-	-	-	-	-	-
7-2151099-7	H	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.55 mm [1.00]	OV

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.70-4.30 mm [1.46-.169 IN]	Ø1.40-2.10 mm [1.055-.083 IN]

TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
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TERMINAL APPLICATION SPECIFICATION

TERMINALS APPLIED

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
1.00mm2	1.20+/-0.05 [1.047+/-0.002]	5.5
0.75mm2	1.18+/-0.05 [1.046+/-0.002]	5.7
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WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.35 + 0.35	1.18+/-0.05 [1.046+/-0.002]	5.7

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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: 8-2151099-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151099-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151099-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151099-6

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 ITEM 50 & 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.

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

MAGNET, ITEM 166 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 THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

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

THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 1) AND 114-18022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED AND APPROVED APPLICATIONS, AS STATED WITHIN TE CONNECTIVITY APPLICATION SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

*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	-	-	-	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
-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

P	LTR	DESCRIPTION	DATE	DWN	APVD
	K	ECR-15-004756	21MAR2015	MR	JT

- 1 - 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 1 2119082-4 CAM, SNAIL, INSULATION ADJUSTMENT 244

- 1 1 1 1 1 1 2079764-1 WASHER, WAVE SPRING, CREST-TO-CREST 243

- 1 1 1 1 1 1 2119083-1 RETAINER, INSULATION DIAL 242

- 1 1 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

- 1 1 1 1 1 1 993111-1 PIN, SLOTTED SPRING 3.0 X 20.0 177

- 1 1 1 1 1 1 8-22280-7 SPRING, COMPRESSION 176

- 1 1 1 1 1 1 1752353-2 GUIDE PIN, HOLDDOWN 175

- 1 1 1 1 1 1 1901680-2 GUIDE PIN, HOLDDOWN 174

- - - - 2 - 21045-3 RING, RETAIN, EXTERN, 3/16 CRESCENT 172

- 1 1 1 1 1 1 994969-1 MAGNET, RARE EARTH HIGH ENERGY 166

- REF 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 1 1-18028-2 WASHER, FLAT, REG M4 119

- - REF REF - - 2119944-1 FEED FINGER ASSEMBLY, SF 117

- 1 1 1 1 1 1 455888-5 SPACER, CRIMPER 82

- 1 1 1 1 1 1 5-547505-2 SPRING, COMPRESSION 77

- 1 1 1 1 1 1 854769-4 HOLDER, INS 74

- 1 1 1 1 1 1 2119956-1 DOCUMENTATION PACKAGE 71

- 1 - - 1 1 1 2119740-1 TAG, IDENTIFICATION 67

- 2 2 2 2 2 2168078-1 SCREW, DRIVE, RH, RoHS, 2 x .188 66

- 1 - 1 1 1 1 2119793-1 LIMITER, ADJUSTMENT BOLT 63

- 3 - 3 3 3 992763-5 SCR, SET, SOC, CONE POINT, M3 x 4.0 62

- 1 1 1 1 1 1 2079383-4 SCR, BHSC, RoHS (M4 X 8) 60

- - - - 1 1 5-18022-5 SCR, HEX HD CAP, M4 X 6.0 59

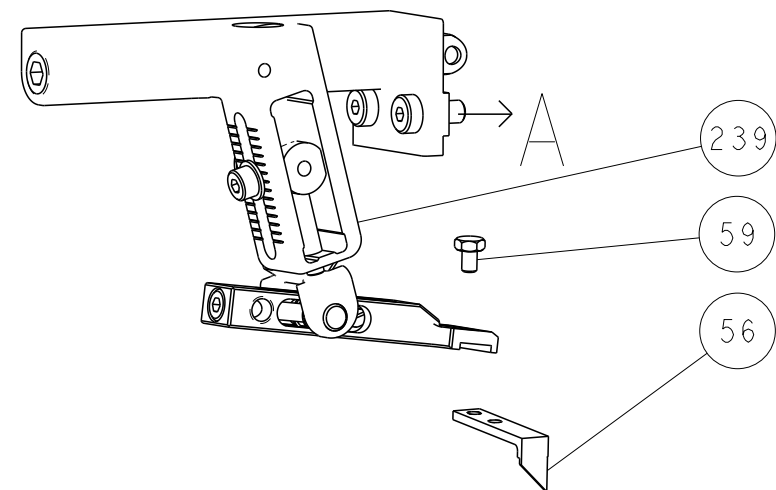
- 1 1 1 1 1 1 21028-2 PIN, SLOTTED SPRING .062 X .250 58

- - - - 1 1 1338685-1 PAWL, FEED 56

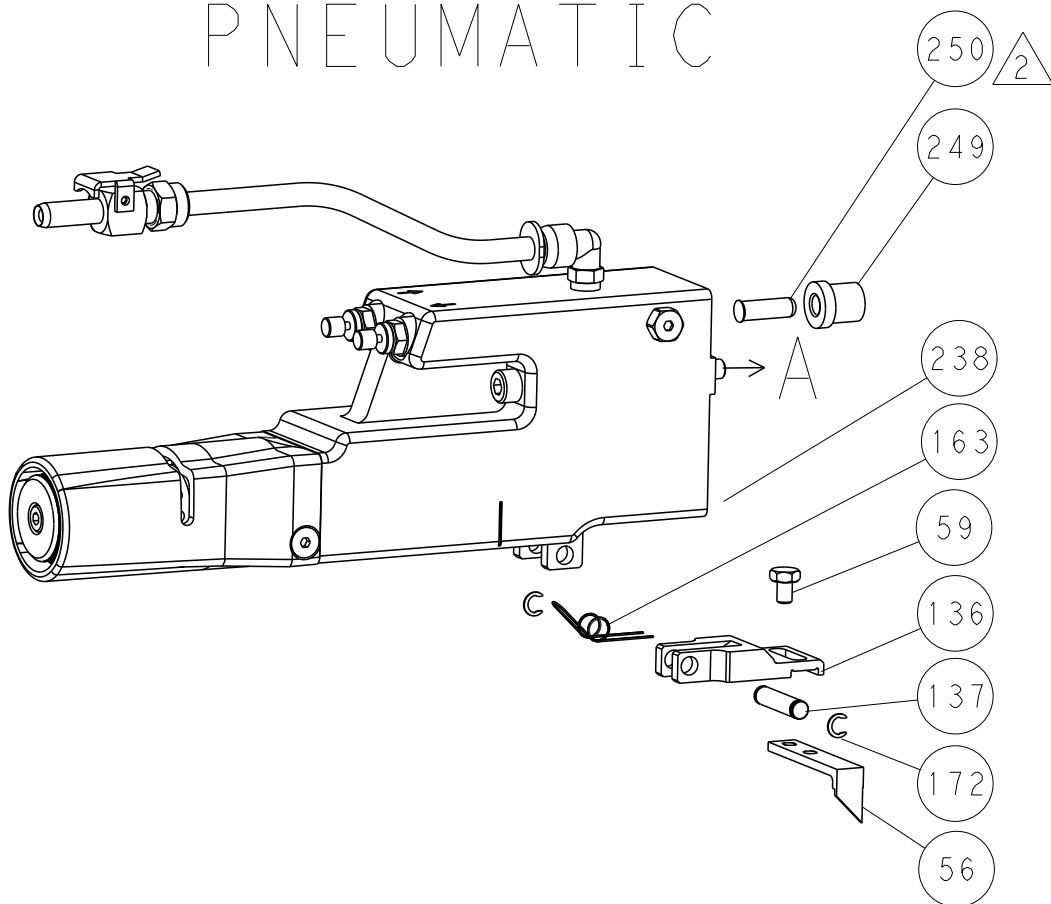
- 4 4 4 4 4 216840

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A	66	P	LTR	DESCRIPTION	DATE	DWN	APVD	
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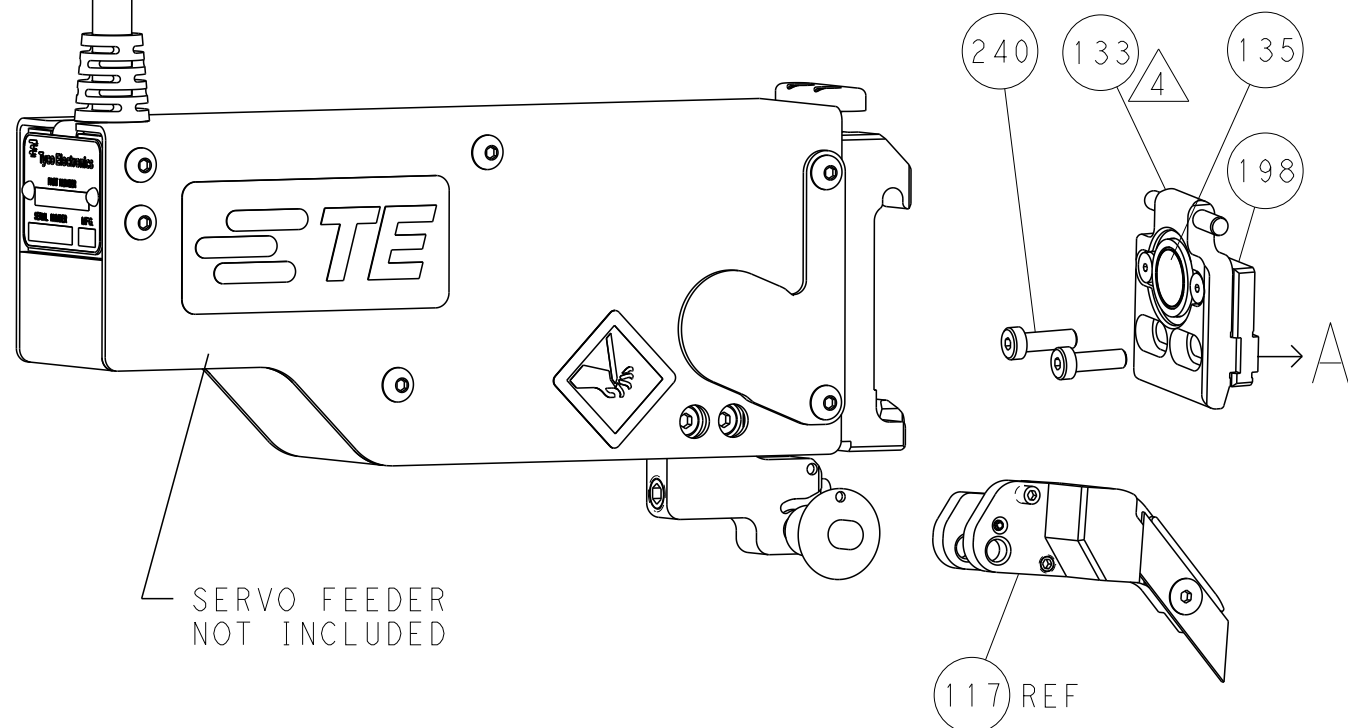
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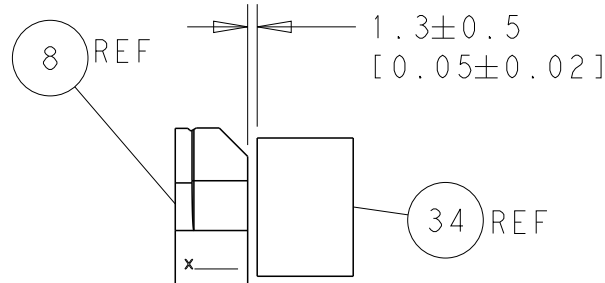
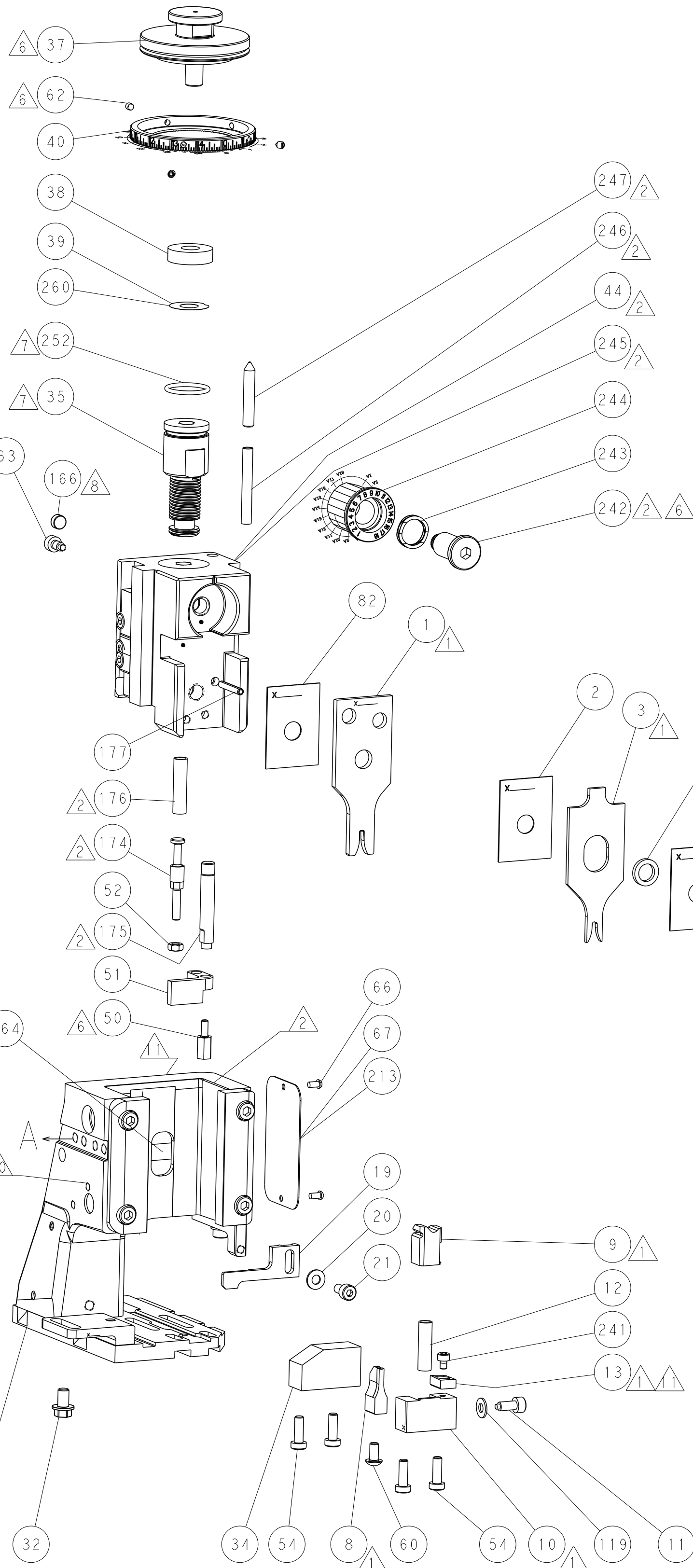
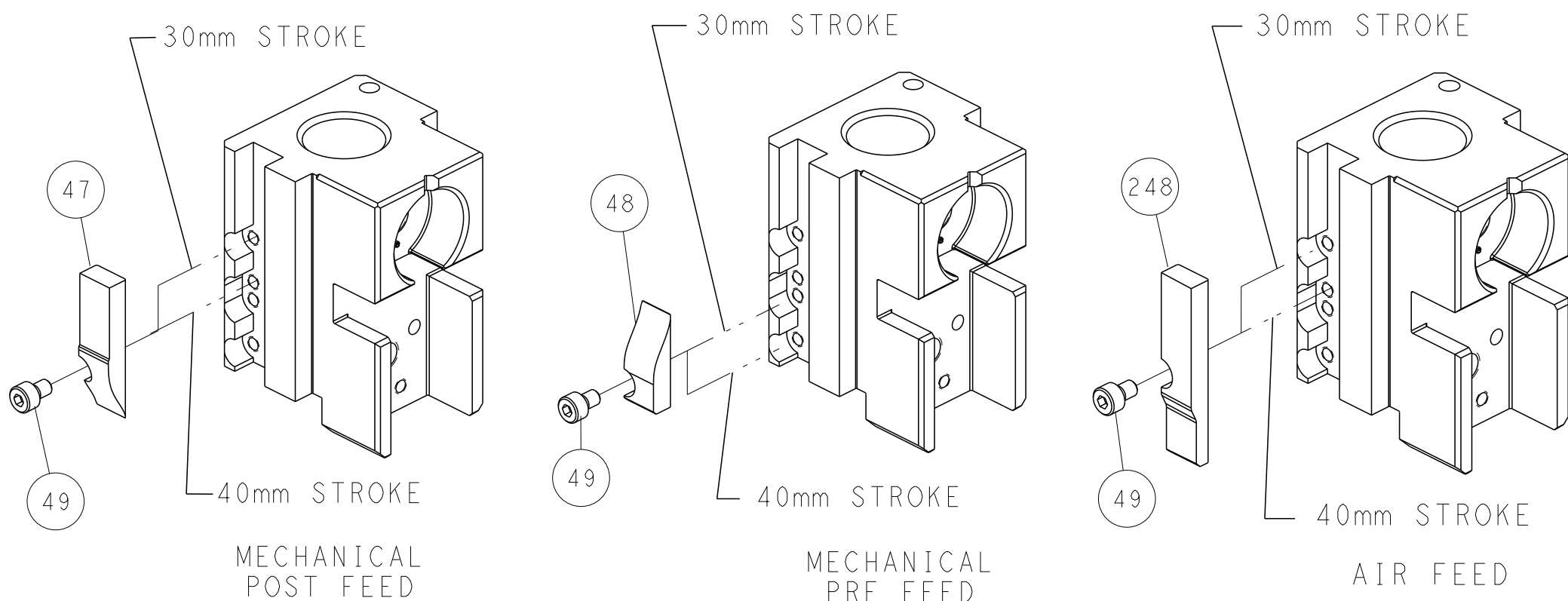
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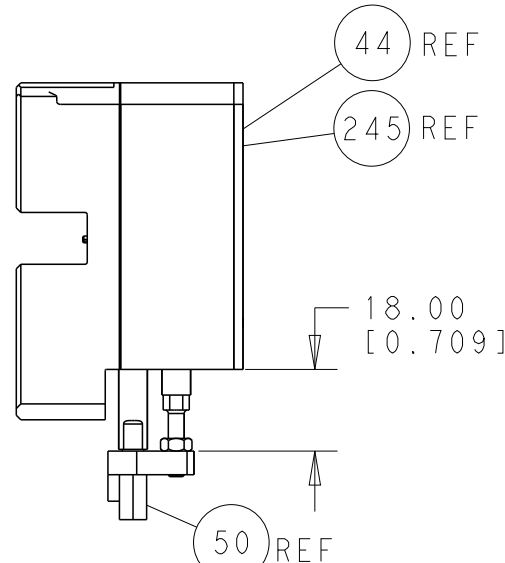
SERVO LATCH PLATE



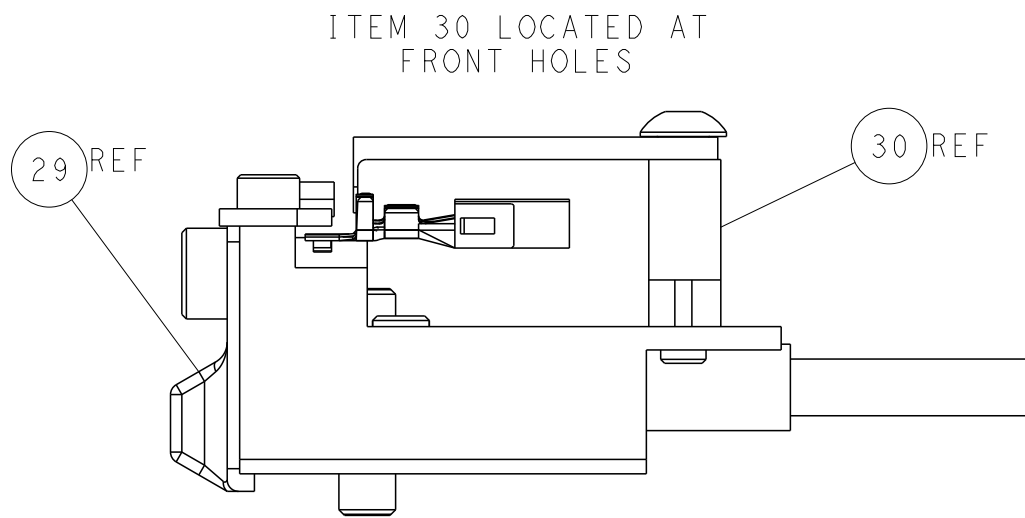
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



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 UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. ANY CHANGES TO THIS DRAWING SHOULD BE CONTACTED FOR THE LATEST VERSION.		DWN Y. YIN 22AUG2011	TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		CHK G. BAILEY 22AUG2011	NAME Ocean Side Feed Applicator	
TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001 ANGLES ±.5 FINISH		APVD S. XI 22AUG2011	SIZE A1	
MATERIAL		PRODUCT SPEC	CAGE CODE 00779	
		APPLICATION SPEC	DRAWING NO C=2151099	
		WEIGHT	RESTRICTED TO	
		Customer Accessible Production Drawing	SCALE 1:2	
			SHEET 2 of 4	
			REV K1	

8		7	
THIS DRAWING IS UNPUBLISHED.		RELEASED FOR PUBLICATION	
20		20	
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PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE	APPLICATOR STYLE CONVERSION CHART						
					CONVERT TO	PART NUMBERS REQUIRED					
	2-2151099-1	K	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	-	8-2151099-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151099-4	-	-	-
	2-2151099-2	K	FINE CRIMP HEIGHT ADJUST	PNEUMATIC	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					SERVO LATCH PLATE	2119951-1	-	8-2151099-5	1901094-3	-	2168400-6 (QUANTITY 2)
					SMART APPLICATOR	2161326-1	-	8-2151099-4	-	-	-
	2-2151099-5	K	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 	MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-2	-	-
					PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-2	2119799-1	2063440-1
	2-2151099-7	K	FINE CRIMP HEIGHT ADJUST	NONE	-	-	-	-	-	-	-
	7-2151099-7	H	CRIMP TOOLING KIT	-	-	-	-	-	-	-	-

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	2.03 mm [.080]	F
INSUL	2.55 mm [.100]	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 Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION			
(A) 114-18050		-	
(B) 114-18051		-	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 964284-1	(A) 1-964284-1	(B) 1-964294-3	(C) 1241388-1
(A) 964284-2	(A) 2-964284-1	(B) 2-964294-1	(C) 1241388-2
(A) 964284-6	(A) 4-964284-1	(B) 2-964294-2	(C) 1241388-3

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING ⁹
1.00mm2			1.20+/-0.05 [0.047+/-0.002]		5.5
0.75mm2			1.18+/-0.05 [0.046+/-0.002]		5.7
0.50mm2			1.15+/-0.05 [0.045+/-0.002]		5.8



 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: 8-2151099-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151099-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151099-5

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 50 & 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

8 MAGNET 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 BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT			
WIRE STRIP LENGTH 3.50-4.10mm [.138-.161 IN]		INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION SPECIFICATION		(C) 114-18387	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(C) 1241388-1			
(C) 1241388-2			
(C) 1241388-3			

WIRE SIZE			CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
1.00mm2			1.20+/-0.05 [.047+/- .002]		5.5
0.75mm2			1.18+/-0.05 [.046+/- .002]		5.7
0.50mm2			1.15+/-0.05 [.045+/- .002]		5.8

THIS CRIMP PARAMETER IS PROVIDED TO MEET A CUSTOM AND UNIQUE CUSTOMER REQUIREMENT. IT HAS BEEN EVALUATED AND IS CONDITIONALLY SPECIFIED BY TE CONNECTIVITY. THIS CUSTOMIZED CRIMP PARAMETER IS NOT LISTED AS AN APPROVED APPLICATION WITHIN A TE CONNECTIVITY APPLICATION SPECIFICATION; HOWEVER, IT HAS BEEN VALIDATED ACCORDING TO TE CONNECTIVITY SPECIFICATIONS 109-18079 (TEST GROUP 3) AND 109-148022. **TE CONNECTIVITY EXPRESSLY DISCLAIMS ALL AND ALL WARRANTIES THAT THE PRODUCT WILL PERFORM SIMILARLY TO VALIDATED APPLICATIONS AND SPECIFICATIONS, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE.** AS SUCH, IT IS HIGHLY RECOMMENDED THAT THE CUSTOMER PERFORM FURTHER DETAILED EVALUATION TO ASSESS PRODUCT PERFORMANCE IN THE SPECIFIC APPLICATION.

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: JUNIOR-POWER-TIMER CONTACT			
WIRE STRIP LENGTH 3.50-4.10mm [.138-.161 IN]		INSULATION DIAMETER RANGE Ø1.40-2.10 mm [.055-.083 IN]	
TERMINAL APPLICATION 		△2	
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
964284-2			
964284-6			
2-964284-1			

WIRE SIZE		CRIMP HEIGHT mm [INCH]		CRIMP HEIGHT REFERENCE SETTING
0.35 + 0.35		1.18+/-0.05 [0.046+/- .002]		5.7

* 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	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-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)

2		1	
SET UP GAUGE 2119599-1	LOC A	DIST 66	REVISONS
P	LTR	DESCRIPTION	DATE
-	-	SEE SHEET 1	-

	-	1	1	1	1	2119082-4	CAM, SNAIL, INSULATION ADJUSTMENT	244
	-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6	-	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	-	-	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	-	-	2119740-2	TAG,IDENTIFICATION	213
	-	-	1	-	-	1901094-3	SPACER, FEEDER	198
	-	1	1	1	1	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
	-	1	1	1	1	8-22280-7	SPRING, COMPRESSION	176
	-	1	1	1	1	1752353-2	GUIDE PIN,HOLDDOWN	175
	-	1	1	1	1	1901680-2	GUIDE PIN,HOLDDOWN	174
8	-	-	-	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
7	-	1	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	1	2119798-2	DETENT PIN	145
	-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
	-	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
	-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
	-	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
	-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
7	-	1	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	1-18028-2	WASHER, FLAT, REG M4	119
	-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
	-	1	1	1	1	455888-5	SPACER, CRIMPER	82
	-	1	1	1	1	5-547505-2	SPRING, COMPRESSION	77
	-	1	1	1	1	854769-4	HOLDER, INS	74
	-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
	-	1	-	1	1	2119740-1	TAG,IDENTIFICATION	67
	-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
	-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
6	-	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
	-	1	1	1	1	21028-2	PIN, SLOTTED SPRING .062 X .250	58
	-	-	-	-	1	1338685-1	PAWL, FEED	56
	-	1	1	1	1	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	52
6	-	1	1	1	1	1901681-1	HOLDDOWN, TERMINAL	51
	-	1	1	1	1	2-1752354-4	STANDOFF,HOLD-DOWN	50
	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
	-	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	2119644-1	RAM WASHER, PRECISION	38
	-	1	1	1	1	1752356-4	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	1-1320908-0	SPACER, STRIP GUIDE	30
	-	1	1	1	1	2119959-2	ASSEMBLY, STRIP GUIDE	29
	-	1	1	1	1	455888-5	SPACER, CRIMPER	28
	-	1	1	1	1	1320928-2	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
7	-	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
7	-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
	-	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
7	1	1	1	1	1	1333204-2	ANVIL, COMBINATION	8
	-	1	1	1	1	2119780-7	DEPRESSOR, SHEAR	5
	-	1	1	1	1	2-238011-2	BLOCK, CRIMPER SPACER	4
7	1	1	1	1	1	2119785-4	CRIMPER, INSULATION OVERLAP PREMIUM	3
	-	1	1	1	1	455888-5	SPACER, CRIMPER	2
7	1	1	1	1	1	1803125-2	CRIMPER, WIRE	1
	-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

THIS DRAWING IS A CONTROL DOCUMENT FOR PRO ELECTRONICS CORPORATION IT IS DERIVED FROM THE PRO DATA SHEET FOR THIS PRODUCT, AND TESTING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.		DWN 22AUG2011 LYN		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm		TO DIMENSIONS UNLESS OTHERWISE SPECIFIED: 0 PLC ±.0 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.0001 ANGLES ±°		CHG 22AUG2011 G.BAILEY APVD 22AUG2011 S.XI PRODUCT SPEC - APPLICATION SPEC -	
		NAME Ocean Side Feed Applicator -		SIZE CAGE CODE DRAWING NO RESTRICTED TO	
MATERIAL -		WEIGHT -		A1 00779 C=2151099 -	
FINISH -		Customer Accessible Production Drawing			
		SCALE 1:2		SHEET 3 OF 4 REV K1	

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

D

C

B

A

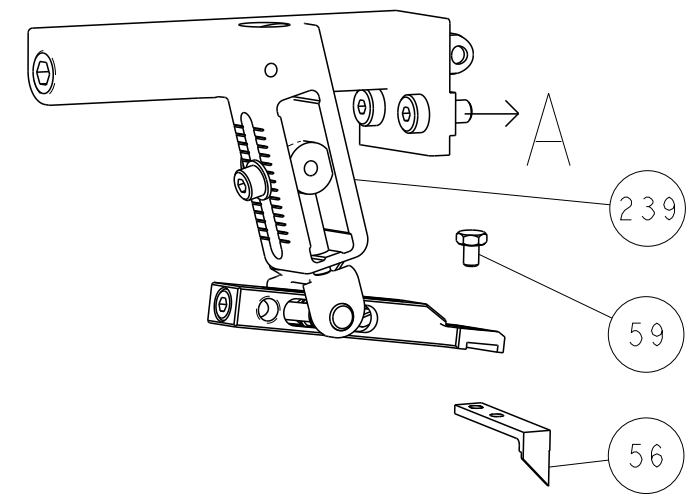
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C

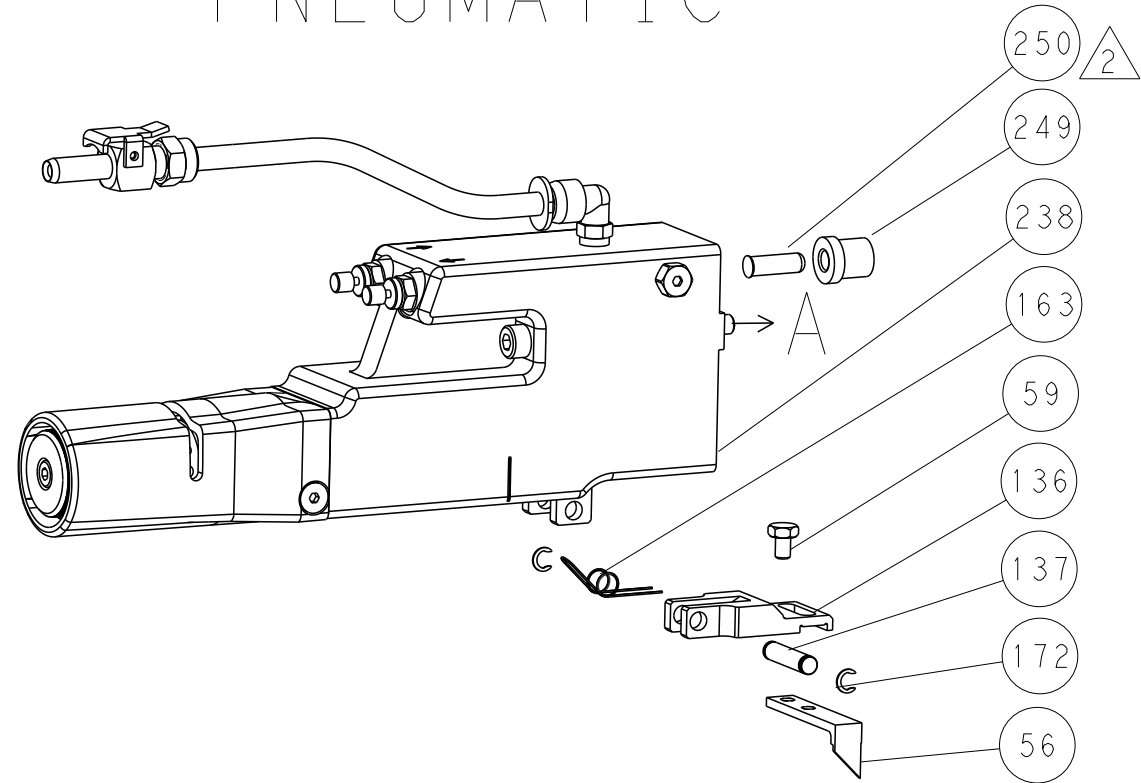
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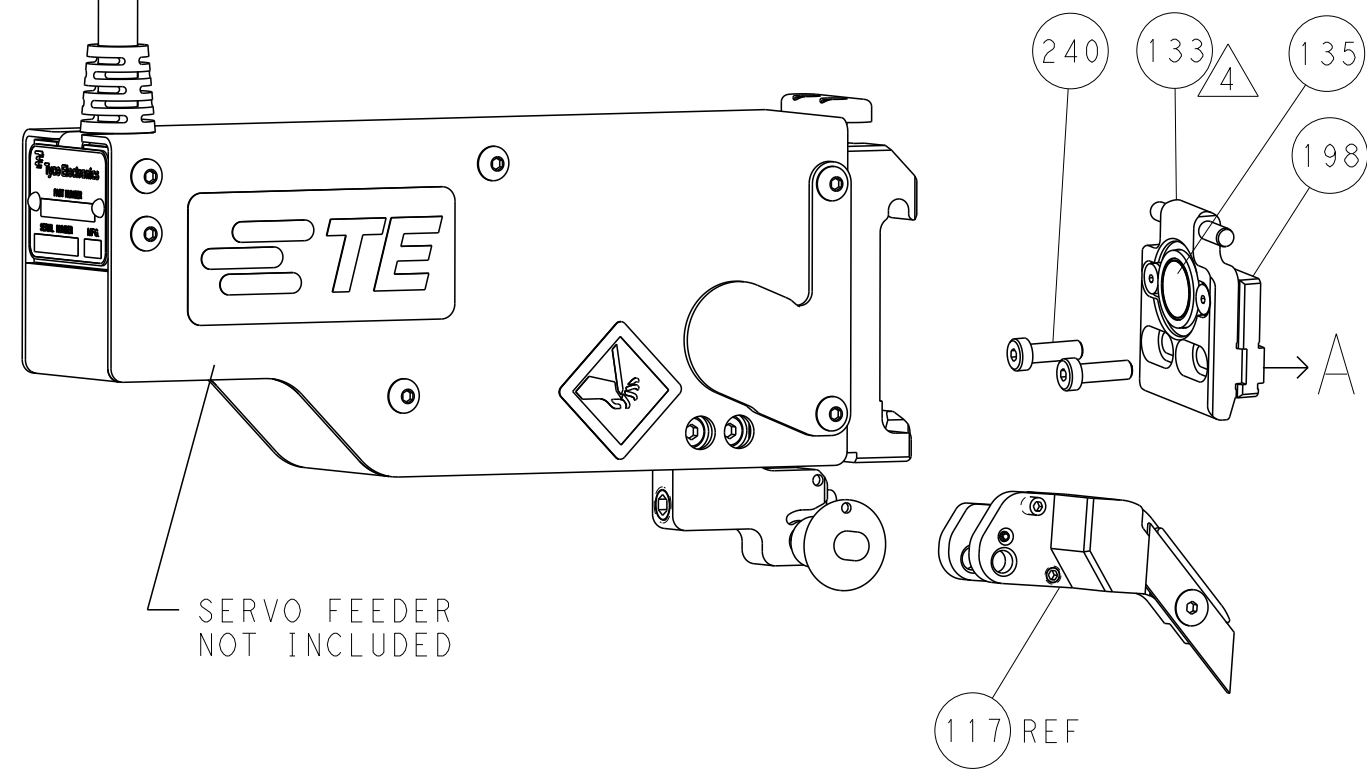
FEED TYPE MECHANICAL



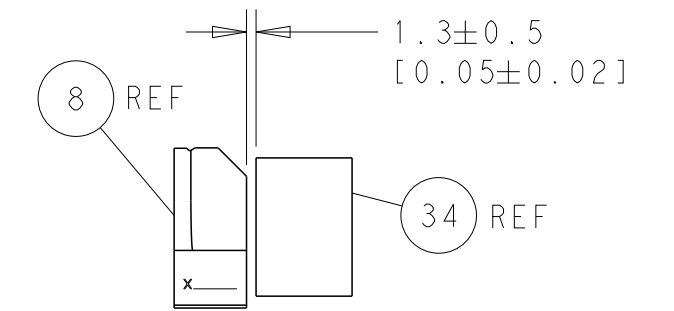
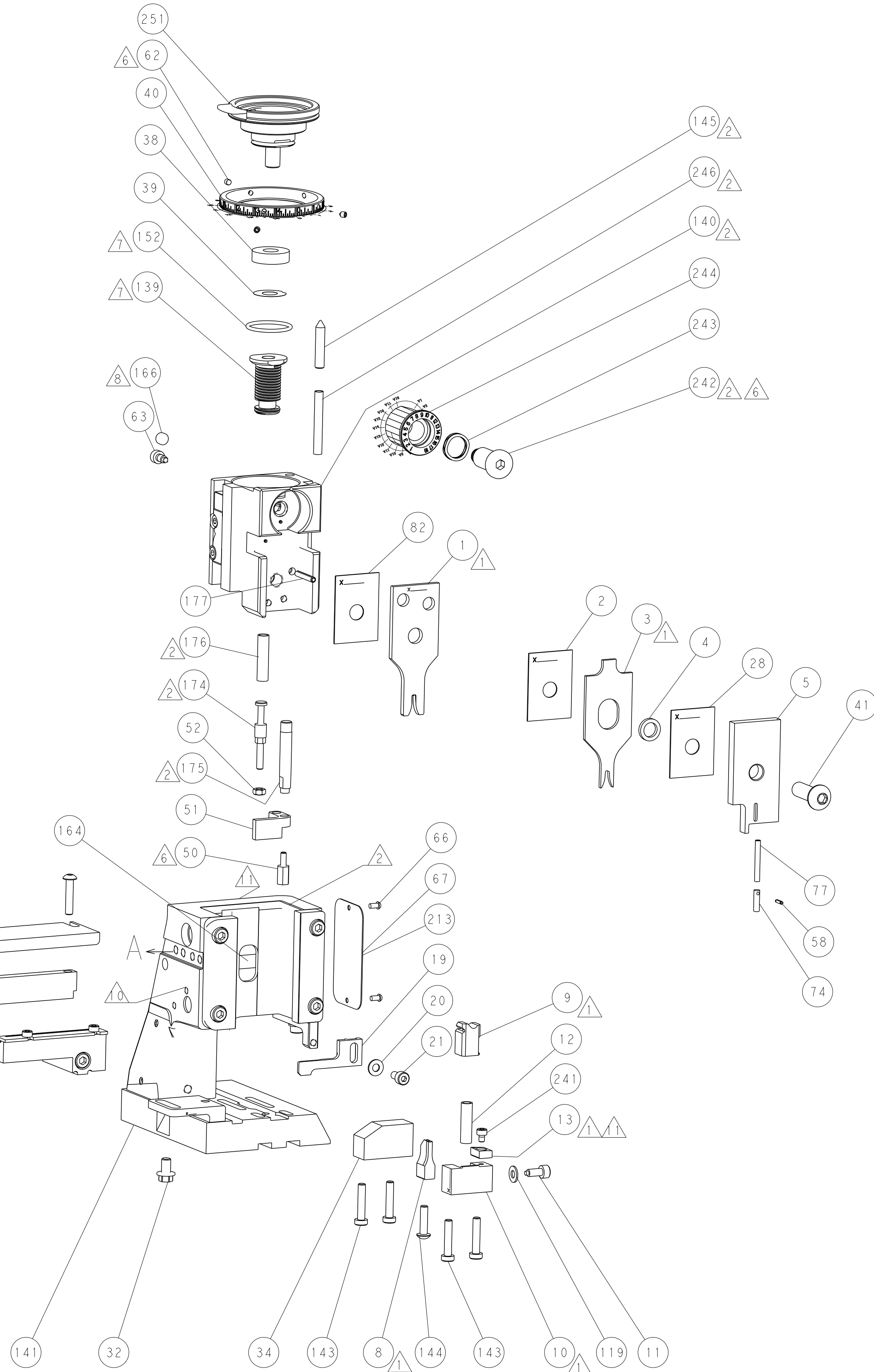
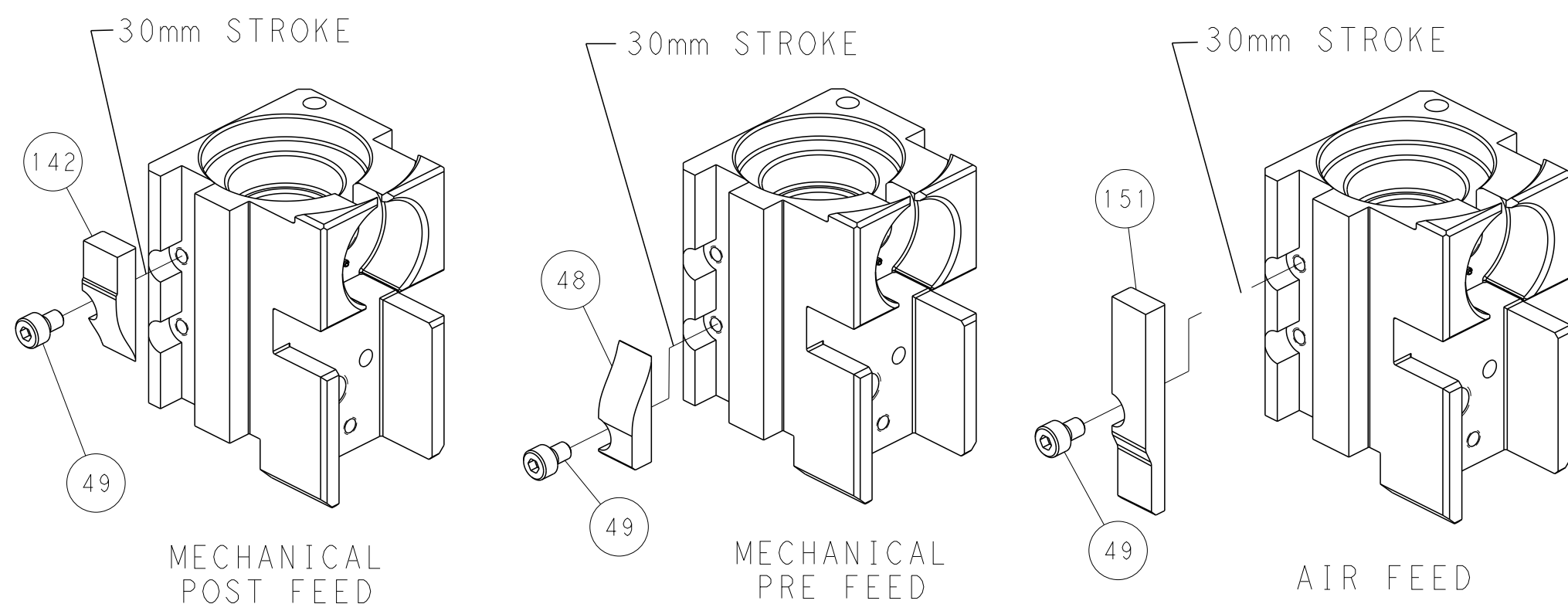
PNEUMATIC



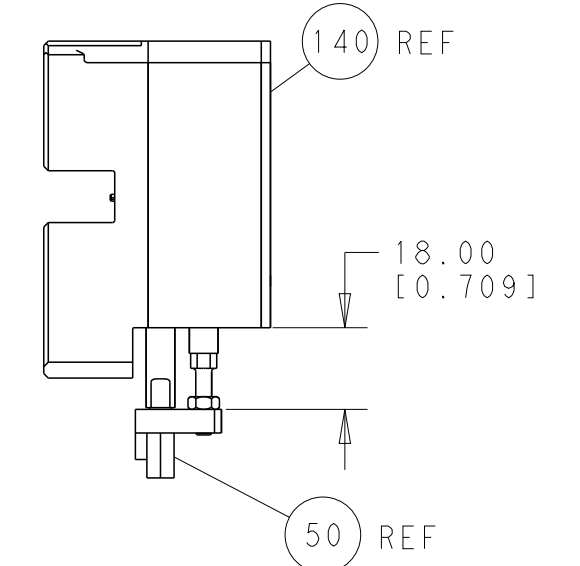
SERVO LATCH PLATE



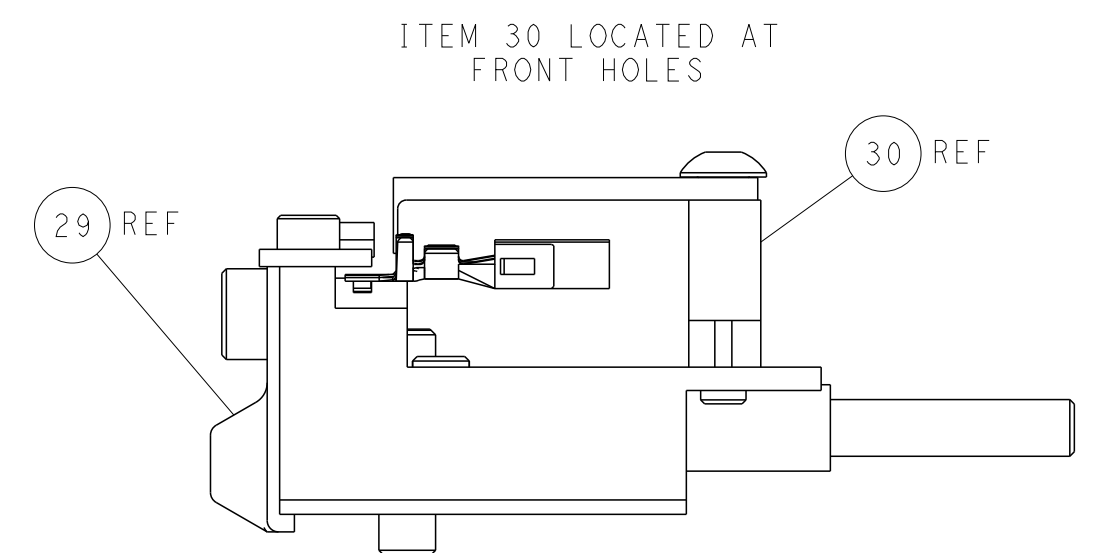
CAM POSITIONS



TERMINAL SUPPORT LOCATION



HOLDDOWN SET-UP



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

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

THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE WITHOUT NOTICE. THE USER SHALL BE RESPONSIBLE FOR THE LATEST VERSION.		DWN Y. YIN	22AUG2011	TE Connectivity Harrisburg, PA 17105-3608	
		CHK G. BAILEY	22AUG2011		
		APVD S. XI	22AUG2011	NAME Ocean Side Feed Applicator	
DIMENSIONS: mm		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC	
		0 PLC ±.5 1 PLC ±0.5 2 PLC ±0.13 3 PLC ±0.013 4 PLC ±0.001		APPLICATION SPEC	
MATERIAL		FINISH		WEIGHT	
				Customer Accessible Production Drawing	
				SCALE 1:2 SHEET 4 OF 4 REV K1	

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

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